

G680 7752

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



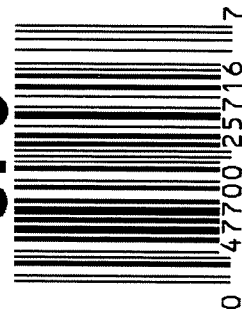
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6807752

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807752

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RZ
430	ASSEMBLE TO STOCK		3-6-09	RZ
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-9-09	RZ
475	DRILL AND TAP SIGHT HOLES	MAR 13 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/13/09	SP
490	MAGNAFLUX BOLT		3/13/09	SP
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SP
	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 10 LBS	<u>40</u> <u>40</u> <u>40</u>	3-28-09	DN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>50</u> <u>50</u>	3-28-09	DN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-28-09	DN
	J) ASSEMBLE STOCK		3-25-09	DN
	K) ASSEMBLE SWIVEL STUDS		3-28-09	DN
	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	3-26-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-28-09	DN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u> <u>2.26</u> <u>2.22</u> <u>2.25</u> <u>2.22</u>	3-26-09	TL
	C) FUNCTION		3-28-09	DN
690	PACK		3-28-09	TL

F004 REV 5/2006

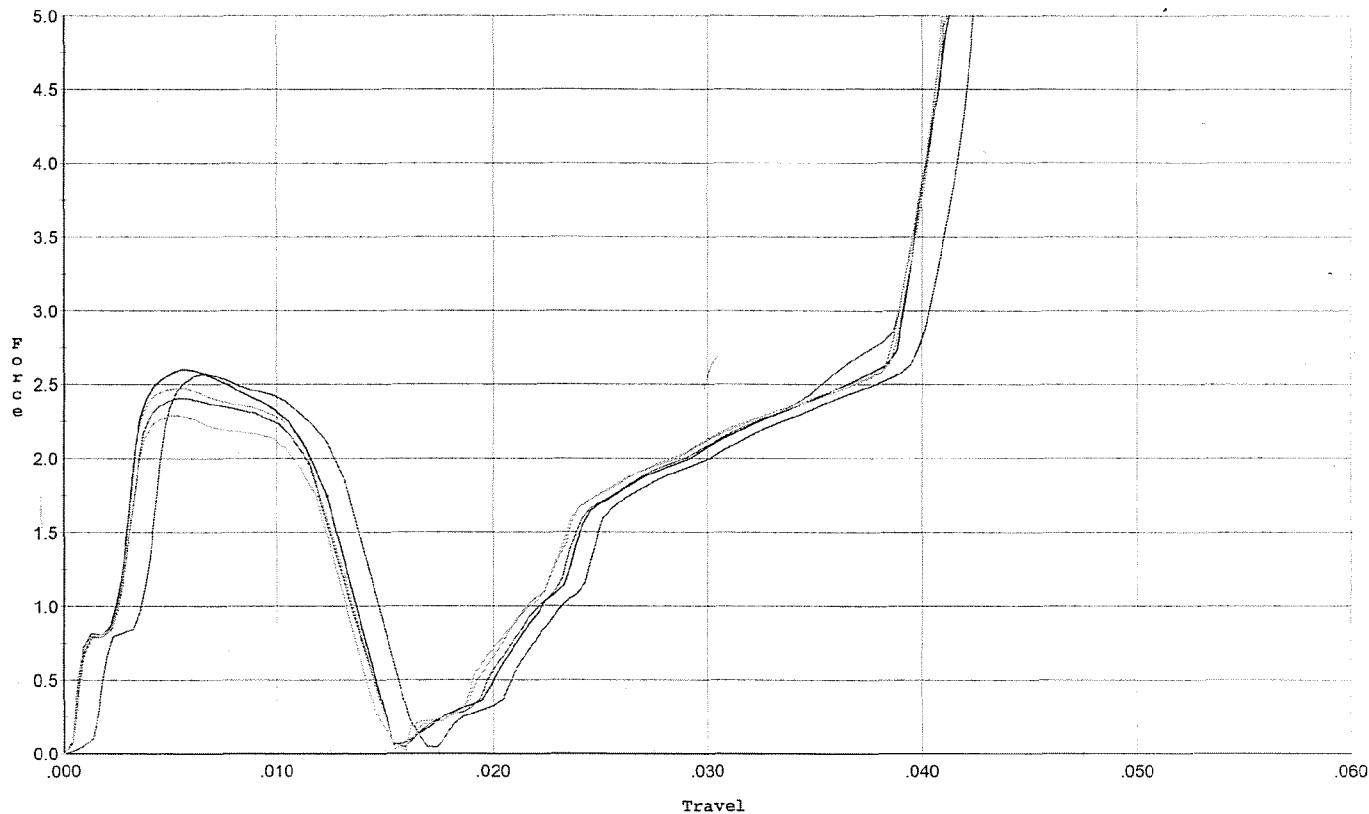
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CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



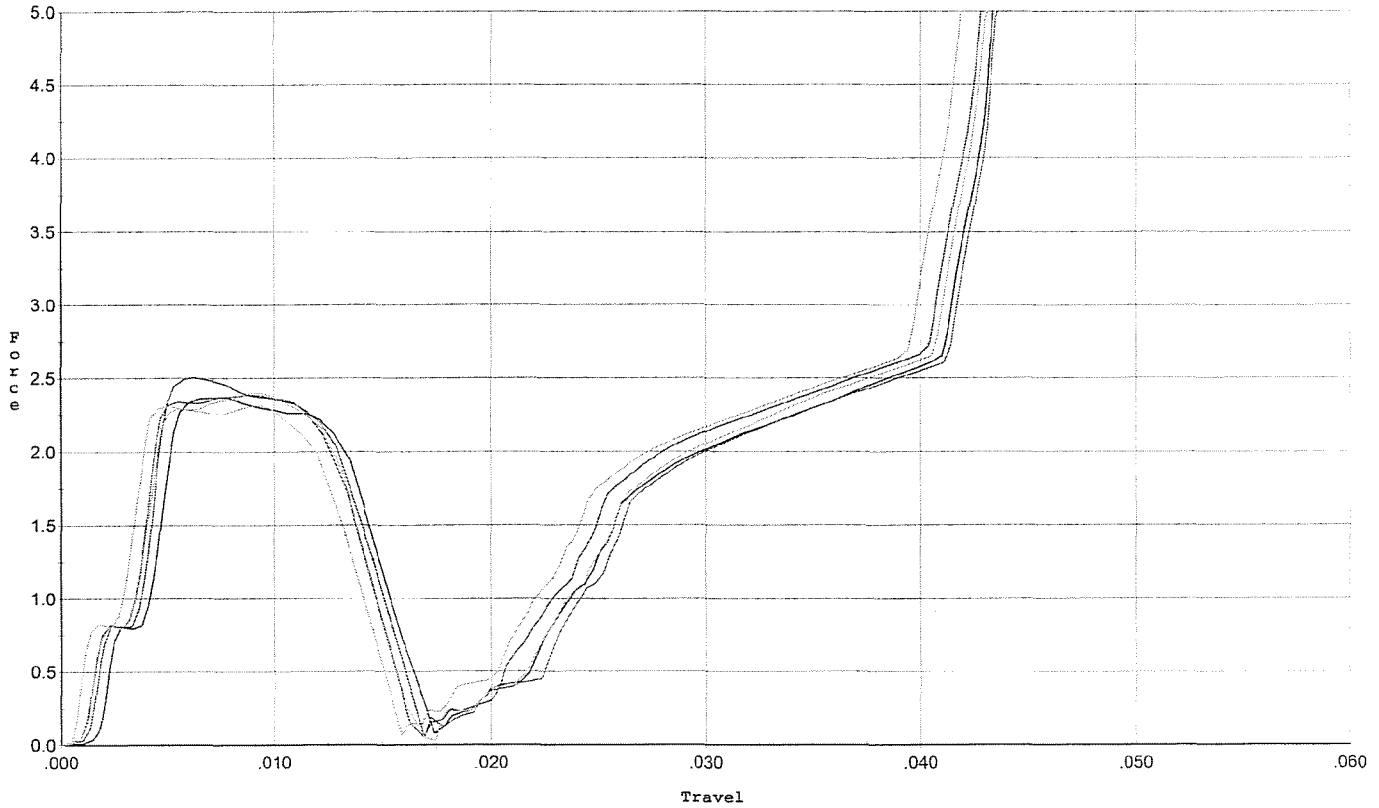
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.013	0.00	0.033	0.022		Set Trigger
2	2.600	0.012	0.00	0.033	0.022		Set Trigger
3	2.406	0.012	0.00	0.033	0.020		Set Trigger
4	2.290	0.012	0.00	0.033	0.019		Set Trigger
5	2.472	0.013	0.00	0.033	0.023		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



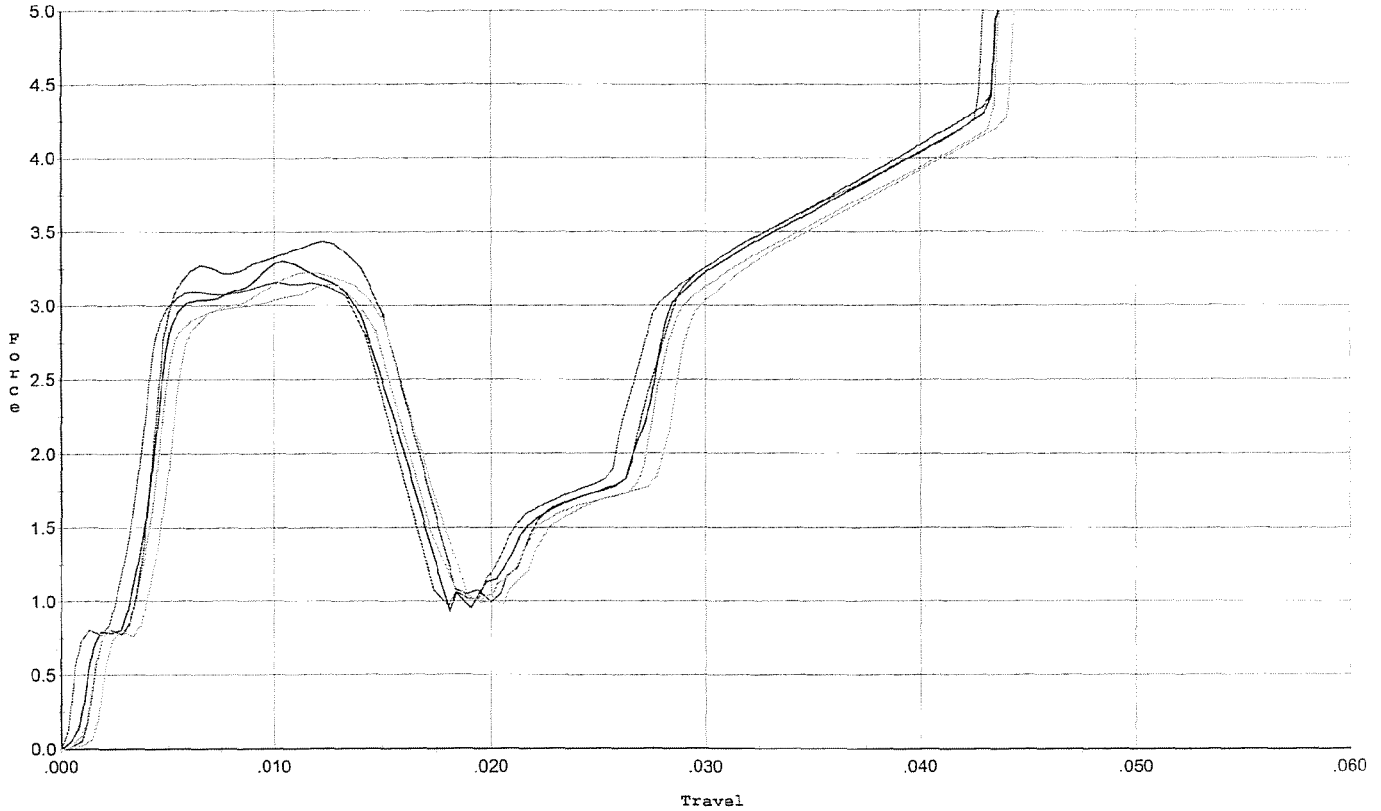
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.504	0.015	0.004	0.033	0.024		Set Trigger
2	2.368	0.014	0.00	0.033	0.021		Set Trigger
3	2.385	0.013	0.00	0.034	0.022		Set Trigger
4	2.400	0.013	0.00	0.034	0.021		Set Trigger
5	2.310	0.013	0.00	0.033	0.022		Set Trigger

A-2.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



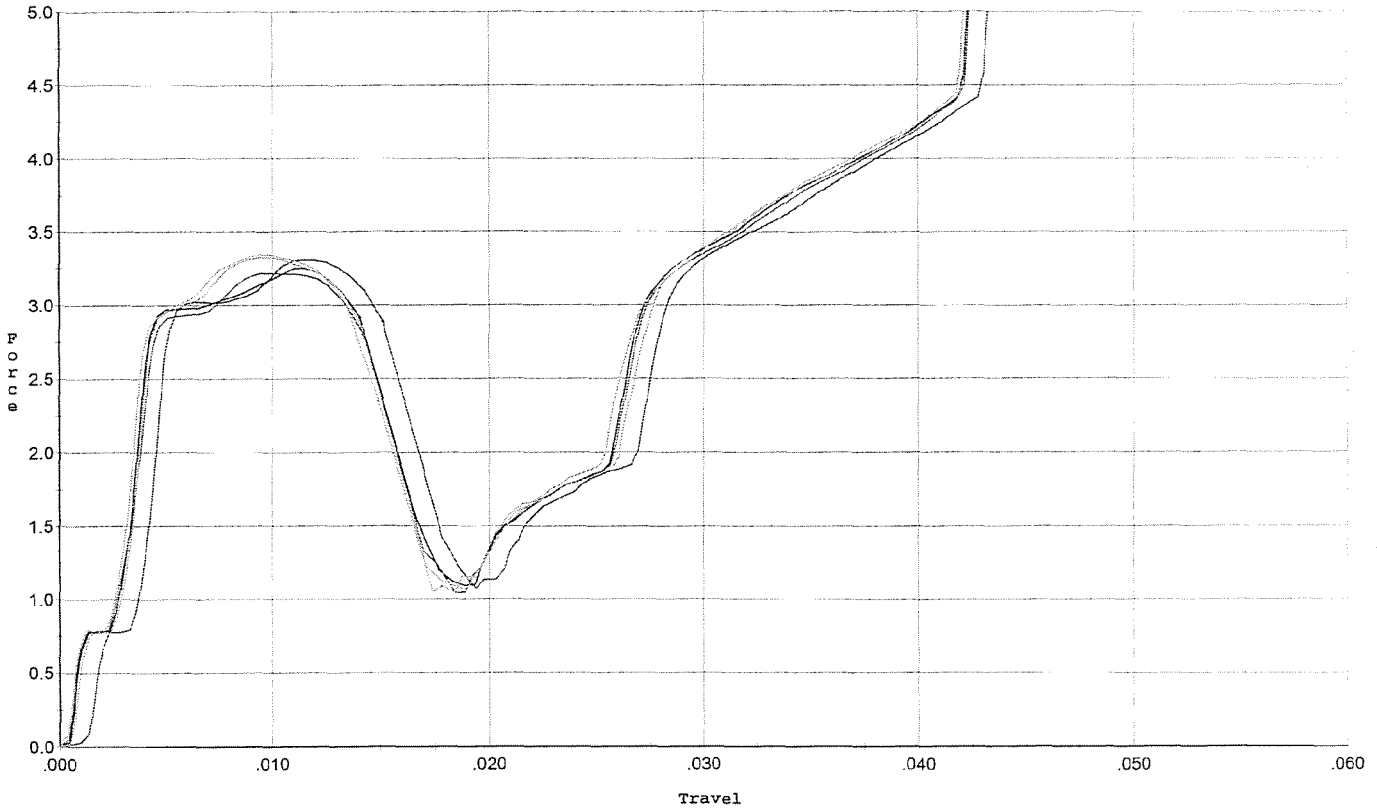
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.433	0.015	0.00	0.029	0.035		Set Trigger
2	3.304	0.016	0.00	0.030	0.034		Set Trigger
3	3.159	0.014	0.00	0.029	0.032		Set Trigger
4	3.224	0.015	0.00	0.030	0.031		Set Trigger
5	3.139	0.015	0.00	0.030	0.031		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



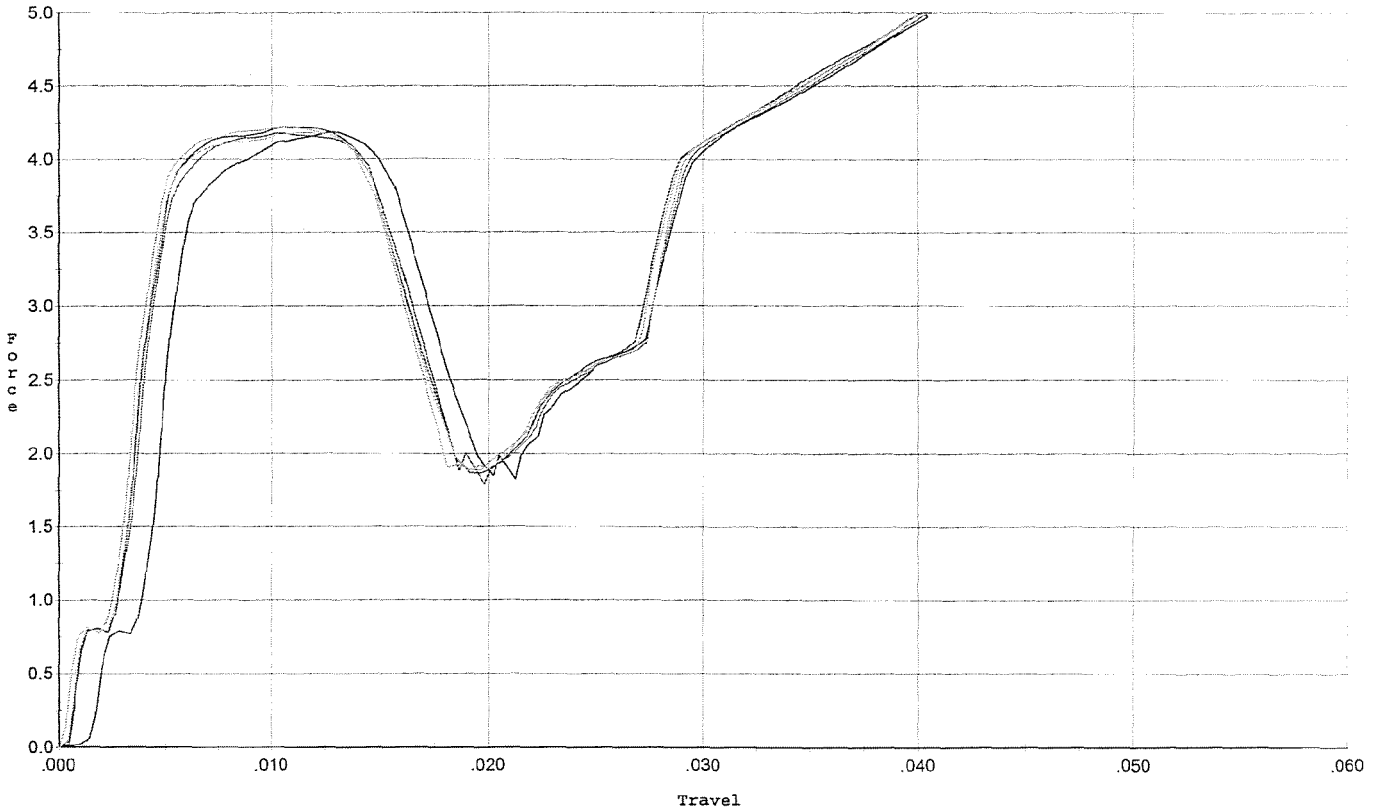
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.309	0.015	0.00	0.029	0.033		Set Trigger
2	3.251	0.014	0.00	0.029	0.032		Set Trigger
3	3.220	0.014	0.00	0.029	0.032		Set Trigger
4	3.347	0.015	0.00	0.029	0.035		Set Trigger
5	3.326	0.014	0.00	0.029	0.032		Set Trigger

A 3.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



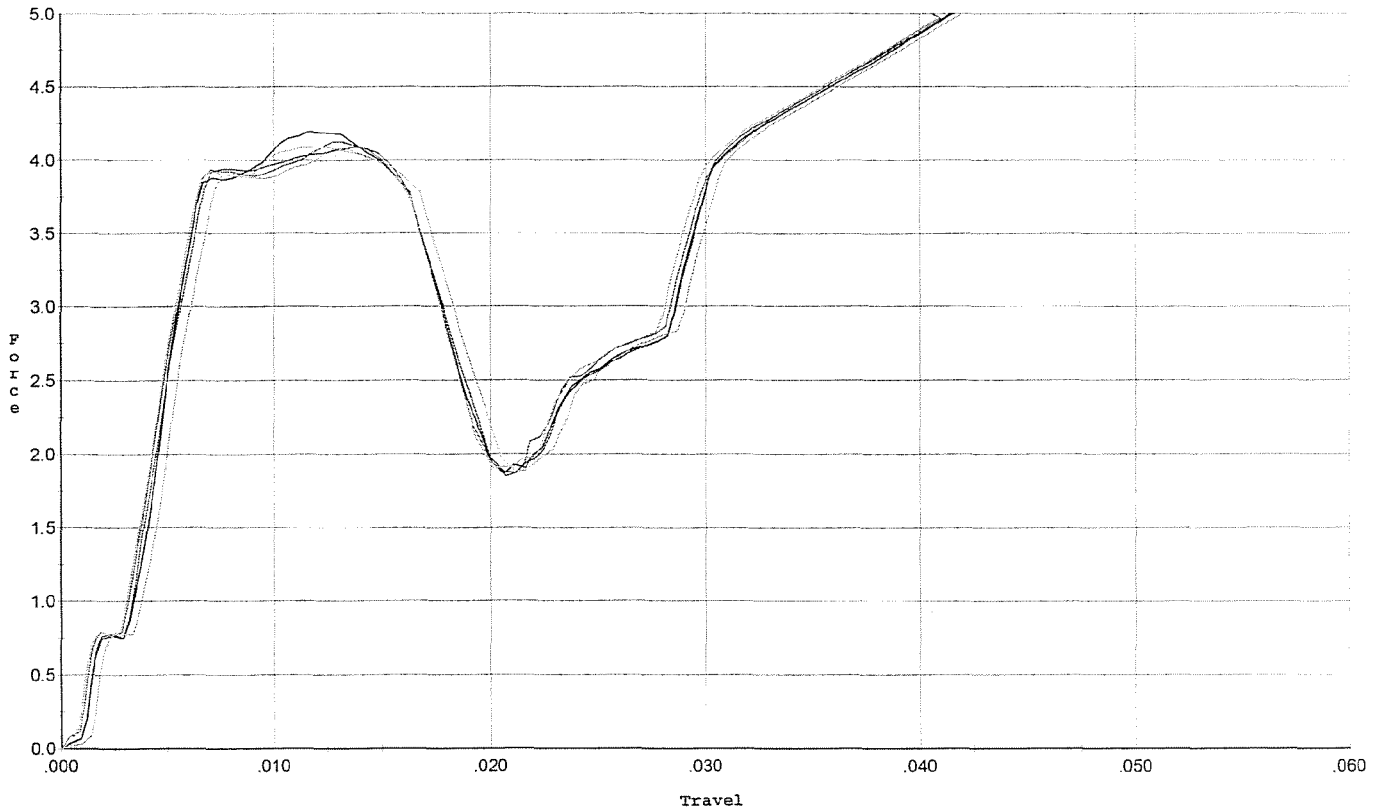
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.222	0.016	0.00	0.027	0.047		Set Trigger
2	4.183	0.016	0.00	0.027	0.042		Set Trigger
3	4.178	0.015	0.00	0.028	0.041		Set Trigger
4	4.183	0.015	0.003	0.027	0.042		Set Trigger
5	4.223	0.015	0.00	0.027	0.043		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



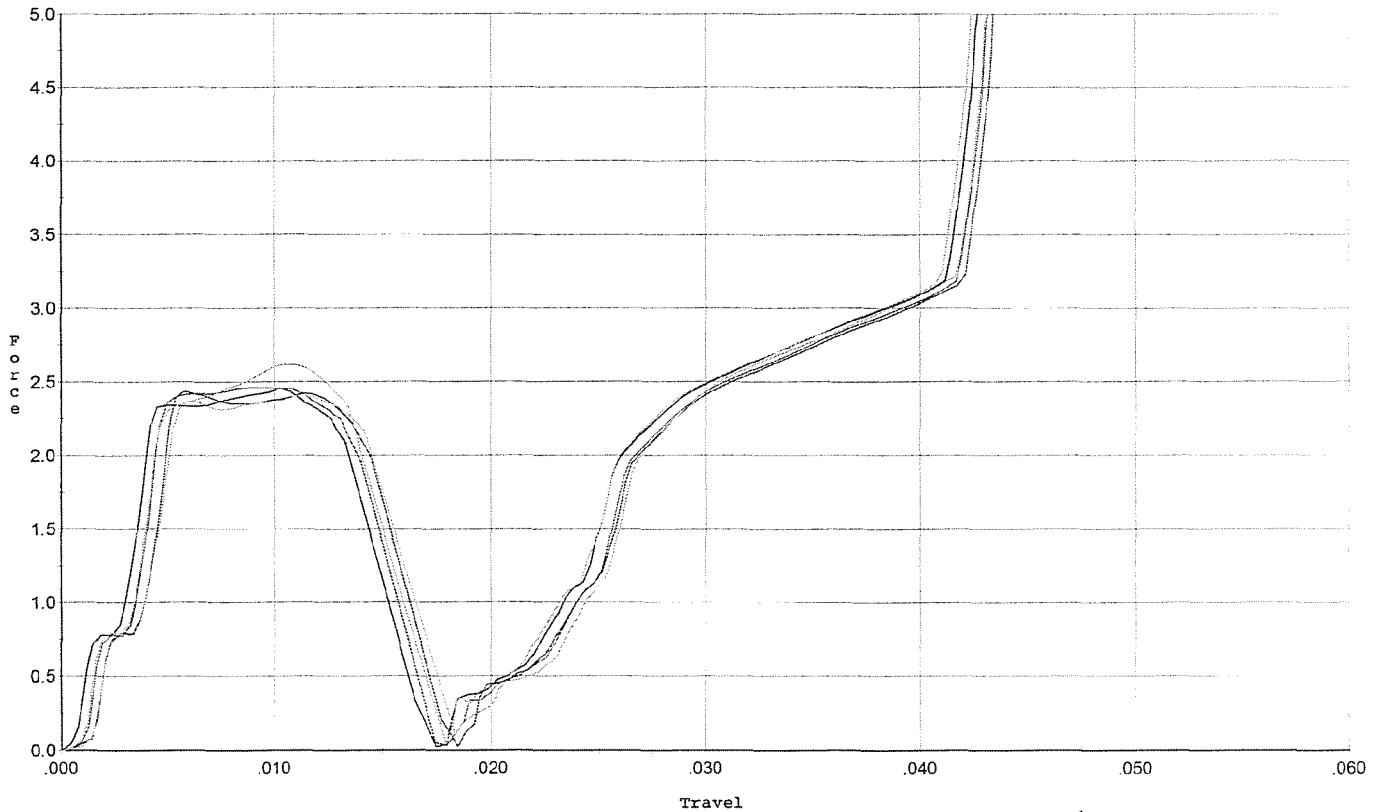
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.089	0.016	0.00	0.027	0.044		Set Trigger
2	4.194	0.016	0.00	0.027	0.045		Set Trigger
3	4.123	0.016	0.00	0.027	0.045		Set Trigger
4	4.089	0.016	0.00	0.027	0.045		Set Trigger
5	4.083	0.017	0.004	0.027	0.044		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



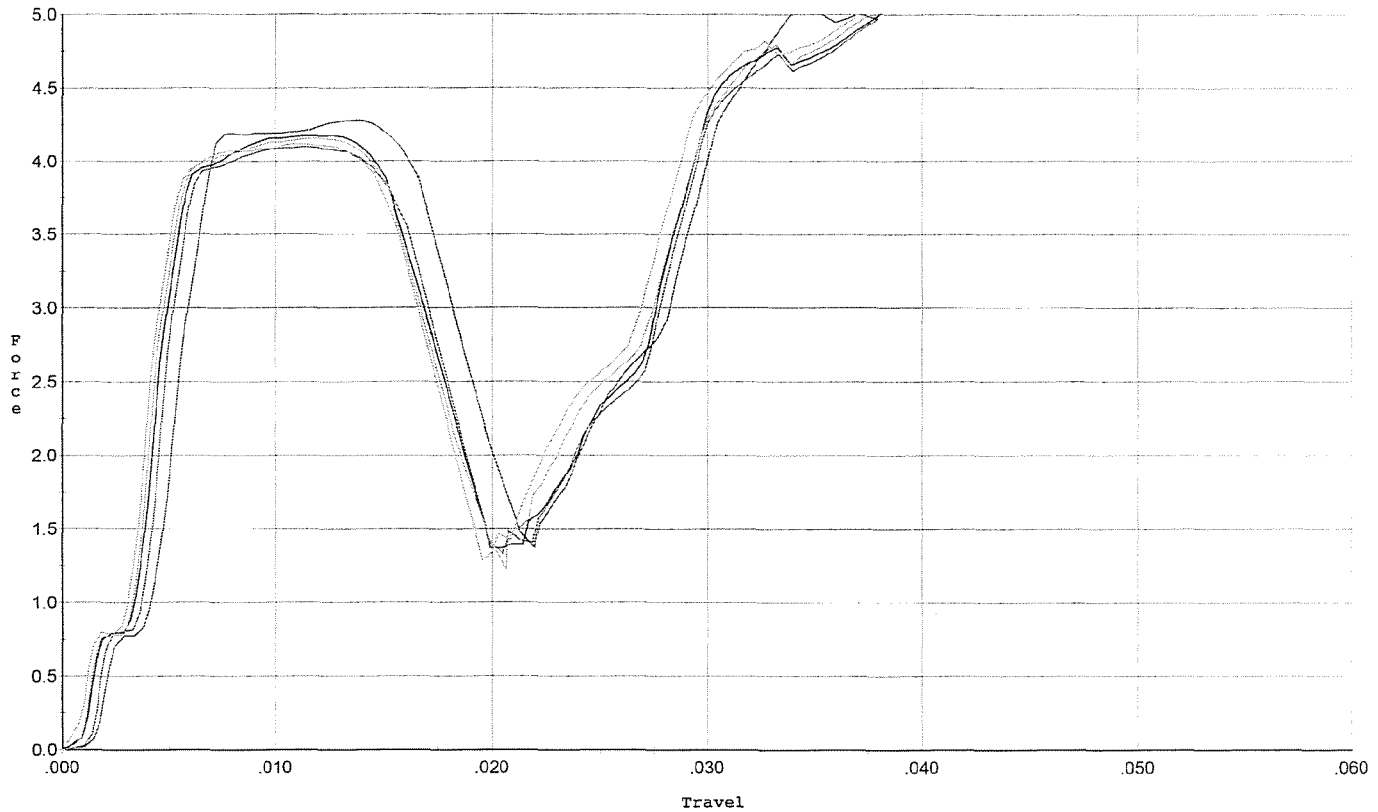
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.437	0.014	0.00	0.032	0.024		Set Trigger
2	2.456	0.013	0.00	0.032	0.023		Set Trigger
3	2.459	0.014	0.00	0.032	0.024		Set Trigger
4	2.415	0.014	0.00	0.032	0.023		Set Trigger
5	2.620	0.013	0.00	0.031	0.024		Set Trigger

A.2.47

Trigger Profile [lbs,inch]

Profile
GunType: SWS
Make: Rifle
Note: Remington
 C Schults 3/24/2009

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	4.282	0.017	0.00	0.027	0.046		Set Trigger
2	4.175	0.017	0.00	0.027	0.048		Set Trigger
3	4.099	0.016	0.00	0.027	0.044		Set Trigger
4	4.118	0.016	0.00	0.027	0.044		Set Trigger
5	4.155	0.015	0.00	0.027	0.042		Set Trigger

A 4.16