

G6845314

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



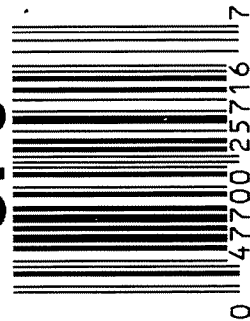
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845314

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845314

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	RJ
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR H	3-20-09	H
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		4-9-09	XJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

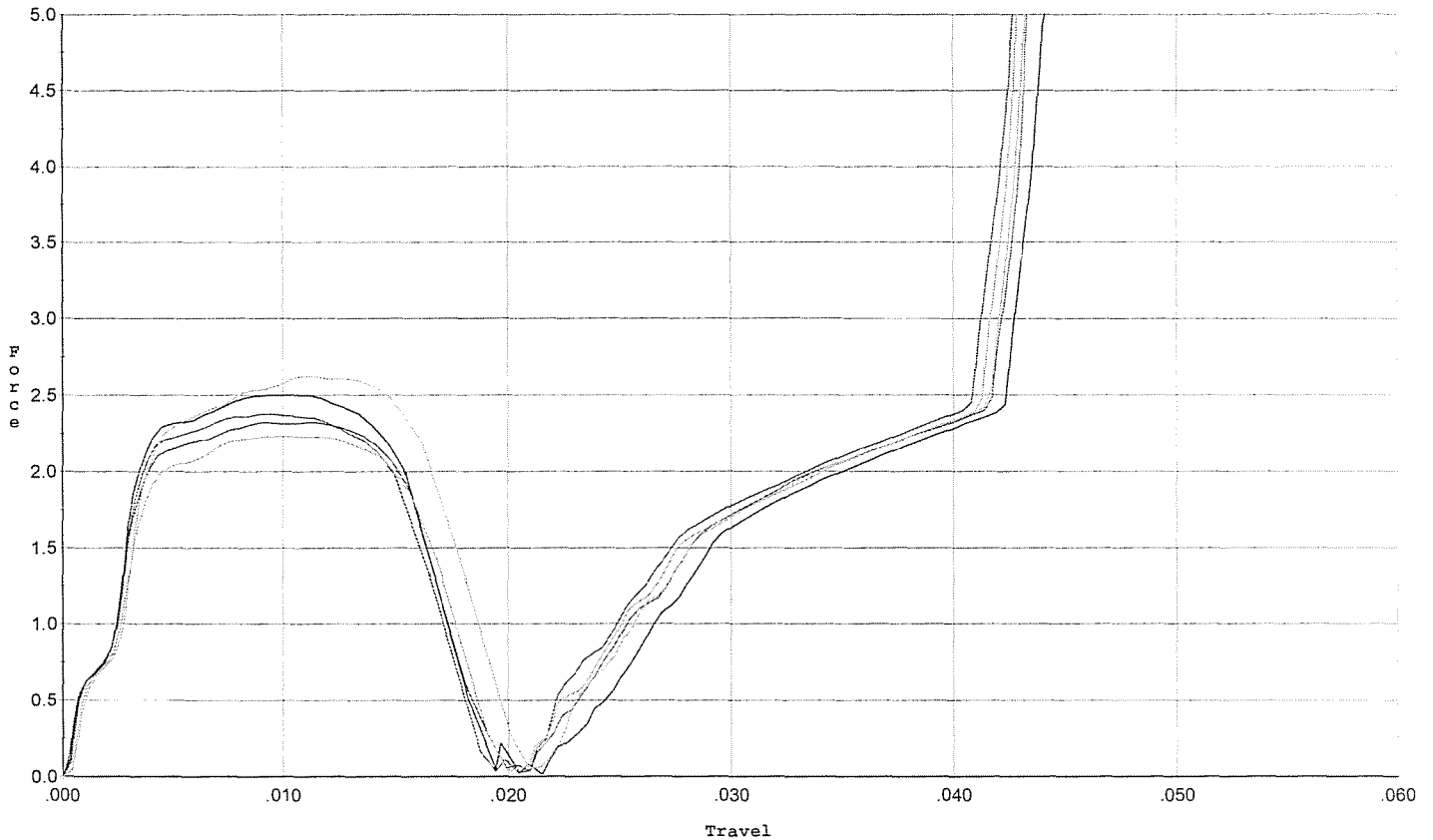
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>0</u> <u>0</u> <u>0</u>	4-17-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-17-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-17-09	NW
	J) ASSEMBLE STOCK		4-9-09	L.S.D.
	K) ASSEMBLE SWIVEL STUDS		4-17-09	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	PASS FAIL PASS FAIL	4-14-09	L.S.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-14-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-17-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.61</u> <u>2.45</u> <u>2.54</u> <u>2.51</u>	4-15-09	RP
	C) FUNCTION		4-17-09	NW
690	PACK		5/30/09	FM

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



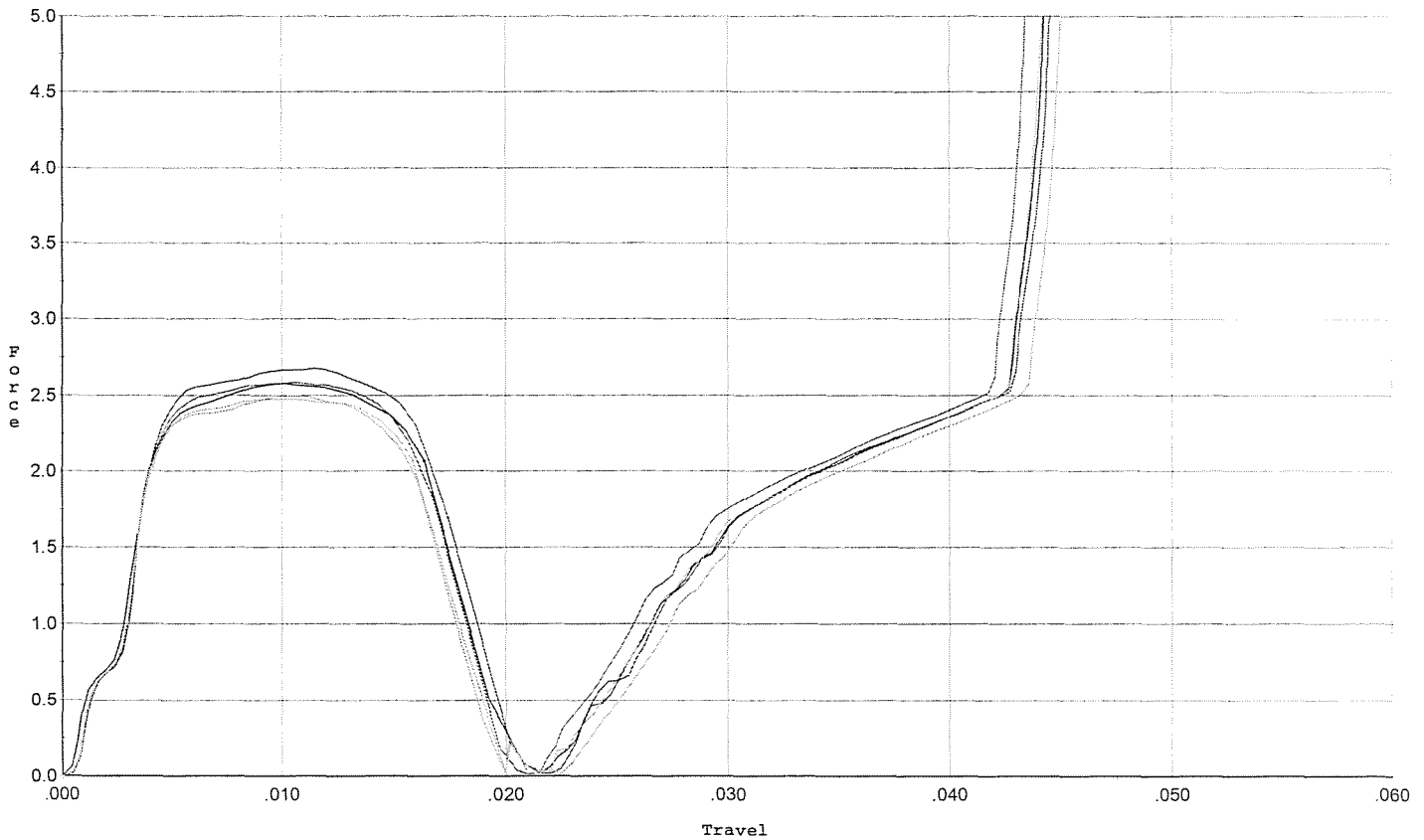
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.323	0.016	0.00	0.031	0.028		Set Trigger
2	2.499	0.015	0.00	0.033	0.029		Set Trigger
3	2.379	0.016	0.00	0.032	0.030		Set Trigger
4	2.626	0.018	0.00	0.030	0.034		Set Trigger
5	2.233	0.017	0.00	0.031	0.029		Set Trigger

A-2.41

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



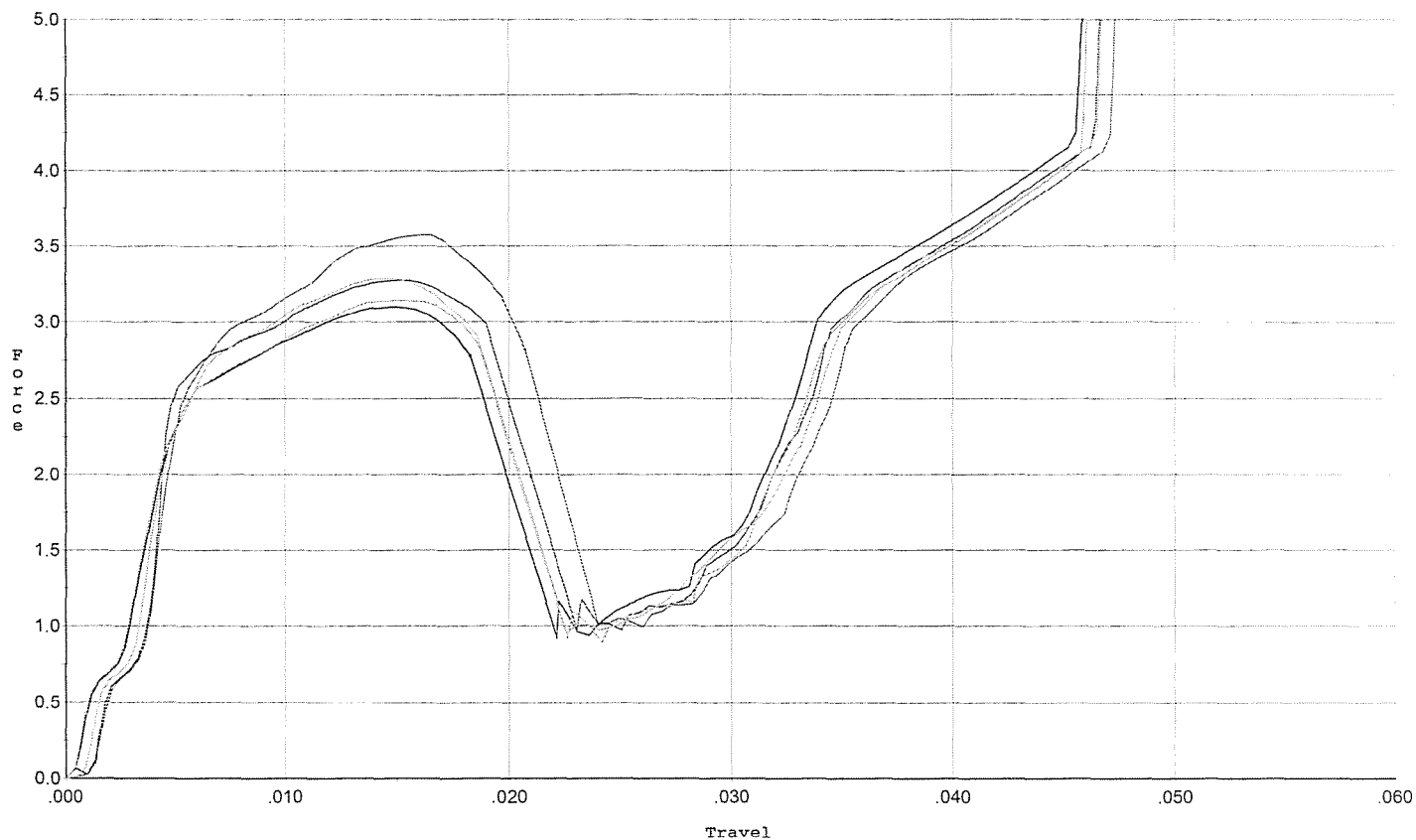
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.676	0.017	0.00	0.031	0.034		Set Trigger
2	2.580	0.016	0.00	0.032	0.031		Set Trigger
3	2.585	0.017	0.00	0.031	0.032		Set Trigger
4	2.476	0.016	0.00	0.032	0.029		Set Trigger
5	2.499	0.016	0.00	0.033	0.029		Set Trigger

A-2-56

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



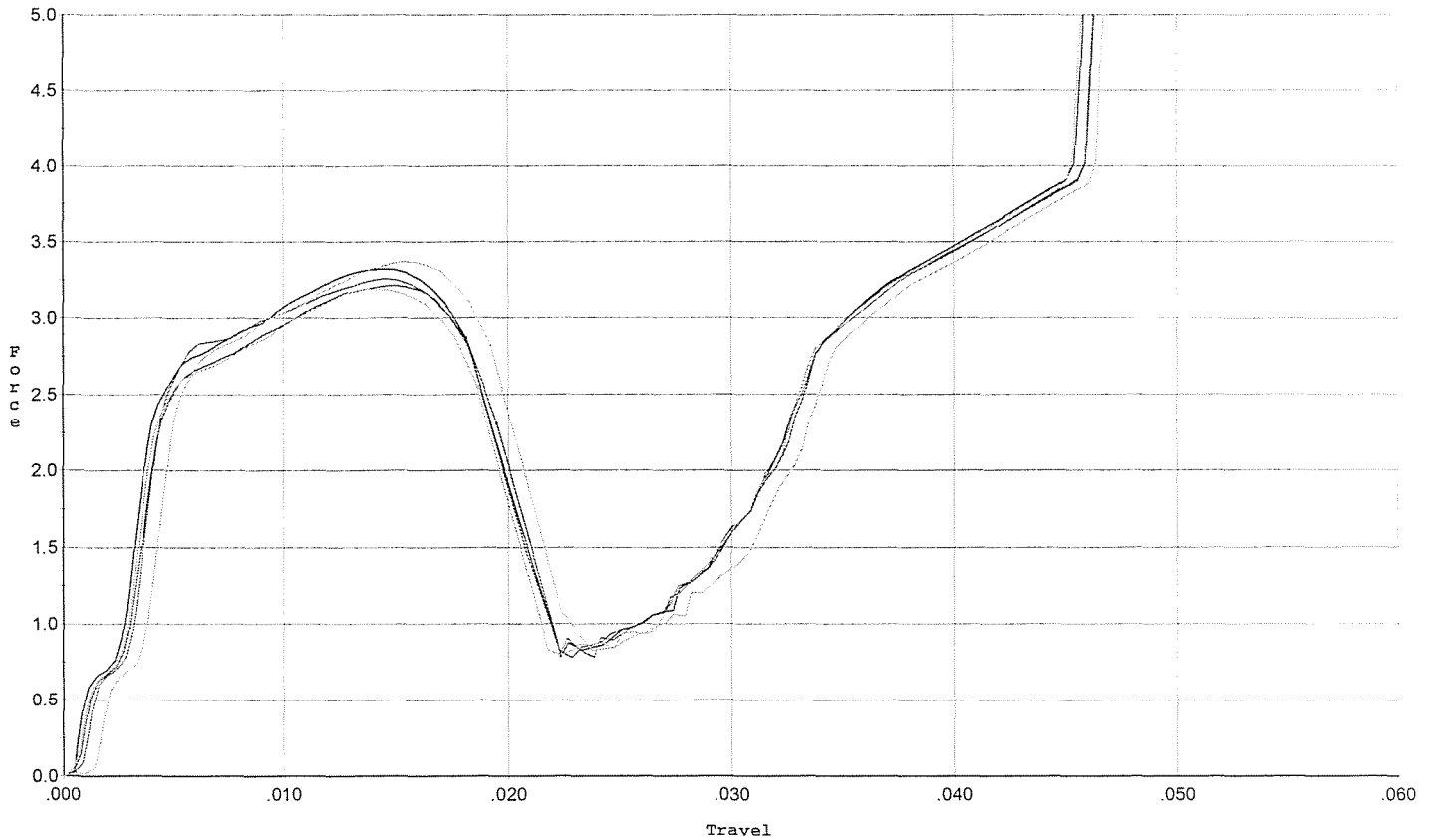
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.278	0.021	0.00	0.030	0.048		Set Trigger
2	3.100	0.018	0.00	0.030	0.041		Set Trigger
3	3.574	0.021	0.00	0.030	0.050		Set Trigger
4	3.288	0.020	0.00	0.031	0.047		Set Trigger
5	3.145	0.019	0.00	0.030	0.042		Set Trigger

A-3.27

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



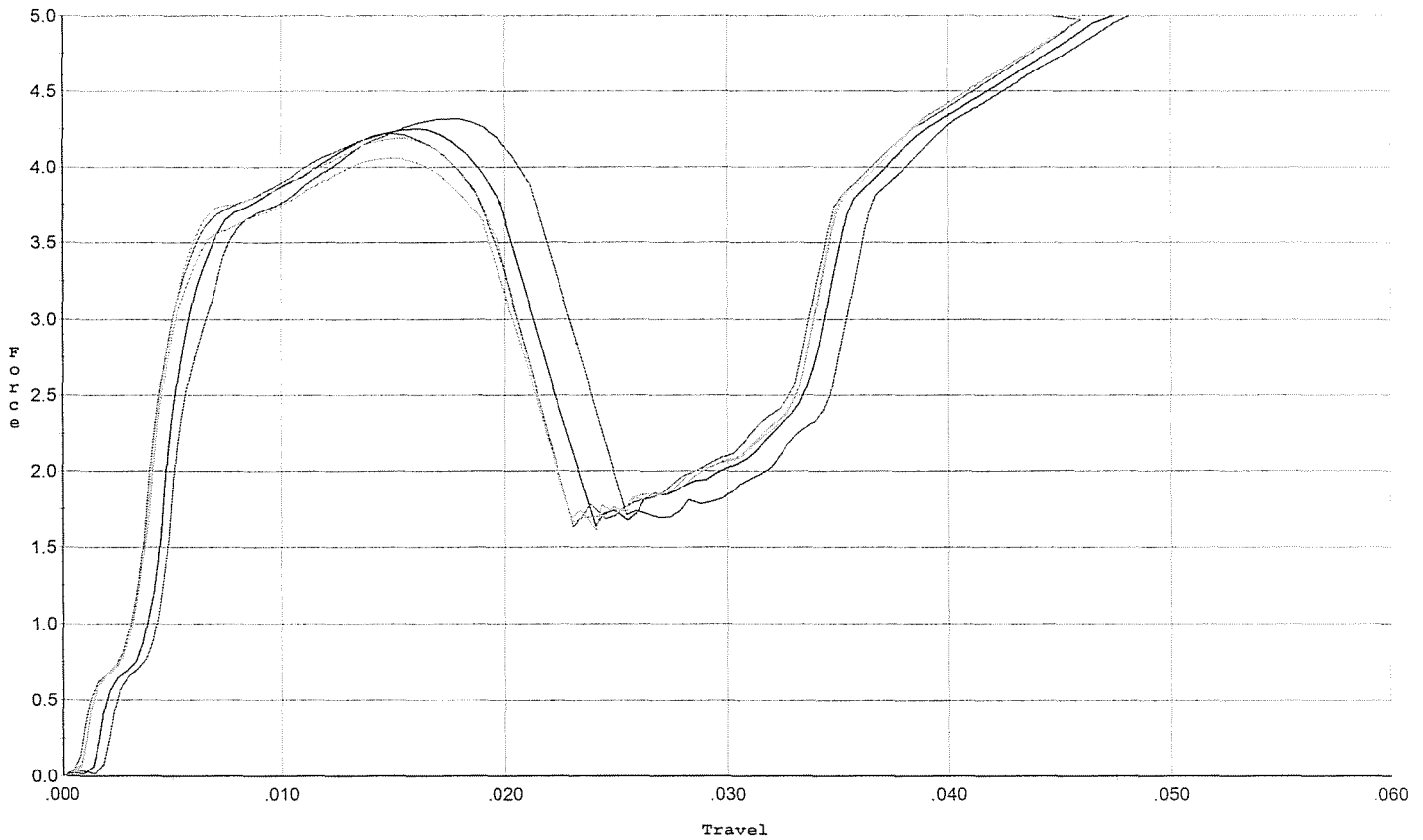
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.213	0.019	0.00	0.030	0.044		Set Trigger
2	3.323	0.018	0.00	0.030	0.043		Set Trigger
3	3.259	0.018	0.00	0.031	0.042		Set Trigger
4	3.372	0.019	0.00	0.031	0.044		Set Trigger
5	3.191	0.019	0.00	0.030	0.042		Set Trigger

A-3-27

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



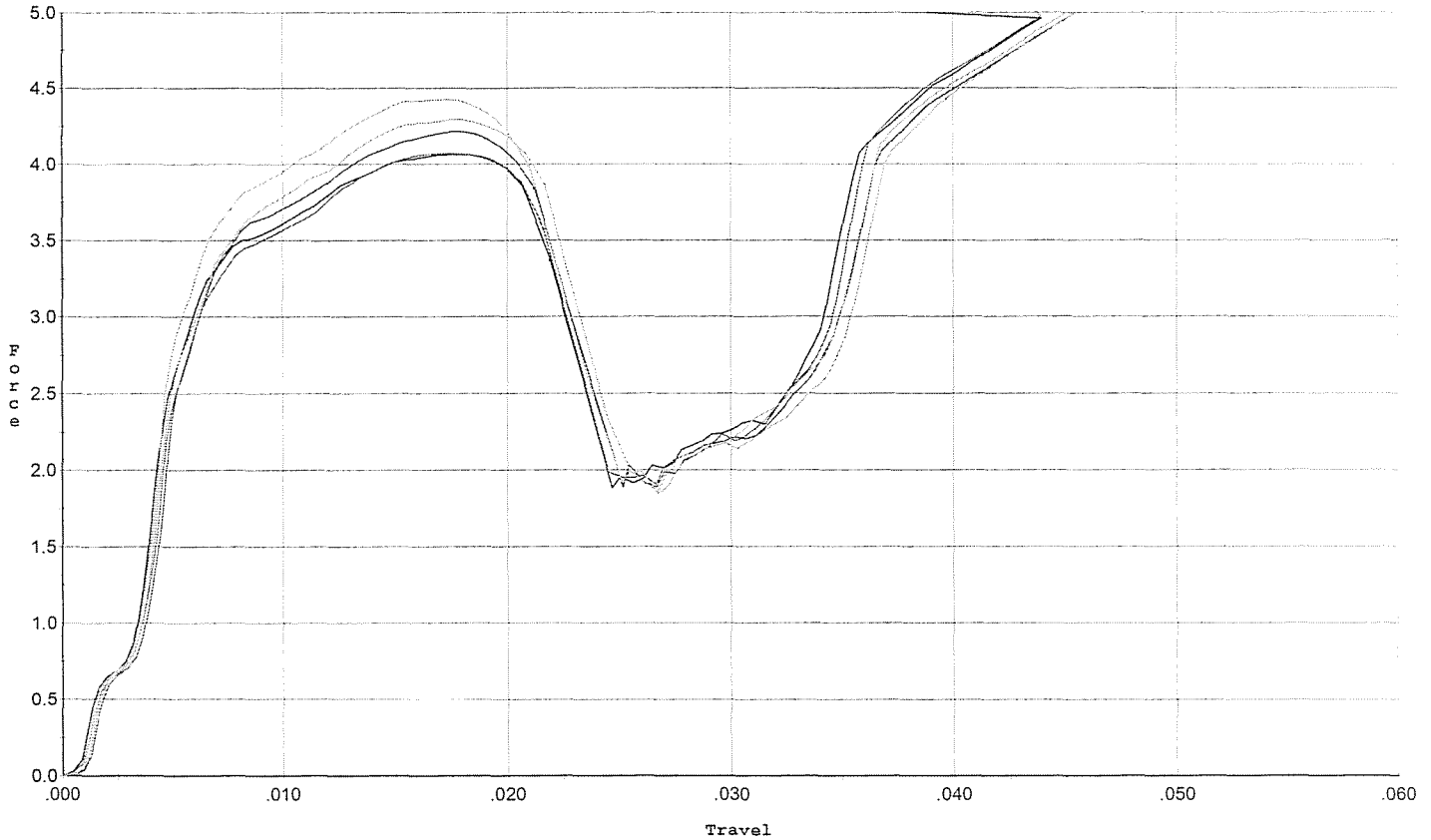
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.318	0.023	0.002	0.027	0.066		Set Trigger
2	4.254	0.020	0.00	0.028	0.056		Set Trigger
3	4.218	0.020	0.00	0.028	0.058		Set Trigger
4	4.190	0.020	0.00	0.028	0.057		Set Trigger
5	4.061	0.021	0.00	0.028	0.058		Set Trigger

A-4-20

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



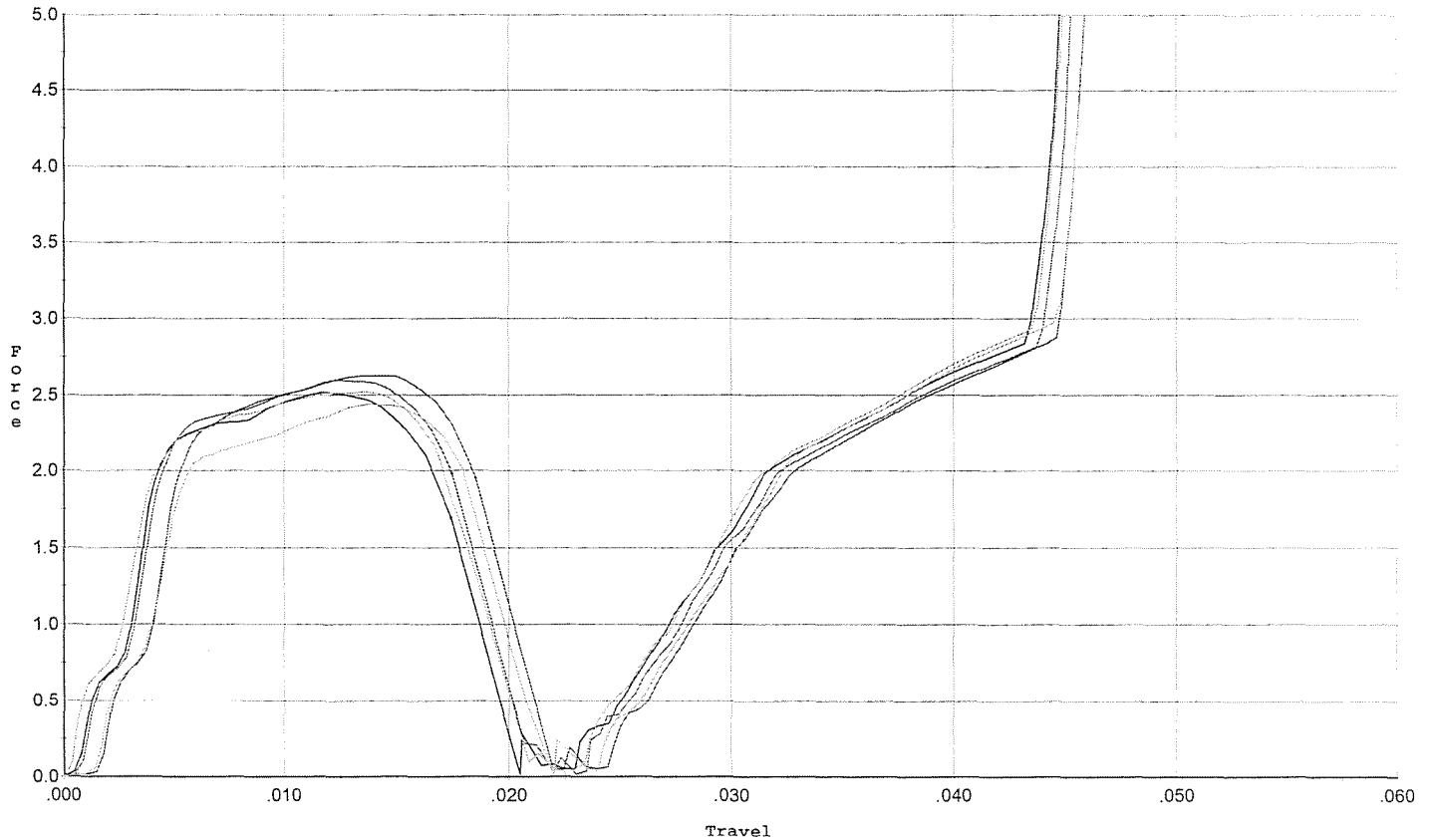
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.216	0.021	0.00	0.027	0.061		Set Trigger
2	4.064	0.022	0.00	0.026	0.062		Set Trigger
3	4.074	0.022	0.00	0.027	0.061		Set Trigger
4	4.427	0.021	0.00	0.027	0.064		Set Trigger
5	4.295	0.022	0.00	0.027	0.064		Set Trigger

A 4.21

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



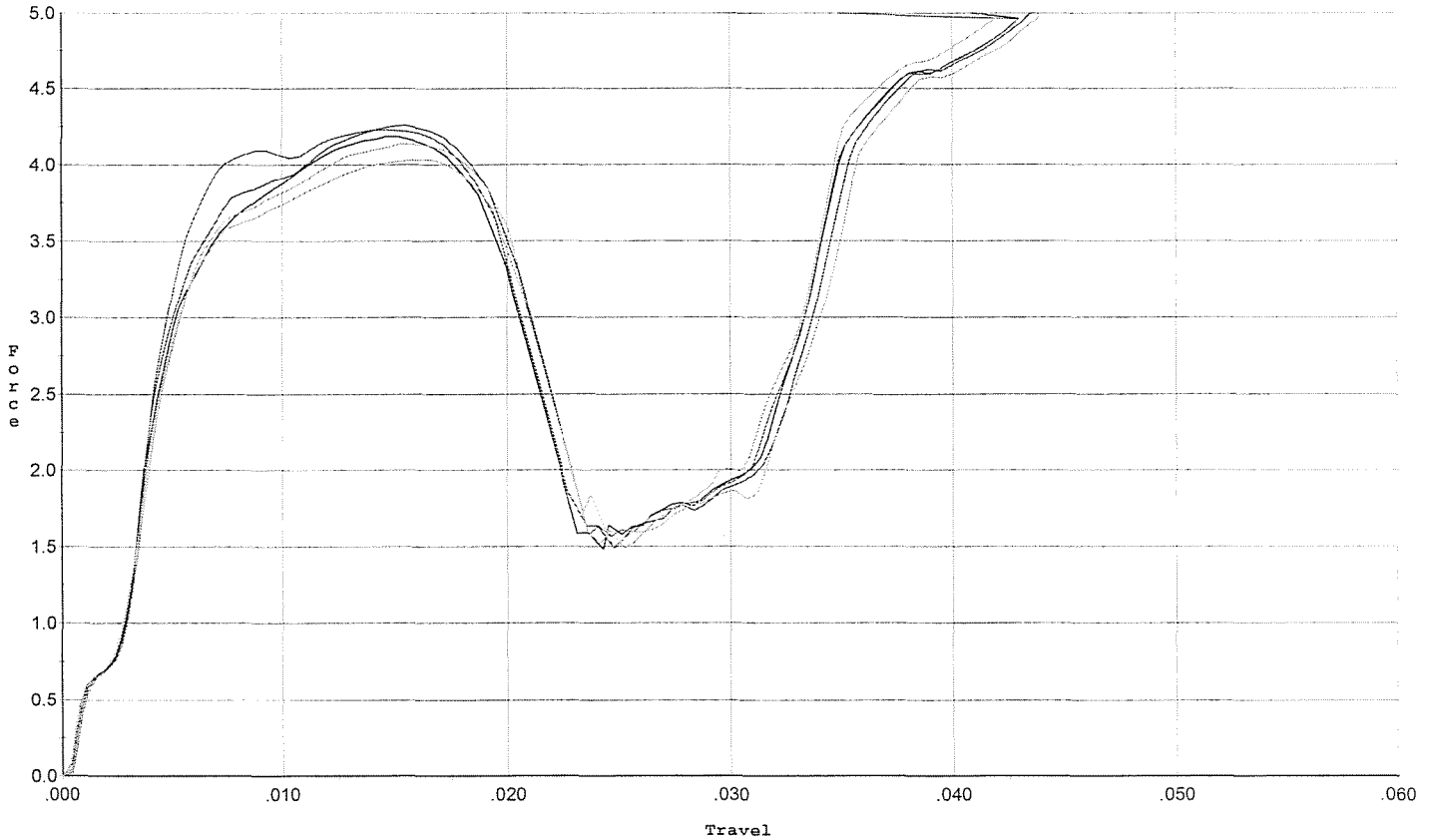
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.019	0.00	0.031	0.034		Set Trigger
2	2.518	0.017	0.00	0.031	0.032		Set Trigger
3	2.598	0.017	0.00	0.032	0.033		Set Trigger
4	2.440	0.018	0.00	0.032	0.031		Set Trigger
5	2.520	0.018	0.00	0.031	0.034		Set Trigger

A-2.54

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	4.258	0.020	0.00	0.028	0.061		Set Trigger
2	4.186	0.020	0.00	0.028	0.058		Set Trigger
3	4.230	0.019	0.00	0.028	0.059		Set Trigger
4	4.136	0.020	0.00	0.028	0.059		Set Trigger
5	4.034	0.021	0.00	0.028	0.059		Set Trigger

A-4.16