

G-6845311

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



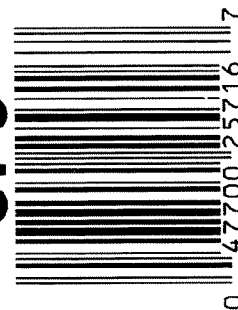
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6845311

UPC



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6845311

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SP
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SP
460	CHECK HEADSPACE		3-17-09	SP
470	DIS-ASSEMBLE ACTION		3-17-09	SP
472	SERIALIZE BOLT HANDLE		3-18-09	KIC
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/20/09	
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		4-8-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

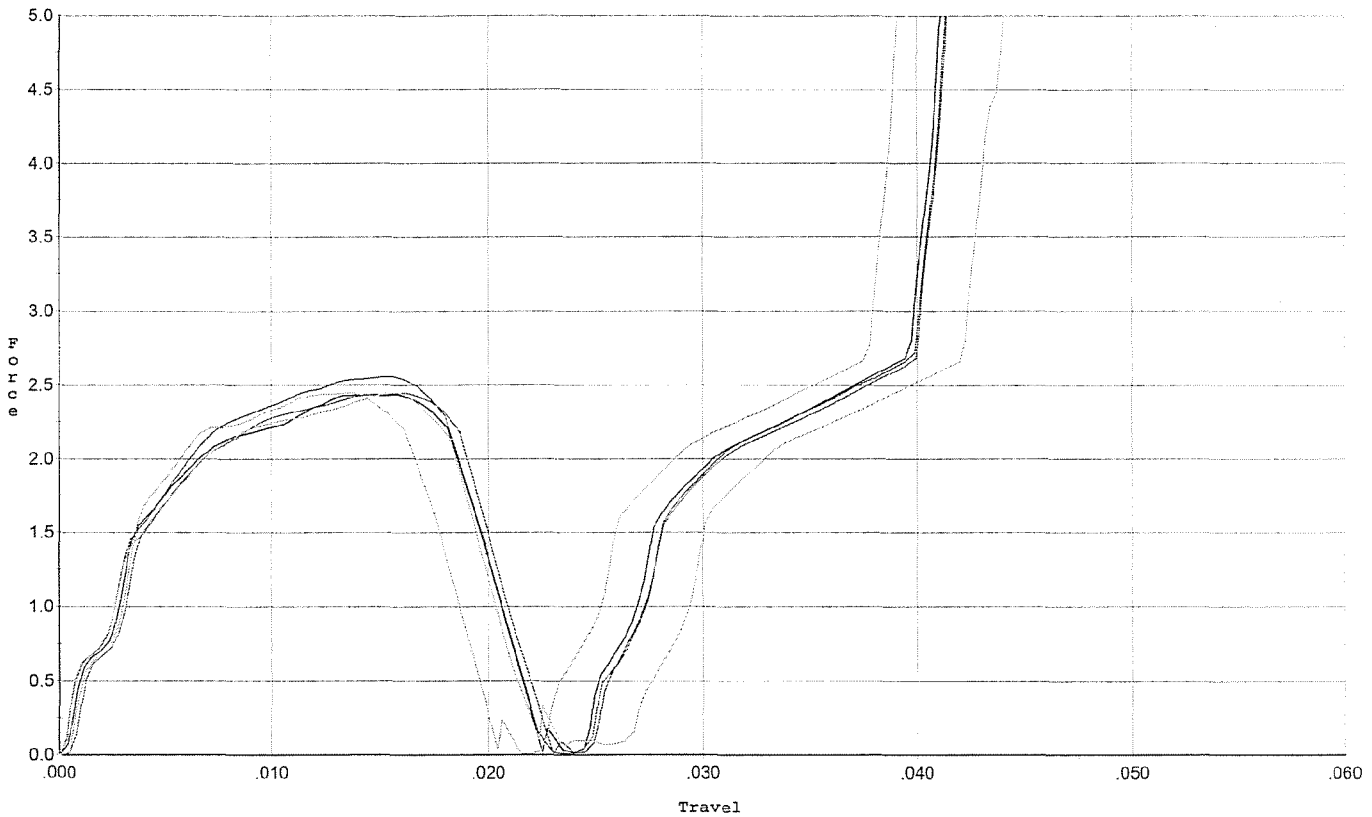
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.8</u> <u>2.8</u> <u>2.9</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.7</u> <u>4.6</u> <u>4.6</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-8-09	RJ
	K) ASSEMBLE SWIVEL STUDS		4-17-09	RP
	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	4-9-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.47</u> <u>2.33</u> <u>2.41</u> <u>2.47</u>	4-14-09	WV
	C) FUNCTION		4-17-09	RP
690	PACK		4-29-09	WV

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



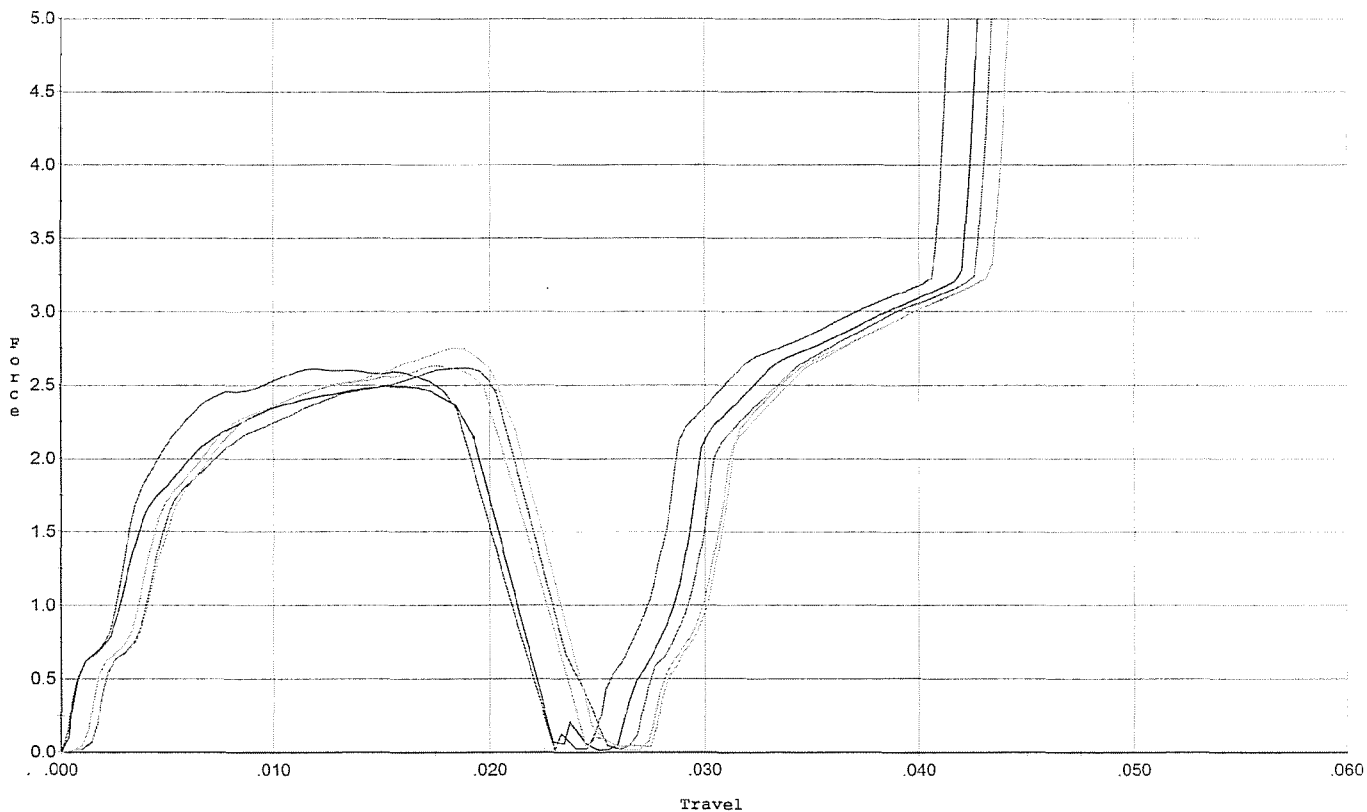
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.559	0.020	0.00	0.027	0.037		Set Trigger
2	2.439	0.020	0.00	0.027	0.036		Set Trigger
3	2.449	0.019	0.00	0.027	0.033		Set Trigger
4	2.454	0.018	0.00	0.030	0.033		Set Trigger
5	2.450	0.018	0.00	0.026	0.031		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



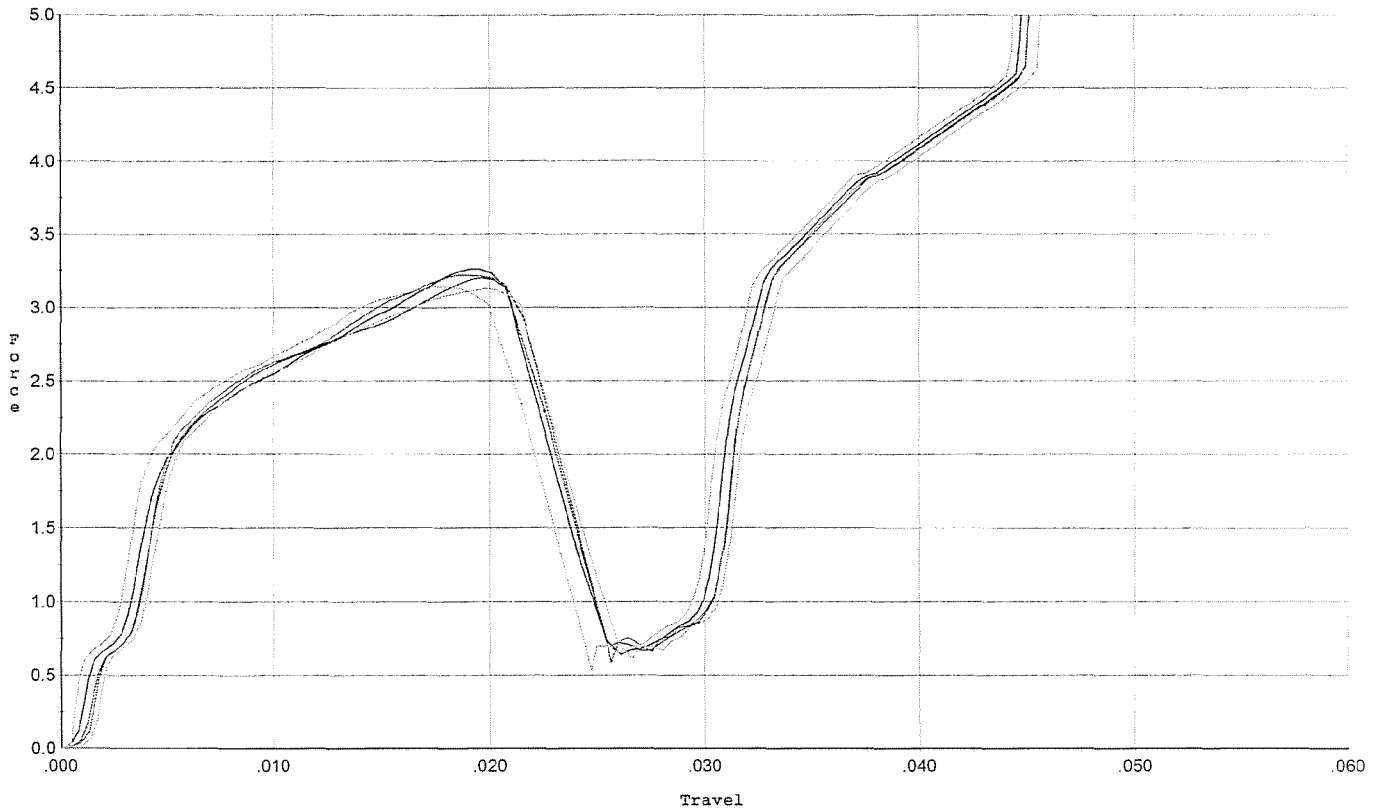
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.613	0.018	0.00	0.027	0.037		Set Trigger
2	2.495	0.019	0.00	0.029	0.036		Set Trigger
3	2.617	0.020	0.00	0.028	0.037		Set Trigger
4	2.752	0.021	0.00	0.029	0.040		Set Trigger
5	2.633	0.022	0.00	0.029	0.041		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



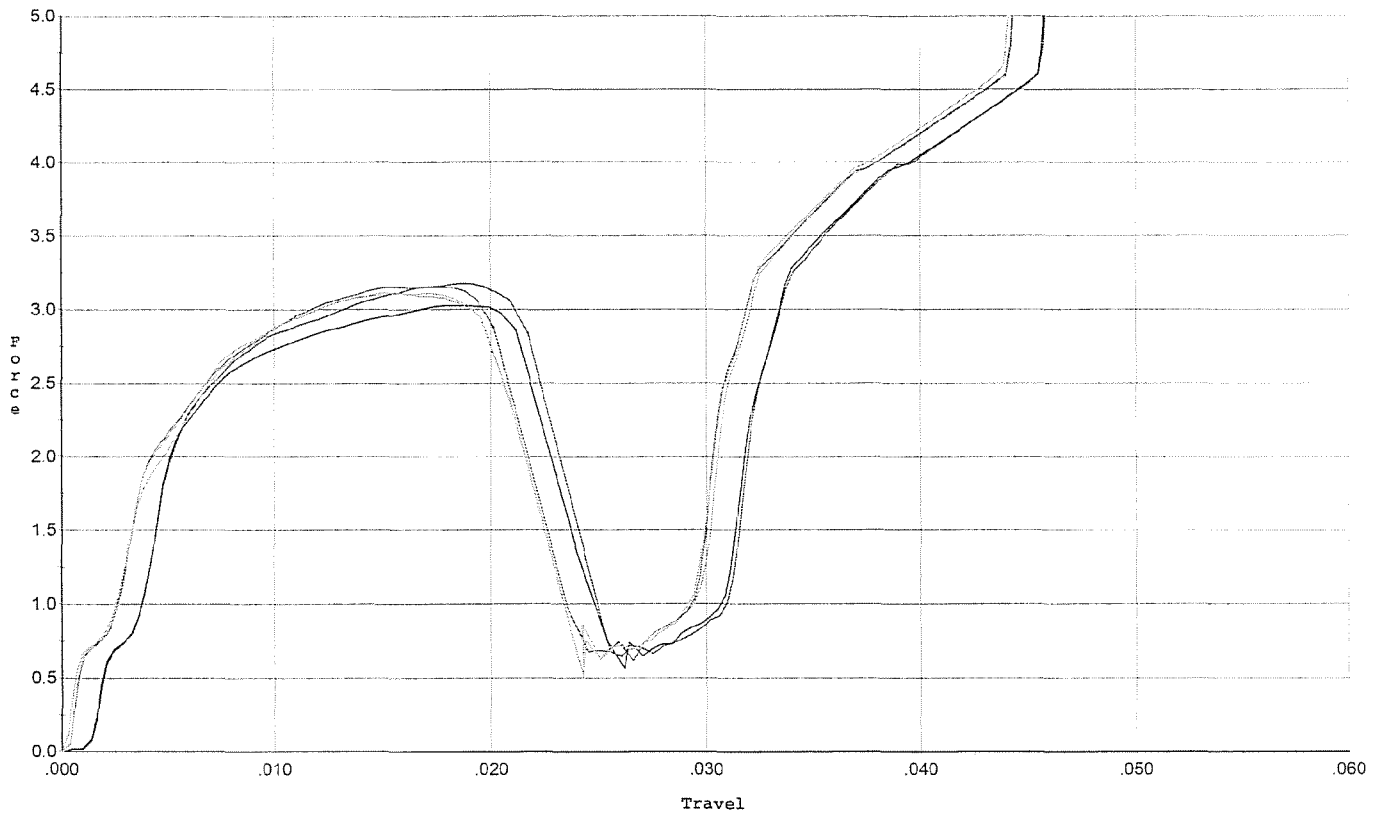
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.201	0.023	0.00	0.028	0.049		Set Trigger
2	3.261	0.021	0.00	0.028	0.046		Set Trigger
3	3.221	0.022	0.00	0.028	0.047		Set Trigger
4	3.129	0.021	0.00	0.028	0.046		Set Trigger
5	3.141	0.021	0.00	0.028	0.048		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



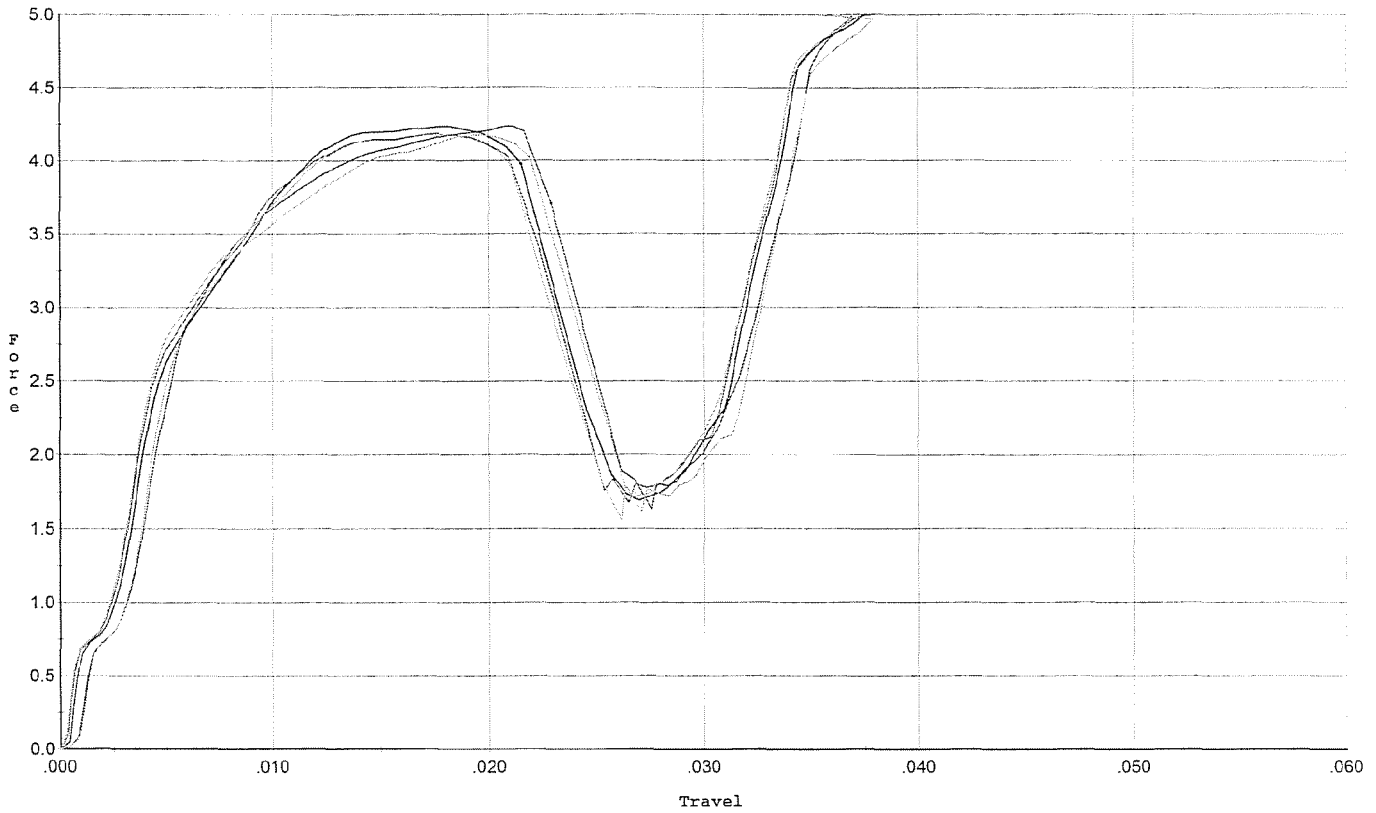
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.179	0.022	0.00	0.028	0.049		Set Trigger
2	3.028	0.021	0.00	0.029	0.046		Set Trigger
3	3.155	0.020	0.00	0.028	0.047		Set Trigger
4	3.114	0.021	0.00	0.028	0.048		Set Trigger
5	3.107	0.021	0.00	0.028	0.047		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



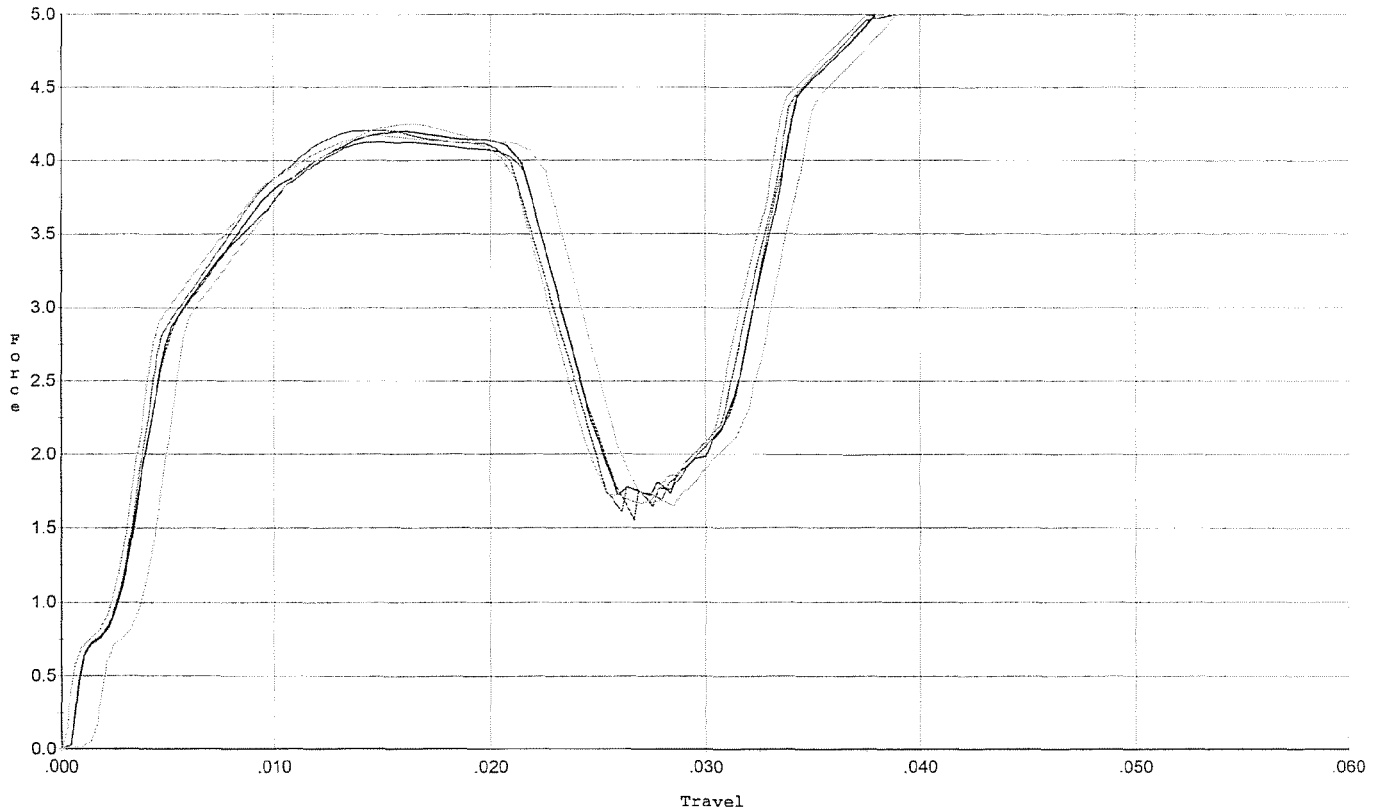
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.236	0.023	0.00	0.021	0.067		Set Trigger
2	4.235	0.021	0.00	0.021	0.064		Set Trigger
3	4.182	0.022	0.00	0.022	0.067		Set Trigger
4	4.187	0.021	0.00	0.023	0.063		Set Trigger
5	4.173	0.022	0.00	0.021	0.064		Set Trigger

A-420

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



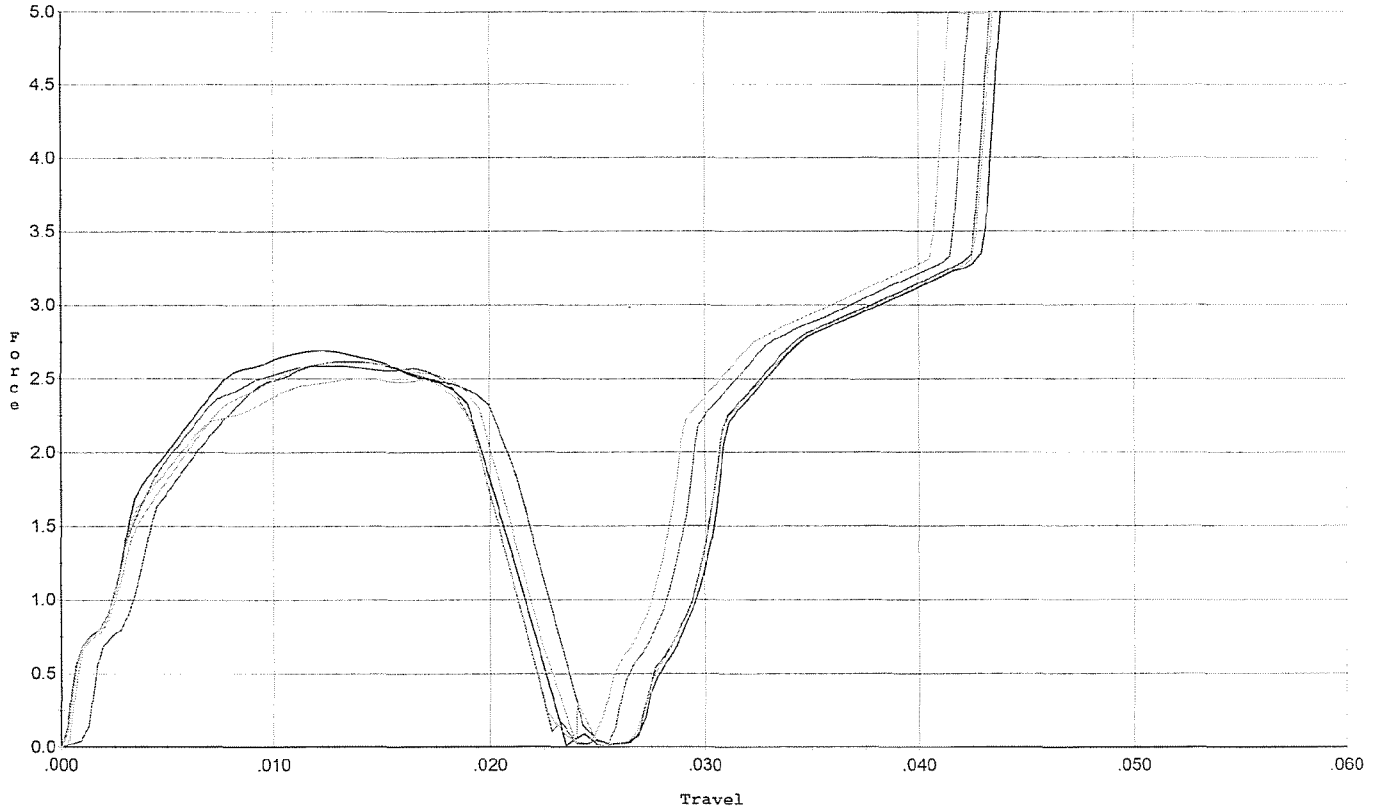
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.126	0.022	0.00	0.022	0.064		Set Trigger
2	4.199	0.021	0.00	0.021	0.064		Set Trigger
3	4.204	0.023	0.00	0.021	0.070		Set Trigger
4	4.251	0.023	0.00	0.021	0.066		Set Trigger
5	4.169	0.021	0.00	0.024	0.064		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



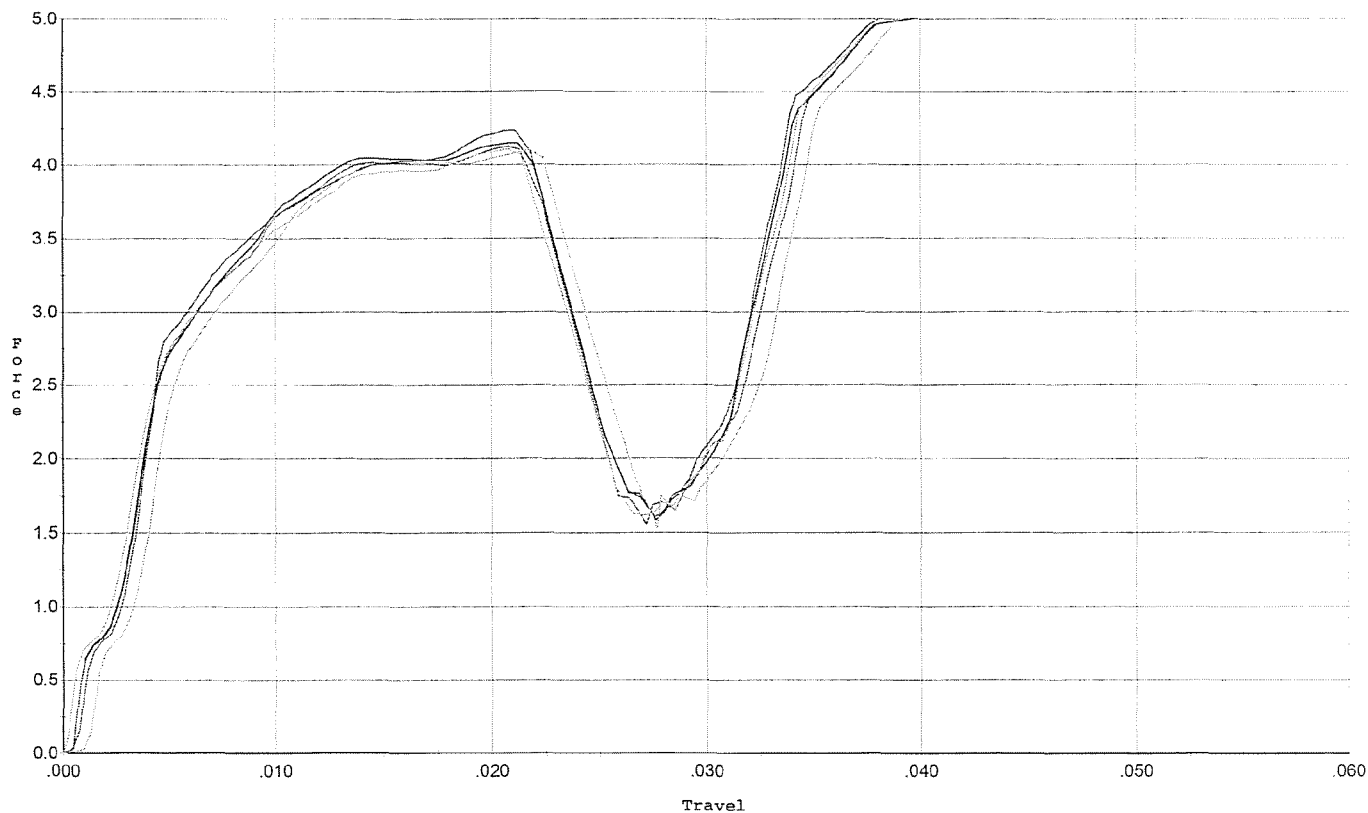
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.021	0.00	0.028	0.040		Set Trigger
2	2.691	0.021	0.00	0.030	0.042		Set Trigger
3	2.585	0.019	0.00	0.028	0.038		Set Trigger
4	2.499	0.019	0.00	0.027	0.037		Set Trigger
5	2.612	0.019	0.00	0.029	0.038		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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	4.238	0.022	0.00	0.021	0.065		Set Trigger
2	4.147	0.022	0.00	0.021	0.065		Set Trigger
3	4.124	0.022	0.00	0.021	0.066		Set Trigger
4	4.109	0.023	0.00	0.021	0.068		Set Trigger
5	4.100	0.022	0.00	0.021	0.064		Set Trigger

A-4.14