

6680 7772

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



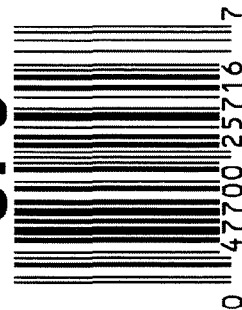
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807772

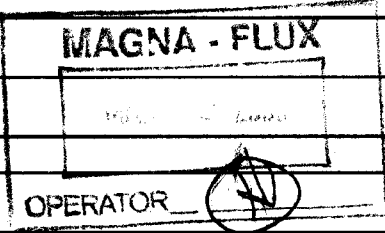
UPC



M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807772

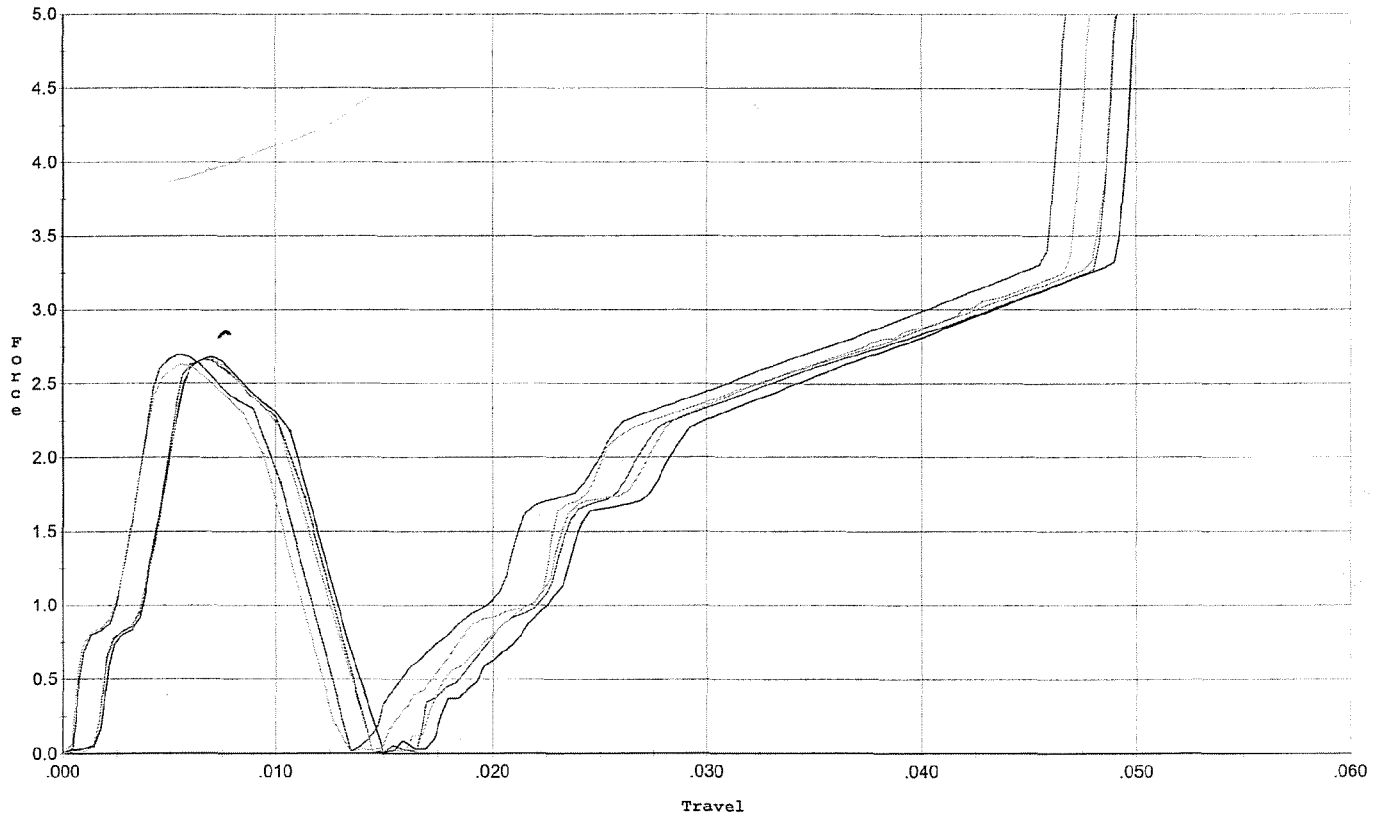
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE		2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION		3/5/09	N
490	MAGNAFLUX BOLT		3/5/09	mk
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	mk
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		3-12-09	RP
	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>5.5</u> <u>5.5</u> <u>4</u>	3-20-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-20-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-20-09	W/W
	J) ASSEMBLE STOCK		3-12-09	L/R
	K) ASSEMBLE SWIVEL STUDS		3-20-09	W/W
	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	L.P.R.
	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	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.49</u> <u>2.58</u> <u>2.60</u> <u>2.52</u>	3-20-09	TL
	C) FUNCTION		3-20-09	W/W
690	PACK		3-20-09	TL

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



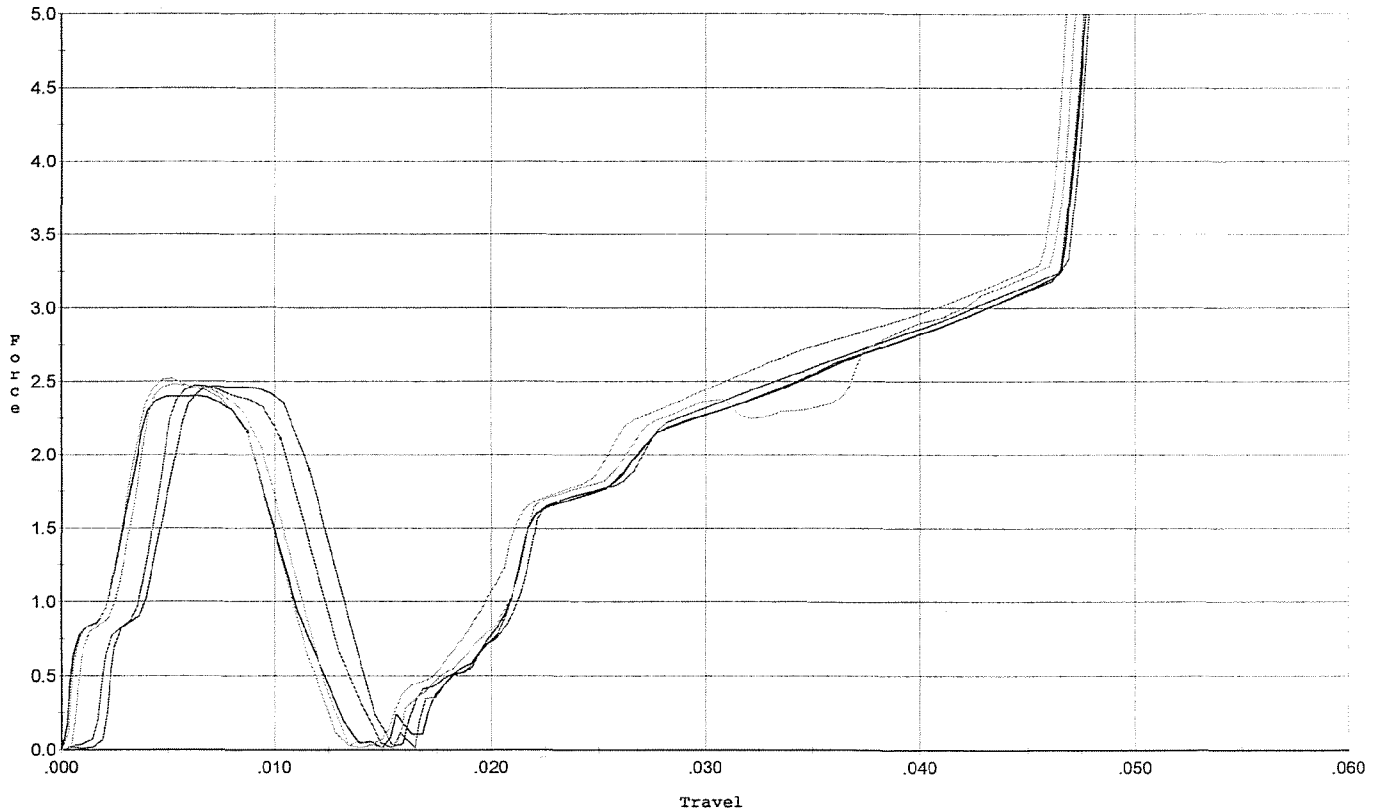
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.697	0.010	0.00	0.039	0.017		Set Trigger
2	2.682	0.011	0.00	0.041	0.016		Set Trigger
3	2.657	0.011	0.00	0.041	0.017		Set Trigger
4	2.631	0.009	0.00	0.041	0.016		Set Trigger
5	2.672	0.010	0.00	0.041	0.015		Set Trigger

A-2.66

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



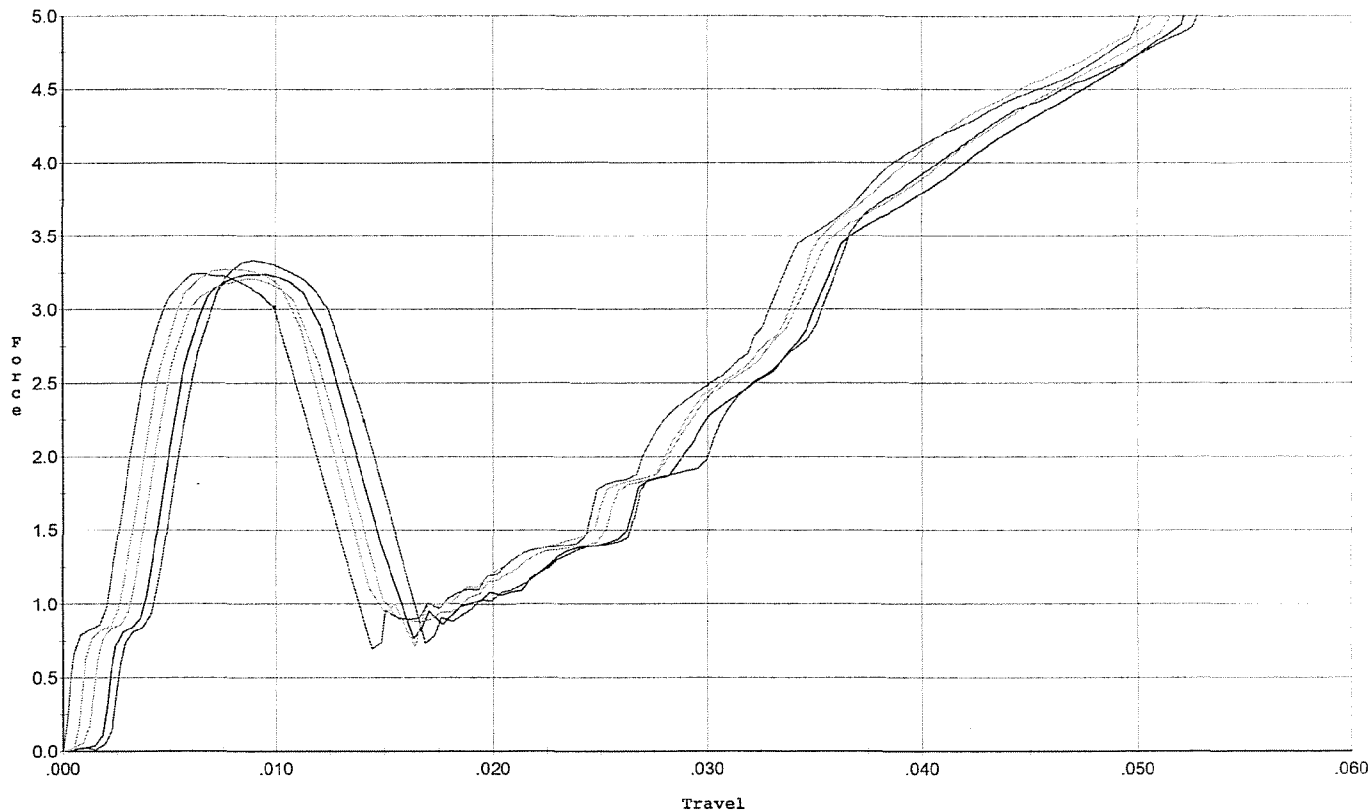
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.471	0.012	0.00	0.039	0.017		Set Trigger
2	2.403	0.009	0.00	0.041	0.014		Set Trigger
3	2.477	0.010	0.00	0.040	0.015		Set Trigger
4	2.481	0.009	0.00	0.040	0.015		Set Trigger
5	2.520	0.009	0.00	0.040	0.015		Set Trigger

A-2-47

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



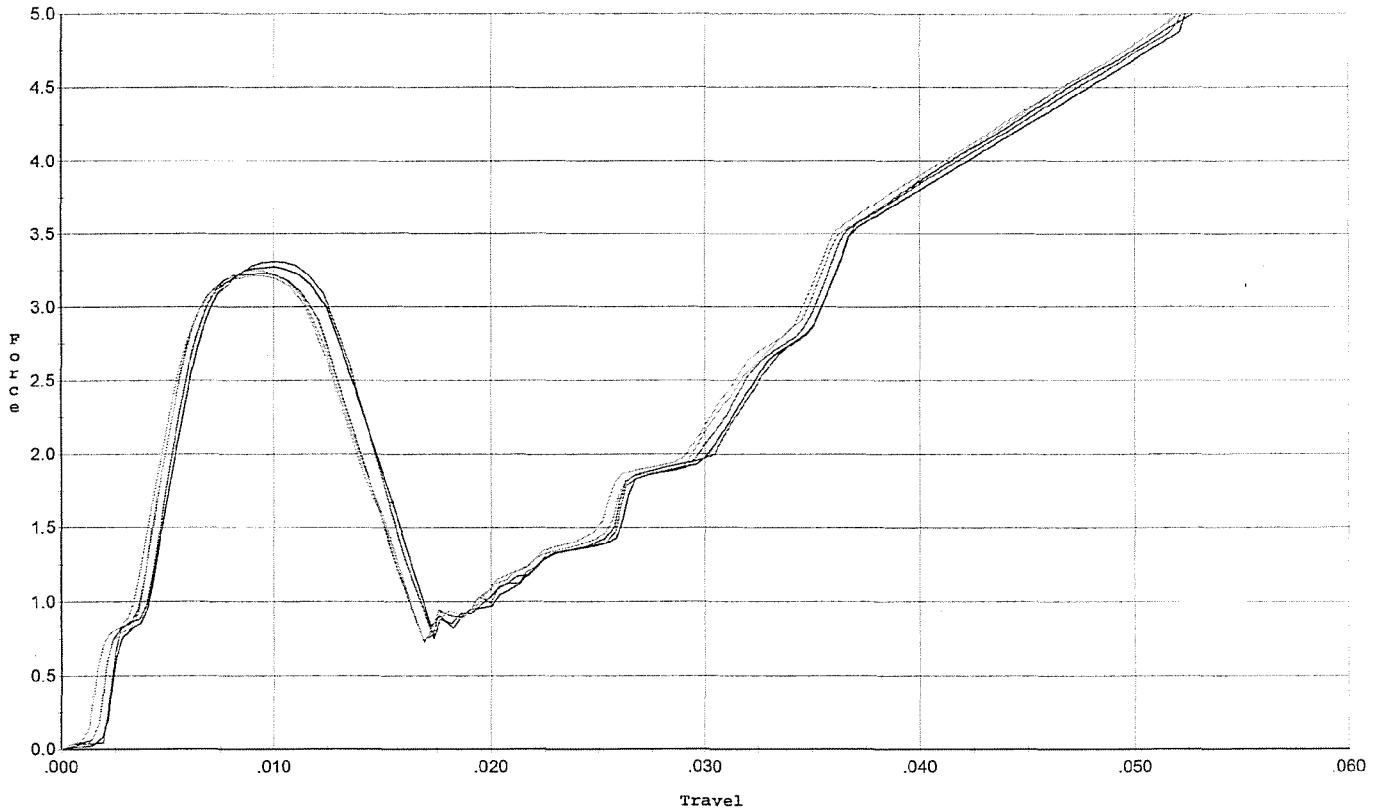
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.334	0.014	0.00	0.039	0.027		Set Trigger
2	3.240	0.012	0.00	0.040	0.024		Set Trigger
3	3.244	0.010	0.00	0.039	0.021		Set Trigger
4	3.272	0.011	0.00	0.039	0.023		Set Trigger
5	3.207	0.012	0.00	0.039	0.024		Set Trigger

A-3-25

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



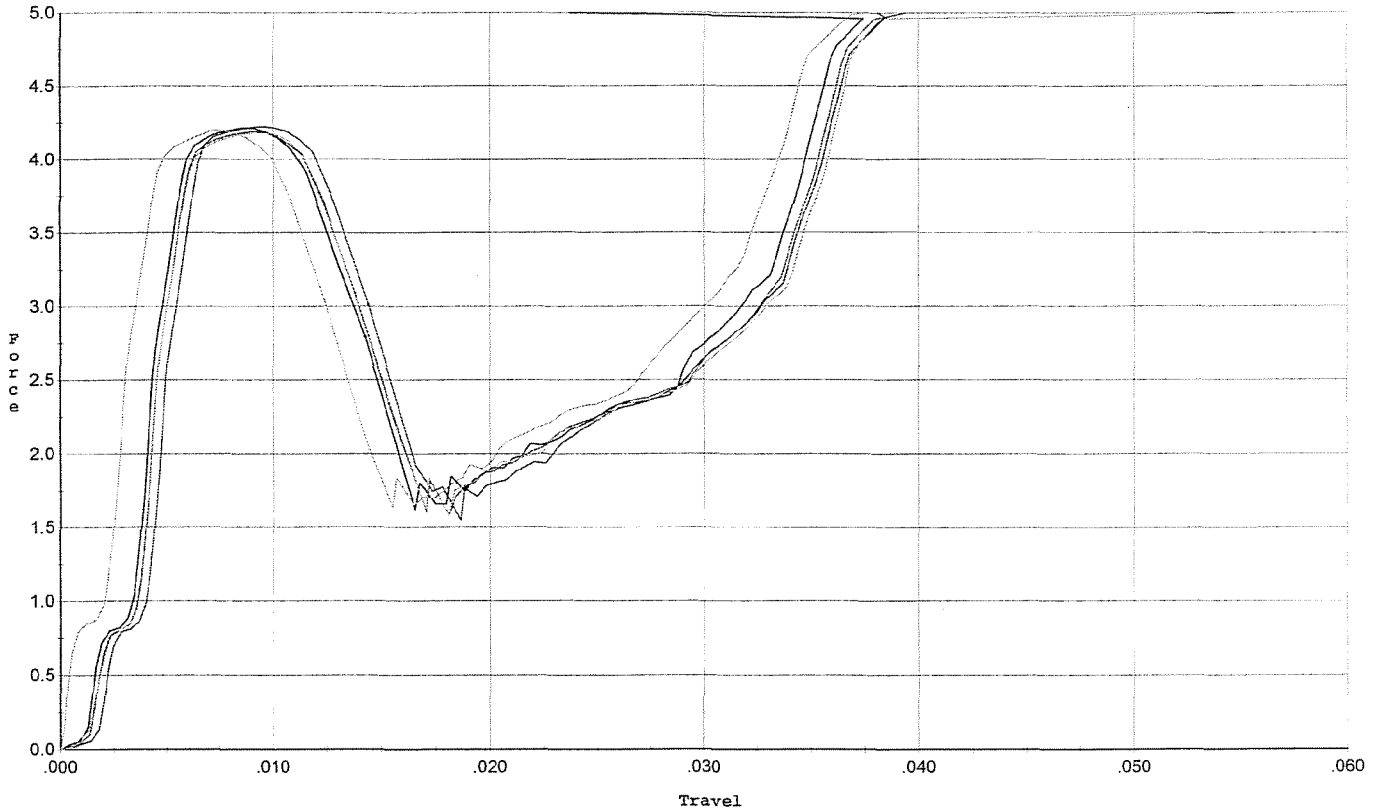
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.306	0.014	0.00	0.039	0.027		Set Trigger
2	3.272	0.015	0.00	0.038	0.030		Set Trigger
3	3.231	0.014	0.00	0.039	0.027		Set Trigger
4	3.212	0.013	0.00	0.039	0.025		Set Trigger
5	3.250	0.012	0.00	0.039	0.024		Set Trigger

A-3-25

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



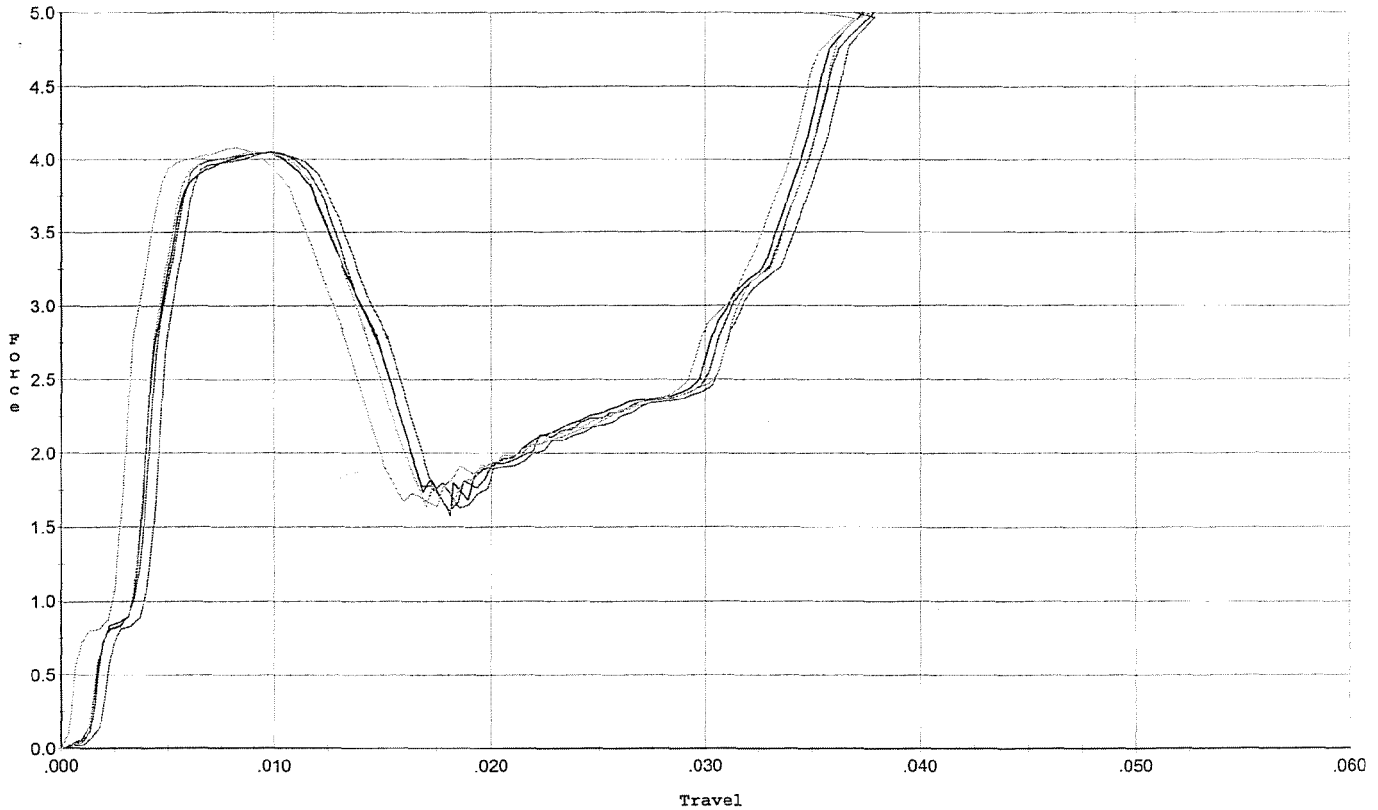
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.223	0.014	0.00	0.034	0.036		Set Trigger
2	4.215	0.014	0.00	0.033	0.037		Set Trigger
3	4.192	0.014	0.00	0.034	0.035		Set Trigger
4	4.179	0.014	0.00	0.034	0.035		Set Trigger
5	4.201	0.012	0.00	0.033	0.034		Set Trigger

A-4.20

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



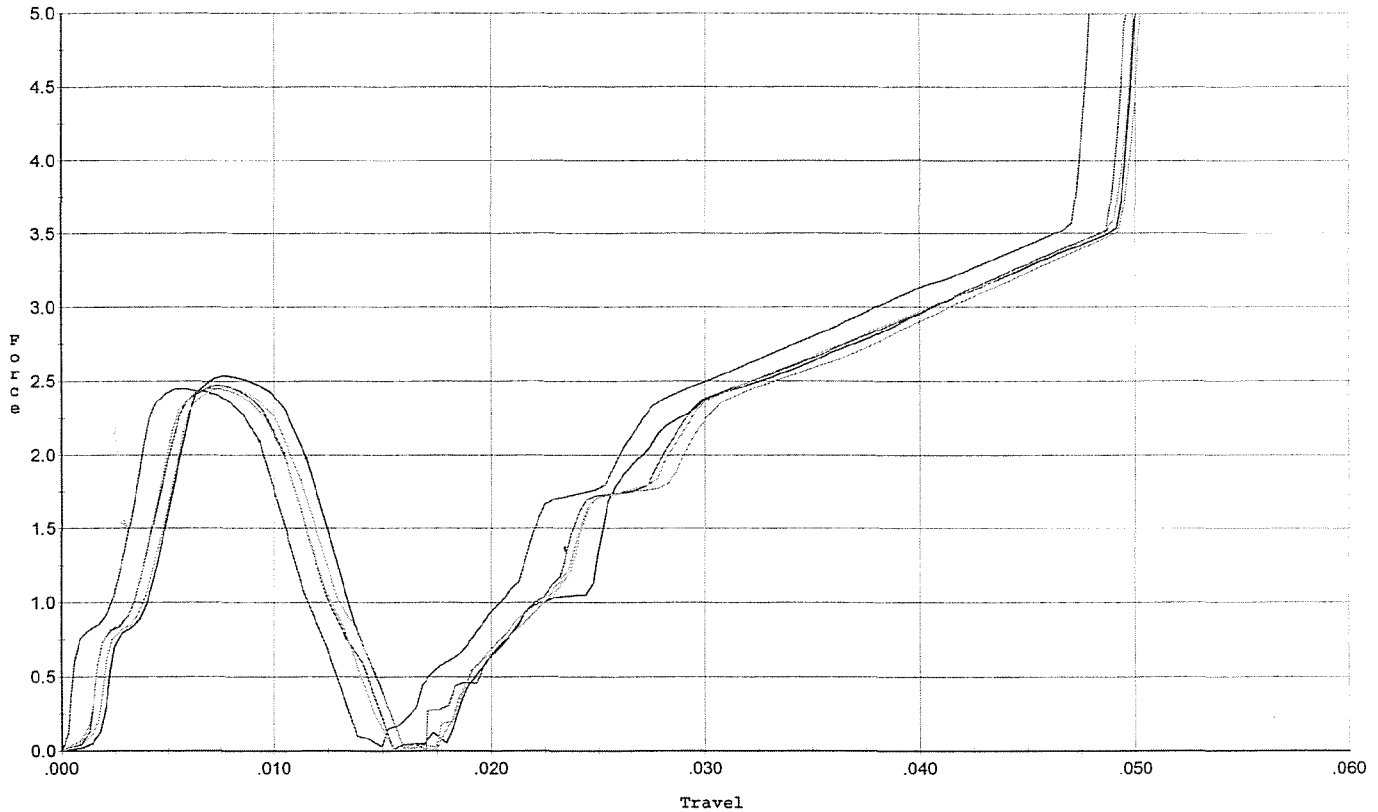
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.049	0.015	0.00	0.033	0.038		Set Trigger
2	4.045	0.015	0.00	0.033	0.037		Set Trigger
3	4.055	0.015	0.00	0.034	0.038		Set Trigger
4	4.053	0.014	0.00	0.033	0.036		Set Trigger
5	4.081	0.013	0.00	0.033	0.035		Set Trigger

A 4.05

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



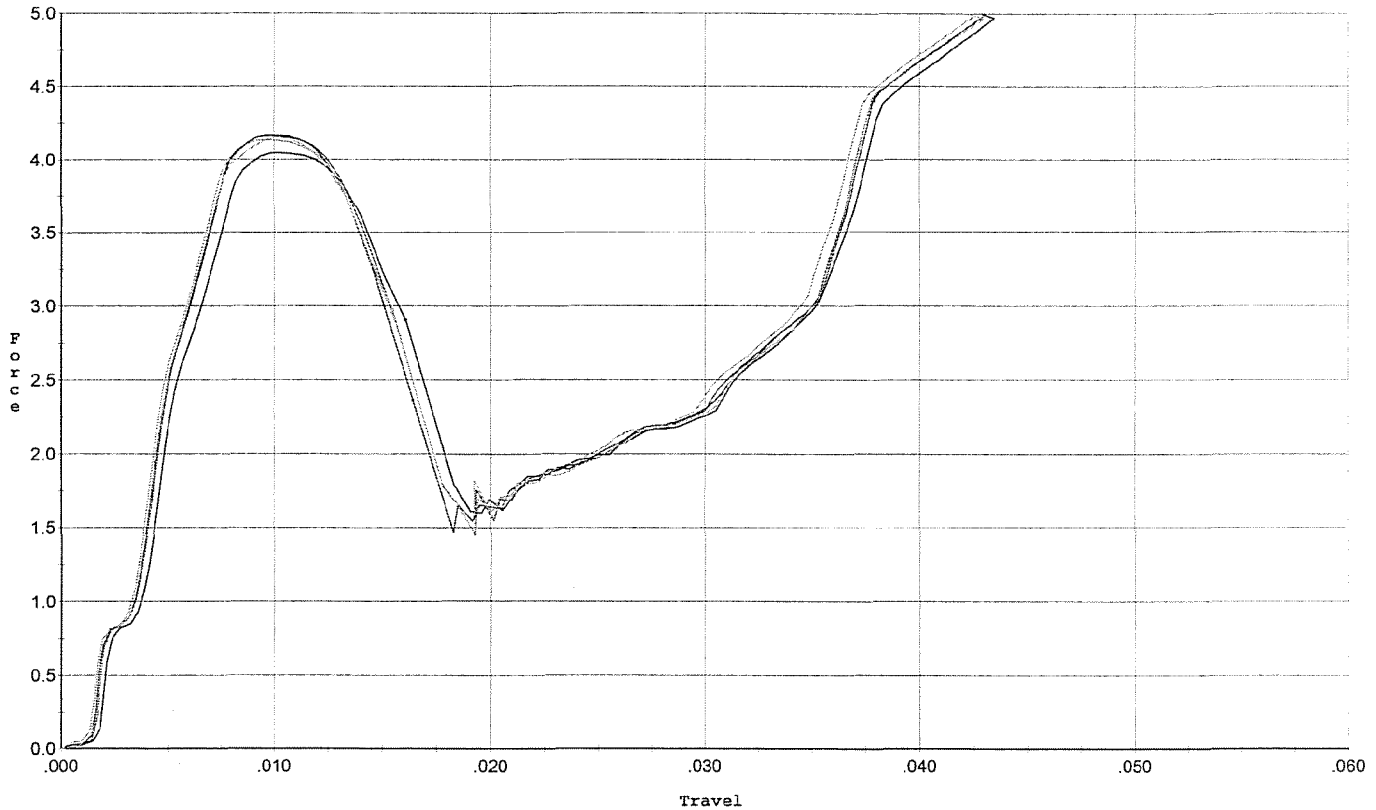
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.451	0.009	0.00	0.040	0.015		Set Trigger
2	2.538	0.011	0.00	0.041	0.017		Set Trigger
3	2.474	0.010	0.00	0.041	0.016		Set Trigger
4	2.456	0.011	0.00	0.041	0.016		Set Trigger
5	2.447	0.010	0.00	0.042	0.016		Set Trigger

A-2.47

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	4.160	0.016	0.00	0.037	0.041		Set Trigger
2	4.044	0.016	0.00	0.036	0.039		Set Trigger
3	4.166	0.016	0.00	0.037	0.039		Set Trigger
4	4.152	0.016	0.00	0.037	0.039		Set Trigger
5	4.136	0.015	0.00	0.037	0.039		Set Trigger

A-4.13