

G6807656

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

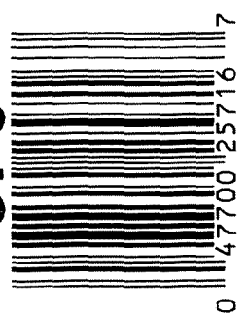
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807656

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807656

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	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RIZ
480	MAGNAFLUX BBL ACTION	(A)	3/9/09	(A)
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	72
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		3-31-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

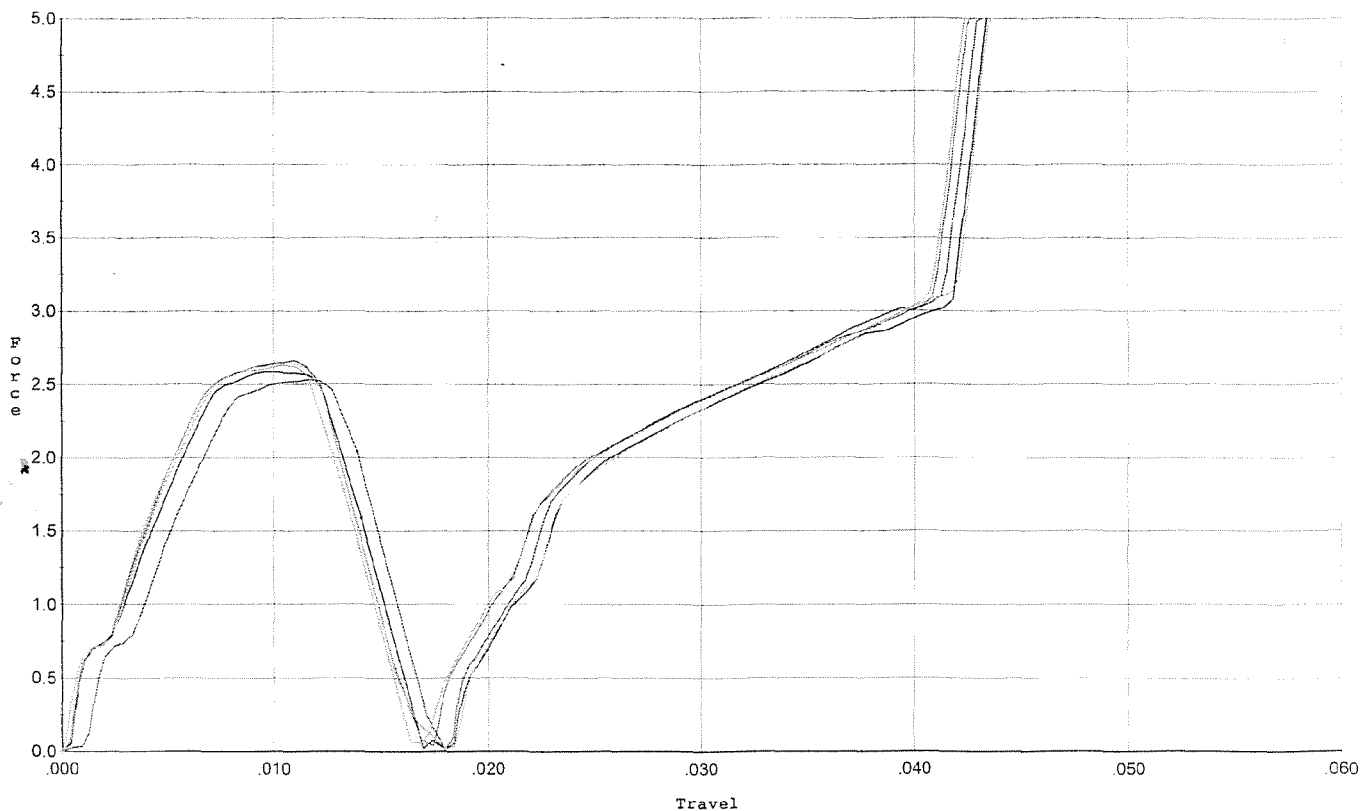
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6</u>	4-1-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>3.5</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-1-09	WV
	J) ASSEMBLE STOCK		3-31-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-1-09	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 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	3-31-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.39</u> <u>2.27</u> <u>2.36</u> <u>2.28</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		4/5/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



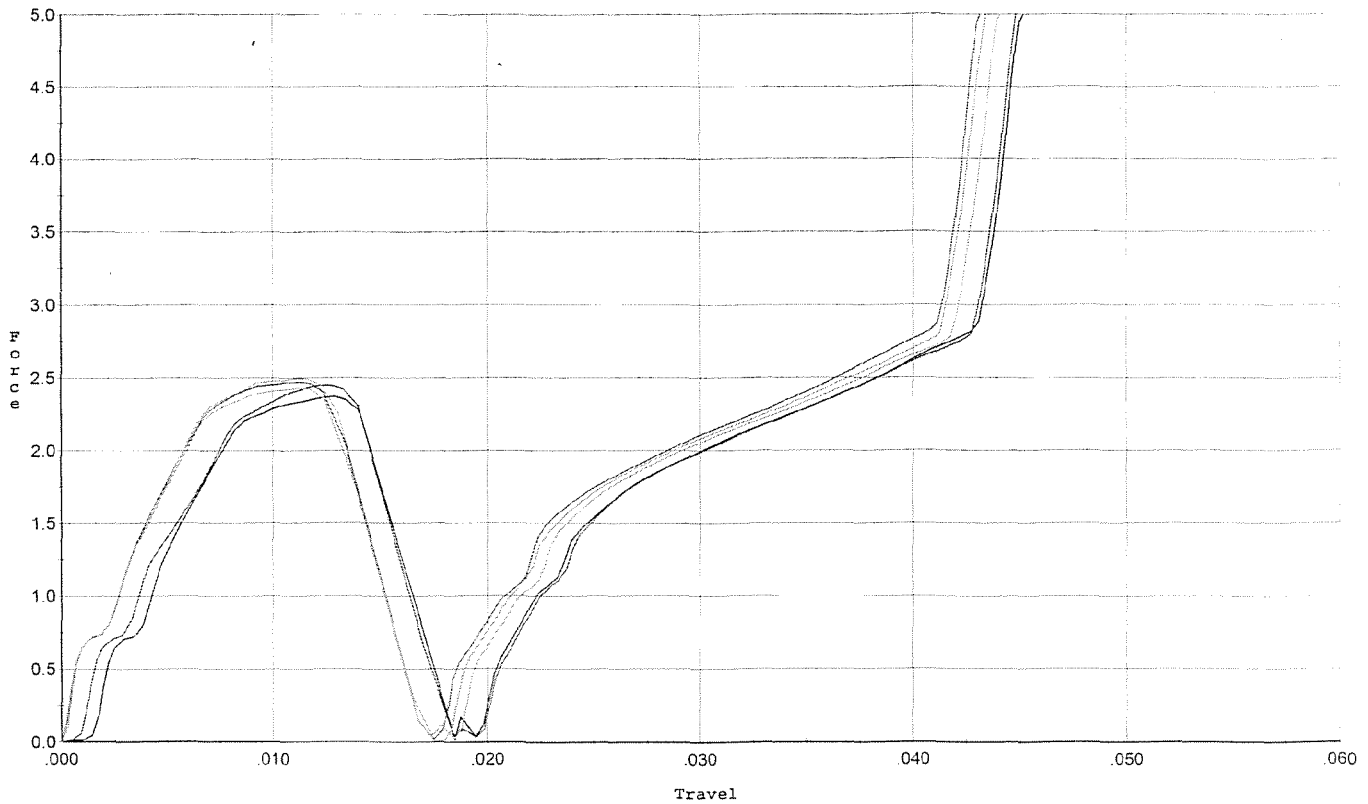
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.014	0.00	0.032	0.022		Set Trigger
2	2.584	0.014	0.00	0.033	0.024		Set Trigger
3	2.655	0.012	0.00	0.033	0.022		Set Trigger
4	2.638	0.012	0.00	0.034	0.021		Set Trigger
5	2.630	0.013	0.00	0.033	0.023		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 30 cycles +/- .50 lb
so cmf



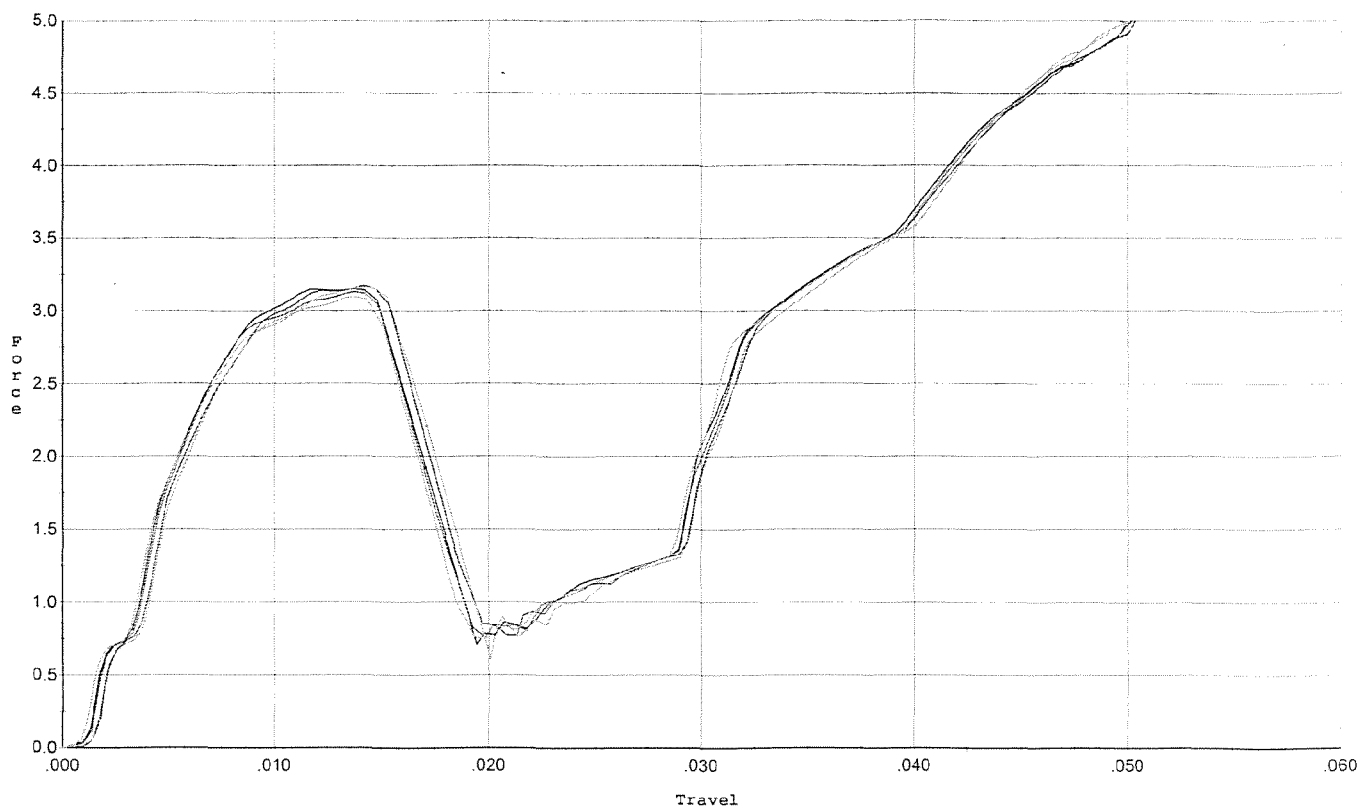
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.448	0.014	0.00	0.034	0.022		Set Trigger
2	2.373	0.014	0.00	0.034	0.021		Set Trigger
3	2.472	0.013	0.00	0.033	0.023		Set Trigger
4	2.496	0.013	0.00	0.034	0.022		Set Trigger
5	2.429	0.014	0.00	0.034	0.023		Set Trigger

A-244

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



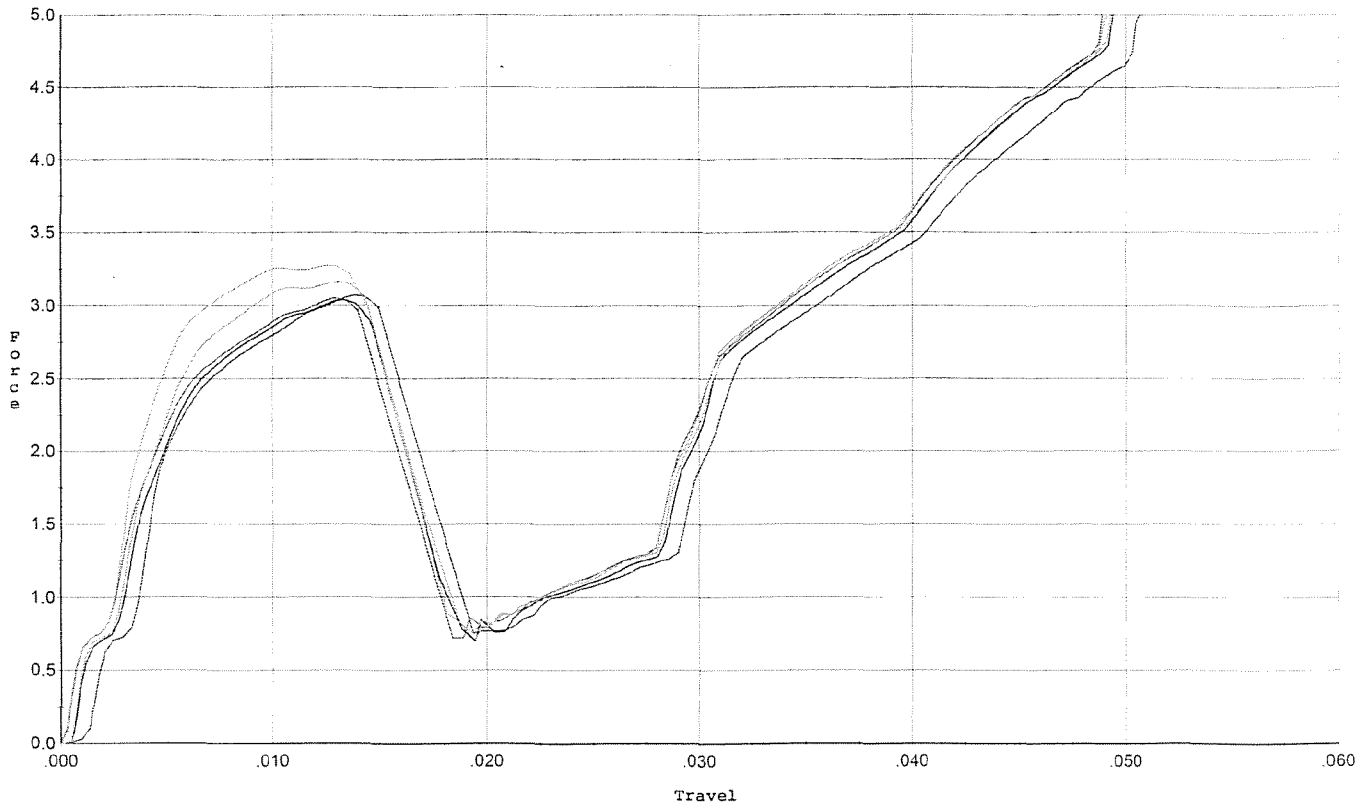
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.172	0.015	0.00	0.036	0.031		Set Trigger
2	3.146	0.017	0.00	0.035	0.035		Set Trigger
3	3.128	0.015	0.00	0.036	0.030		Set Trigger
4	3.095	0.015	0.00	0.036	0.030		Set Trigger
5	3.165	0.017	0.00	0.035	0.034		Set Trigger

A.3-14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



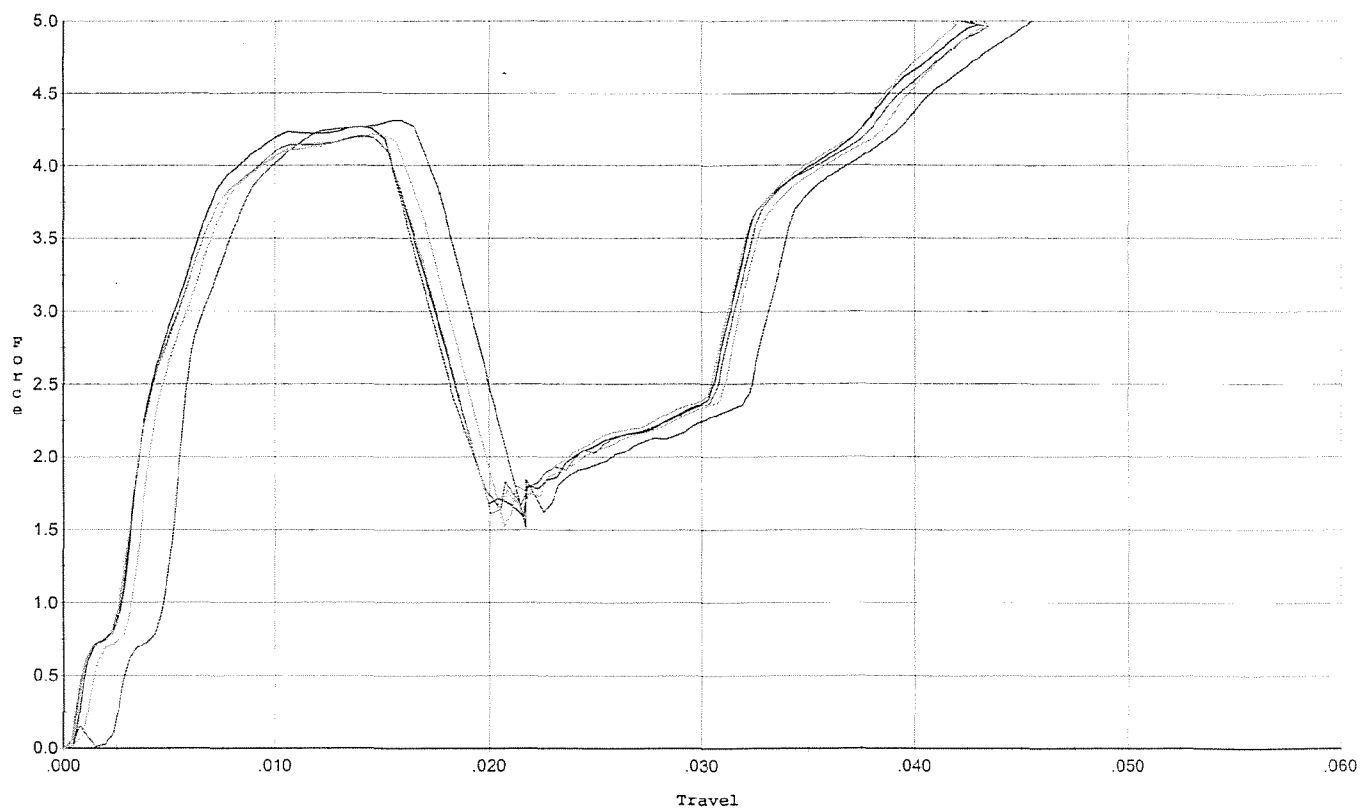
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.015	0.00	0.036	0.030		Set Trigger
2	3.039	0.015	0.00	0.036	0.030		Set Trigger
3	3.050	0.014	0.00	0.036	0.029		Set Trigger
4	3.274	0.014	0.00	0.035	0.033		Set Trigger
5	3.162	0.014	0.00	0.036	0.031		Set Trigger

A.3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



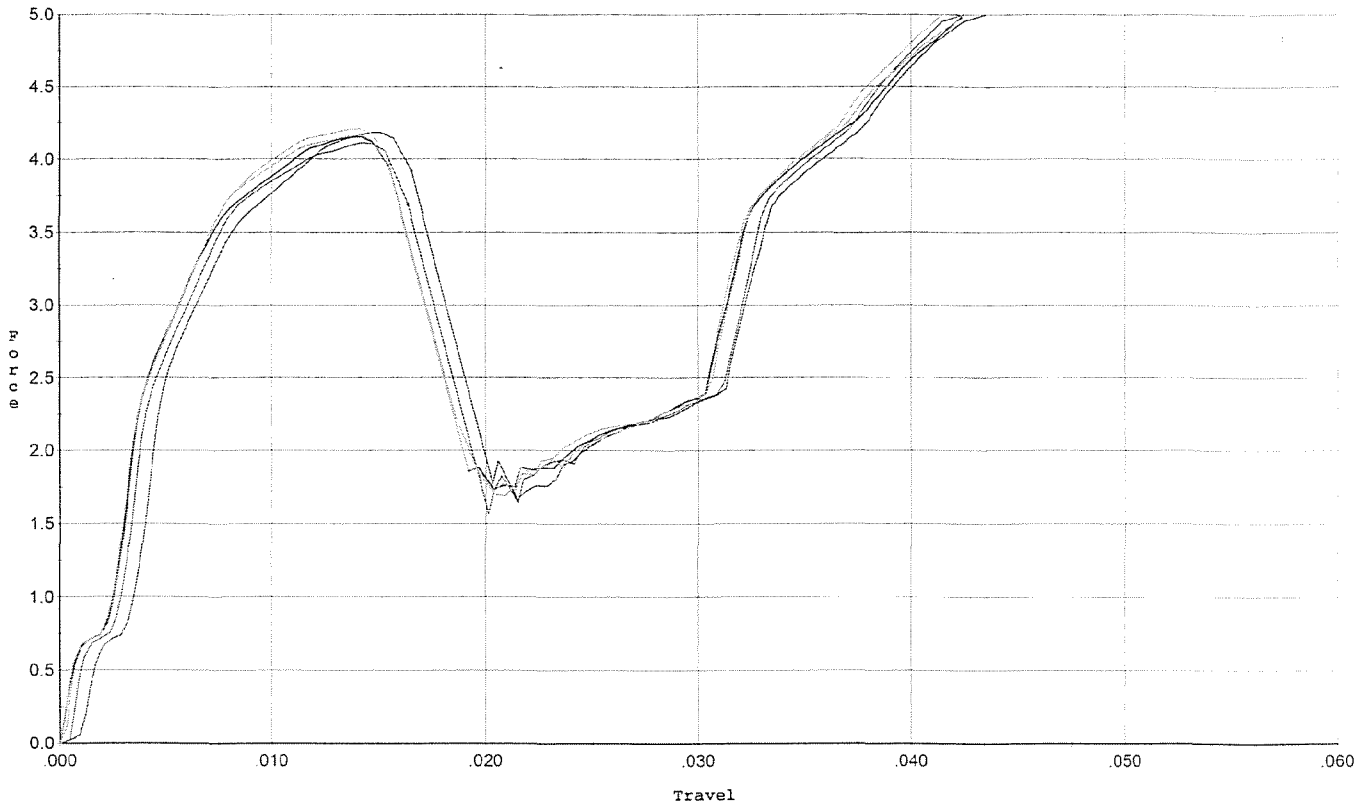
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.311	0.018	0.00	0.033	0.047		Set Trigger
2	4.267	0.017	0.00	0.032	0.049		Set Trigger
3	4.207	0.015	0.00	0.033	0.043		Set Trigger
4	4.216	0.017	0.00	0.032	0.047		Set Trigger
5	4.196	0.017	0.00	0.032	0.048		Set Trigger

A-4.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



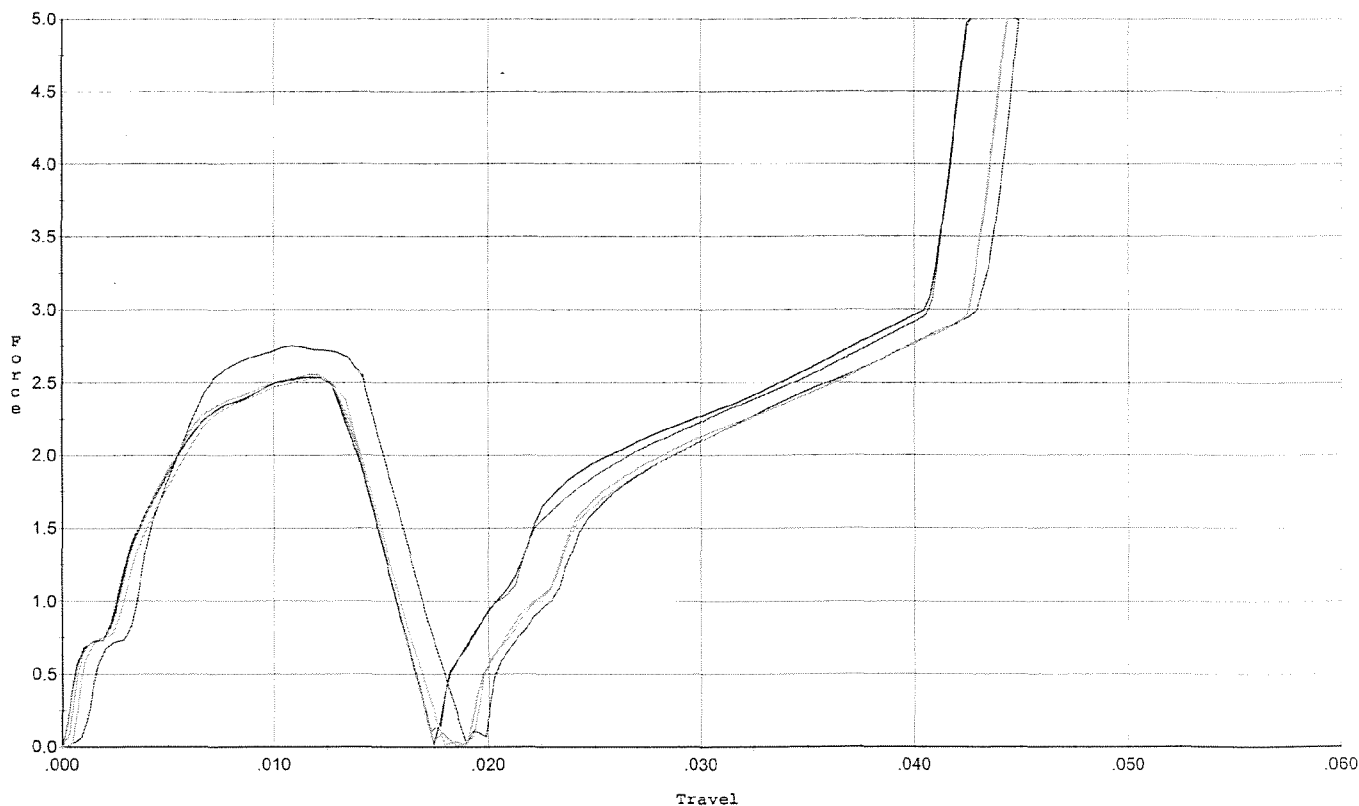
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.181	0.017	0.00	0.033	0.044		Set Trigger
2	4.155	0.016	0.00	0.032	0.043		Set Trigger
3	4.112	0.016	0.00	0.033	0.044		Set Trigger
4	4.165	0.015	0.00	0.032	0.043		Set Trigger
5	4.211	0.015	0.00	0.032	0.043		Set Trigger

A. 4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



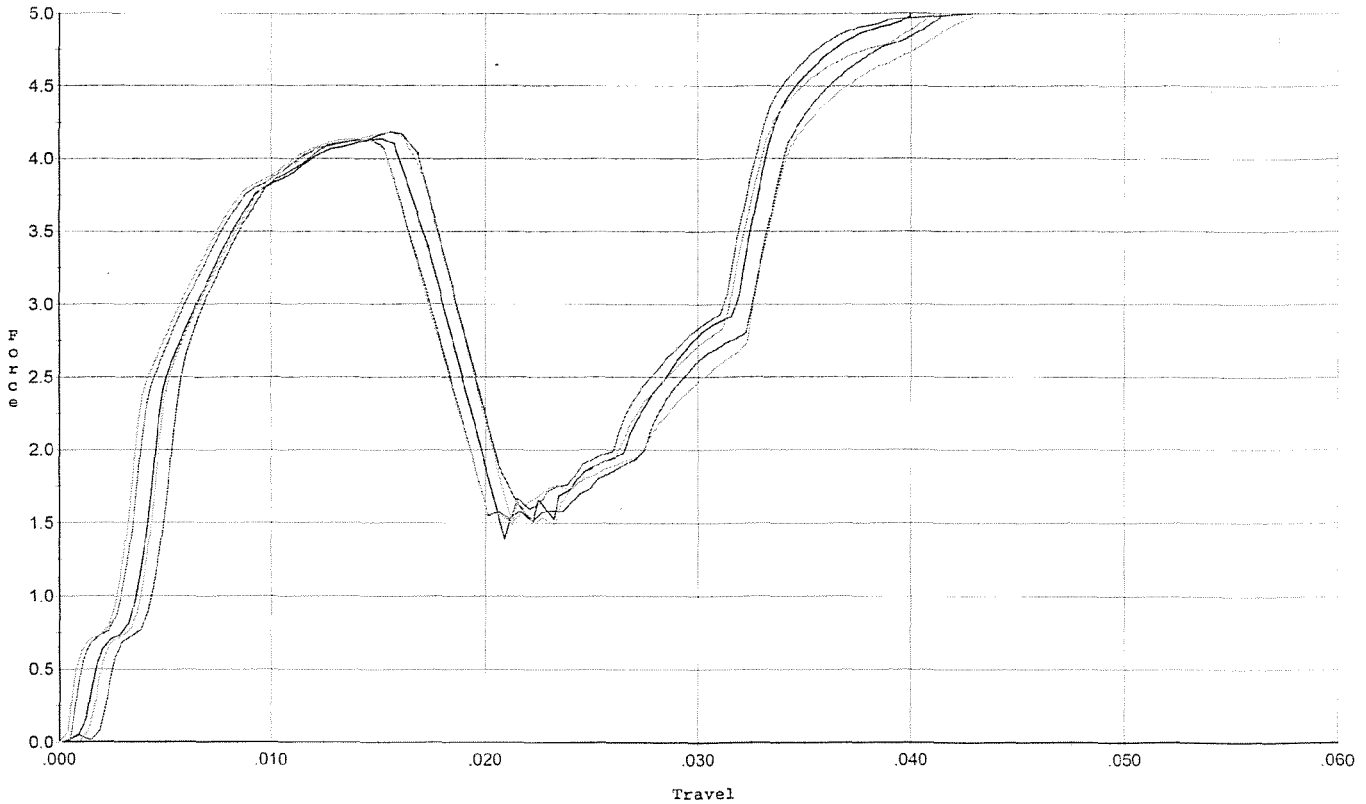
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.753	0.014	0.00	0.033	0.026		Set Trigger
2	2.539	0.014	0.00	0.032	0.025		Set Trigger
3	2.555	0.014	0.00	0.032	0.024		Set Trigger
4	2.531	0.013	0.00	0.034	0.023		Set Trigger
5	2.555	0.014	0.00	0.034	0.024		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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	0.017	0.00	0.033	0.043		Set Trigger
2	4.140	0.017	0.00	0.032	0.046		Set Trigger
3	4.135	0.017	0.00	0.032	0.047		Set Trigger
4	4.180	0.017	0.00	0.033	0.045		Set Trigger
5	4.139	0.018	0.00	0.032	0.049		Set Trigger

A-4.15