

6680 7746

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

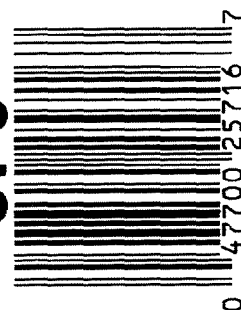
24"

CAPACITY

6

G6807746

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6 8 0 7 7 4 6

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	RP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	3/5/09	(A)
490	MAGNAFLUX BOLT		3/5/09	AK
500	ROLLMARK CALIBER		3/5/09	RP
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	mon
540	APPLY COATINGS (BARREL ACTION)		3/11	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-14-09	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

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400017139

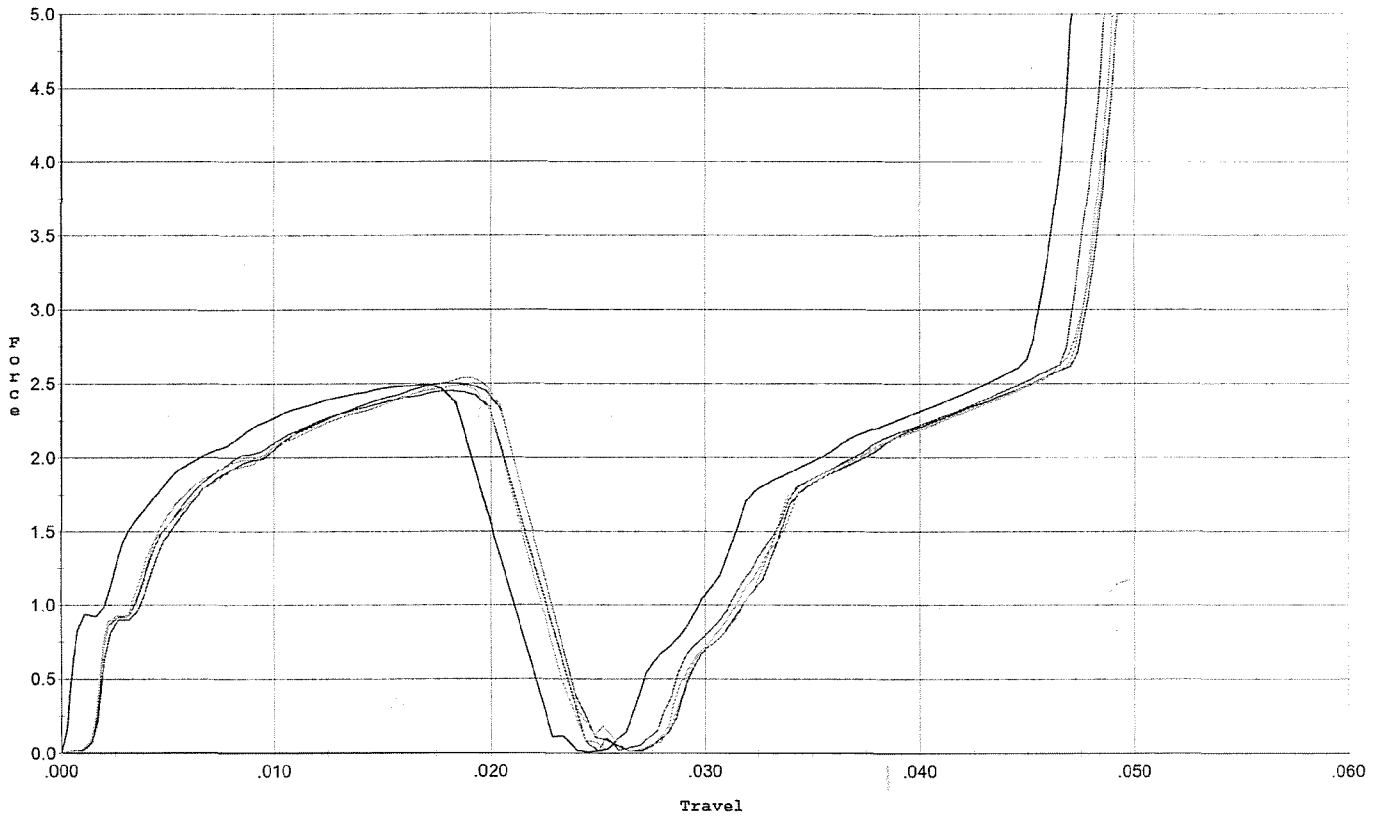
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>4.5</u>	3-20-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-20-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.024</u>	3-20-09	W/W
	J) ASSEMBLE STOCK		3-16-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	W/W
	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	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.69</u> <u>2.70</u> <u>2.72</u> <u>2.49</u>	3-20-09	W/W
	C) FUNCTION		3-20-09	W/W
690	PACK		3-21-09	TC

F004 REV 5/2006

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



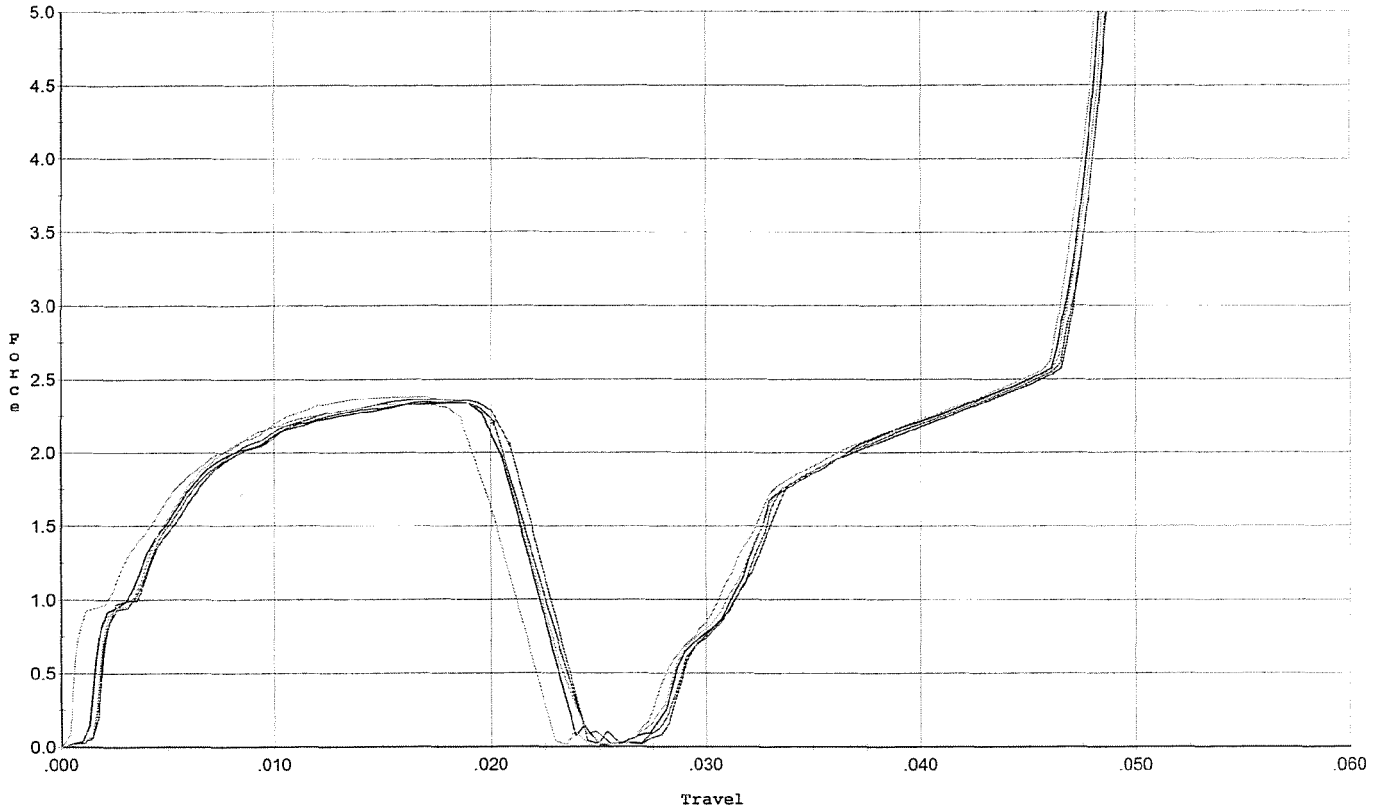
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.020	0.00	0.033	0.036		Set Trigger
2	2.491	0.018	0.00	0.032	0.035		Set Trigger
3	2.448	0.020	0.00	0.033	0.035		Set Trigger
4	2.490	0.020	0.00	0.033	0.035		Set Trigger
5	2.539	0.020	0.00	0.033	0.036		Set Trigger

A-2.49

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



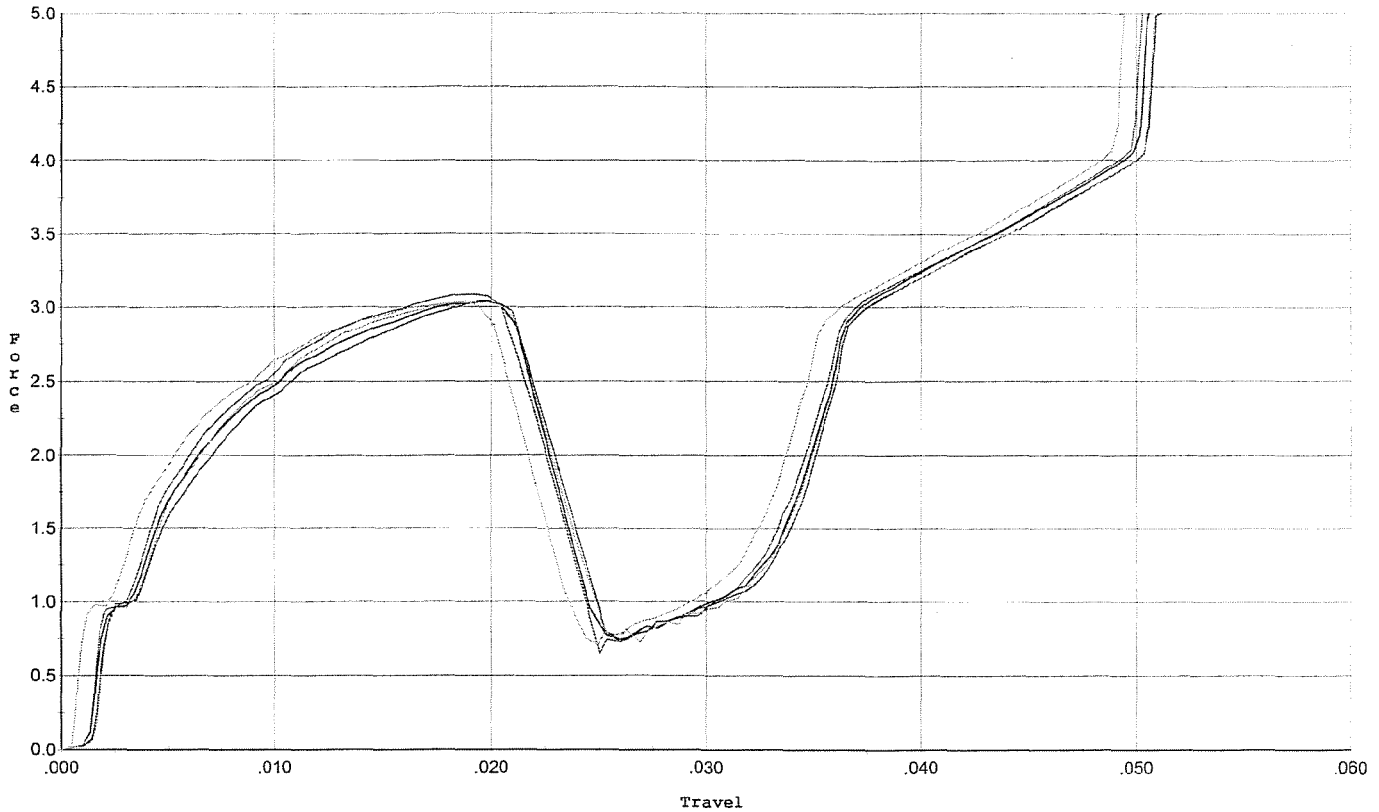
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.347	0.020	0.00	0.033	0.034		Set Trigger
2	2.337	0.021	0.00	0.032	0.035		Set Trigger
3	2.367	0.021	0.00	0.032	0.036		Set Trigger
4	2.379	0.020	0.00	0.032	0.035		Set Trigger
5	2.330	0.020	0.00	0.033	0.036		Set Trigger

A.2-35

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



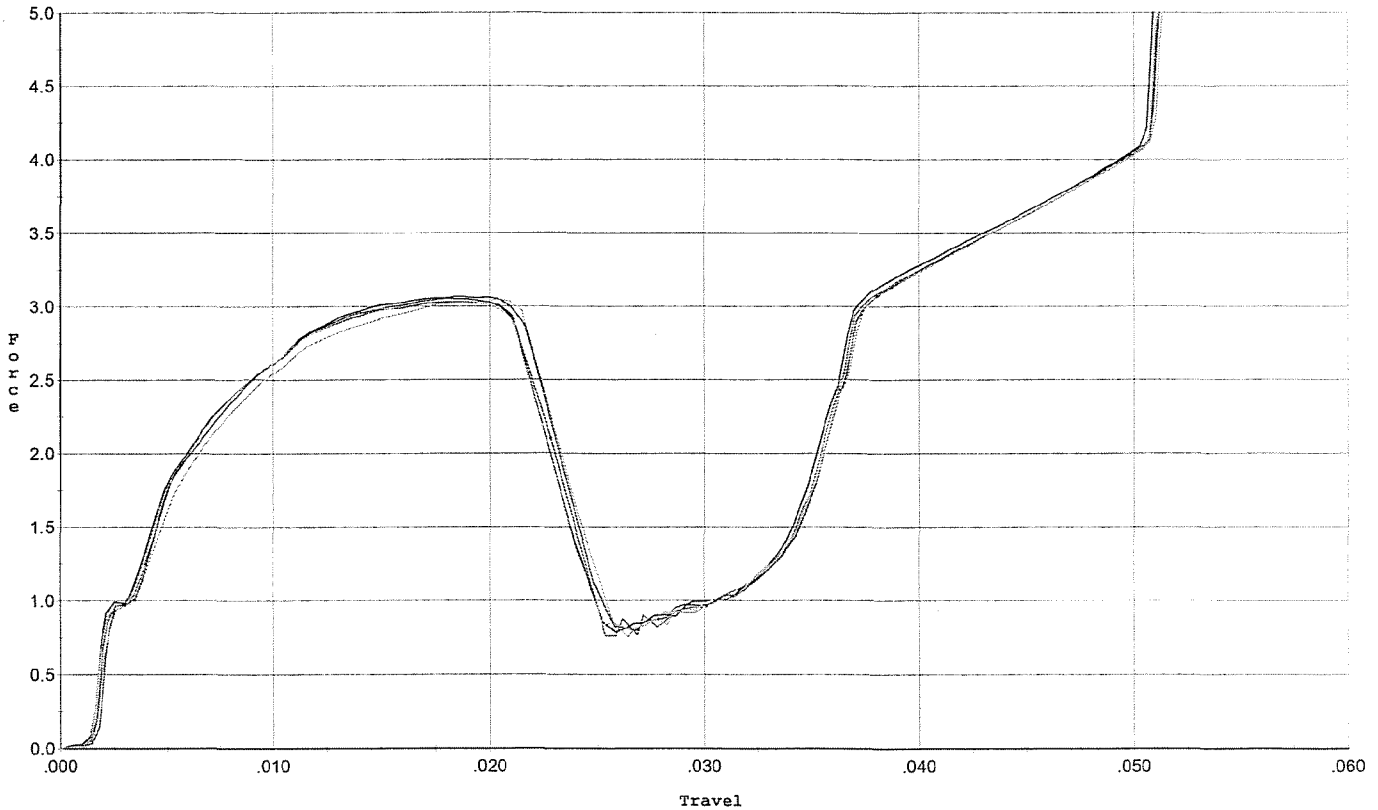
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.031	0.023	0.00	0.033	0.047		Set Trigger
2	3.045	0.021	0.00	0.033	0.044		Set Trigger
3	3.086	0.022	0.00	0.033	0.047		Set Trigger
4	3.040	0.020	0.00	0.032	0.044		Set Trigger
5	3.038	0.021	0.00	0.033	0.044		Set Trigger

A.3.04

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



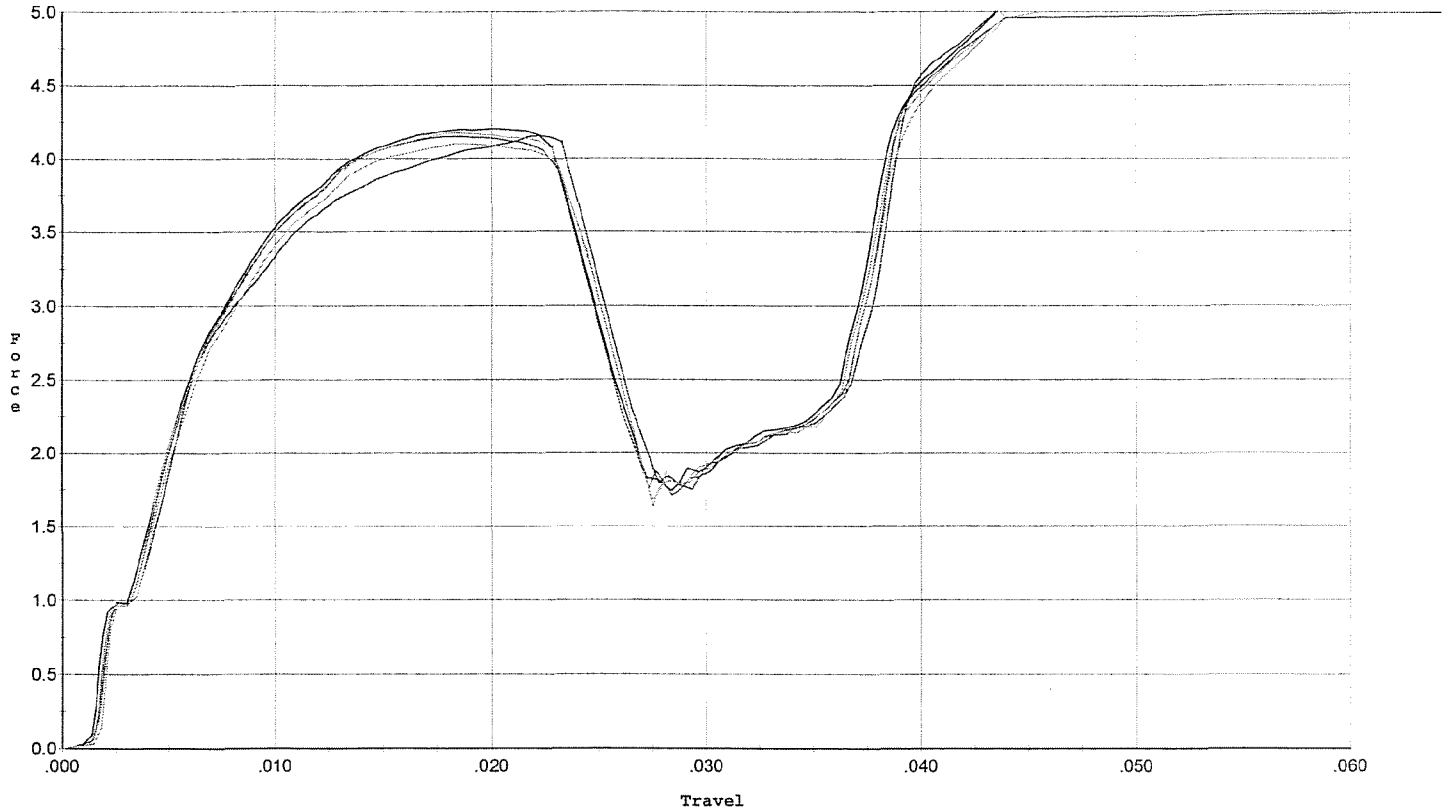
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.065	0.022	0.00	0.033	0.047		Set Trigger
2	3.056	0.021	0.00	0.033	0.046		Set Trigger
3	3.032	0.023	0.00	0.033	0.049		Set Trigger
4	3.034	0.021	0.00	0.034	0.045		Set Trigger
5	3.047	0.021	0.00	0.033	0.045		Set Trigger

A-3.04

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



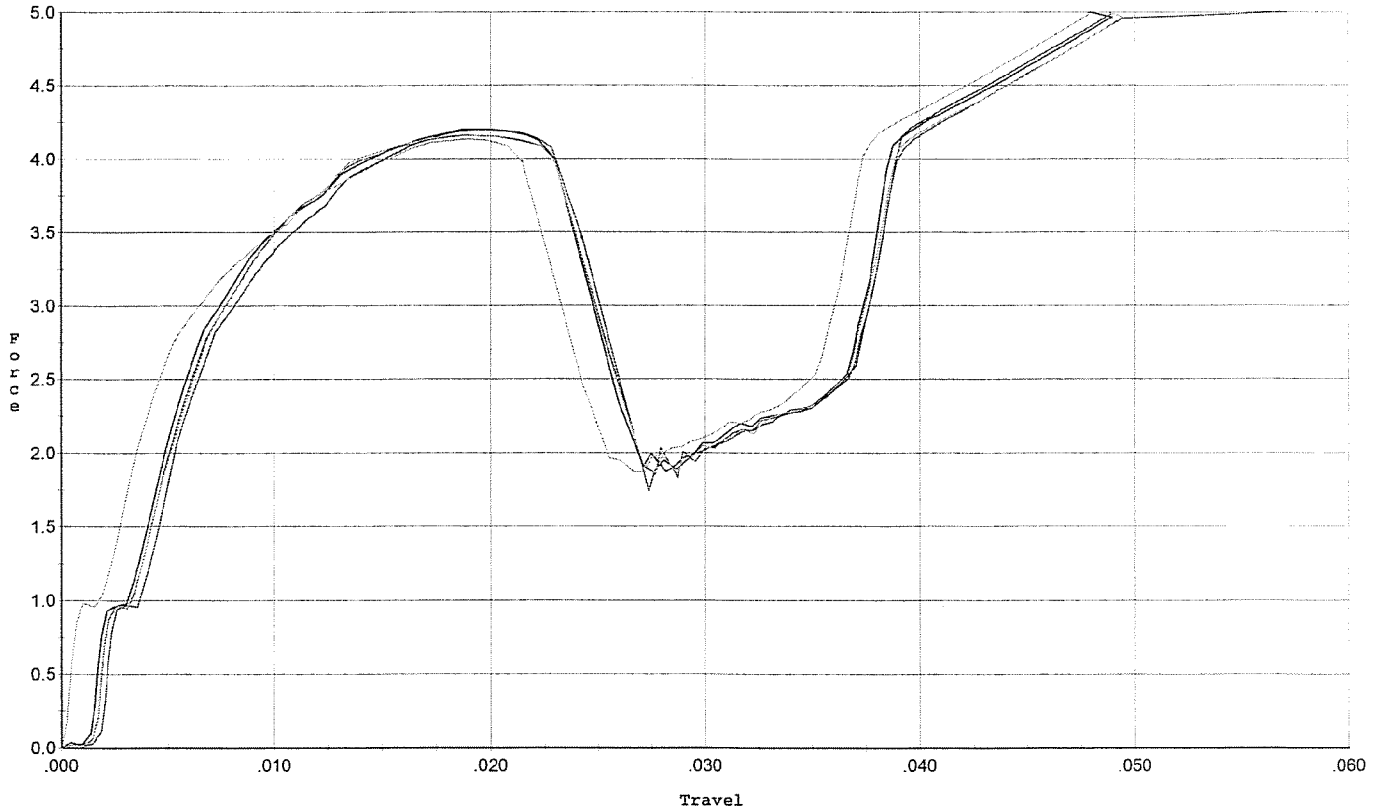
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.156	0.023	0.00	0.030	0.066		Set Trigger
2	4.203	0.023	0.00	0.030	0.066		Set Trigger
3	4.150	0.023	0.00	0.030	0.066		Set Trigger
4	4.176	0.024	0.00	0.029	0.071		Set Trigger
5	4.101	0.024	0.00	0.029	0.069		Set Trigger

A-4.15

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



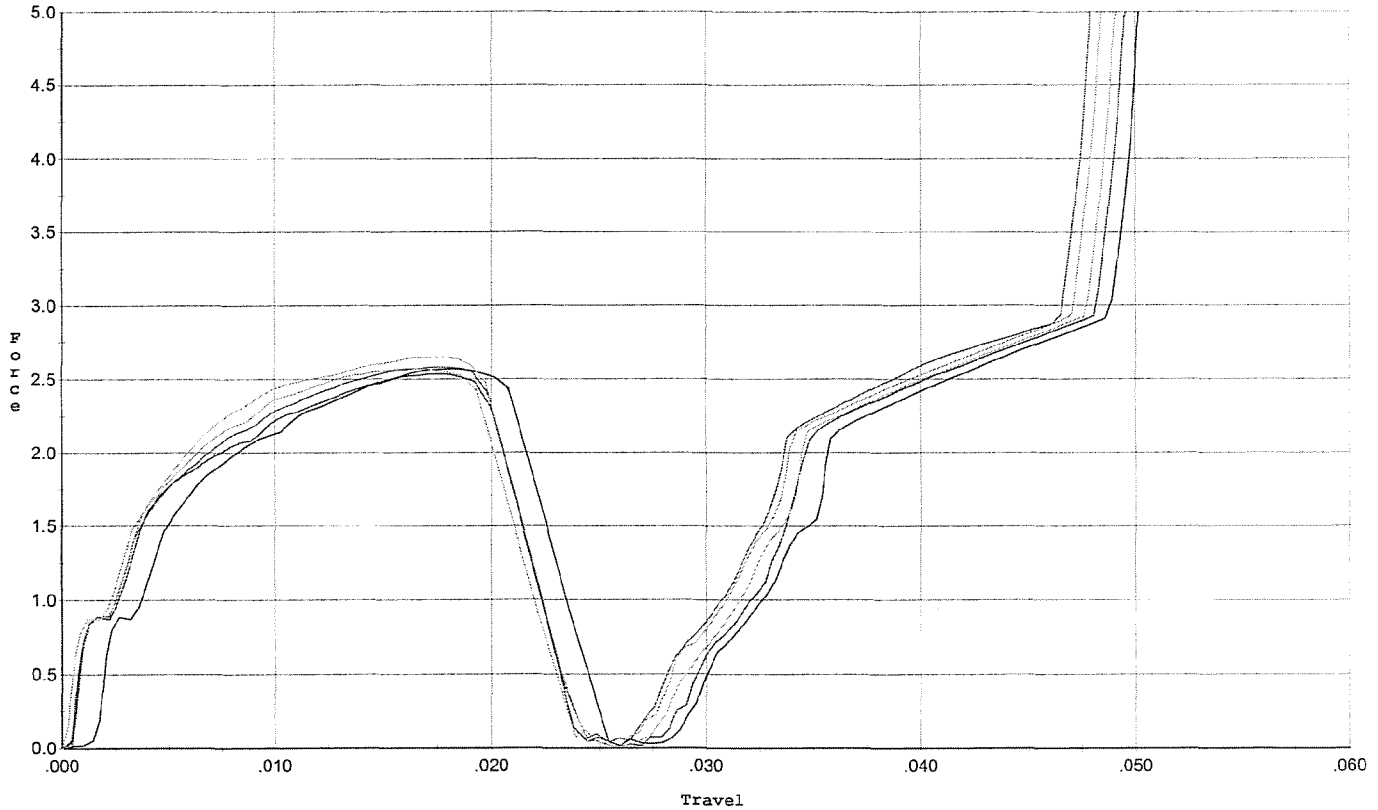
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.198	0.024	0.00	0.029	0.069		Set Trigger
2	4.201	0.023	0.00	0.029	0.066		Set Trigger
3	4.161	0.023	0.00	0.030	0.066		Set Trigger
4	4.161	0.023	0.00	0.029	0.066		Set Trigger
5	4.134	0.021	0.00	0.029	0.063		Set Trigger

A-4-17

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



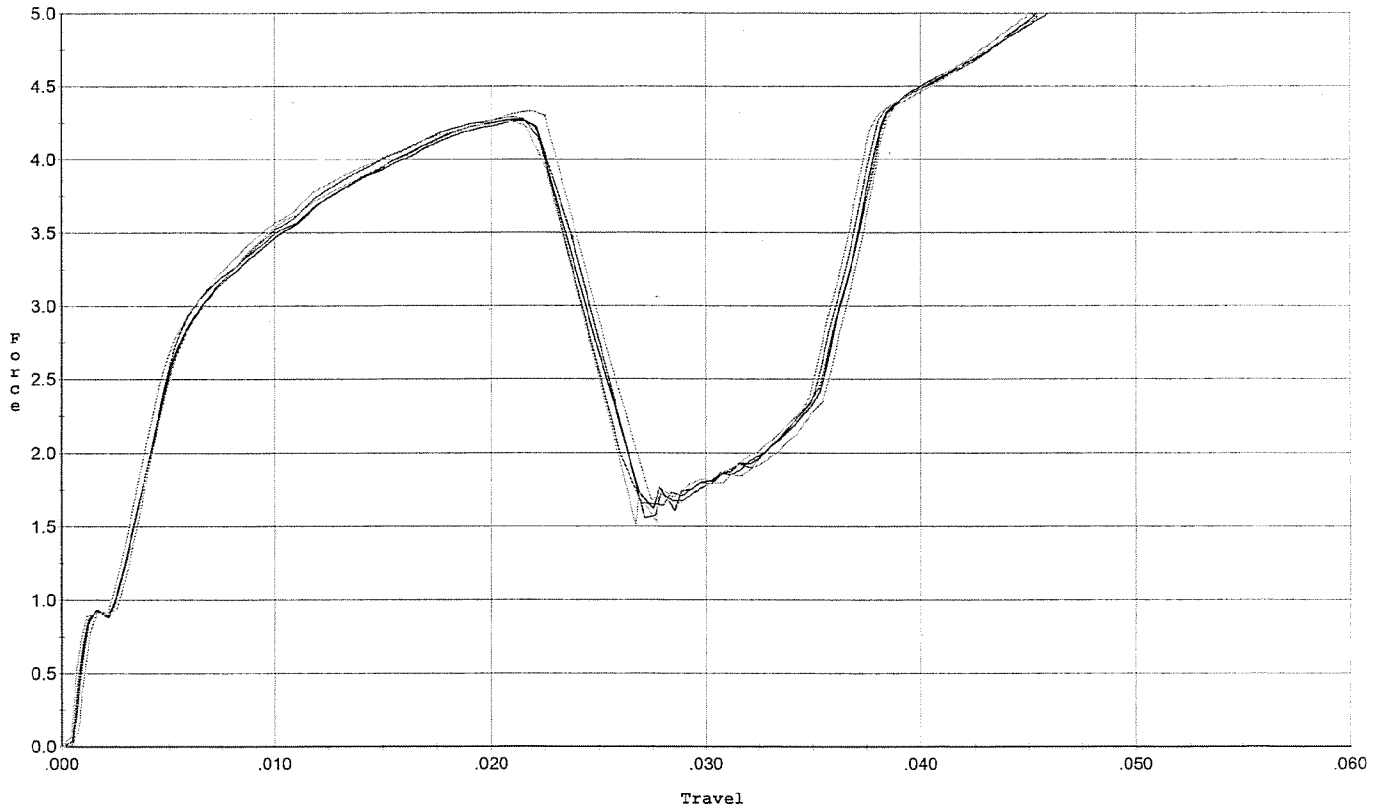
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.534	0.020	0.00	0.033	0.037		Set Trigger
2	2.569	0.021	0.00	0.034	0.038		Set Trigger
3	2.581	0.020	0.00	0.032	0.038		Set Trigger
4	2.648	0.020	0.00	0.033	0.039		Set Trigger
5	2.568	0.019	0.00	0.033	0.037		Set Trigger

A-2.58

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 ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.263	0.024	0.00	0.029	0.070		Set Trigger
2	4.272	0.022	0.00	0.029	0.065		Set Trigger
3	4.291	0.022	0.00	0.029	0.066		Set Trigger
4	4.257	0.022	0.00	0.029	0.068		Set Trigger
5	4.331	0.022	0.00	0.029	0.067		Set Trigger

A 4.28