

66807771

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



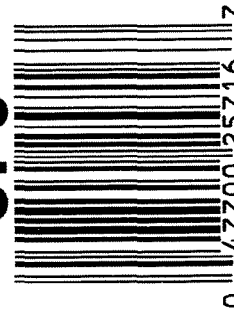
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807771

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807771

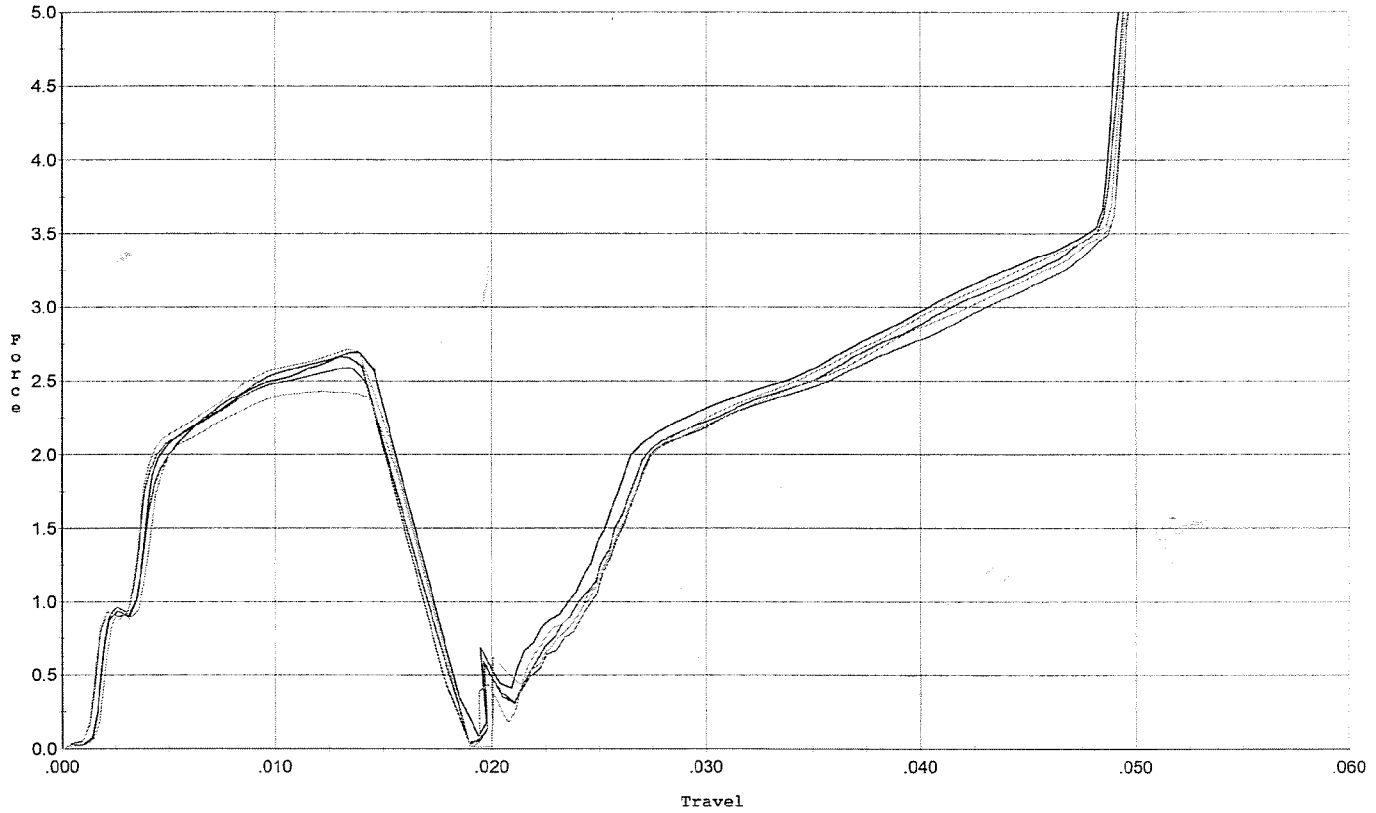
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SP
460	CHECK HEADSPACE	MAGNA-FLUX	2-27-09	SP
470	DIS-ASSEMBLE ACTION		2-27-09	SP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	3/5/09	(D)
490	MAGNAFLUX BOLT		3/5/09	mk
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	non
540	APPLY COATINGS (BARREL ACTION)		3/9	
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		3-13-09	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>4</u> <u>4</u> <u>4.5</u>	3-20-09	NW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	3-20-09	NW
	J) ASSEMBLE STOCK		3-13-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	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	3-19-09	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	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.74</u> <u>2.71</u> <u>2.71</u> <u>2.71</u>	3-20-09	TL
	C) FUNCTION		3-20-09	NW
690	PACK		3-21-09	TL

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



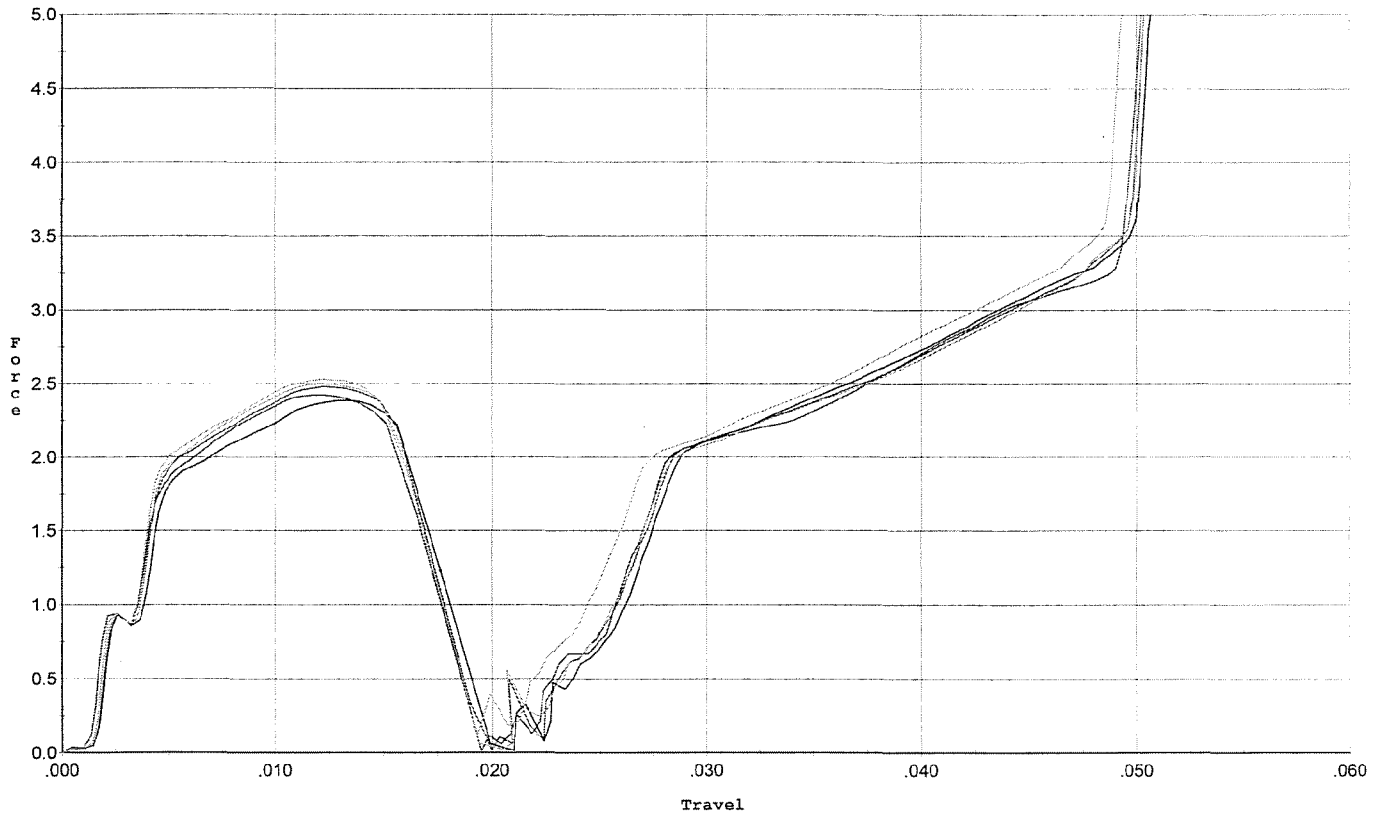
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.663	0.014	0.00	0.037	0.025		Set Trigger
2	2.696	0.015	0.00	0.036	0.026		Set Trigger
3	2.585	0.014	0.00	0.038	0.025		Set Trigger
4	2.715	0.015	0.00	0.037	0.028		Set Trigger
5	2.429	0.016	0.00	0.037	0.026		Set Trigger

A-2-61

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



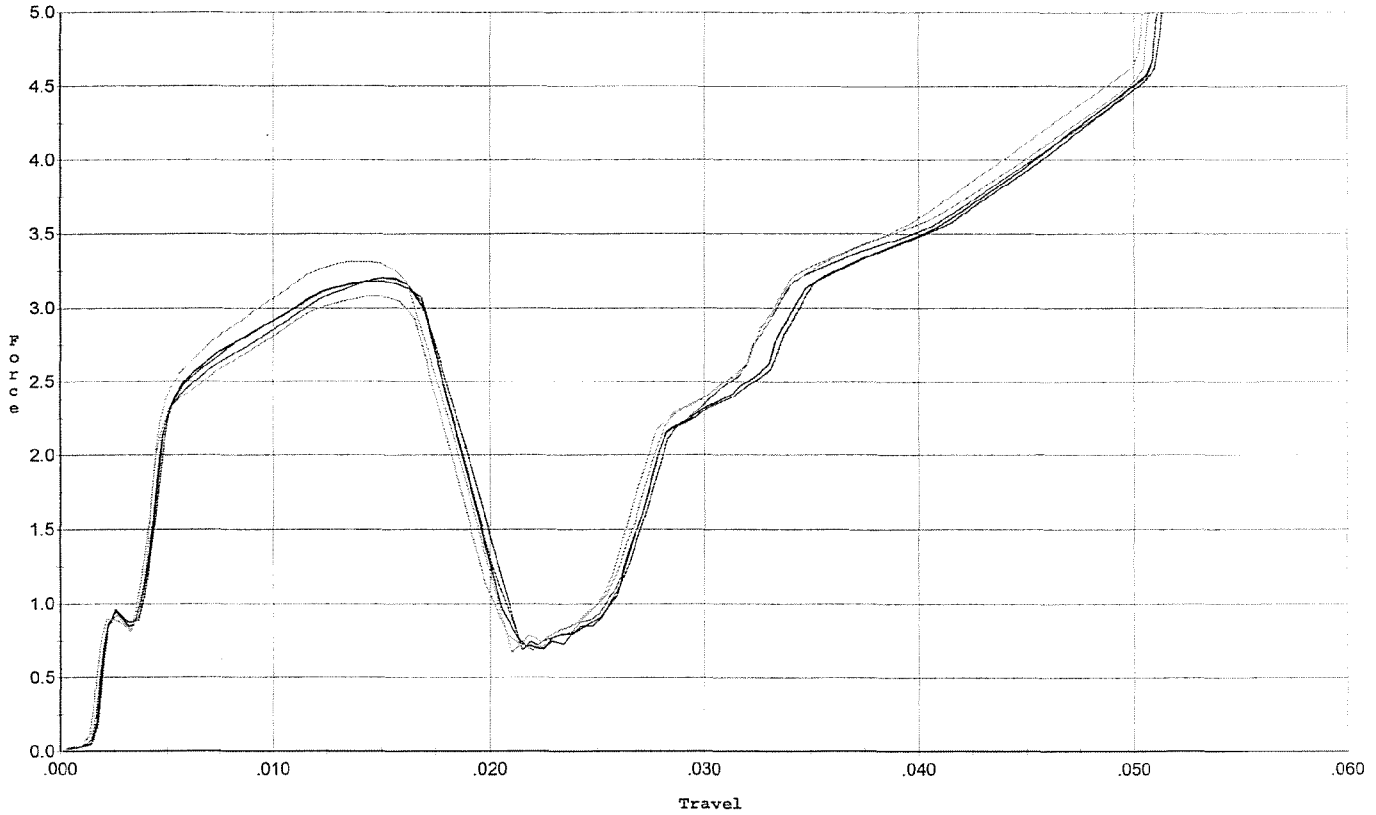
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.423	0.017	0.00	0.037	0.028		Set Trigger
2	2.385	0.018	0.00	0.037	0.029		Set Trigger
3	2.482	0.016	0.00	0.037	0.027		Set Trigger
4	2.528	0.016	0.00	0.036	0.028		Set Trigger
5	2.502	0.016	0.00	0.037	0.027		Set Trigger

A-2-46

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



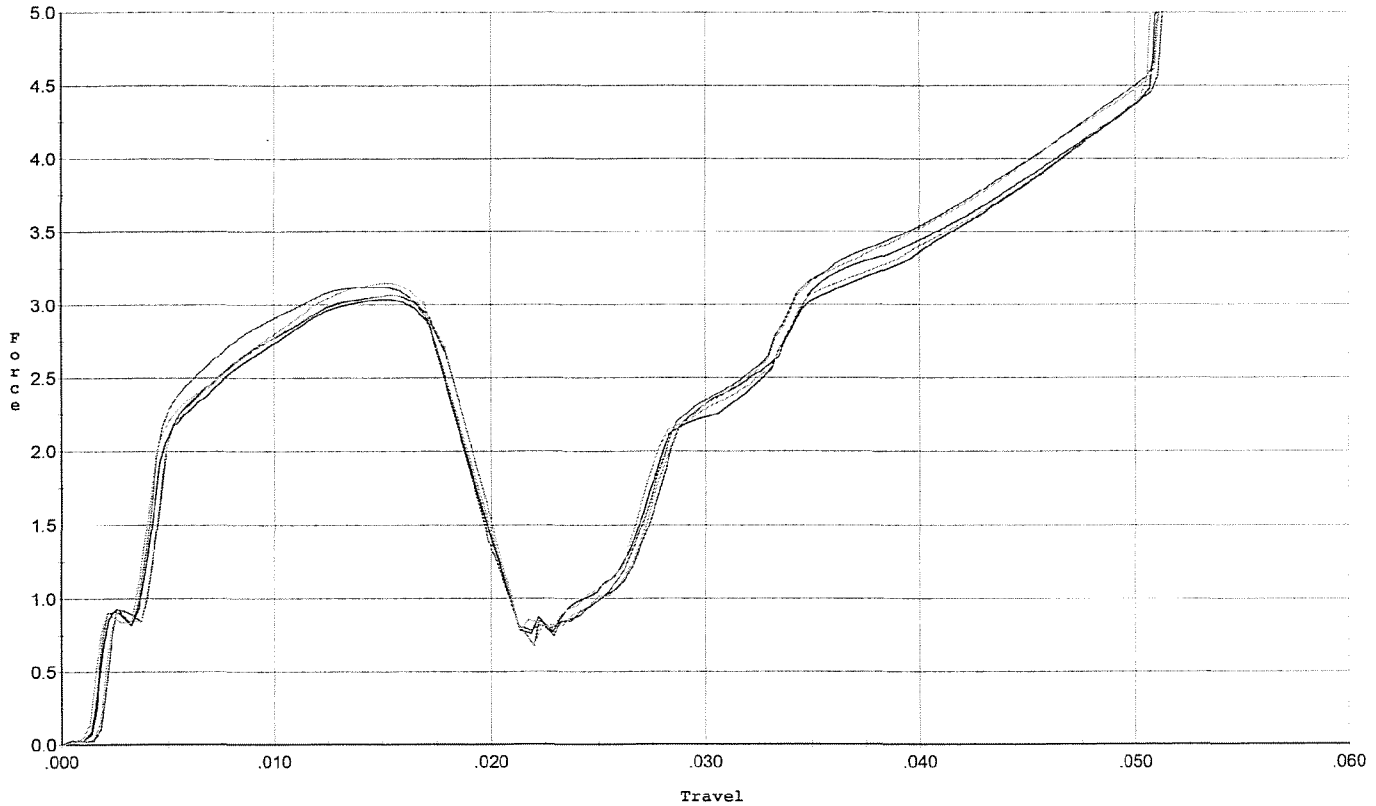
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.182	0.019	0.00	0.034	0.040		Set Trigger
2	3.205	0.017	0.00	0.035	0.037		Set Trigger
3	3.203	0.017	0.00	0.035	0.036		Set Trigger
4	3.313	0.018	0.00	0.034	0.040		Set Trigger
5	3.083	0.017	0.004	0.035	0.035		Set Trigger

A-3-19

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



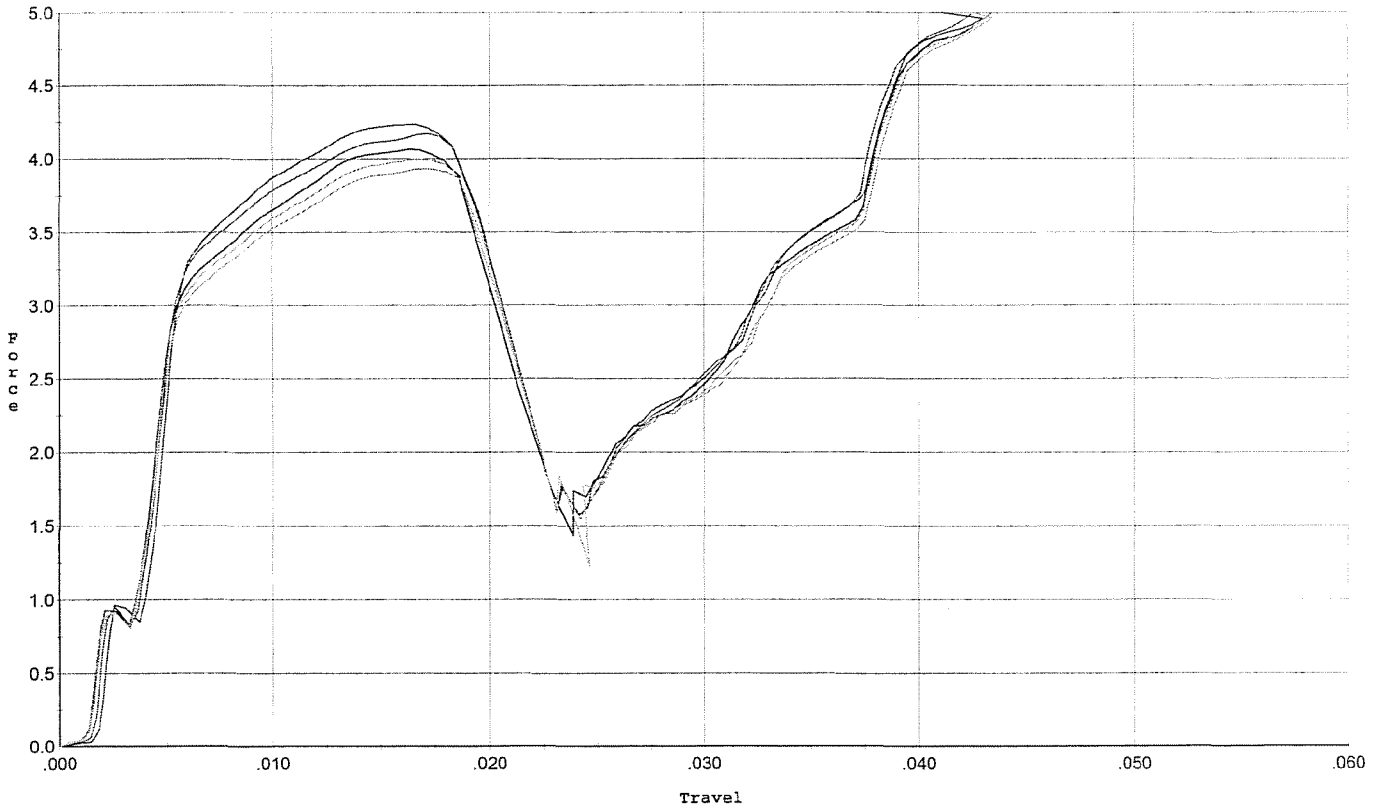
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.018	0.004	0.034	0.037		Set Trigger
2	3.038	0.017	0.00	0.034	0.035		Set Trigger
3	3.120	0.017	0.00	0.035	0.037		Set Trigger
4	3.065	0.018	0.004	0.034	0.037		Set Trigger
5	3.149	0.017	0.003	0.034	0.036		Set Trigger

A-3.08

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



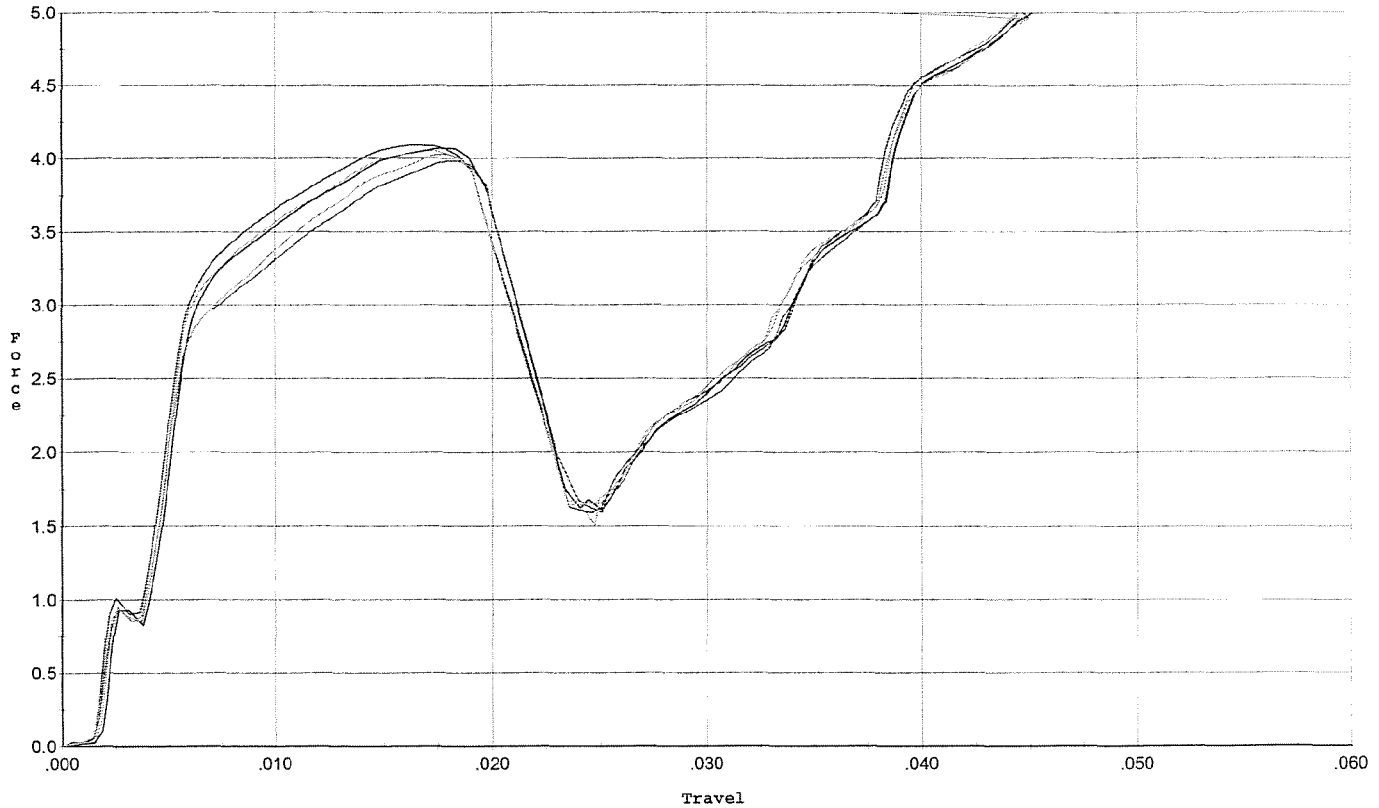
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.235	0.019	0.004	0.032	0.055		Set Trigger
2	4.065	0.019	0.004	0.032	0.051		Set Trigger
3	4.171	0.020	0.00	0.032	0.055		Set Trigger
4	3.999	0.020	0.004	0.032	0.055		Set Trigger
5	3.933	0.020	0.00	0.032	0.053		Set Trigger

A-4.08

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



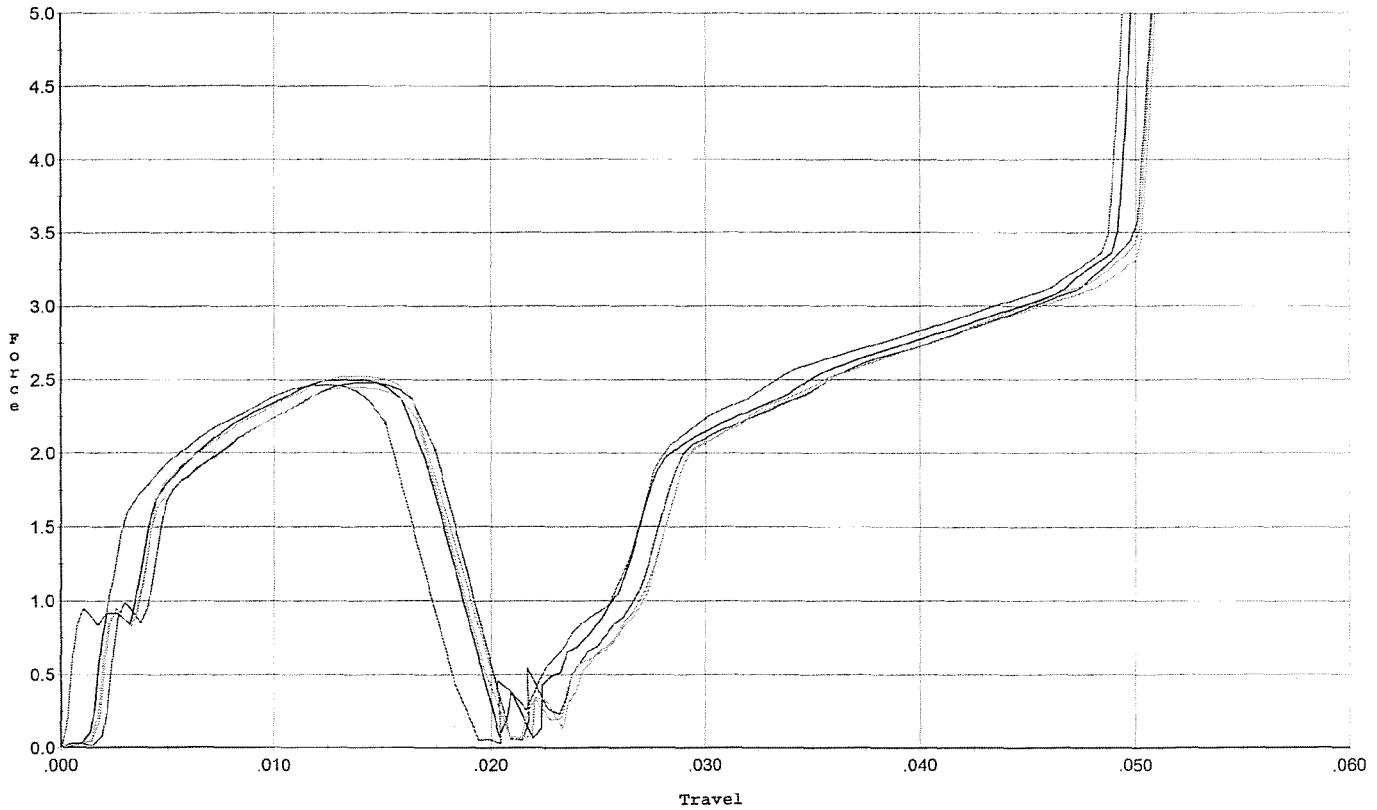
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.089	0.019	0.00	0.032	0.052		Set Trigger
2	4.069	0.020	0.002	0.032	0.053		Set Trigger
3	3.981	0.020	0.004	0.032	0.051		Set Trigger
4	4.050	0.019	0.004	0.032	0.051		Set Trigger
5	4.028	0.021	0.00	0.032	0.056		Set Trigger

A. 4.03

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



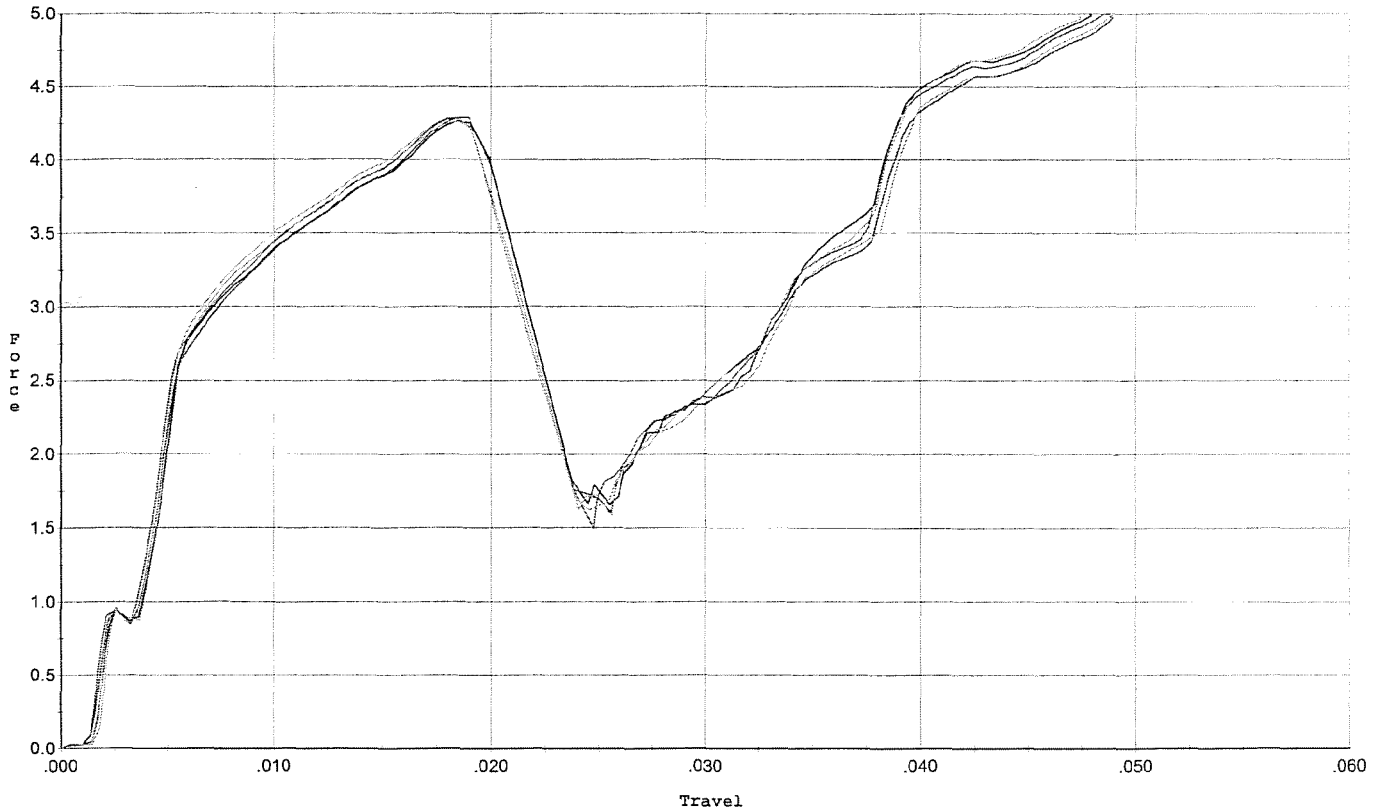
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.017	0.00	0.036	0.029		Set Trigger
2	2.499	0.017	0.003	0.036	0.030		Set Trigger
3	2.461	0.015	0.00	0.036	0.028		Set Trigger
4	2.447	0.017	0.00	0.037	0.028		Set Trigger
5	2.524	0.019	0.00	0.036	0.032		Set Trigger

A-2.48

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	4.285	0.020	0.00	0.032	0.054		Set Trigger
2	4.262	0.020	0.00	0.031	0.054		Set Trigger
3	4.280	0.019	0.00	0.032	0.052		Set Trigger
4	4.285	0.019	0.00	0.032	0.052		Set Trigger
5	4.258	0.021	0.004	0.032	0.057		Set Trigger

A-4.27