

G6801464

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



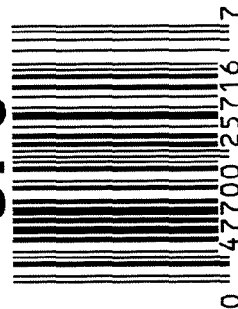
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801464

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801464

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	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR	3/9/09	SP
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)		5/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-03	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-03	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-03	SP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

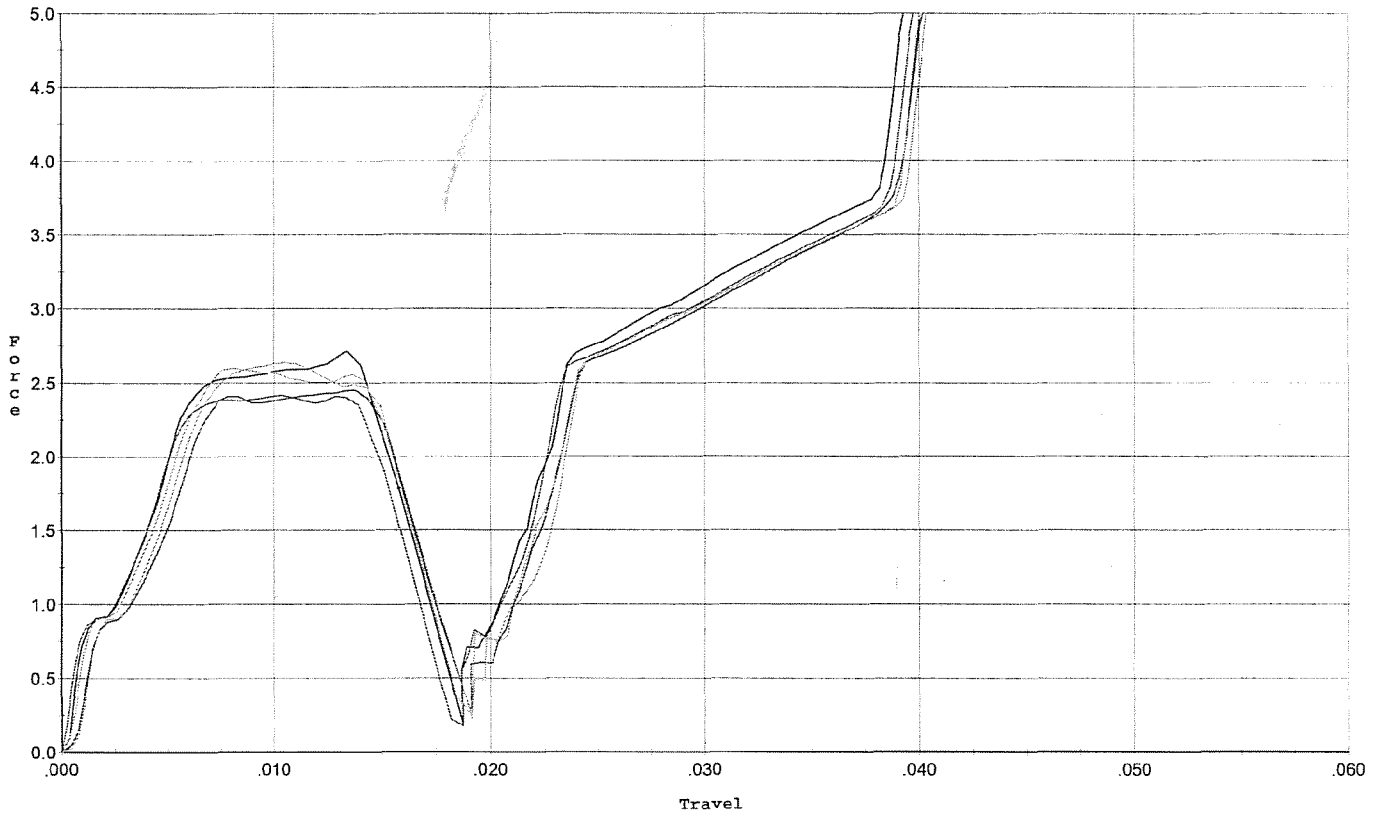
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>6.5</u> <u>7</u>	3-25-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-25-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-25-09	WW
	J) ASSEMBLE STOCK		3-23-09	TC
	K) ASSEMBLE SWIVEL STUDS		3-25-09	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	3-24-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	WW
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.39</u> <u>2.31</u> <u>2.35</u> <u>2.25</u>	3-24-09	TC
	C) FUNCTION		3-25-09	WW
690	PACK		3/27/09	Fay

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



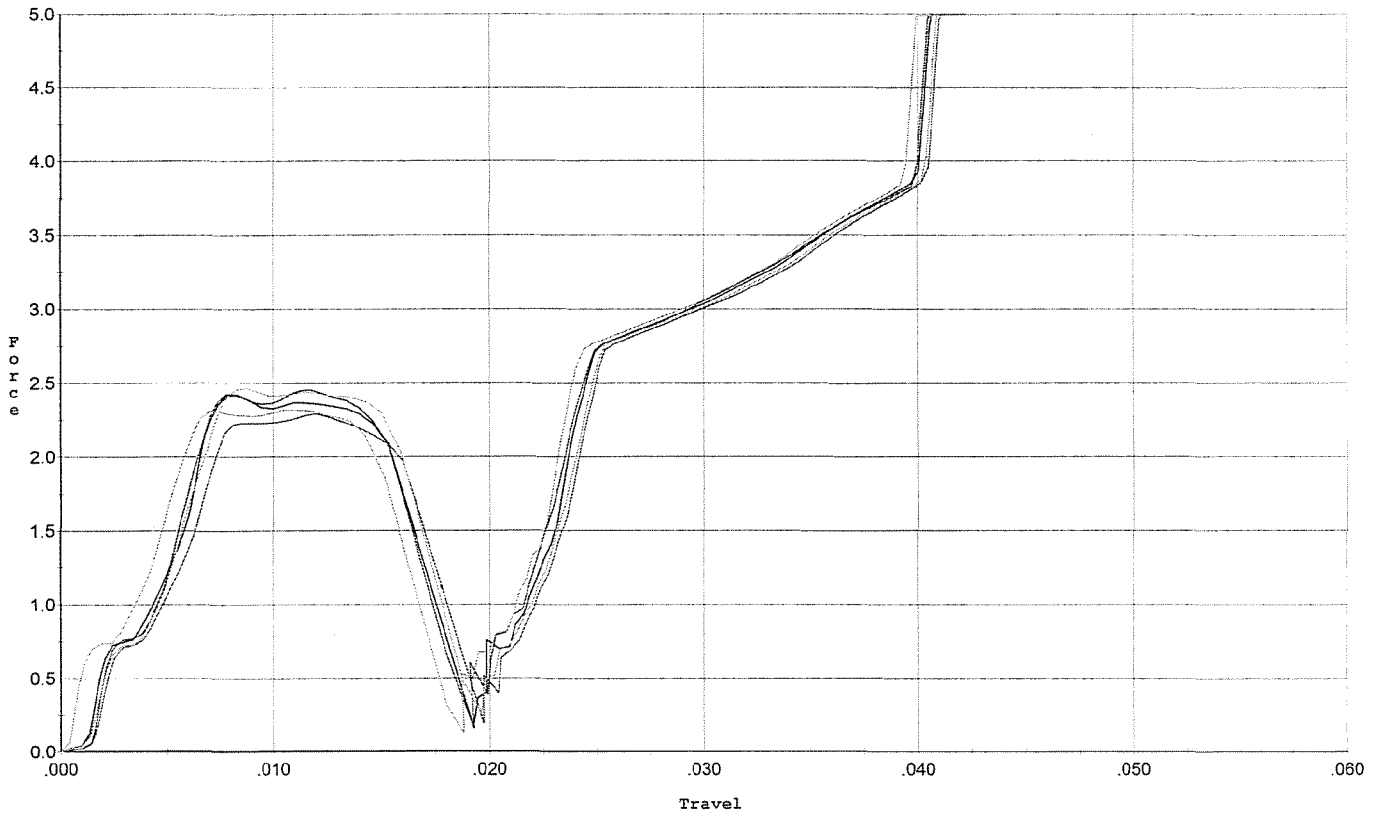
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.451	0.015	0.00	0.028	0.026		Set Trigger
2	2.713	0.016	0.00	0.027	0.030		Set Trigger
3	2.417	0.015	0.00	0.028	0.027		Set Trigger
4	2.598	0.015	0.00	0.027	0.028		Set Trigger
5	2.638	0.015	0.00	0.028	0.027		Set Trigger

A-2-56

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



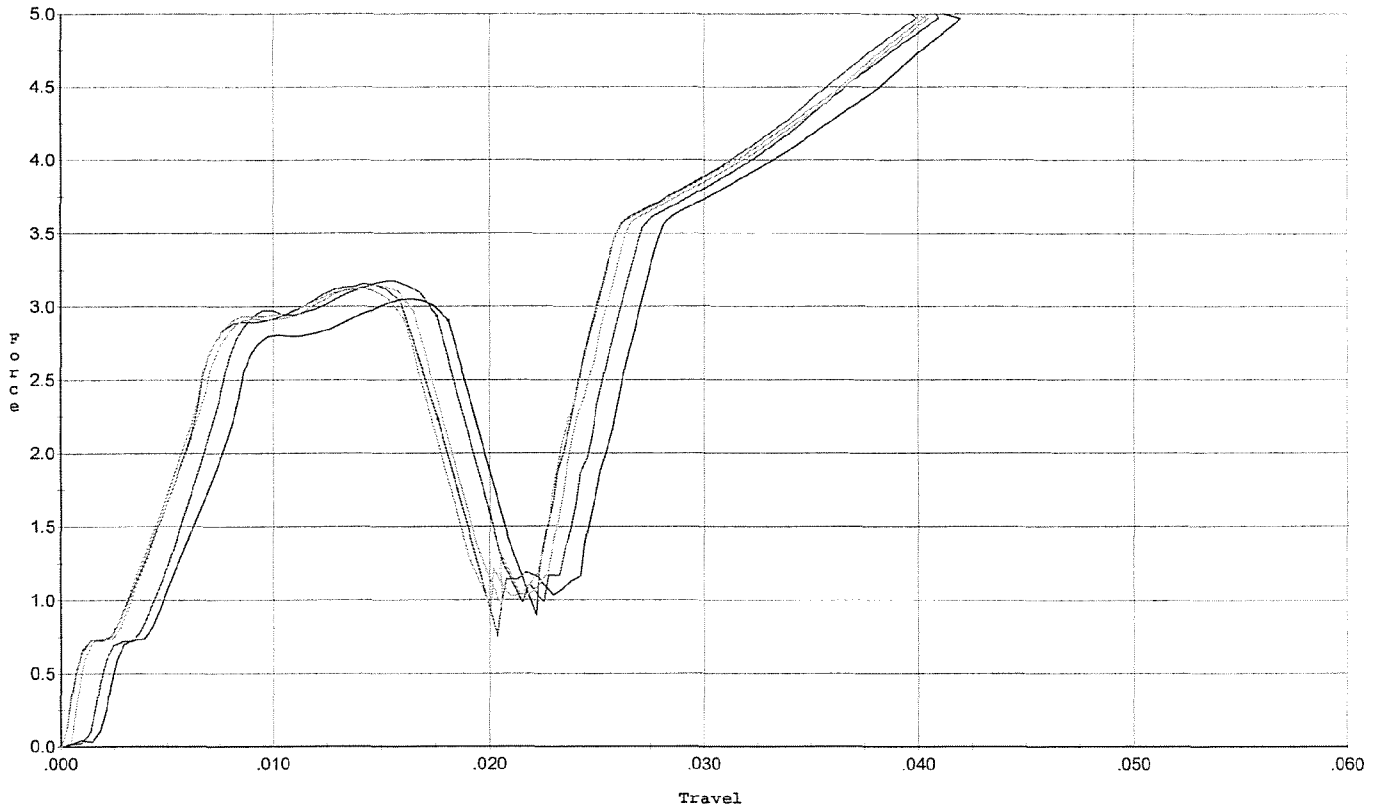
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.452	0.015	0.00	0.028	0.025		Set Trigger
2	2.415	0.015	0.00	0.028	0.024		Set Trigger
3	2.292	0.018	0.00	0.027	0.026		Set Trigger
4	2.466	0.016	0.00	0.028	0.026		Set Trigger
5	2.320	0.015	0.00	0.028	0.025		Set Trigger

A-2-38

Trigger Profile [lbs,inch]

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

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



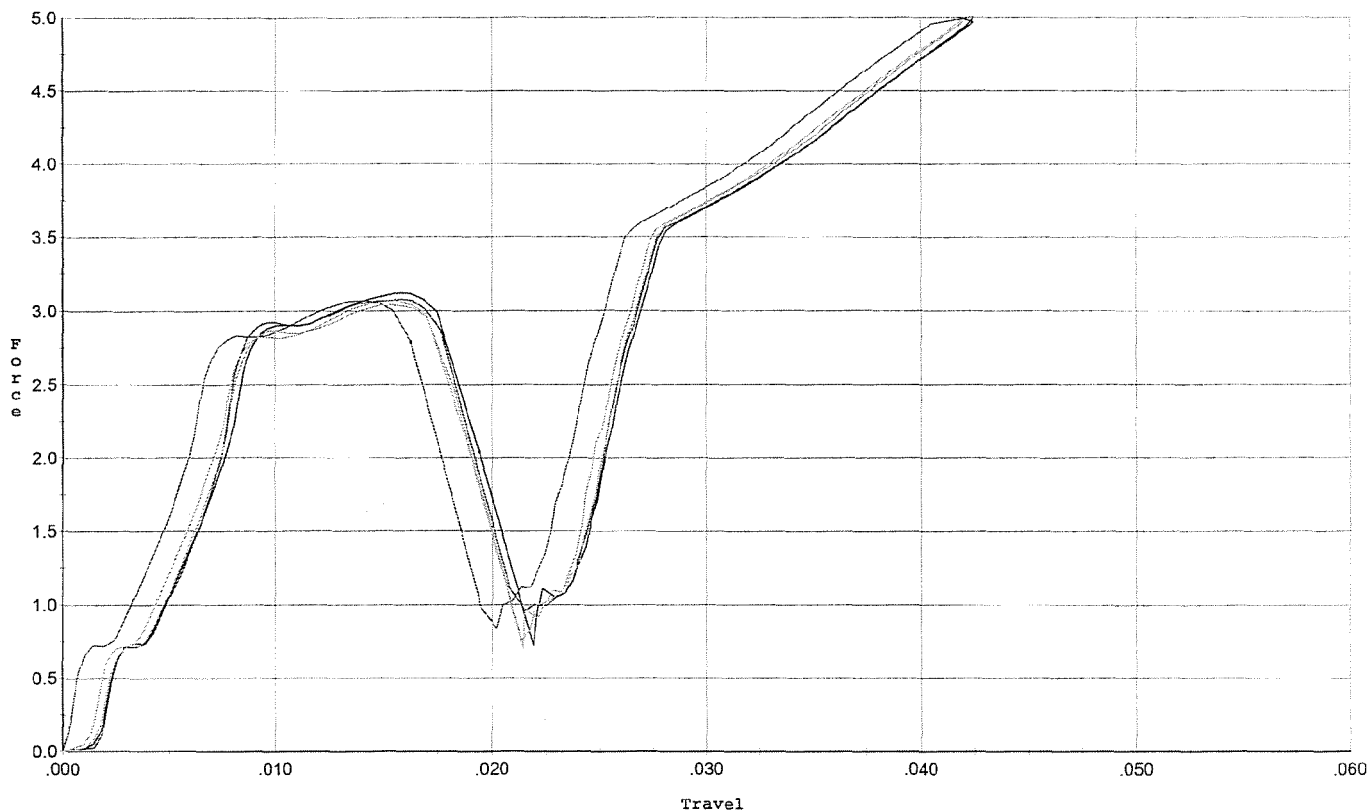
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.173	0.018	0.00	0.025	0.036		Set Trigger
2	3.053	0.018	0.00	0.026	0.035		Set Trigger
3	3.160	0.018	0.00	0.025	0.037		Set Trigger
4	3.149	0.016	0.00	0.025	0.035		Set Trigger
5	3.123	0.016	0.00	0.025	0.034		Set Trigger

A-3-13

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



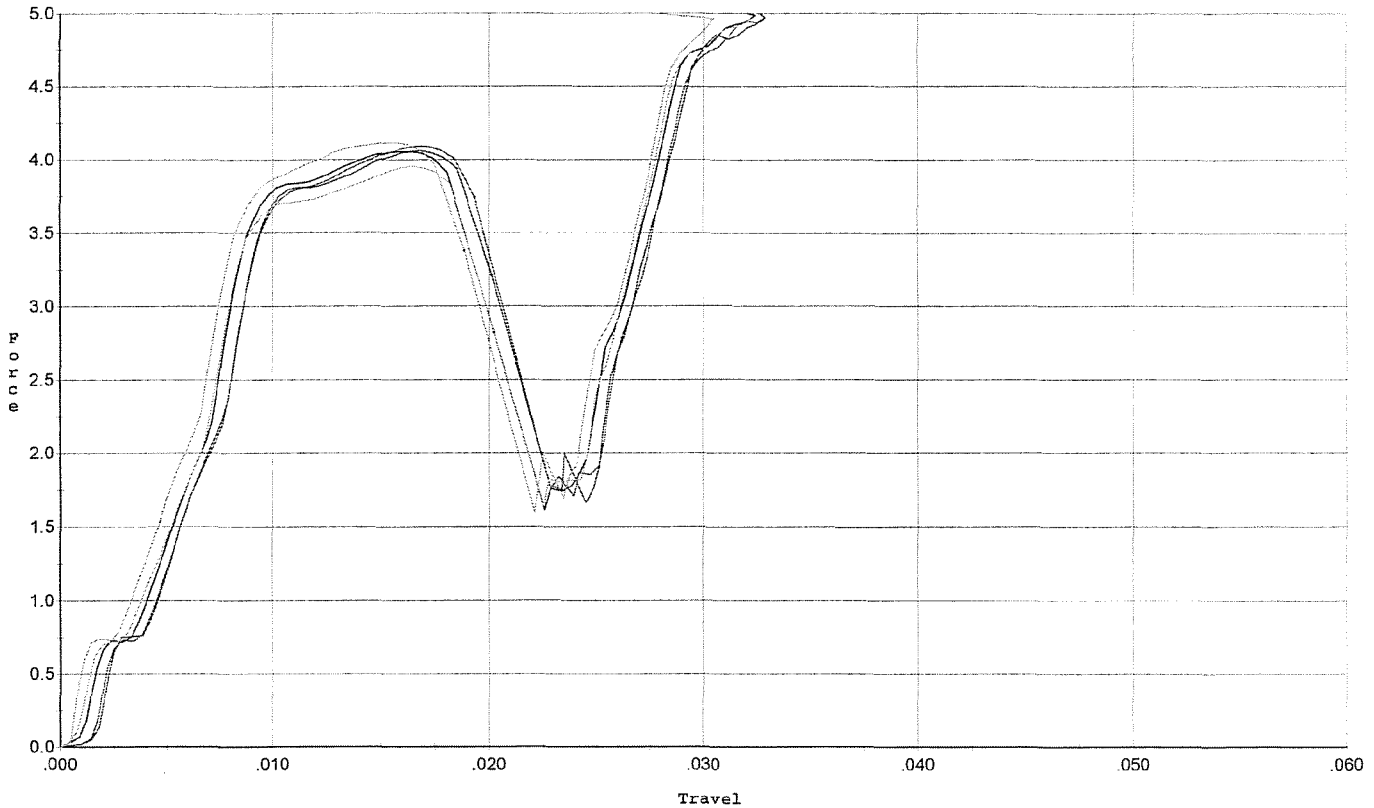
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.080	0.018	0.00	0.026	0.034		Set Trigger
2	3.123	0.019	0.00	0.026	0.038		Set Trigger
3	3.068	0.016	0.00	0.026	0.034		Set Trigger
4	3.070	0.019	0.00	0.026	0.037		Set Trigger
5	3.042	0.018	0.00	0.026	0.035		Set Trigger

A-3.07

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



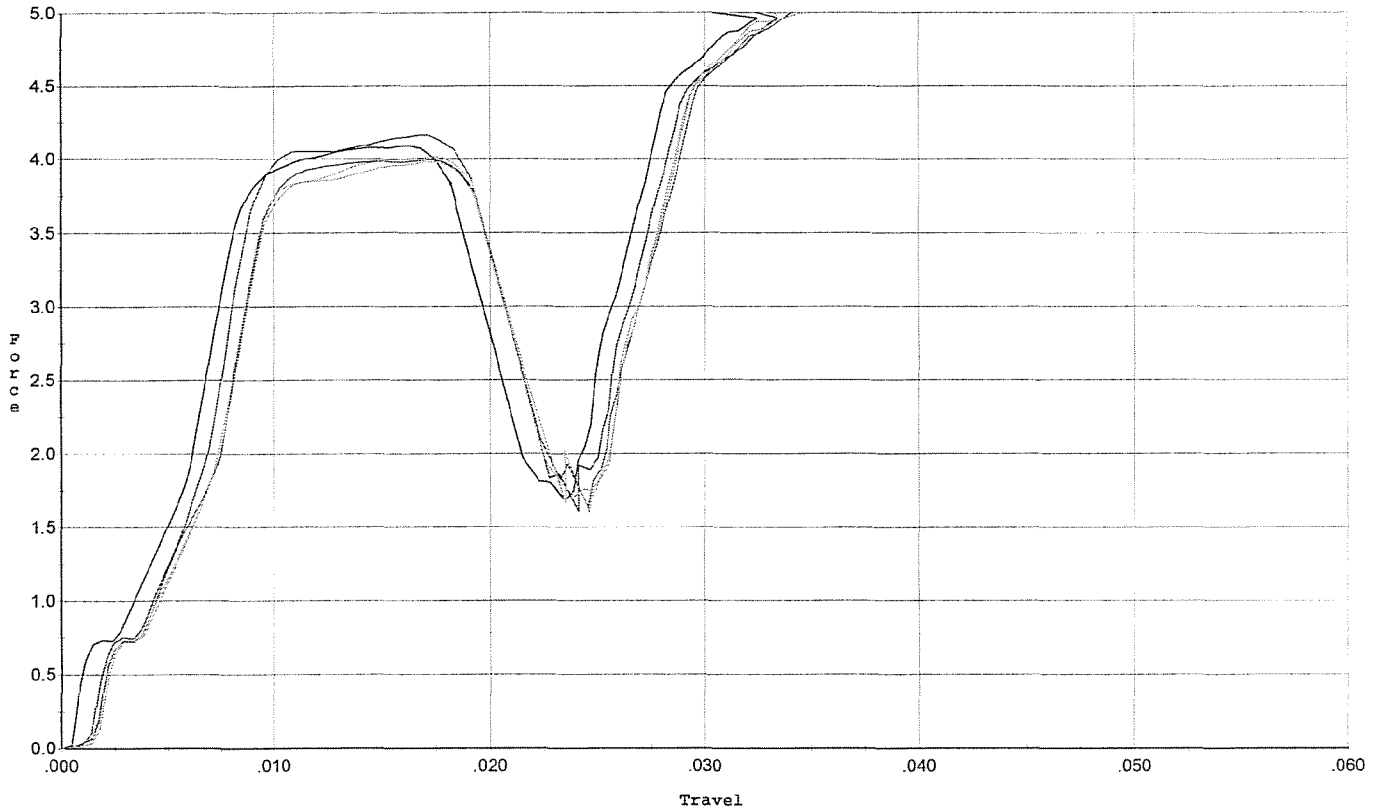
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.062	0.020	0.004	0.025	0.050		Set Trigger
2	4.057	0.020	0.00	0.025	0.051		Set Trigger
3	4.093	0.019	0.00	0.025	0.048		Set Trigger
4	3.957	0.020	0.00	0.025	0.051		Set Trigger
5	4.117	0.019	0.00	0.024	0.050		Set Trigger

A-4.05

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



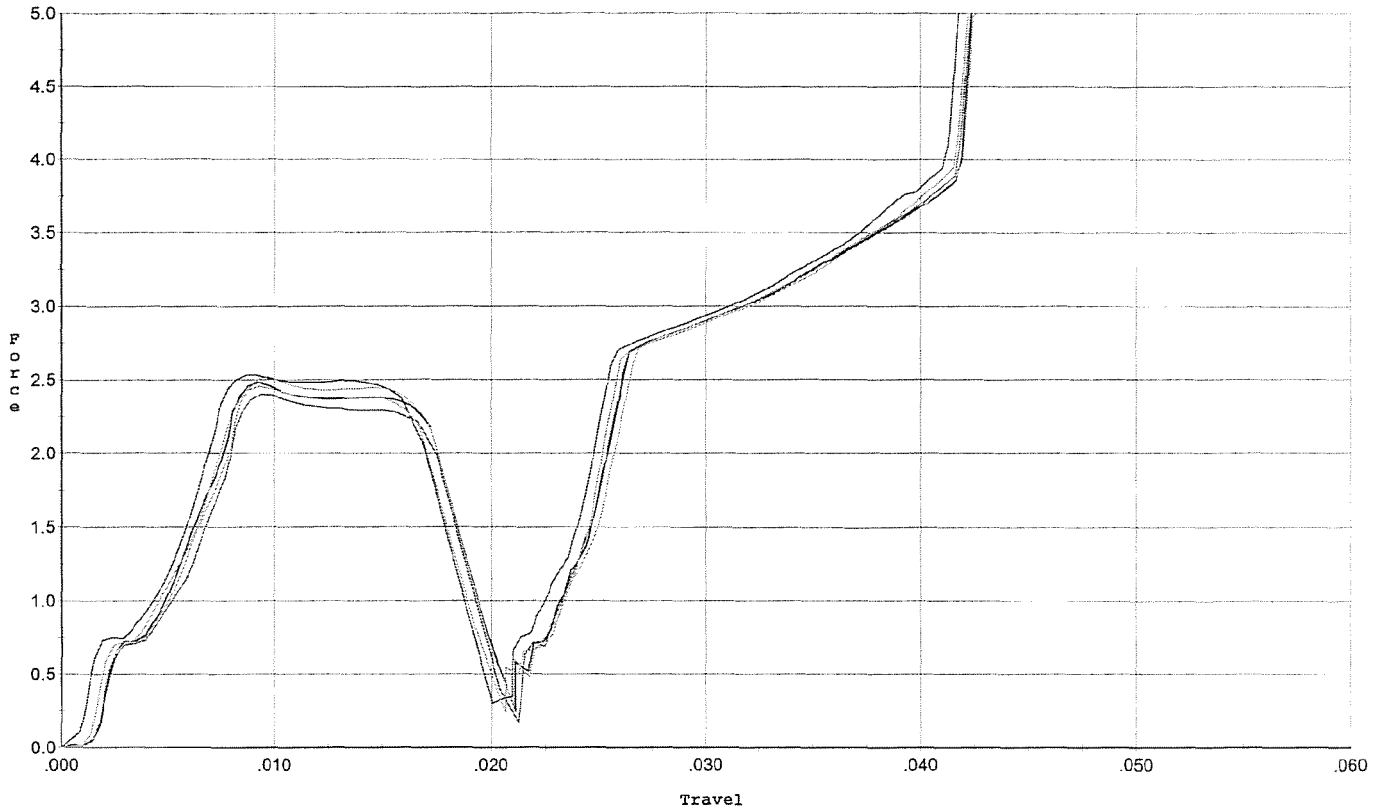
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.162	0.019	0.00	0.025	0.050		Set Trigger
2	4.089	0.018	0.00	0.025	0.048		Set Trigger
3	3.996	0.019	0.00	0.025	0.048		Set Trigger
4	3.980	0.019	0.00	0.025	0.048		Set Trigger
5	4.015	0.019	0.00	0.025	0.047		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: reset to 2.5 lbs +/- .50 lb for final test



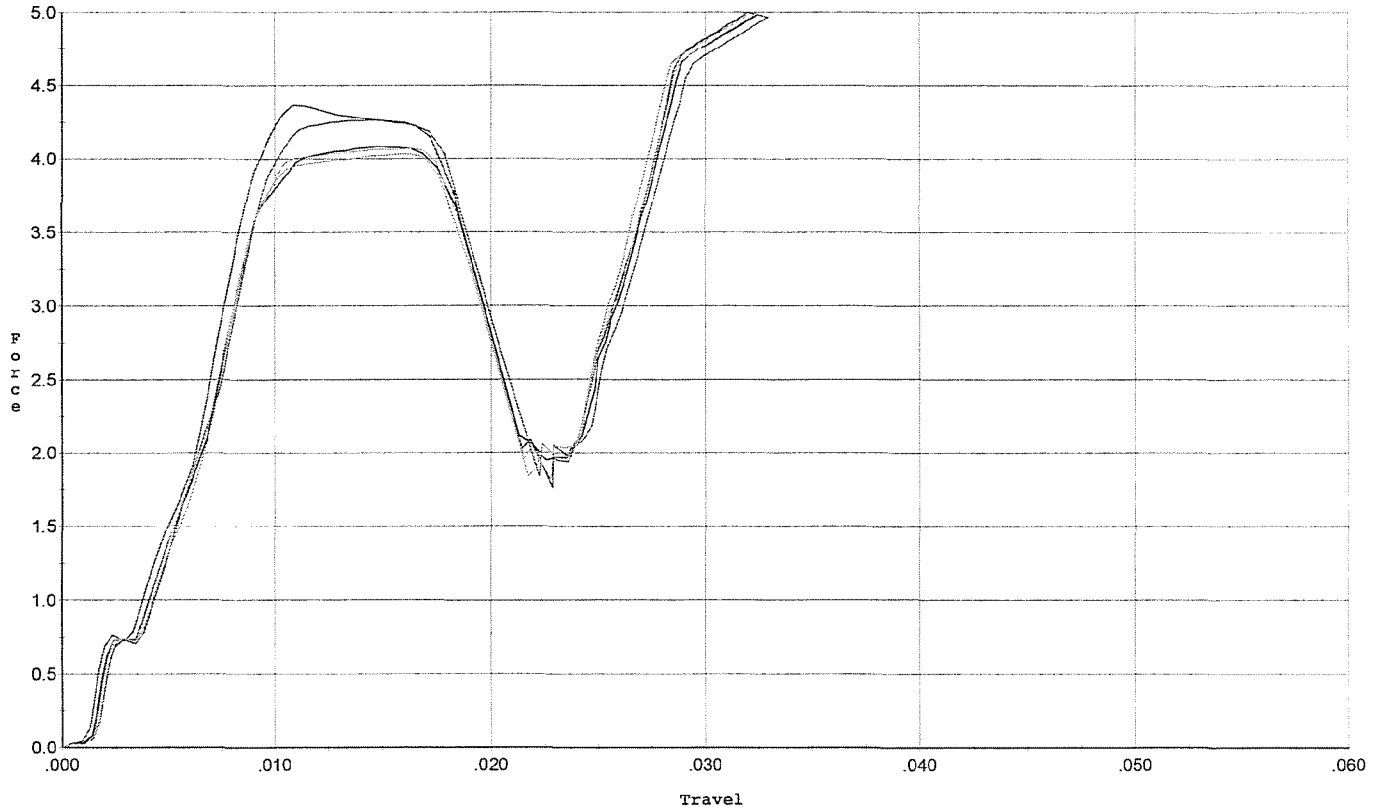
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.017	0.00	0.027	0.029		Set Trigger
2	2.482	0.017	0.00	0.027	0.028		Set Trigger
3	2.403	0.017	0.00	0.027	0.027		Set Trigger
4	2.520	0.017	0.00	0.028	0.028		Set Trigger
5	2.455	0.017	0.00	0.028	0.027		Set Trigger

A-2.47

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	4.365	0.018	0.00	0.023	0.049		Set Trigger
2	4.082	0.018	0.00	0.024	0.047		Set Trigger
3	4.264	0.018	0.00	0.025	0.046		Set Trigger
4	4.033	0.019	0.00	0.024	0.048		Set Trigger
5	4.071	0.019	0.00	0.024	0.047		Set Trigger

A-4-16