

6680 7745

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



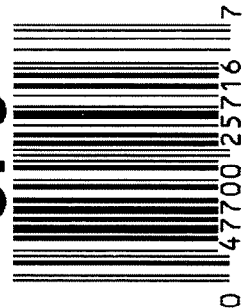
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807745

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807745

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	MAGNA-FLUX	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	Ⓟ
490	MAGNAFLUX BOLT		3/5/09	ML
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	WON
540	APPLY COATINGS (BARREL ACTION)		3/11	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-16-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

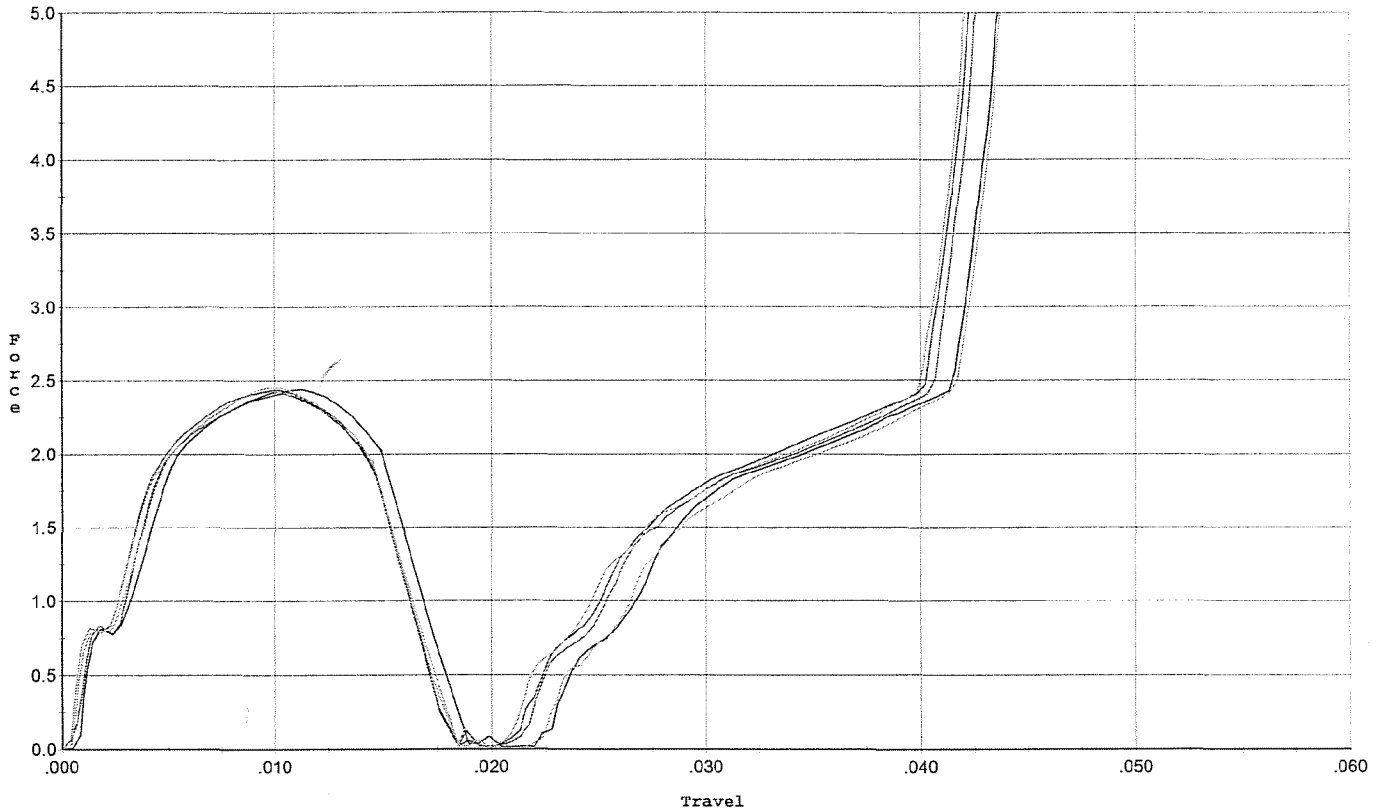
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-20-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>3.5</u> <u>3.5</u>	3-20-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	3-20-09	WV
	J) ASSEMBLE STOCK		3-16-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	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	3-19-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-19-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.26</u> <u>2.23</u> <u>2.26</u> <u>2.22</u> <u>2.27</u>	3-20-09	TC
	C) FUNCTION		3-20-09	WV
690	PACK		3-21-09	TC

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



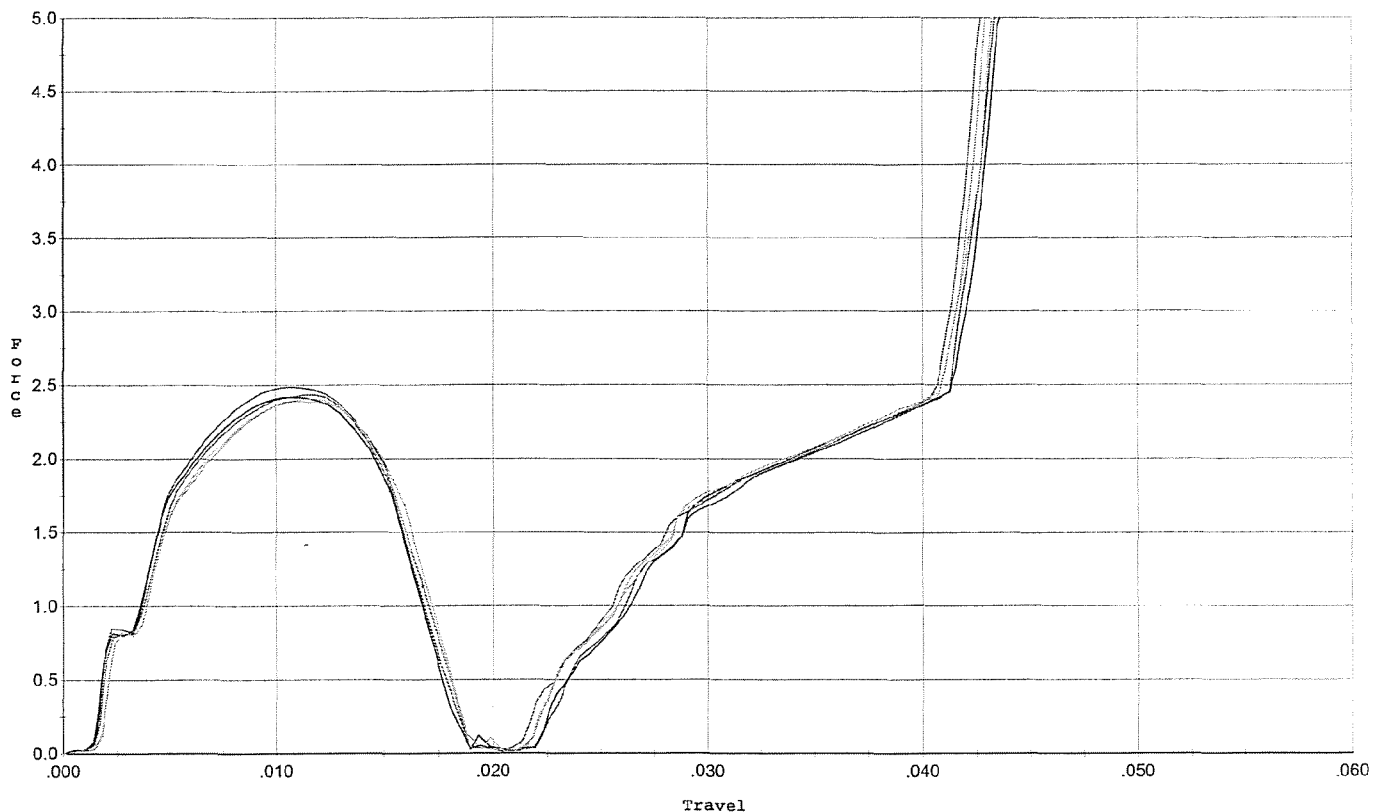
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.408	0.015	0.00	0.032	0.025		Set Trigger
2	2.439	0.015	0.00	0.033	0.025		Set Trigger
3	2.434	0.015	0.00	0.032	0.026		Set Trigger
4	2.455	0.015	0.00	0.033	0.025		Set Trigger
5	2.423	0.015	0.00	0.032	0.025		Set Trigger

A-2-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



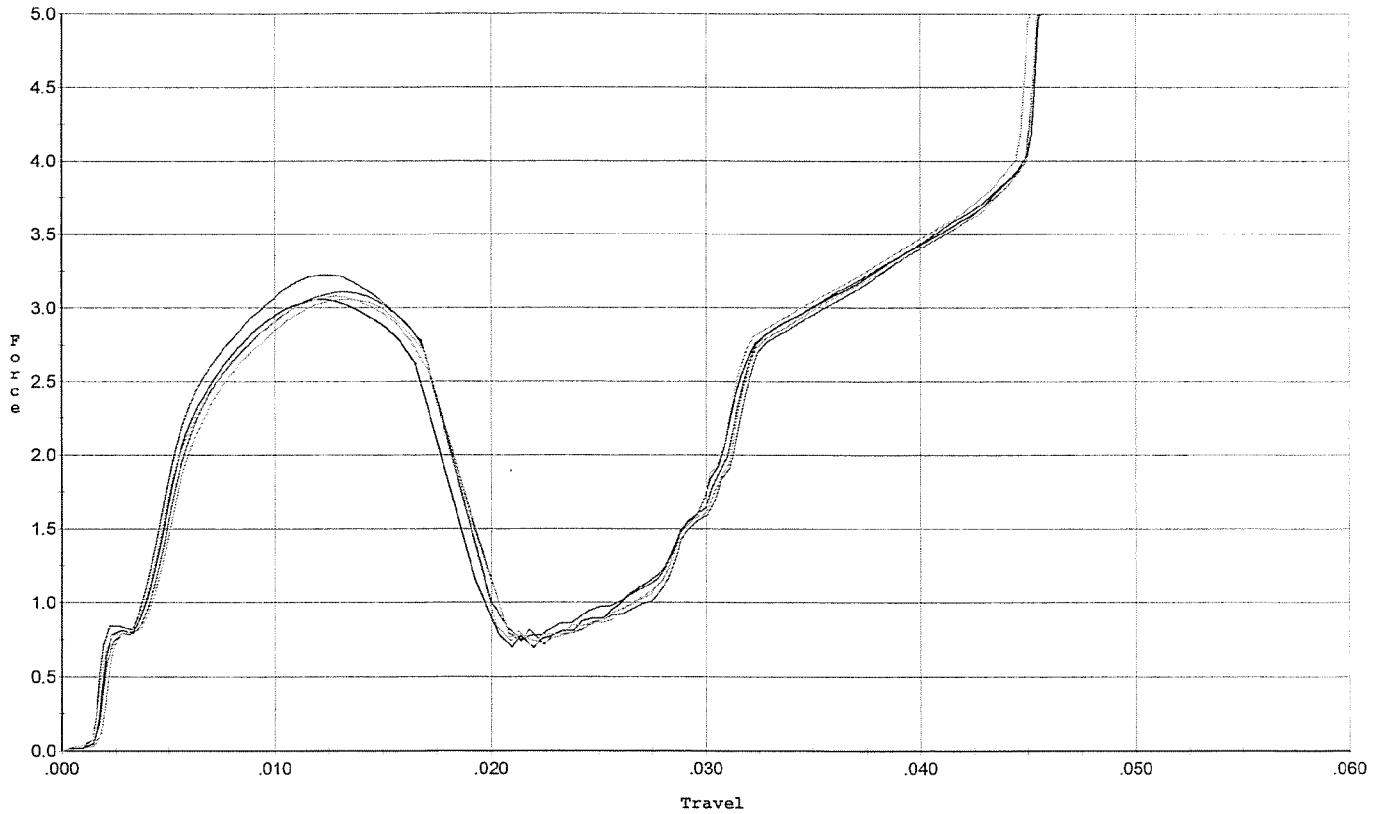
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.487	0.017	0.004	0.032	0.028		Set Trigger
2	2.417	0.015	0.00	0.033	0.025		Set Trigger
3	2.434	0.015	0.00	0.032	0.024		Set Trigger
4	2.406	0.017	0.00	0.031	0.026		Set Trigger
5	2.387	0.016	0.00	0.032	0.025		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



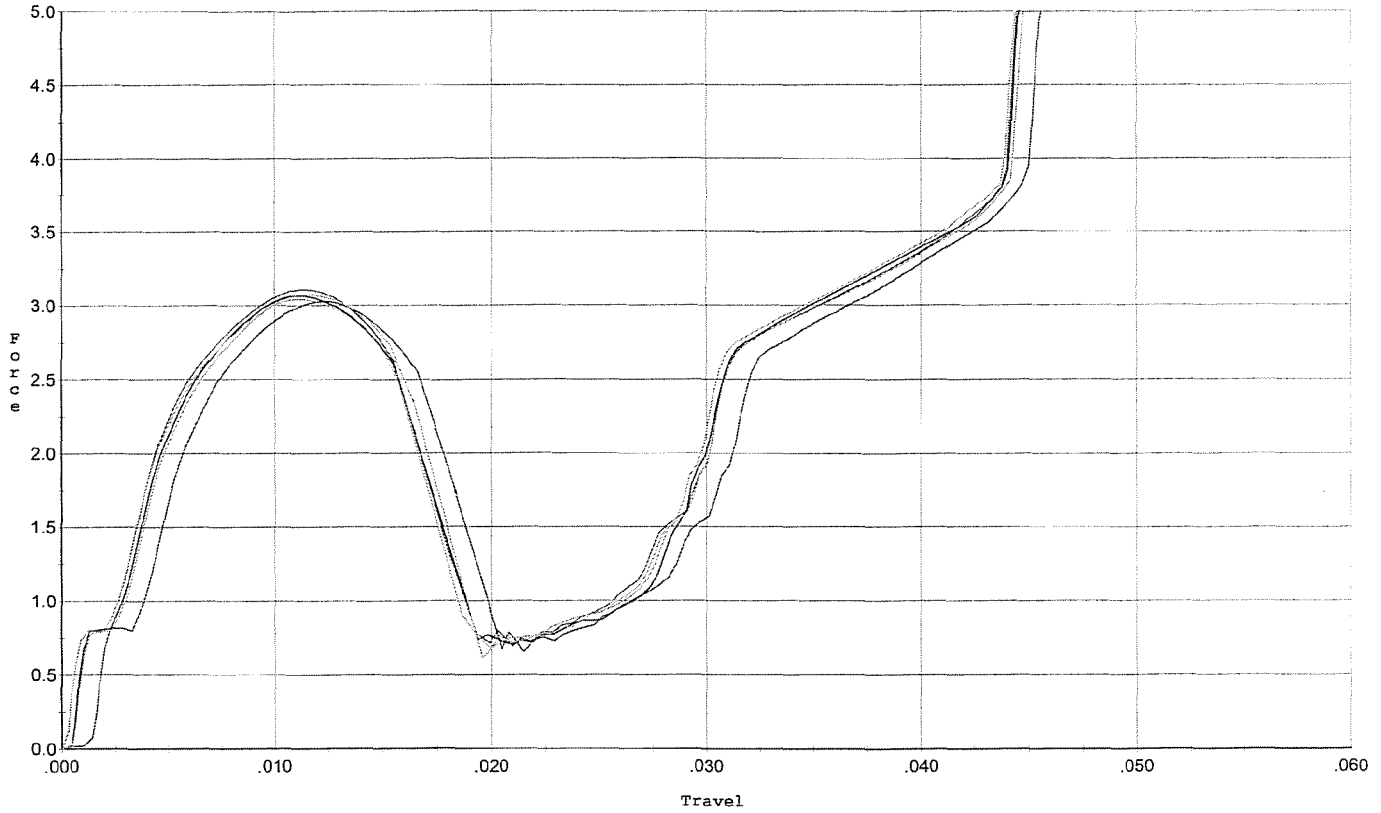
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.223	0.017	0.004	0.031	0.035		Set Trigger
2	3.058	0.017	0.00	0.031	0.033		Set Trigger
3	3.109	0.017	0.00	0.031	0.034		Set Trigger
4	3.079	0.017	0.00	0.031	0.035		Set Trigger
5	3.059	0.017	0.00	0.031	0.033		Set Trigger

A-3-10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



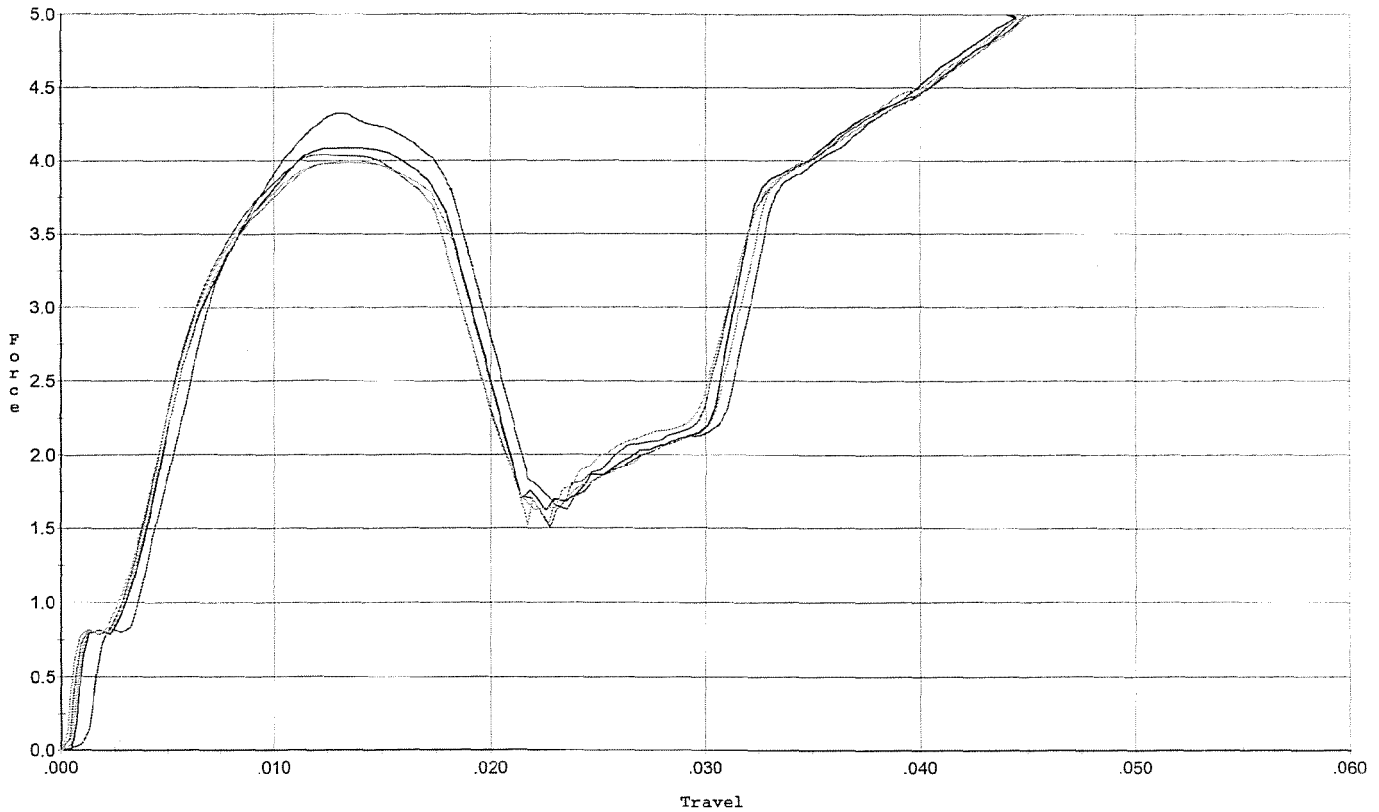
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.028	0.018	0.004	0.031	0.036		Set Trigger
2	3.067	0.016	0.00	0.031	0.032		Set Trigger
3	3.107	0.016	0.00	0.031	0.033		Set Trigger
4	3.042	0.016	0.00	0.031	0.033		Set Trigger
5	3.074	0.016	0.00	0.031	0.034		Set Trigger

A . 3.06

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



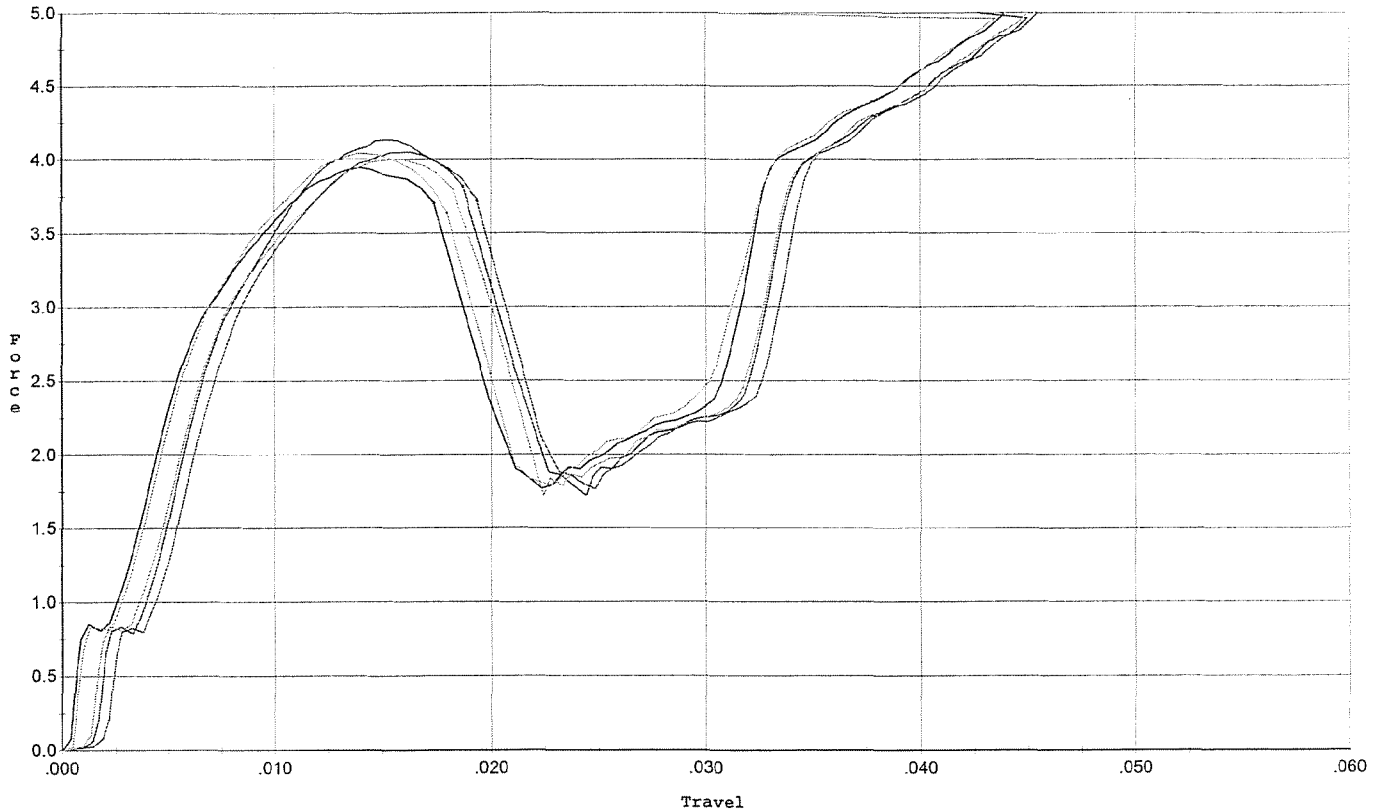
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.323	0.018	0.00	0.028	0.050		Set Trigger
2	4.088	0.018	0.00	0.028	0.049		Set Trigger
3	4.043	0.017	0.00	0.028	0.047		Set Trigger
4	4.001	0.017	0.00	0.028	0.047		Set Trigger
5	3.988	0.018	0.00	0.028	0.049		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



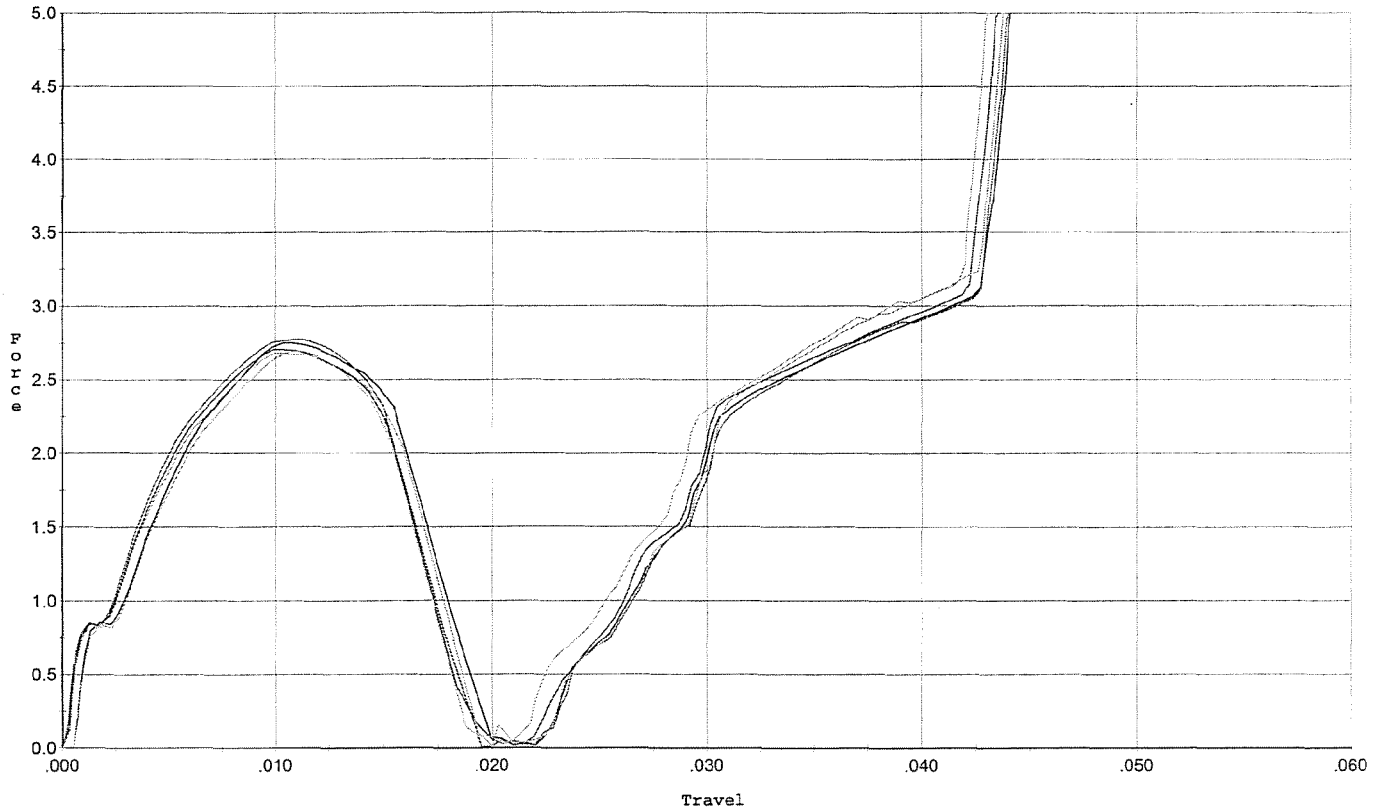
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.019	0.00	0.028	0.048		Set Trigger
2	3.944	0.017	0.00	0.029	0.046		Set Trigger
3	4.046	0.019	0.00	0.028	0.048		Set Trigger
4	4.039	0.018	0.003	0.028	0.048		Set Trigger
5	4.002	0.020	0.00	0.028	0.050		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



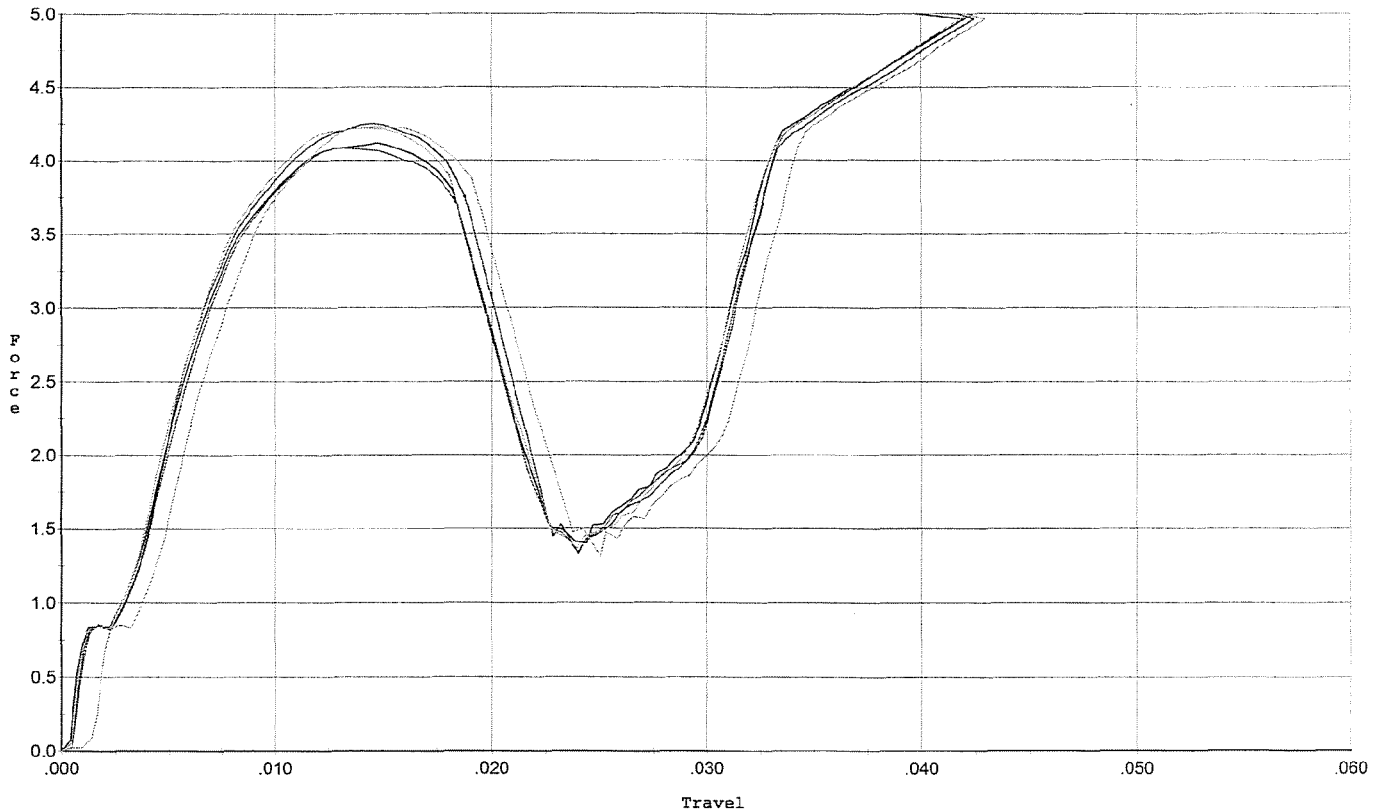
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.704	0.015	0.00	0.031	0.029		Set Trigger
2	2.750	0.015	0.00	0.031	0.029		Set Trigger
3	2.775	0.015	0.00	0.032	0.029		Set Trigger
4	2.696	0.015	0.00	0.031	0.029		Set Trigger
5	2.676	0.016	0.00	0.031	0.029		Set Trigger

A-2.72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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	4.250	0.019	0.00	0.028	0.053		Set Trigger
2	4.119	0.018	0.003	0.028	0.050		Set Trigger
3	4.084	0.018	0.00	0.028	0.050		Set Trigger
4	4.223	0.018	0.00	0.028	0.051		Set Trigger
5	4.230	0.019	0.00	0.028	0.051		Set Trigger

A. 4.18