

G 680 1432

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



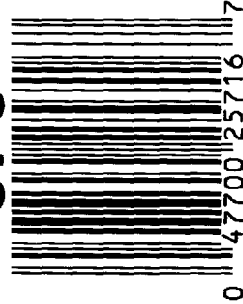
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

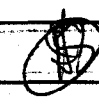
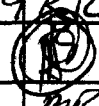
G6801432

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801432

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/9/09	
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/18	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-19-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

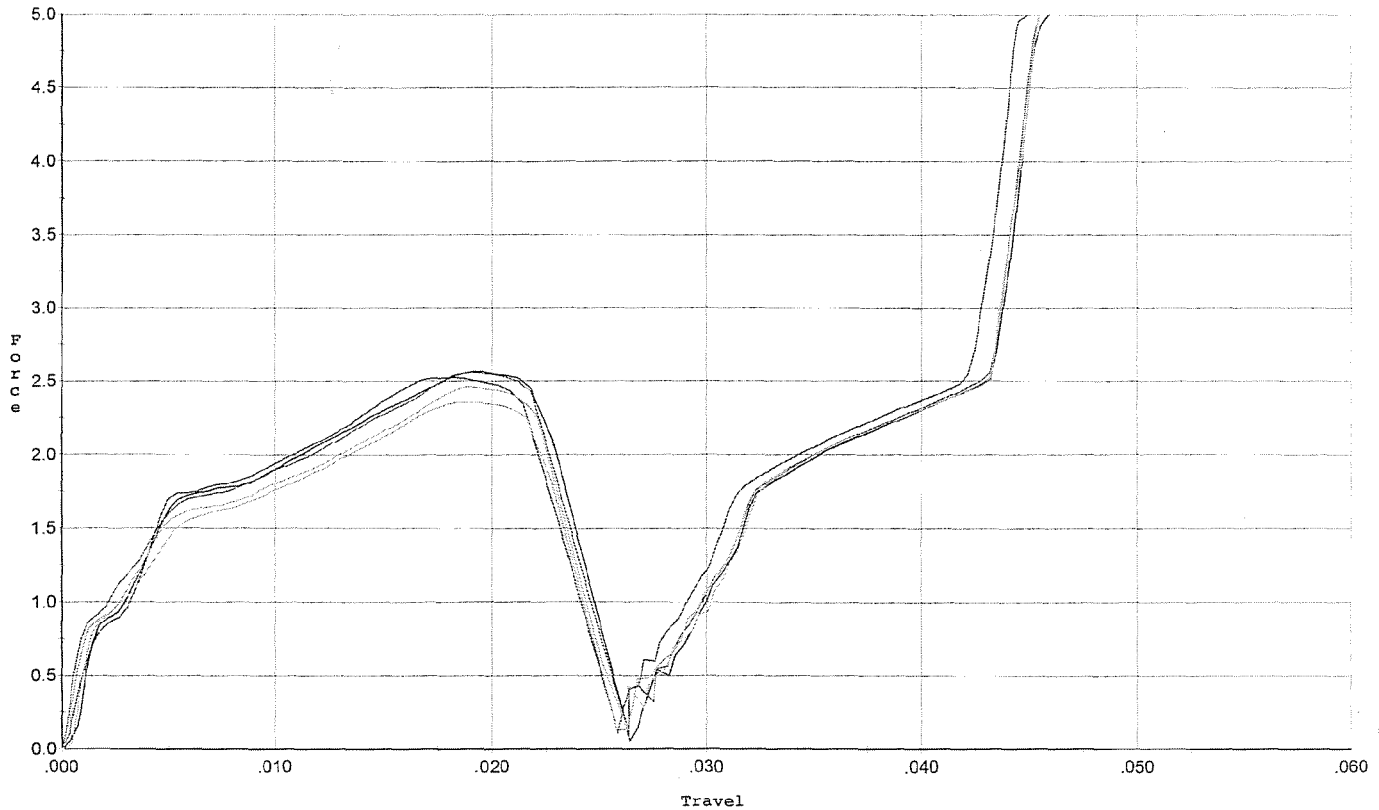
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-23-09	WW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-23-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-23-09	WW
	J) ASSEMBLE STOCK		3-19-09	WW
	K) ASSEMBLE SWIVEL STUDS		3-23-09	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	3-20-09	WW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-20-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-23-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.23</u> <u>2.29</u> <u>2.29</u> <u>2.32</u> <u>2.20</u>	2-23-09	KL
	C) FUNCTION		3-23-09	WW
690	PACK		3/25/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



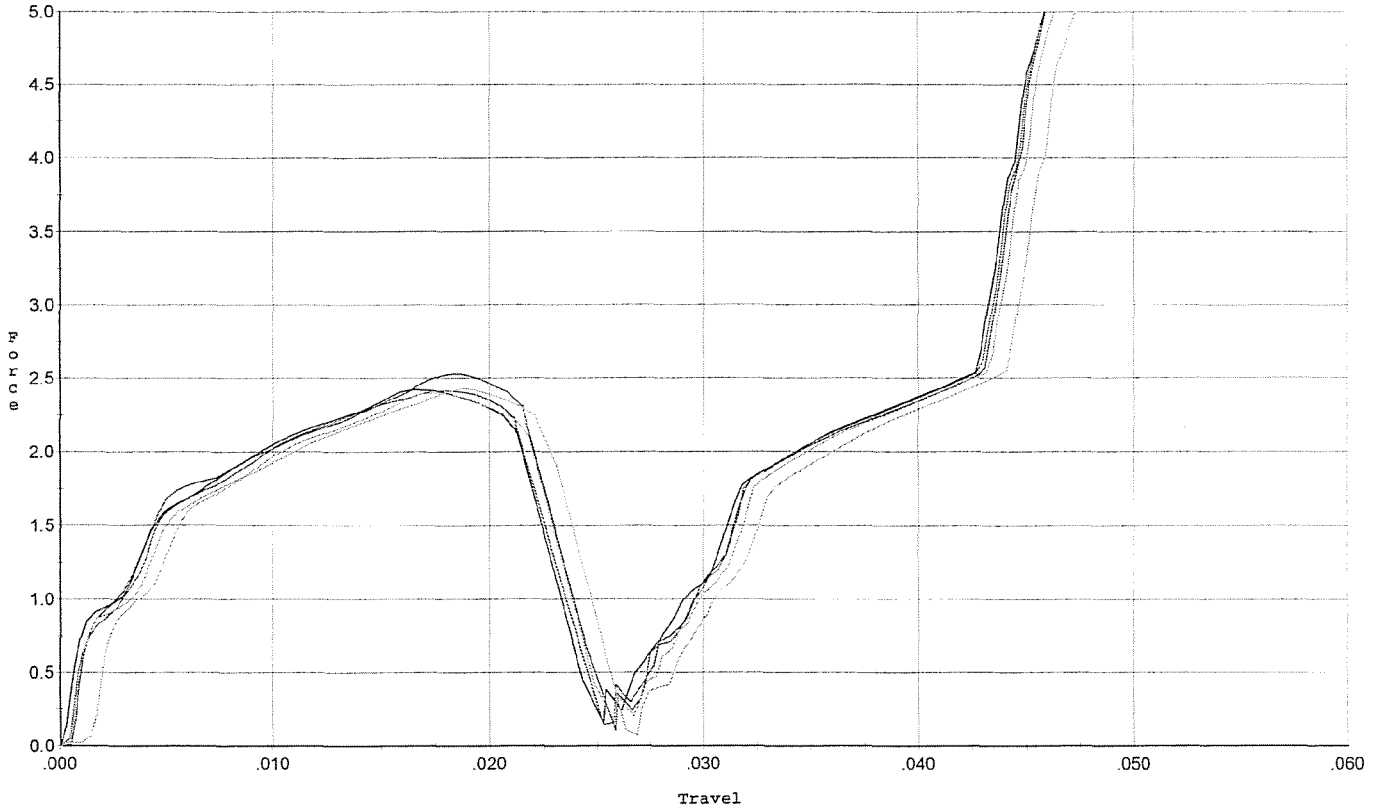
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.526	0.024	0.00	0.029	0.042		Set Trigger
2	2.568	0.023	0.00	0.029	0.041		Set Trigger
3	2.562	0.022	0.00	0.030	0.040		Set Trigger
4	2.463	0.022	0.00	0.030	0.038		Set Trigger
5	2.358	0.023	0.00	0.030	0.038		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



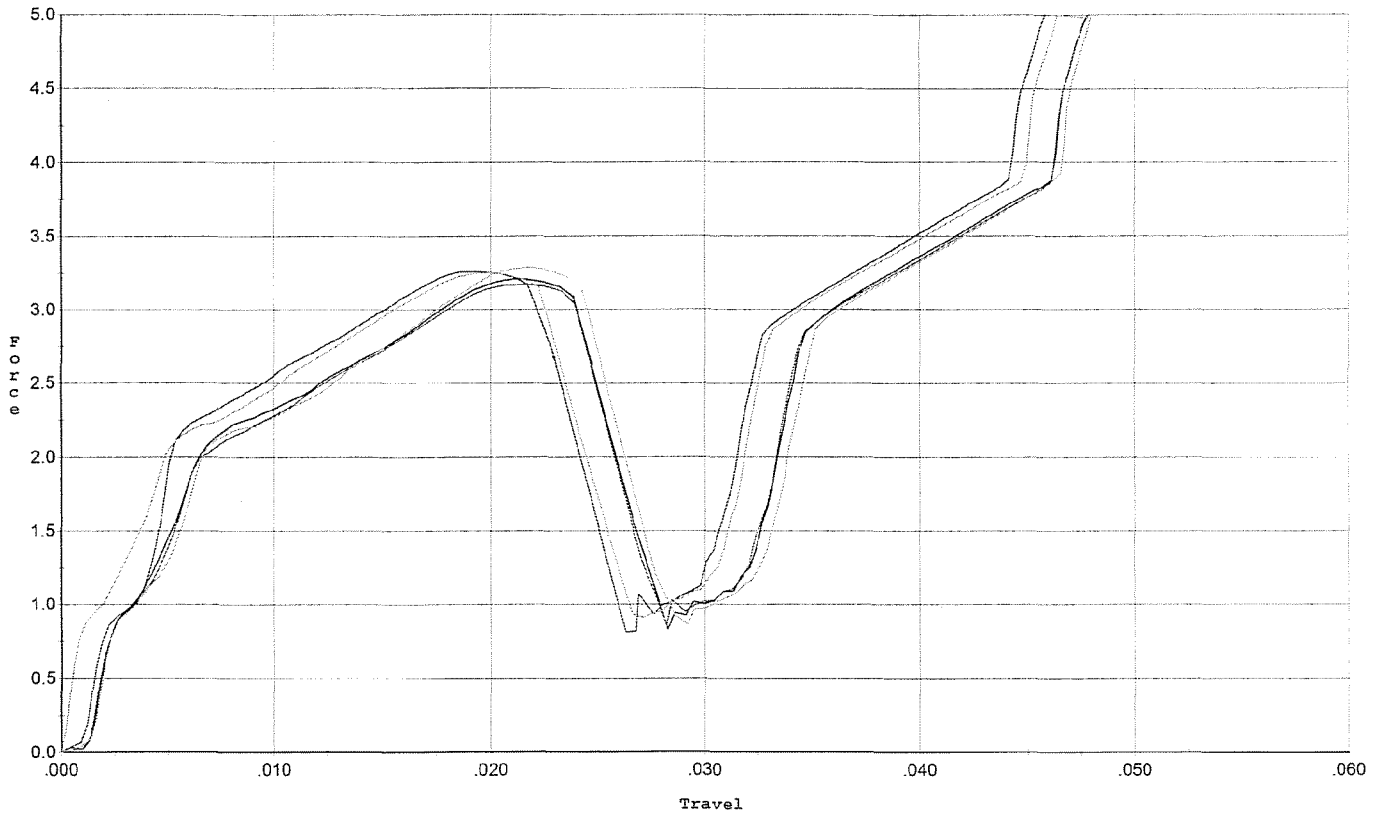
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.530	0.021	0.00	0.030	0.039		Set Trigger
2	2.420	0.021	0.00	0.030	0.038		Set Trigger
3	2.418	0.021	0.00	0.030	0.037		Set Trigger
4	2.432	0.023	0.00	0.030	0.039		Set Trigger
5	2.401	0.022	0.00	0.030	0.038		Set Trigger

A. 2.44

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



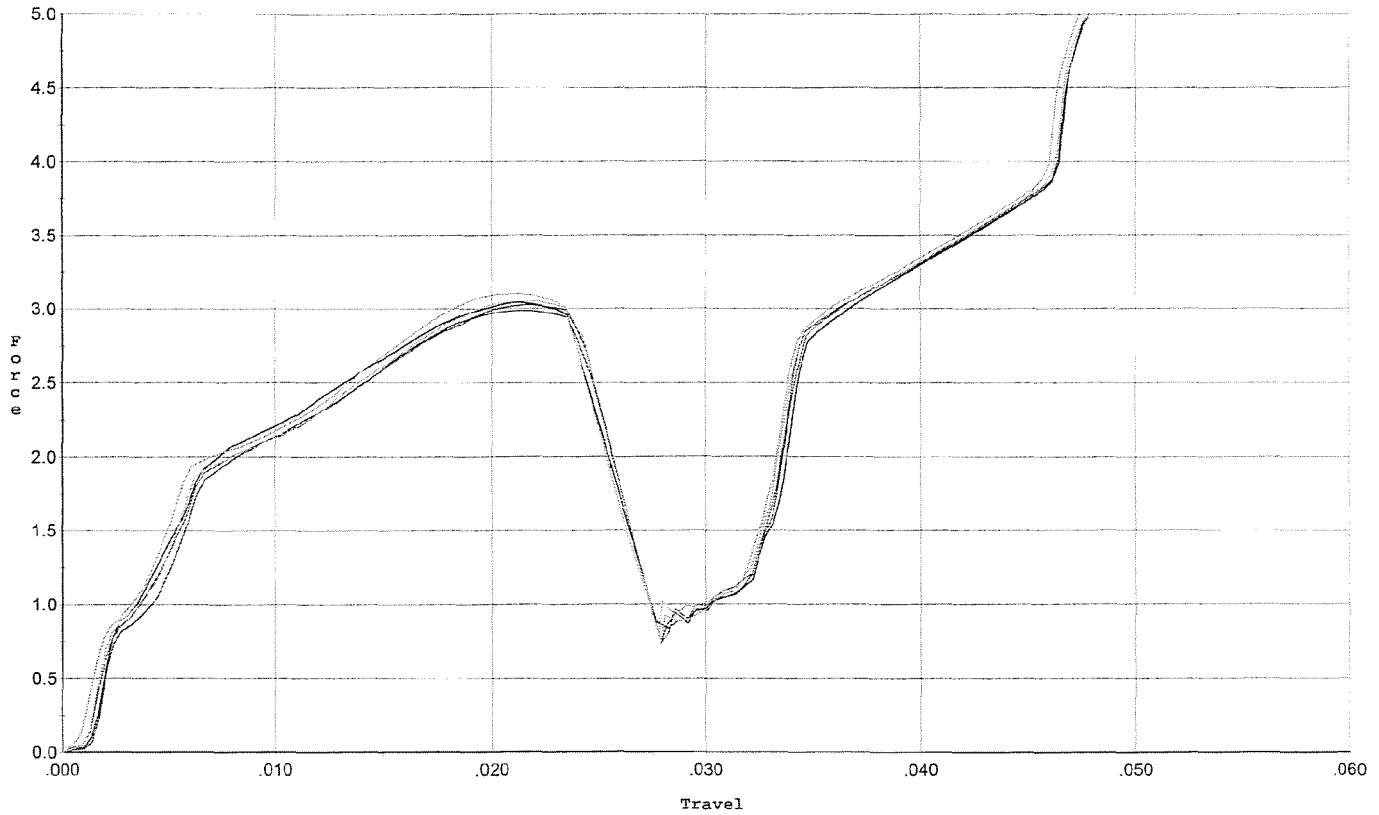
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.023	0.00	0.028	0.051		Set Trigger
2	3.207	0.024	0.00	0.028	0.051		Set Trigger
3	3.173	0.024	0.00	0.028	0.051		Set Trigger
4	3.285	0.024	0.00	0.024	0.052		Set Trigger
5	3.251	0.022	0.00	0.028	0.051		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



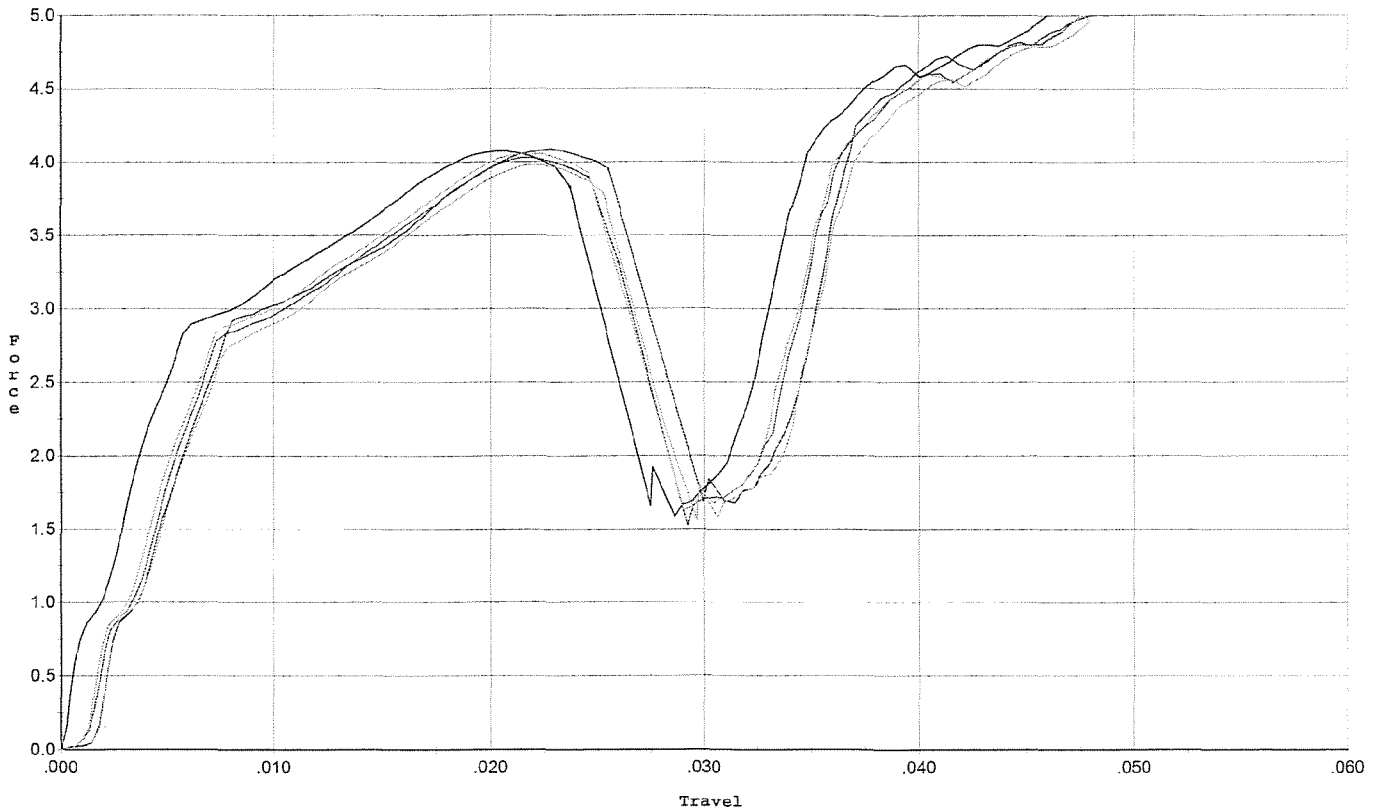
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.023	0.024	0.00	0.028	0.049		Set Trigger
2	3.039	0.026	0.00	0.028	0.052		Set Trigger
3	2.987	0.025	0.00	0.028	0.050		Set Trigger
4	3.050	0.024	0.00	0.028	0.050		Set Trigger
5	3.102	0.023	0.00	0.028	0.049		Set Trigger

A-3.04

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



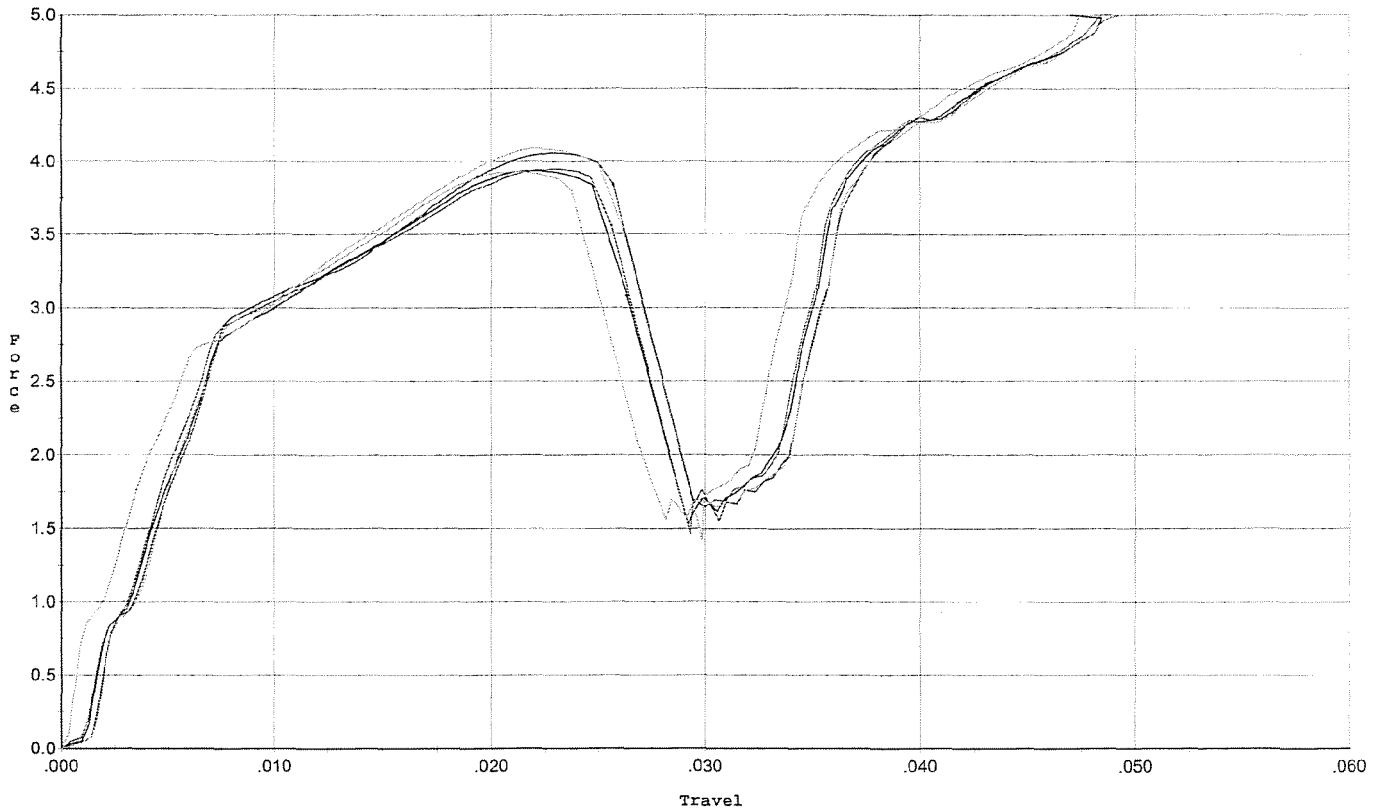
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.090	0.025	0.00	0.021	0.069		Set Trigger
2	4.075	0.024	0.00	0.021	0.068		Set Trigger
3	4.029	0.026	0.00	0.021	0.070		Set Trigger
4	4.058	0.026	0.00	0.021	0.073		Set Trigger
5	3.986	0.025	0.00	0.021	0.067		Set Trigger

A 4.04

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



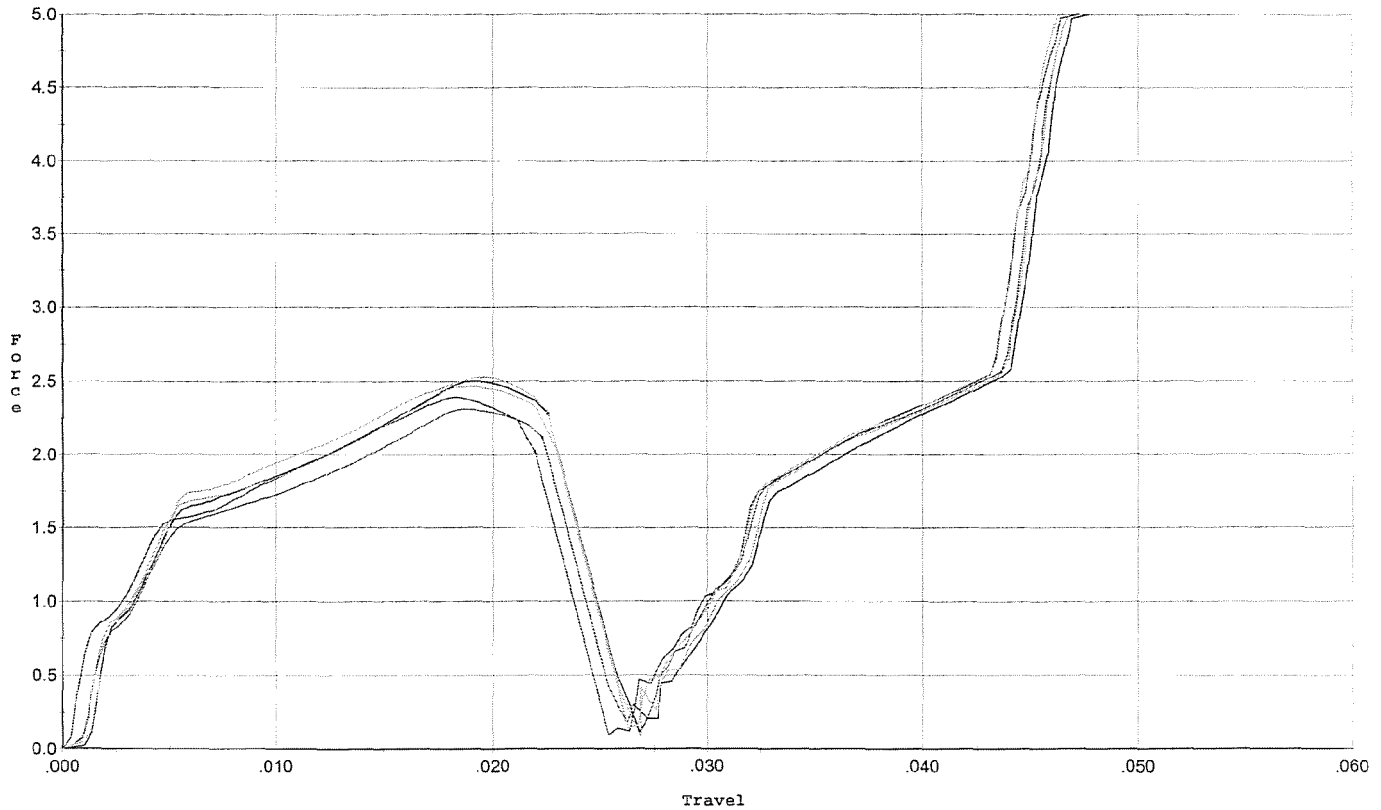
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.057	0.026	0.00	0.021	0.070		Set Trigger
2	3.931	0.026	0.00	0.022	0.071		Set Trigger
3	3.945	0.026	0.00	0.022	0.070		Set Trigger
4	4.085	0.026	0.00	0.021	0.072		Set Trigger
5	3.928	0.024	0.00	0.022	0.066		Set Trigger

A-3.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



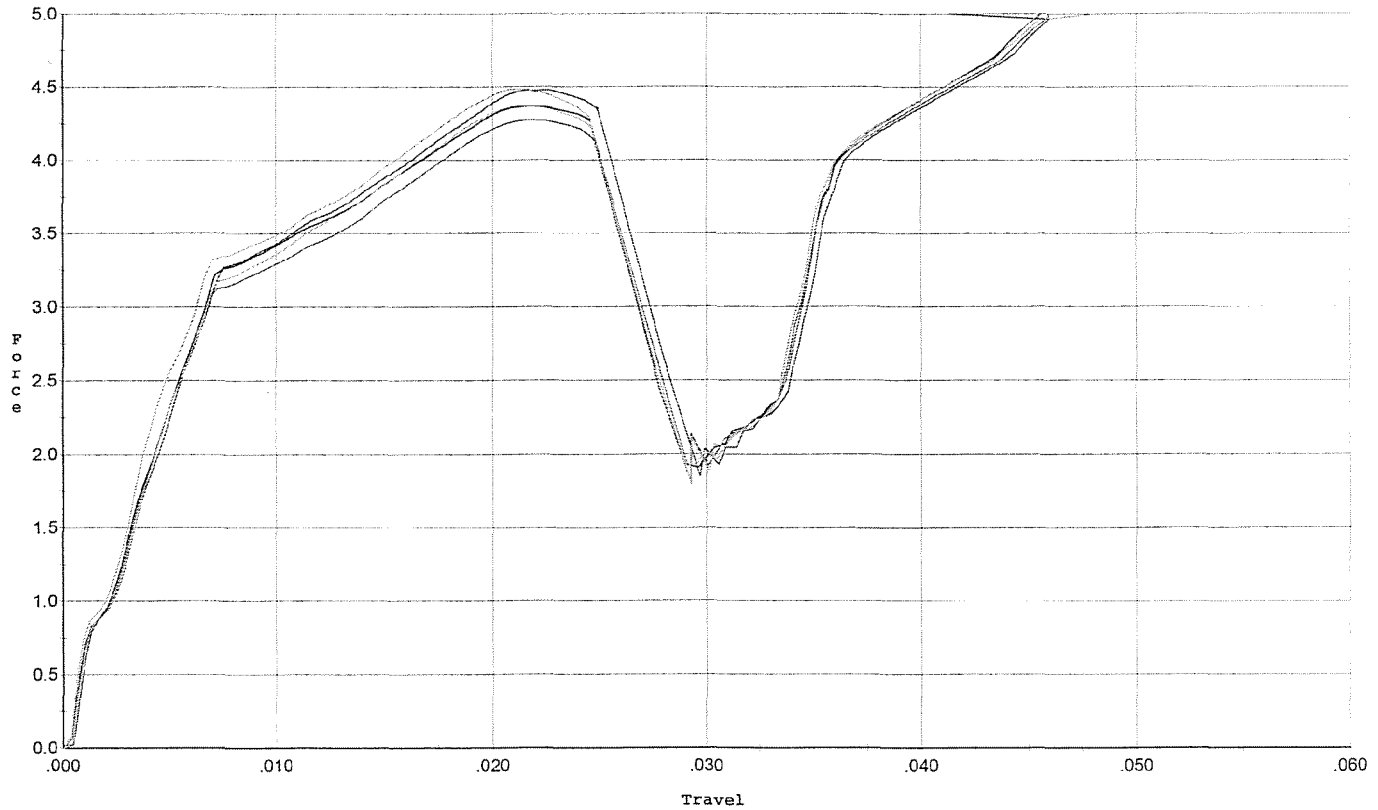
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.395	0.022	0.00	0.030	0.037		Set Trigger
2	2.501	0.023	0.00	0.030	0.039		Set Trigger
3	2.311	0.022	0.00	0.030	0.036		Set Trigger
4	2.464	0.023	0.00	0.029	0.039		Set Trigger
5	2.528	0.023	0.00	0.030	0.040		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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	4.478	0.025	0.00	0.020	0.077		Set Trigger
2	4.369	0.024	0.00	0.020	0.075		Set Trigger
3	4.276	0.025	0.00	0.020	0.074		Set Trigger
4	4.372	0.025	0.00	0.020	0.074		Set Trigger
5	4.486	0.024	0.00	0.020	0.077		Set Trigger

A-4-39