

G6801475

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



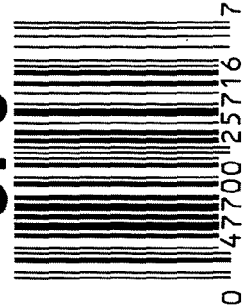
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801475

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801475

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	(11)	3-9-09	SP
490	MAGNAFLUX BOLT		3-9-09	MR
500	ROLLMARK CALIBER		3-9-09	RT
510	DRILL AND TAP SIGHT HOLES		2-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3-1-09	—
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		3-17-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-17-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

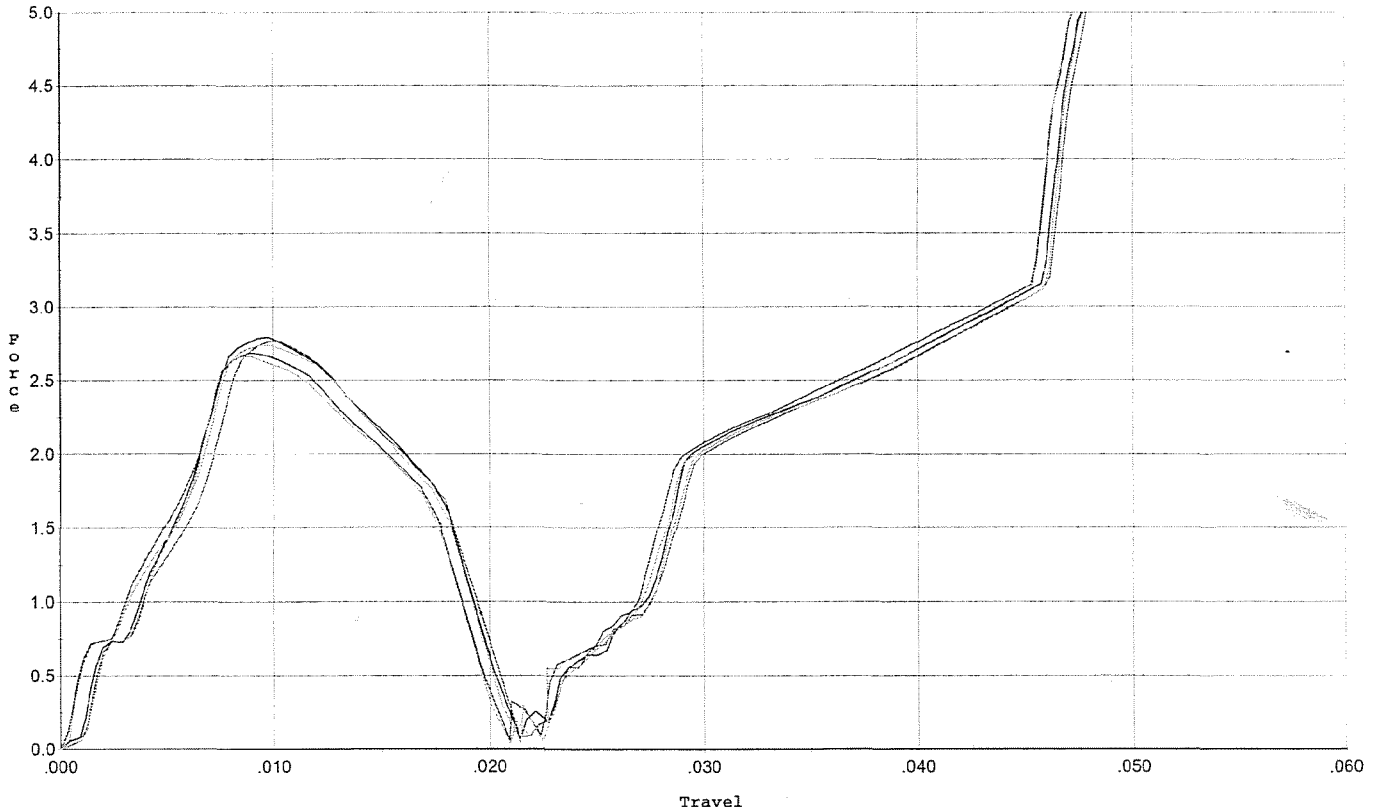
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-25-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>3.5</u> <u>4</u>	3-25-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-25-09	WW
	J) ASSEMBLE STOCK		3-23-09	RTC
	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	TL
	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>2.69</u> <u>2.60</u> <u>2.63</u> <u>2.53</u> <u>2.59</u>	3-24-09	TL
	C) FUNCTION		3-25-09	WW
690	PACK		3-27-09	Fm

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



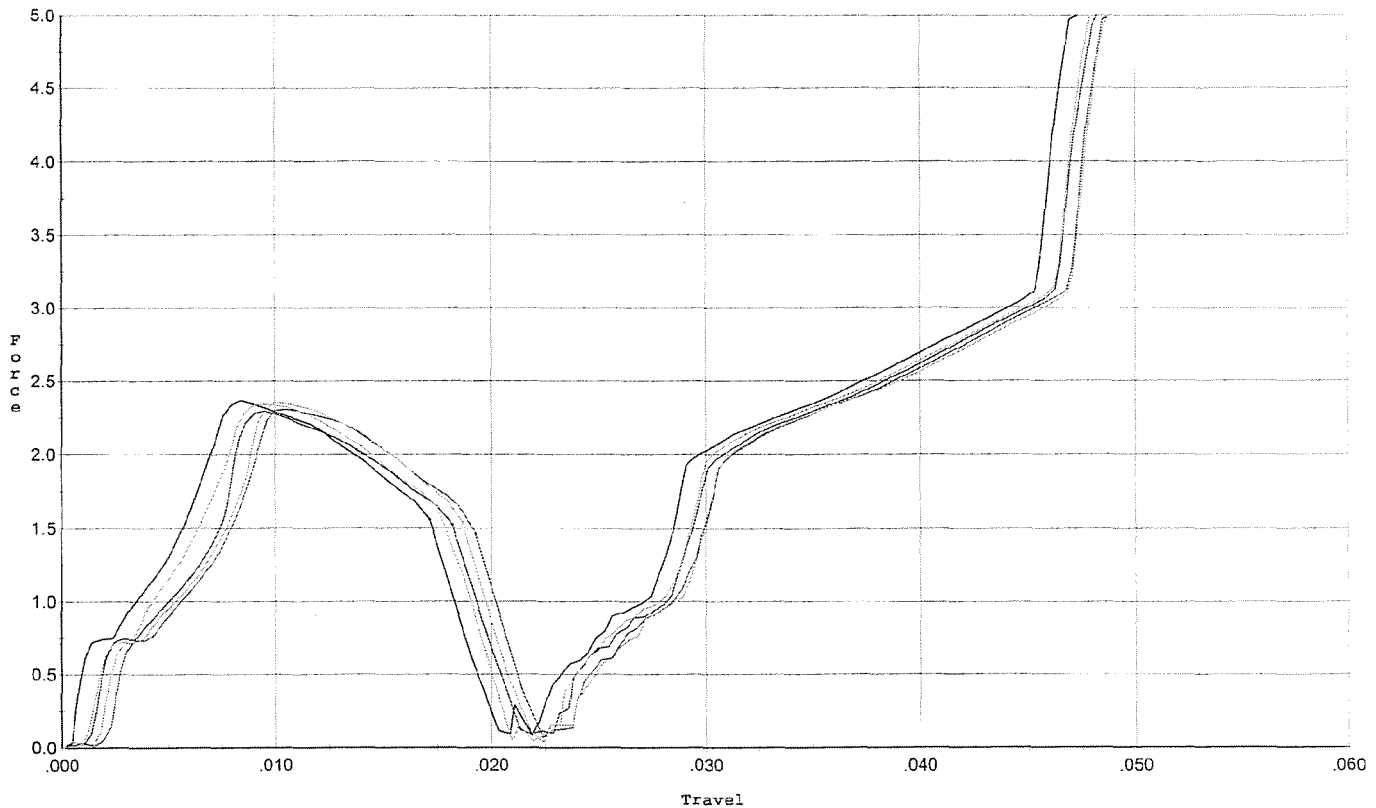
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.687	0.018	0.00	0.033	0.031		Set Trigger
2	2.795	0.018	0.00	0.034	0.031		Set Trigger
3	2.767	0.020	0.00	0.033	0.033		Set Trigger
4	2.742	0.018	0.00	0.034	0.031		Set Trigger
5	2.663	0.018	0.00	0.034	0.030		Set Trigger

A. 2-73

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



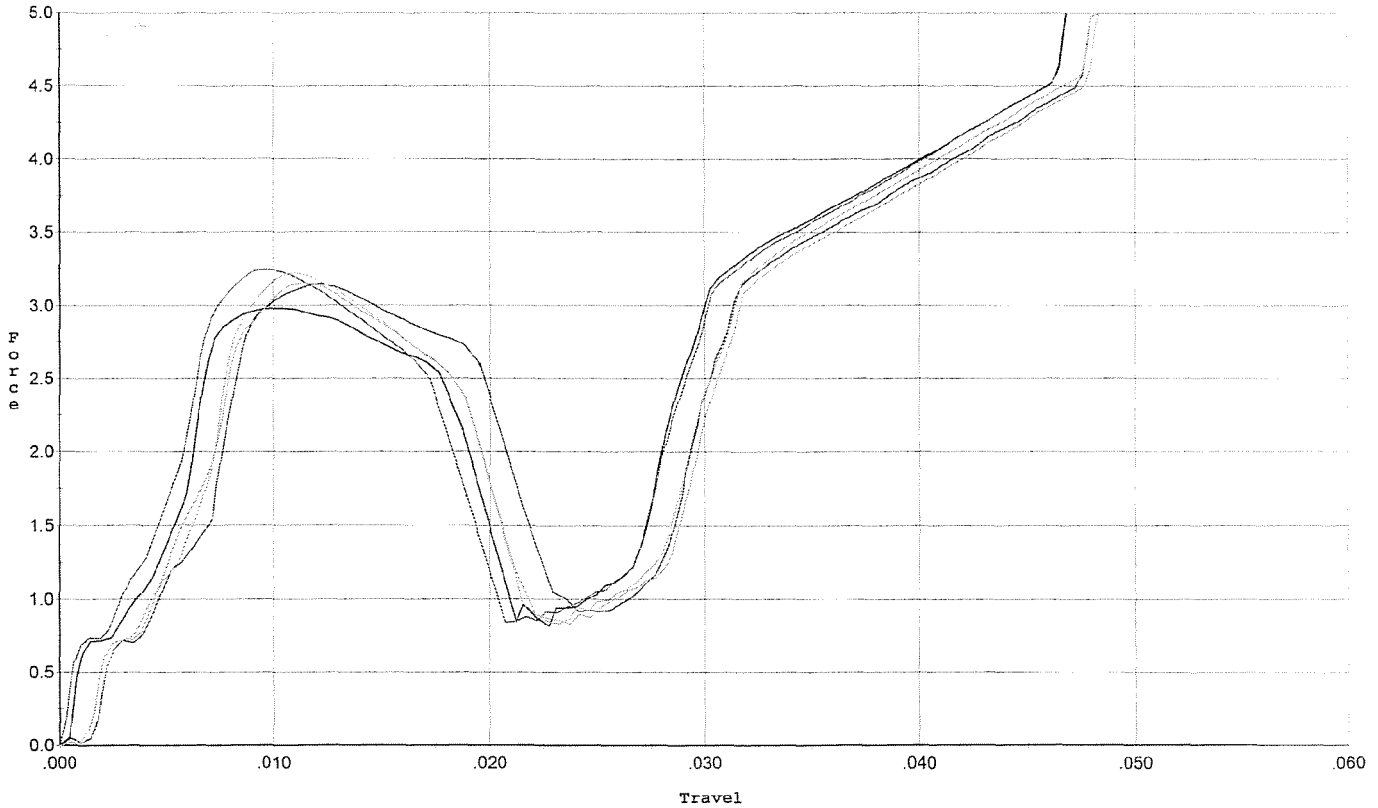
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.292	0.018	0.00	0.034	0.026		Set Trigger
2	2.364	0.017	0.00	0.034	0.027		Set Trigger
3	2.305	0.019	0.00	0.034	0.027		Set Trigger
4	2.342	0.019	0.00	0.034	0.028		Set Trigger
5	2.346	0.019	0.00	0.034	0.027		Set Trigger

A-2-33

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



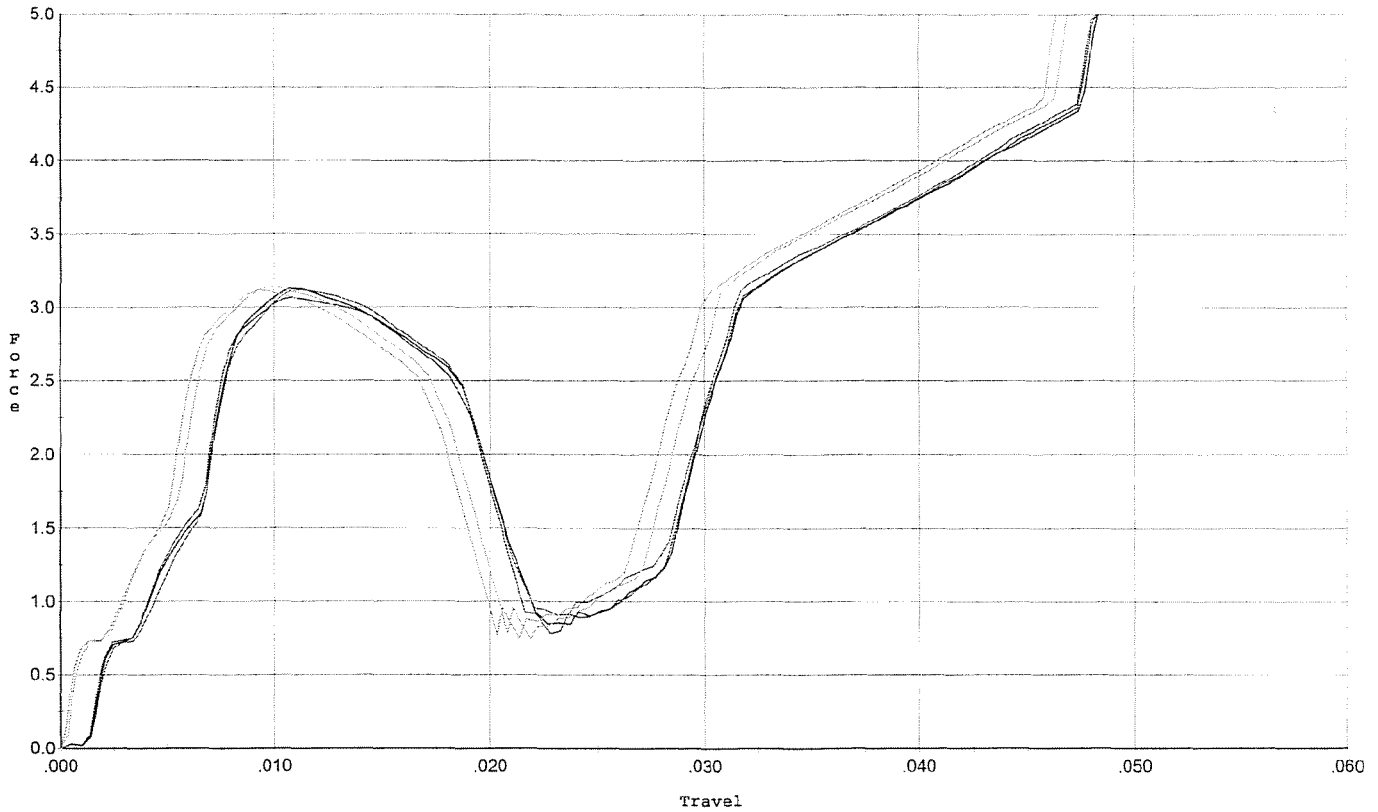
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.148	0.020	0.00	0.030	0.039		Set Trigger
2	2.980	0.019	0.00	0.030	0.038		Set Trigger
3	3.246	0.019	0.00	0.031	0.040		Set Trigger
4	3.221	0.019	0.00	0.031	0.038		Set Trigger
5	3.152	0.019	0.00	0.032	0.037		Set Trigger

A-3.14

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



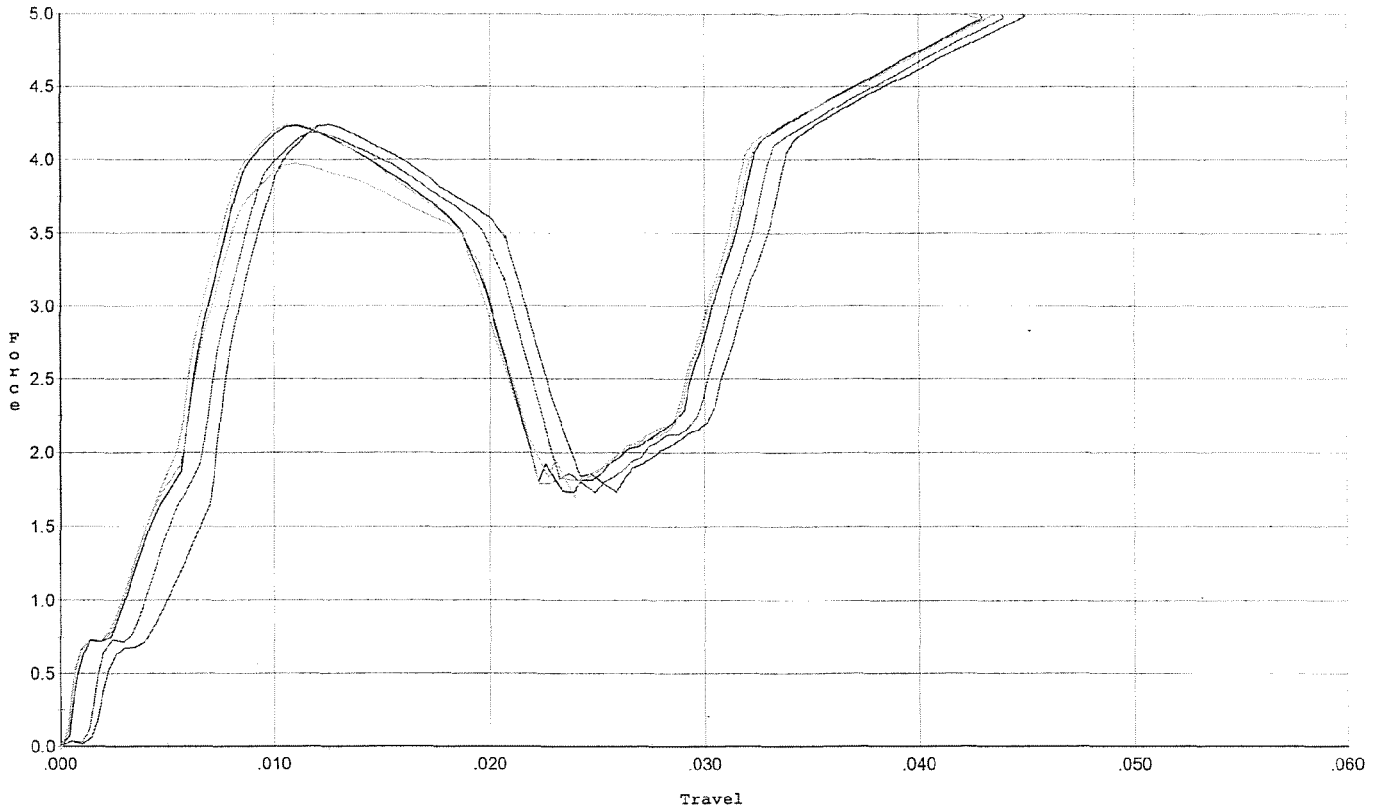
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.019	0.00	0.031	0.038		Set Trigger
2	3.129	0.019	0.00	0.031	0.037		Set Trigger
3	3.120	0.019	0.00	0.031	0.037		Set Trigger
4	3.142	0.018	0.00	0.031	0.038		Set Trigger
5	3.119	0.018	0.00	0.031	0.037		Set Trigger

A-3.11

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



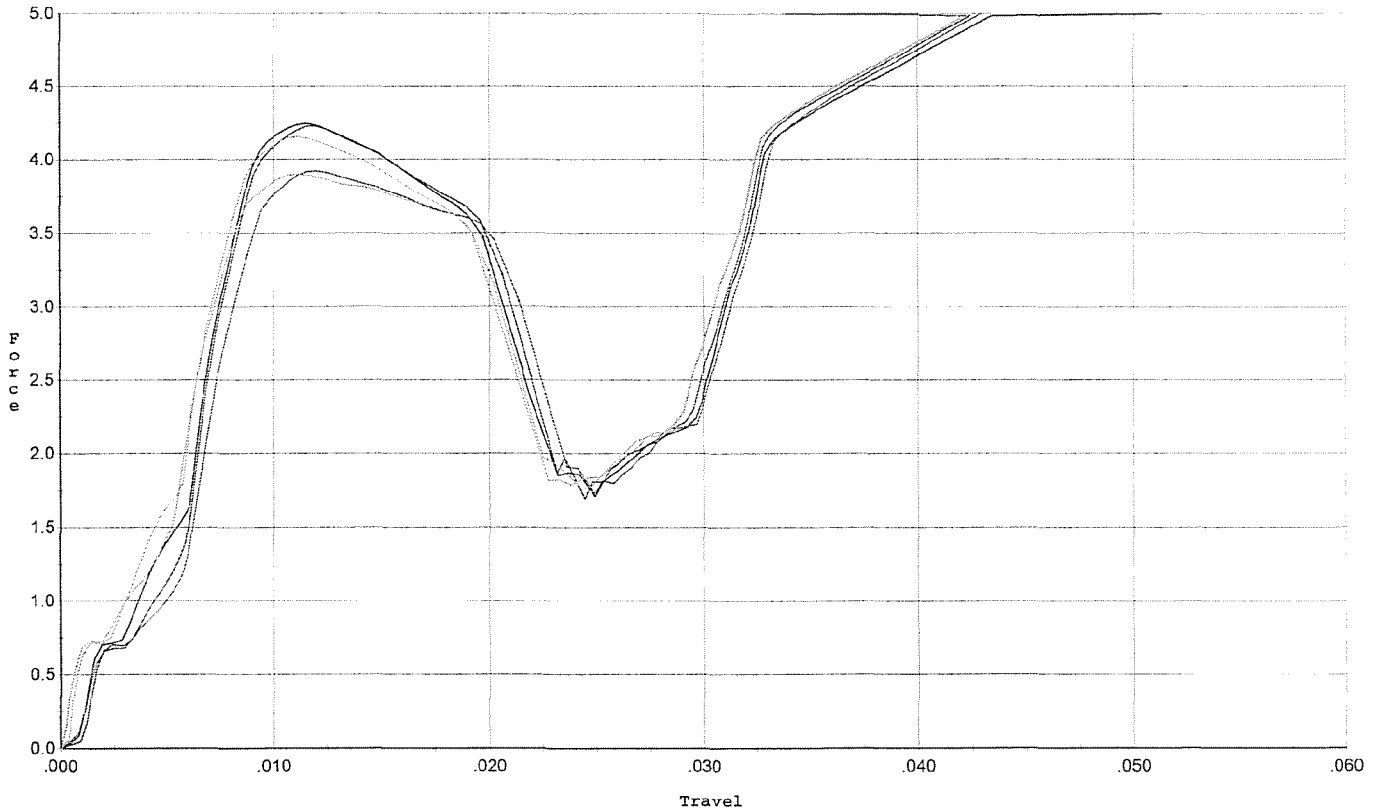
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.239	0.021	0.00	0.030	0.053		Set Trigger
2	4.231	0.020	0.00	0.029	0.054		Set Trigger
3	4.182	0.021	0.00	0.029	0.054		Set Trigger
4	3.971	0.019	0.00	0.029	0.052		Set Trigger
5	4.240	0.020	0.00	0.029	0.056		Set Trigger

A-4.17

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



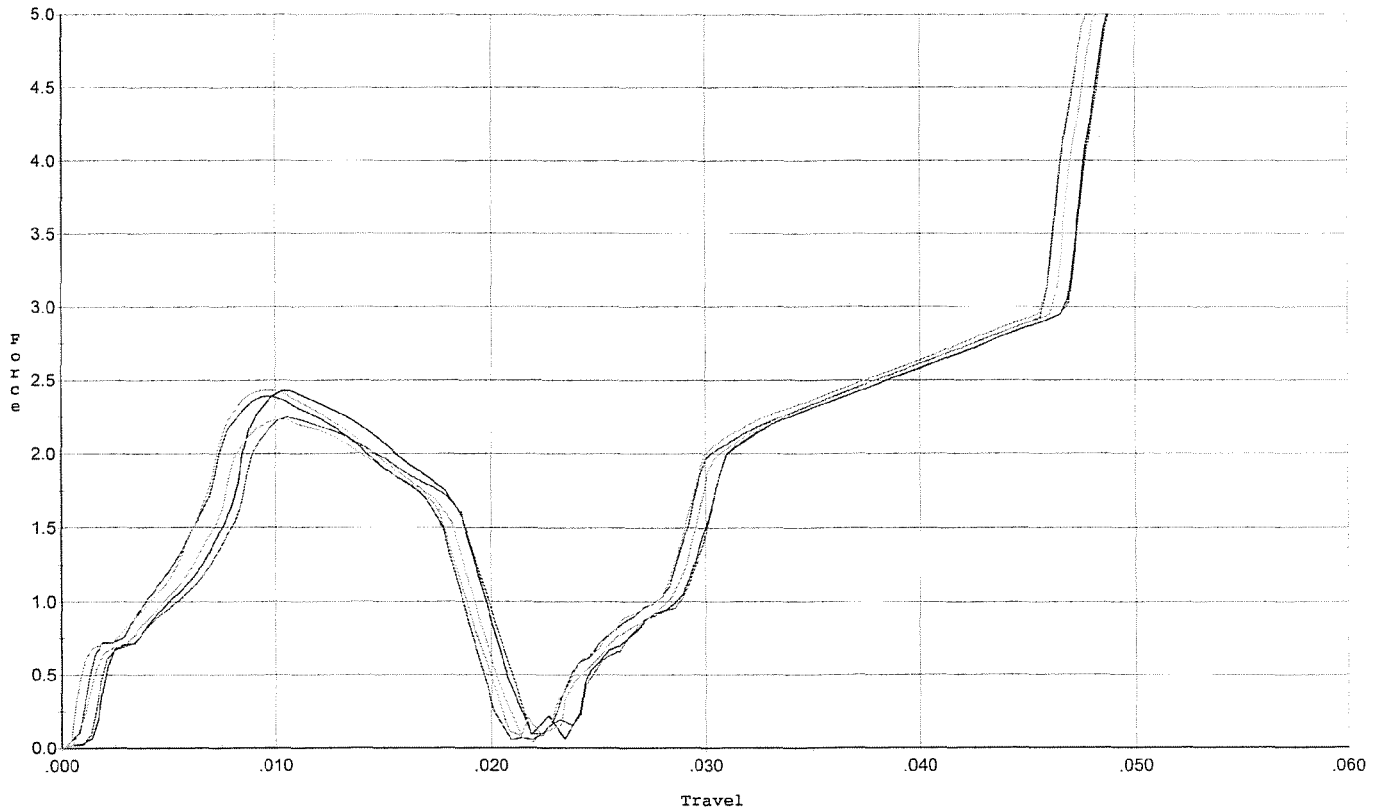
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.228	0.021	0.00	0.029	0.054		Set Trigger
2	4.246	0.020	0.00	0.030	0.053		Set Trigger
3	3.921	0.021	0.00	0.029	0.054		Set Trigger
4	4.156	0.021	0.00	0.029	0.056		Set Trigger
5	3.899	0.020	0.00	0.029	0.053		Set Trigger

A-4.09

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



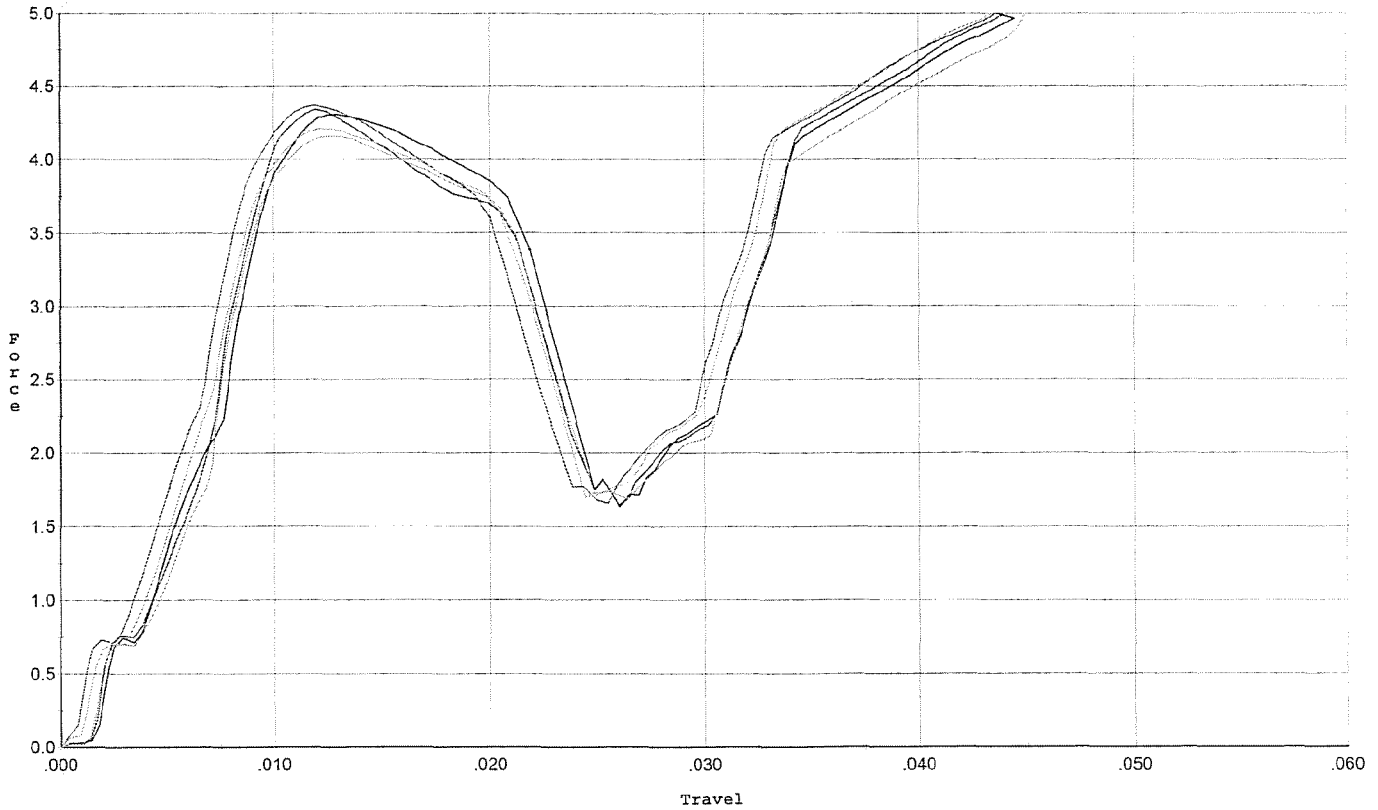
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.393	0.018	0.00	0.034	0.027		Set Trigger
2	2.428	0.019	0.00	0.034	0.027		Set Trigger
3	2.248	0.019	0.00	0.034	0.026		Set Trigger
4	2.231	0.018	0.00	0.034	0.026		Set Trigger
5	2.434	0.018	0.00	0.034	0.028		Set Trigger

A-2-34

Trigger Profile [lbs,inch]

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

Model: M/24
Serial No: Form #F005
Trigger: 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	4.339	0.021	0.00	0.029	0.056		Set Trigger
2	4.307	0.022	0.00	0.029	0.059		Set Trigger
3	4.368	0.020	0.00	0.029	0.056		Set Trigger
4	4.209	0.022	0.00	0.028	0.059		Set Trigger
5	4.156	0.021	0.004	0.029	0.055		Set Trigger

A 4-27