

G6801482

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

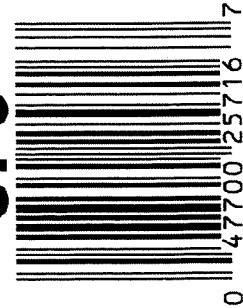
24"

CAPACITY

6

G6801482

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 1482

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	RIZ
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
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		3-27-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

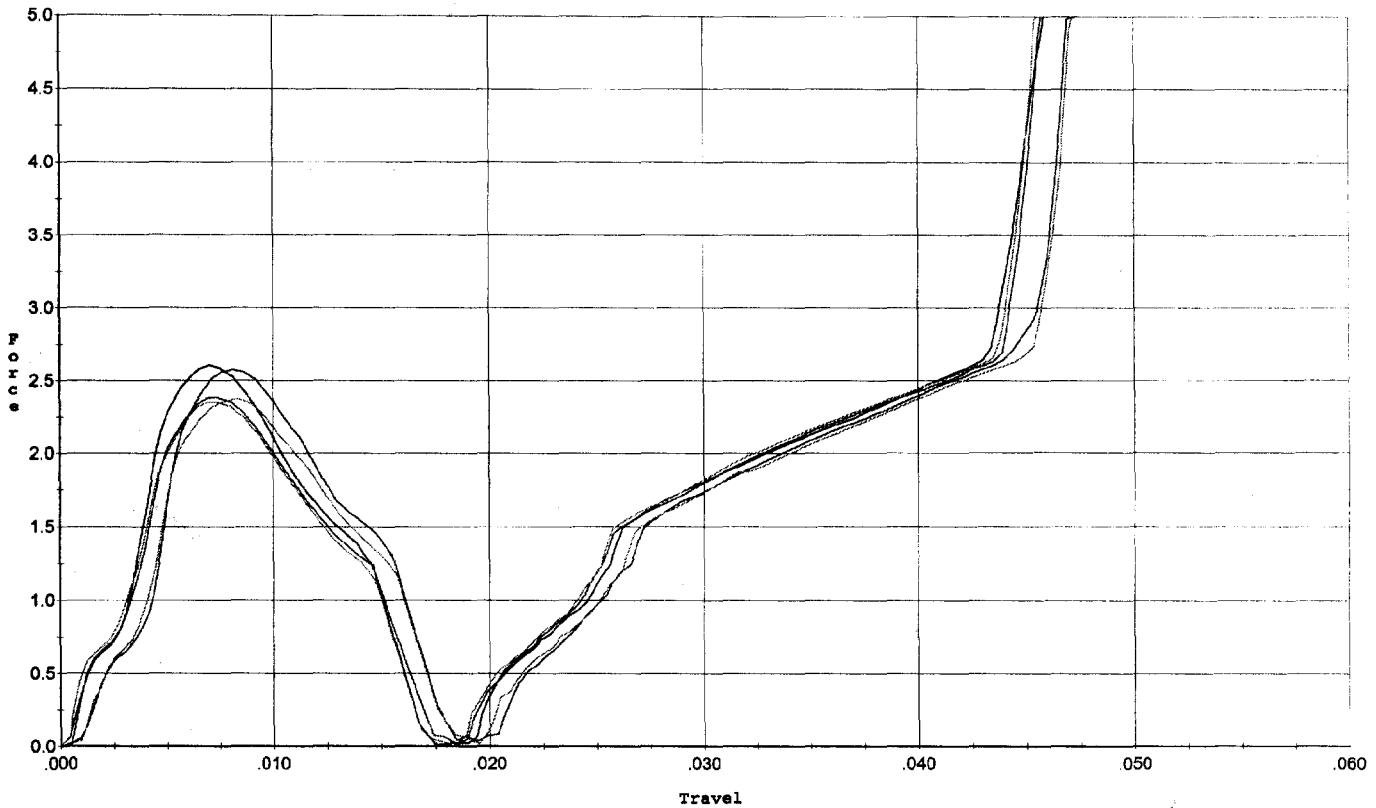
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>5.5</u> <u>6</u>	3-31-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-31-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-31-09	WV
	J) ASSEMBLE STOCK		3-27-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-31-09	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	3-30-09	J.P.R.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.62</u> <u>2.57</u> <u>2.17</u> <u>2.55</u>	3-31-09	WV
	C) FUNCTION		3-31-09	WV
690	PACK		5/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



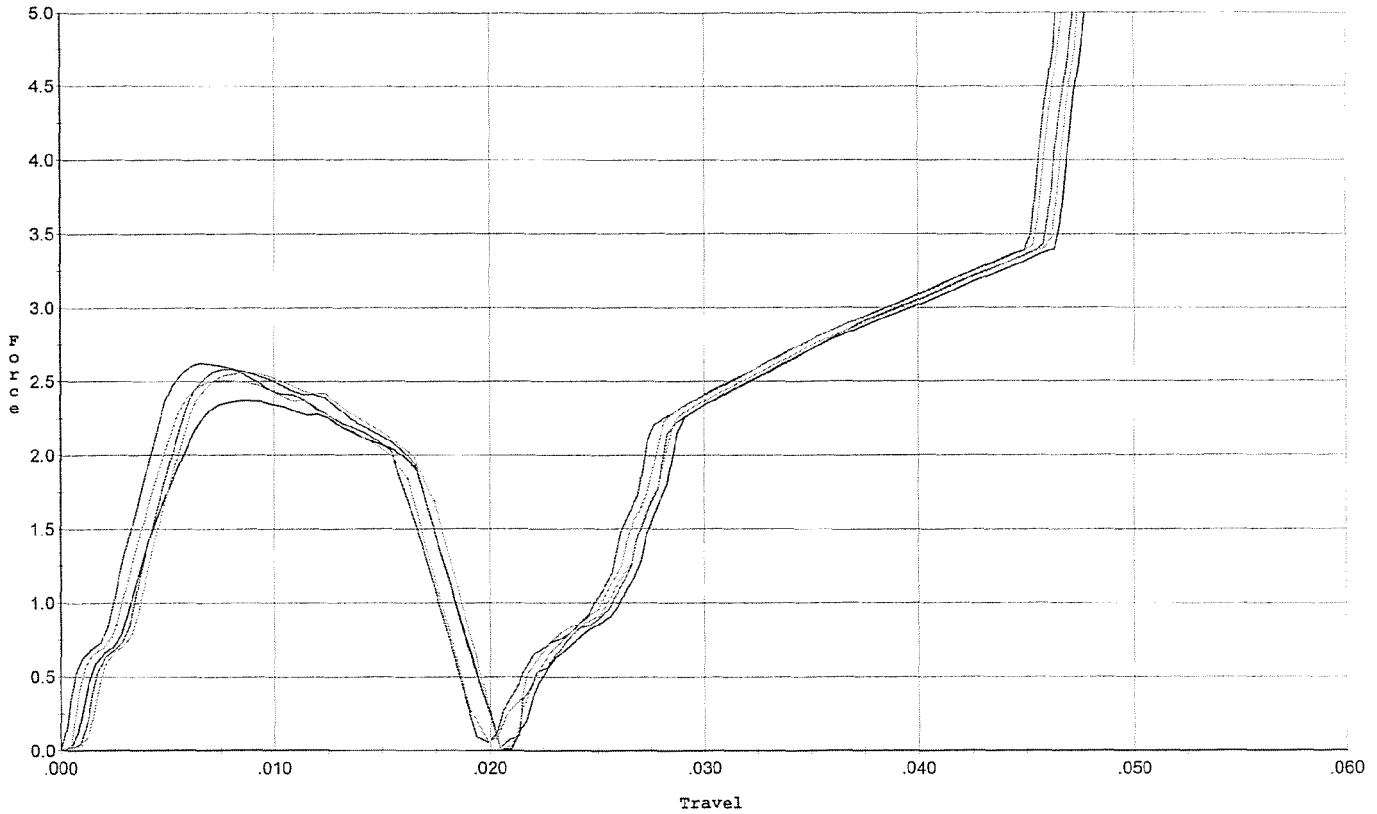
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.576	0.016	0.00	0.036	0.023		Set Trigger
2	2.606	0.015	0.00	0.036	0.023		Set Trigger
3	2.386	0.015	0.00	0.036	0.021		Set Trigger
4	2.351	0.015	0.00	0.036	0.022		Set Trigger
5	2.374	0.016	0.00	0.036	0.022		Set Trigger

A-2-45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



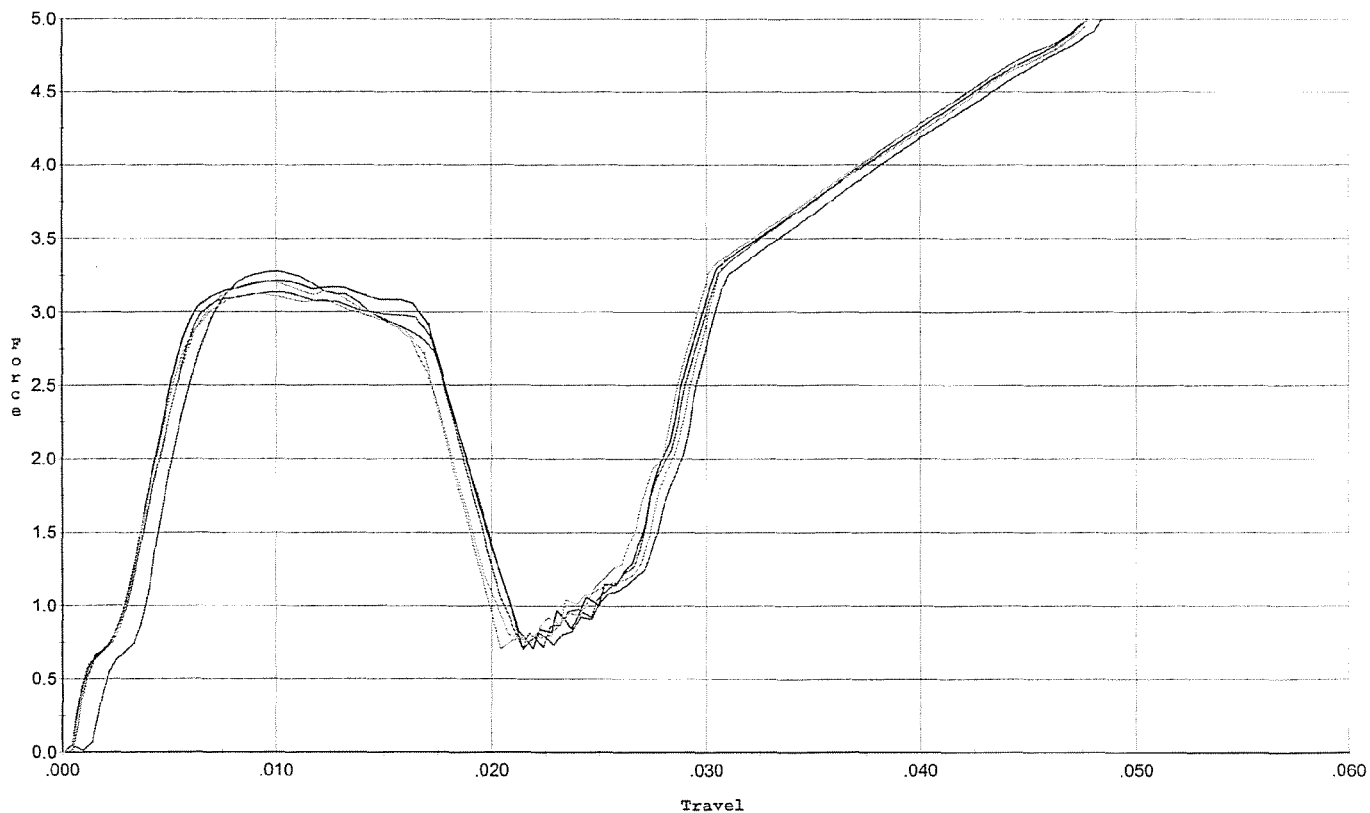
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.624	0.017	0.00	0.033	0.031		Set Trigger
2	2.370	0.017	0.00	0.034	0.028		Set Trigger
3	2.578	0.017	0.00	0.034	0.029		Set Trigger
4	2.560	0.017	0.00	0.034	0.030		Set Trigger
5	2.508	0.016	0.00	0.033	0.029		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



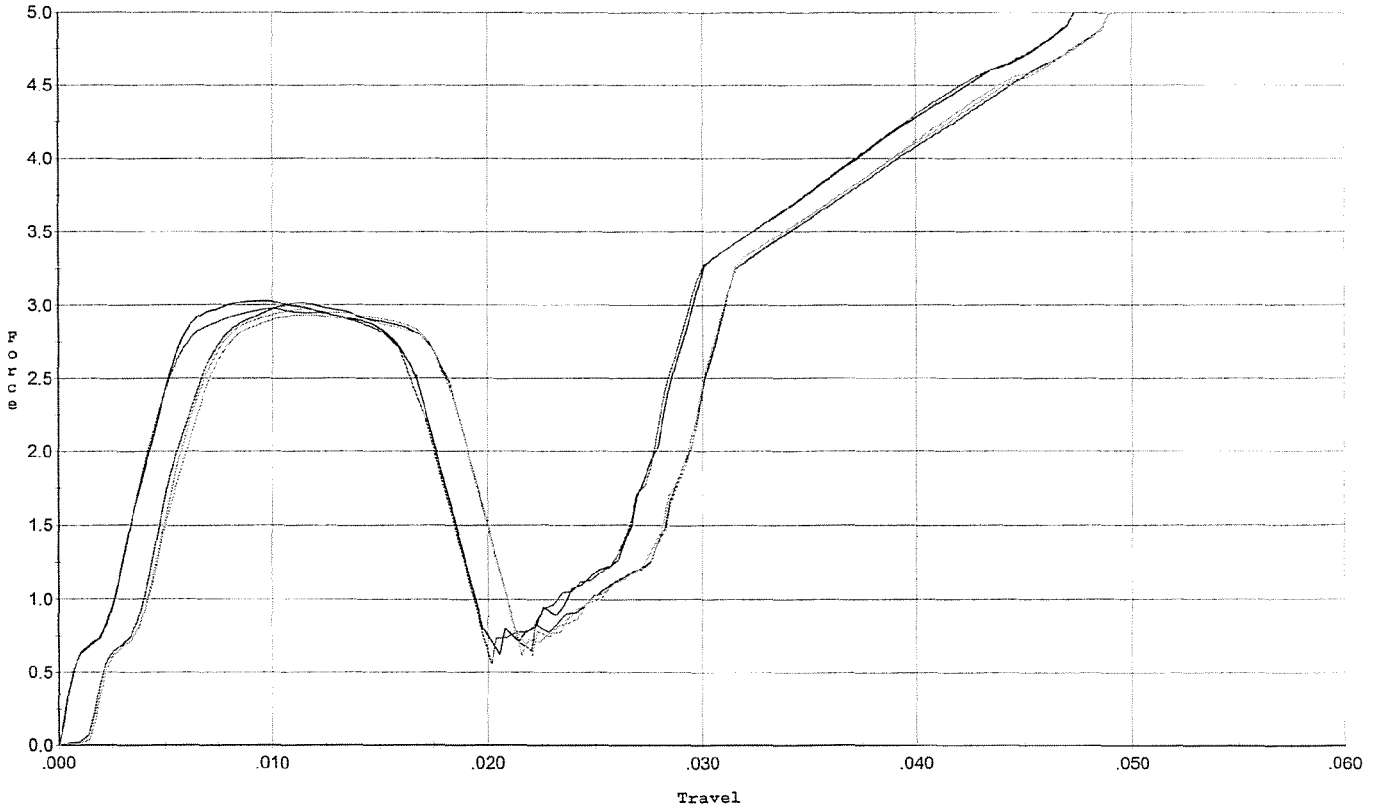
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.278	0.019	0.00	0.031	0.042		Set Trigger
2	3.214	0.017	0.00	0.031	0.039		Set Trigger
3	3.137	0.017	0.00	0.031	0.039		Set Trigger
4	3.212	0.017	0.00	0.031	0.038		Set Trigger
5	3.126	0.017	0.00	0.031	0.038		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



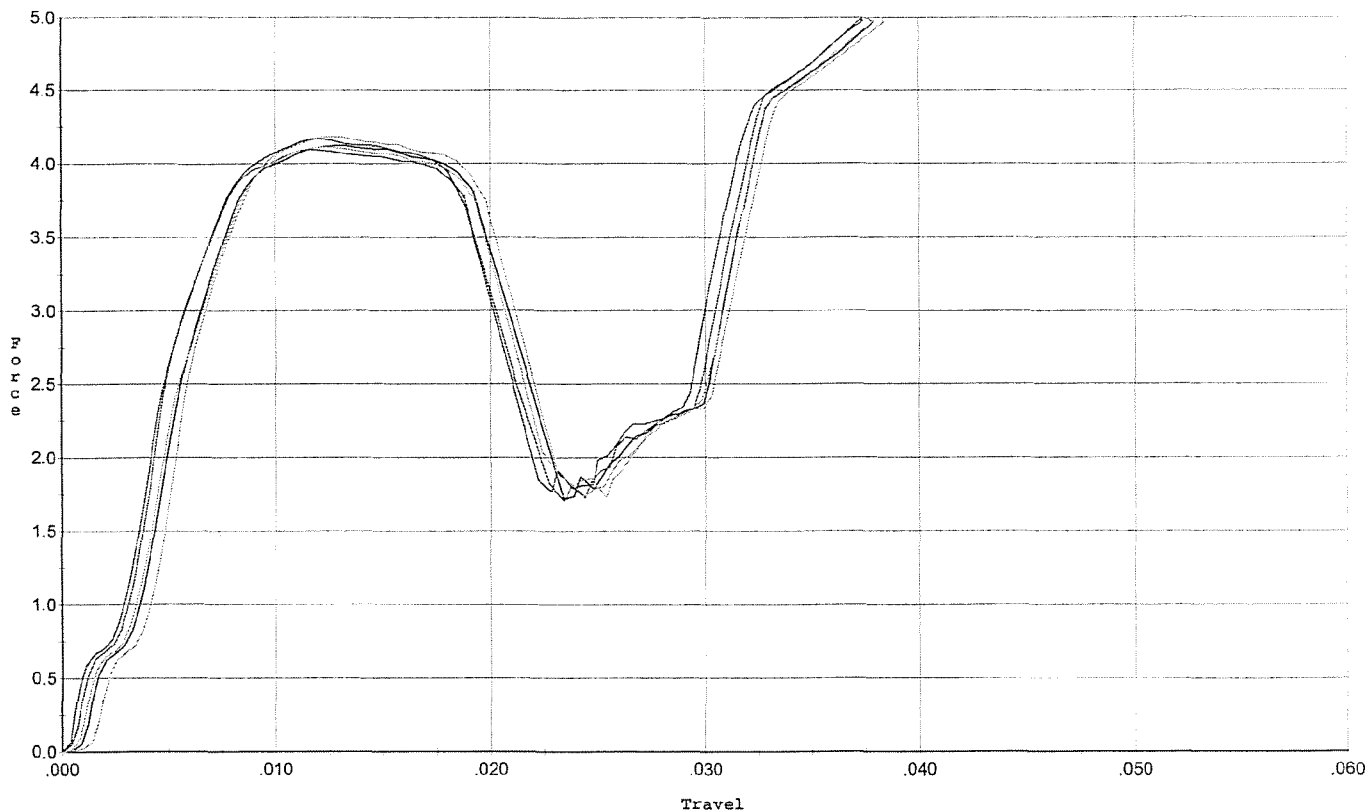
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.017	0.018	0.00	0.032	0.037		Set Trigger
2	3.030	0.017	0.00	0.031	0.037		Set Trigger
3	2.975	0.017	0.00	0.031	0.037		Set Trigger
4	2.934	0.018	0.00	0.032	0.036		Set Trigger
5	2.973	0.018	0.00	0.032	0.037		Set Trigger

A-298

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



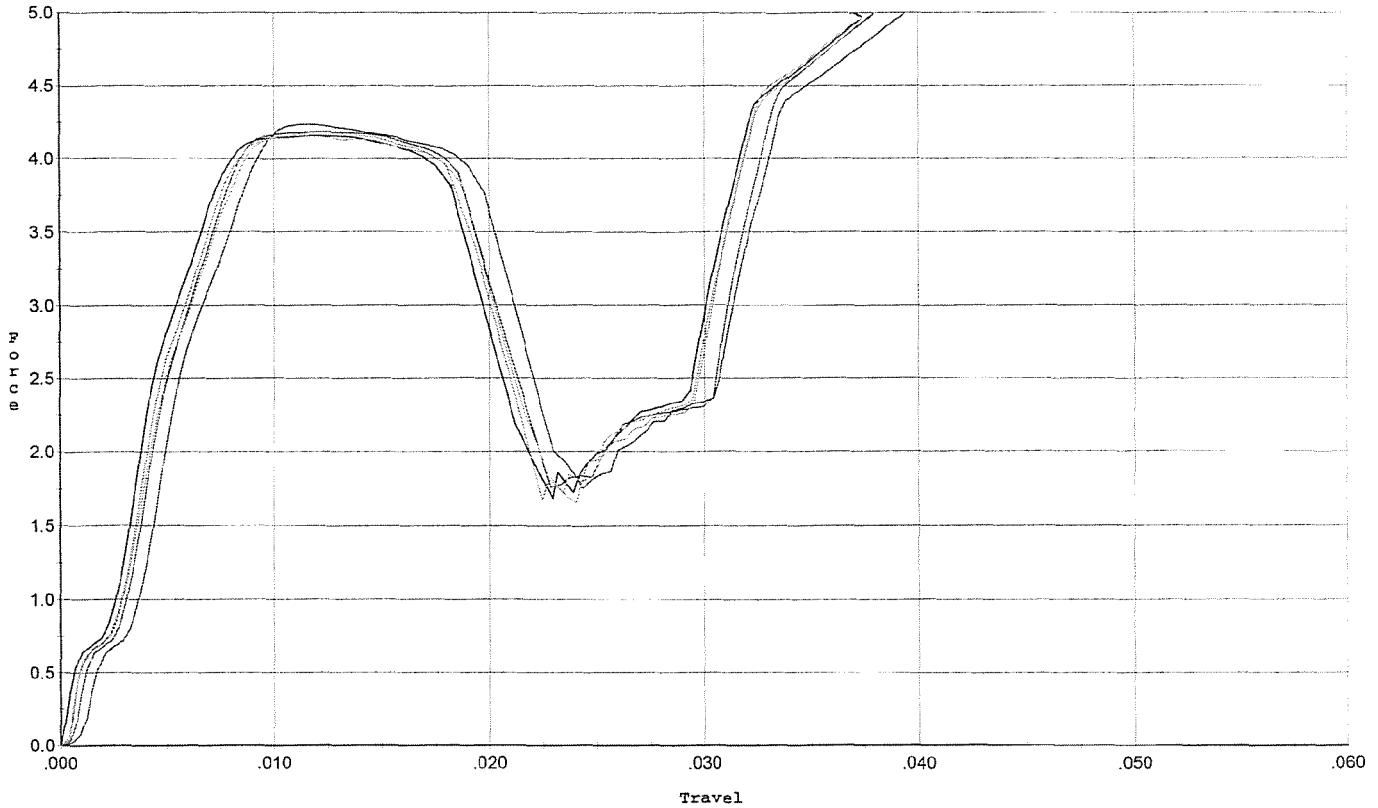
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.019	0.00	0.030	0.055		Set Trigger
2	4.123	0.019	0.00	0.030	0.053		Set Trigger
3	4.095	0.019	0.00	0.030	0.053		Set Trigger
4	4.115	0.019	0.00	0.030	0.054		Set Trigger
5	4.180	0.020	0.00	0.030	0.055		Set Trigger

A.4-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



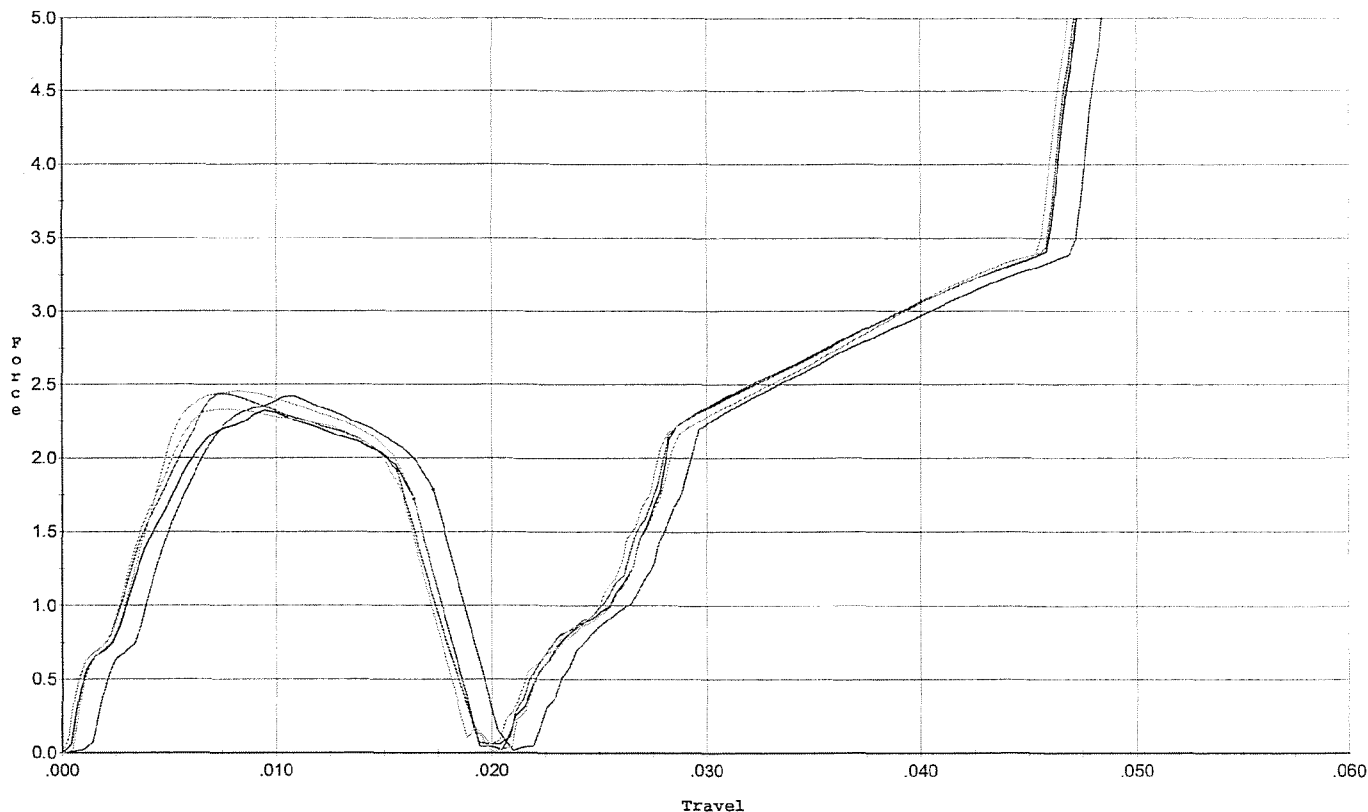
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.235	0.020	0.00	0.030	0.056		Set Trigger
2	4.159	0.018	0.00	0.030	0.053		Set Trigger
3	4.183	0.019	0.00	0.030	0.053		Set Trigger
4	4.156	0.019	0.00	0.030	0.054		Set Trigger
5	4.175	0.019	0.00	0.030	0.056		Set Trigger

A. 4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



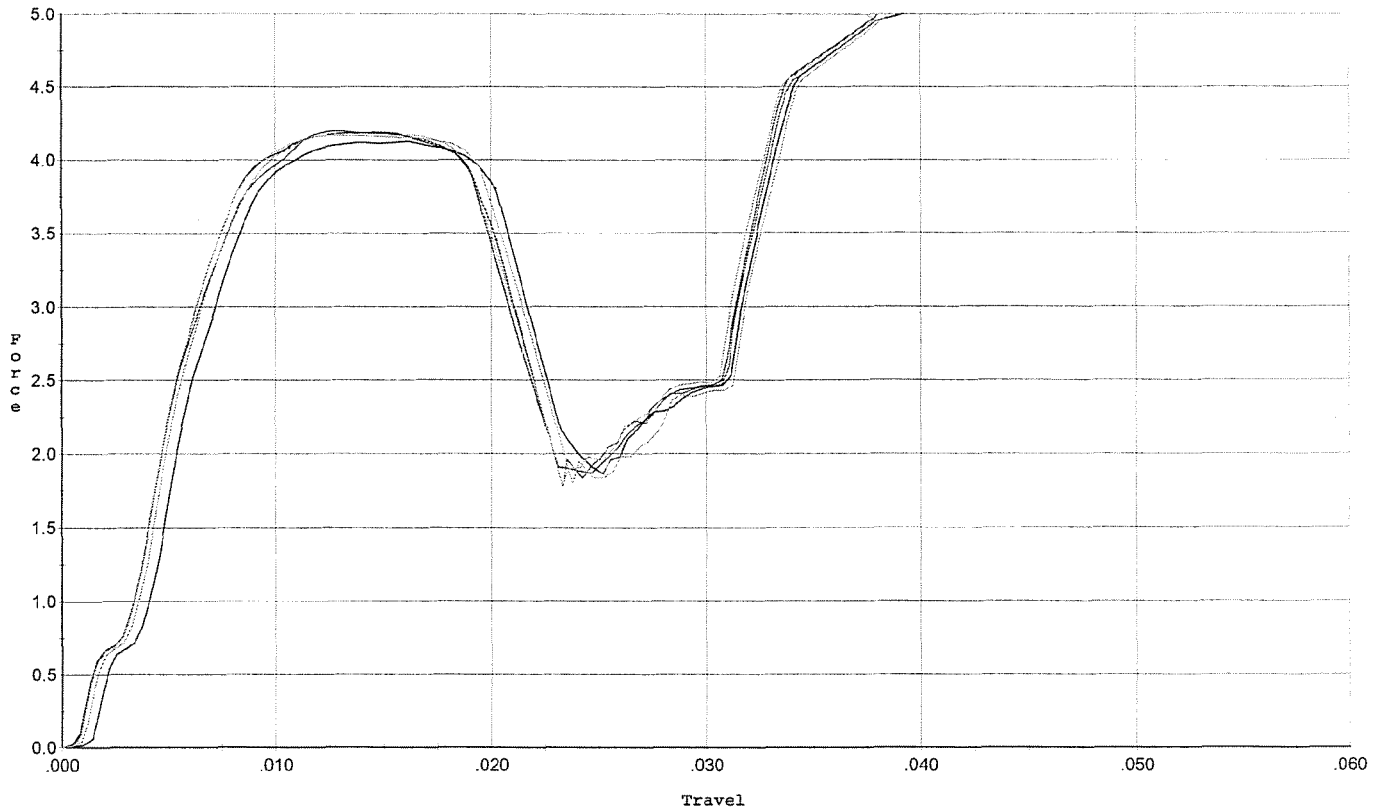
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.418	0.017	0.00	0.034	0.028		Set Trigger
2	2.324	0.016	0.00	0.034	0.027		Set Trigger
3	2.434	0.016	0.00	0.034	0.027		Set Trigger
4	2.330	0.016	0.00	0.034	0.027		Set Trigger
5	2.455	0.016	0.00	0.034	0.029		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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	4.184	0.019	0.00	0.030	0.054		Set Trigger
2	4.128	0.020	0.00	0.029	0.056		Set Trigger
3	4.197	0.020	0.00	0.029	0.058		Set Trigger
4	4.173	0.021	0.00	0.029	0.059		Set Trigger
5	4.176	0.021	0.00	0.028	0.061		Set Trigger

A-4017