

6680 7769

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



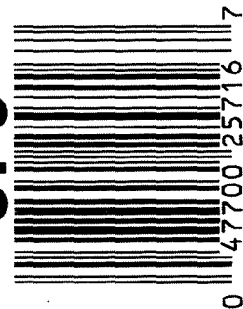
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

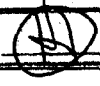
G6807769

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 680 7769

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
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	RT
475	DRILL AND TAP SIGHT HOLES	MAR 10 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3-13-09	MR
490	MAGNAFLUX BOLT		3-13-09	RT
500	ROLLMARK CALIBER		3-16	BH
520	GOFF BLAST BBL / REC		3-16	BH
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			

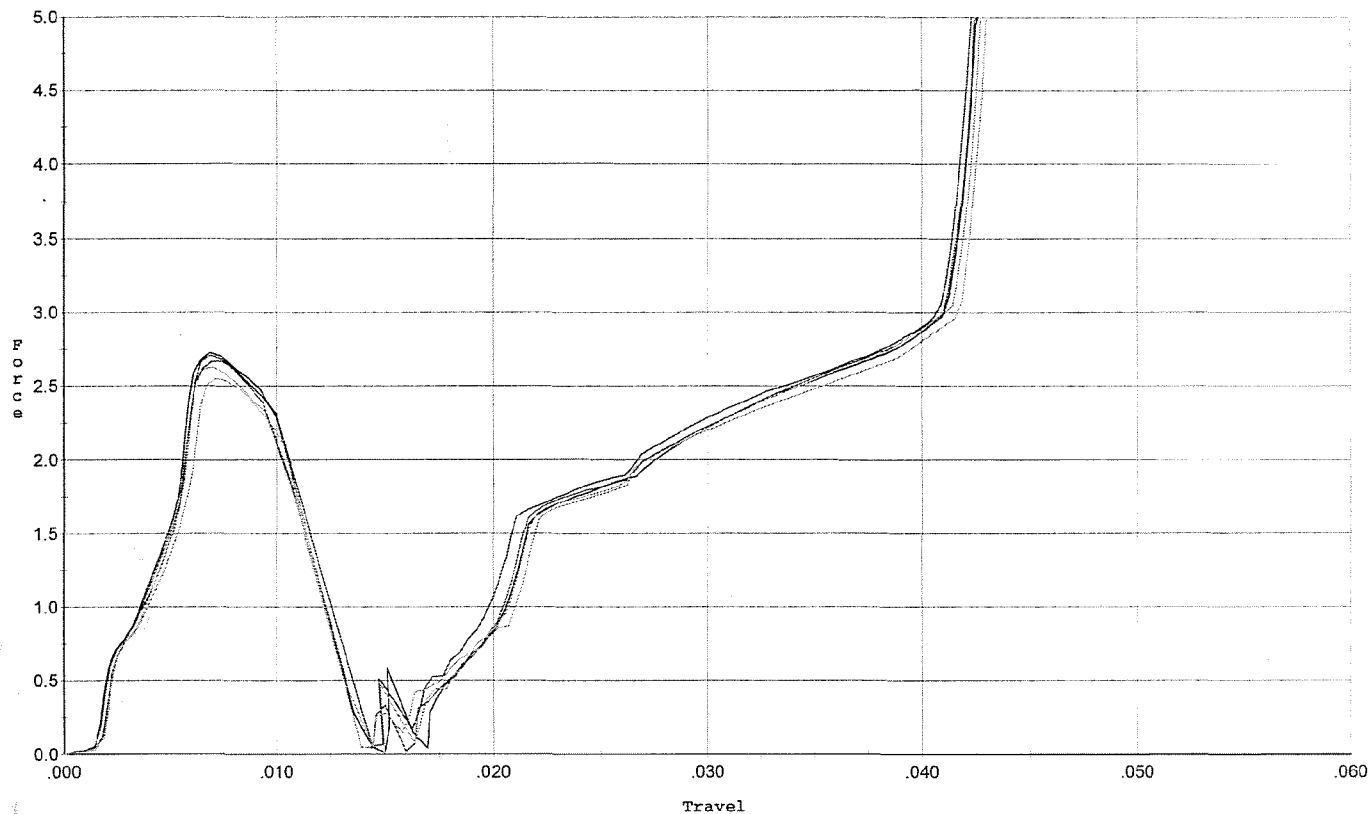
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	3-28-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>5.0</u> <u>50</u>	3-28-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-28-09	LN
	J) ASSEMBLE STOCK		3-25-09	LN
	K) ASSEMBLE SWIVEL STUDS		3-28-09	LN
	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> <u>PASS</u> FAIL FAIL	3-26-09	LN
	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	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.47</u> <u>2.47</u> <u>2.43</u> <u>2.52</u>	3-26-09	TL
	C) FUNCTION		3-28-09	LN
690	PACK		3/31/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



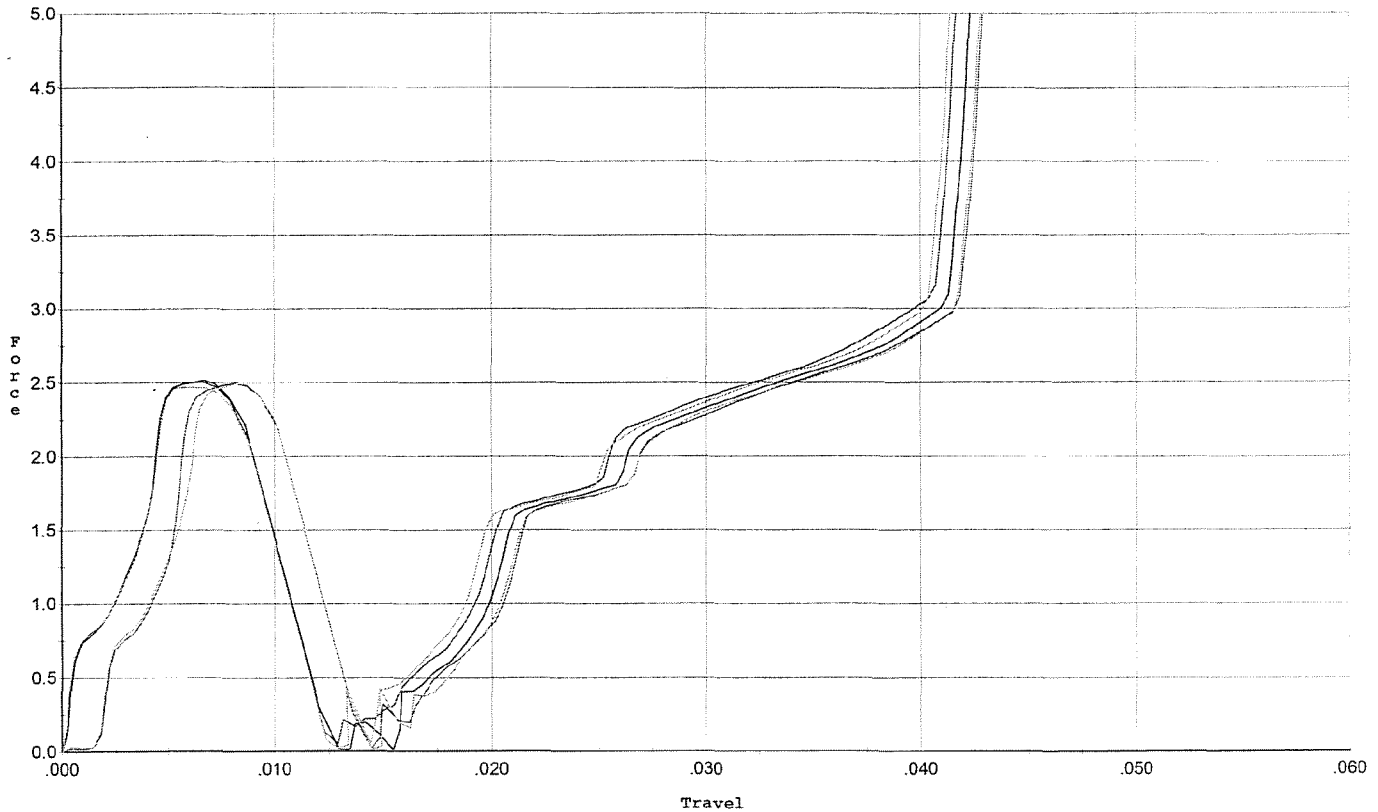
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.667	0.010	0.00	0.035	0.014		Set Trigger
2	2.729	0.010	0.00	0.035	0.015		Set Trigger
3	2.714	0.011	0.00	0.035	0.016		Set Trigger
4	2.626	0.011	0.00	0.035	0.015		Set Trigger
5	2.549	0.010	0.00	0.036	0.014		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



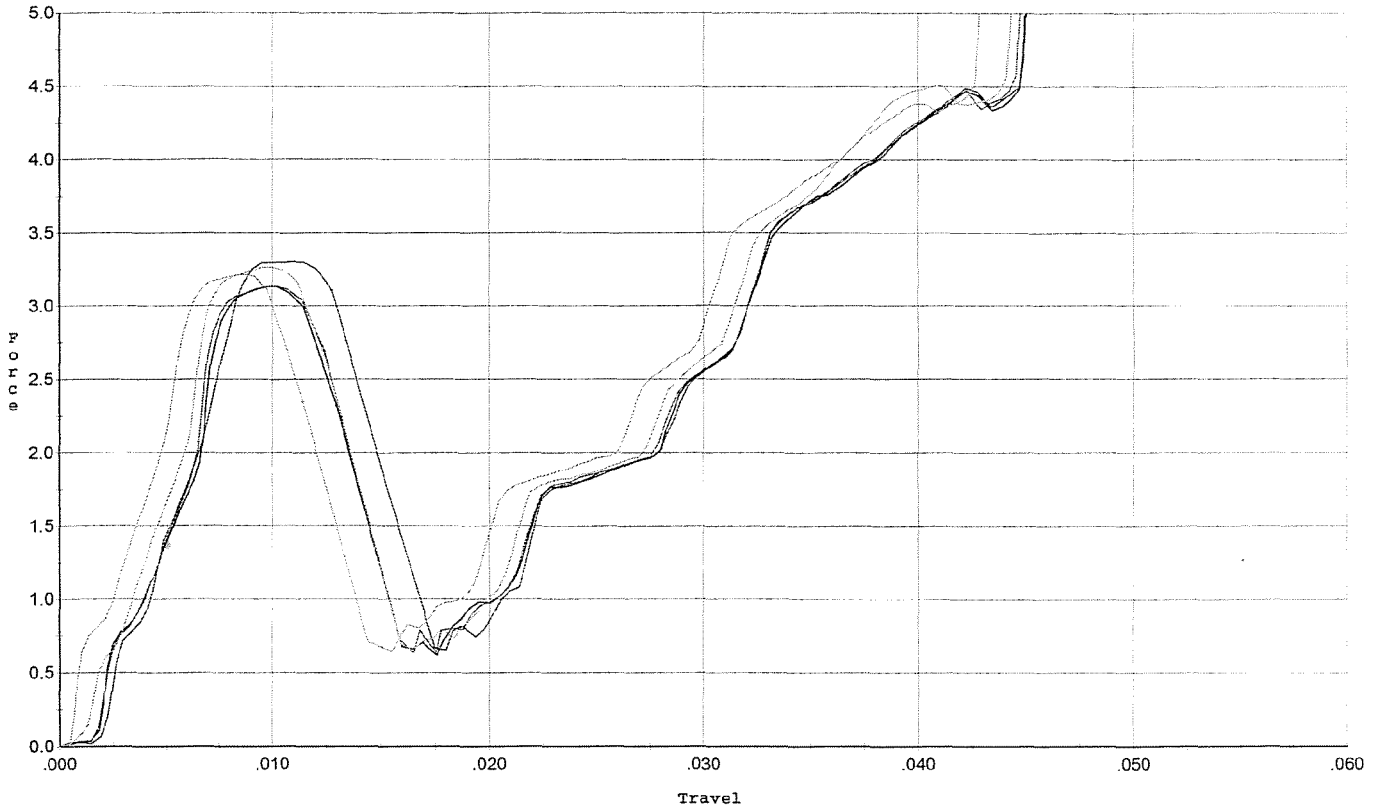
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.501	0.009	0.00	0.035	0.014		Set Trigger
2	2.514	0.009	0.00	0.036	0.014		Set Trigger
3	2.494	0.010	0.00	0.035	0.014		Set Trigger
4	2.469	0.009	0.00	0.035	0.014		Set Trigger
5	2.491	0.010	0.00	0.035	0.014		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



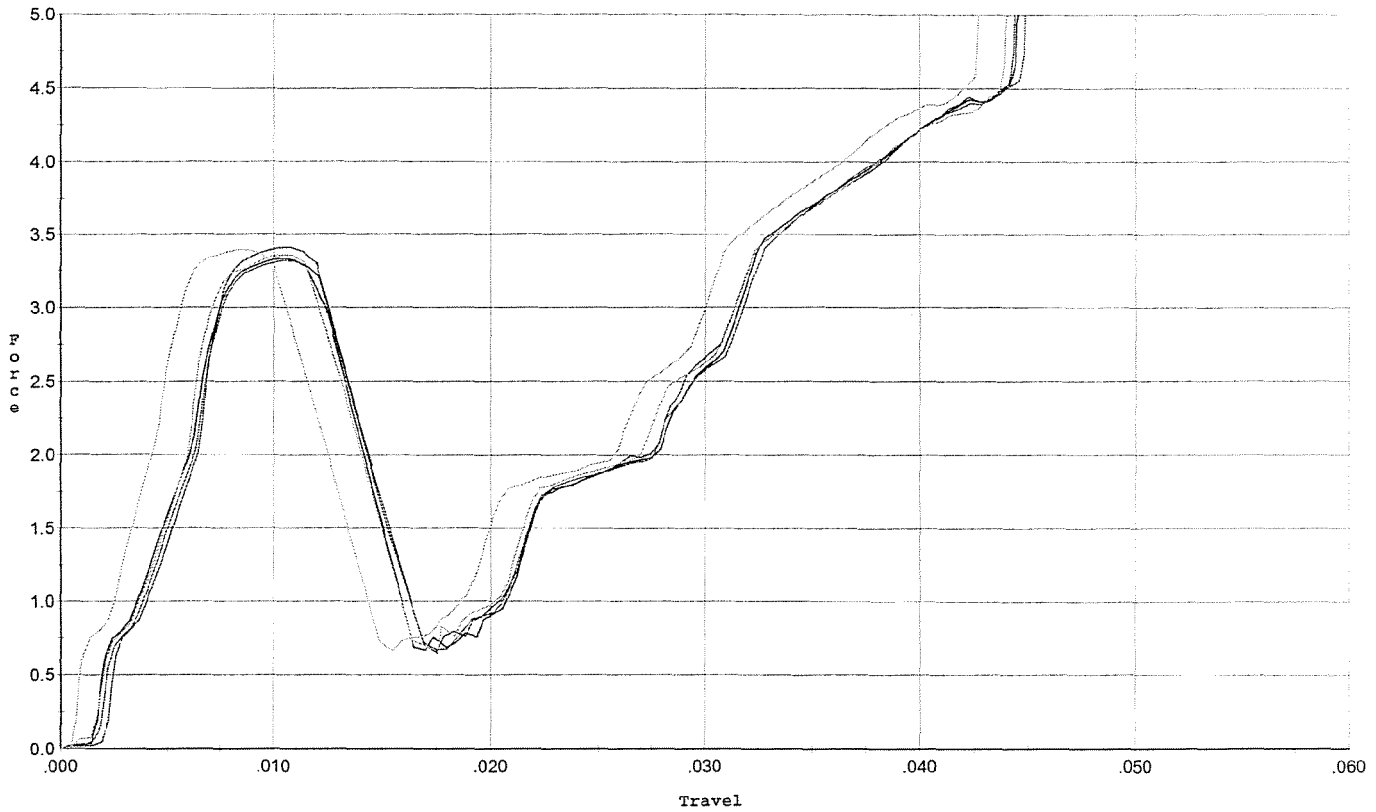
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.304	0.013	0.002	0.032	0.023		Set Trigger
2	3.131	0.013	0.00	0.033	0.022		Set Trigger
3	3.133	0.012	0.00	0.033	0.022		Set Trigger
4	3.266	0.013	0.00	0.032	0.024		Set Trigger
5	3.217	0.011	0.00	0.032	0.022		Set Trigger

A-3.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



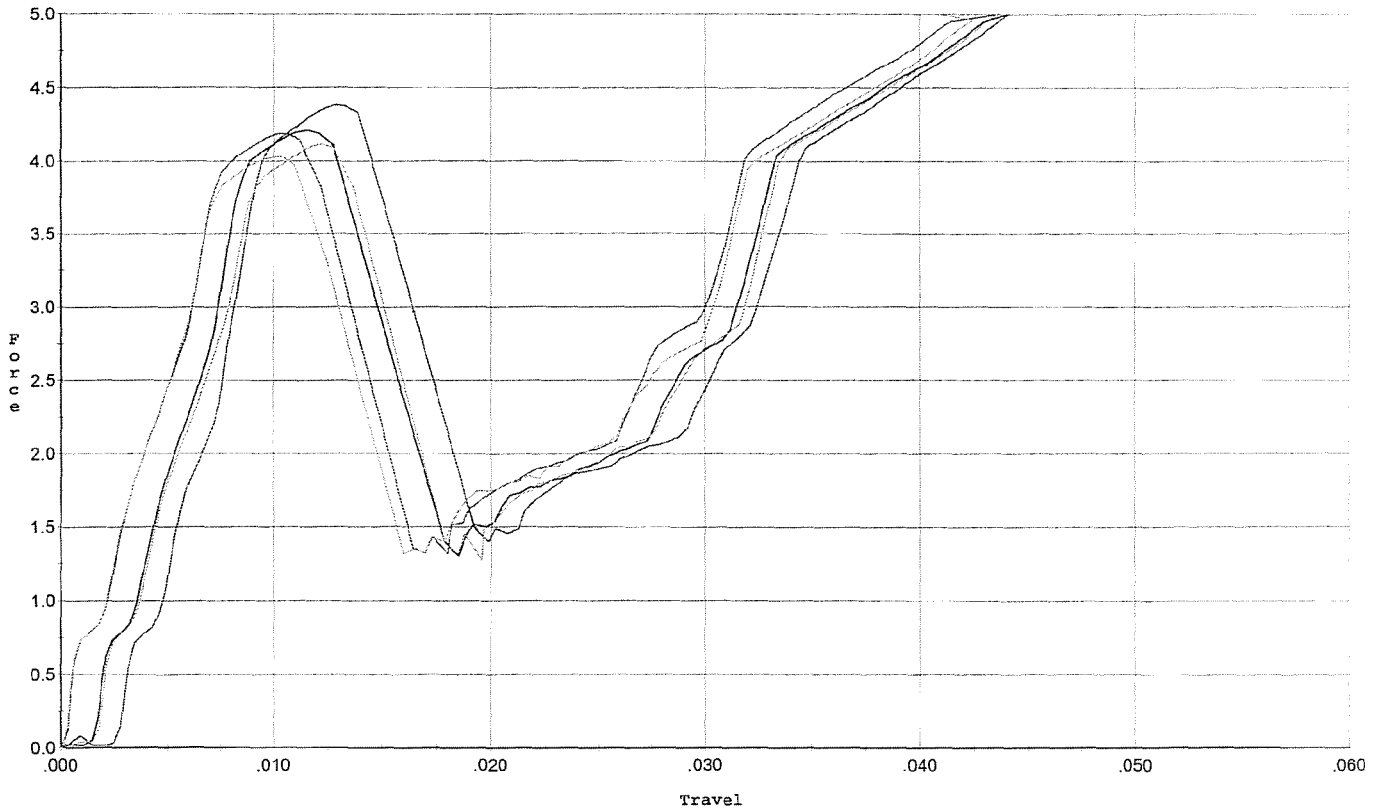
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.409	0.012	0.002	0.032	0.022		Set Trigger
2	3.332	0.012	0.00	0.032	0.024		Set Trigger
3	3.317	0.012	0.002	0.032	0.023		Set Trigger
4	3.394	0.012	0.00	0.032	0.025		Set Trigger
5	3.359	0.013	0.00	0.032	0.026		Set Trigger

A-3.36

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



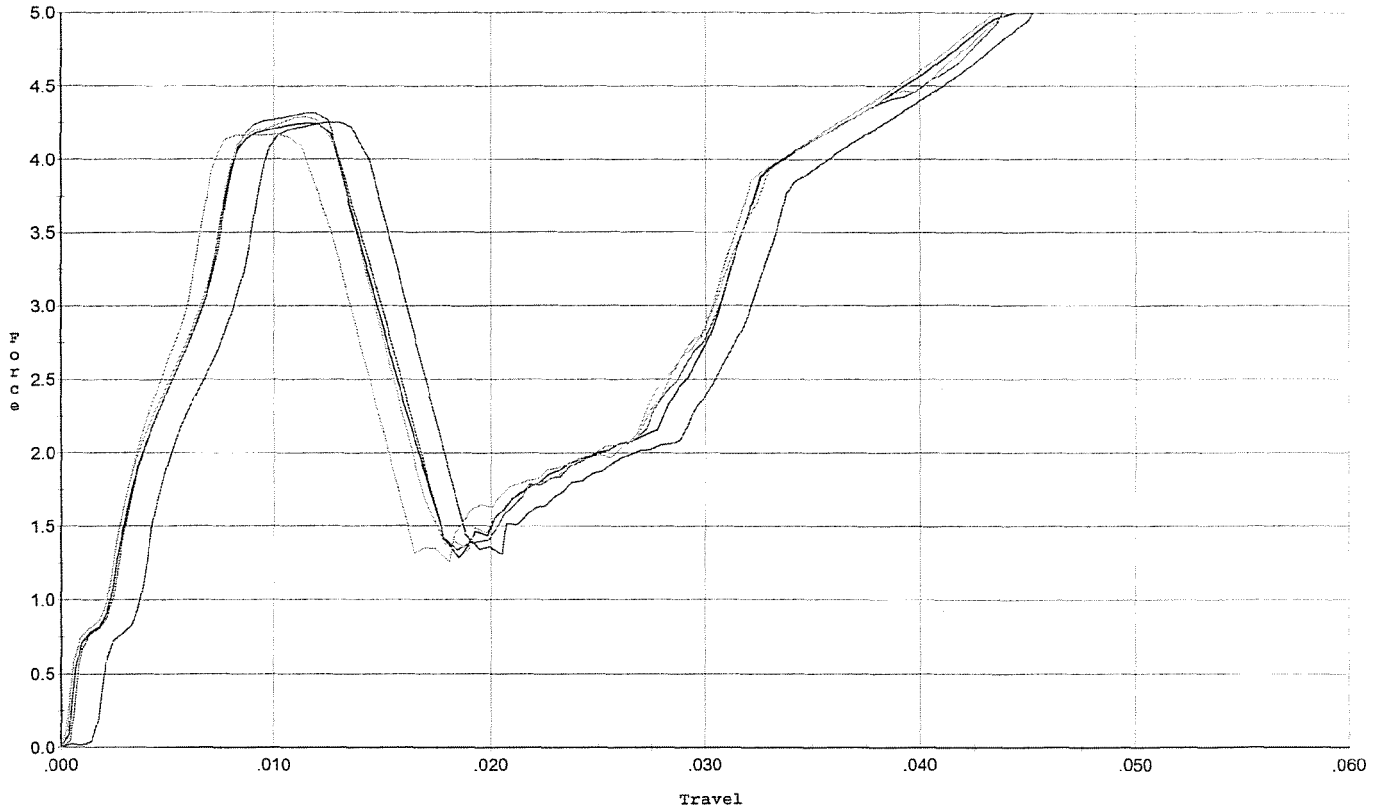
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.384	0.016	0.003	0.030	0.038		Set Trigger
2	4.210	0.013	0.00	0.031	0.030		Set Trigger
3	4.188	0.012	0.00	0.030	0.031		Set Trigger
4	4.031	0.012	0.00	0.031	0.030		Set Trigger
5	4.117	0.014	0.00	0.031	0.031		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



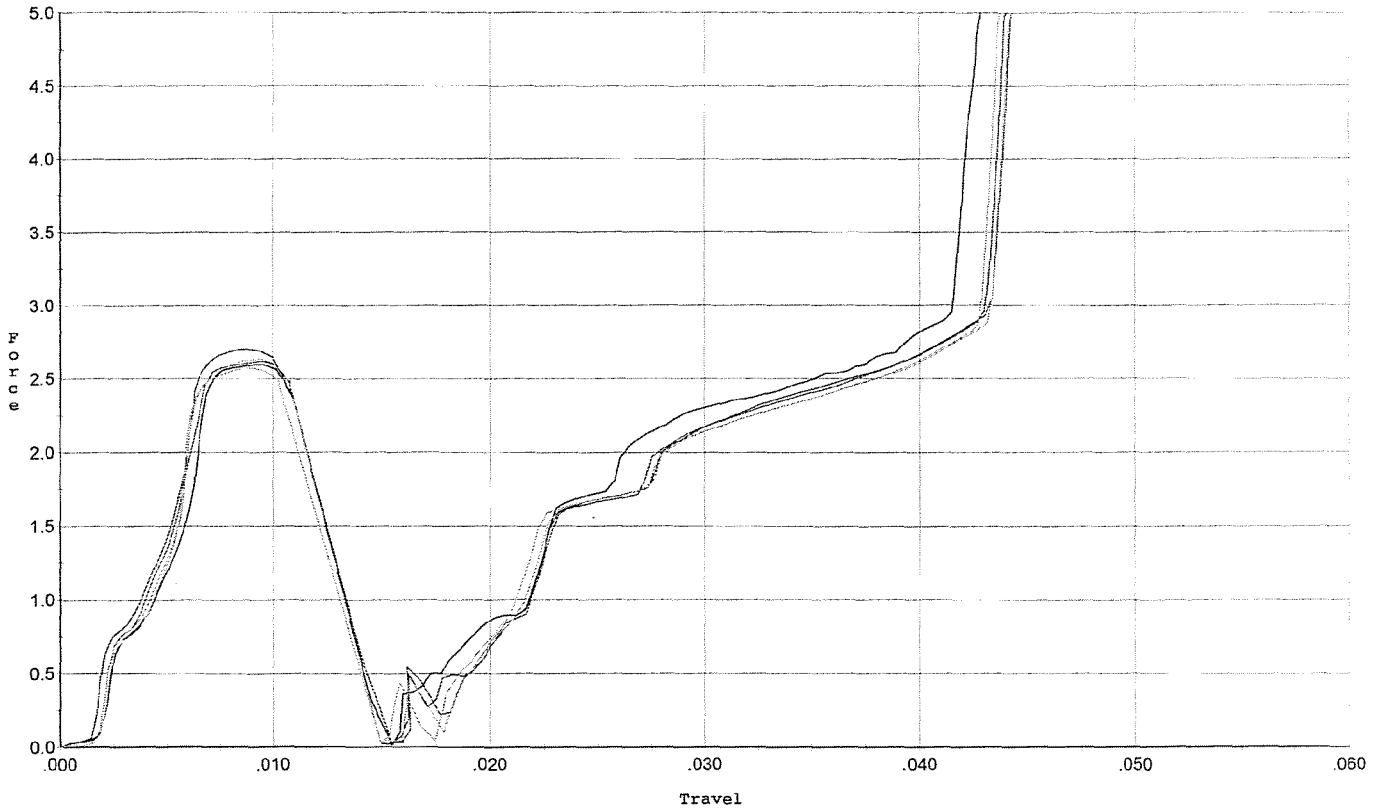
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.252	0.014	0.00	0.031	0.035		Set Trigger
2	4.246	0.013	0.00	0.030	0.033		Set Trigger
3	4.318	0.015	0.00	0.030	0.039		Set Trigger
4	4.288	0.013	0.00	0.030	0.033		Set Trigger
5	4.170	0.013	0.00	0.030	0.033		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



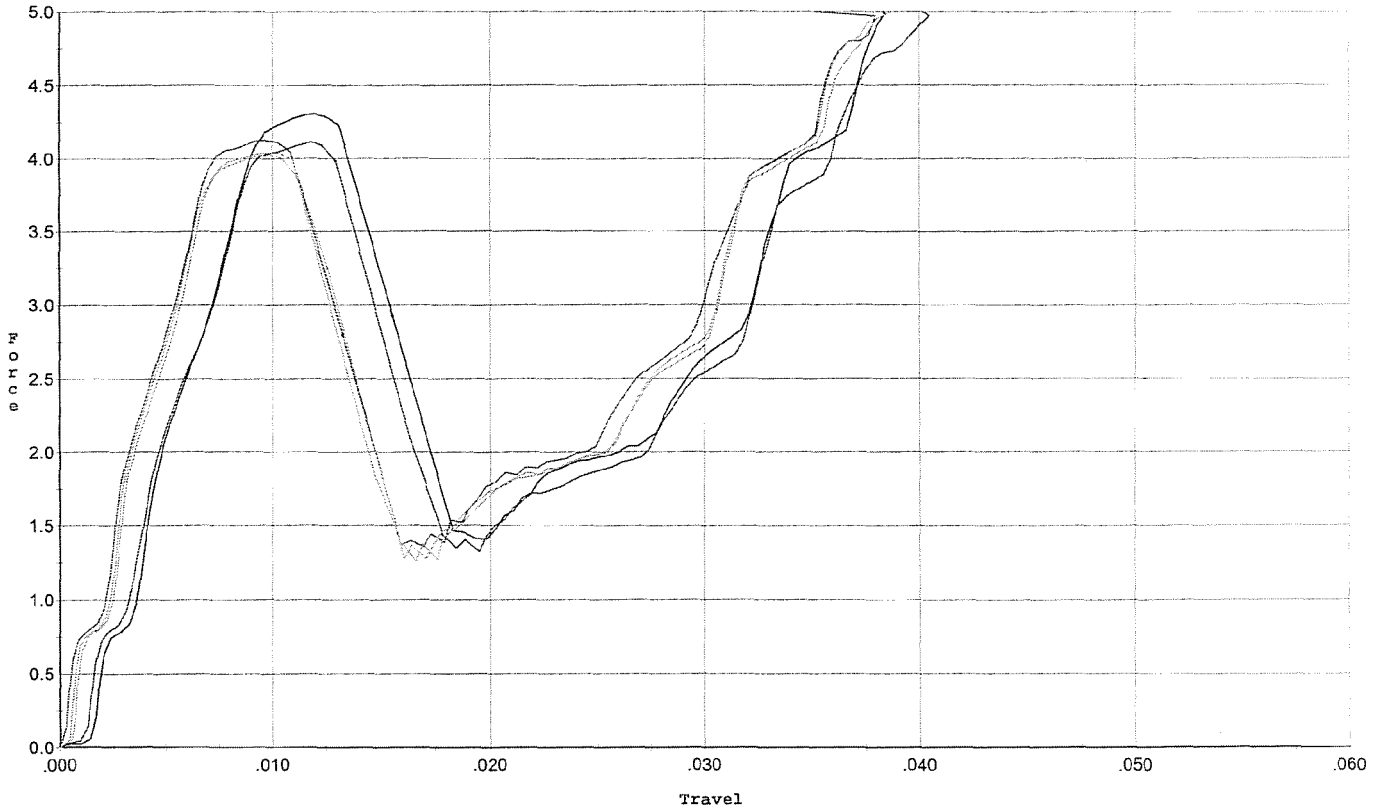
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.701	0.011	0.00	0.035	0.017		Set Trigger
2	2.599	0.011	0.00	0.035	0.015		Set Trigger
3	2.621	0.011	0.00	0.036	0.016		Set Trigger
4	2.634	0.011	0.00	0.036	0.016		Set Trigger
5	2.574	0.013	0.00	0.035	0.018		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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	4.112	0.013	0.00	0.031	0.031		Set Trigger
2	4.307	0.016	0.00	0.030	0.038		Set Trigger
3	4.126	0.013	0.00	0.030	0.034		Set Trigger
4	4.026	0.011	0.00	0.031	0.028		Set Trigger
5	4.039	0.013	0.00	0.031	0.031		Set Trigger

A-4.12