

6680 7740

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



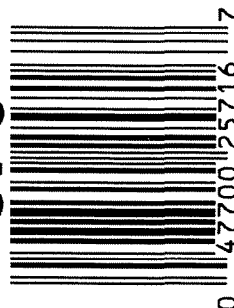
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807740

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 7740

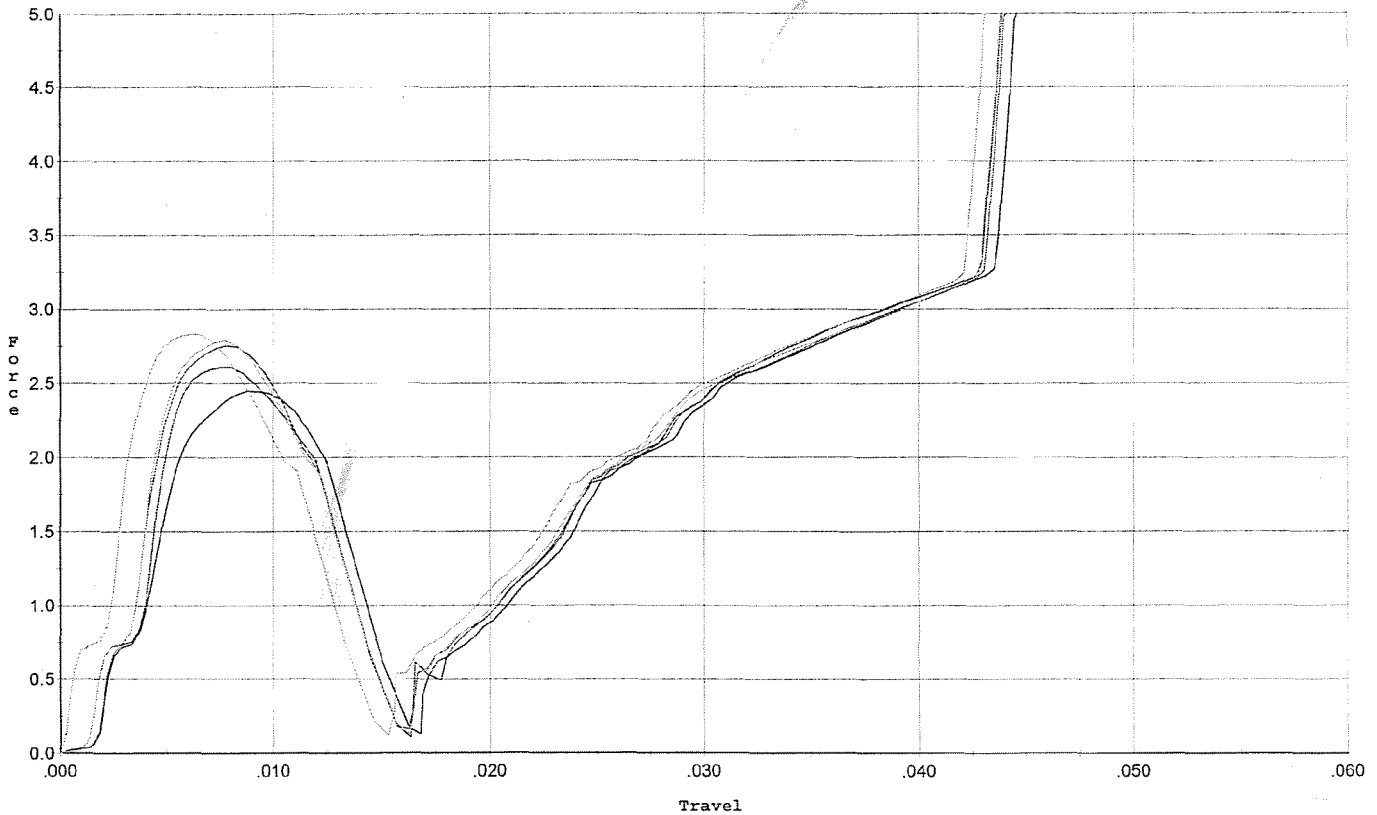
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE		2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR	3/5/09	RP
490	MAGNAFLUX BOLT		3/5/09	RP
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	JP
520	GOFF BLAST BBL / REC		3/6	RP
540	APPLY COATINGS (BARREL ACTION)		3/11	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-18-09	RP
	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>6</u> <u>6</u> <u>4</u>	3-23-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-23-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	J) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.022</u>	3-23-09	WV
	J) ASSEMBLE STOCK		3-18-09	L.S.
	K) ASSEMBLE SWIVEL STUDS		3-23-09	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	3-20-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-20-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-23-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.41</u> <u>2.47</u> <u>2.45</u> <u>2.44</u>	3-23-09	WV
	C) FUNCTION		3-23-09	WV
690	PACK		3/25/09	FM

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



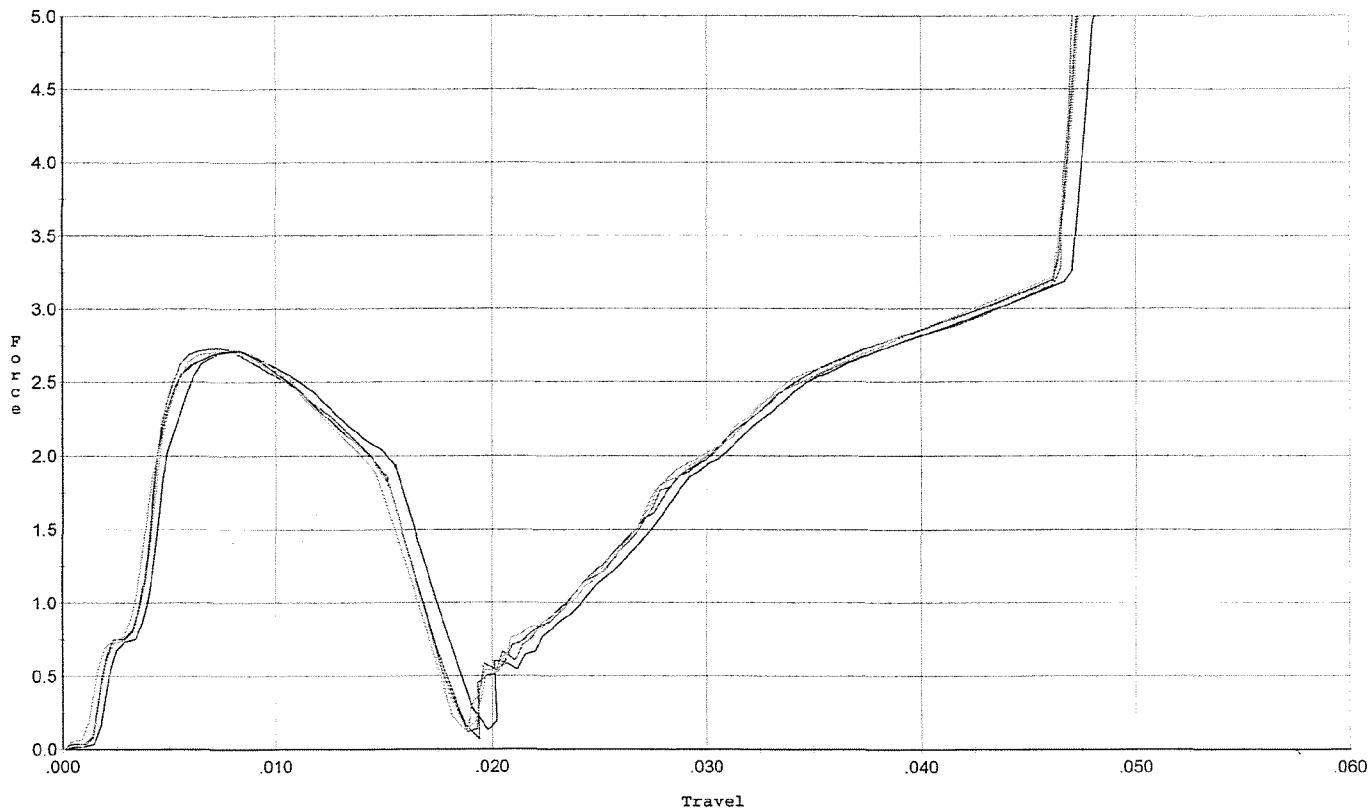
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.012	0.00	0.034	0.019		Set Trigger
2	2.447	0.013	0.00	0.035	0.019		Set Trigger
3	2.753	0.012	0.00	0.034	0.020		Set Trigger
4	2.788	0.012	0.00	0.034	0.020		Set Trigger
5	2.833	0.011	0.00	0.035	0.020		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



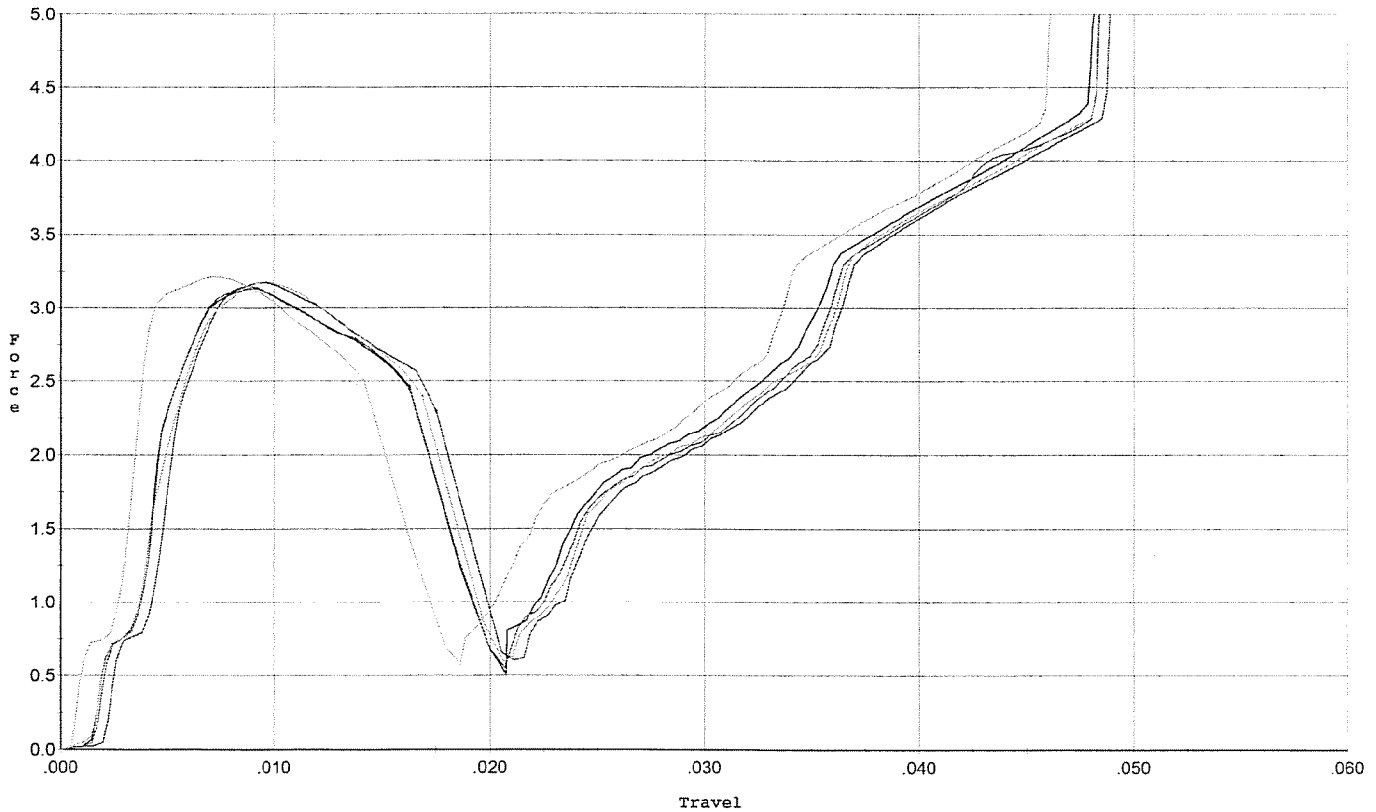
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.712	0.015	0.00	0.035	0.027		Set Trigger
2	2.704	0.016	0.00	0.036	0.027		Set Trigger
3	2.728	0.015	0.00	0.035	0.027		Set Trigger
4	2.714	0.015	0.00	0.035	0.027		Set Trigger
5	2.698	0.016	0.00	0.035	0.028		Set Trigger

A-2-71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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	3.174	0.018	0.00	0.034	0.035		Set Trigger
2	3.133	0.016	0.00	0.034	0.034		Set Trigger
3	3.151	0.016	0.00	0.034	0.033		Set Trigger
4	3.219	0.014	0.00	0.034	0.031		Set Trigger
5	3.180	0.017	0.00	0.034	0.035		Set Trigger

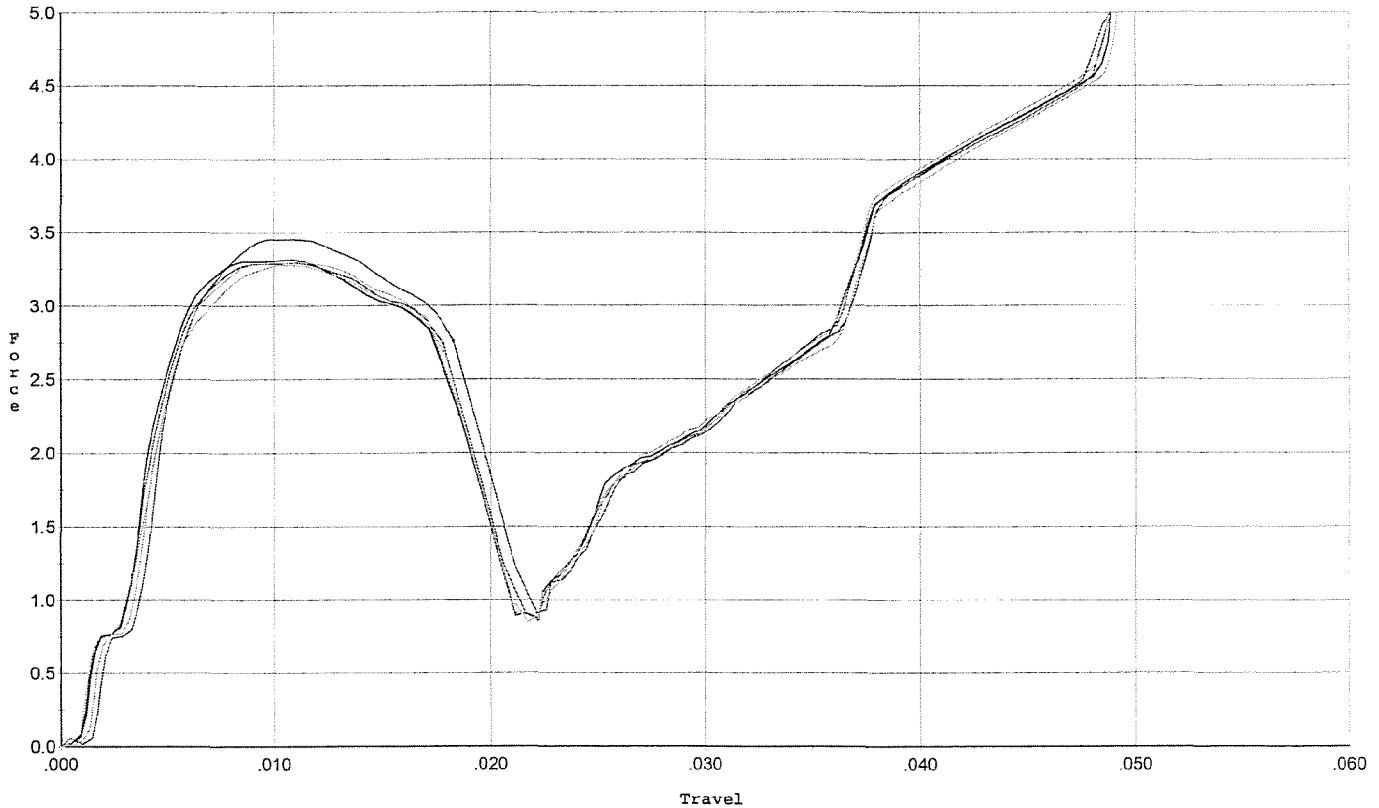
A-3-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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

*After 20 cycles
cms*



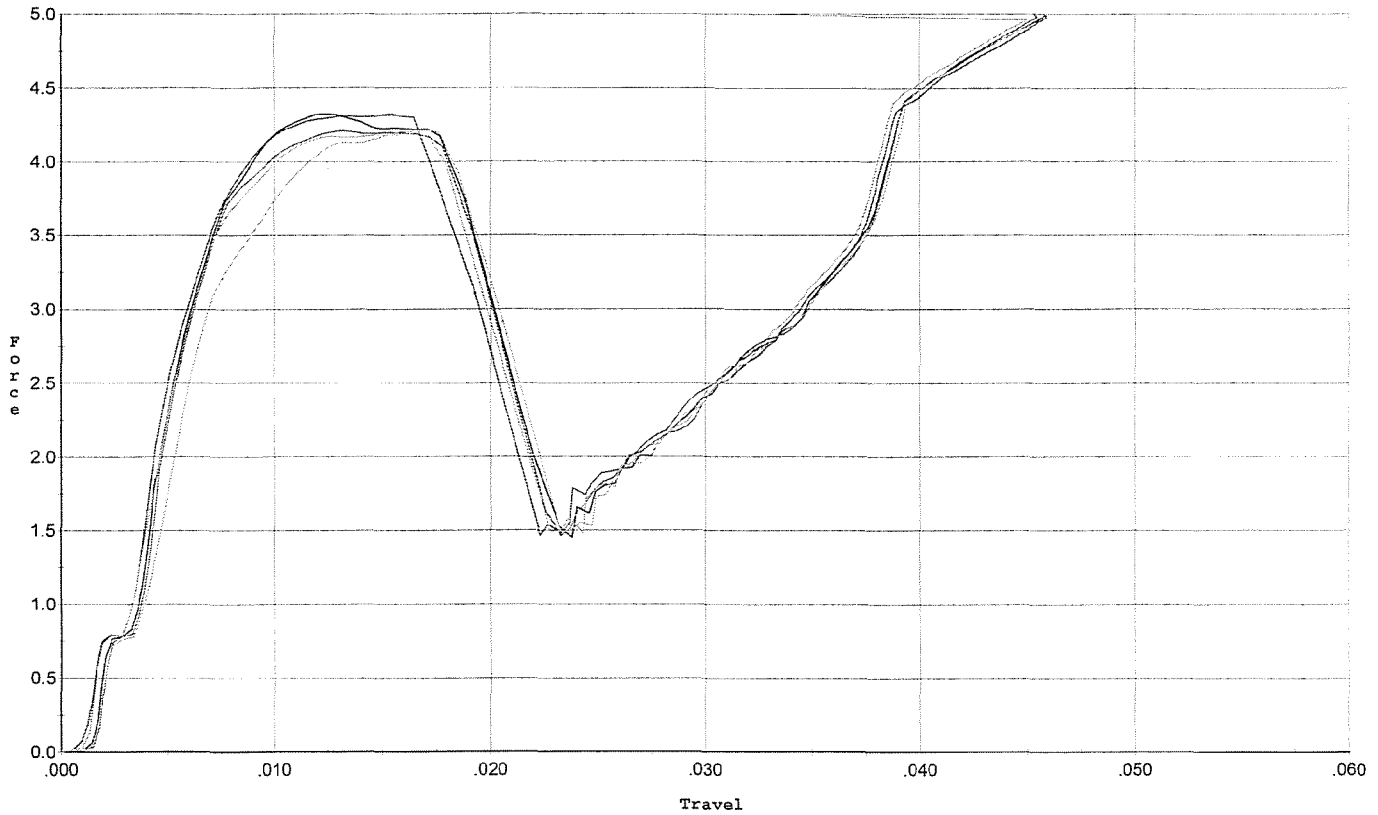
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.453	0.018	0.00	0.033	0.043		Set Trigger
2	3.311	0.019	0.00	0.033	0.043		Set Trigger
3	3.289	0.018	0.00	0.033	0.041		Set Trigger
4	3.283	0.018	0.00	0.033	0.041		Set Trigger
5	3.298	0.018	0.00	0.033	0.042		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



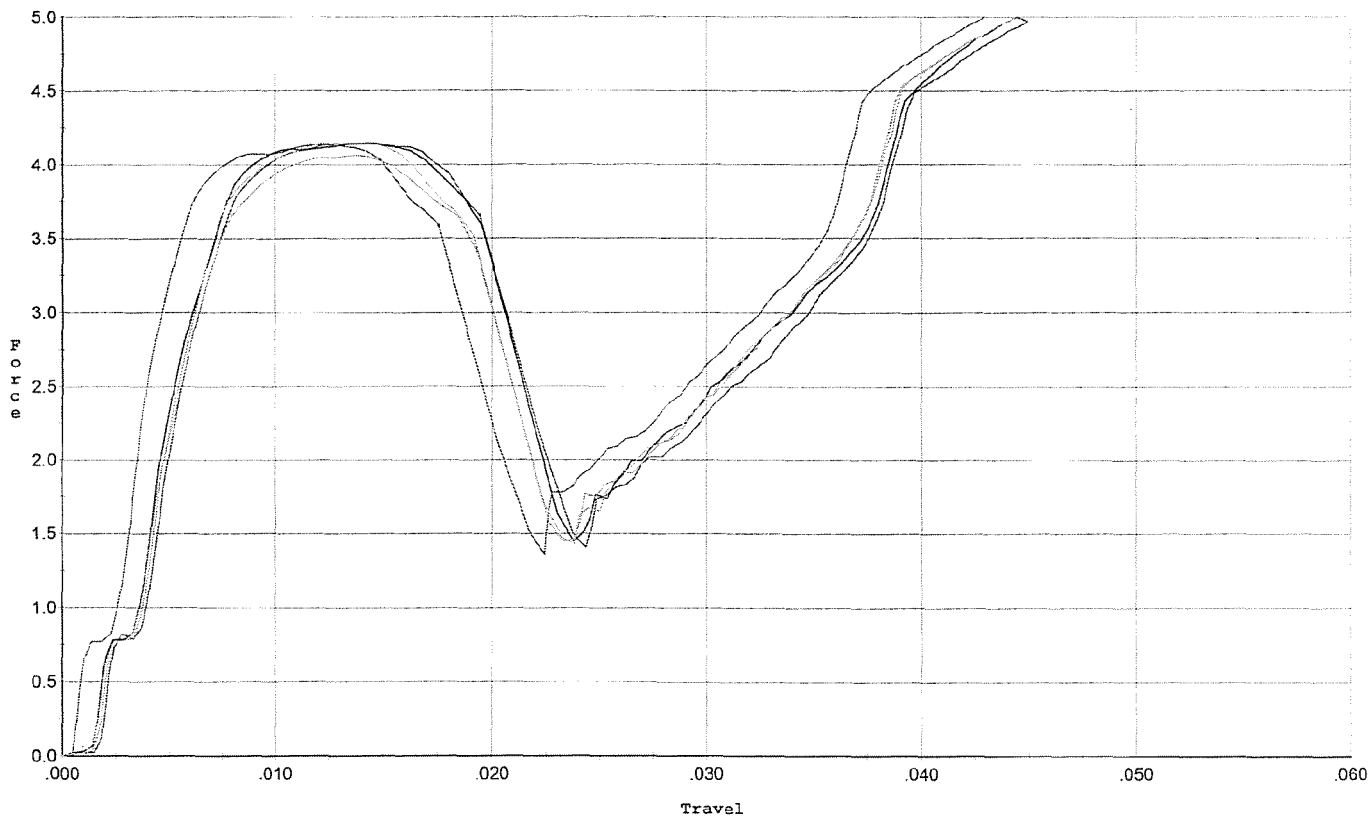
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.323	0.019	0.00	0.031	0.055		Set Trigger
2	4.324	0.019	0.00	0.031	0.054		Set Trigger
3	4.211	0.019	0.00	0.031	0.053		Set Trigger
4	4.215	0.021	0.00	0.031	0.055		Set Trigger
5	4.193	0.018	0.00	0.031	0.050		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



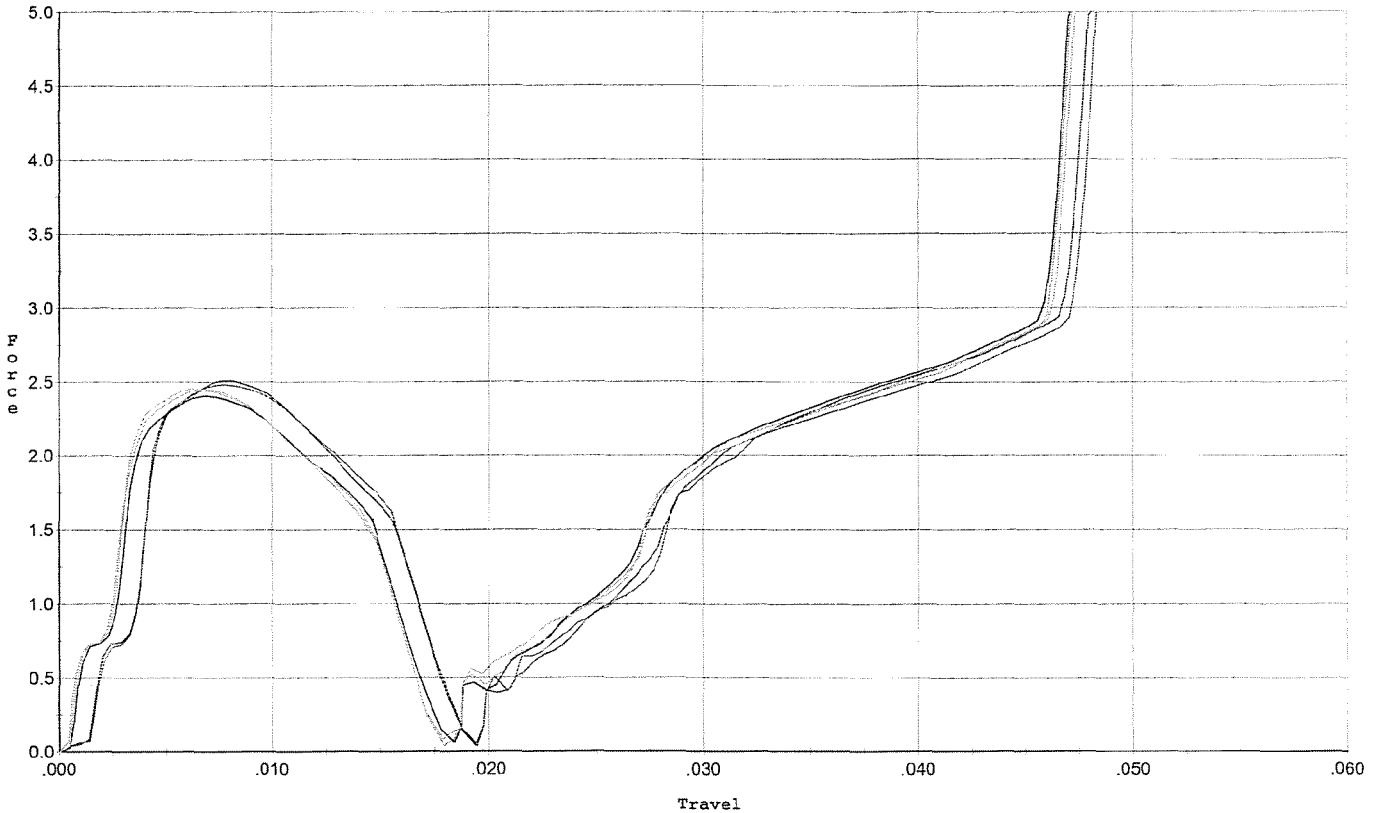
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.019	0.00	0.031	0.054		Set Trigger
2	4.150	0.020	0.00	0.031	0.055		Set Trigger
3	4.136	0.018	0.00	0.030	0.051		Set Trigger
4	4.148	0.019	0.00	0.031	0.053		Set Trigger
5	4.064	0.019	0.00	0.031	0.052		Set Trigger

A-4-12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



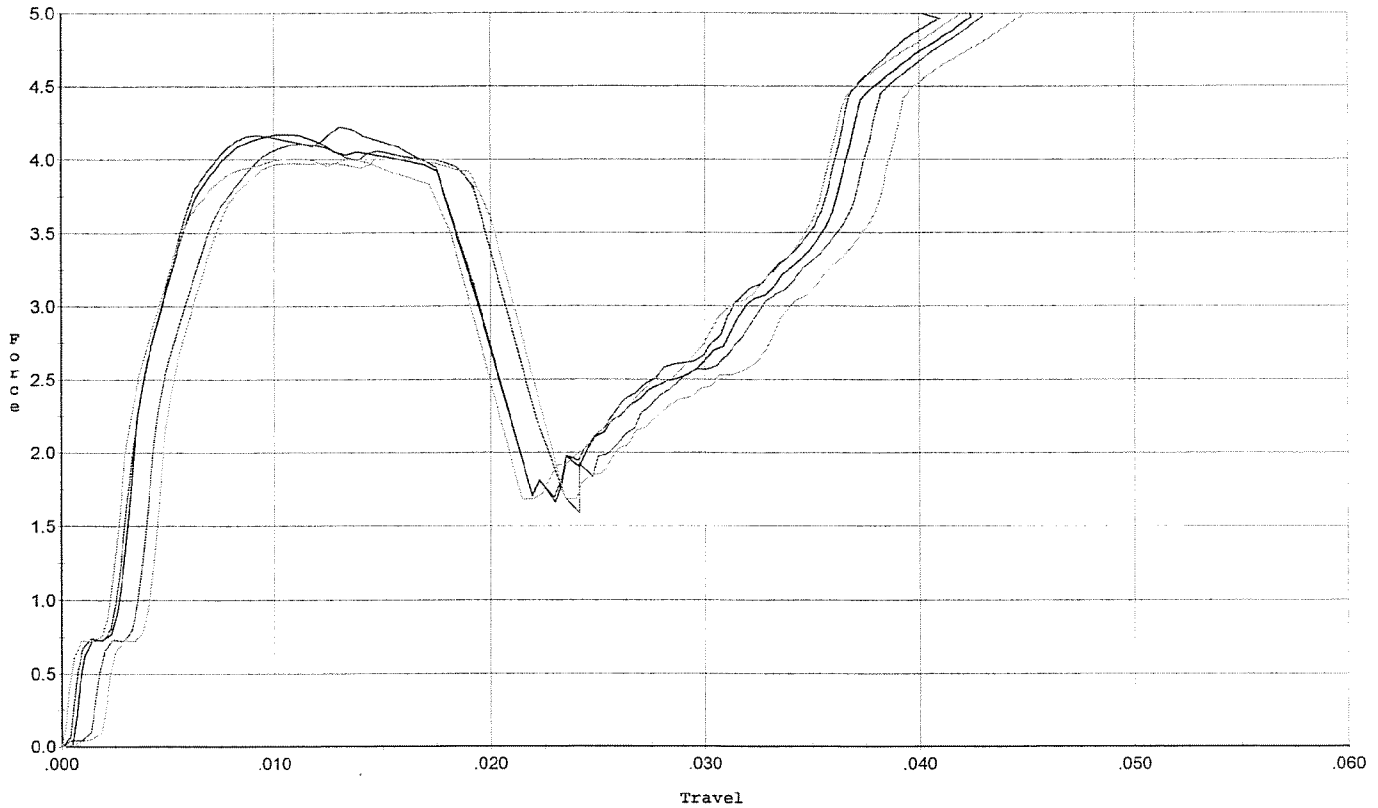
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.016	0.00	0.036	0.026		Set Trigger
2	2.409	0.015	0.00	0.036	0.025		Set Trigger
3	2.482	0.016	0.00	0.036	0.026		Set Trigger
4	2.455	0.015	0.00	0.036	0.025		Set Trigger
5	2.453	0.015	0.00	0.036	0.025		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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	4.223	0.019	0.00	0.029	0.058		Set Trigger
2	4.171	0.019	0.00	0.030	0.057		Set Trigger
3	4.107	0.019	0.00	0.030	0.055		Set Trigger
4	4.034	0.020	0.00	0.030	0.055		Set Trigger
5	4.012	0.018	0.00	0.029	0.053		Set Trigger

A-4-10