

G680 1467

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



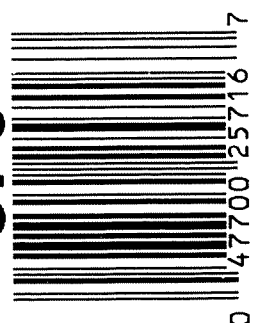
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801467

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801467

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	RTZ
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
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	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SPD
	D) OIL FIRING PIN ASSEMBLY		3-19-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

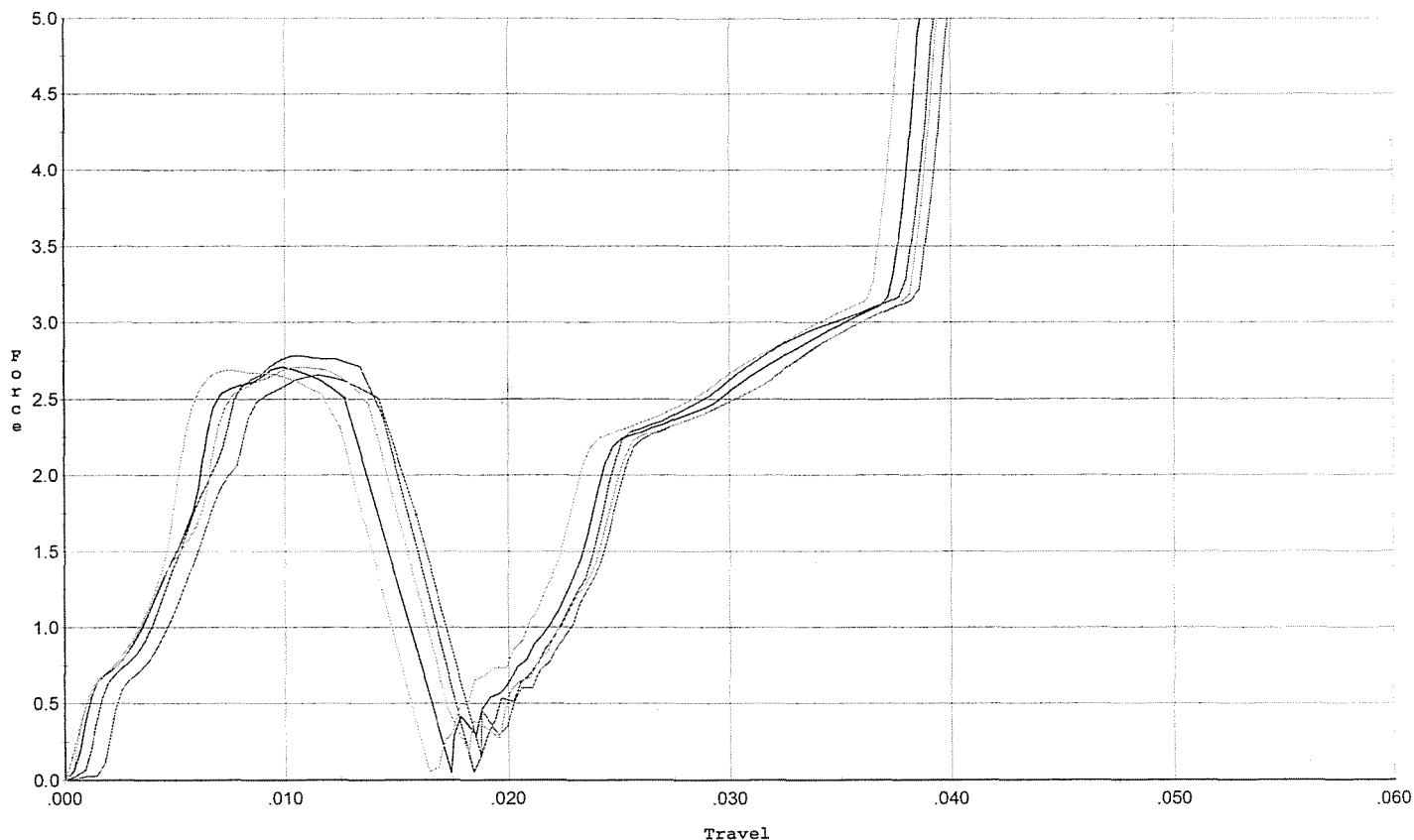
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.3</u> <u>2.2</u> <u>2.3</u>	3/23/09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-19-09	292.
	K) ASSEMBLE SWIVEL STUDS			
	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	PASS FAIL PASS FAIL	3-23-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	222
670	FINAL INSPECTION A) HEADSPACE		3-23-09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.65</u> <u>2.59</u> <u>2.53</u> <u>2.52</u>	3-23-09	TC
	C) FUNCTION		3-23-09	RP
690	PACK		3/24/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



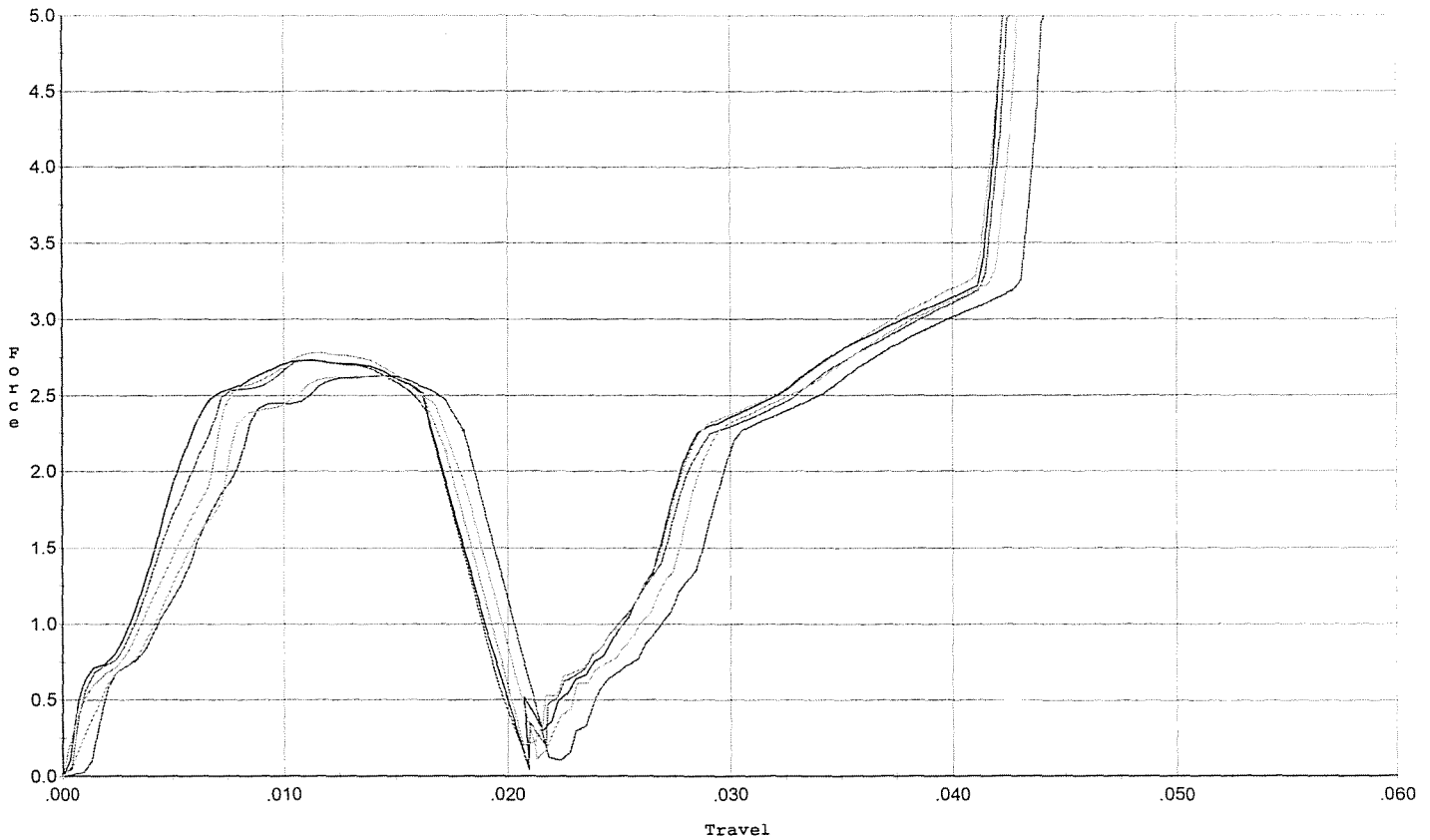
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.780	0.014	0.00	0.027	0.025		Set Trigger
2	2.709	0.013	0.00	0.028	0.022		Set Trigger
3	2.655	0.016	0.00	0.027	0.025		Set Trigger
4	2.687	0.012	0.00	0.028	0.022		Set Trigger
5	2.708	0.014	0.00	0.028	0.024		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



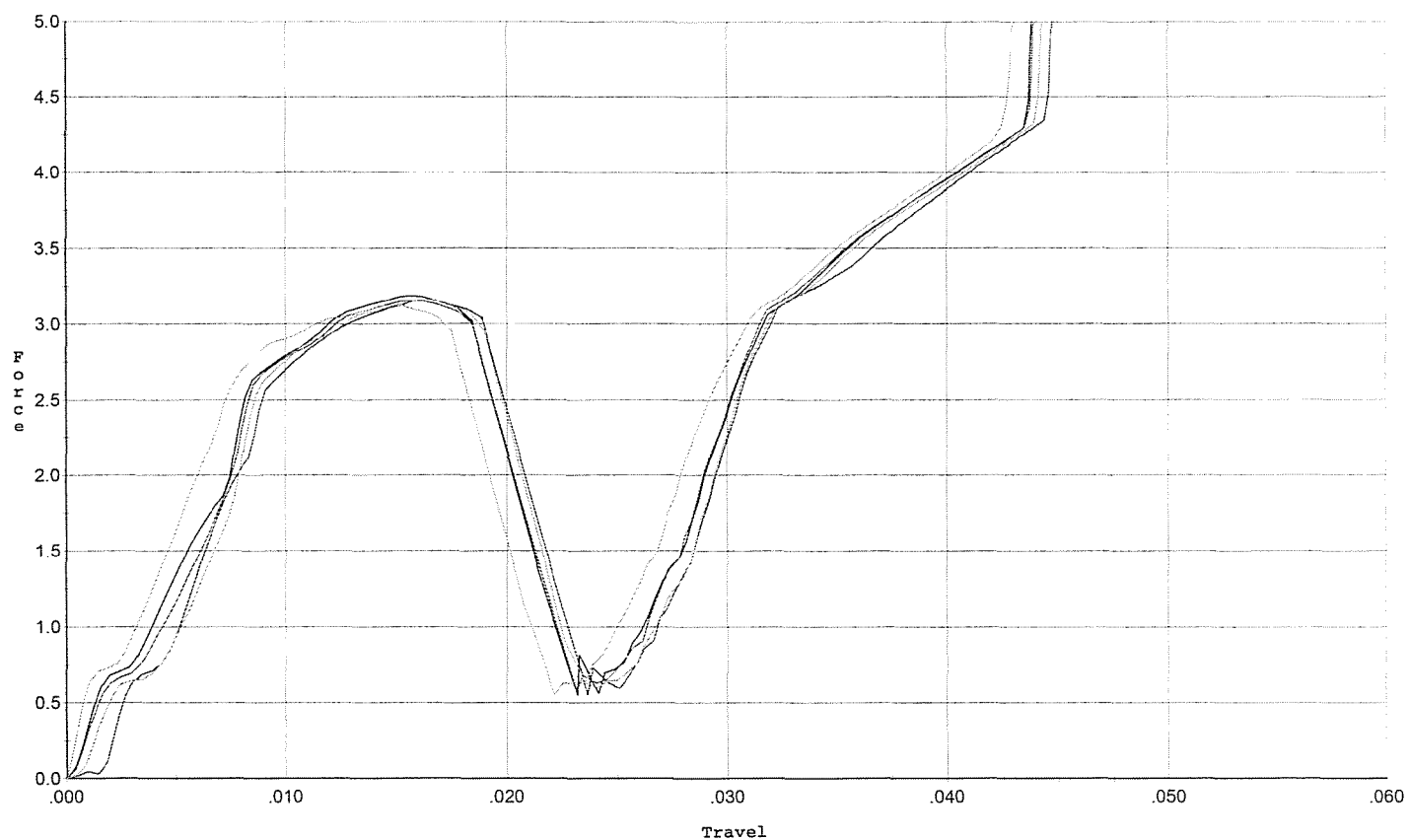
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.628	0.018	0.00	0.030	0.031		Set Trigger
2	2.731	0.016	0.00	0.029	0.032		Set Trigger
3	2.732	0.016	0.00	0.029	0.031		Set Trigger
4	2.628	0.018	0.00	0.029	0.032		Set Trigger
5	2.781	0.017	0.00	0.028	0.032		Set Trigger

A-2.70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



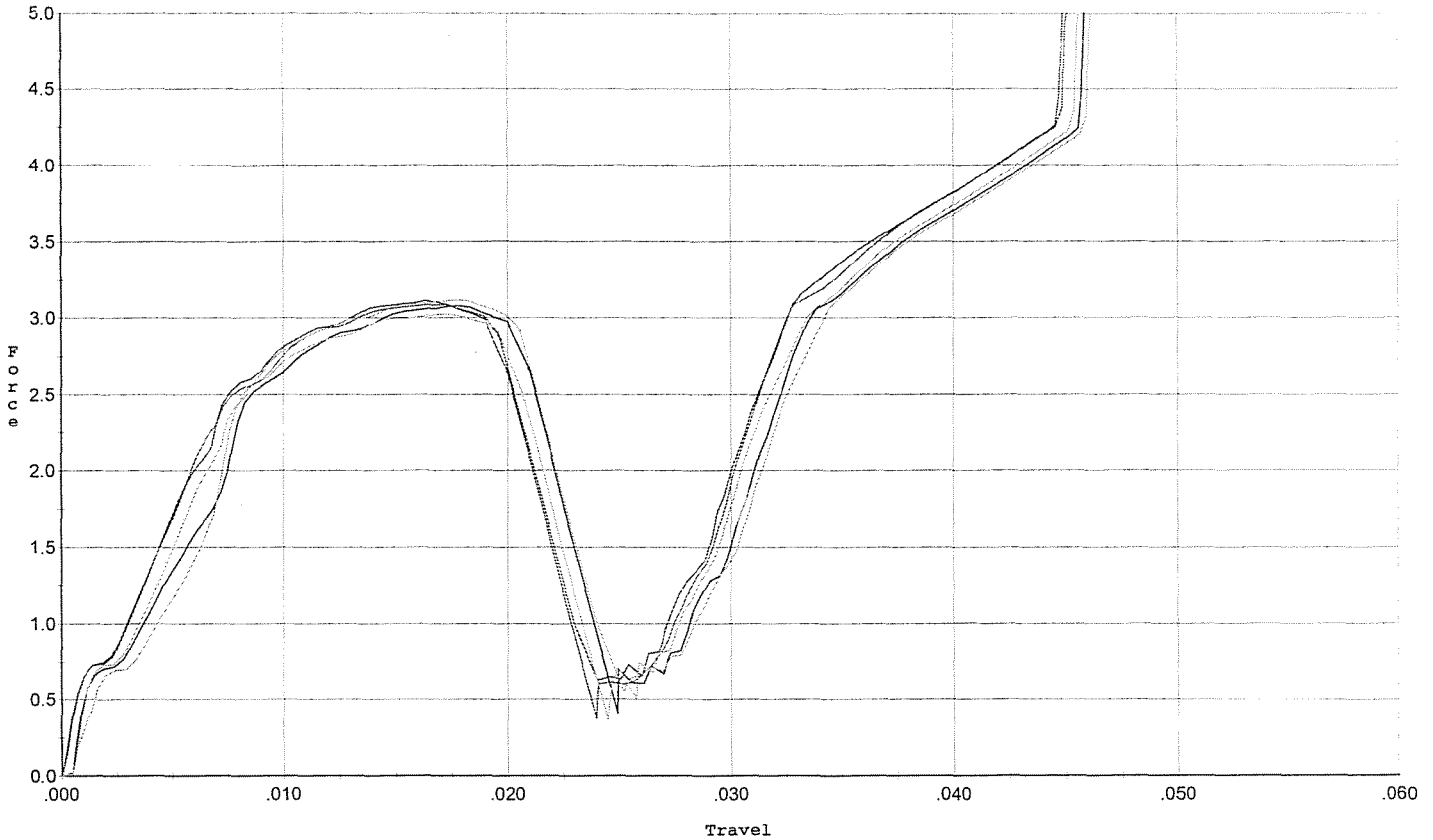
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.161	0.019	0.00	0.029	0.037		Set Trigger
2	3.183	0.018	0.00	0.028	0.038		Set Trigger
3	3.155	0.018	0.00	0.028	0.037		Set Trigger
4	3.123	0.018	0.00	0.028	0.037		Set Trigger
5	3.160	0.019	0.00	0.028	0.038		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



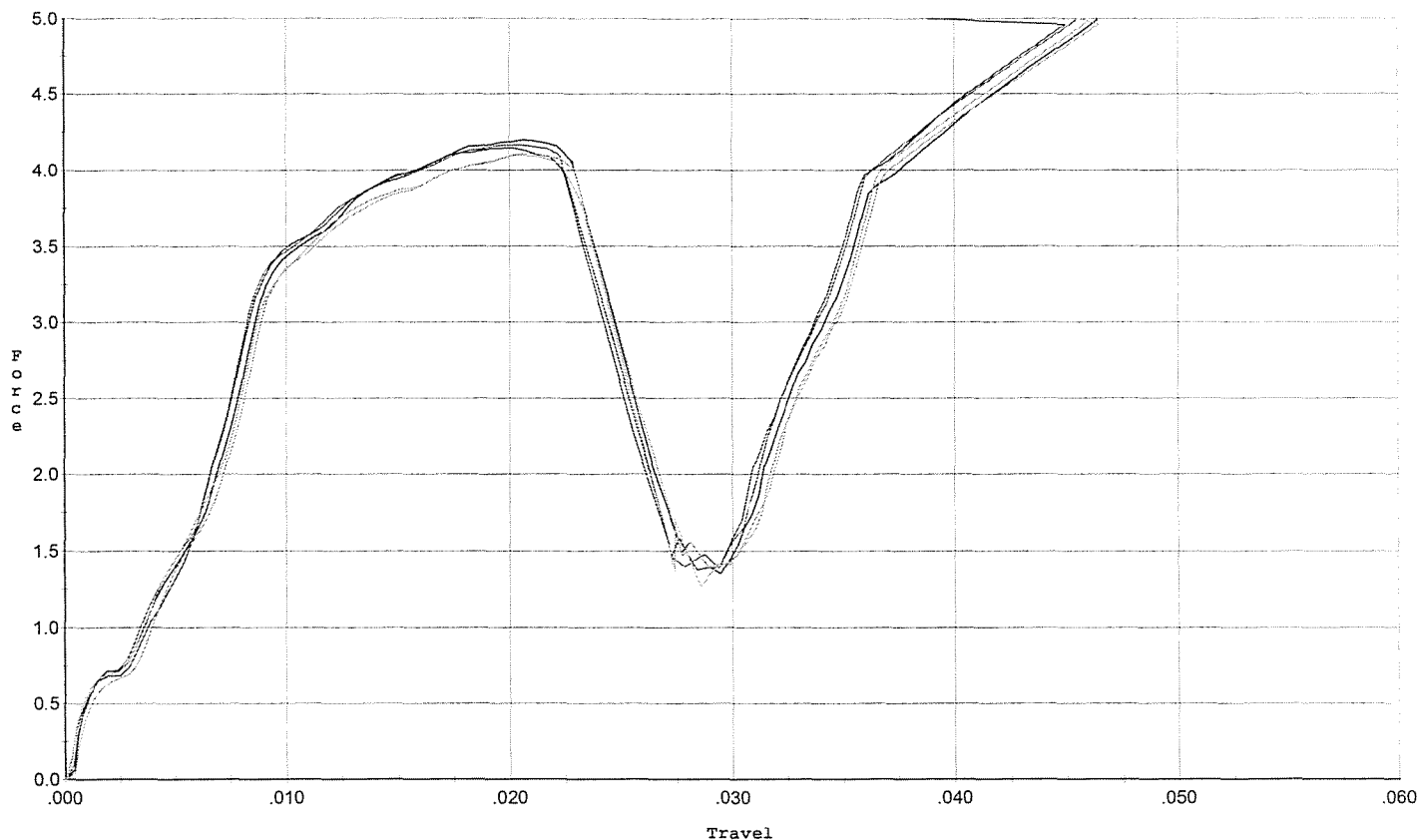
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.107	0.020	0.00	0.028	0.044		Set Trigger
2	3.077	0.021	0.00	0.029	0.044		Set Trigger
3	3.082	0.020	0.00	0.029	0.043		Set Trigger
4	3.023	0.021	0.00	0.029	0.044		Set Trigger
5	3.116	0.021	0.00	0.029	0.043		Set Trigger

A.3.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



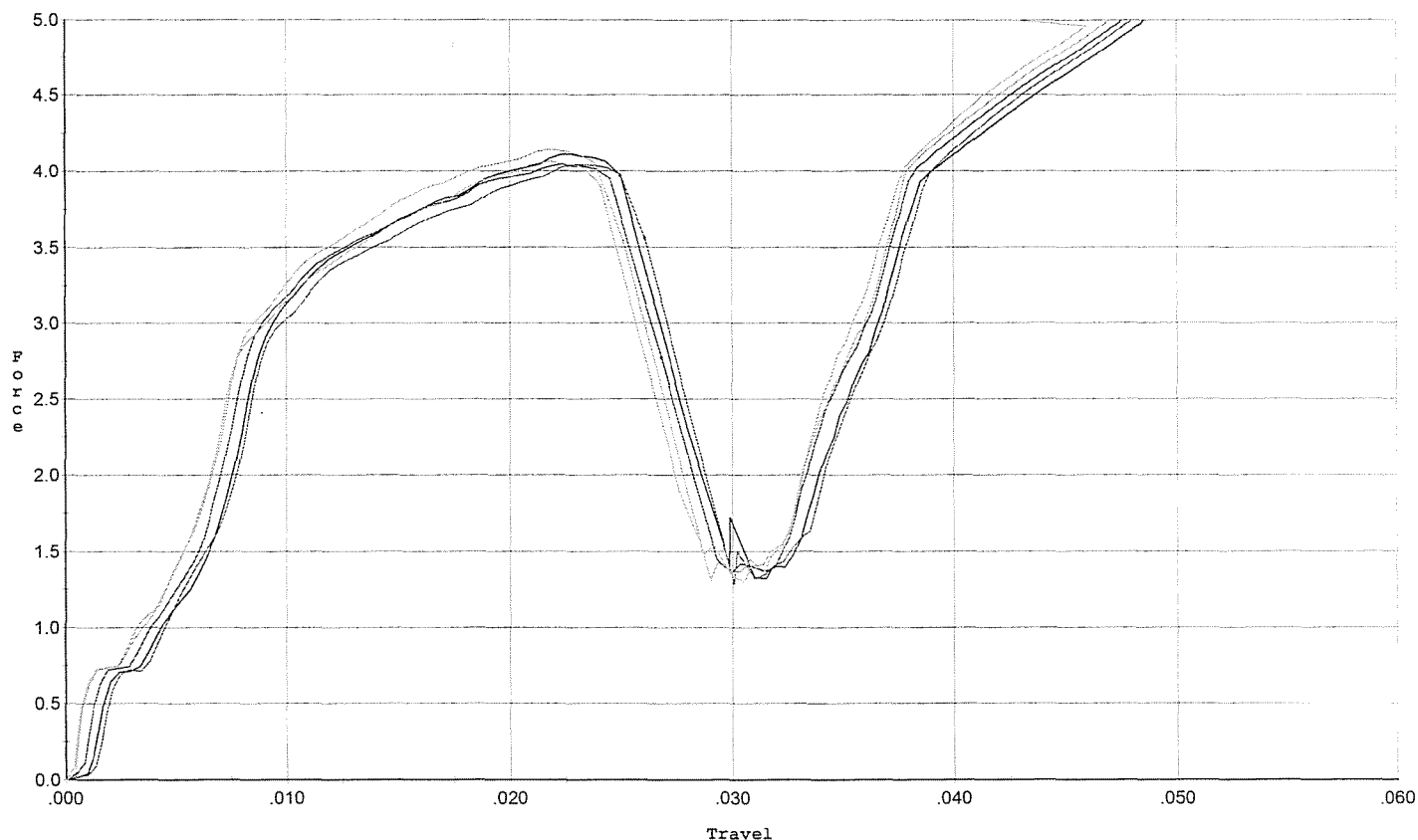
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.022	0.00	0.022	0.062		Set Trigger
2	4.198	0.023	0.00	0.022	0.063		Set Trigger
3	4.164	0.025	0.00	0.021	0.068		Set Trigger
4	4.096	0.023	0.00	0.022	0.063		Set Trigger
5	4.108	0.023	0.00	0.022	0.062		Set Trigger

A. 4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



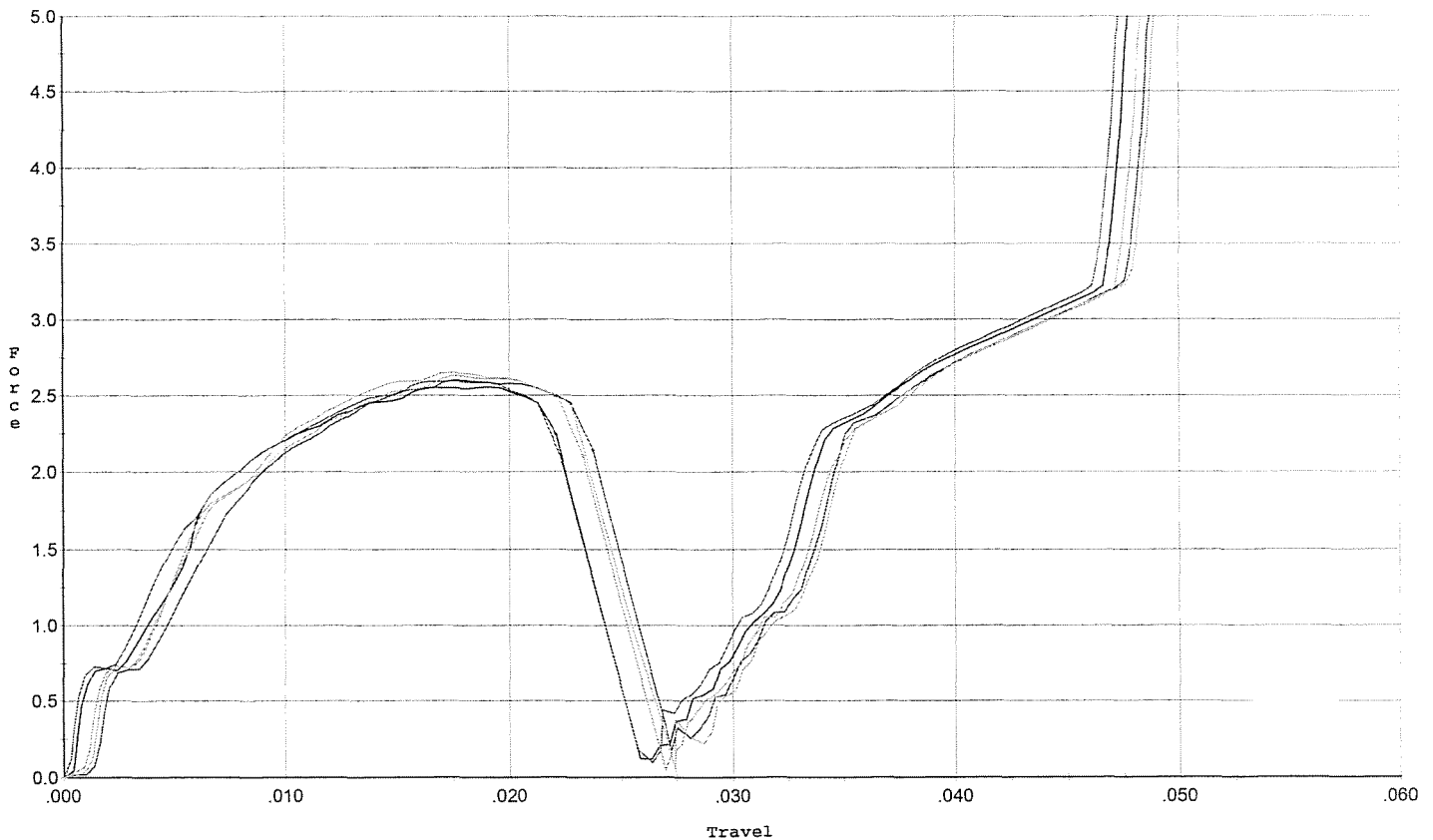
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.043	0.027	0.00	0.021	0.072		Set Trigger
2	4.113	0.025	0.00	0.022	0.067		Set Trigger
3	4.040	0.026	0.00	0.022	0.069		Set Trigger
4	4.061	0.024	0.00	0.022	0.065		Set Trigger
5	4.140	0.025	0.00	0.022	0.070		Set Trigger

A. 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



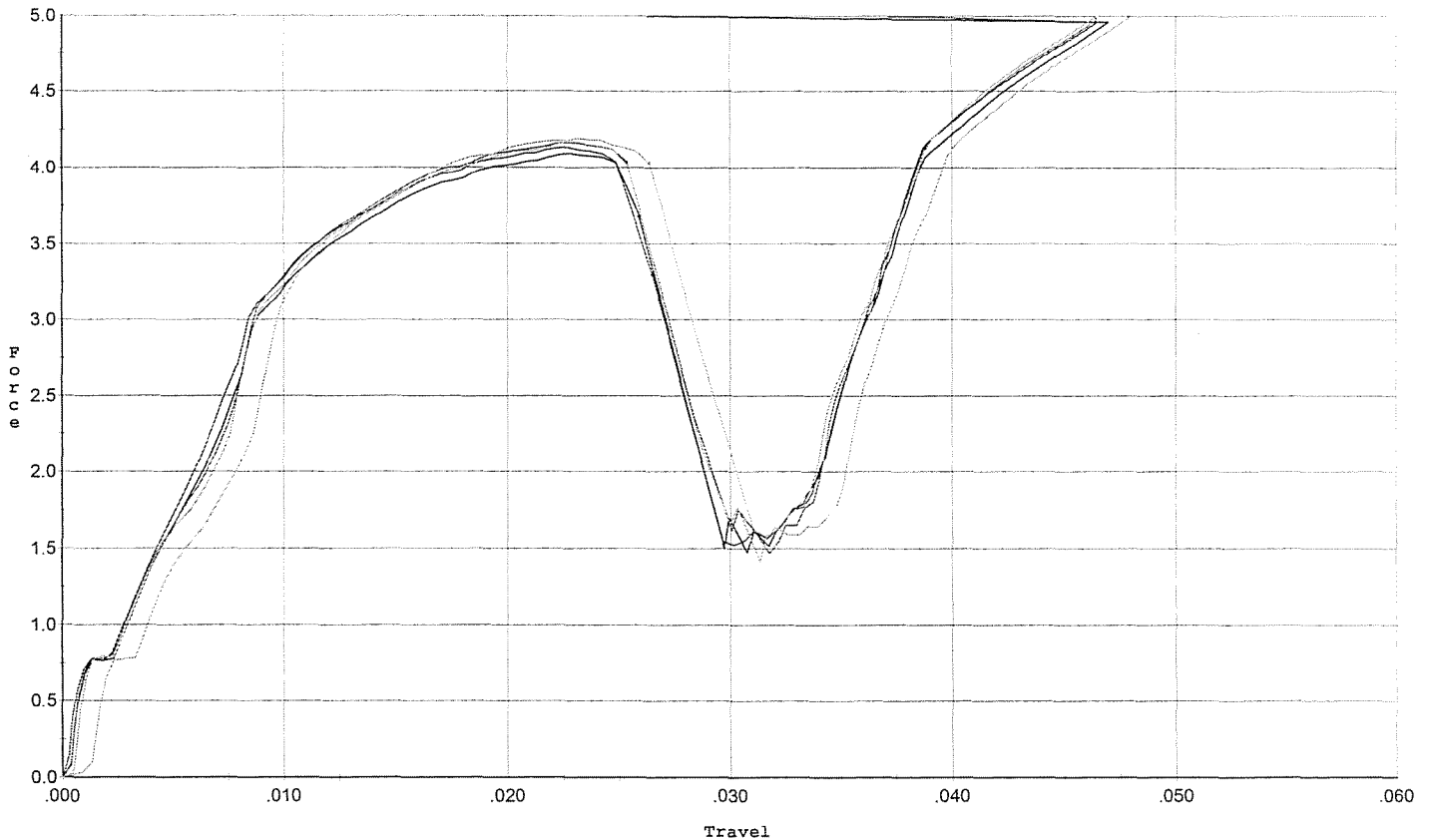
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.024	0.00	0.030	0.043		Set Trigger
2	2.558	0.022	0.00	0.031	0.041		Set Trigger
3	2.593	0.022	0.00	0.030	0.042		Set Trigger
4	2.628	0.023	0.00	0.031	0.042		Set Trigger
5	2.652	0.023	0.00	0.030	0.044		Set Trigger

A 2.60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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	4.133	0.026	0.00	0.021	0.076		Set Trigger
2	4.093	0.026	0.00	0.021	0.073		Set Trigger
3	4.164	0.025	0.00	0.021	0.073		Set Trigger
4	4.189	0.026	0.00	0.022	0.074		Set Trigger
5	4.166	0.025	0.00	0.022	0.072		Set Trigger

A-4-14