

G6845295

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



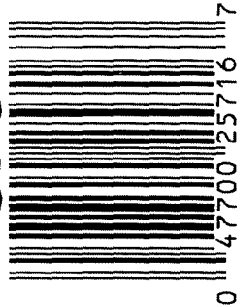
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845295

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6845295

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RT
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
472	SERIALIZE BOLT HANDLE		3-18-09	RT
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION		3/20/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

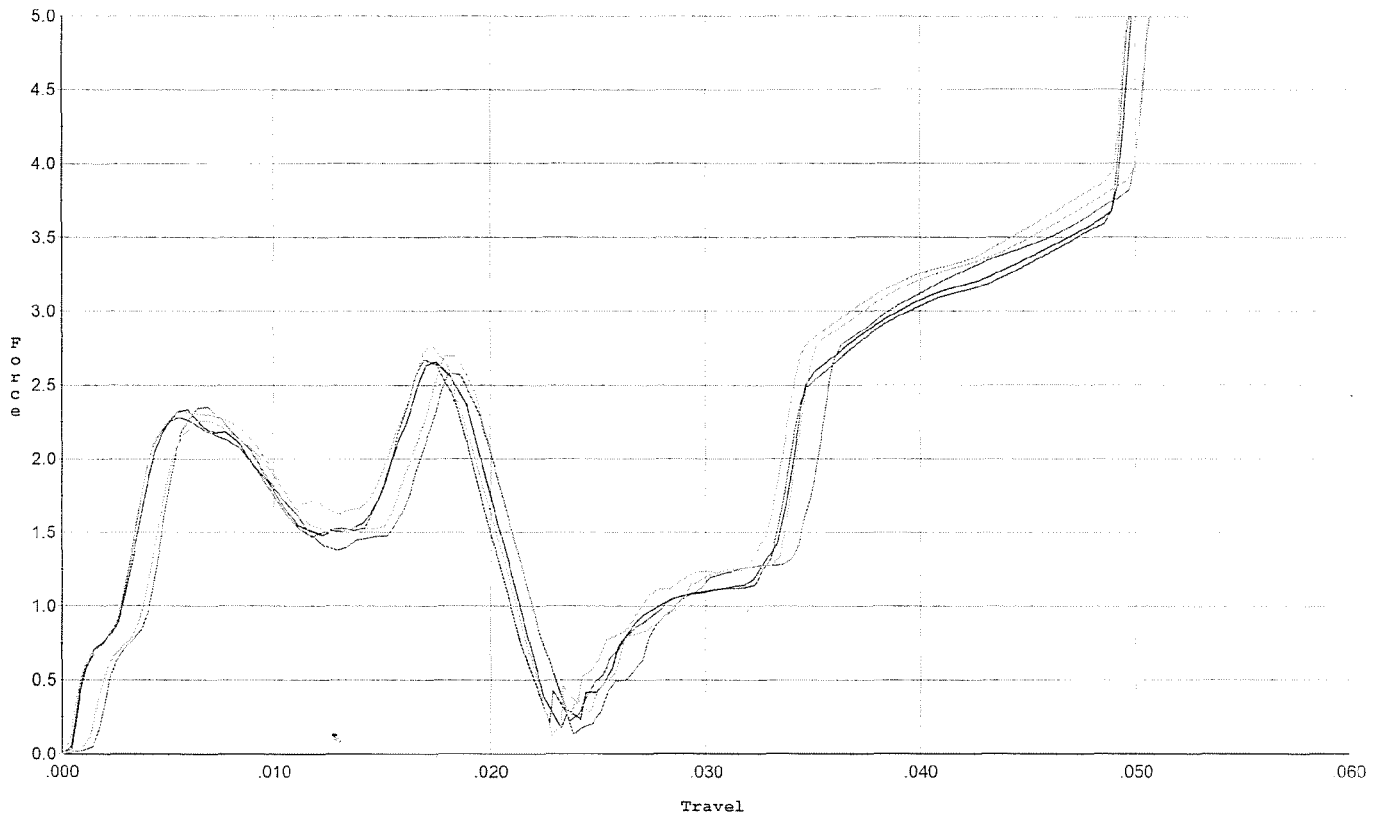
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	5-7-09	LJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	5-7-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-7-09	LJN
	J) ASSEMBLE STOCK		4-20-09	LJN
	K) ASSEMBLE SWIVEL STUDS		5-7-09	LJN
	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	4-21-09	WZ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-21-09	TJR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE		5-7-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>3.46</u> <u>3.52</u> <u>3.52</u> <u>3.66</u> <u>3.46</u>	4-22-09	WZ
	C) FUNCTION		5-7-09	LJN
690	PACK		5/27/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



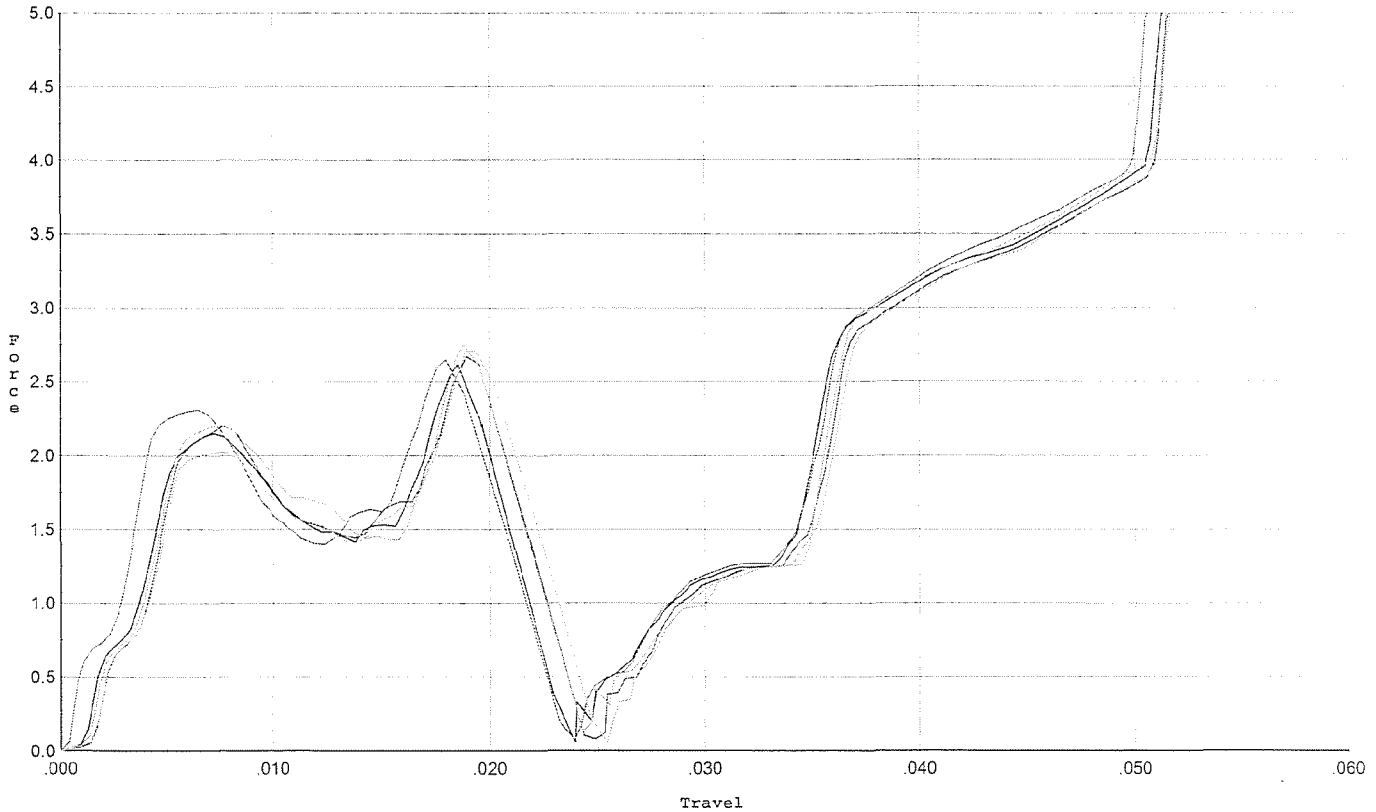
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.672	0.018	0.015	0.034	0.031		Set Trigger
2	2.657	0.019	0.015	0.034	0.032		Set Trigger
3	2.582	0.020	0.016	0.035	0.030		Set Trigger
4	2.699	0.019	0.015	0.034	0.031		Set Trigger
5	2.770	0.020	0.015	0.034	0.035		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



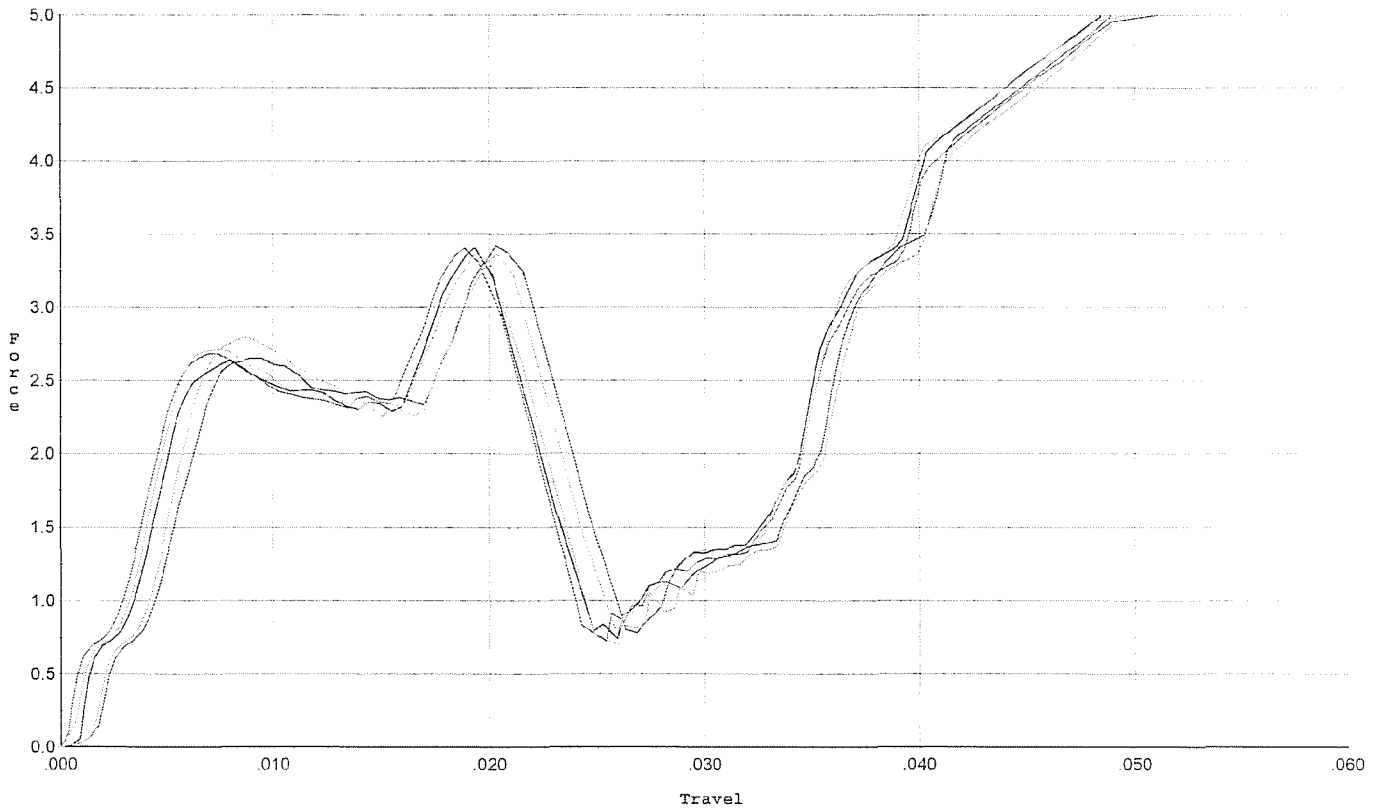
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.671	0.022	0.015	0.035	0.033		Set Trigger
2	2.616	0.020	0.014	0.035	0.030		Set Trigger
3	2.648	0.021	0.013	0.035	0.034		Set Trigger
4	2.703	0.022	0.015	0.035	0.034		Set Trigger
5	2.752	0.022	0.016	0.035	0.034		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



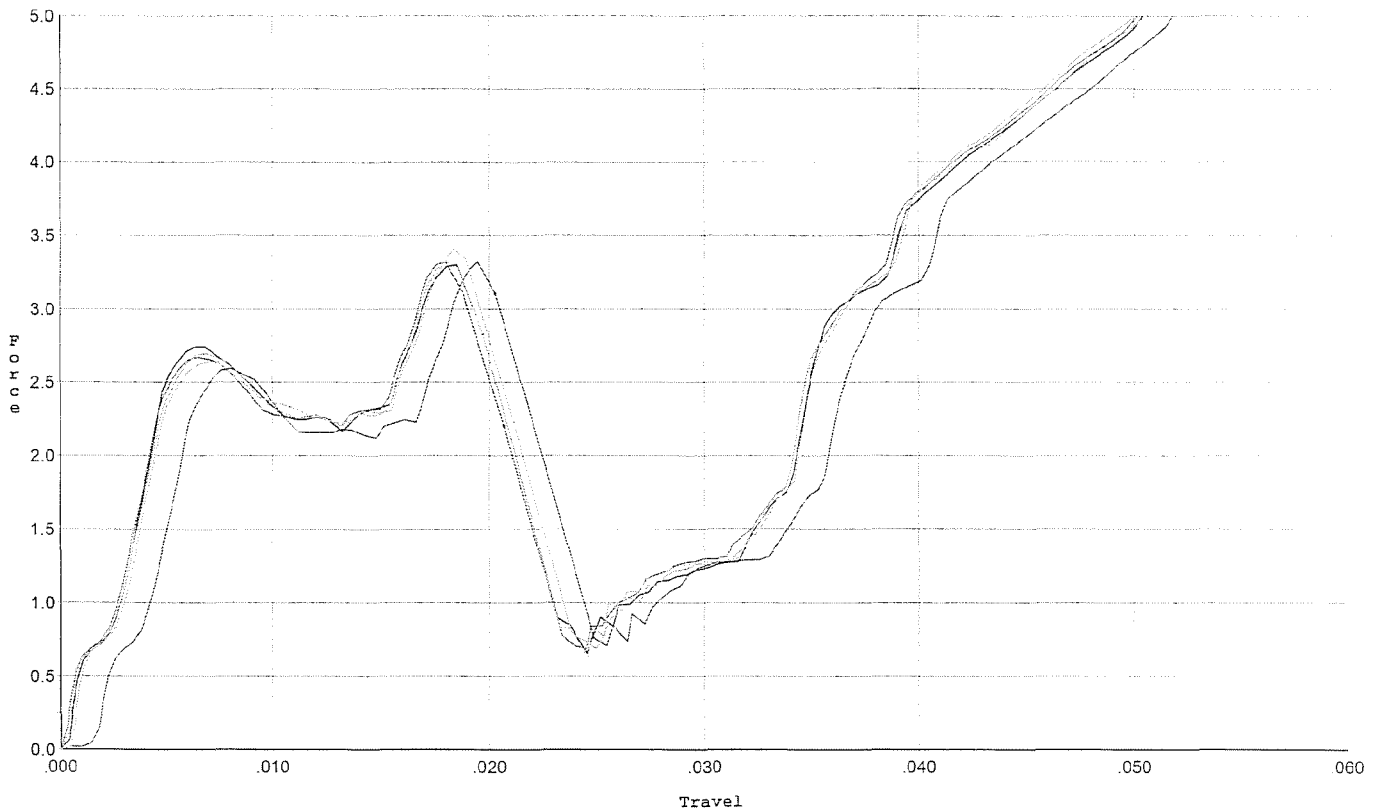
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.426	0.022	0.00	0.033	0.044		Set Trigger
2	3.410	0.020	0.00	0.033	0.042		Set Trigger
3	3.407	0.021	0.00	0.033	0.044		Set Trigger
4	3.367	0.022	0.00	0.033	0.046		Set Trigger
5	3.371	0.021	0.00	0.033	0.043		Set Trigger

A-3.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



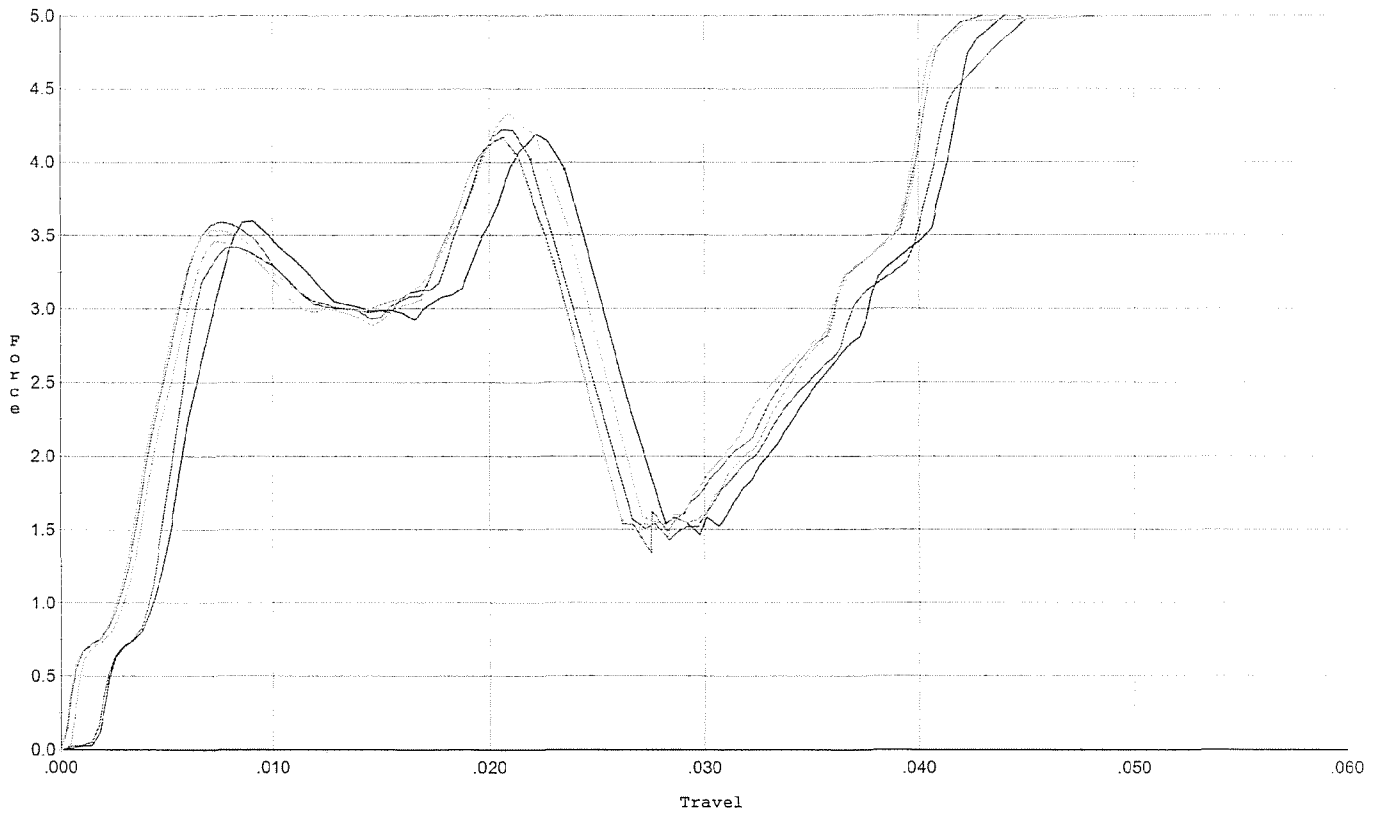
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.020	0.015	0.034	0.039		Set Trigger
2	3.299	0.020	0.00	0.033	0.041		Set Trigger
3	3.326	0.021	0.00	0.033	0.043		Set Trigger
4	3.331	0.020	0.00	0.034	0.041		Set Trigger
5	3.405	0.021	0.014	0.033	0.044		Set Trigger

A-3.33

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



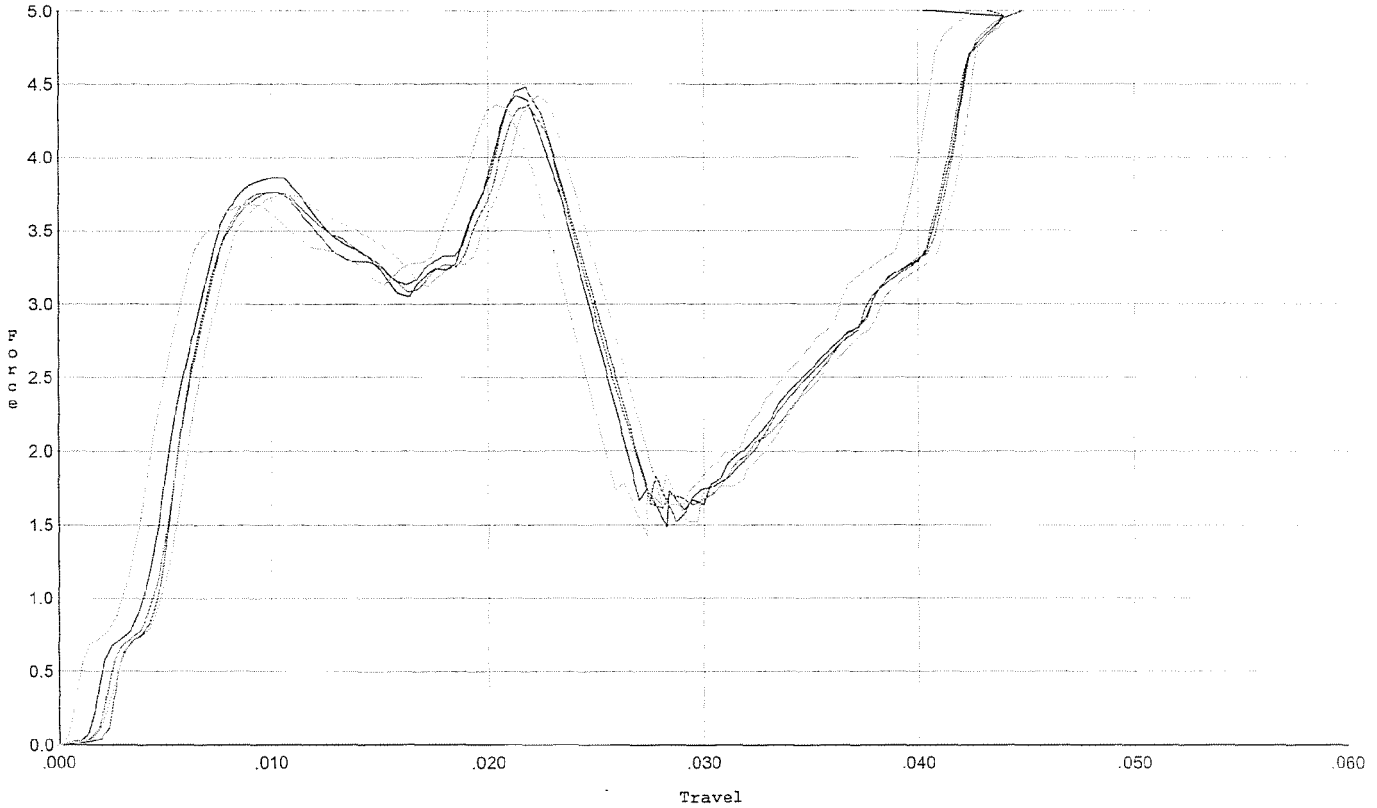
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.224	0.022	0.00	0.031	0.056		Set Trigger
2	4.191	0.023	0.00	0.030	0.060		Set Trigger
3	4.174	0.023	0.00	0.030	0.062		Set Trigger
4	4.164	0.023	0.00	0.030	0.062		Set Trigger
5	4.336	0.023	0.00	0.029	0.064		Set Trigger

A-4.21

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



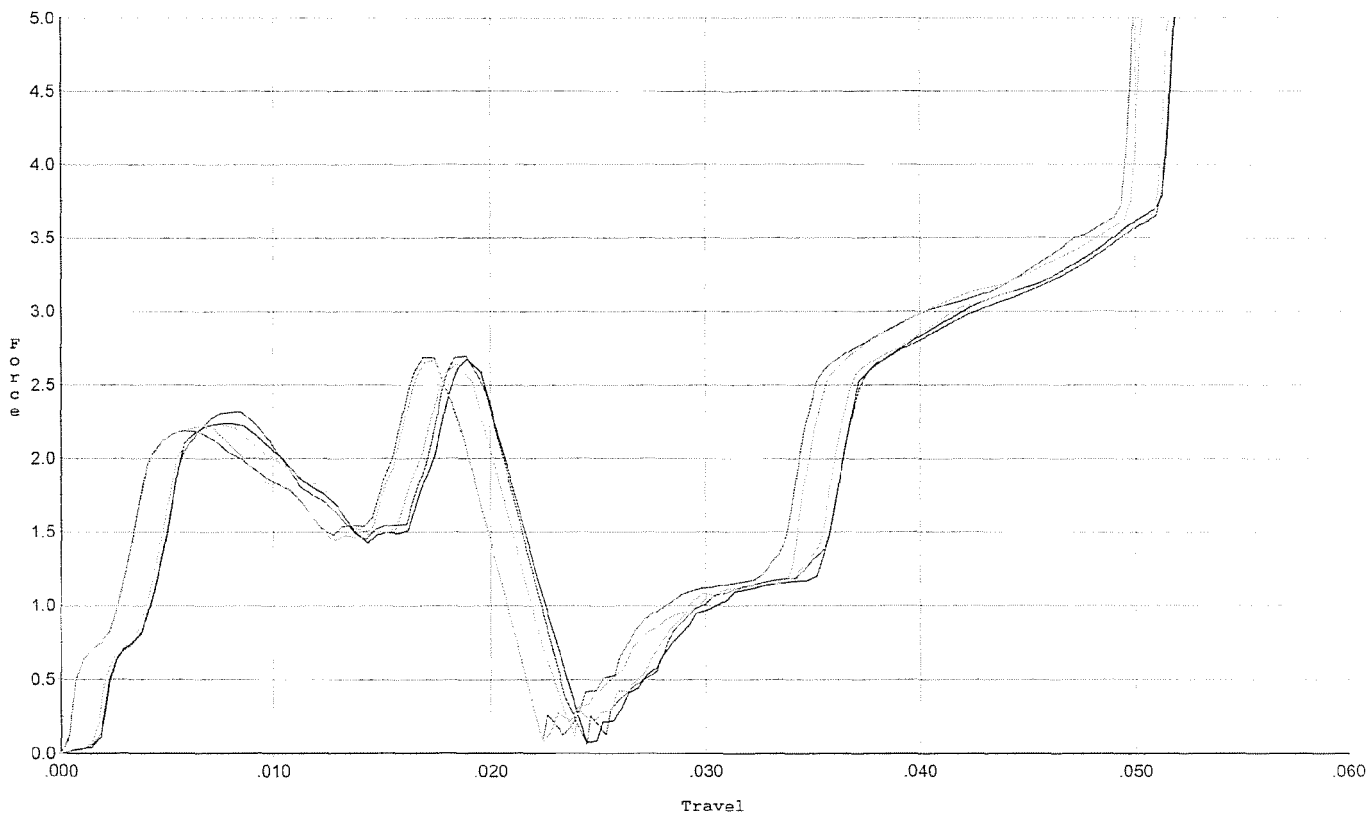
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.474	0.025	0.00	0.030	0.066		Set Trigger
2	4.420	0.023	0.00	0.030	0.063		Set Trigger
3	4.355	0.023	0.00	0.030	0.060		Set Trigger
4	4.421	0.025	0.00	0.030	0.067		Set Trigger
5	4.361	0.022	0.00	0.030	0.061		Set Trigger

A-4.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



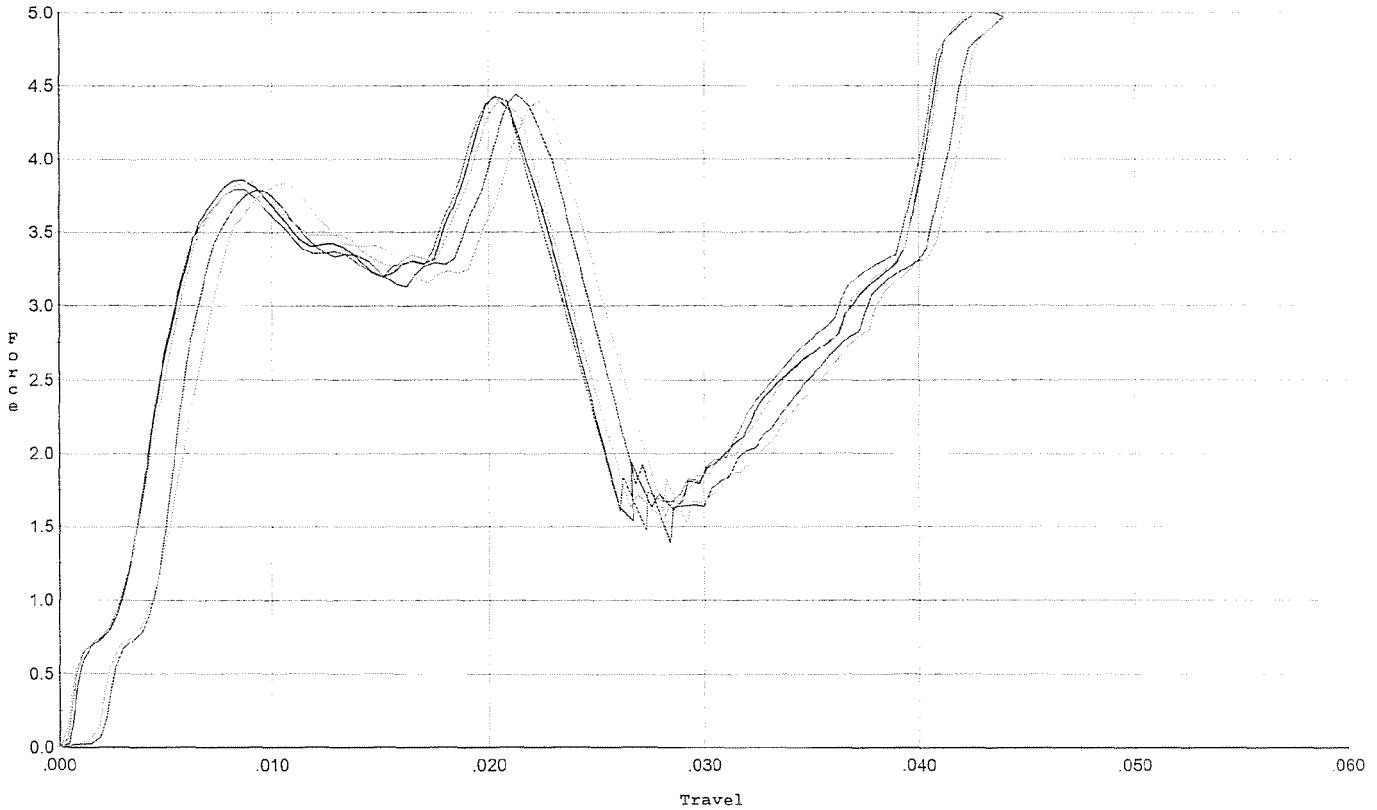
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.699	0.020	0.015	0.036	0.031		Set Trigger
2	2.675	0.020	0.015	0.036	0.031		Set Trigger
3	2.688	0.019	0.013	0.034	0.031		Set Trigger
4	2.643	0.019	0.016	0.036	0.030		Set Trigger
5	2.669	0.019	0.015	0.035	0.031		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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	4.444	0.023	0.002	0.030	0.062		Set Trigger
2	4.431	0.022	0.00	0.030	0.064		Set Trigger
3	4.420	0.023	0.00	0.030	0.066		Set Trigger
4	4.395	0.023	0.00	0.030	0.062		Set Trigger
5	4.409	0.022	0.00	0.030	0.061		Set Trigger

A-4.42