

G680 7773

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

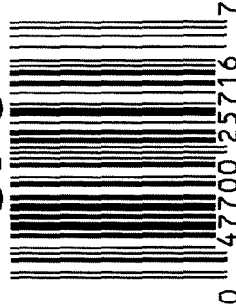
24"

CAPACITY

6

G6807773

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807773

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
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	OPERATOR 	3/5/09	
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-8-09	SP
520	GOFF BLAST BBL / REC		3/6	mon
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		3-11-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

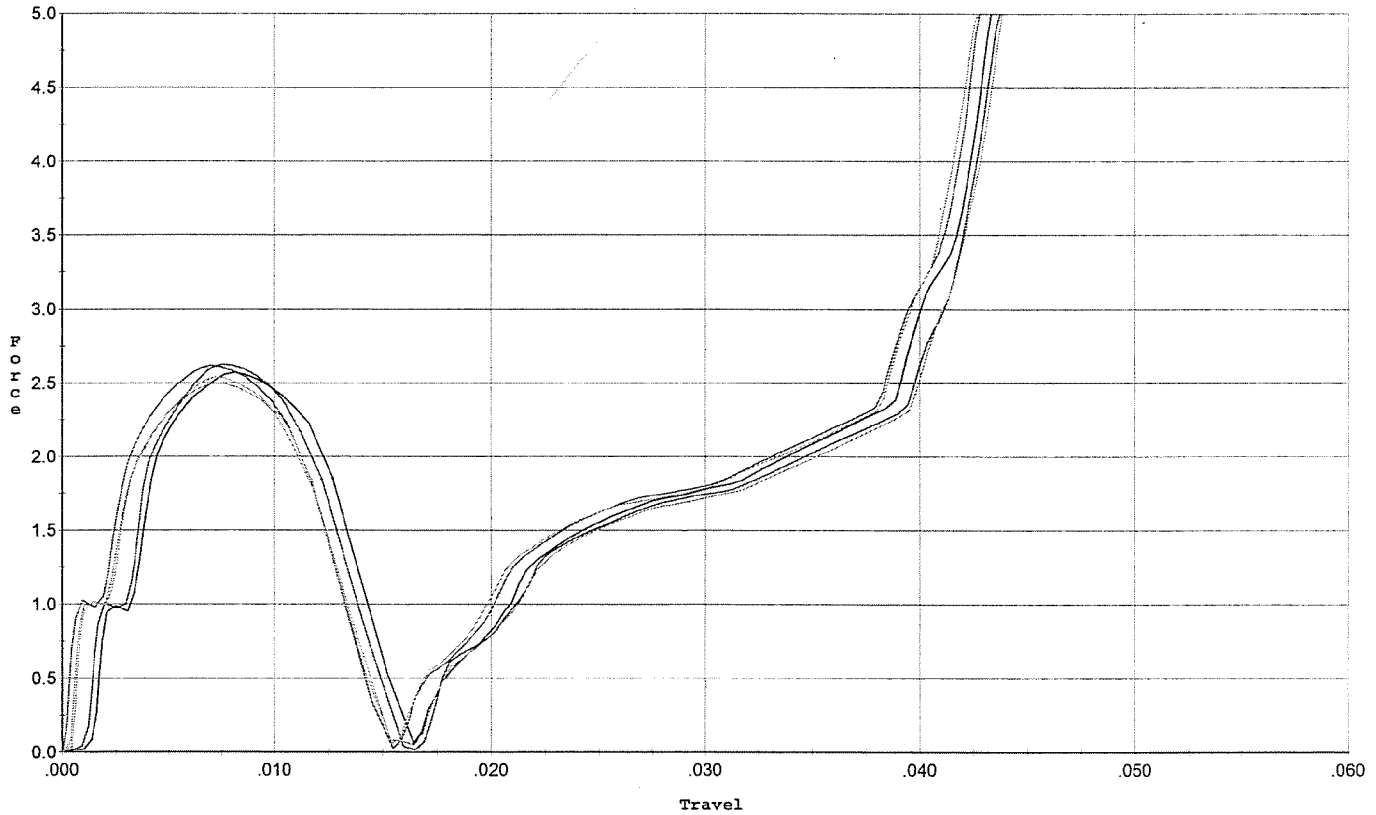
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-18-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-18-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-18-09	WV
	J) ASSEMBLE STOCK		3-11-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-18-09	WV
	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	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-16-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.33</u> <u>2.29</u> <u>2.31</u> <u>2.35</u>	3-18-09	WV
	C) FUNCTION		3-18-09	WV
690	PACK		3/19/09	FM

F004 REV 5/2006

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



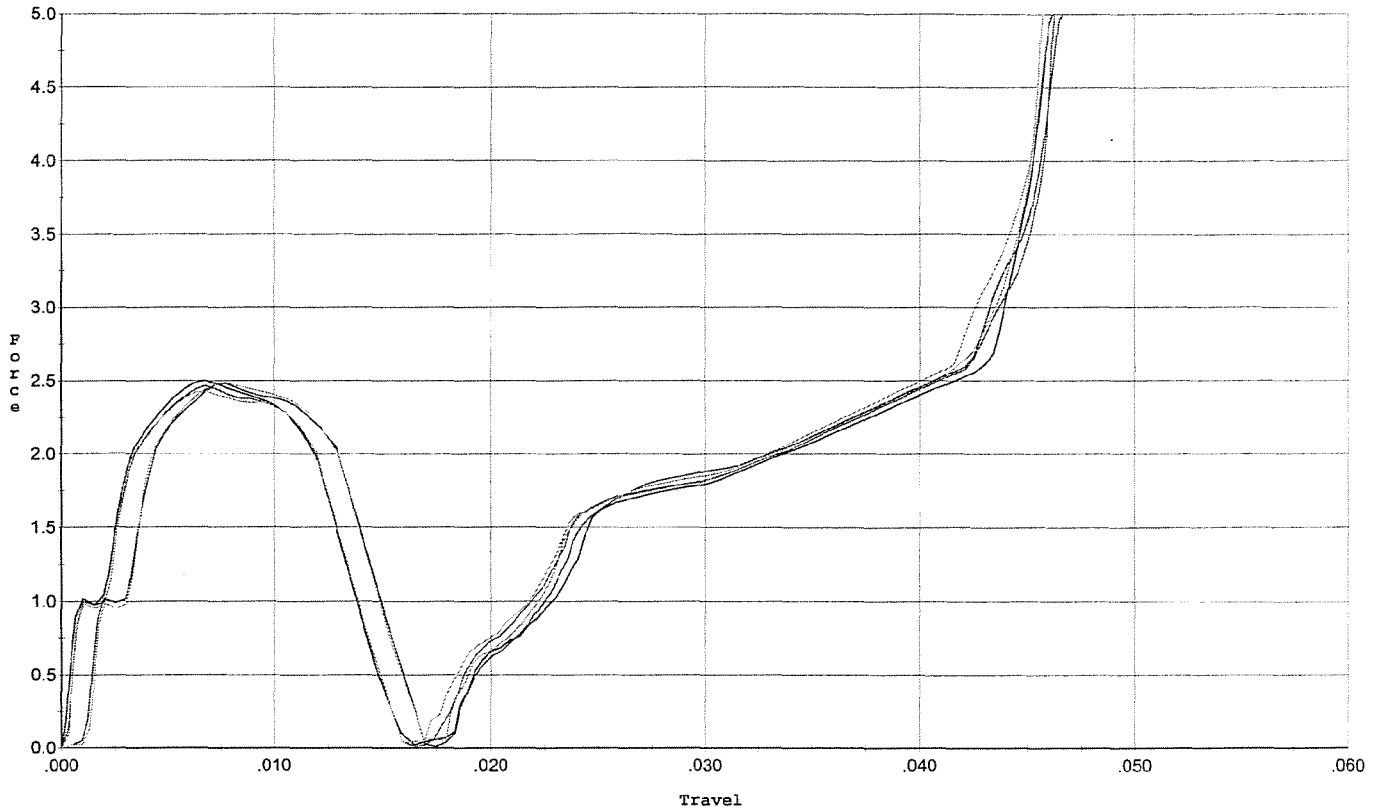
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.012	0.00	0.036	0.021		Set Trigger
2	2.572	0.013	0.00	0.035	0.021		Set Trigger
3	2.620	0.012	0.00	0.035	0.022		Set Trigger
4	2.540	0.012	0.00	0.035	0.021		Set Trigger
5	2.499	0.012	0.00	0.036	0.021		Set Trigger

A-2.57

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



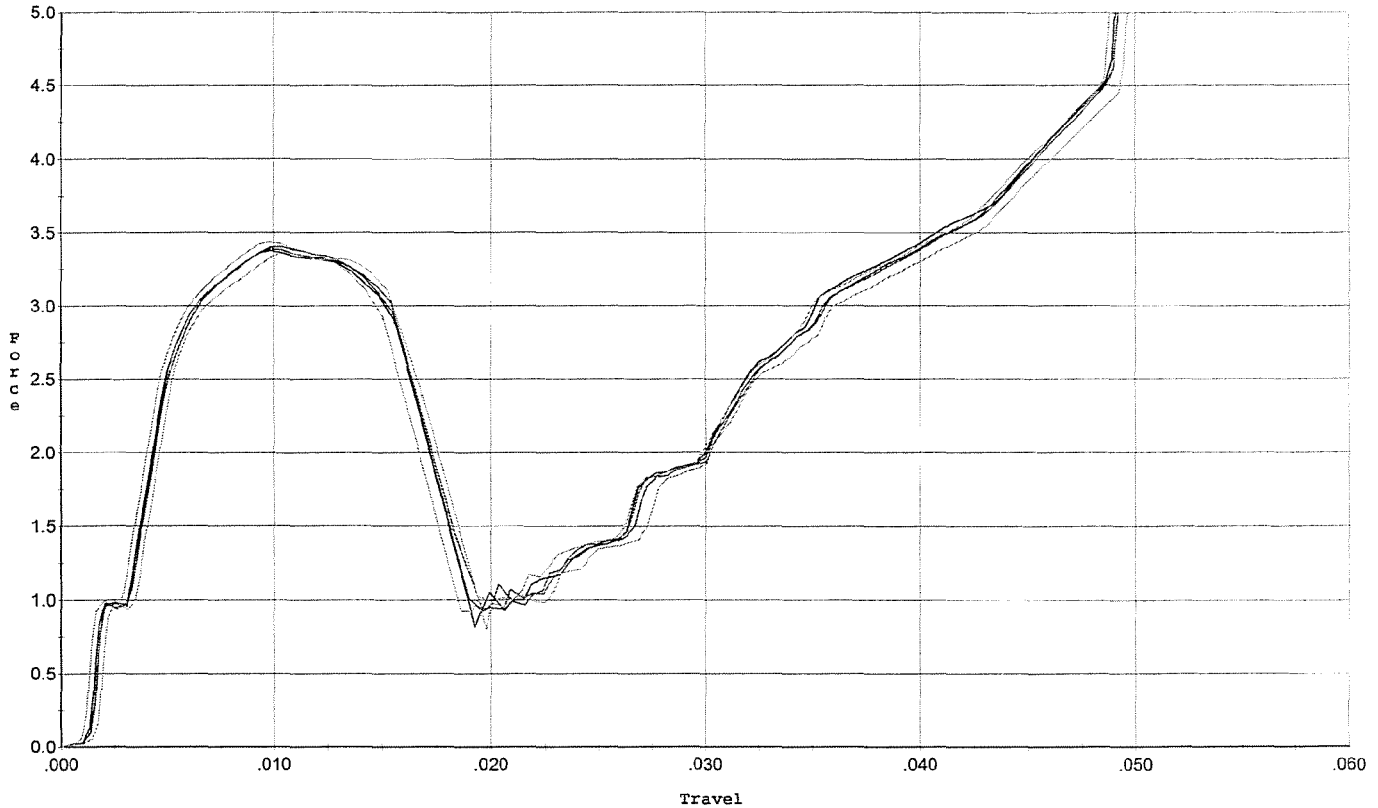
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.481	0.013	0.00	0.037	0.022		Set Trigger
2	2.499	0.012	0.00	0.038	0.022		Set Trigger
3	2.464	0.012	0.00	0.038	0.021		Set Trigger
4	2.430	0.012	0.00	0.037	0.021		Set Trigger
5	2.490	0.013	0.00	0.037	0.022		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



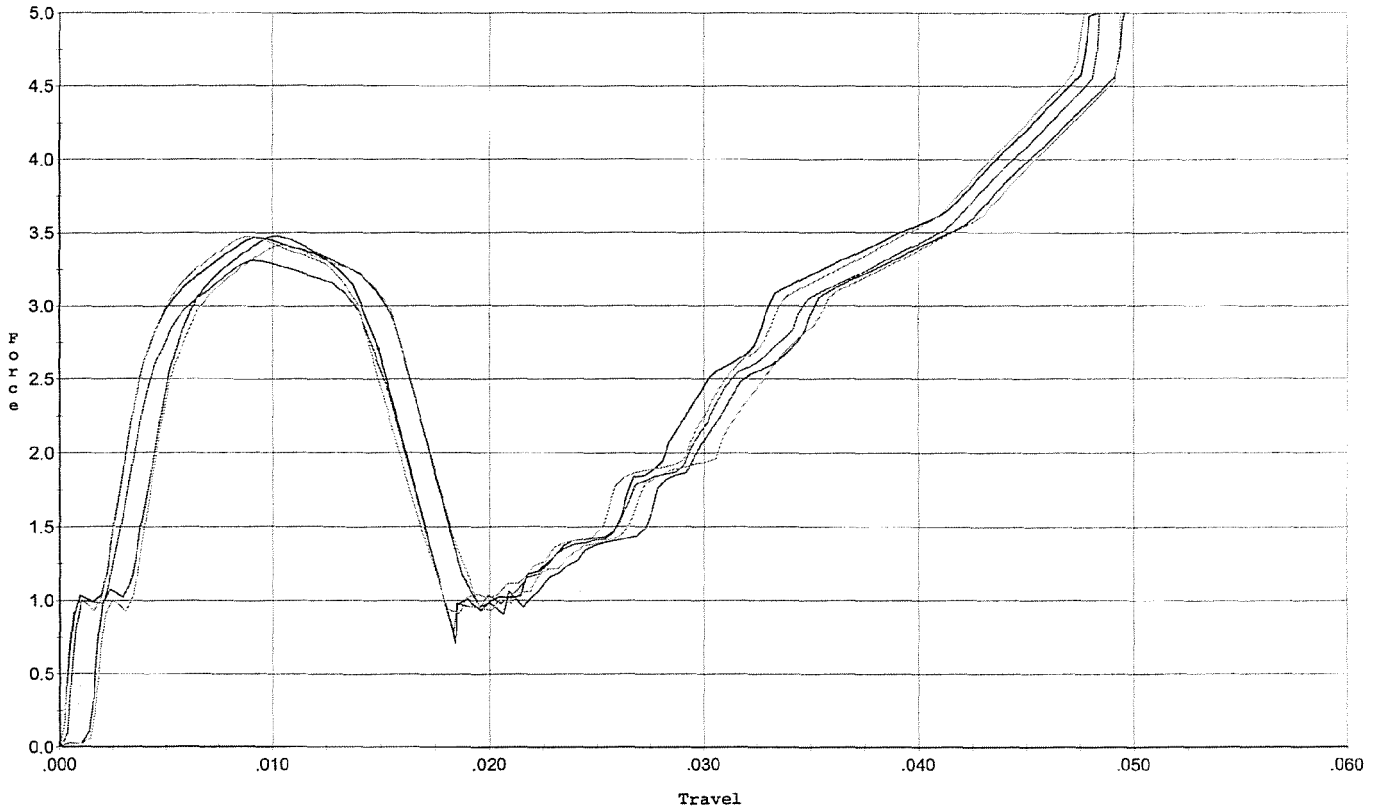
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.391	0.016	0.00	0.035	0.035		Set Trigger
2	3.377	0.016	0.00	0.035	0.036		Set Trigger
3	3.404	0.015	0.00	0.035	0.035		Set Trigger
4	3.367	0.017	0.00	0.035	0.038		Set Trigger
5	3.438	0.015	0.00	0.035	0.035		Set Trigger

A-3-39

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



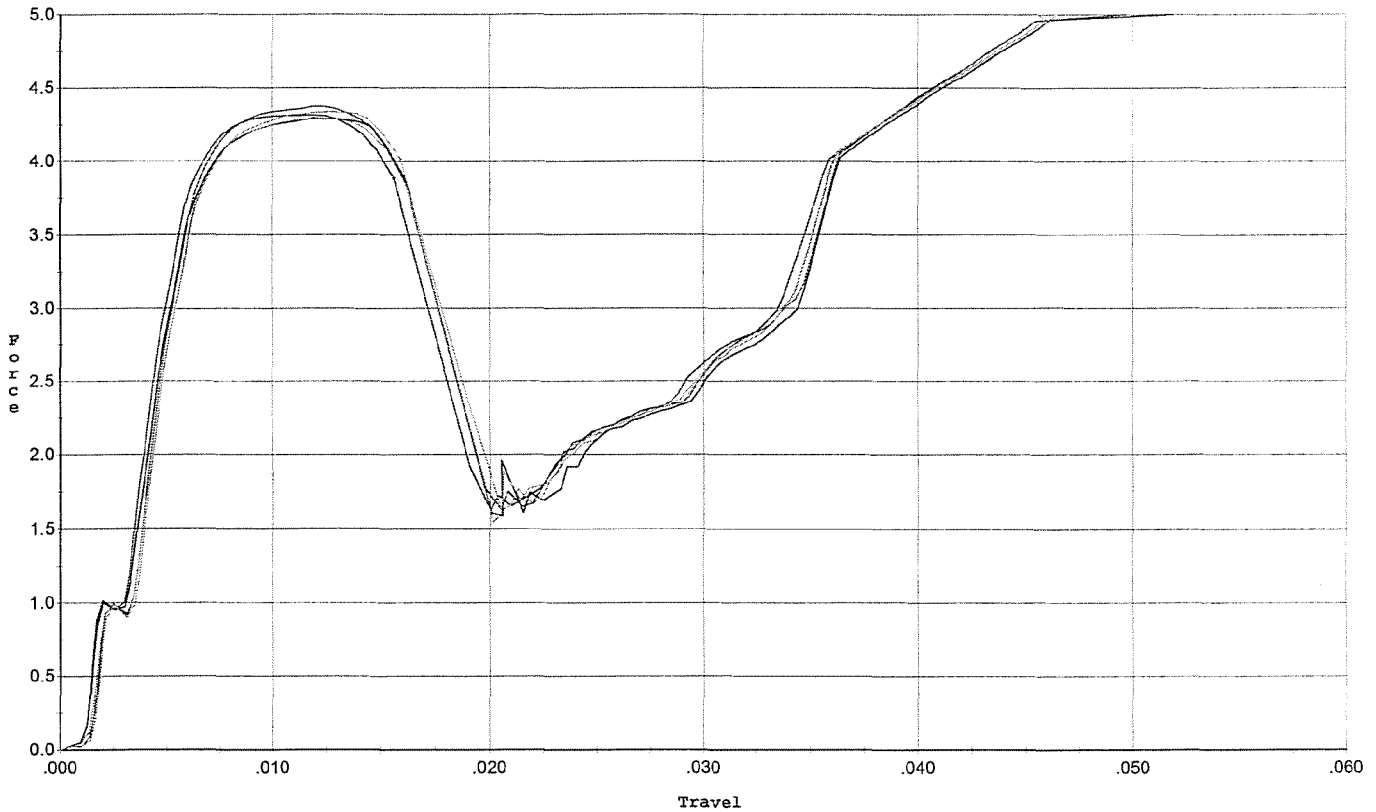
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.479	0.016	0.00	0.035	0.036		Set Trigger
2	3.470	0.015	0.00	0.034	0.037		Set Trigger
3	3.311	0.015	0.002	0.034	0.036		Set Trigger
4	3.416	0.015	0.00	0.035	0.035		Set Trigger
5	3.474	0.014	0.00	0.034	0.034		Set Trigger

A-3.43

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



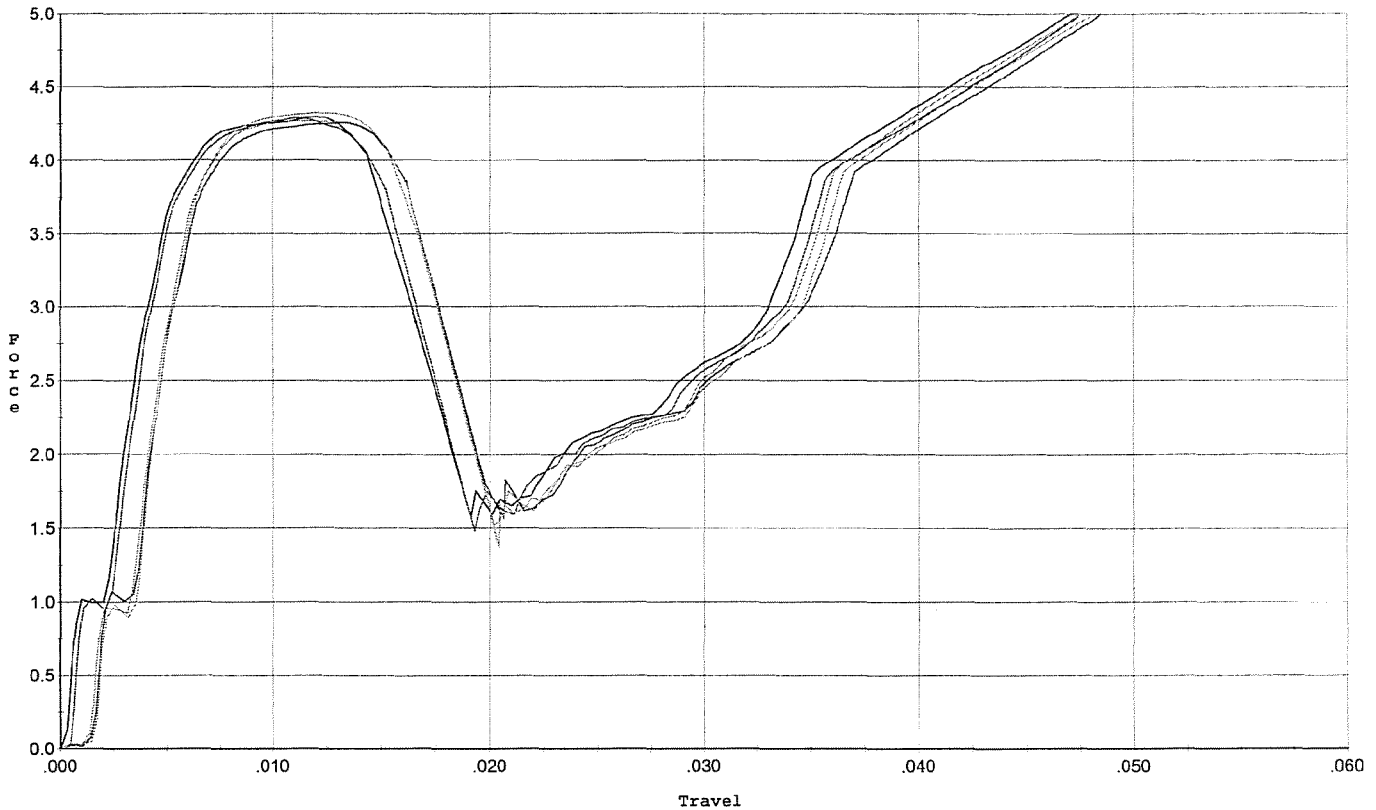
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.311	0.016	0.00	0.032	0.045		Set Trigger
2	4.291	0.016	0.00	0.032	0.046		Set Trigger
3	4.372	0.016	0.00	0.032	0.046		Set Trigger
4	4.332	0.016	0.00	0.032	0.045		Set Trigger
5	4.291	0.016	0.00	0.032	0.046		Set Trigger

A. 4.31

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



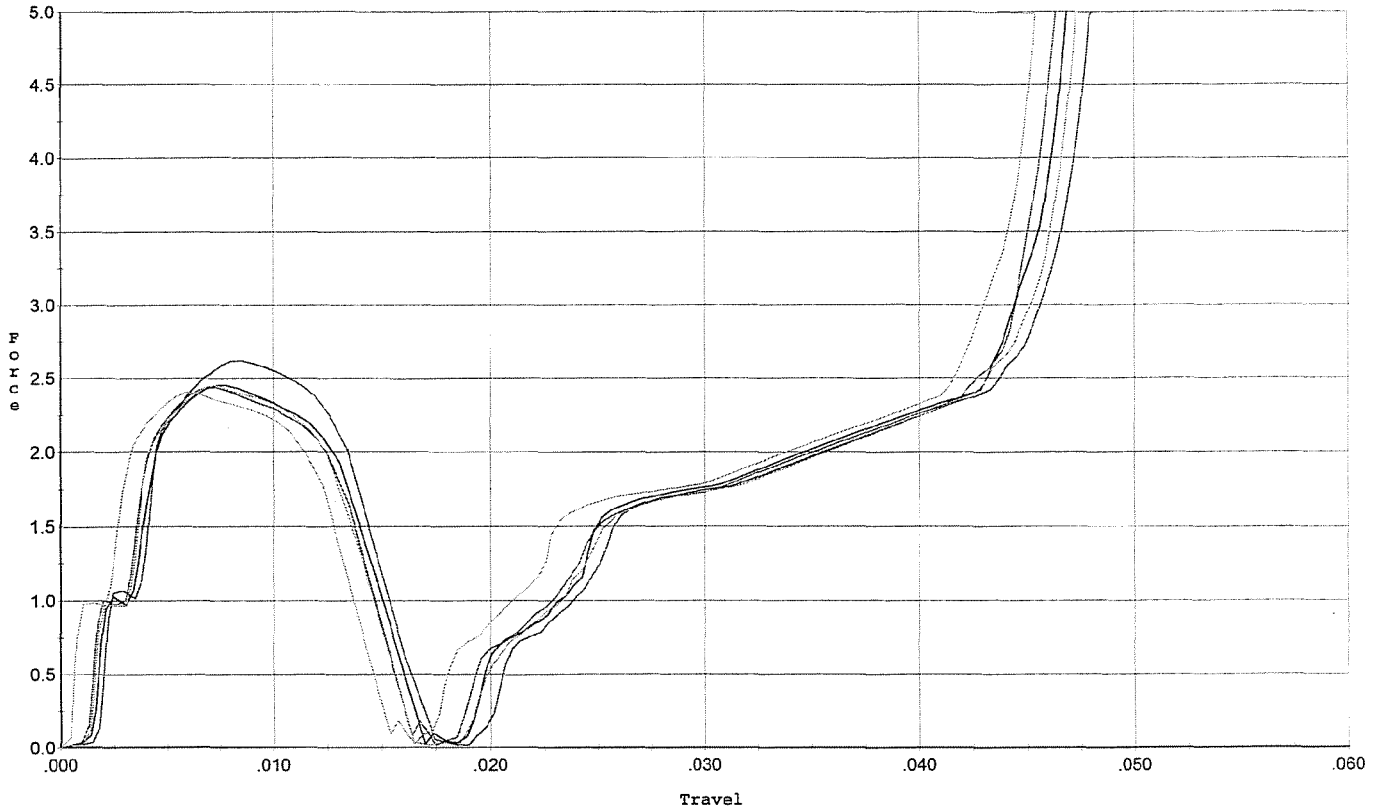
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.255	0.016	0.00	0.033	0.045		Set Trigger
2	4.294	0.017	0.002	0.032	0.050		Set Trigger
3	4.288	0.015	0.00	0.033	0.045		Set Trigger
4	4.323	0.016	0.00	0.033	0.046		Set Trigger
5	4.266	0.017	0.003	0.032	0.047		Set Trigger

A-4.28

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



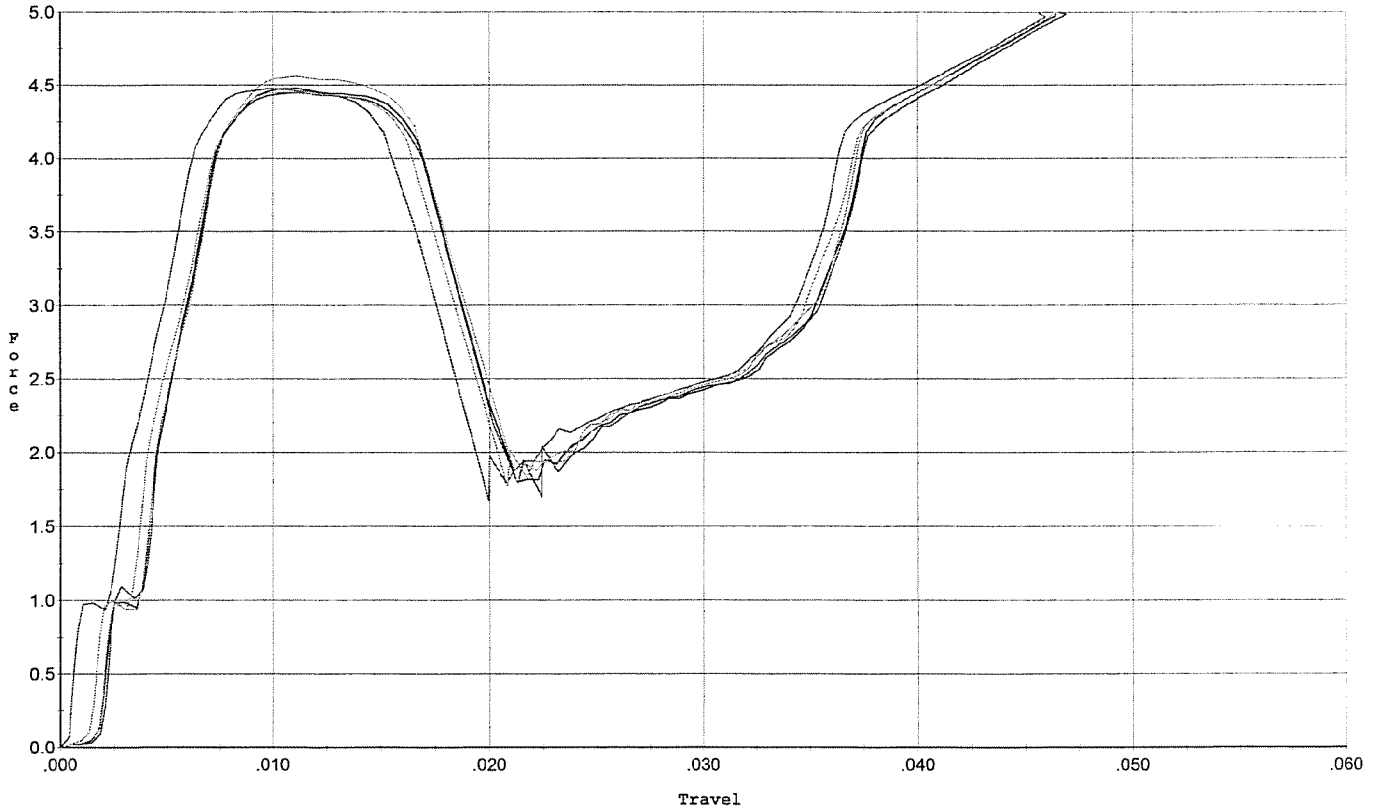
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.619	0.013	0.00	0.038	0.023		Set Trigger
2	2.450	0.015	0.00	0.037	0.024		Set Trigger
3	2.438	0.014	0.00	0.037	0.023		Set Trigger
4	2.404	0.012	0.00	0.037	0.022		Set Trigger
5	2.452	0.014	0.003	0.038	0.023		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 ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.449	0.017	0.00	0.033	0.049		Set Trigger
2	4.477	0.017	0.004	0.033	0.048		Set Trigger
3	4.474	0.017	0.00	0.032	0.051		Set Trigger
4	4.561	0.017	0.004	0.032	0.048		Set Trigger
5	4.451	0.018	0.00	0.032	0.054		Set Trigger

A. 4.418