

6680 1456

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



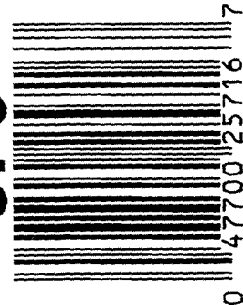
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801456

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 1456

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO 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	R12
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	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	TZ
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 2.60 LBS +/- .5 LBS			

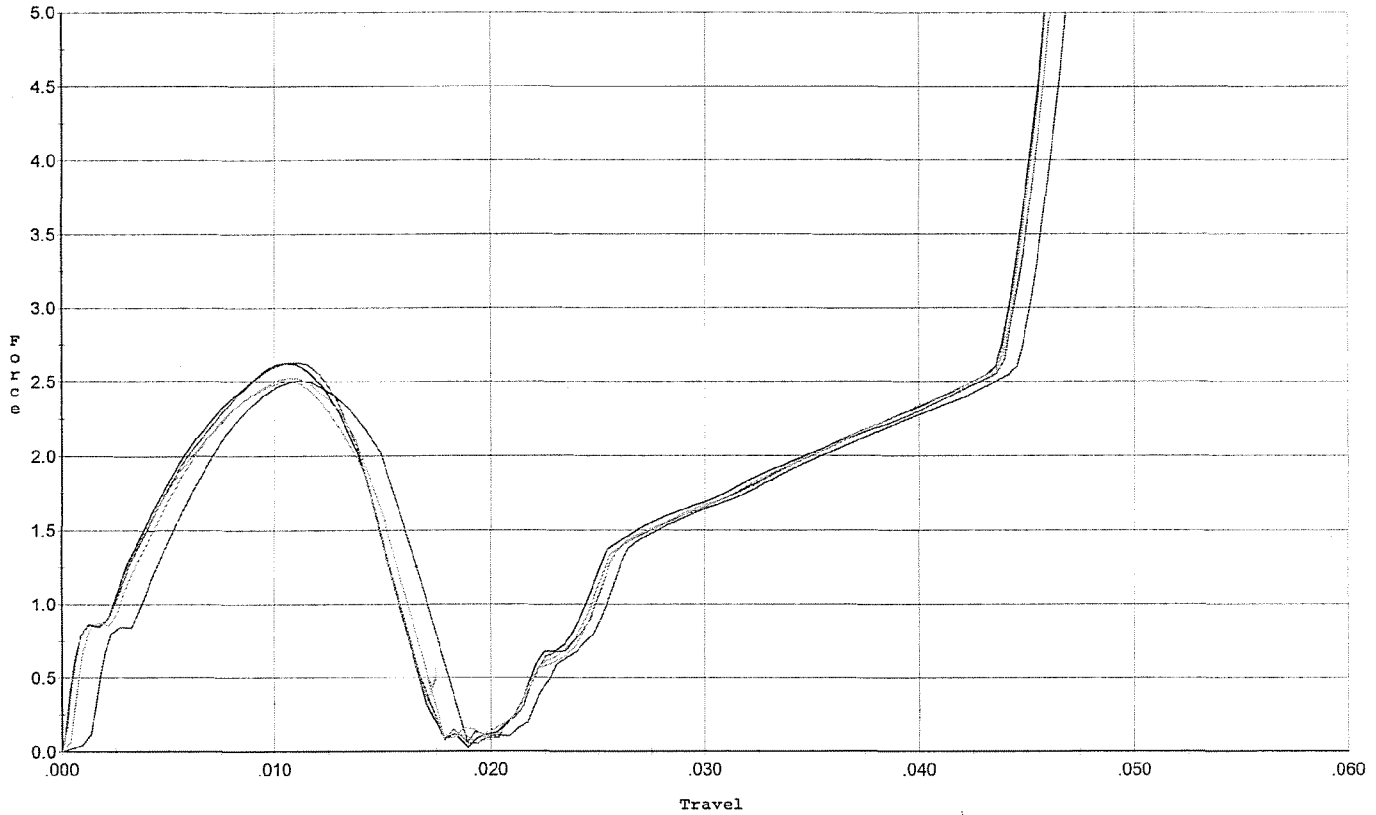
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>6</u>	3-23-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3</u>	3-23-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-23-09	WV
	J) ASSEMBLE STOCK		3-18-09	L J.
	K) ASSEMBLE SWIVEL STUDS		3-23-09	WV
	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	3-23-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-23-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.44</u> <u>2.42</u> <u>2.47</u> <u>2.48</u>	3-23-09	TC
	C) FUNCTION		3-23-09	WV
690	PACK		3/25/09	Fm

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



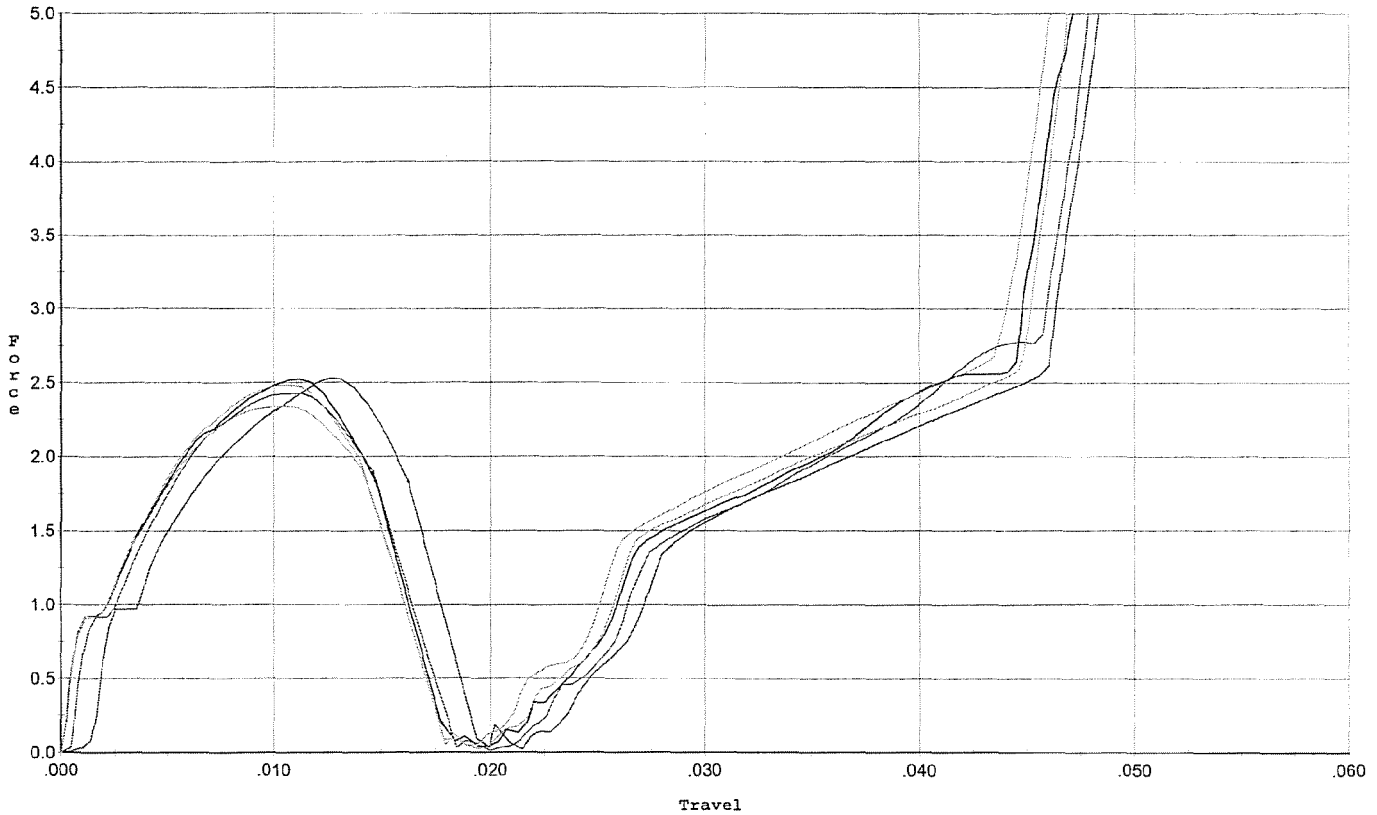
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.509	0.017	0.00	0.035	0.026		Set Trigger
2	2.626	0.014	0.00	0.036	0.025		Set Trigger
3	2.631	0.014	0.00	0.036	0.025		Set Trigger
4	2.526	0.015	0.00	0.035	0.026		Set Trigger
5	2.504	0.014	0.00	0.036	0.024		Set Trigger

A-2.55

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



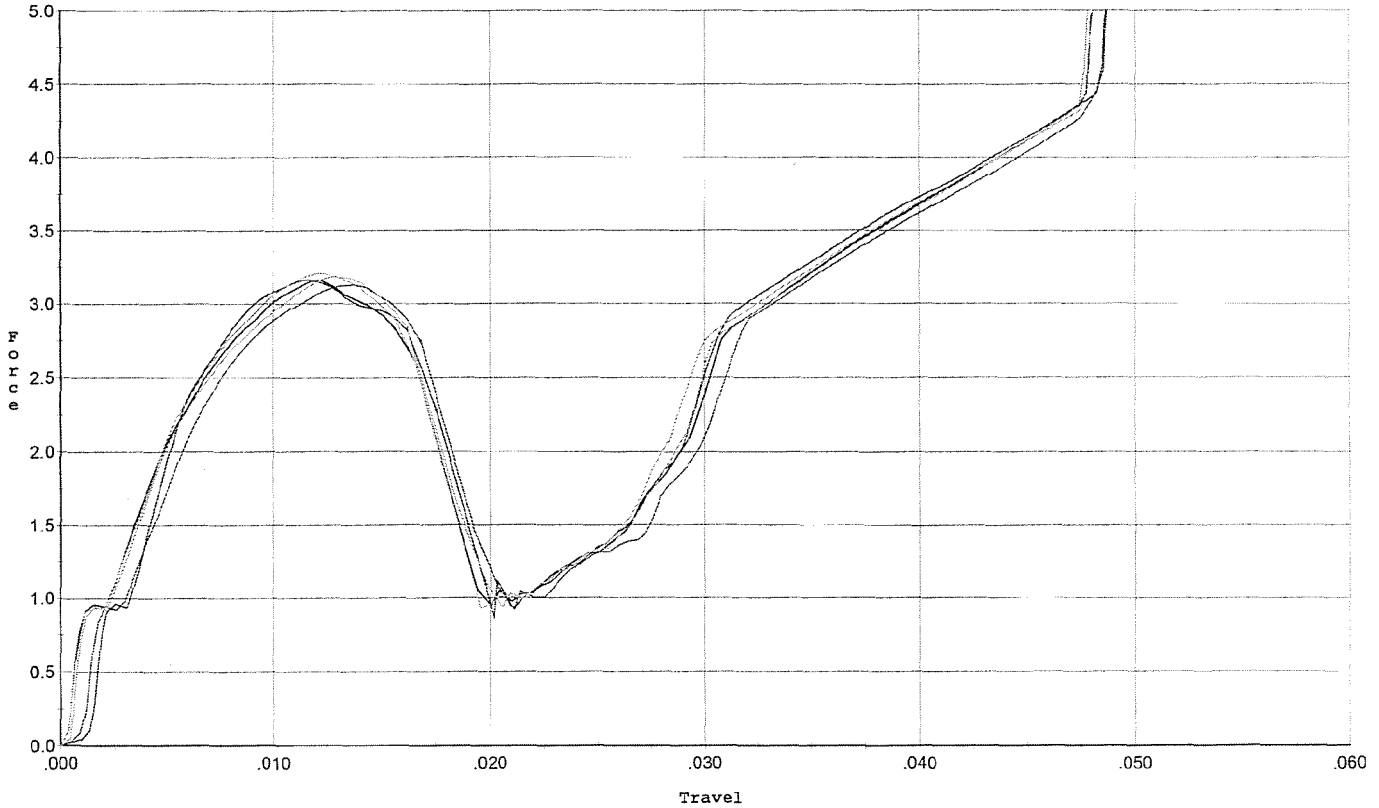
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.016	0.004	0.036	0.026		Set Trigger
2	2.524	0.015	0.00	0.036	0.026		Set Trigger
3	2.428	0.015	0.00	0.037	0.025		Set Trigger
4	2.482	0.016	0.00	0.036	0.027		Set Trigger
5	2.345	0.016	0.00	0.035	0.026		Set Trigger

A-2.46

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



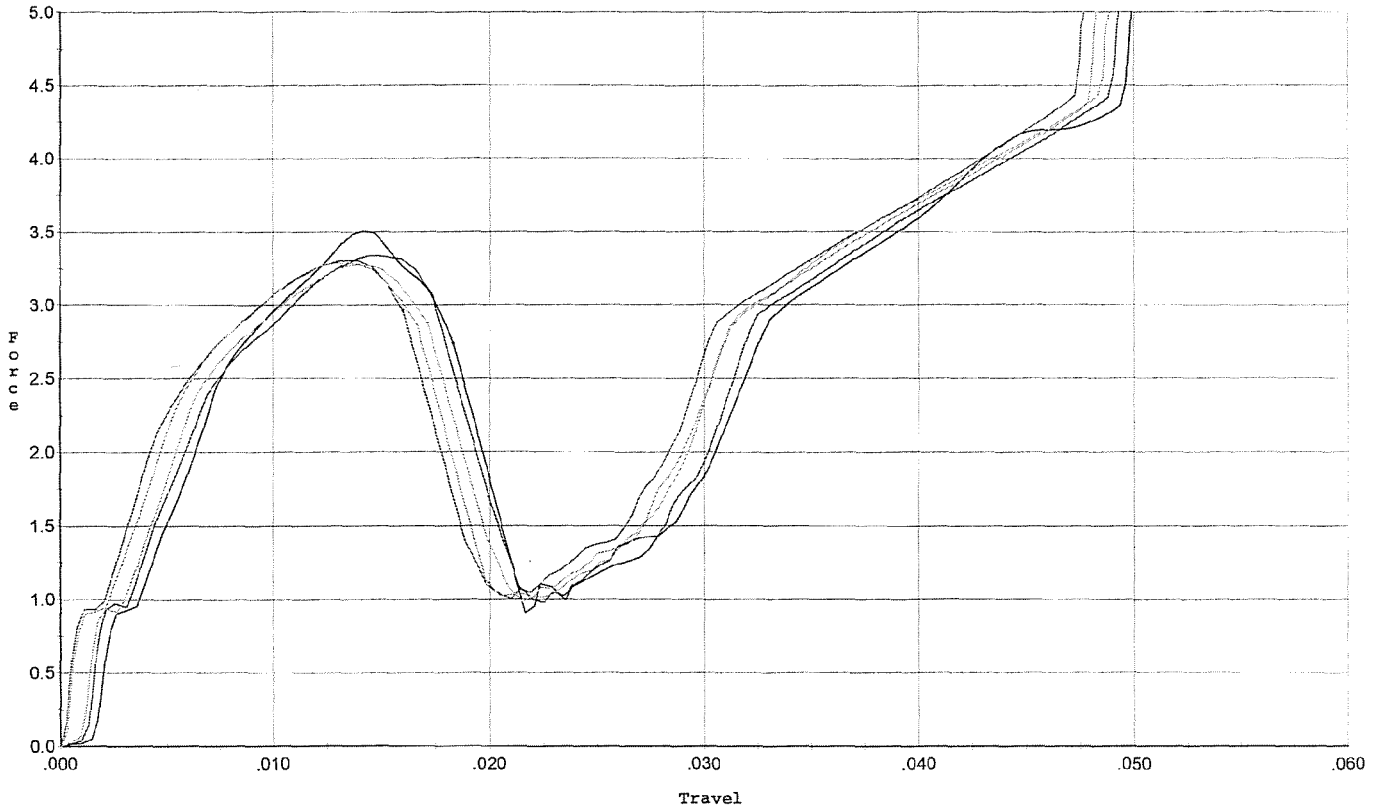
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.163	0.018	0.00	0.033	0.037		Set Trigger
2	3.161	0.017	0.00	0.033	0.036		Set Trigger
3	3.129	0.017	0.00	0.033	0.035		Set Trigger
4	3.208	0.017	0.00	0.033	0.036		Set Trigger
5	3.182	0.016	0.00	0.032	0.035		Set Trigger

A-3-16

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



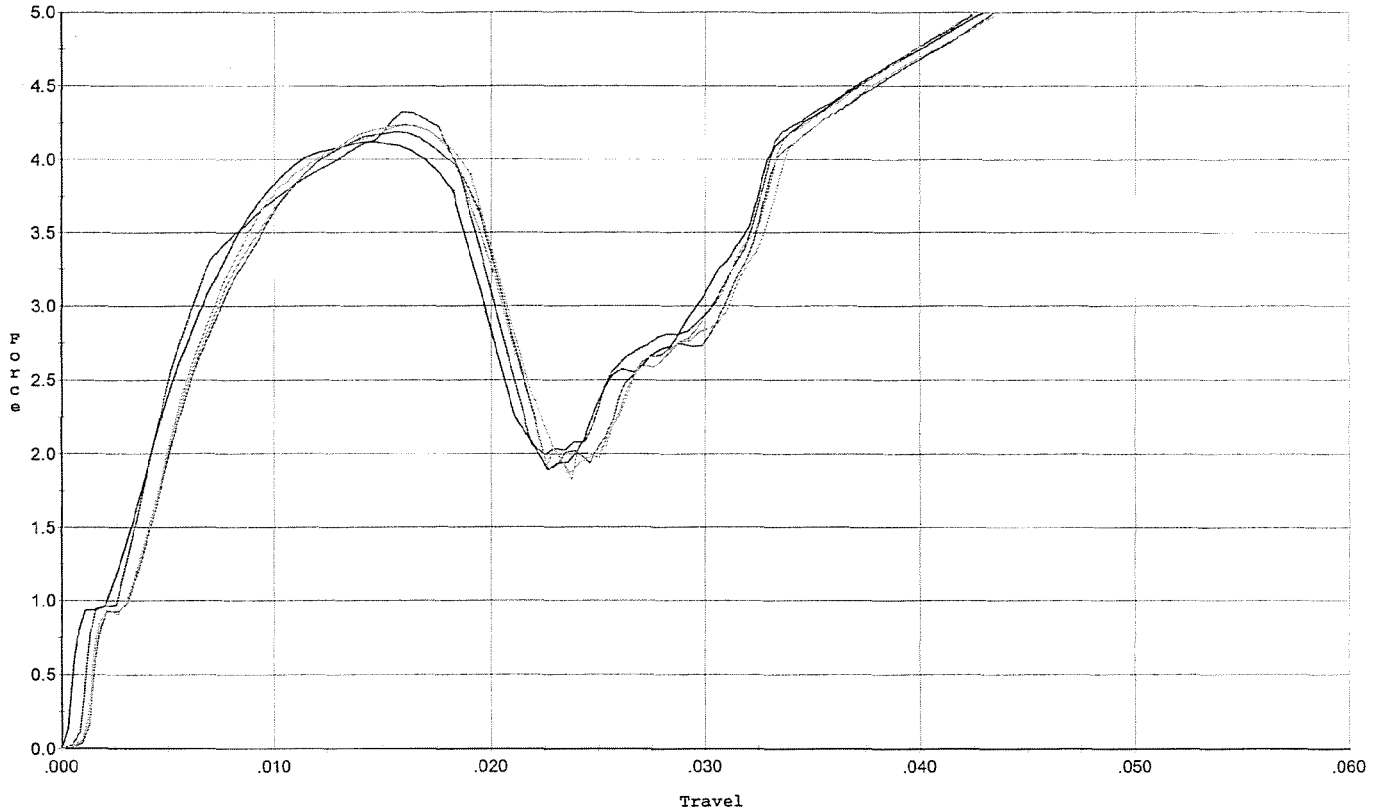
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.333	0.017	0.00	0.033	0.038		Set Trigger
2	3.505	0.018	0.00	0.033	0.039		Set Trigger
3	3.307	0.016	0.00	0.032	0.036		Set Trigger
4	3.277	0.017	0.00	0.032	0.037		Set Trigger
5	3.291	0.017	0.00	0.032	0.038		Set Trigger

A-3-34

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



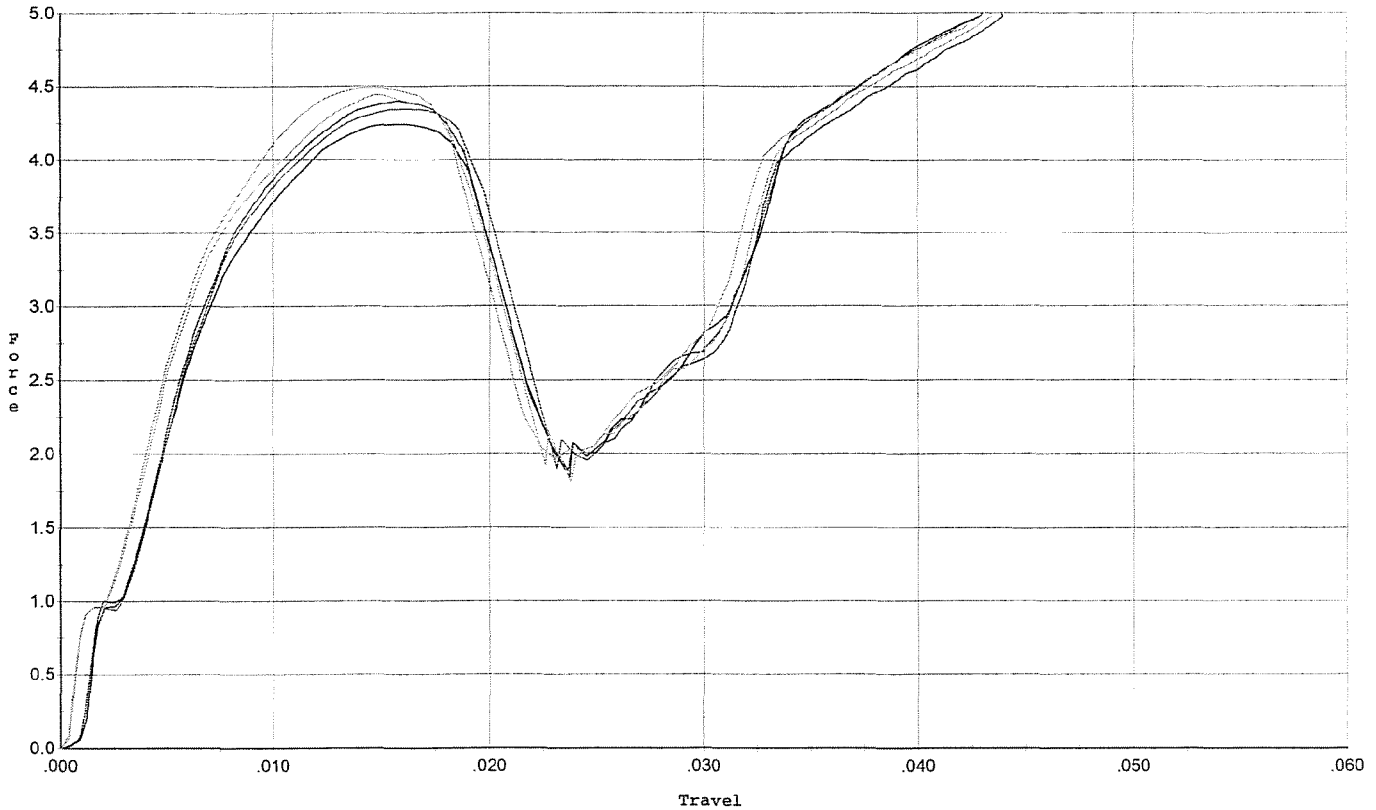
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.322	0.019	0.00	0.030	0.053		Set Trigger
2	4.120	0.018	0.00	0.030	0.051		Set Trigger
3	4.186	0.019	0.00	0.030	0.053		Set Trigger
4	4.233	0.020	0.00	0.030	0.055		Set Trigger
5	4.238	0.019	0.00	0.030	0.052		Set Trigger

A. 4.22

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



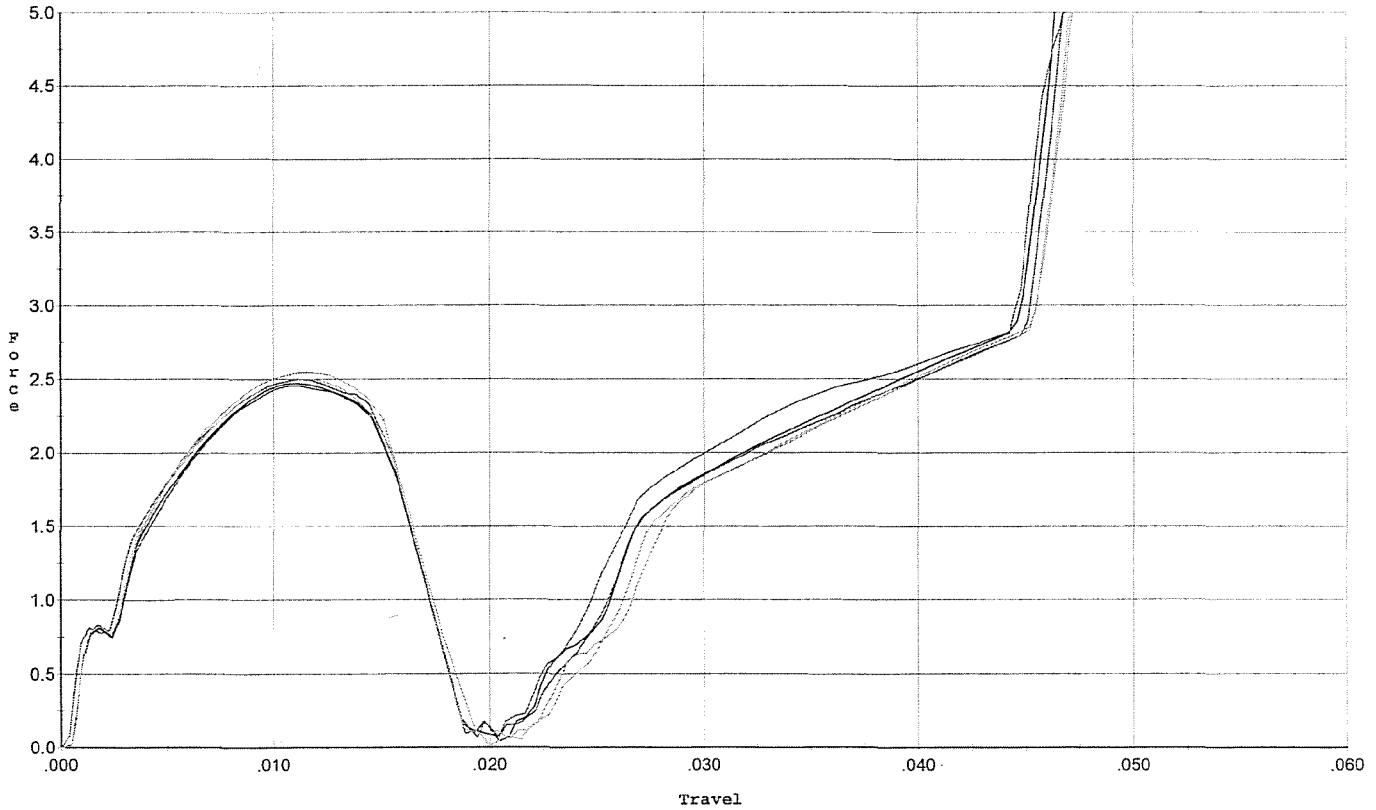
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.400	0.019	0.00	0.030	0.054		Set Trigger
2	4.244	0.019	0.00	0.030	0.053		Set Trigger
3	4.340	0.020	0.00	0.030	0.057		Set Trigger
4	4.445	0.019	0.00	0.029	0.058		Set Trigger
5	4.489	0.018	0.00	0.030	0.055		Set Trigger

A-4-38

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



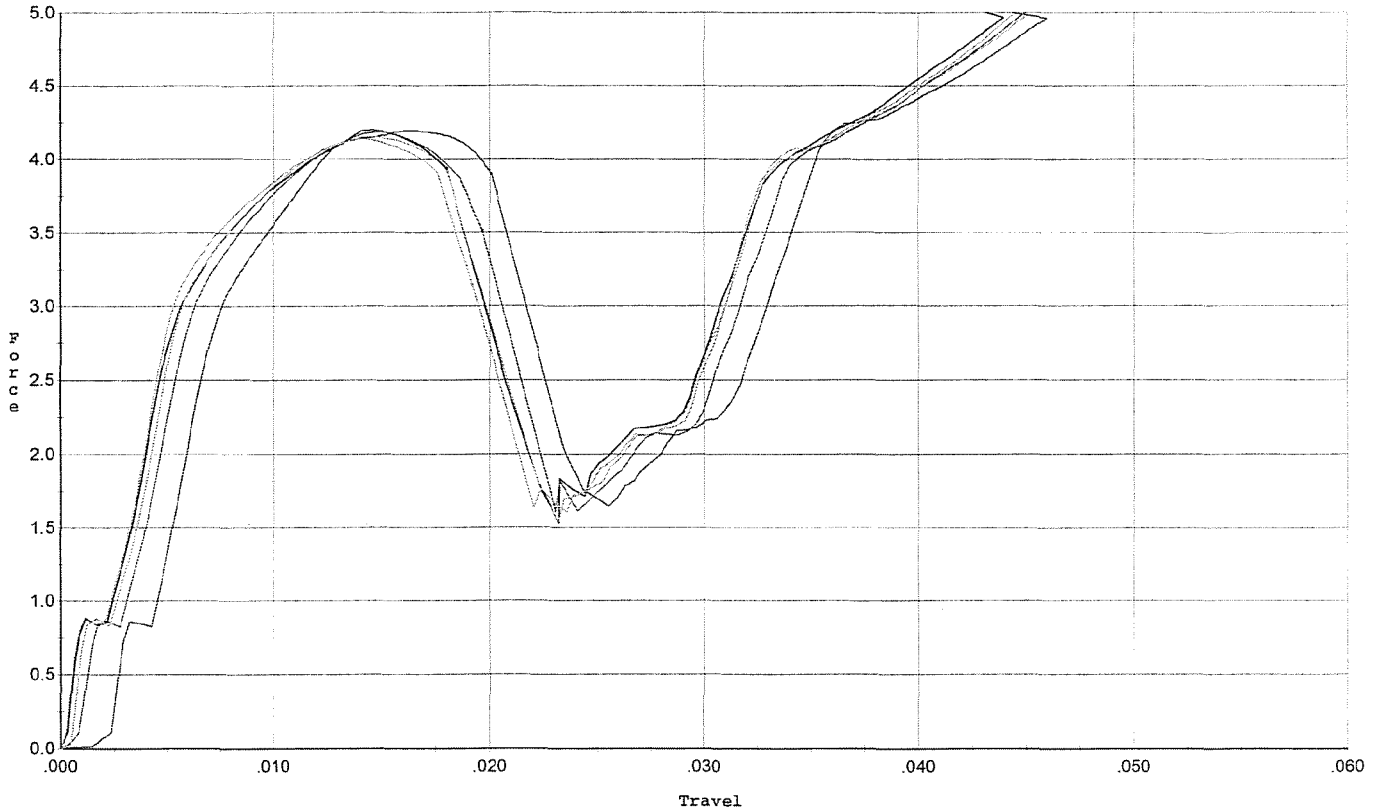
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.455	0.016	0.00	0.035	0.027		Set Trigger
2	2.472	0.016	0.00	0.035	0.027		Set Trigger
3	2.499	0.015	0.00	0.034	0.027		Set Trigger
4	2.501	0.015	0.00	0.035	0.027		Set Trigger
5	2.545	0.015	0.00	0.035	0.027		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: 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	4.192	0.020	0.003	0.031	0.054		Set Trigger
2	4.199	0.018	0.00	0.030	0.051		Set Trigger
3	4.183	0.020	0.00	0.030	0.055		Set Trigger
4	4.152	0.018	0.00	0.030	0.051		Set Trigger
5	4.137	0.019	0.00	0.030	0.055		Set Trigger

A-4.17