

G680 7755

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



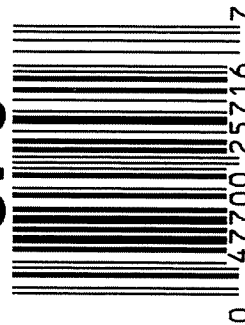
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807755

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807755

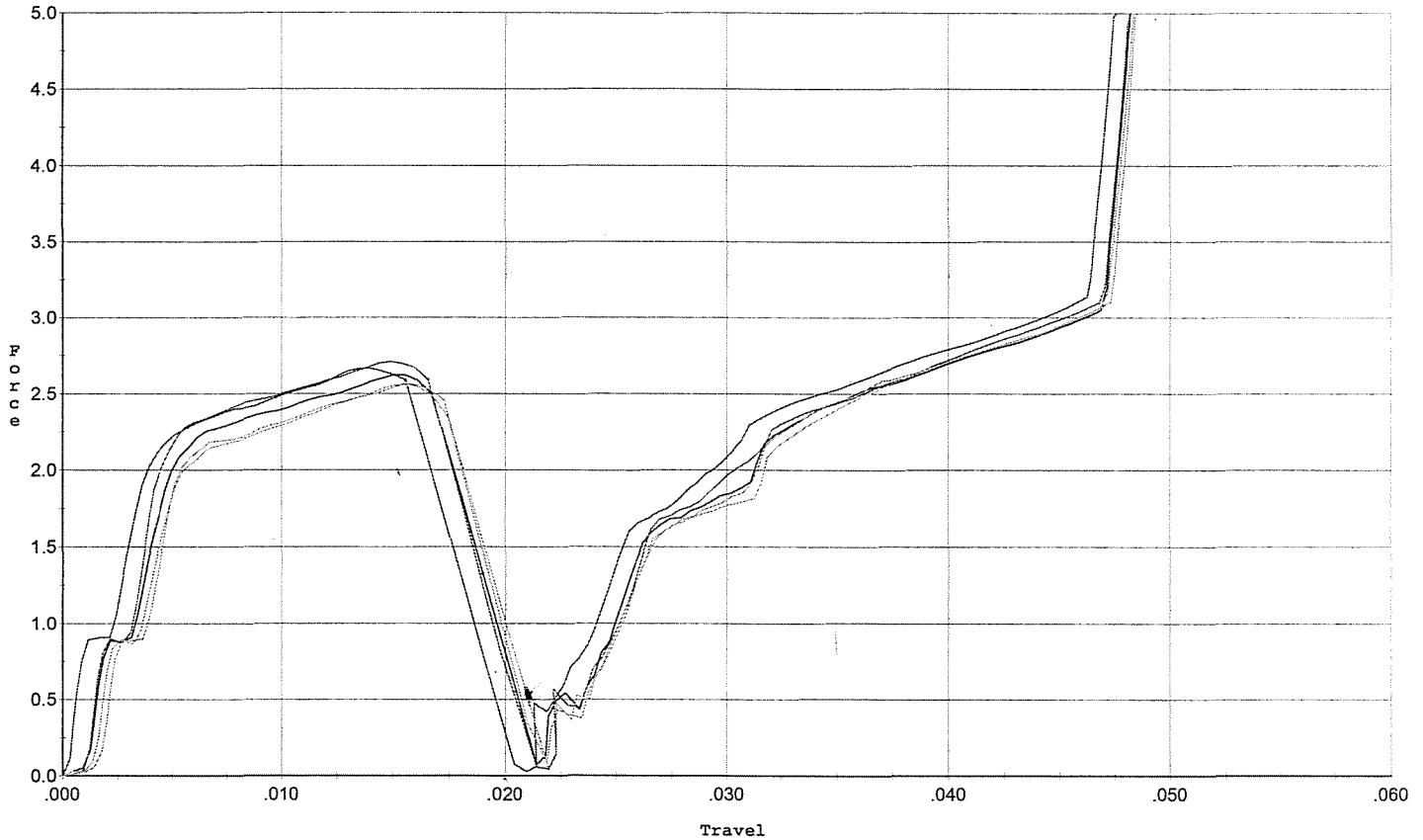
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SP
460	CHECK HEADSPACE		2-27-09	SP
470	DIS-ASSEMBLE ACTION		2-27-09	SP
472	SERIALIZE BOLT HANDLE		3-2-09	RJL
480	MAGNAFLUX BBL ACTION	OPERATOR A	3/5/09	A
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	MR
540	APPLY COATINGS (BARREL ACTION)		5/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-11-09	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 MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-18-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-18-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>1022</u>	3-18-09	NW
	J) ASSEMBLE STOCK		3-11-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-19-09	NW
	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	3-16-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-18-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.74</u> <u>2.79</u> <u>2.68</u> <u>2.64</u>	3-18-09	TL
	C) FUNCTION		3-18-09	NW
690	PACK		3/19/09	FM

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



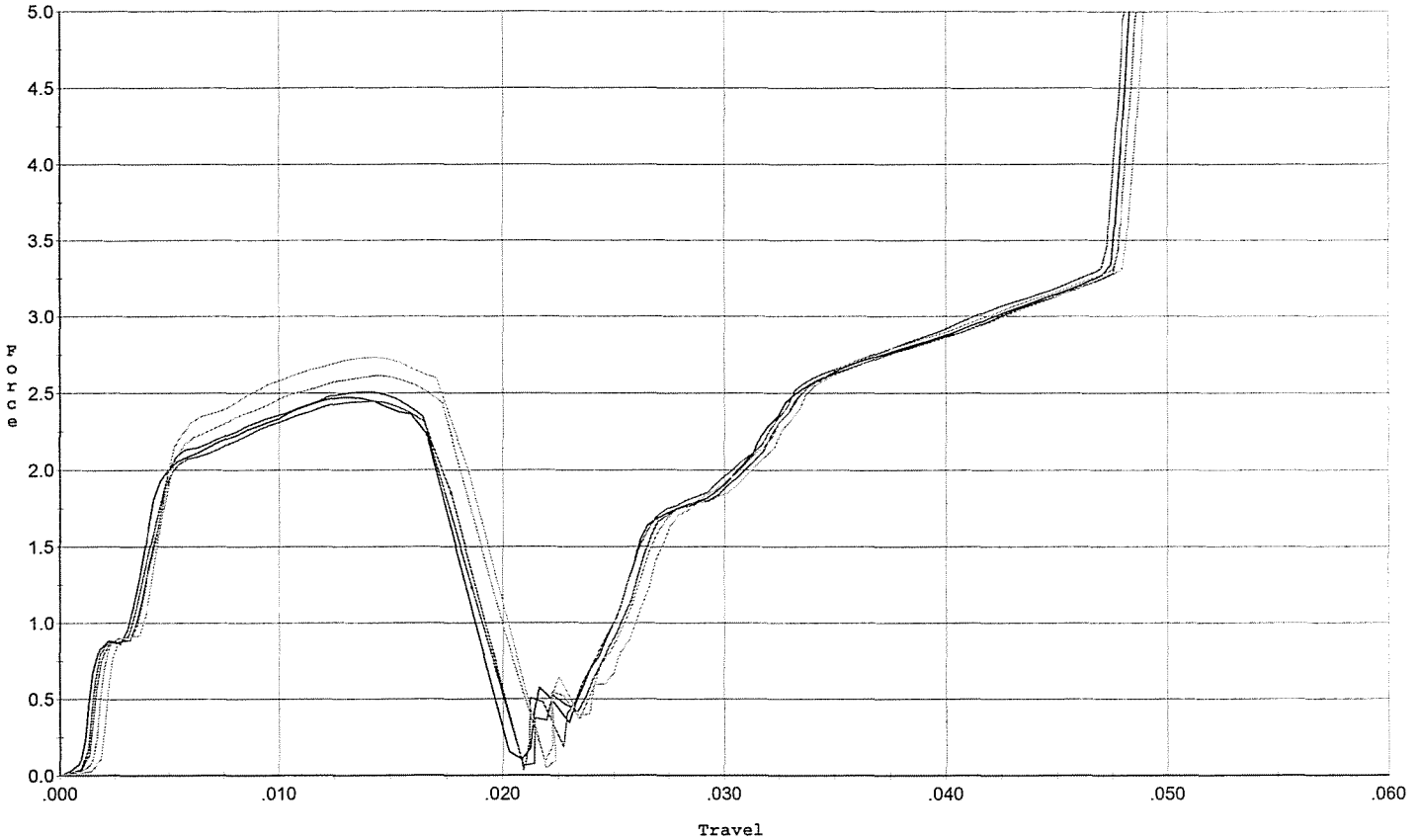
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.668	0.016	0.00	0.034	0.031		Set Trigger
2	2.623	0.019	0.00	0.033	0.035		Set Trigger
3	2.710	0.017	0.00	0.034	0.032		Set Trigger
4	2.568	0.017	0.00	0.034	0.031		Set Trigger
5	2.561	0.017	0.00	0.033	0.031		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



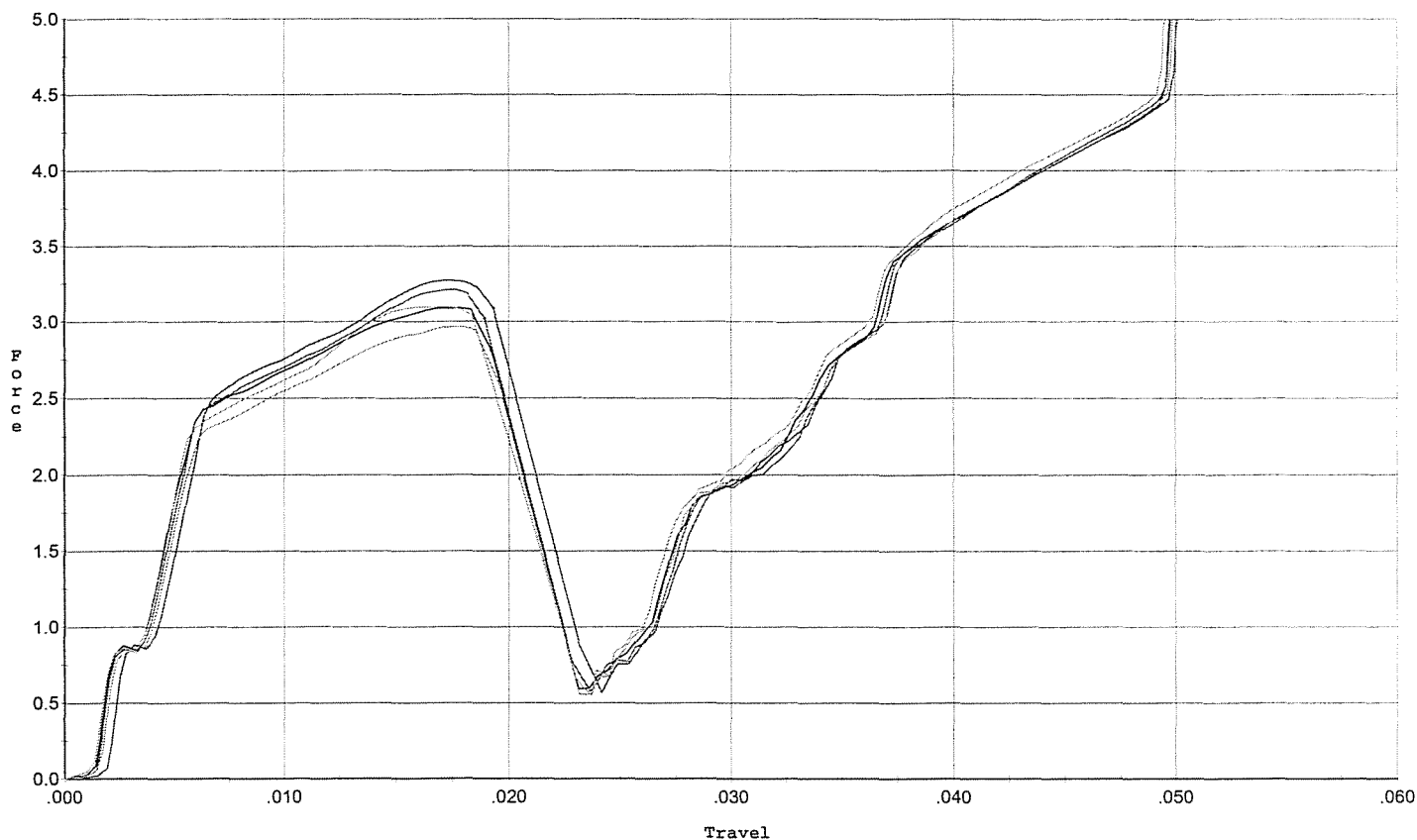
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.509	0.019	0.00	0.034	0.033		Set Trigger
2	2.474	0.017	0.00	0.034	0.030		Set Trigger
3	2.447	0.018	0.00	0.034	0.031		Set Trigger
4	2.736	0.018	0.00	0.034	0.035		Set Trigger
5	2.615	0.017	0.00	0.034	0.032		Set Trigger

A-255

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



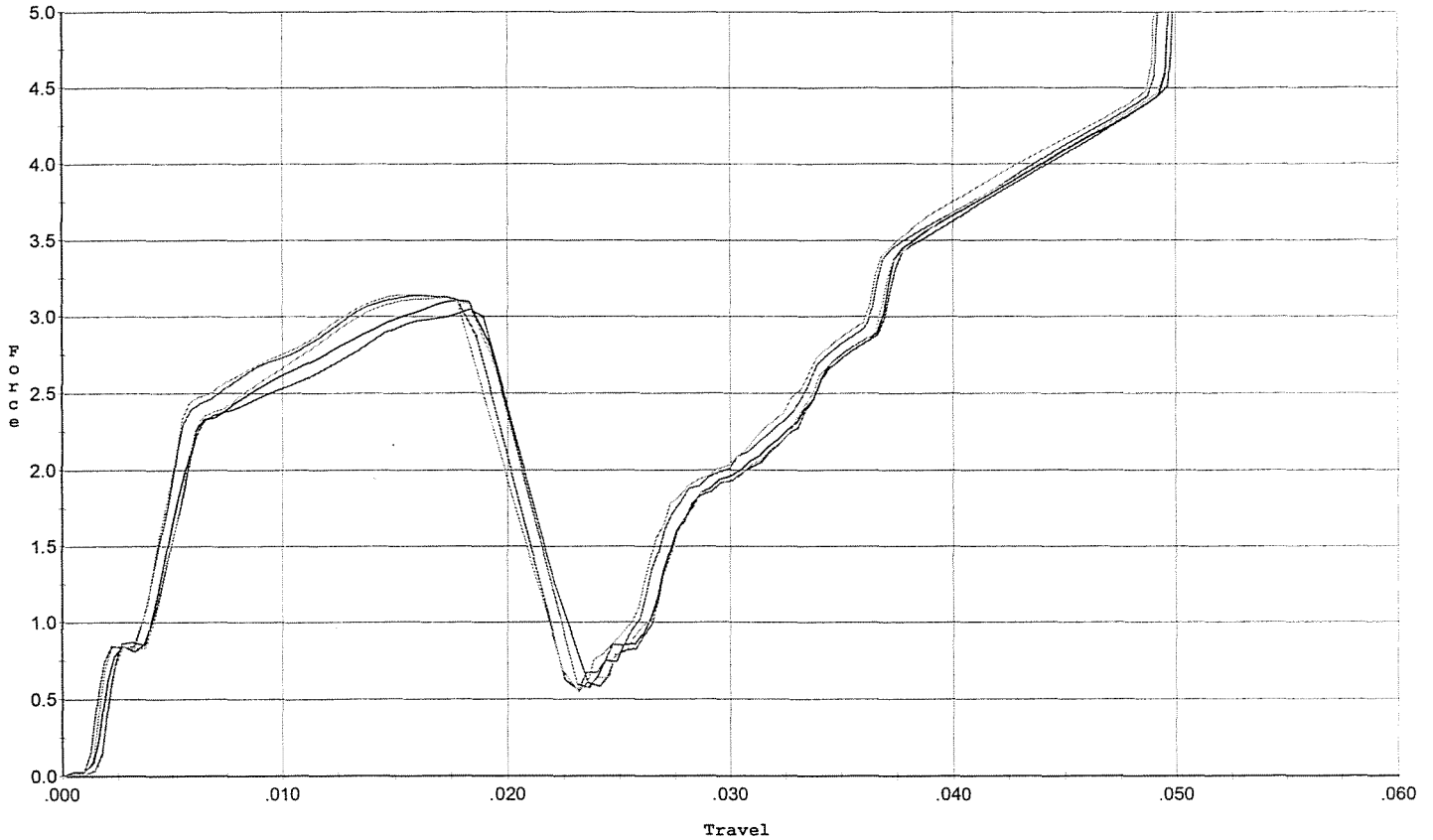
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.271	0.019	0.00	0.033	0.041		Set Trigger
2	3.089	0.019	0.00	0.033	0.041		Set Trigger
3	3.213	0.019	0.00	0.033	0.040		Set Trigger
4	3.099	0.020	0.00	0.032	0.043		Set Trigger
5	2.966	0.020	0.00	0.033	0.039		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



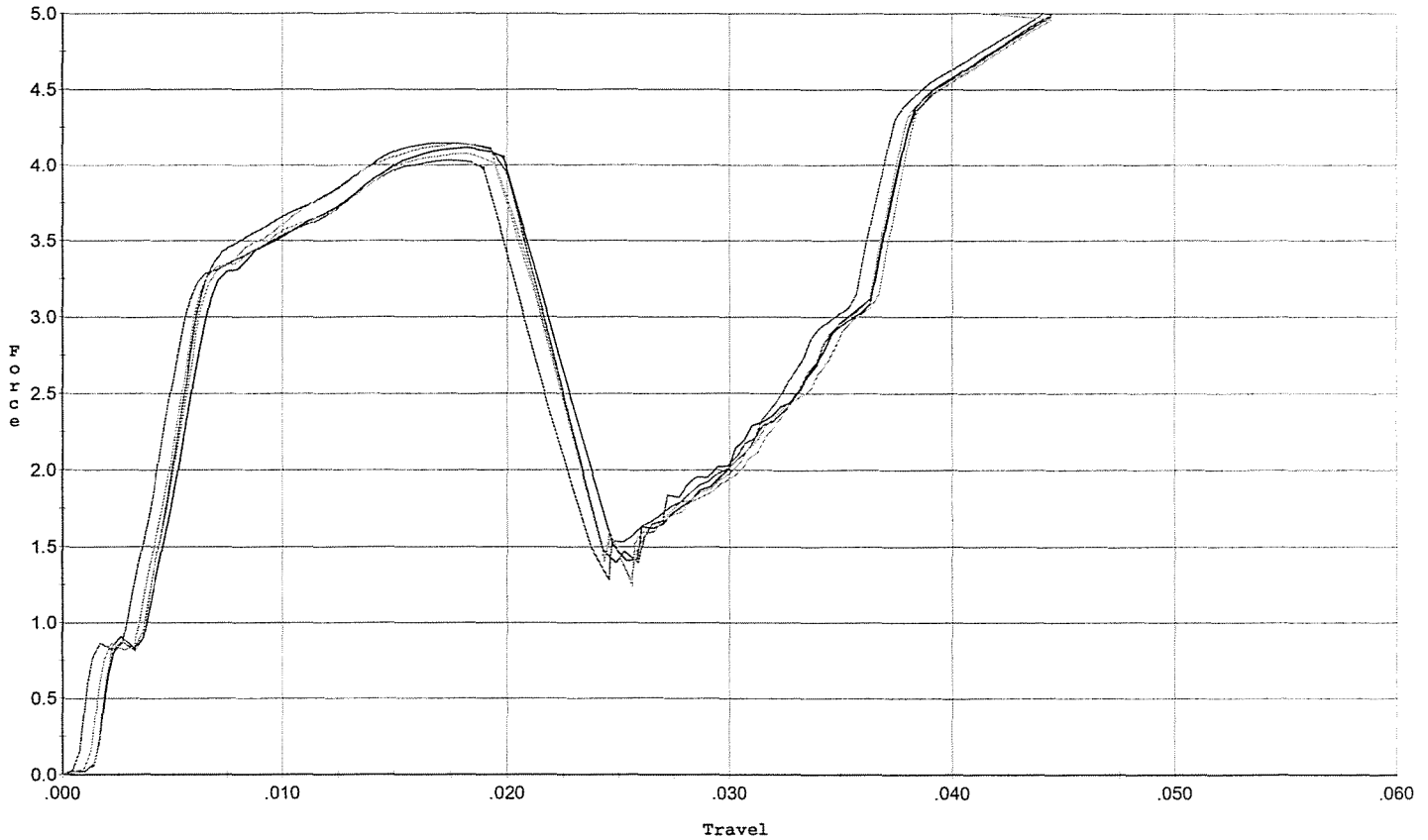
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.019	0.00	0.033	0.038		Set Trigger
2	3.104	0.019	0.00	0.033	0.040		Set Trigger
3	3.137	0.019	0.00	0.032	0.040		Set Trigger
4	3.120	0.019	0.004	0.033	0.040		Set Trigger
5	3.143	0.018	0.00	0.033	0.038		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



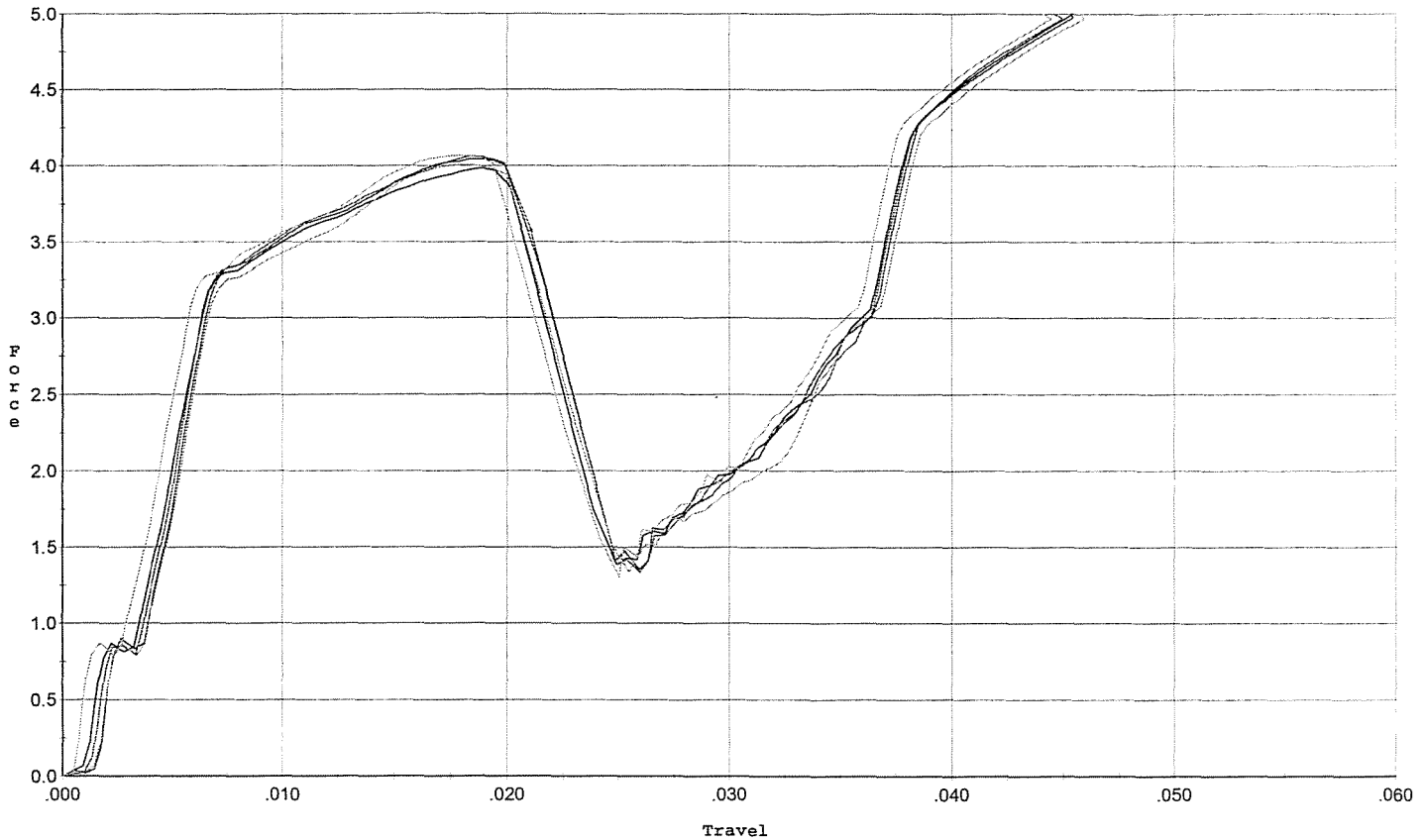
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.146	0.020	0.00	0.030	0.056		Set Trigger
2	4.117	0.020	0.00	0.030	0.054		Set Trigger
3	4.034	0.019	0.00	0.030	0.053		Set Trigger
4	4.077	0.021	0.00	0.030	0.058		Set Trigger
5	4.145	0.021	0.00	0.030	0.058		Set Trigger

A. 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



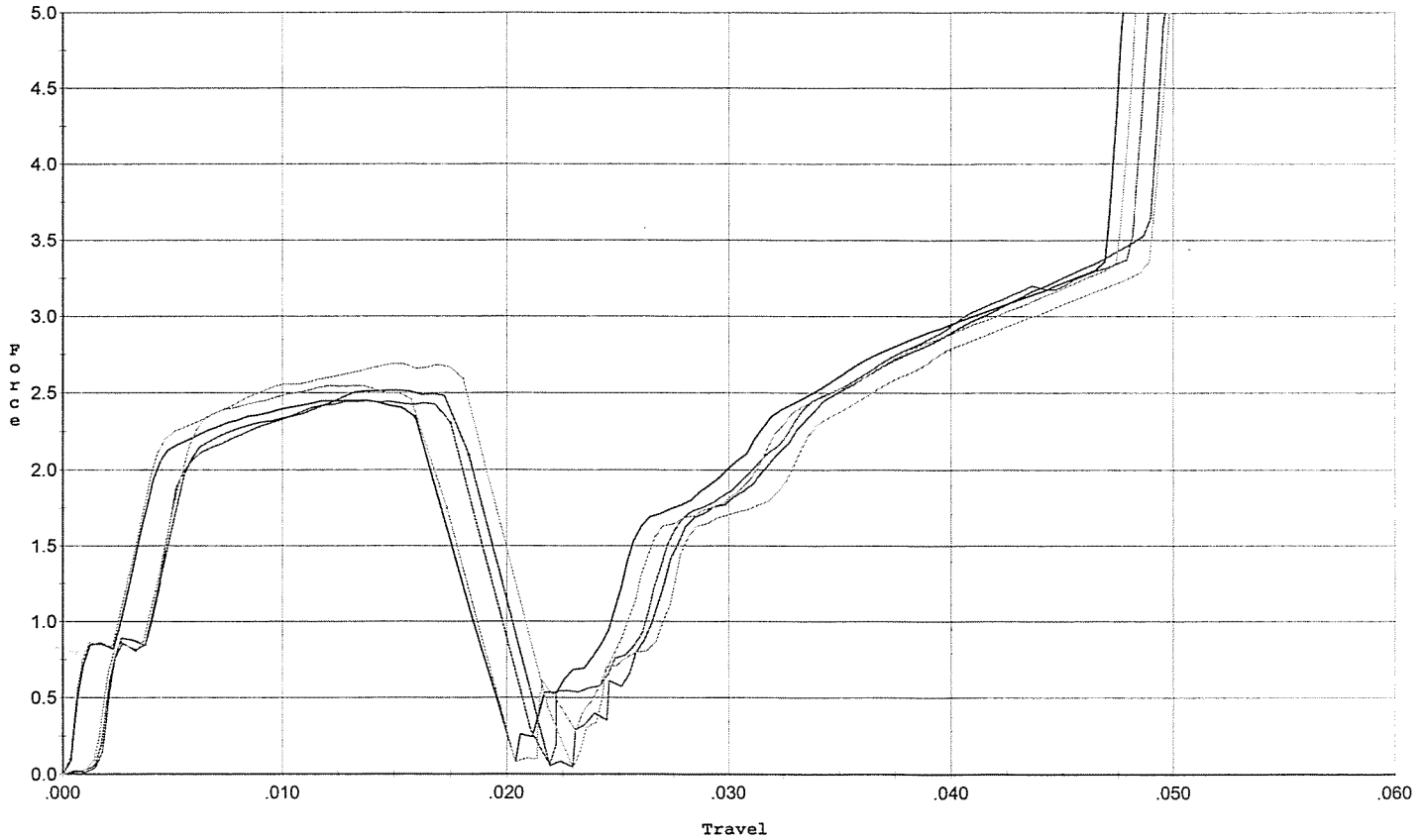
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.044	0.021	0.00	0.030	0.058		Set Trigger
2	3.982	0.020	0.00	0.030	0.055		Set Trigger
3	4.064	0.021	0.00	0.030	0.058		Set Trigger
4	4.066	0.019	0.00	0.030	0.054		Set Trigger
5	4.007	0.020	0.00	0.031	0.053		Set Trigger

A.4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



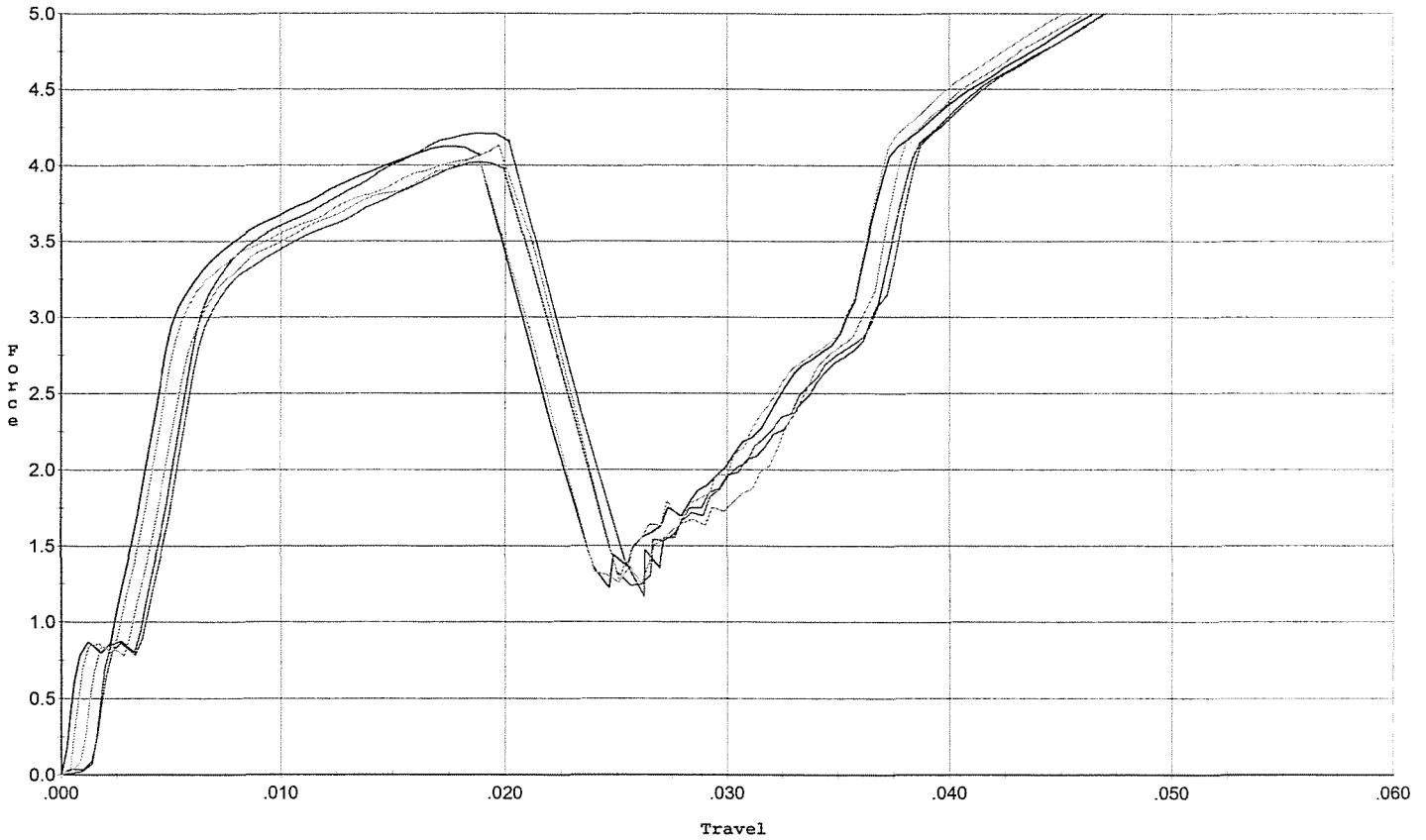
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.516	0.018	0.004	0.034	0.032		Set Trigger
2	2.450	0.016	0.00	0.034	0.030		Set Trigger
3	2.447	0.017	0.00	0.034	0.031		Set Trigger
4	2.689	0.018	0.00	0.034	0.035		Set Trigger
5	2.547	0.017	0.002	0.034	0.033		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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	4.207	0.020	0.00	0.030	0.056		Set Trigger
2	4.124	0.019	0.00	0.031	0.054		Set Trigger
3	4.021	0.022	0.00	0.030	0.059		Set Trigger
4	4.069	0.021	0.00	0.030	0.059		Set Trigger
5	4.134	0.021	0.00	0.030	0.058		Set Trigger

A-4.51