

6680 7757

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

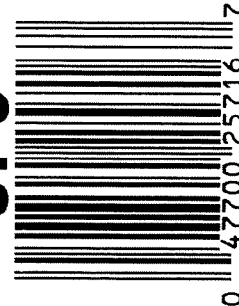
24"

CAPACITY

6

G6807757

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807757

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		2-27-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
490	MAGNAFLUX BOLT		3/5/09	RP
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	
540	APPLY COATINGS (BARREL ACTION)		3/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-12-09	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	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

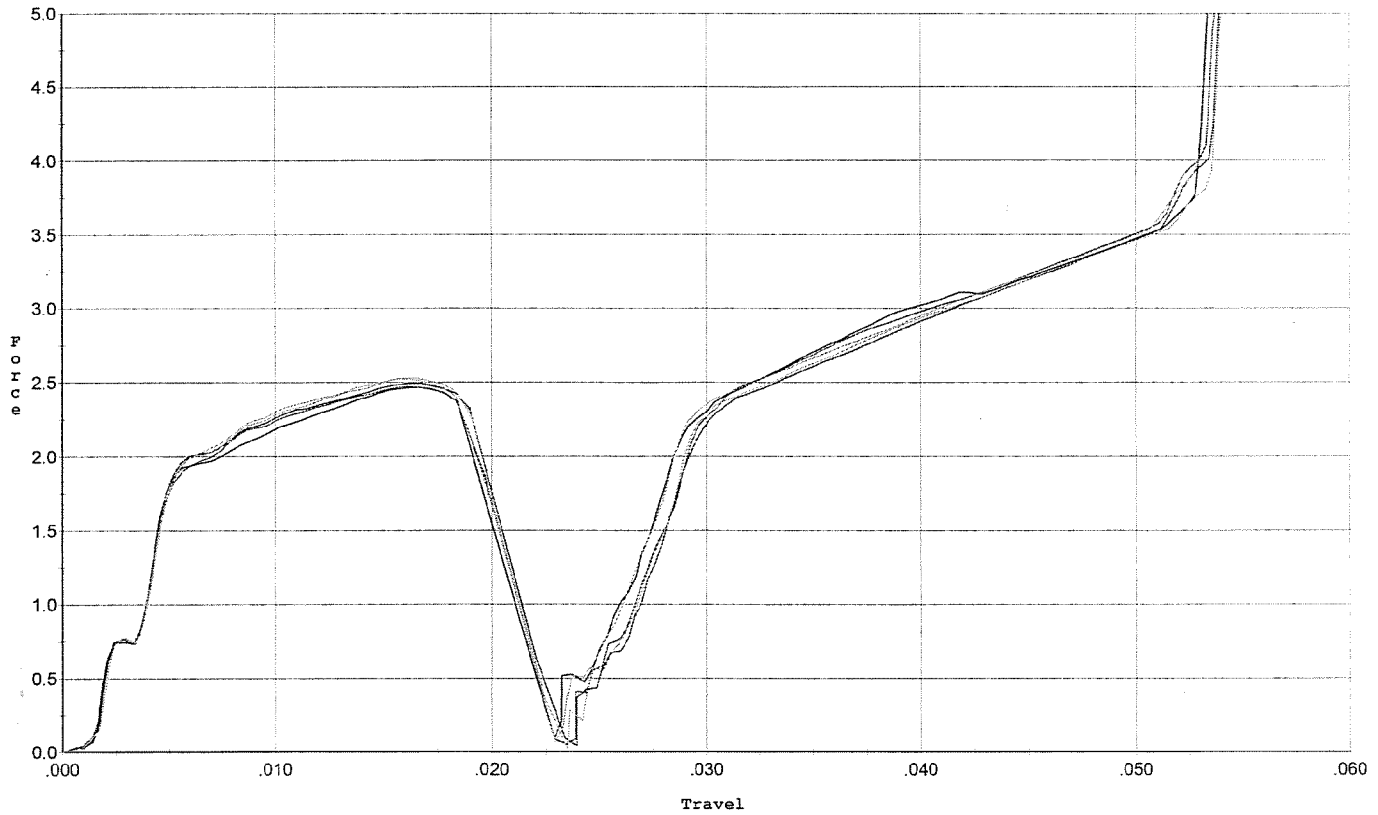
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>6.5</u>	3-20-09	WZ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-20-09	WZ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	3-20-09	WZ
	J) ASSEMBLE STOCK		3-16-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	WZ
	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	PASS FAIL PASS 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	WZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.20</u> <u>2.22</u> <u>2.21</u> <u>2.22</u>	3-20-09	TL
	C) FUNCTION		3-20-09	WZ
690	PACK		3-21-09	TL

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



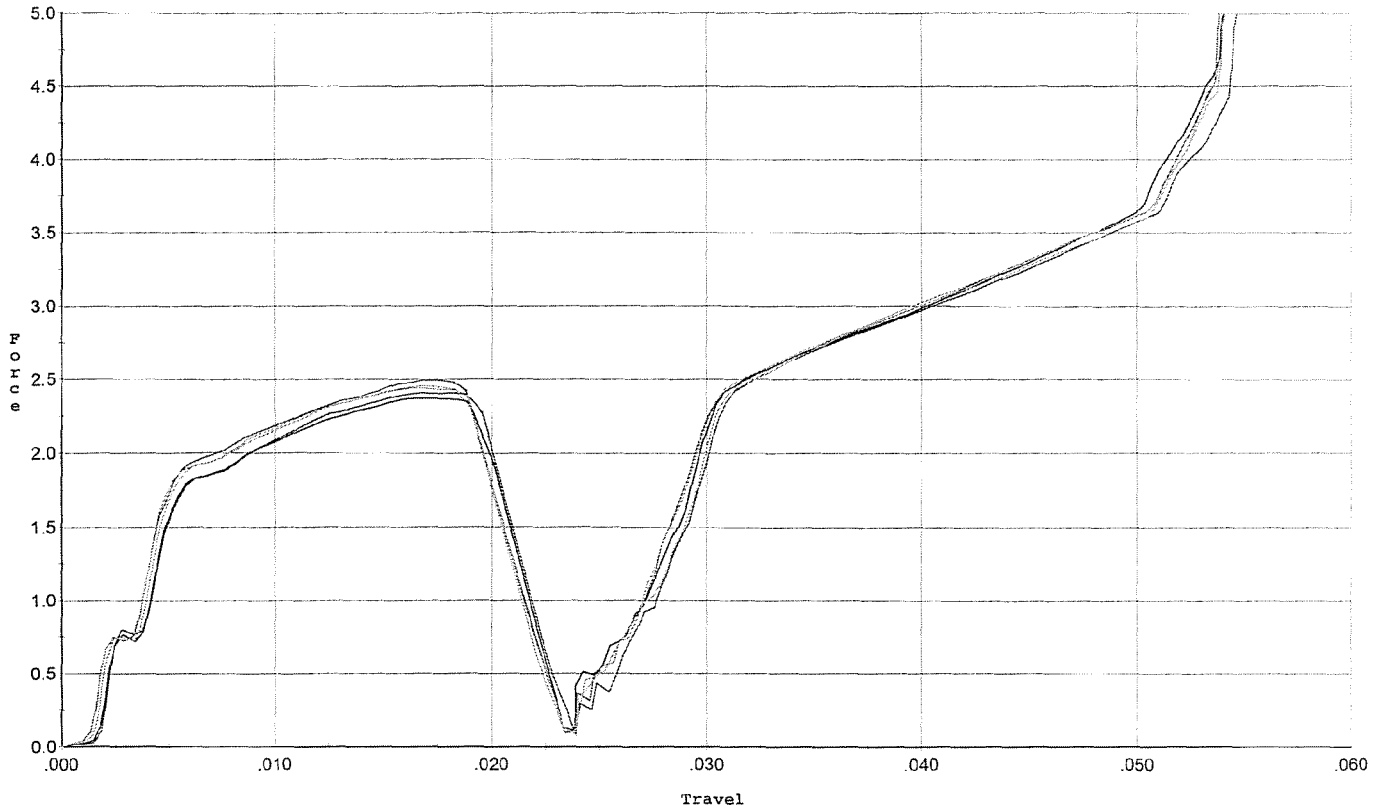
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.019	0.00	0.037	0.034		Set Trigger
2	2.466	0.018	0.00	0.037	0.032		Set Trigger
3	2.472	0.020	0.004	0.037	0.034		Set Trigger
4	2.528	0.019	0.00	0.037	0.034		Set Trigger
5	2.524	0.020	0.00	0.036	0.035		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 20 cycles+/- .50 lb



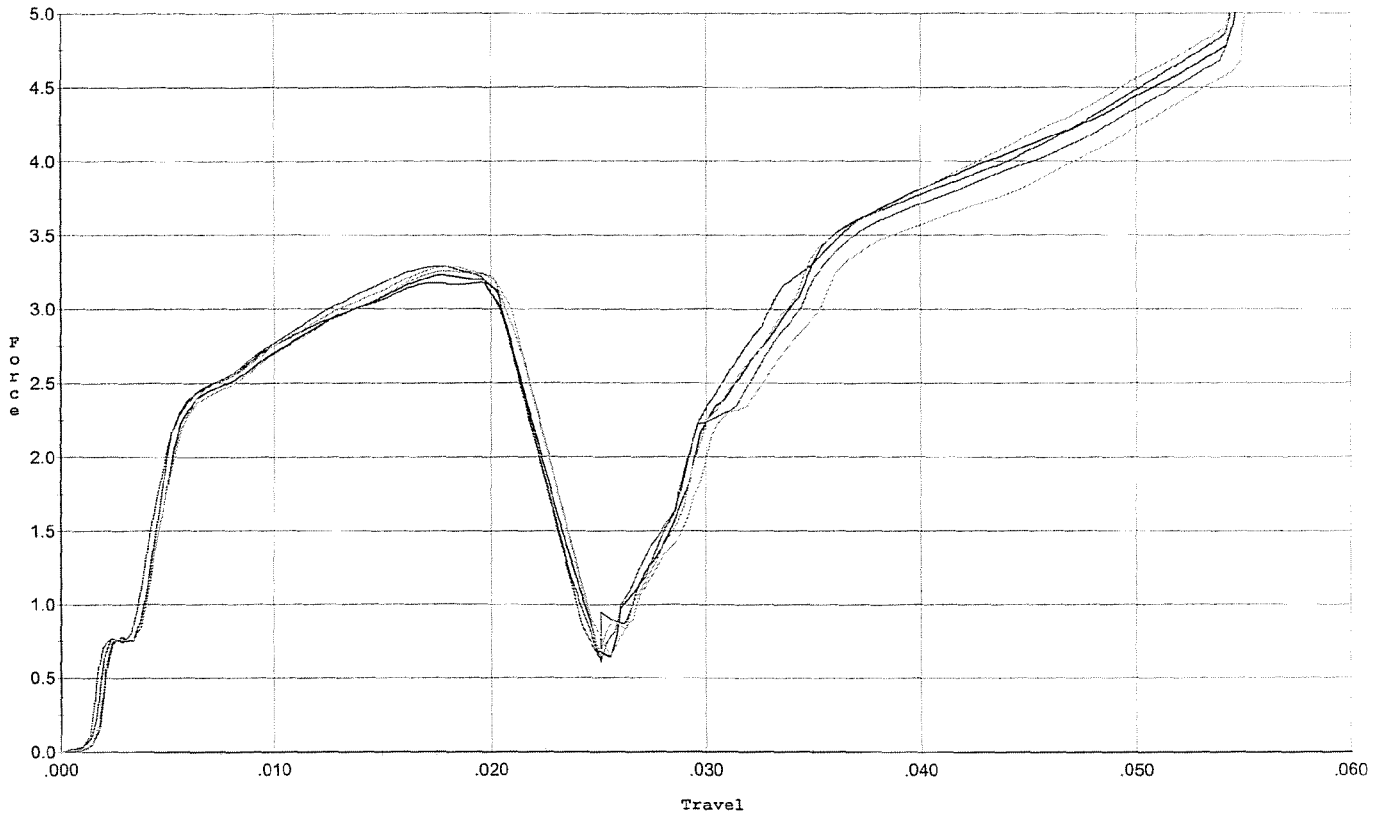
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.405	0.020	0.00	0.037	0.033		Set Trigger
2	2.370	0.020	0.00	0.037	0.033		Set Trigger
3	2.490	0.019	0.00	0.037	0.033		Set Trigger
4	2.455	0.019	0.00	0.037	0.033		Set Trigger
5	2.438	0.019	0.00	0.037	0.033		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: 3.0 lbs ini +/- .75 lb



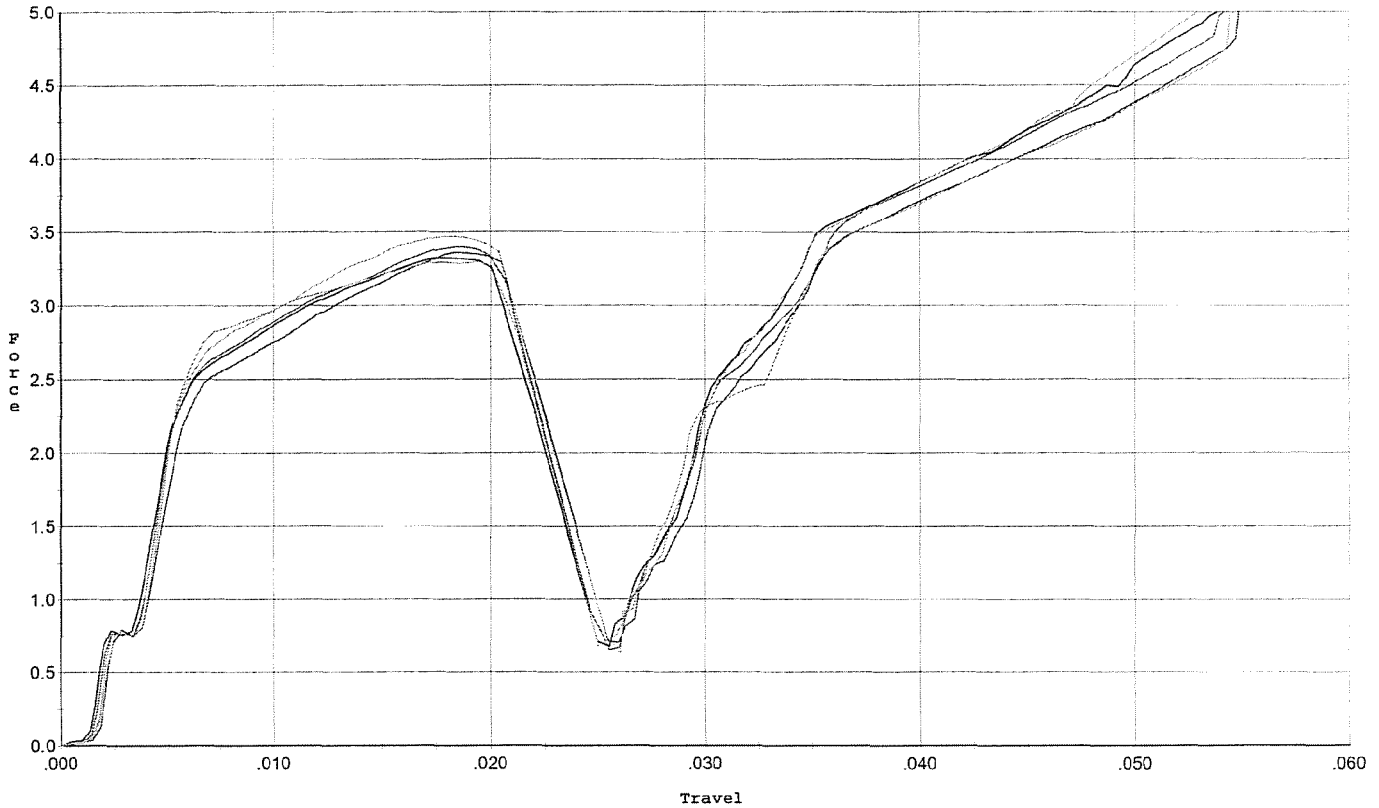
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.182	0.020	0.004	0.034	0.045		Set Trigger
2	3.231	0.020	0.00	0.035	0.044		Set Trigger
3	3.288	0.020	0.00	0.034	0.046		Set Trigger
4	3.288	0.021	0.00	0.035	0.047		Set Trigger
5	3.261	0.021	0.00	0.034	0.047		Set Trigger

1A-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



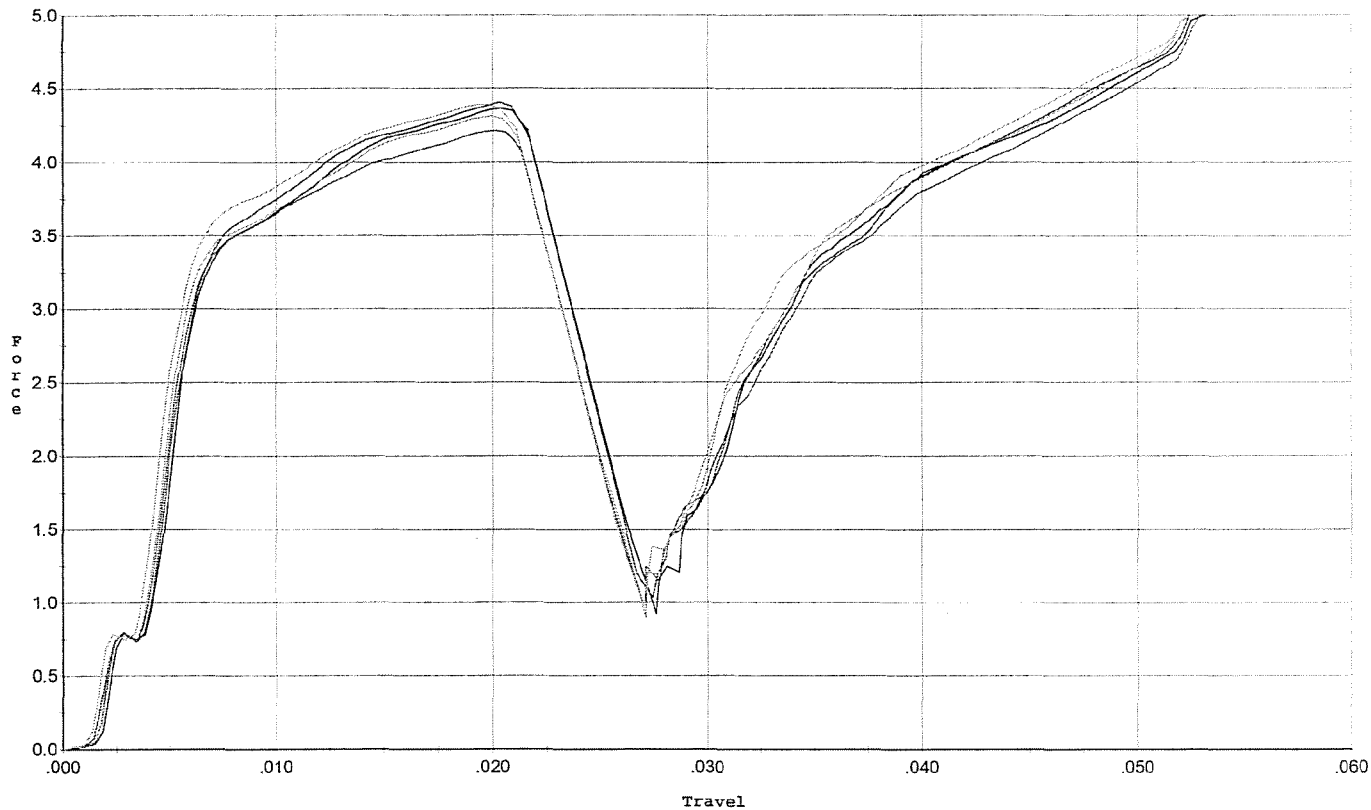
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.360	0.023	0.00	0.034	0.051		Set Trigger
2	3.323	0.022	0.00	0.033	0.051		Set Trigger
3	3.397	0.021	0.004	0.034	0.048		Set Trigger
4	3.468	0.020	0.00	0.033	0.048		Set Trigger
5	3.296	0.021	0.00	0.034	0.049		Set Trigger

A 3.36

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



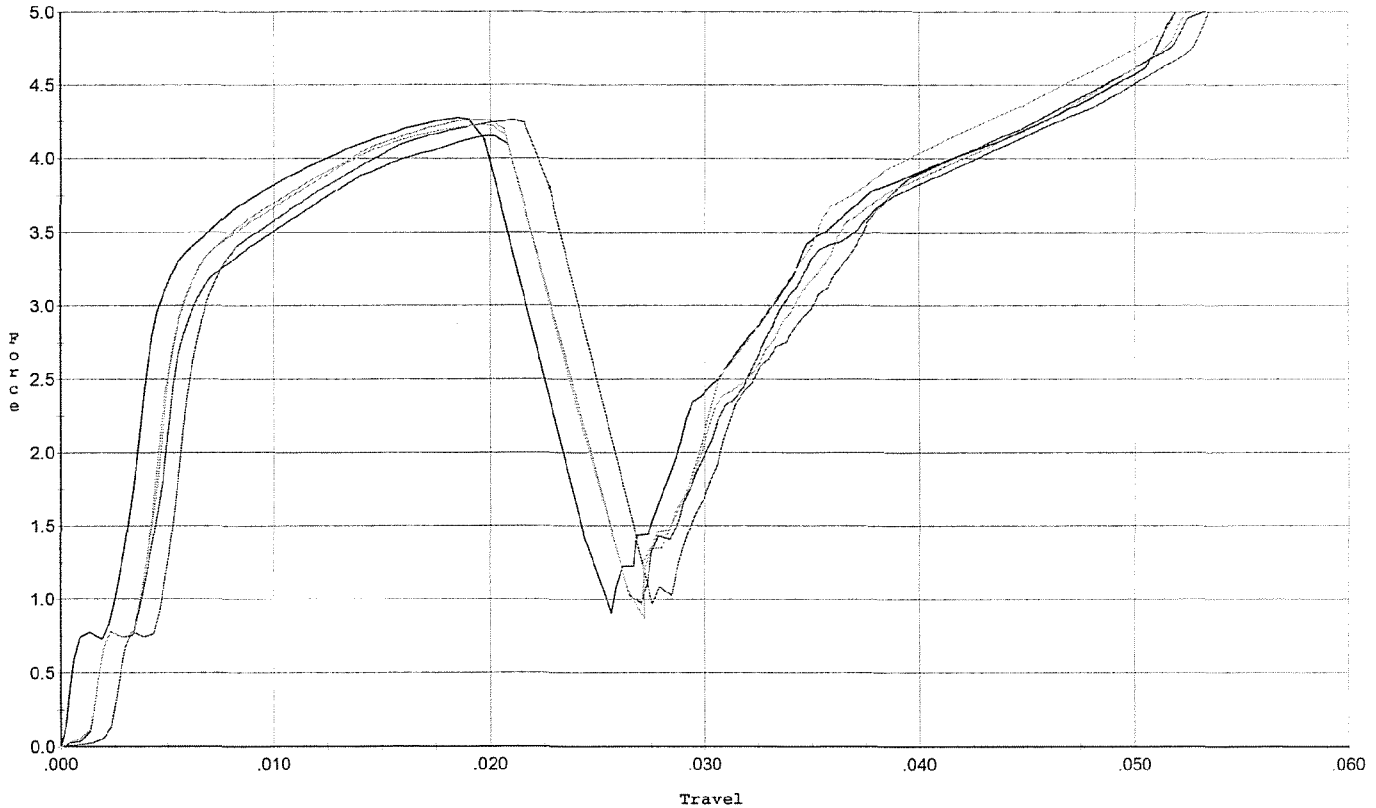
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.407	0.022	0.00	0.032	0.064		Set Trigger
2	4.365	0.022	0.00	0.032	0.063		Set Trigger
3	4.215	0.021	0.00	0.033	0.061		Set Trigger
4	4.389	0.021	0.00	0.033	0.063		Set Trigger
5	4.312	0.021	0.00	0.032	0.062		Set Trigger

A-4.33

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



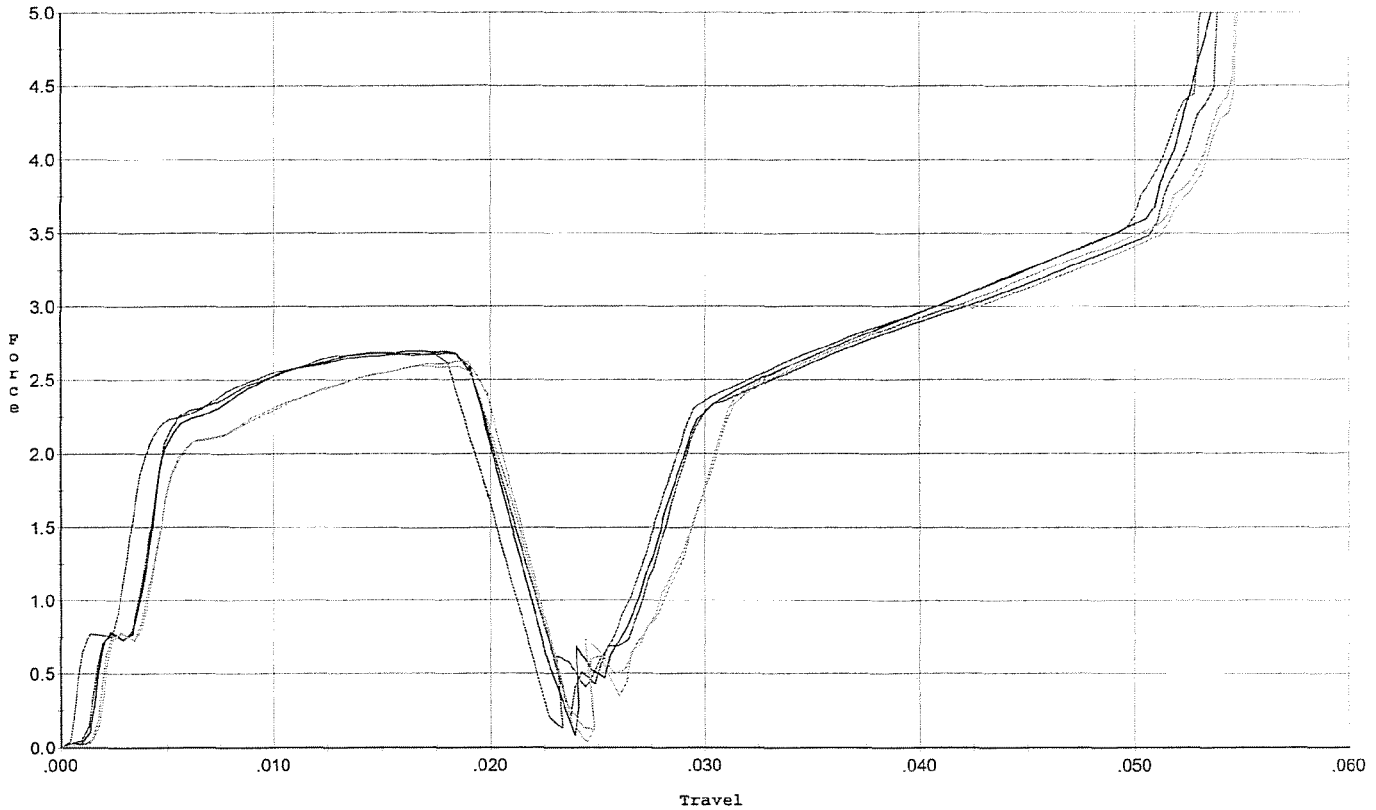
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.151	0.023	0.00	0.033	0.065		Set Trigger
2	4.275	0.020	0.00	0.033	0.060		Set Trigger
3	4.263	0.023	0.00	0.033	0.064		Set Trigger
4	4.227	0.021	0.00	0.033	0.060		Set Trigger
5	4.259	0.023	0.00	0.033	0.068		Set Trigger

A-4-23

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



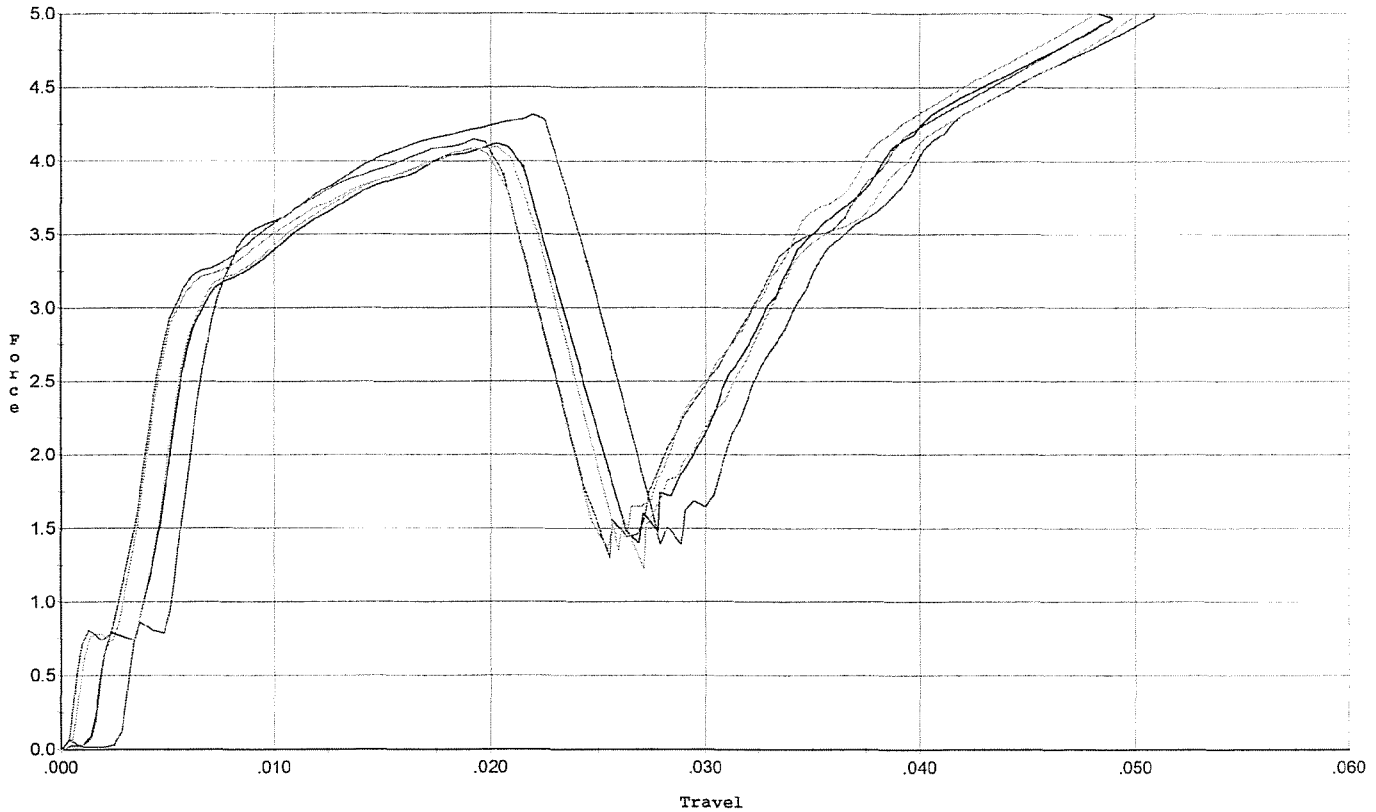
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.682	0.019	0.00	0.036	0.038		Set Trigger
2	2.693	0.019	0.00	0.036	0.038		Set Trigger
3	2.686	0.020	0.003	0.036	0.040		Set Trigger
4	2.592	0.021	0.00	0.037	0.038		Set Trigger
5	2.626	0.020	0.00	0.037	0.037		Set Trigger

A-2-65

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	4.315	0.024	0.003	0.033	0.069		Set Trigger
2	4.121	0.021	0.004	0.033	0.059		Set Trigger
3	4.151	0.021	0.00	0.032	0.060		Set Trigger
4	4.097	0.022	0.004	0.033	0.061		Set Trigger
5	4.091	0.021	0.00	0.032	0.059		Set Trigger

A.4.15