

1
G6801458

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



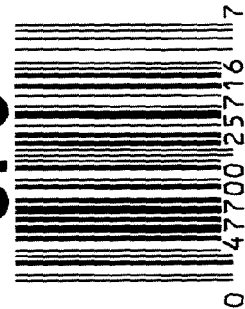
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801458

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801458

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	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	EJECTOR (H)	3/9/09	(N)
490	MAGNAFLUX BOLT			
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)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-31-09	L.H.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

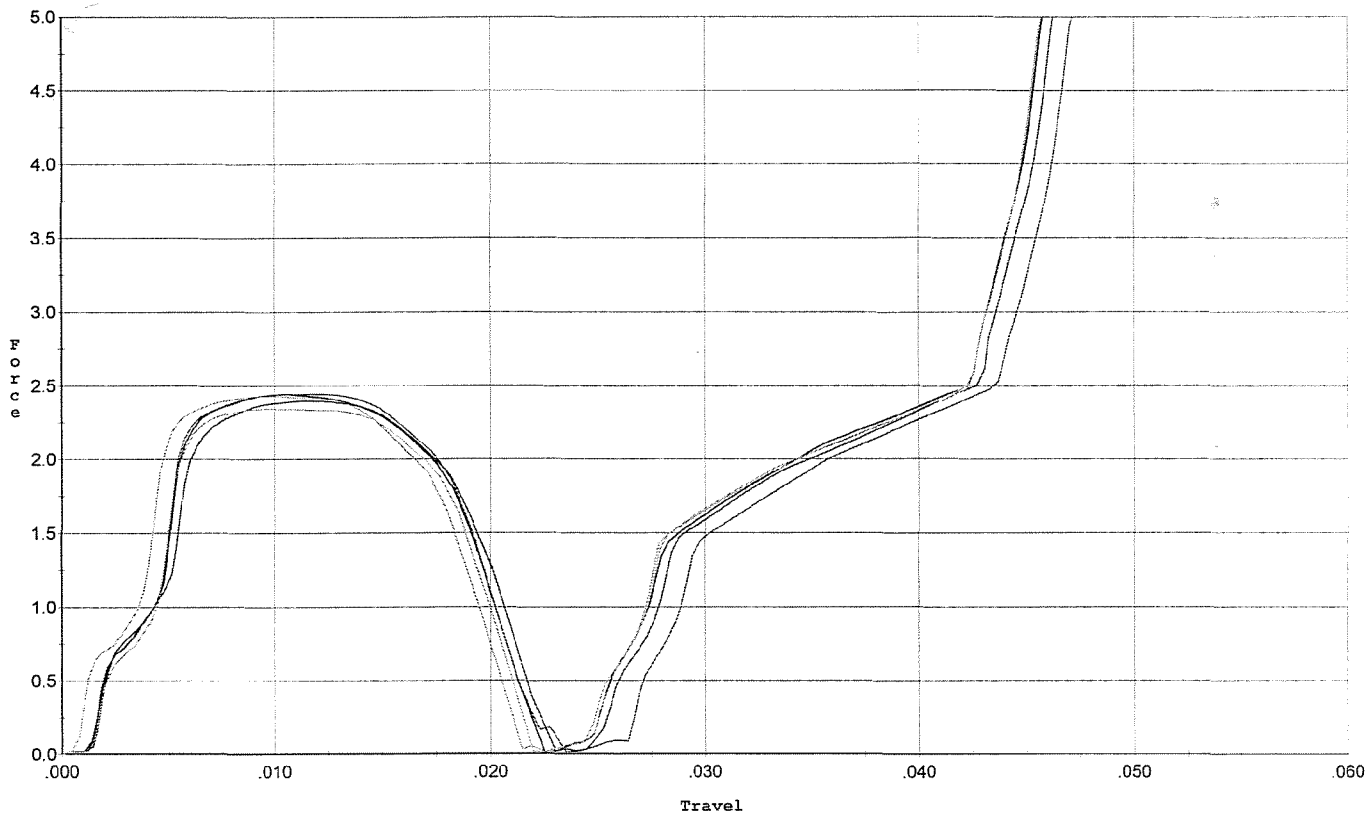
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	4-1-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-1-09	WV
	J) ASSEMBLE STOCK		3-31-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-1-09	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	3-31-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.74</u> <u>2.64</u> <u>2.60</u> <u>2.63</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		5/28/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



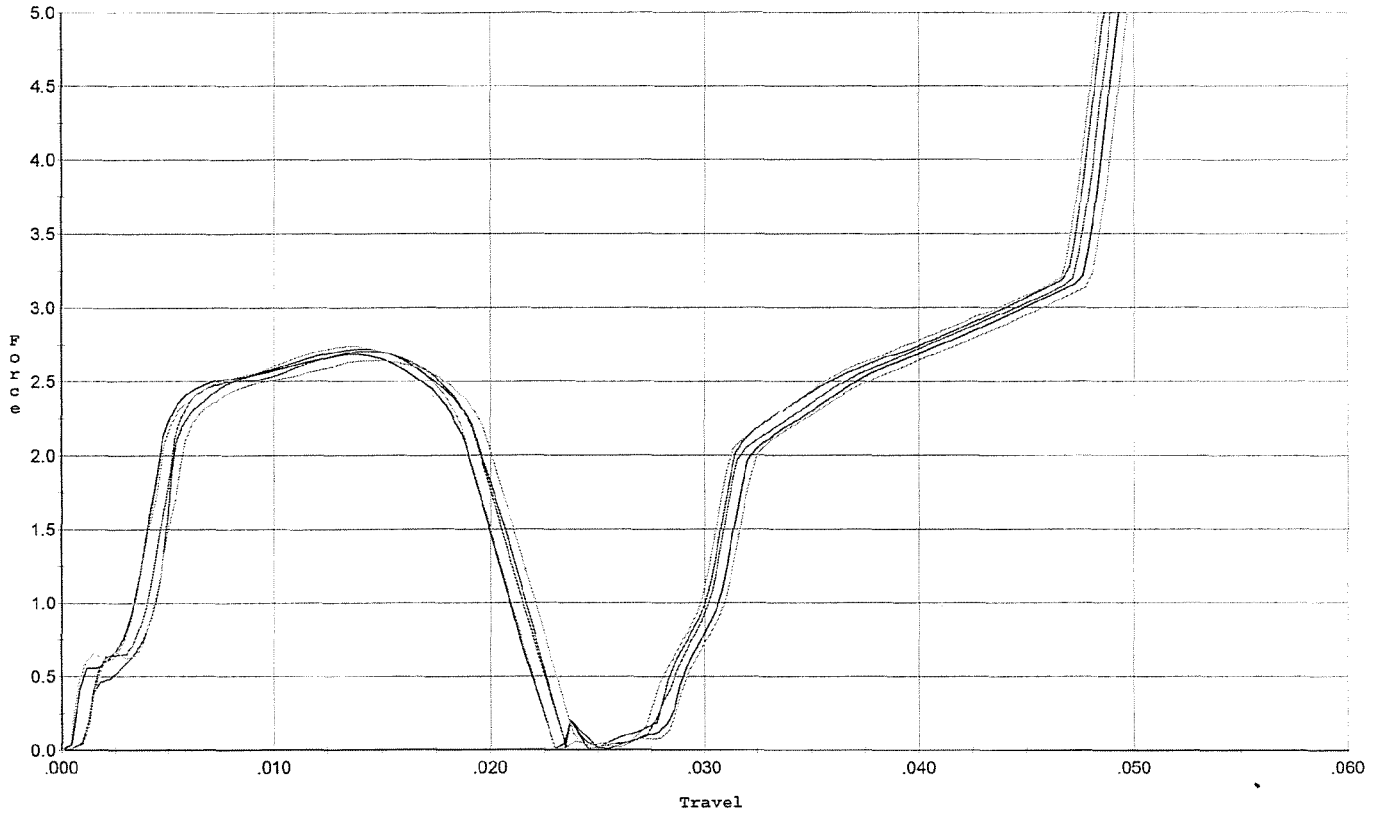
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.399	0.020	0.00	0.031	0.033		Set Trigger
2	2.442	0.019	0.00	0.031	0.033		Set Trigger
3	2.443	0.019	0.00	0.033	0.033		Set Trigger
4	2.342	0.020	0.00	0.031	0.033		Set Trigger
5	2.427	0.019	0.00	0.032	0.034		Set Trigger

A-2-41

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



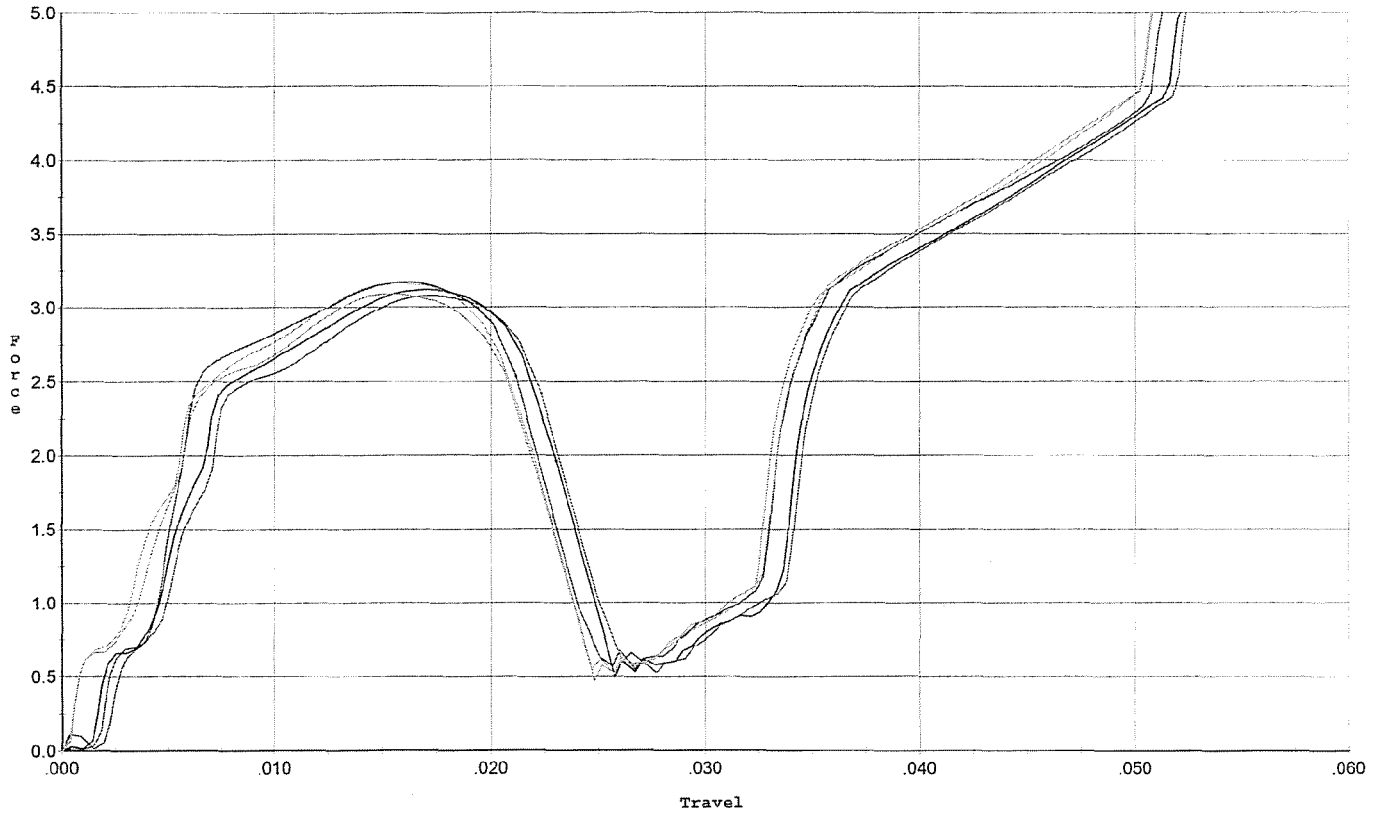
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.718	0.021	0.00	0.032	0.039		Set Trigger
2	2.685	0.019	0.00	0.034	0.037		Set Trigger
3	2.704	0.019	0.00	0.033	0.037		Set Trigger
4	2.738	0.019	0.00	0.033	0.037		Set Trigger
5	2.642	0.022	0.00	0.033	0.040		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



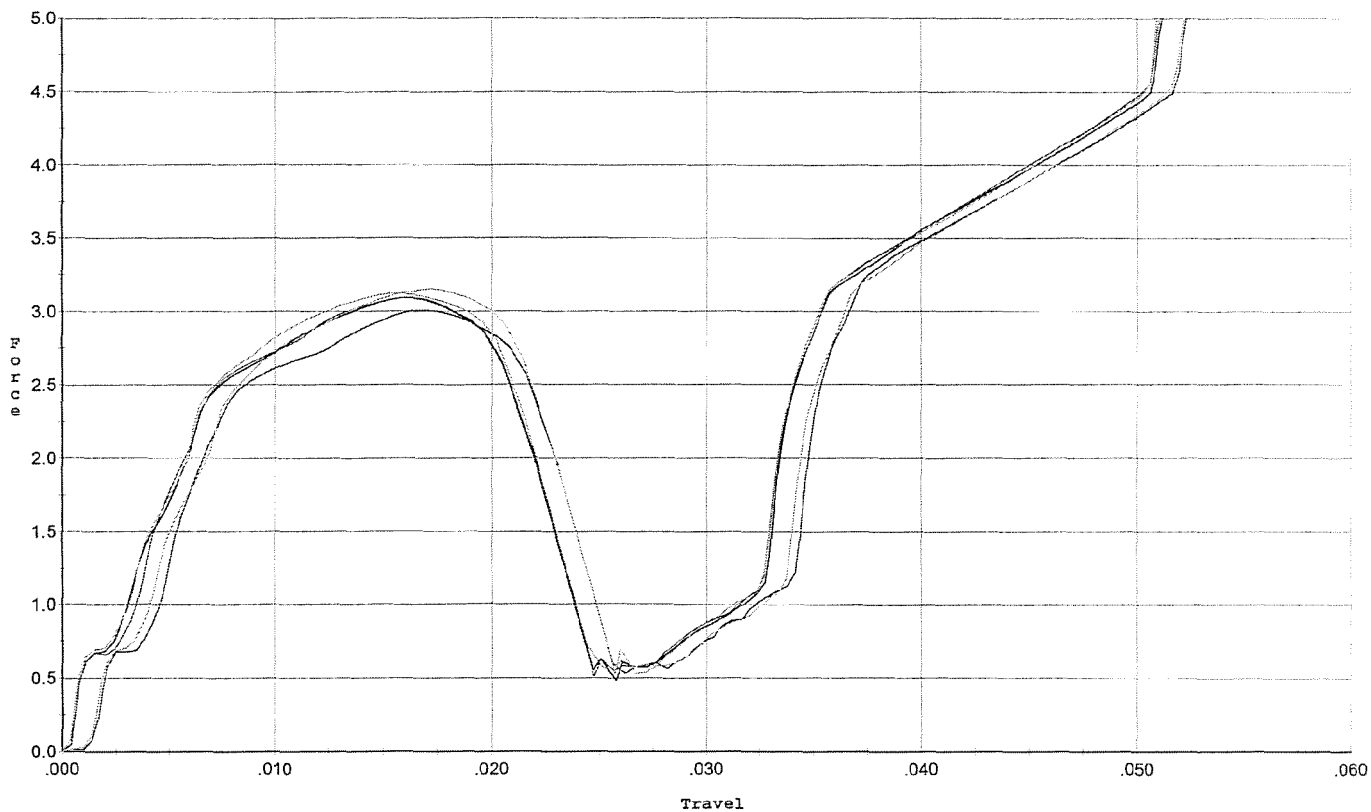
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.170	0.021	0.002	0.033	0.046		Set Trigger
2	3.116	0.023	0.00	0.034	0.048		Set Trigger
3	3.077	0.022	0.00	0.034	0.046		Set Trigger
4	3.165	0.022	0.00	0.033	0.049		Set Trigger
5	3.090	0.022	0.00	0.033	0.048		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



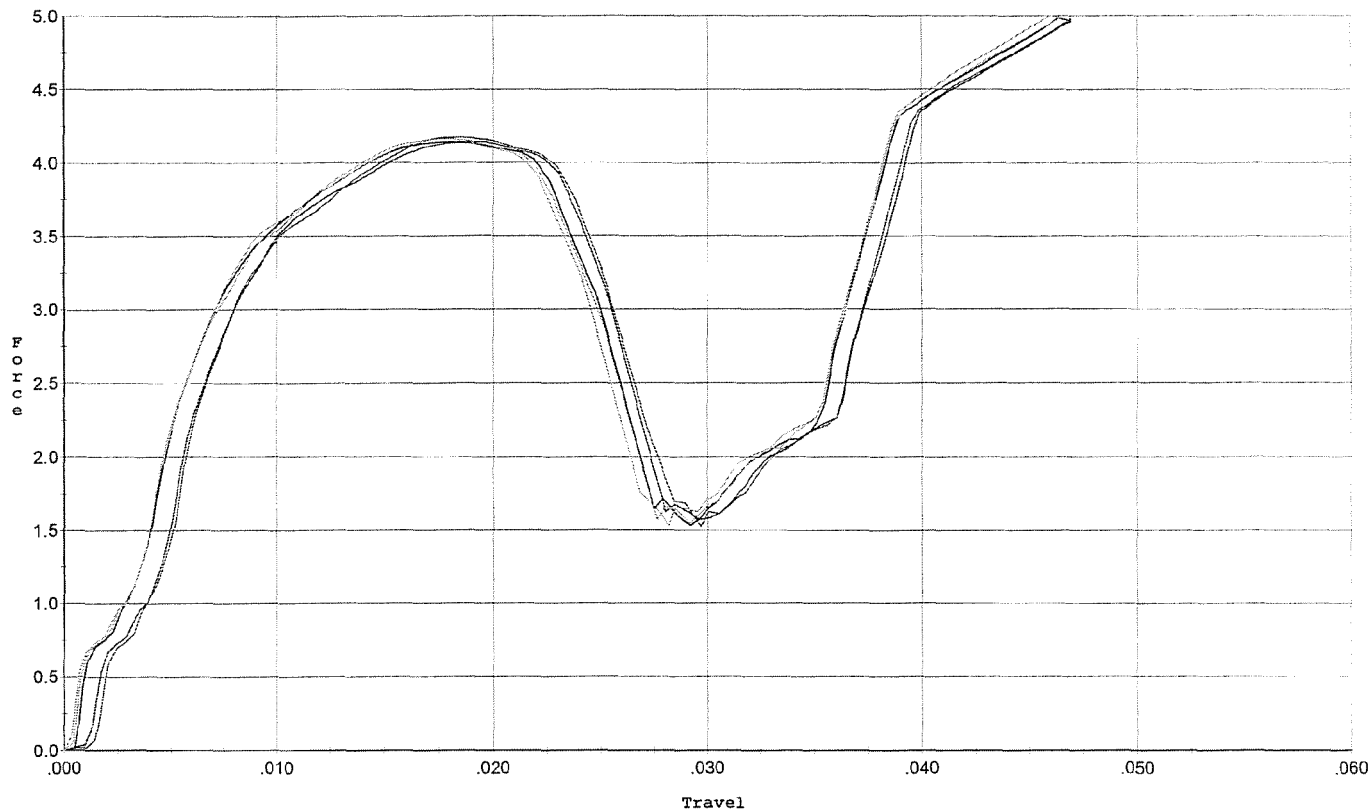
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.007	0.023	0.00	0.034	0.047		Set Trigger
2	3.092	0.022	0.00	0.033	0.048		Set Trigger
3	3.091	0.022	0.00	0.033	0.048		Set Trigger
4	3.153	0.023	0.00	0.034	0.049		Set Trigger
5	3.123	0.022	0.00	0.033	0.048		Set Trigger

A-3-09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



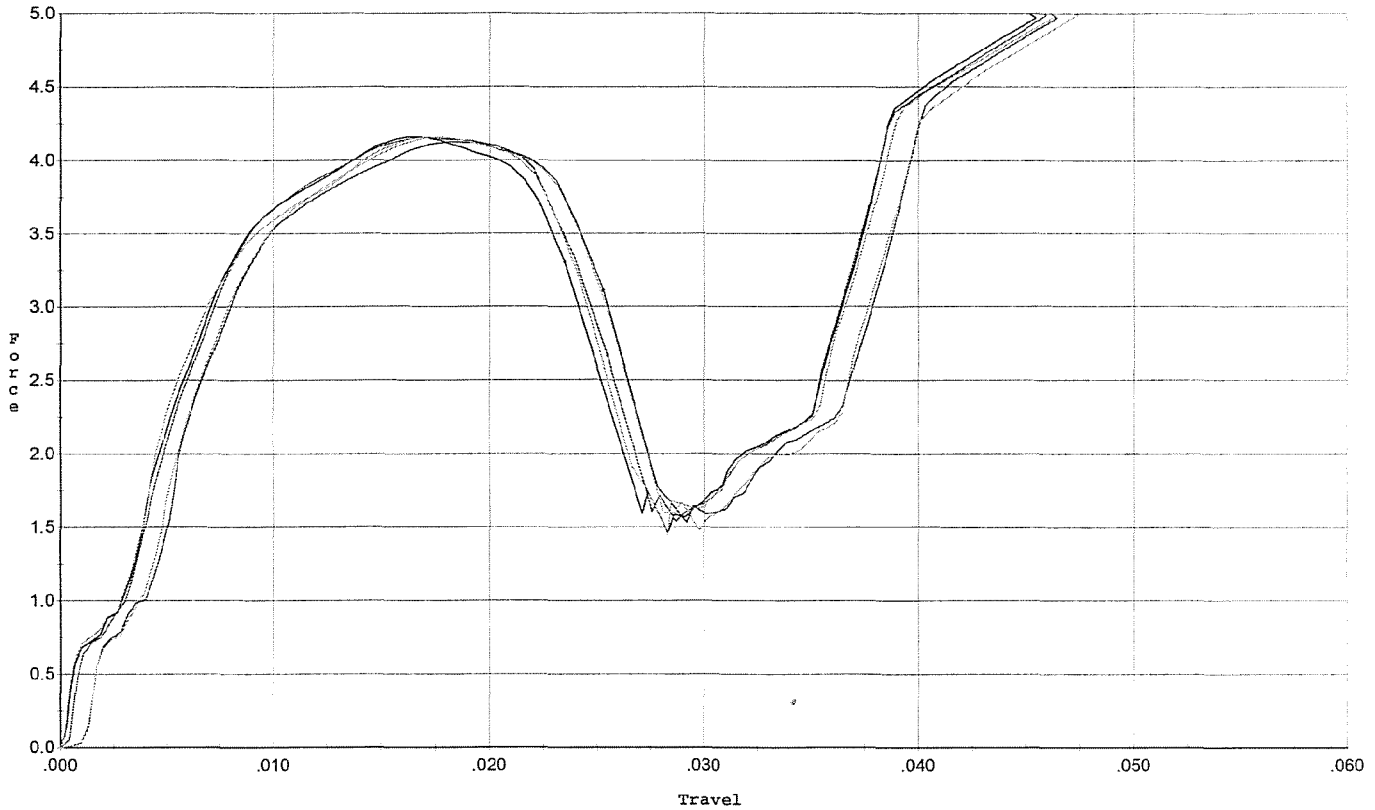
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.143	0.025	0.00	0.031	0.071		Set Trigger
2	4.142	0.025	0.00	0.030	0.072		Set Trigger
3	4.172	0.025	0.00	0.031	0.071		Set Trigger
4	4.162	0.024	0.00	0.030	0.070		Set Trigger
5	4.164	0.025	0.00	0.030	0.073		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



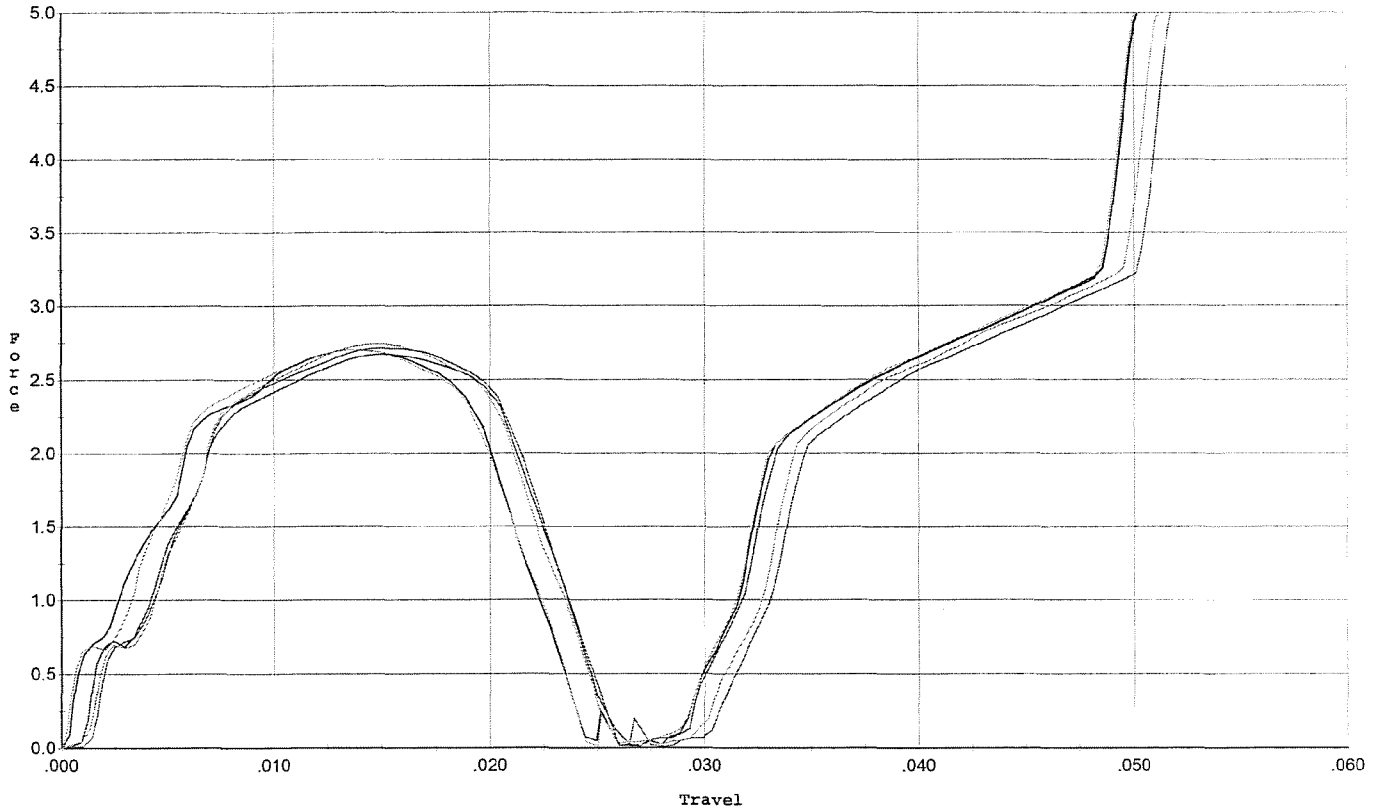
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.124	0.025	0.00	0.031	0.071		Set Trigger
2	4.158	0.023	0.00	0.031	0.068		Set Trigger
3	4.155	0.025	0.00	0.030	0.074		Set Trigger
4	4.156	0.025	0.00	0.031	0.072		Set Trigger
5	4.158	0.024	0.00	0.031	0.071		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



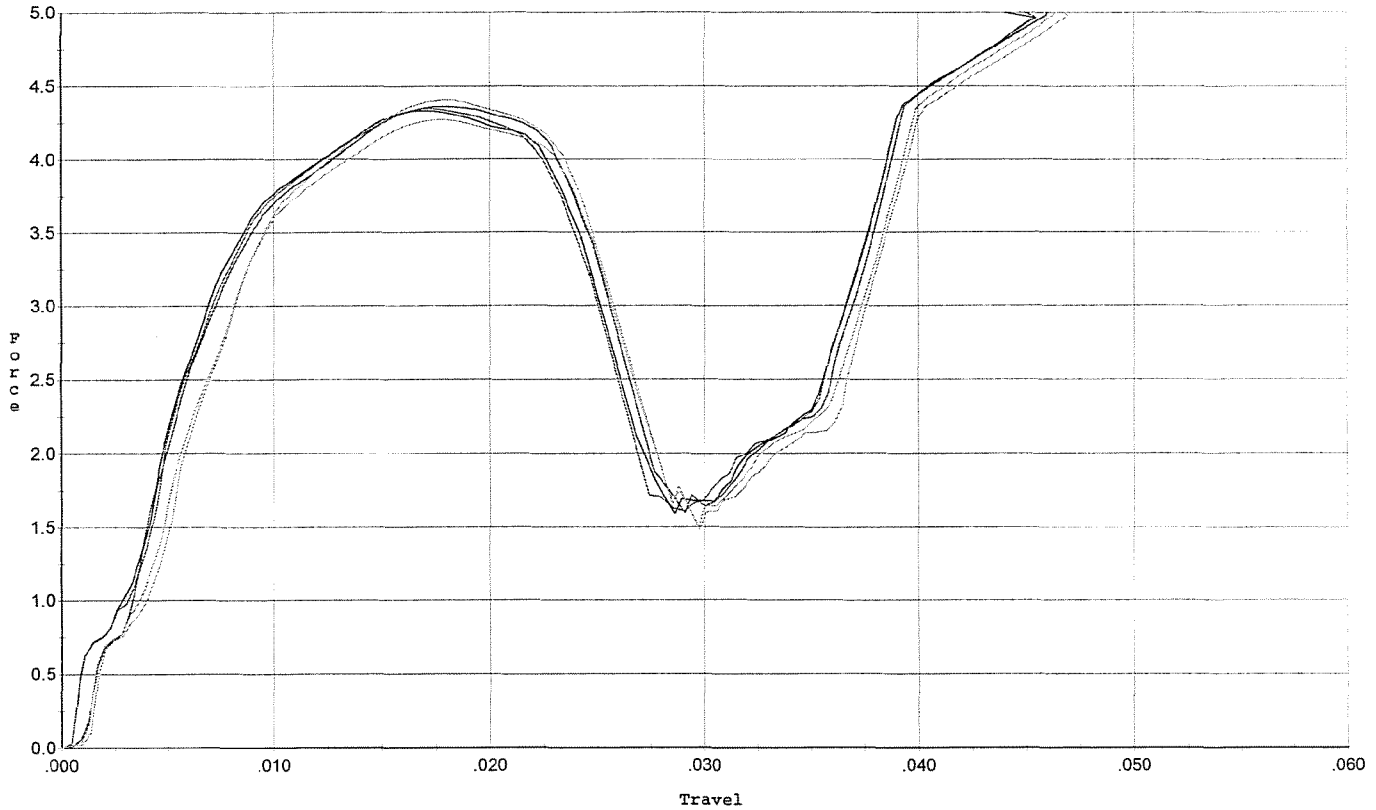
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.023	0.00	0.033	0.043		Set Trigger
2	2.705	0.020	0.00	0.034	0.039		Set Trigger
3	2.715	0.021	0.00	0.034	0.040		Set Trigger
4	2.704	0.023	0.00	0.033	0.043		Set Trigger
5	2.742	0.021	0.00	0.034	0.039		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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	4.358	0.025	0.00	0.030	0.074		Set Trigger
2	4.331	0.024	0.00	0.031	0.073		Set Trigger
3	4.345	0.025	0.00	0.031	0.074		Set Trigger
4	4.269	0.025	0.00	0.031	0.071		Set Trigger
5	4.406	0.024	0.00	0.031	0.071		Set Trigger

A-4.34