

G680 1459

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

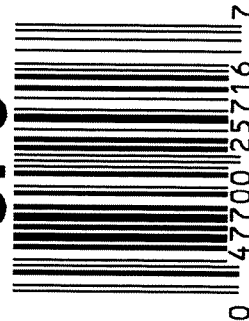
24"

CAPACITY

6

G6801459

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801459

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	RT
480	MAGNAFLUX BBL ACTION	OPERATOR	3/9/09	RT
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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400015575

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.6</u> <u>2.8</u> <u>2.6</u>	3/23/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.3</u> <u>4.1</u> <u>4.2</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-19-09	SN
	K) ASSEMBLE SWIVEL STUDS		3/23/09	RP
	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	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	SN
670	FINAL INSPECTION A) HEADSPACE		3/23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.45</u> <u>2.35</u> <u>2.33</u> <u>2.40</u>	3-23-09	TL
	C) FUNCTION		3/23/09	RP
690	PACK		3/25/09	FM

F004 REV 5/2006

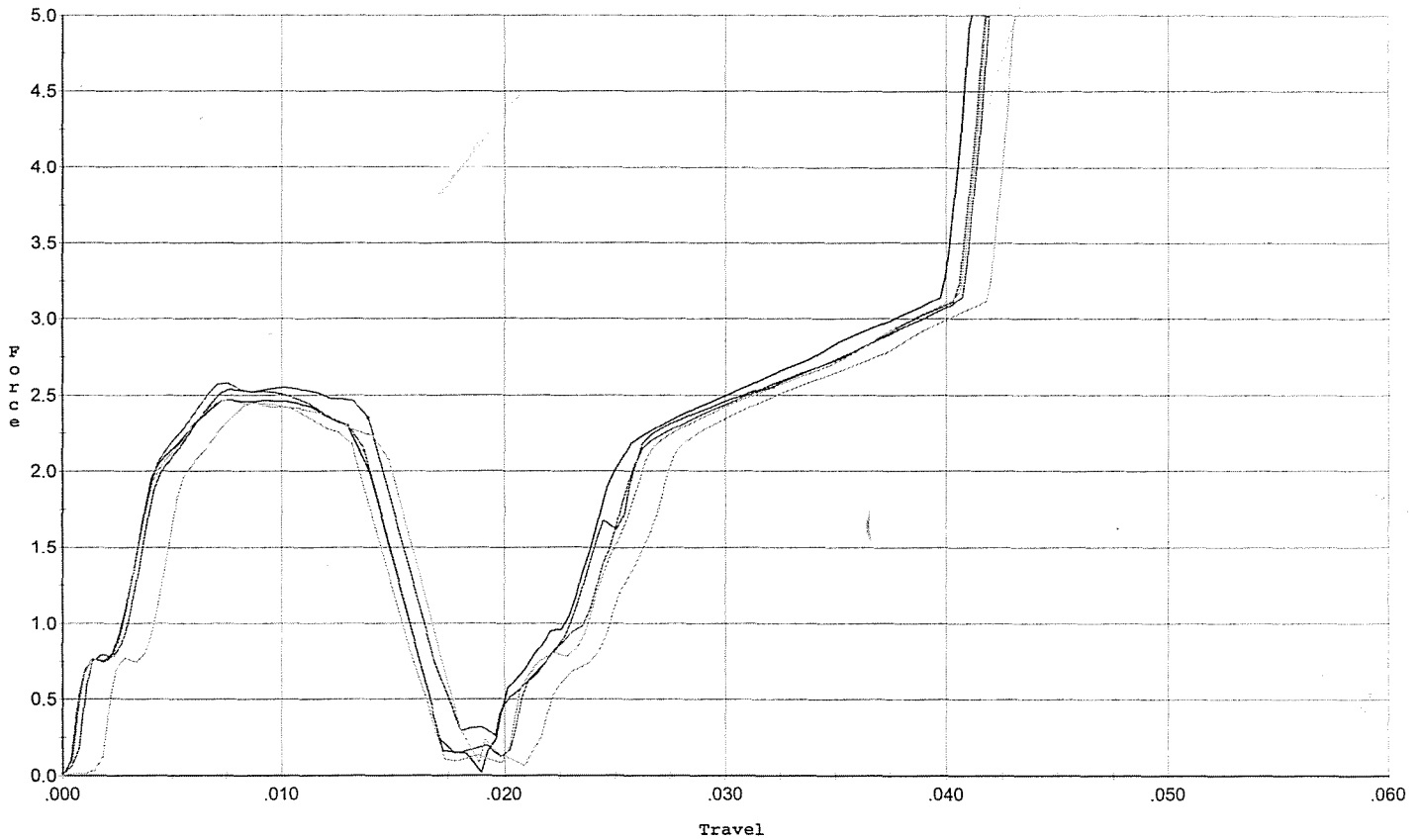
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400015576

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



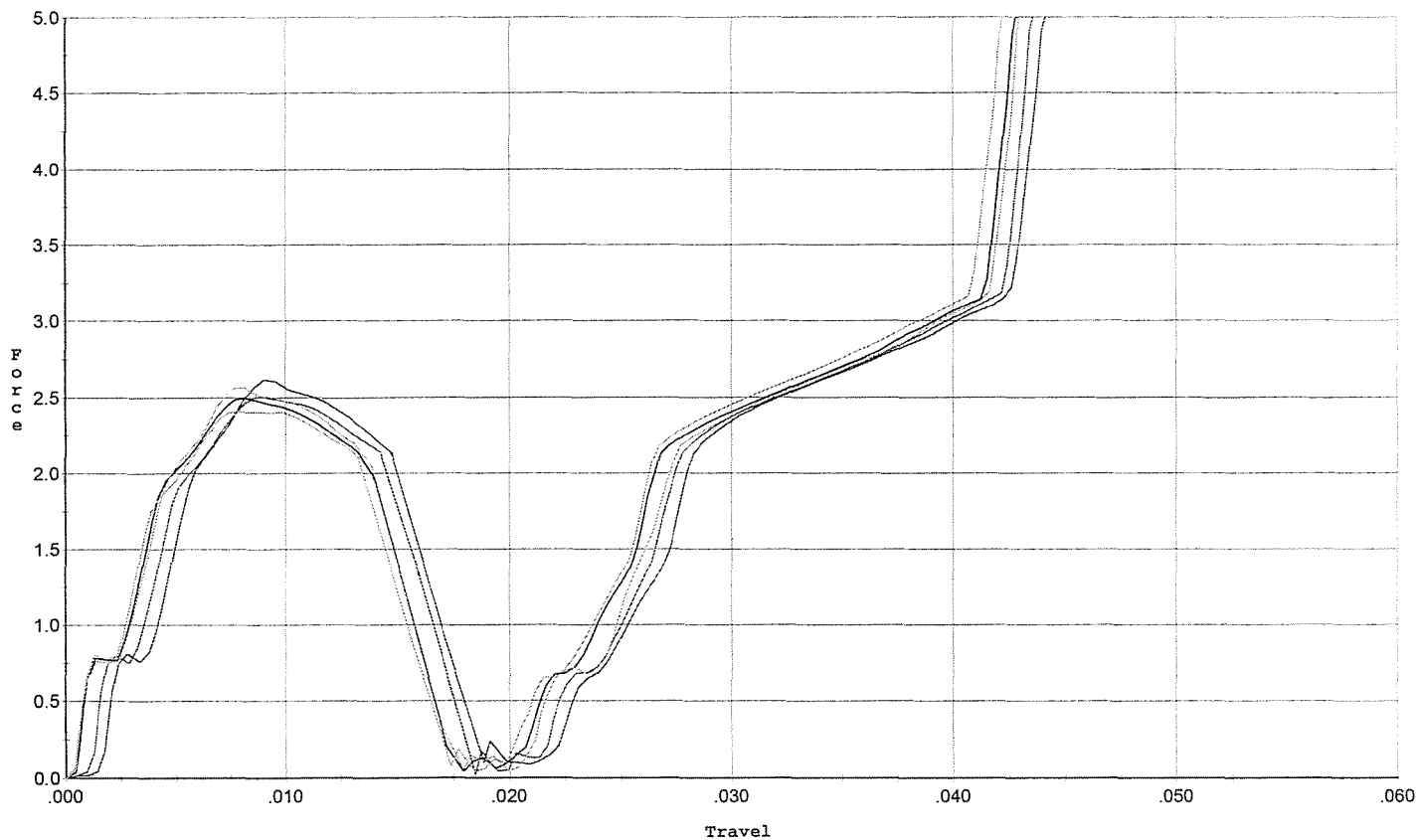
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.014	0.00	0.031	0.025		Set Trigger
2	2.469	0.014	0.00	0.030	0.025		Set Trigger
3	2.580	0.014	0.00	0.031	0.025		Set Trigger
4	2.451	0.015	0.00	0.031	0.024		Set Trigger
5	2.466	0.013	0.00	0.031	0.023		Set Trigger

A-2-50

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



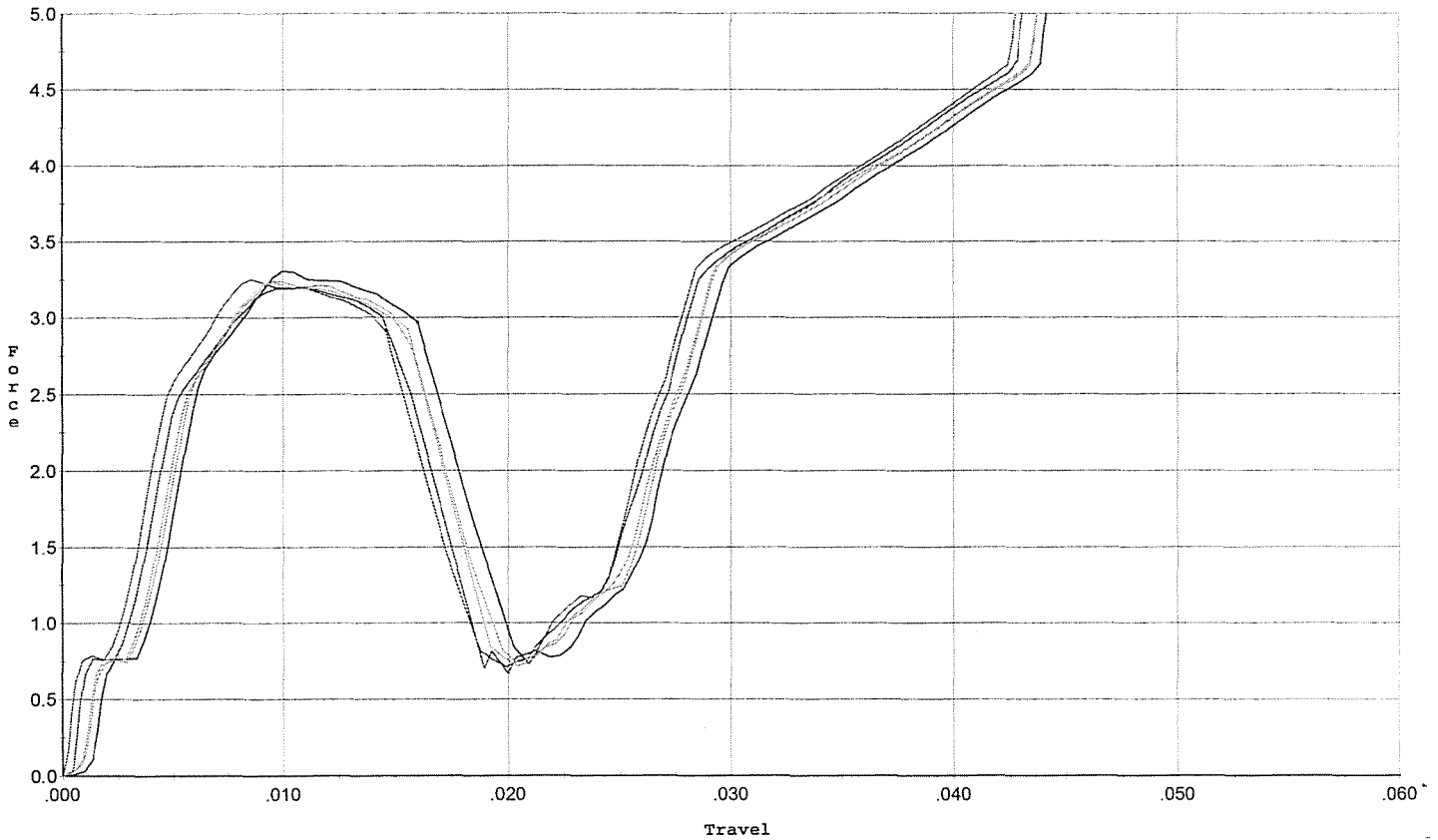
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.616	0.015	0.00	0.032	0.024		Set Trigger
2	2.496	0.014	0.003	0.032	0.024		Set Trigger
3	2.505	0.016	0.00	0.032	0.027		Set Trigger
4	2.567	0.014	0.003	0.032	0.024		Set Trigger
5	2.409	0.013	0.00	0.032	0.023		Set Trigger

A. 2.51

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



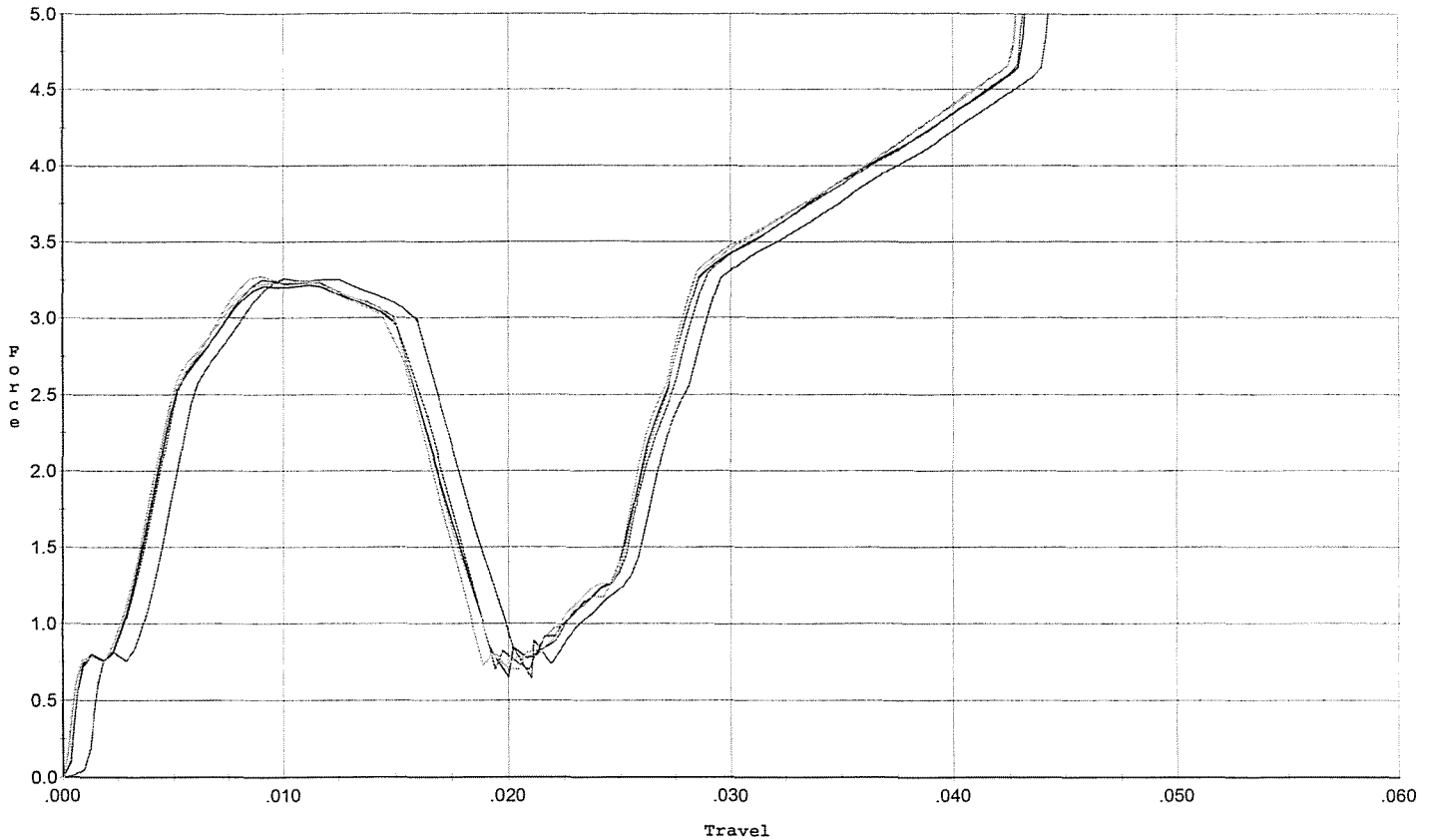
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.196	0.016	0.003	0.029	0.034		Set Trigger
2	3.309	0.016	0.00	0.029	0.034		Set Trigger
3	3.255	0.015	0.00	0.028	0.033		Set Trigger
4	3.235	0.016	0.00	0.029	0.034		Set Trigger
5	3.243	0.016	0.00	0.029	0.033		Set Trigger

A-3.24

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



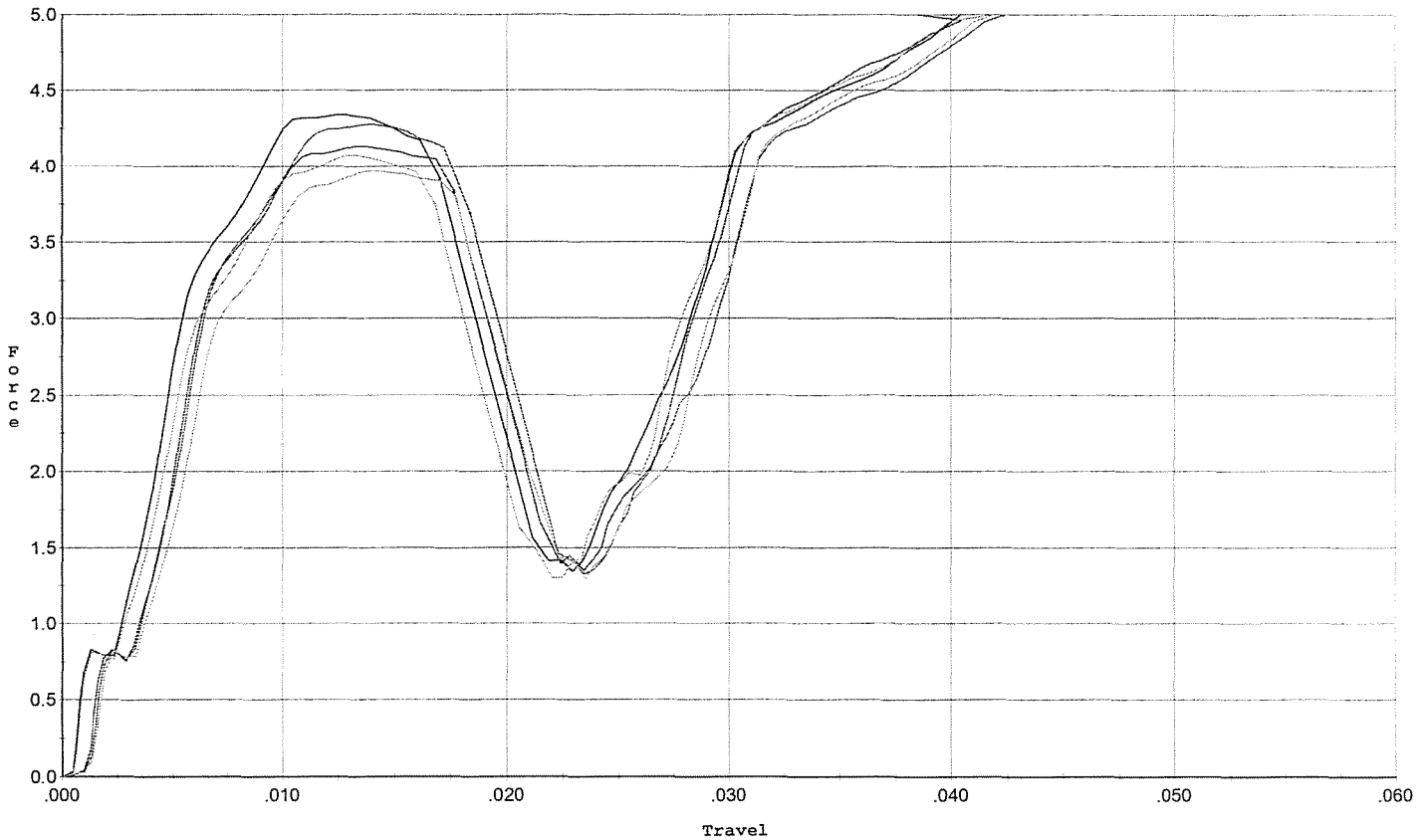
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.260	0.016	0.00	0.029	0.035		Set Trigger
2	3.216	0.015	0.00	0.029	0.033		Set Trigger
3	3.253	0.016	0.00	0.028	0.037		Set Trigger
4	3.247	0.015	0.00	0.028	0.034		Set Trigger
5	3.277	0.015	0.00	0.028	0.035		Set Trigger

A.3.25

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



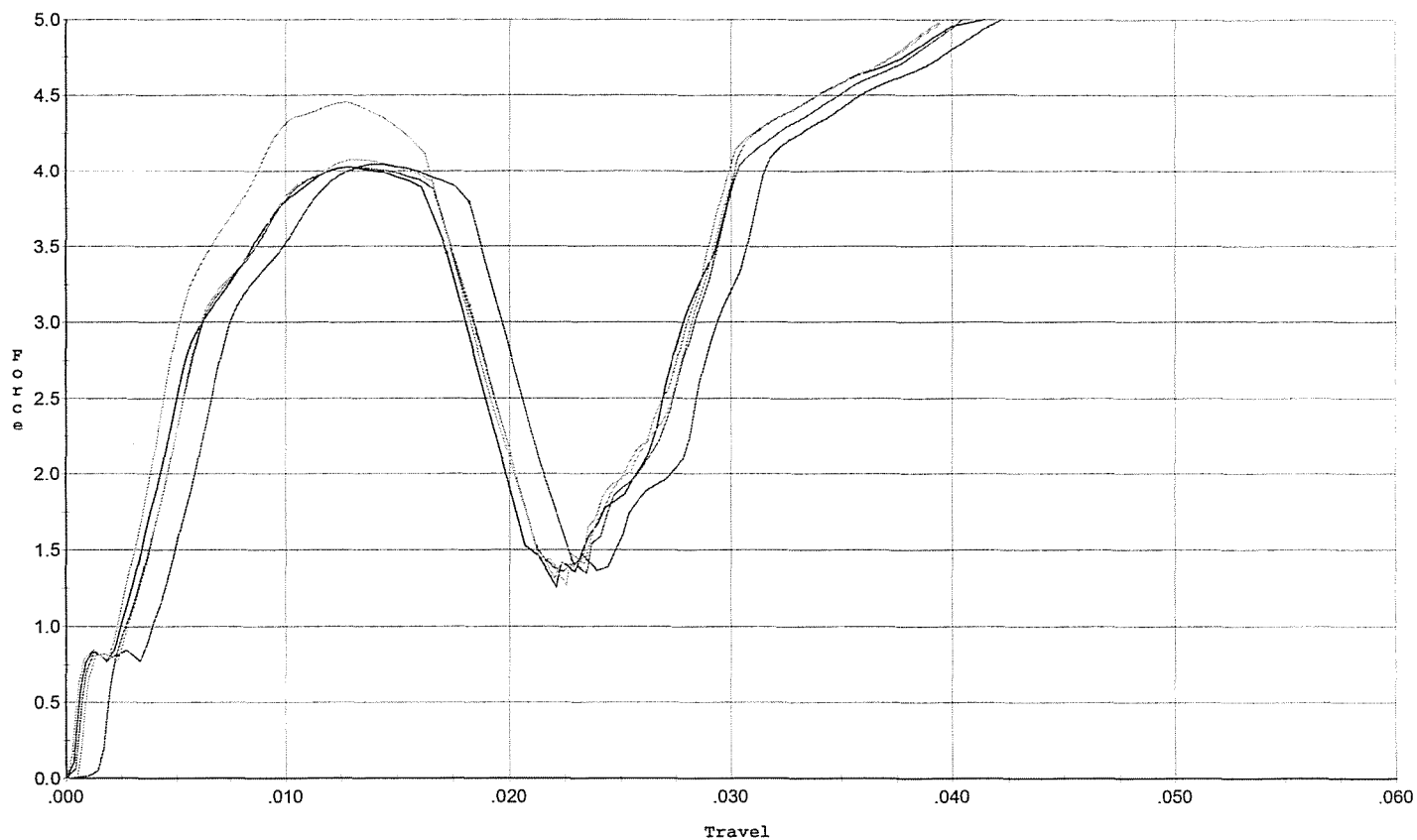
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.132	0.018	0.00	0.027	0.048		Set Trigger
2	4.337	0.017	0.003	0.027	0.049		Set Trigger
3	4.277	0.018	0.00	0.027	0.051		Set Trigger
4	3.969	0.018	0.00	0.028	0.045		Set Trigger
5	4.074	0.017	0.003	0.027	0.045		Set Trigger

A-4.015

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



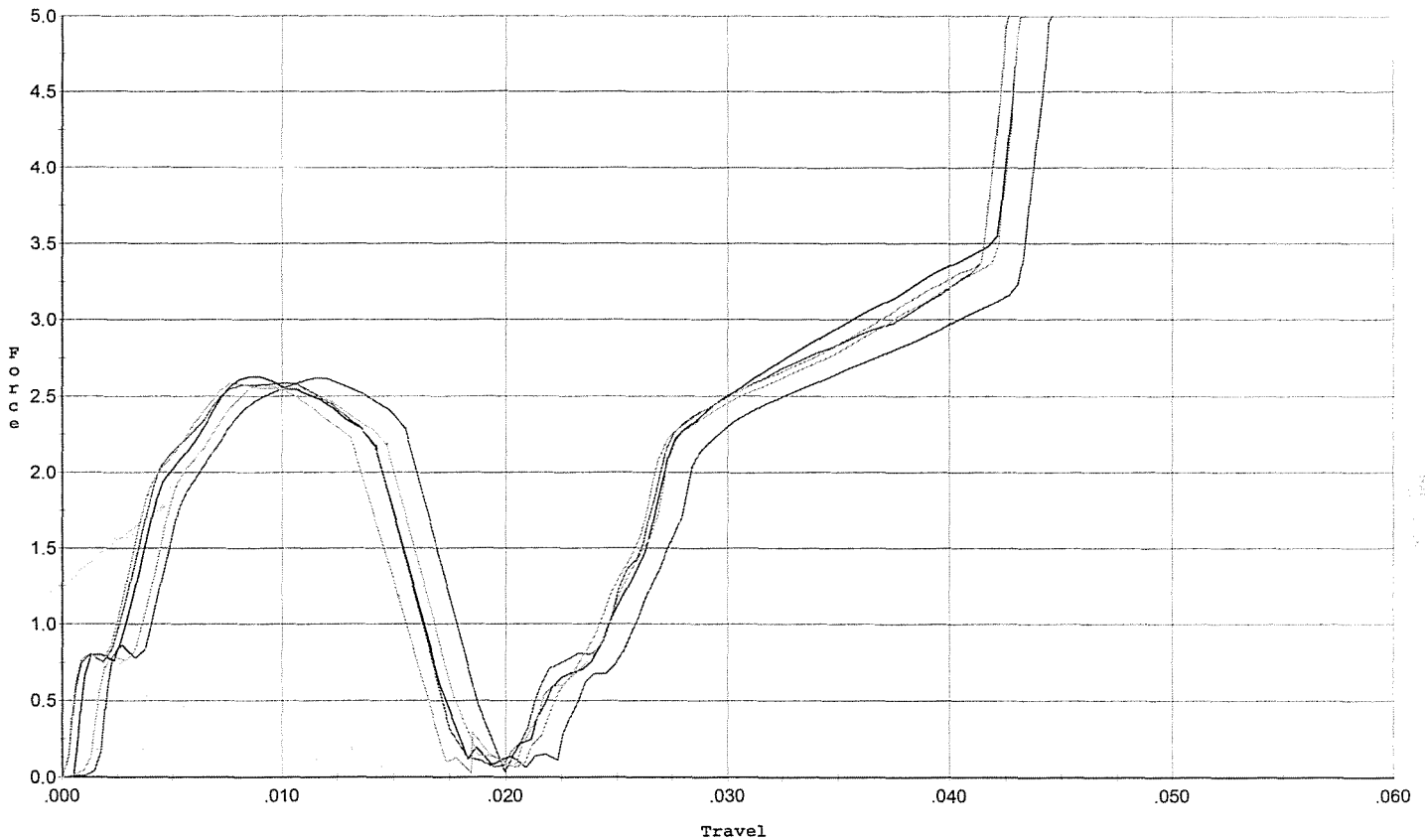
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.047	0.018	0.00	0.028	0.046		Set Trigger
2	4.024	0.017	0.00	0.027	0.046		Set Trigger
3	4.027	0.019	0.00	0.027	0.050		Set Trigger
4	4.077	0.018	0.00	0.027	0.049		Set Trigger
5	4.454	0.016	0.00	0.027	0.048		Set Trigger

A-412

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



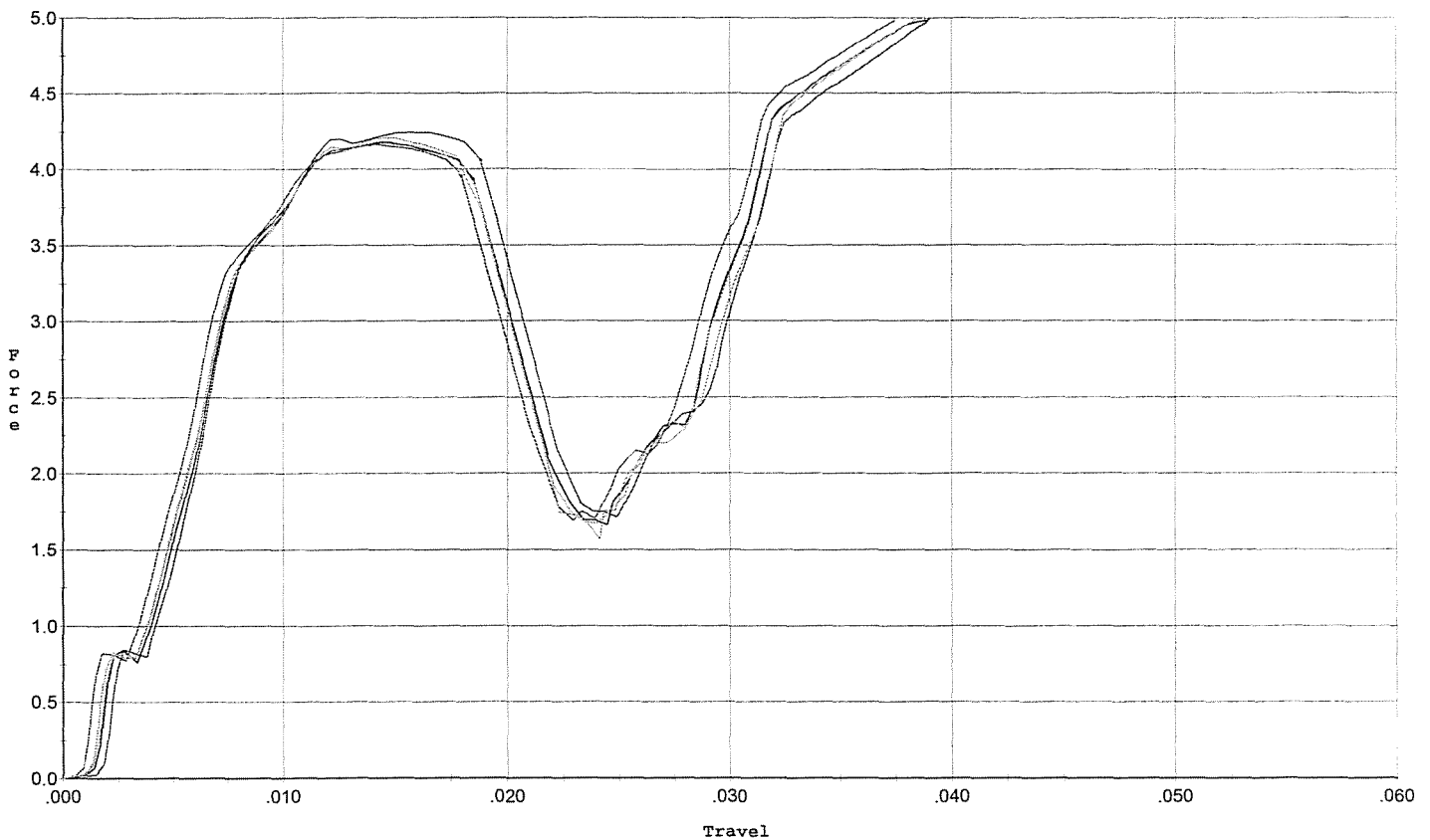
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.620	0.016	0.00	0.032	0.027		Set Trigger
2	2.625	0.014	0.003	0.031	0.026		Set Trigger
3	2.585	0.014	0.00	0.031	0.026		Set Trigger
4	2.574	0.015	0.00	0.031	0.025		Set Trigger
5	2.582	0.015	0.00	0.032	0.027		Set Trigger

A. 2.59

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 ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.246	0.019	0.002	0.027	0.051		Set Trigger
2	4.179	0.019	0.00	0.027	0.049		Set Trigger
3	4.166	0.018	0.003	0.027	0.049		Set Trigger
4	4.209	0.019	0.004	0.027	0.050		Set Trigger
5	4.186	0.019	0.004	0.027	0.050		Set Trigger

A-4.19