

G6801418

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



ORDER NO.

25716

BARREL LENGTH

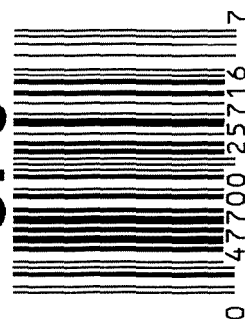
24"

CAPACITY

6

G6801418

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801418

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TE
460	CHECK HEADSPACE		3-6-09	TE
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE		3-6-09	RT
475	DRILL AND TAP SIGHT HOLES		3-6-09	JP
480	MAGNAFLUX BBL ACTION		3/9/09	(N)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	huz
542	APPLY COATINGS (BARREL ACTION)		3-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	JP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

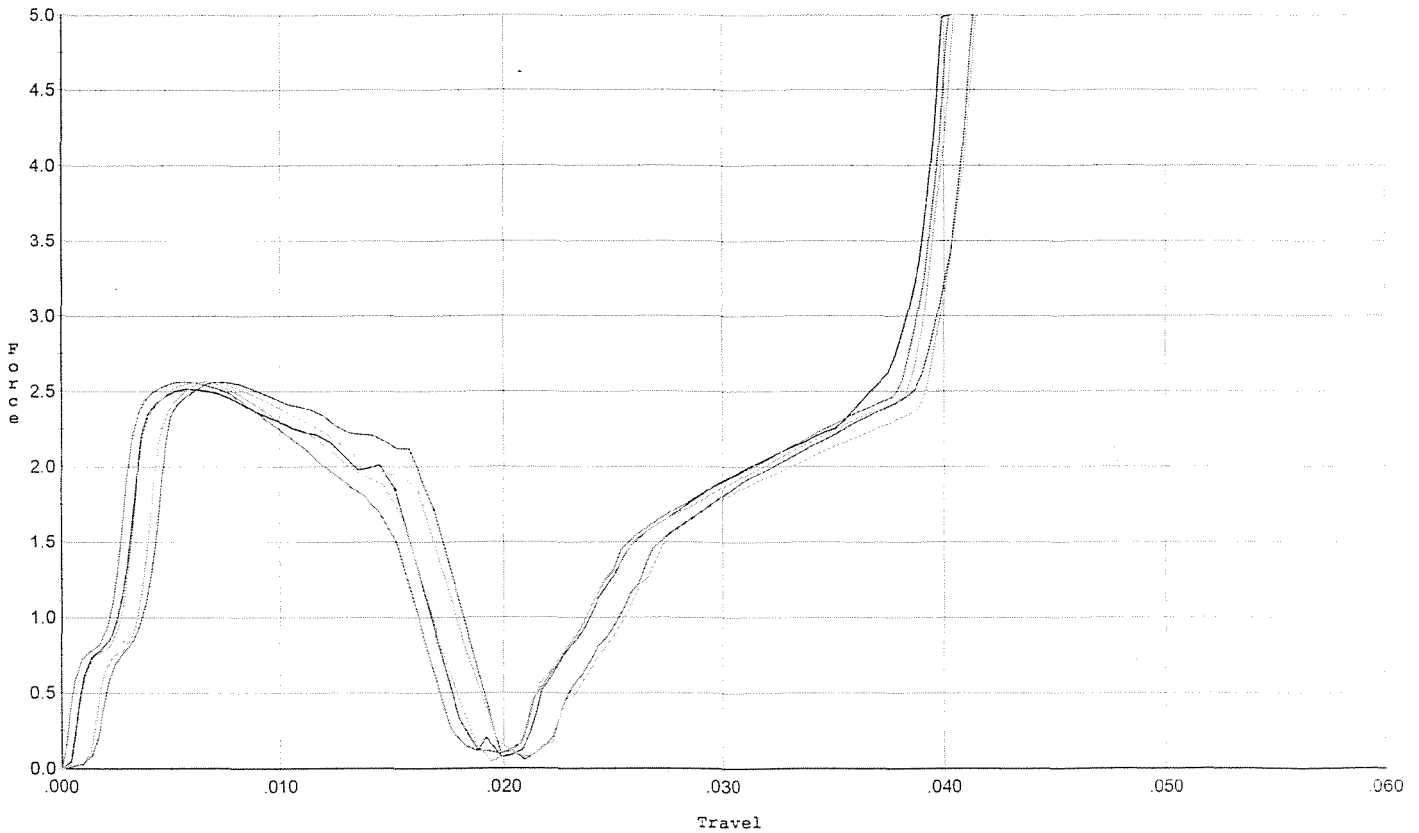
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	3-26-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-26-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	3-26-09	WW
	J) ASSEMBLE STOCK		3-23-09	LLD
	K) ASSEMBLE SWIVEL STUDS		3-26-09	WW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-25-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WW
670	FINAL INSPECTION A) HEADSPACE		3-26-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.55</u> <u>2.44</u> <u>2.54</u> <u>2.48</u>	3-25-09	TL
	C) FUNCTION		3-26-09	WW
690	PACK		3/28/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .50 lb



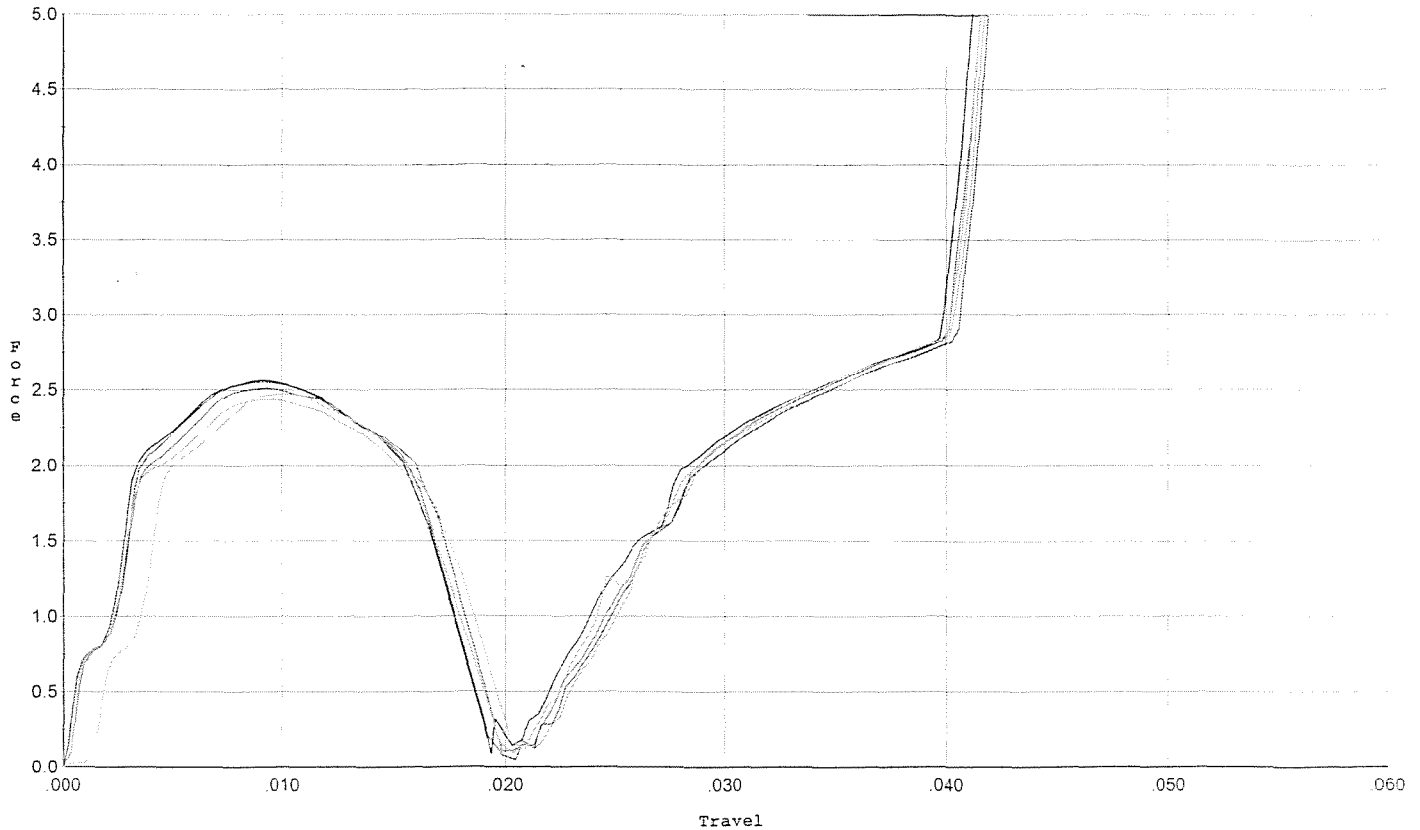
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.017	0.00	0.029	0.029		Set Trigger
2	2.516	0.015	0.00	0.029	0.027		Set Trigger
3	2.564	0.015	0.00	0.030	0.028		Set Trigger
4	2.564	0.016	0.00	0.030	0.028		Set Trigger
5	2.568	0.015	0.00	0.030	0.028		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 50 cycles+/- .50 lb



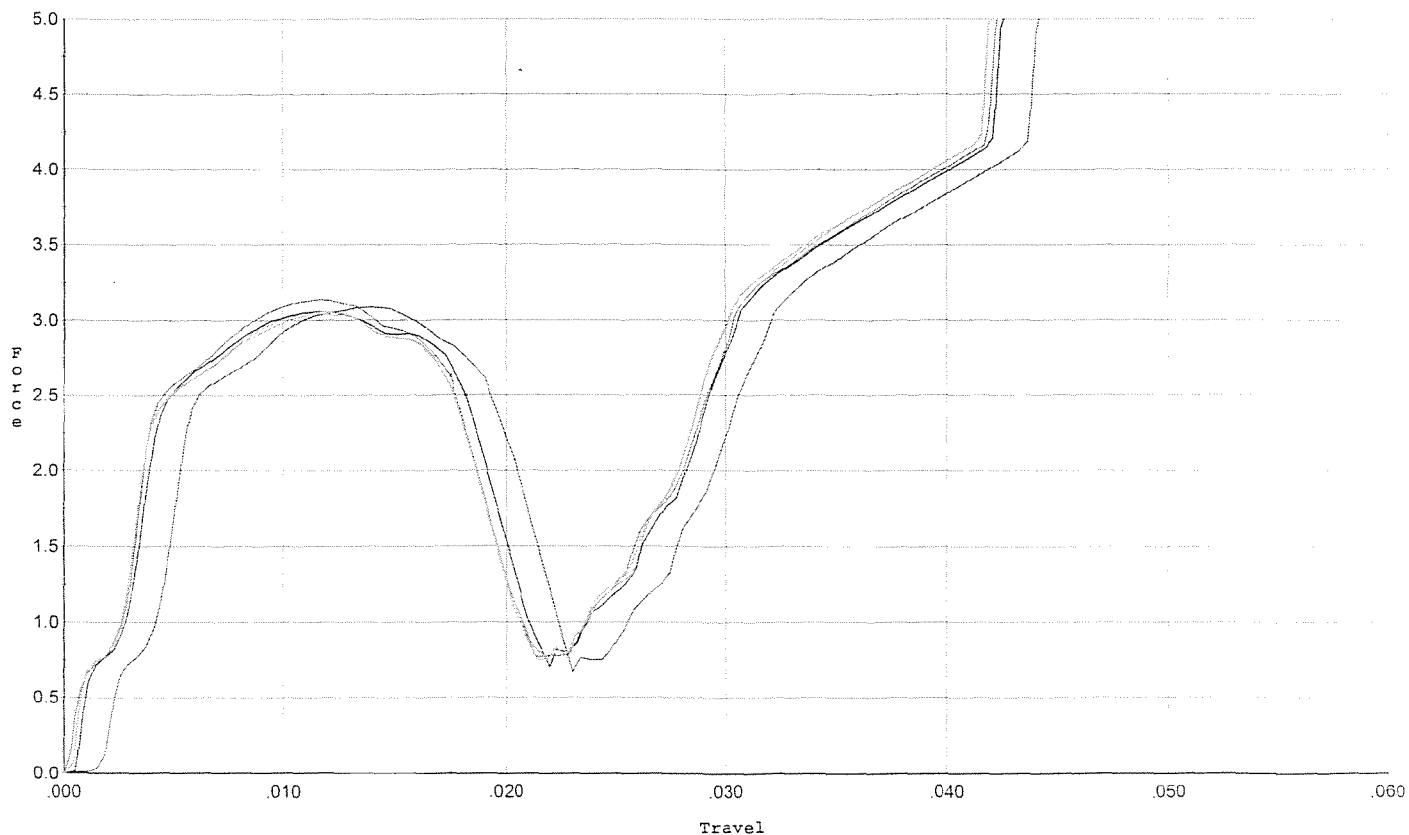
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.016	0.00	0.030	0.031		Set Trigger
2	2.562	0.017	0.00	0.029	0.031		Set Trigger
3	2.509	0.017	0.00	0.029	0.032		Set Trigger
4	2.471	0.018	0.00	0.029	0.031		Set Trigger
5	2.442	0.016	0.00	0.029	0.029		Set Trigger

A-250

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .75 lb



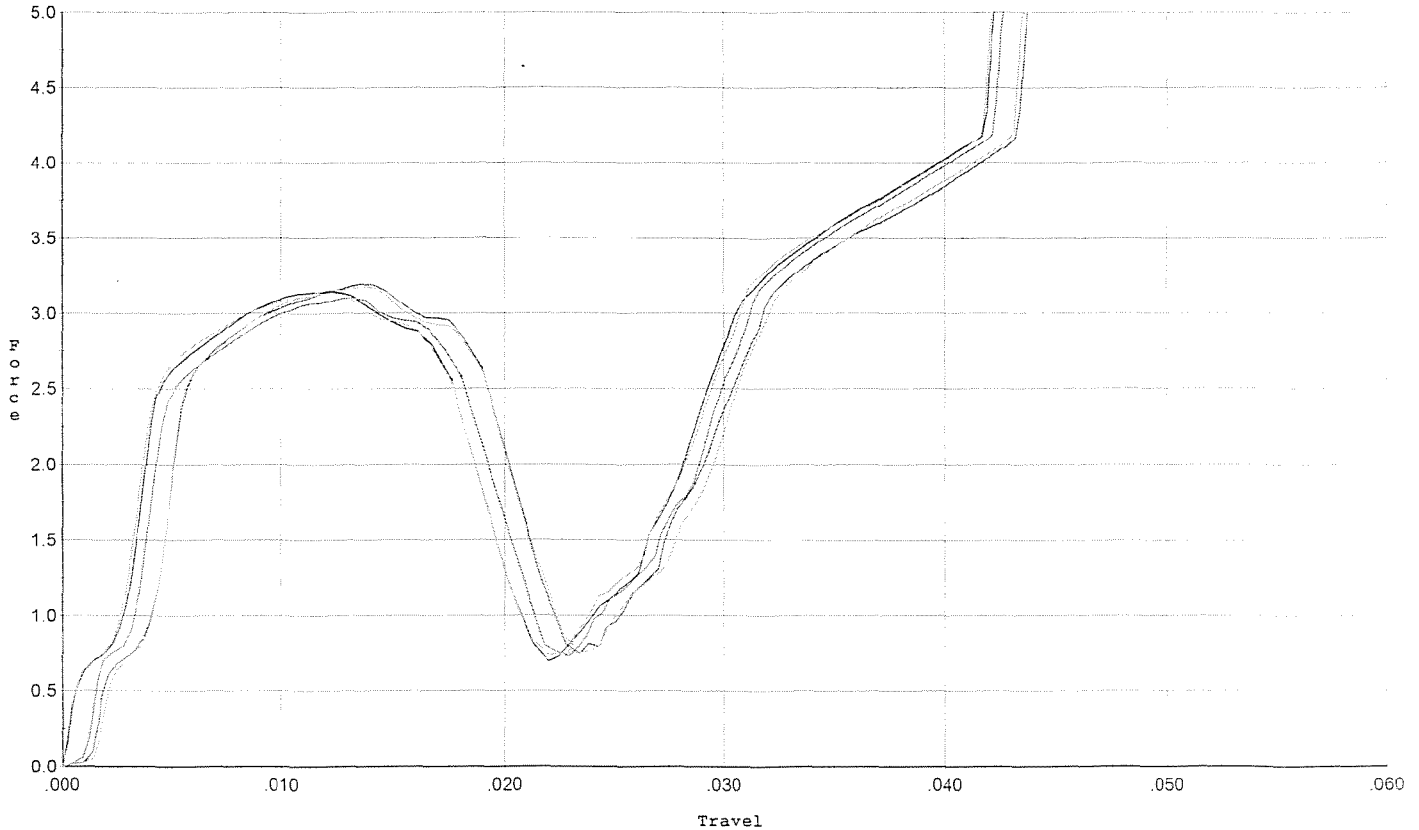
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.086	0.020	0.00	0.028	0.043		Set Trigger
2	3.059	0.018	0.00	0.028	0.041		Set Trigger
3	3.140	0.018	0.00	0.028	0.040		Set Trigger
4	3.045	0.018	0.00	0.028	0.039		Set Trigger
5	3.058	0.018	0.00	0.028	0.040		Set Trigger

A-3-07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles+/- .75 lb



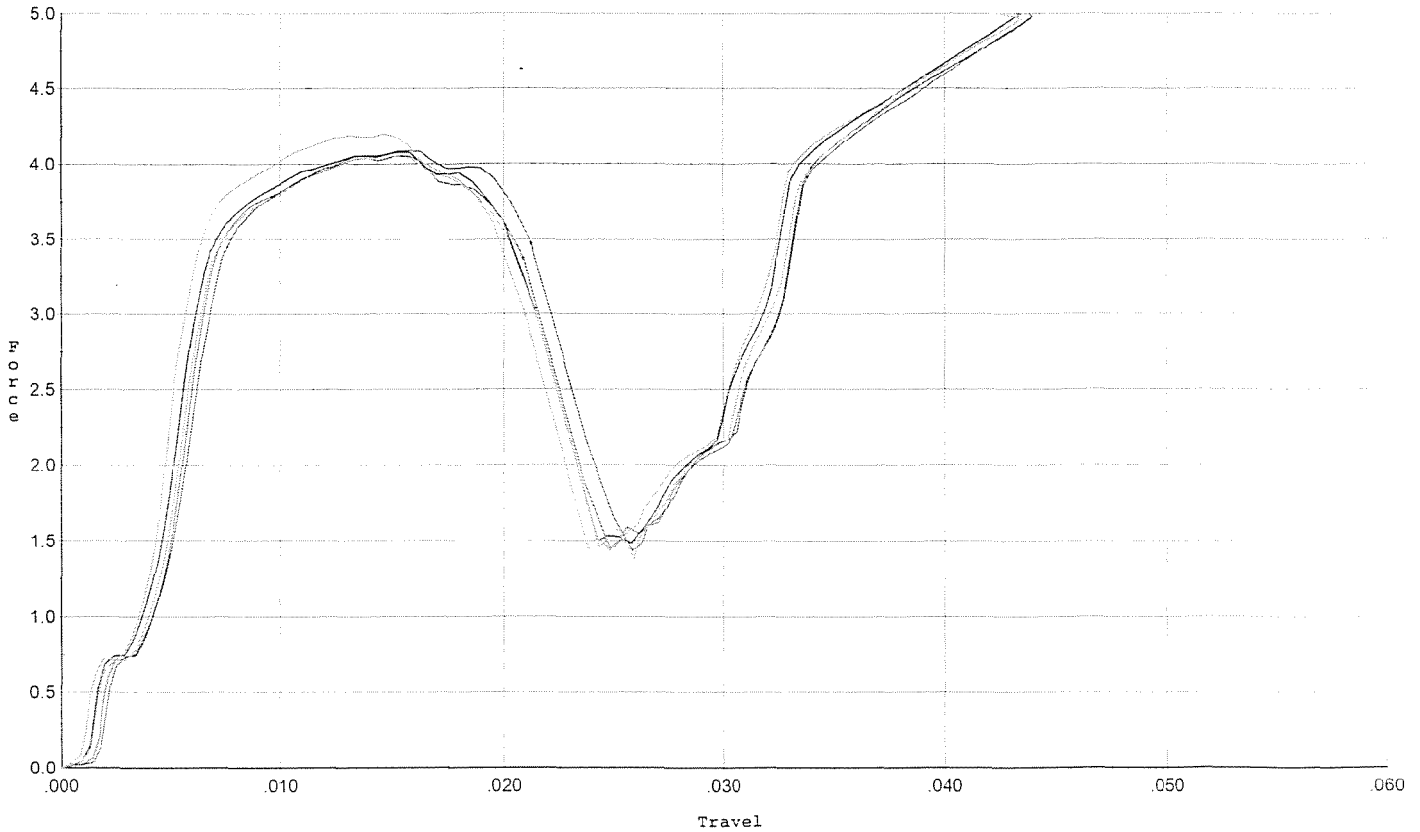
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.191	0.019	0.00	0.028	0.041		Set Trigger
2	3.146	0.018	0.00	0.028	0.040		Set Trigger
3	3.102	0.018	0.00	0.028	0.040		Set Trigger
4	3.177	0.019	0.00	0.028	0.041		Set Trigger
5	3.137	0.018	0.00	0.028	0.040		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



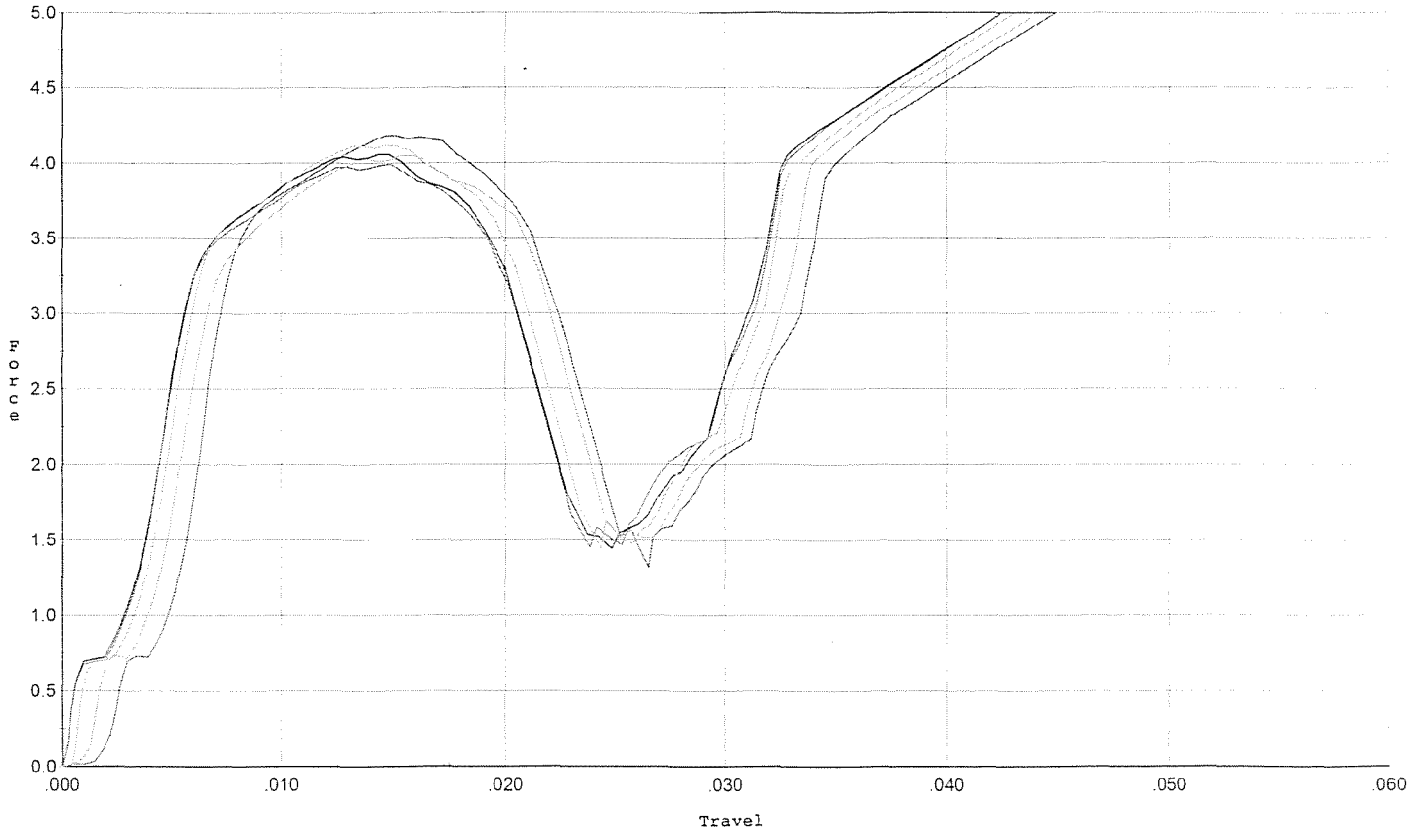
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.021	0.00	0.026	0.058		Set Trigger
2	4.078	0.021	0.00	0.025	0.059		Set Trigger
3	4.057	0.021	0.00	0.026	0.057		Set Trigger
4	4.052	0.021	0.00	0.026	0.058		Set Trigger
5	4.200	0.021	0.00	0.026	0.060		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 20 cyclew+/- 1.0 lb



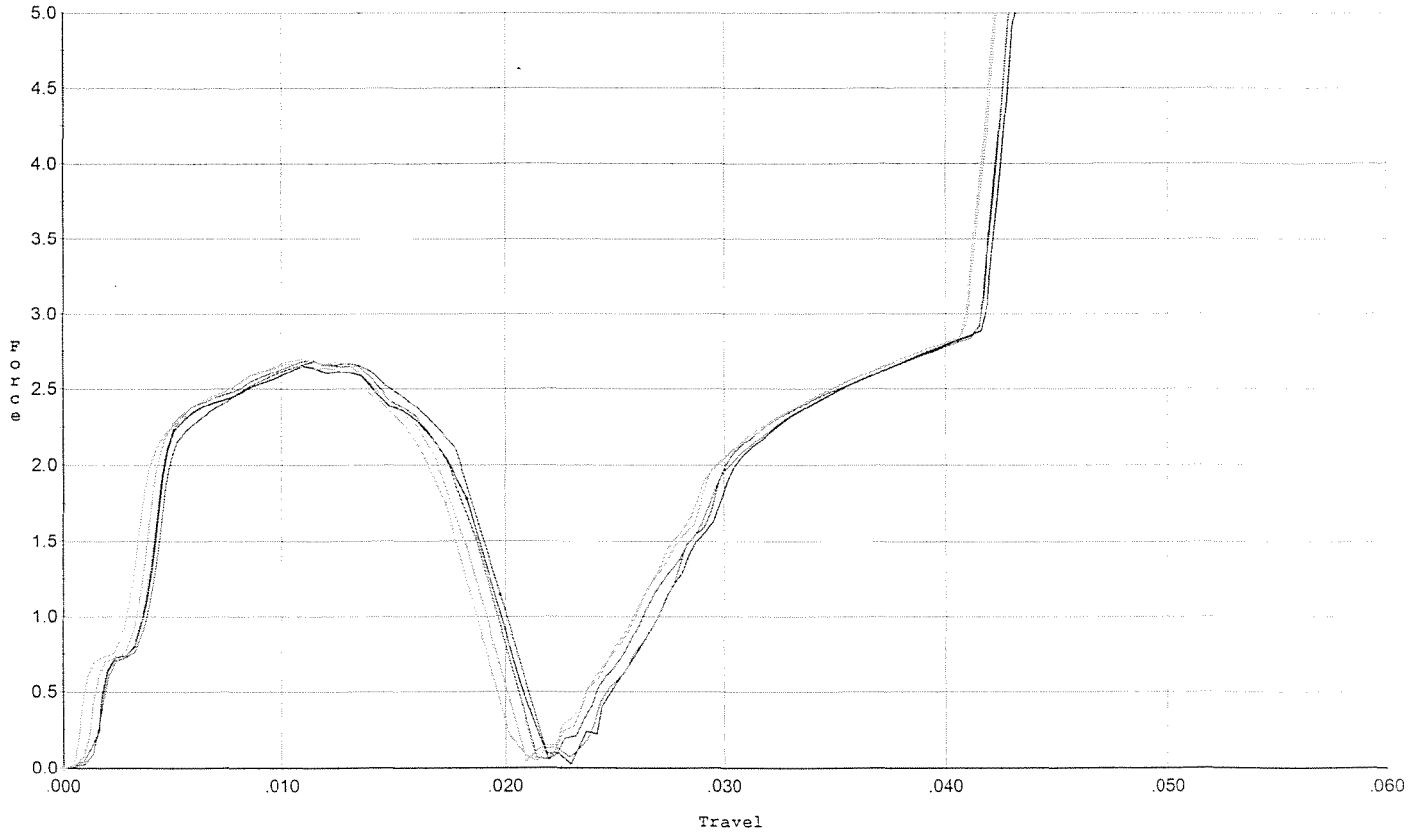
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.181	0.023	0.00	0.026	0.061		Set Trigger
2	4.058	0.020	0.00	0.026	0.056		Set Trigger
3	3.992	0.020	0.00	0.026	0.056		Set Trigger
4	4.119	0.020	0.00	0.026	0.058		Set Trigger
5	4.050	0.022	0.00	0.025	0.059		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: reset to 2.5 lbs +/- .50 lb for final test



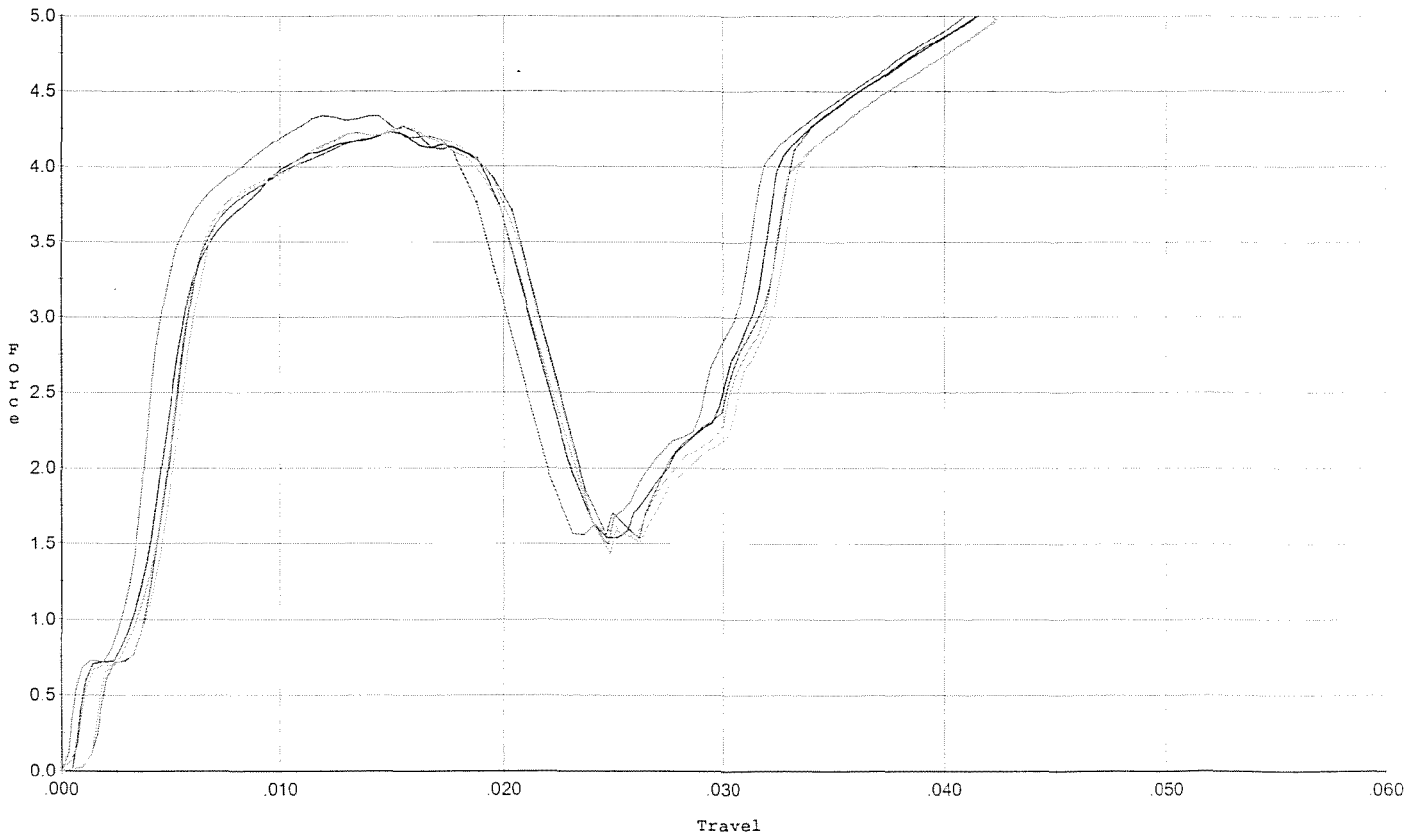
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.680	0.020	0.00	0.029	0.036		Set Trigger
2	2.655	0.018	0.00	0.030	0.034		Set Trigger
3	2.690	0.019	0.00	0.029	0.035		Set Trigger
4	2.669	0.017	0.00	0.029	0.033		Set Trigger
5	2.697	0.018	0.00	0.029	0.035		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.265	0.020	0.00	0.025	0.059		Set Trigger
2	4.234	0.020	0.00	0.025	0.058		Set Trigger
3	4.337	0.019	0.00	0.025	0.057		Set Trigger
4	4.262	0.021	0.00	0.025	0.059		Set Trigger
5	4.274	0.020	0.00	0.026	0.058		Set Trigger

A-4.27