

G680 7754

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



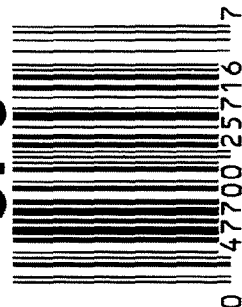
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807754

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807754

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	H
490	MAGNAFLUX BOLT		3/5/09	md
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	JP
520	GOFF BLAST BBL / REC		3/6	mm
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		3-16-09	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

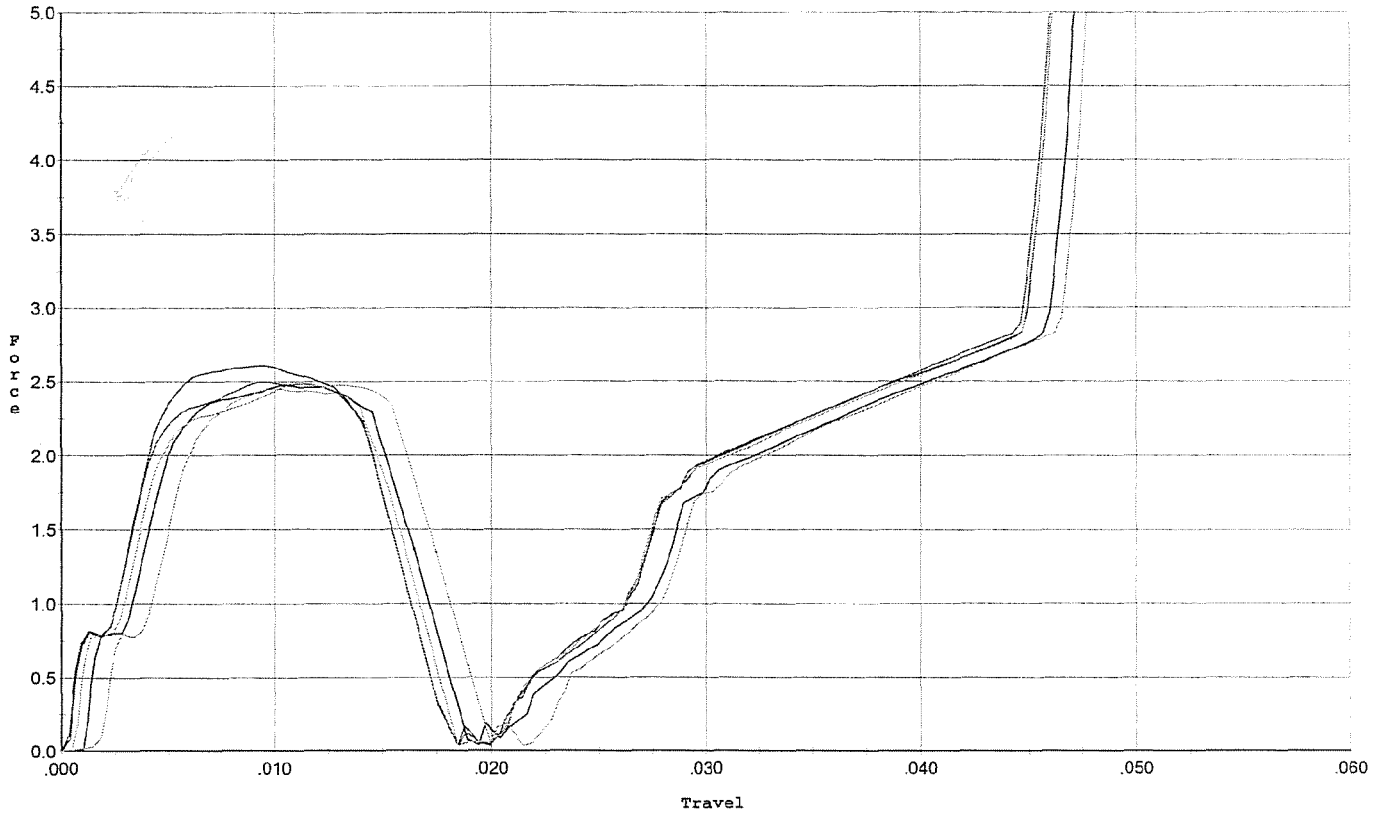
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OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-20-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) 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 N/A		
	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>2.37</u> <u>2.49</u> <u>2.41</u> <u>2.42</u> <u>2.46</u>	3-20-09	TL
	C) FUNCTION		3-20-09	WV
690	PACK		3-21-09	TL

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



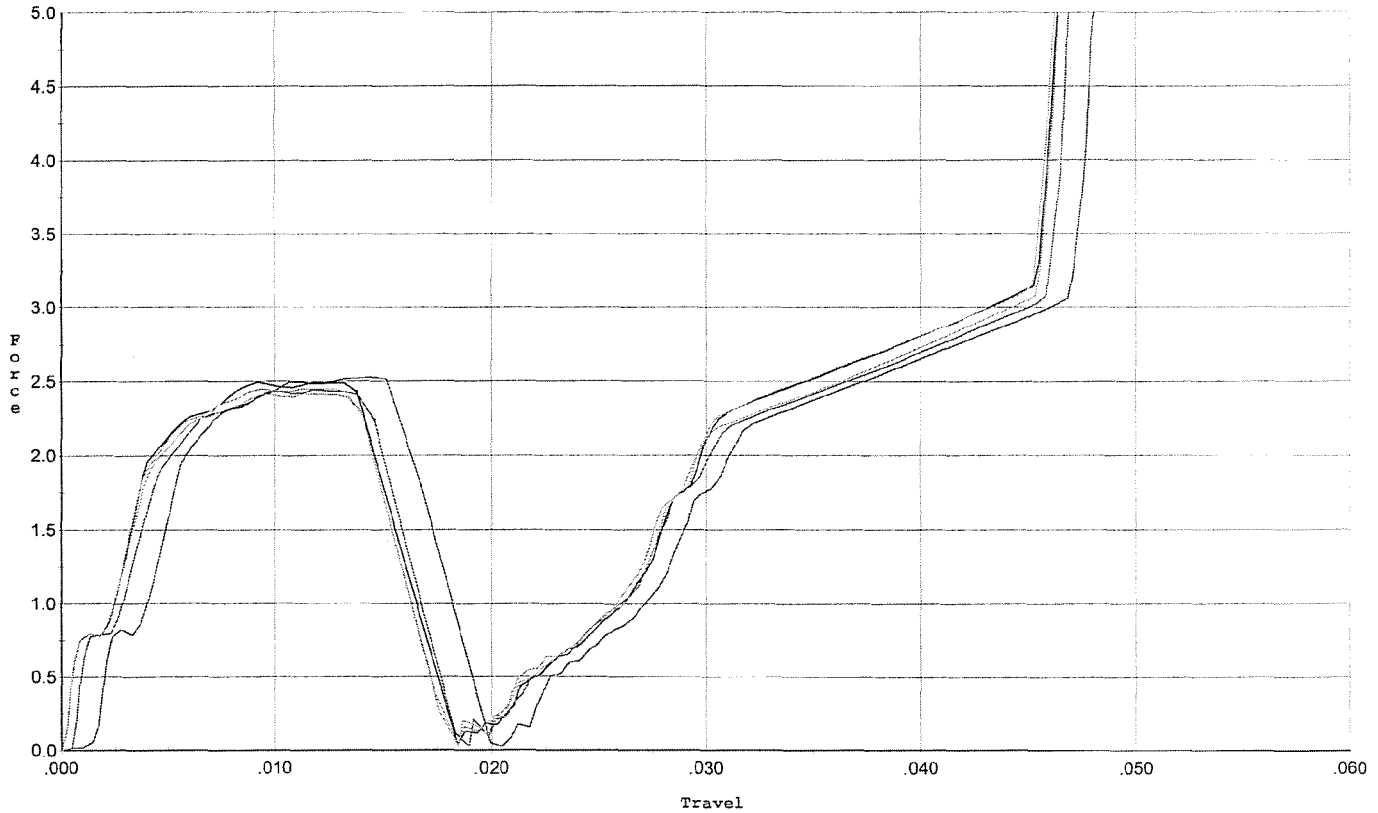
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.607	0.014	0.00	0.035	0.027		Set Trigger
2	2.471	0.016	0.00	0.035	0.028		Set Trigger
3	2.496	0.014	0.00	0.035	0.026		Set Trigger
4	2.448	0.015	0.00	0.035	0.027		Set Trigger
5	2.488	0.017	0.00	0.035	0.029		Set Trigger

A-2-50

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



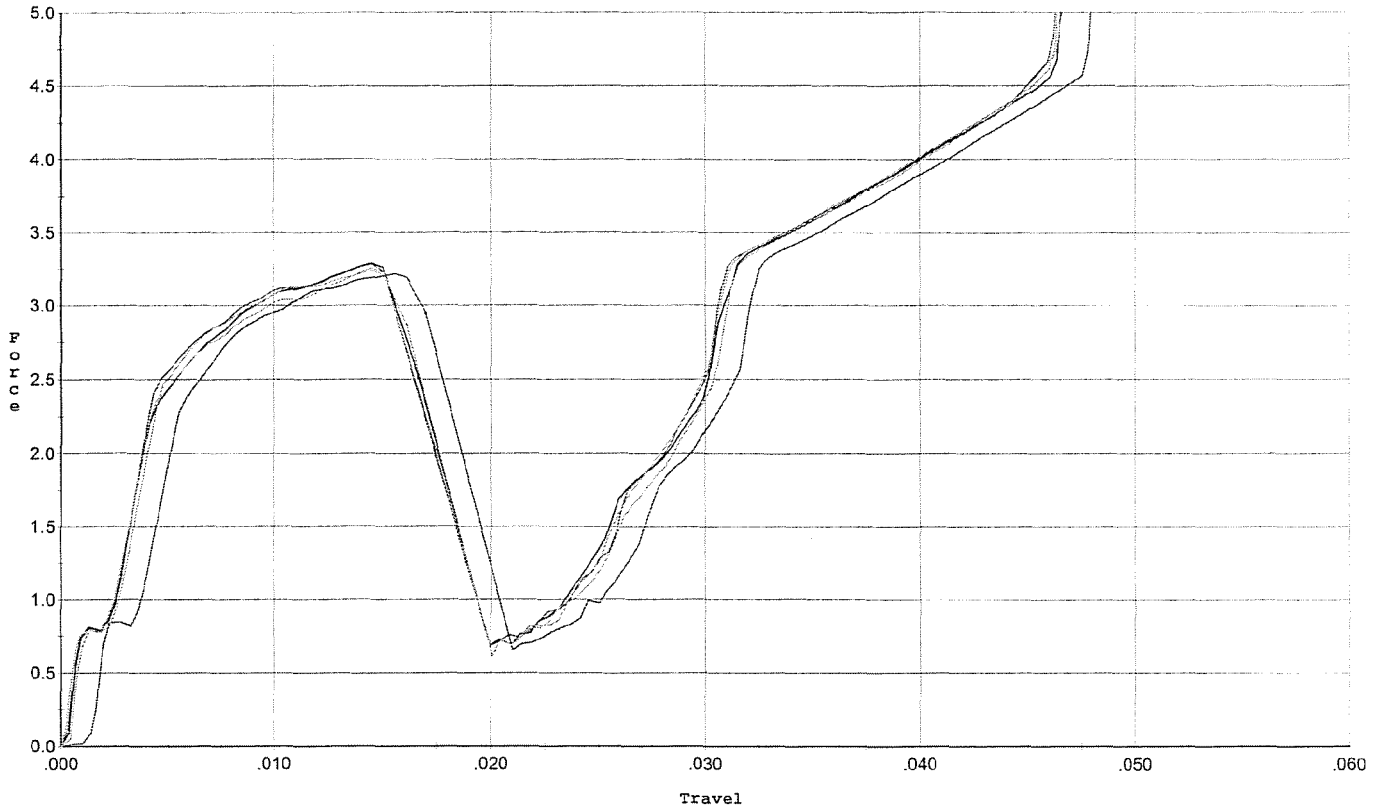
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.530	0.017	0.00	0.034	0.029		Set Trigger
2	2.493	0.014	0.00	0.035	0.025		Set Trigger
3	2.444	0.015	0.00	0.035	0.026		Set Trigger
4	2.416	0.014	0.00	0.035	0.025		Set Trigger
5	2.450	0.014	0.00	0.035	0.026		Set Trigger

A-2.46

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



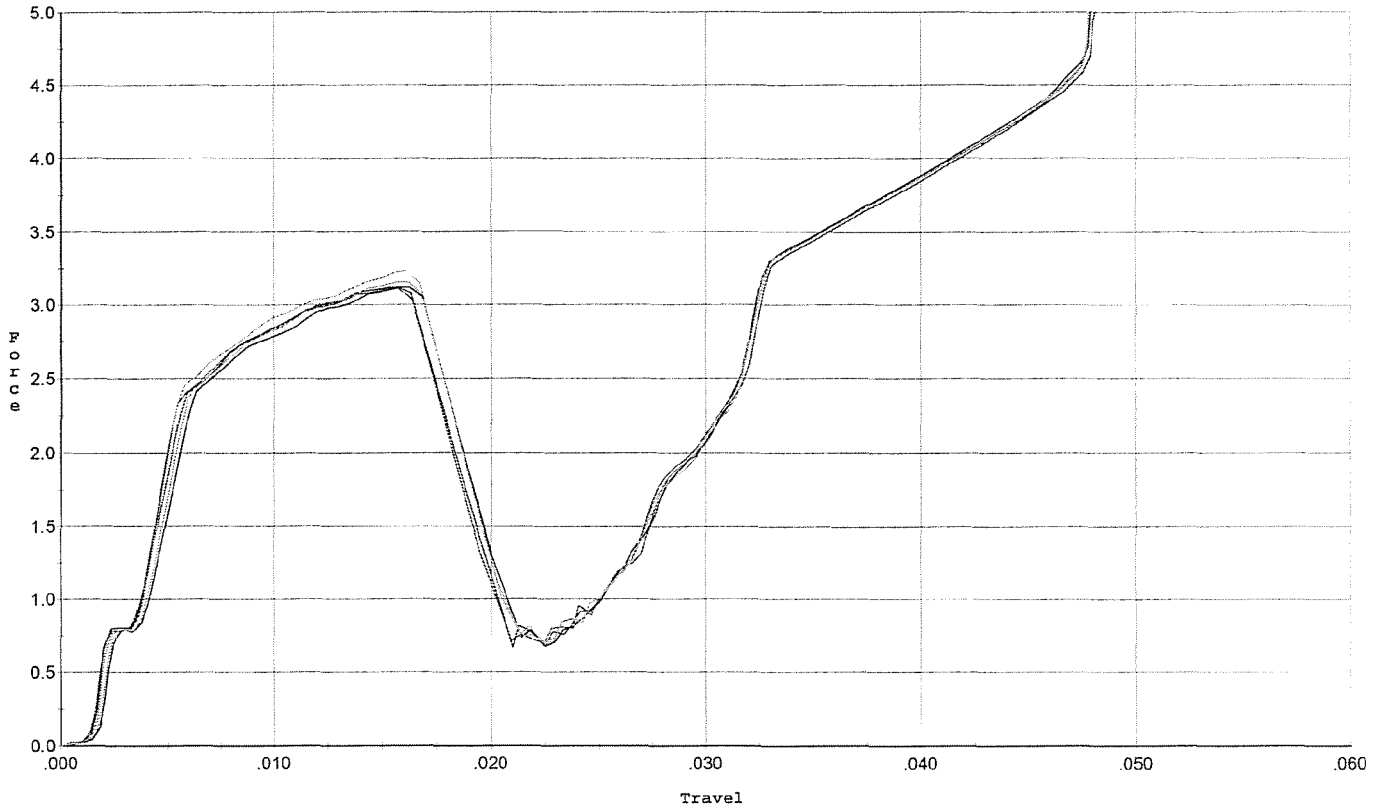
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.216	0.017	0.00	0.032	0.036		Set Trigger
2	3.288	0.017	0.00	0.031	0.038		Set Trigger
3	3.280	0.017	0.00	0.031	0.040		Set Trigger
4	3.255	0.017	0.00	0.031	0.039		Set Trigger
5	3.238	0.016	0.00	0.031	0.036		Set Trigger

A-3-25

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



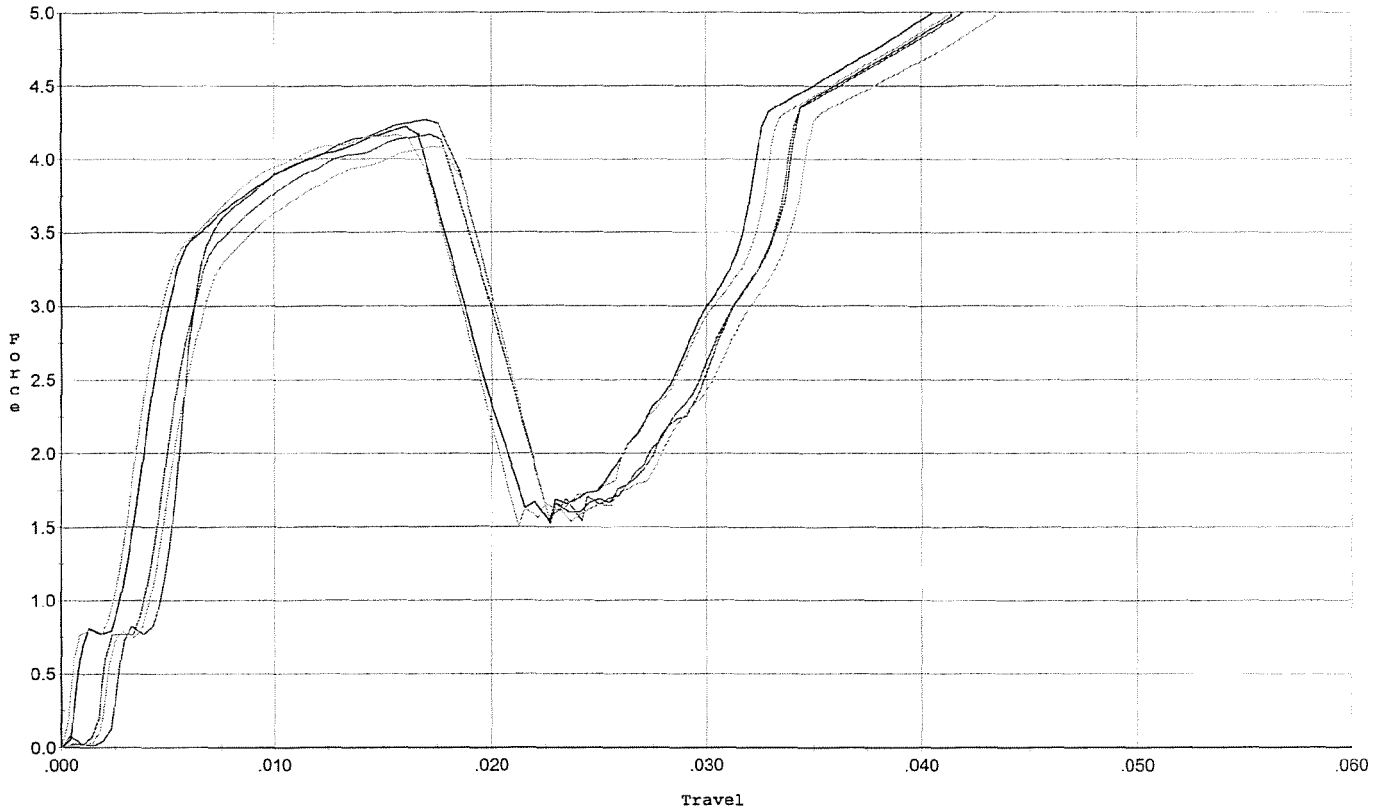
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.016	0.004	0.033	0.034		Set Trigger
2	3.118	0.017	0.00	0.032	0.034		Set Trigger
3	3.108	0.016	0.00	0.032	0.034		Set Trigger
4	3.155	0.017	0.00	0.032	0.035		Set Trigger
5	3.236	0.017	0.00	0.032	0.035		Set Trigger

A-3-14

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



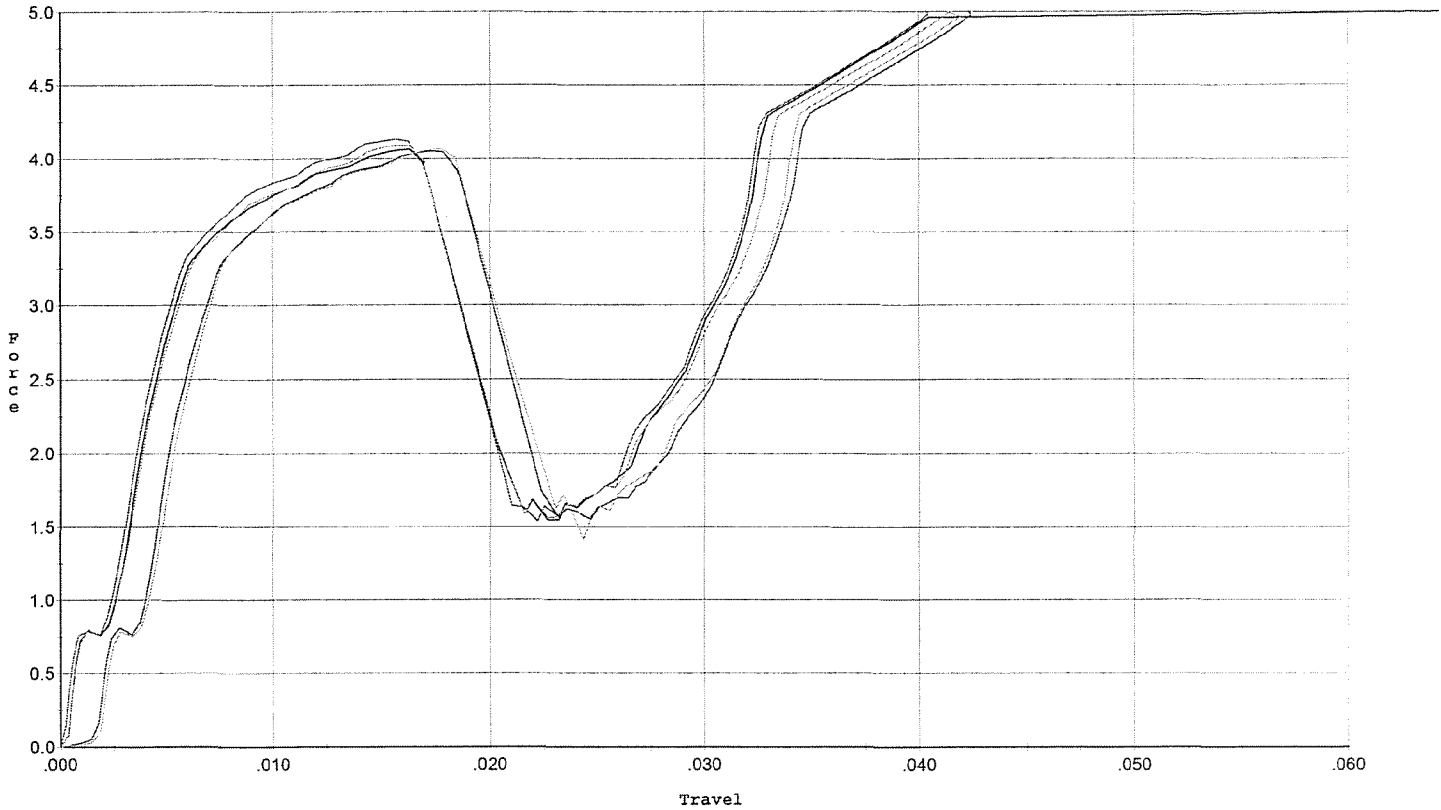
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.269	0.019	0.002	0.030	0.050		Set Trigger
2	4.222	0.017	0.00	0.029	0.048		Set Trigger
3	4.169	0.020	0.004	0.030	0.054		Set Trigger
4	4.086	0.019	0.00	0.031	0.049		Set Trigger
5	4.165	0.017	0.00	0.030	0.050		Set Trigger

A-4.18

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



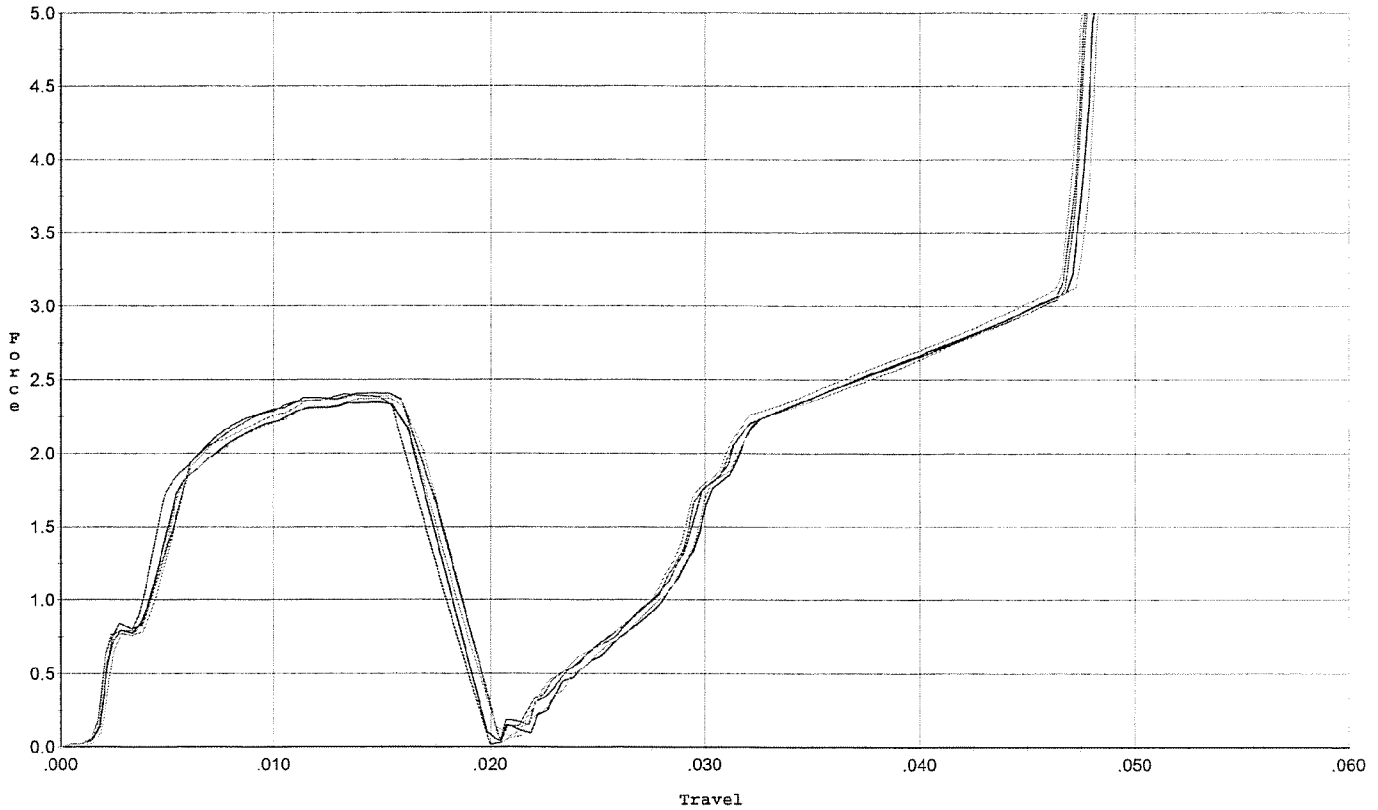
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.050	0.019	0.00	0.030	0.049		Set Trigger
2	4.064	0.017	0.00	0.030	0.047		Set Trigger
3	4.131	0.017	0.00	0.029	0.048		Set Trigger
4	4.065	0.018	0.00	0.030	0.048		Set Trigger
5	4.091	0.017	0.00	0.030	0.047		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: reset to 2.5 lbs +/- .50 lb for final test



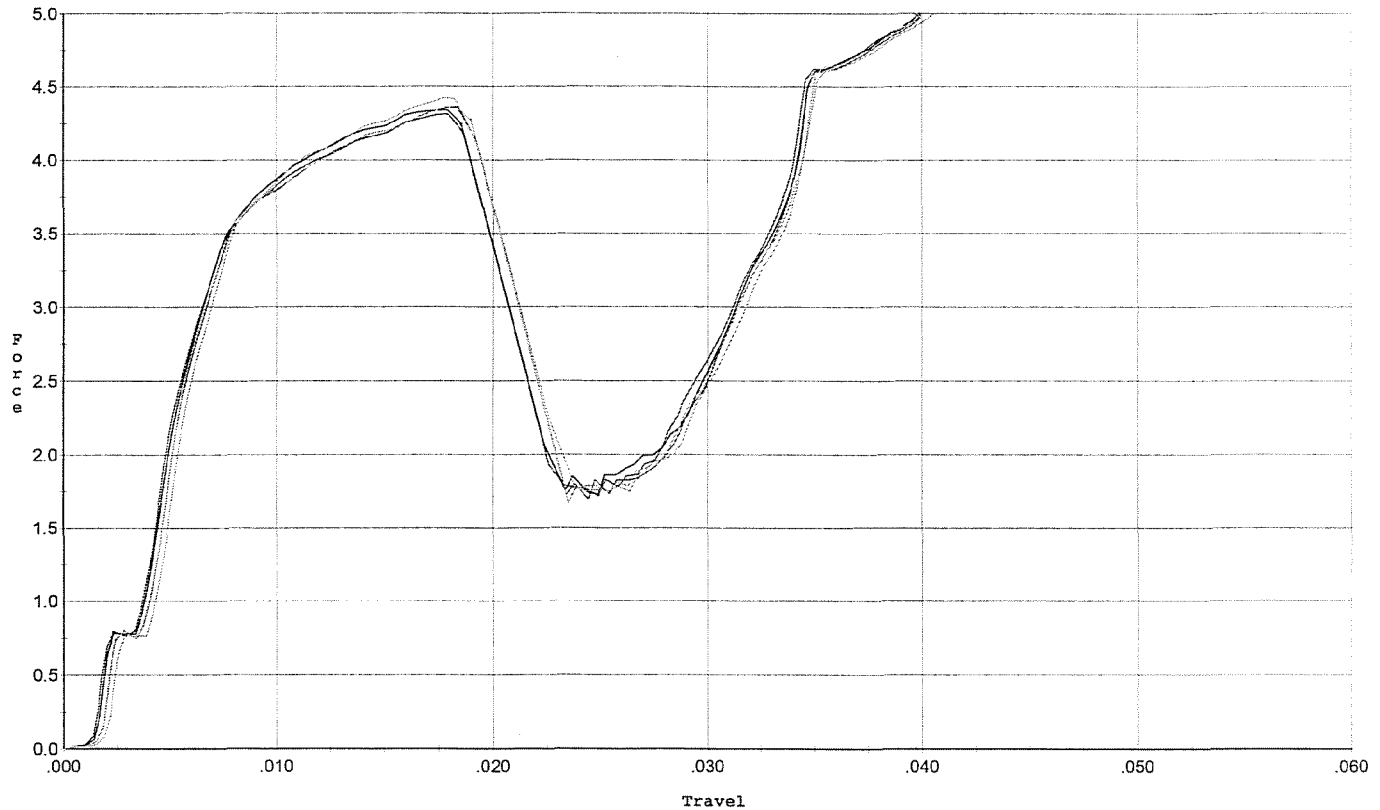
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.409	0.017	0.00	0.034	0.029		Set Trigger
2	2.348	0.016	0.00	0.034	0.026		Set Trigger
3	2.404	0.015	0.00	0.035	0.025		Set Trigger
4	2.401	0.017	0.00	0.033	0.027		Set Trigger
5	2.376	0.016	0.00	0.035	0.026		Set Trigger

A-2-38

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	4.312	0.019	0.00	0.029	0.052		Set Trigger
2	4.342	0.019	0.004	0.028	0.052		Set Trigger
3	4.361	0.019	0.00	0.028	0.054		Set Trigger
4	4.424	0.019	0.00	0.028	0.054		Set Trigger
5	4.367	0.019	0.004	0.029	0.052		Set Trigger

A-4.36