

G6784563

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

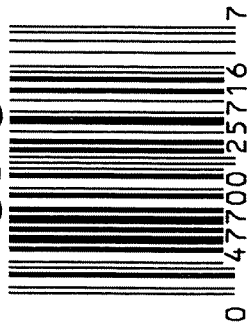


BM FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6784563

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 678 4563

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE	FLUX	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES	OCT 02 1008	9-30-08	SP
480	MAGNAFLUX BBL ACTION	OPERAT (RB)	10/2/08	(RB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DK
542	APPLY COATINGS (BARREL ACTION)		10 9	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-31-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

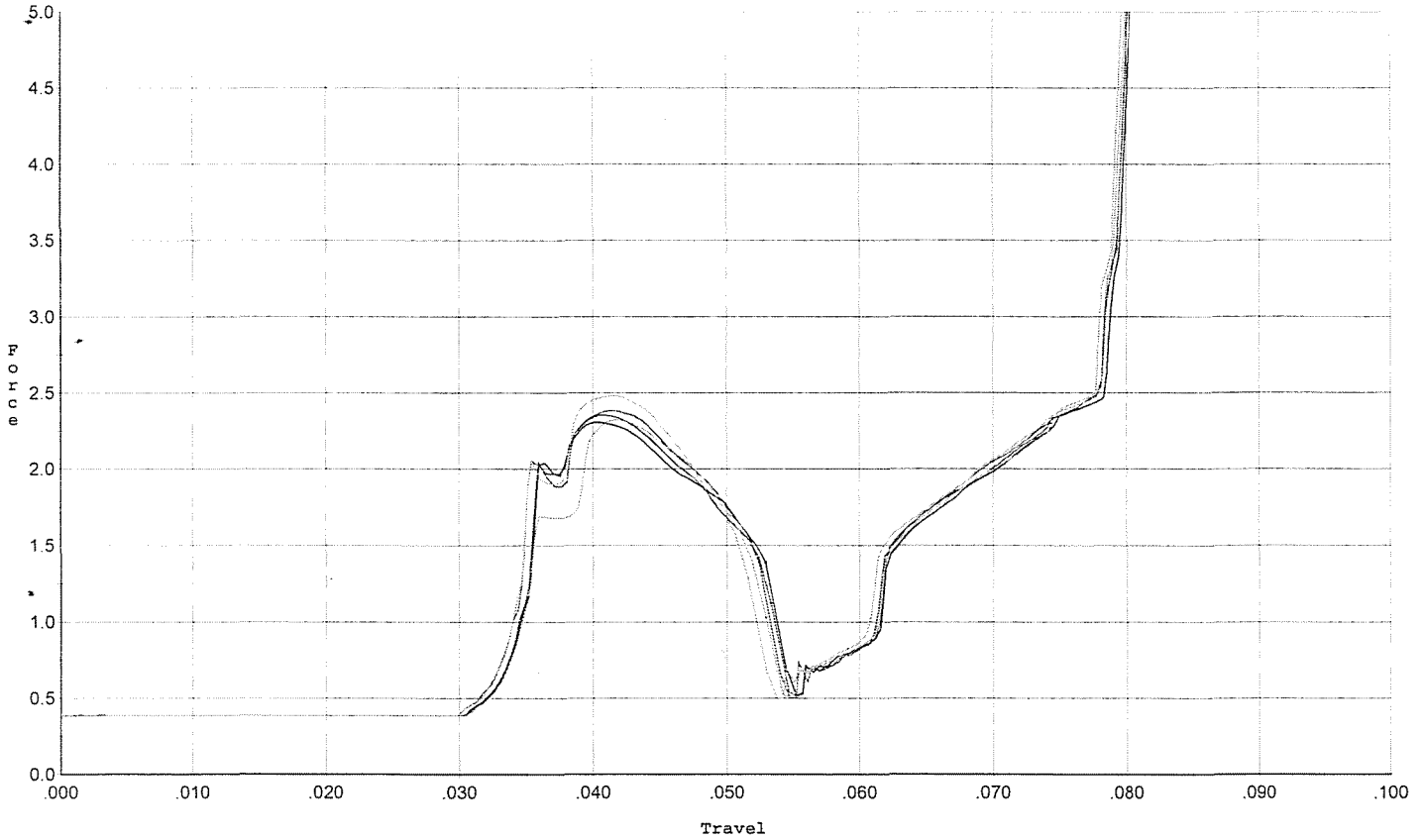
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.0</u>	<u>4.0</u>	<u>3.0</u>	11-6-08	L. J.		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u>	<u>5.0</u>	<u>5.0</u>	11-6-08	L. J.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>-.023</u>	<u>-.023</u>	<u>-.023</u>	11-6-08	R. J.		
	J) ASSEMBLE STOCK					10-31-08	L. J.		
	K) ASSEMBLE SWIVEL STUDS					11-6-08	L. J.		
	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		11-3-08	L. J.		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					11-3-08	TC		
670	FINAL INSPECTION A) HEADSPACE					11-6-08	L. J.		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u>	<u>2.42</u>	<u>2.31</u>	<u>2.38</u>	<u>2.43</u>	11-5-08	Fm
	C) FUNCTION					11-6-08	L. J.		
690	PACK					11/7/08	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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



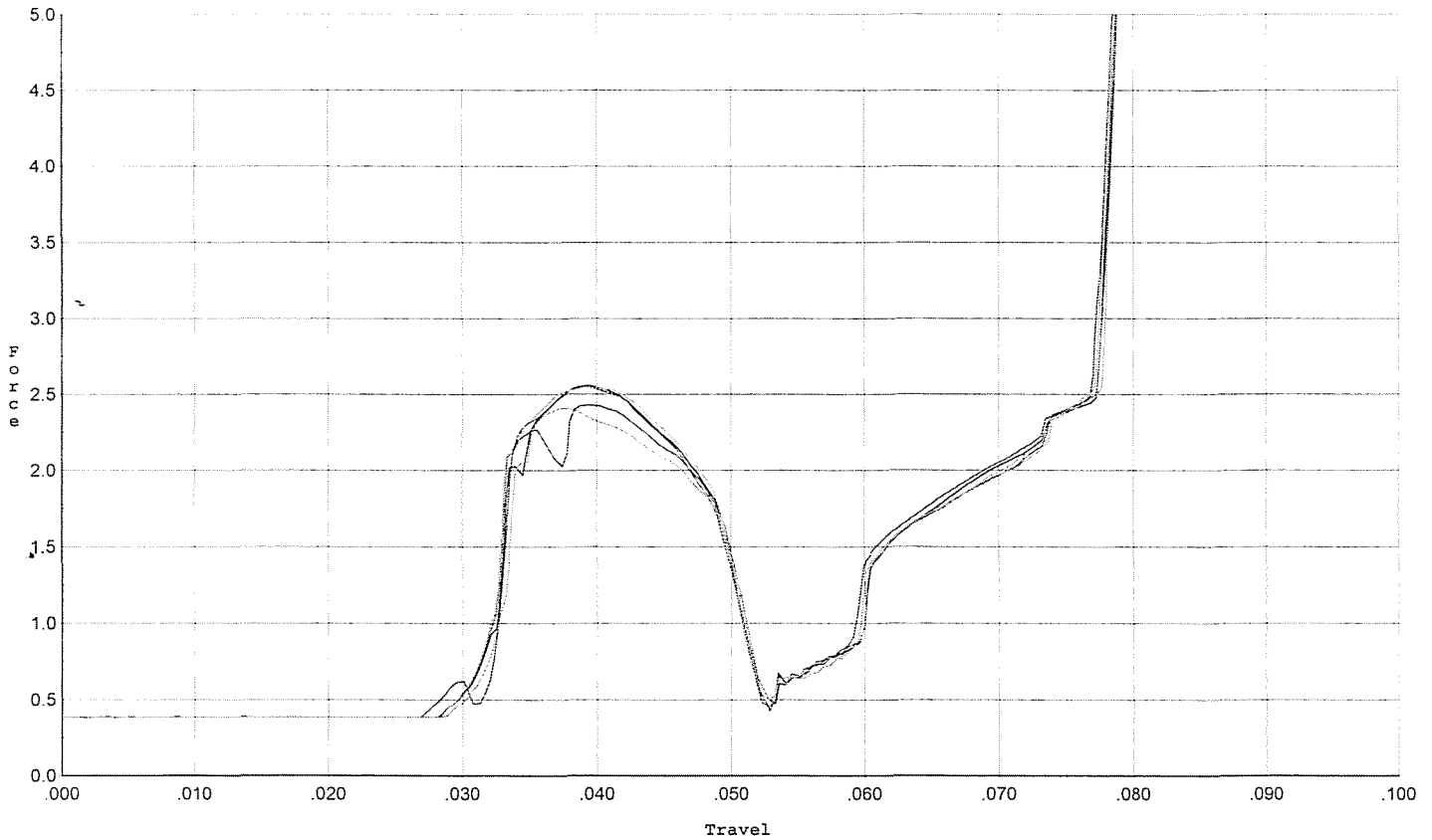
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.352	0.053	0.033	0.034	0.050		Set Trigger
2	2.306	0.053	0.033	0.034	0.050		Set Trigger
3	2.384	0.052	0.033	0.034	0.051		Set Trigger
4	2.480	0.052	0.033	0.034	0.050		Set Trigger
5	2.320	0.053	0.033	0.034	0.048		Set Trigger

A-236

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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

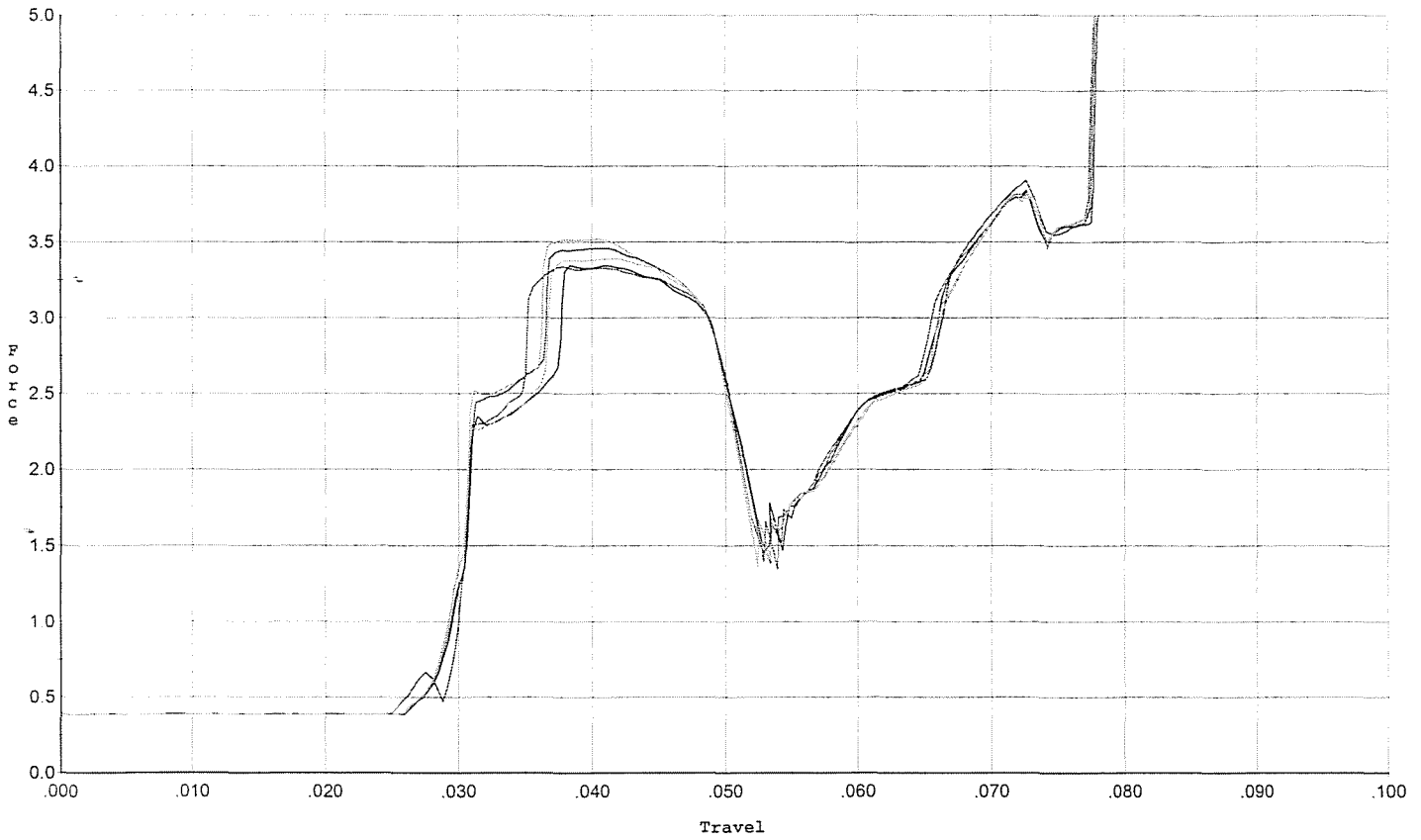


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.429	0.050	0.032	0.034	0.050		Set Trigger
2	2.558	0.051	0.031	0.033	0.053		Set Trigger
3	2.553	0.050	0.030	0.033	0.052		Set Trigger
4	2.550	0.050	0.030	0.033	0.052		Set Trigger
5	2.409	0.051	0.031	0.034	0.050		Set Trigger

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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



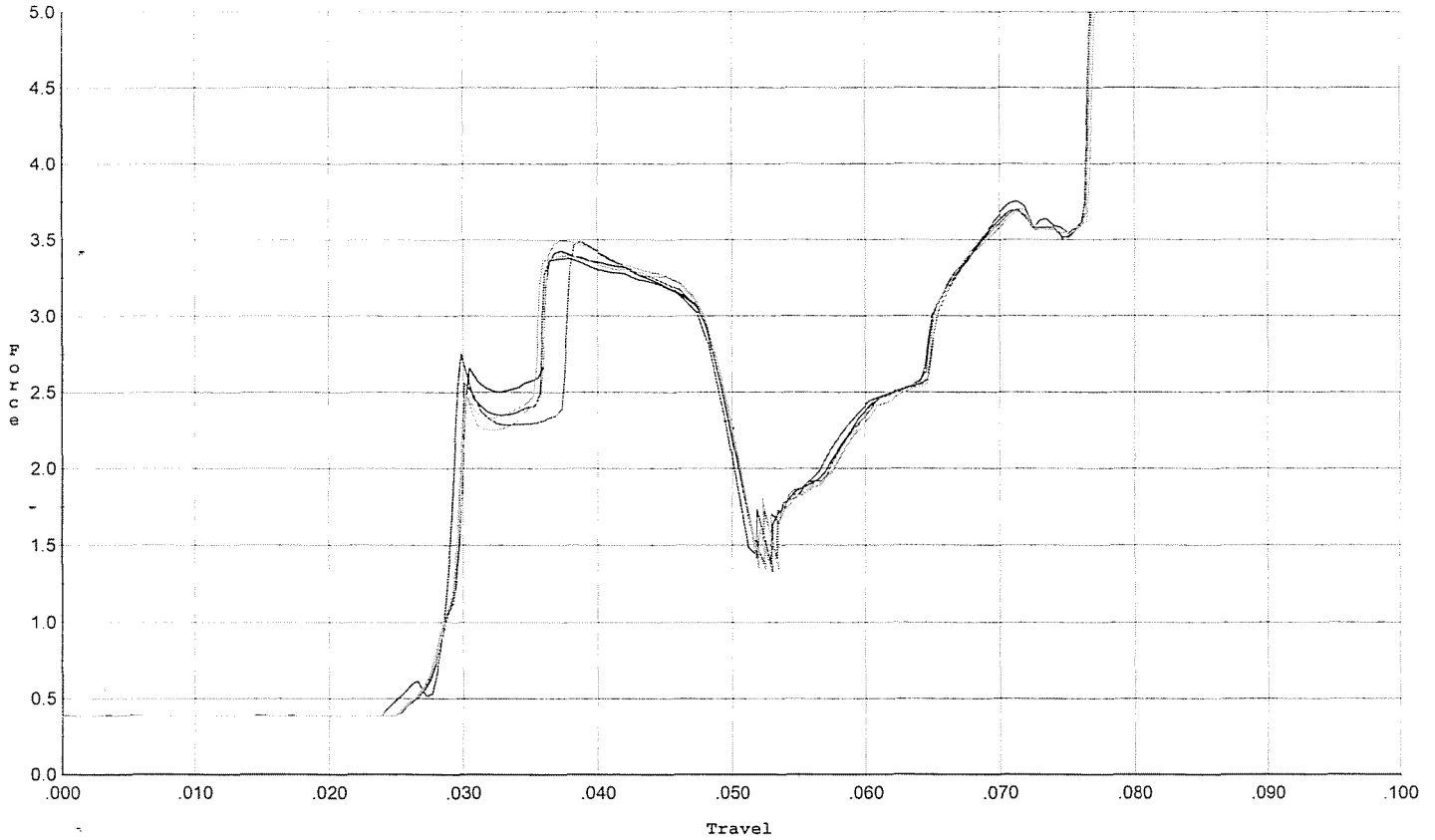
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.459	0.050	0.027	0.031	0.073		Set Trigger
2	3.347	0.051	0.028	0.031	0.072		Set Trigger
3	3.340	0.051	0.028	0.031	0.074		Set Trigger
4	3.394	0.050	0.026	0.031	0.072		Set Trigger
5	3.519	0.050	0.028	0.031	0.074		Set Trigger

A 3.41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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



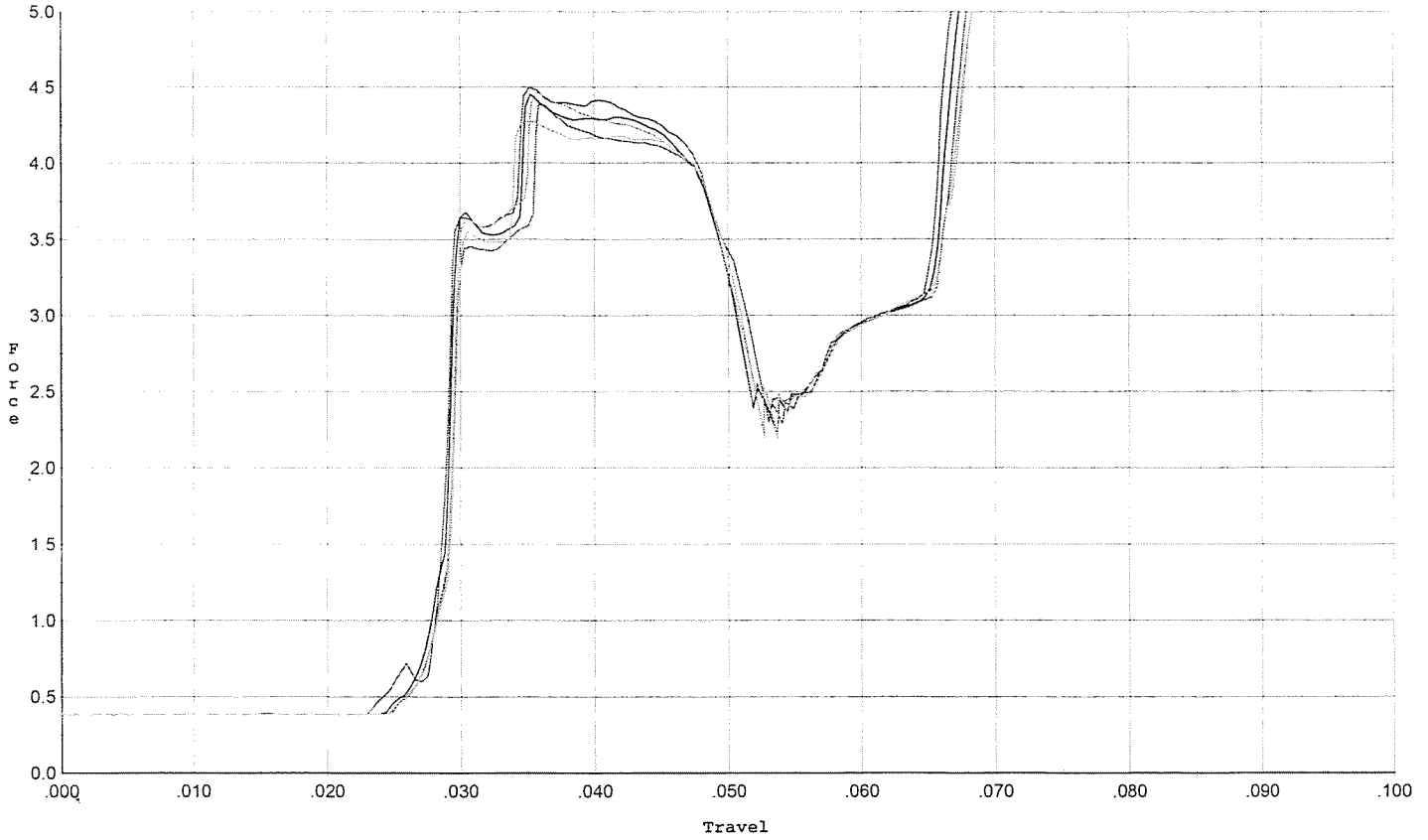
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.377	0.049	0.028	0.030	0.072		Set Trigger
2	3.426	0.050	0.028	0.030	0.073		Set Trigger
3	3.489	0.050	0.027	0.030	0.071		Set Trigger
4	3.398	0.050	0.028	0.030	0.073		Set Trigger
5	3.493	0.050	0.027	0.030	0.073		Set Trigger

A-3-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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



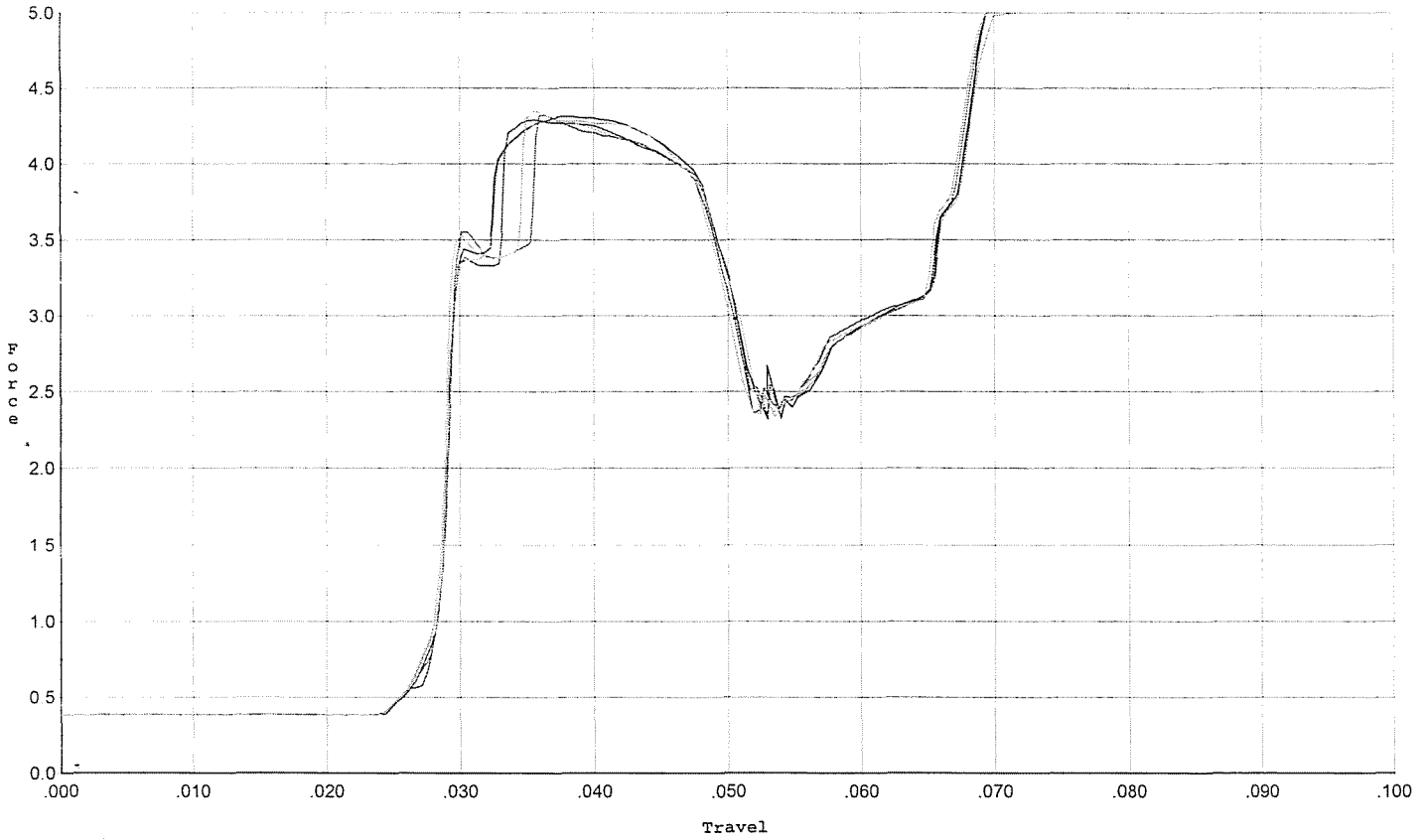
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.497	0.051	0.025	0.021	0.102		Set Trigger
2	4.453	0.050	0.027	0.023	0.096		Set Trigger
3	4.383	0.050	0.027	0.023	0.093		Set Trigger
4	4.275	0.051	0.027	0.023	0.096		Set Trigger
5	4.462	0.051	0.025	0.023	0.098		Set Trigger

A-4-41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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



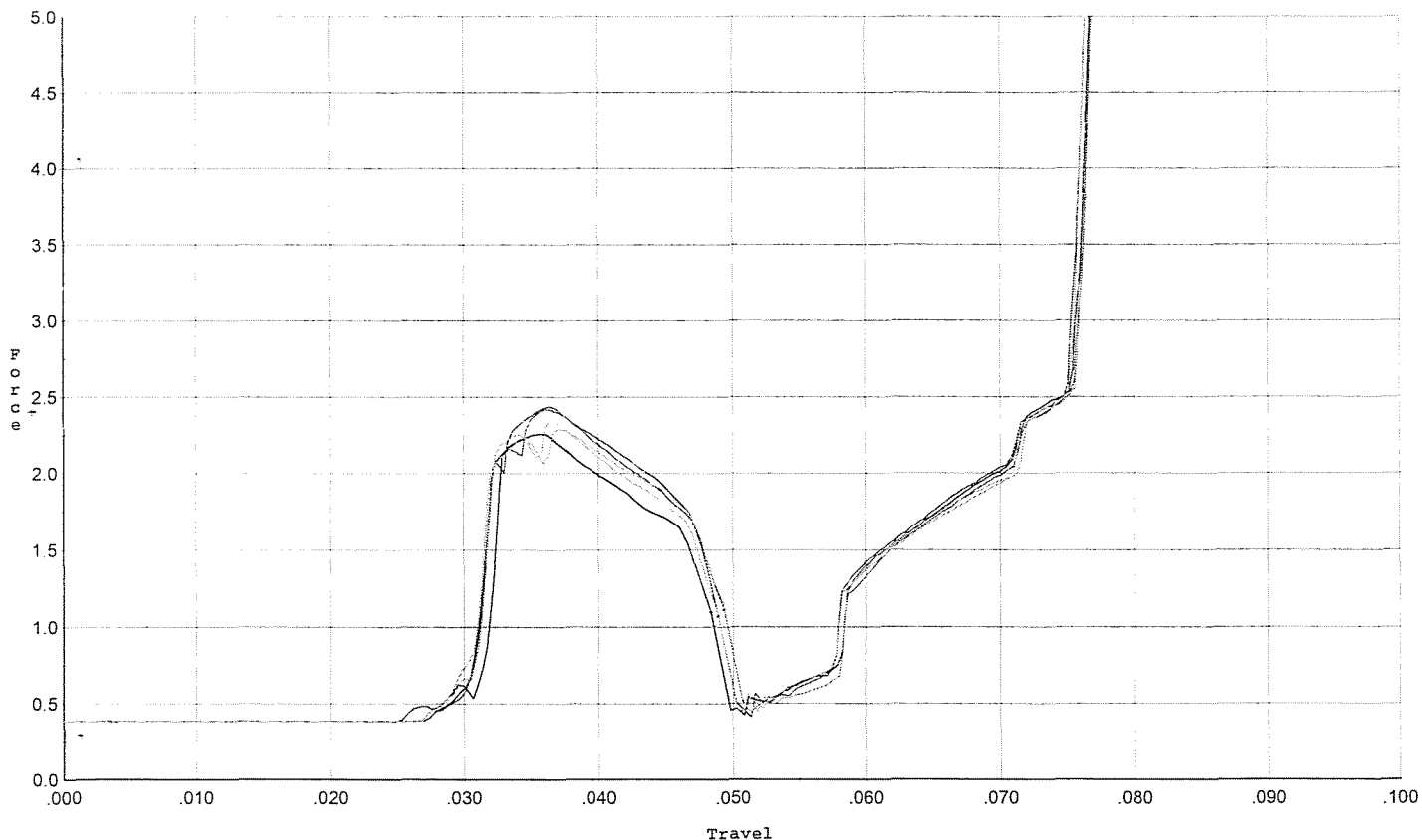
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.286	0.050	0.027	0.028	0.095		Set Trigger
2	4.312	0.050	0.027	0.028	0.096		Set Trigger
3	4.320	0.050	0.025	0.029	0.093		Set Trigger
4	4.347	0.050	0.026	0.029	0.093		Set Trigger
5	4.281	0.051	0.027	0.029	0.098		Set Trigger

A-430

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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



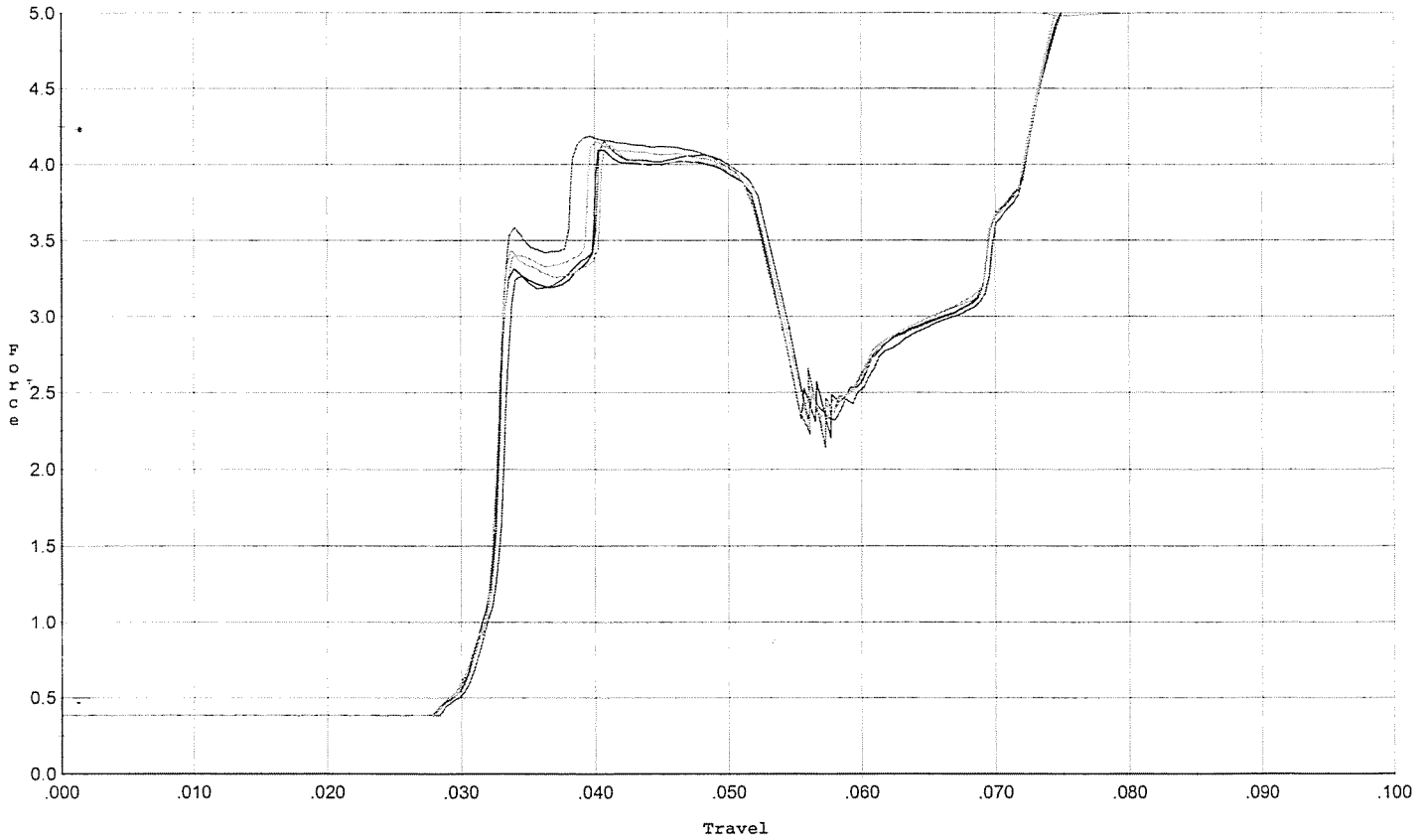
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.433	0.049	0.030	0.032	0.049		Set Trigger
2	2.256	0.048	0.031	0.033	0.044		Set Trigger
3	2.413	0.049	0.030	0.032	0.049		Set Trigger
4	2.340	0.049	0.030	0.032	0.047		Set Trigger
5	2.291	0.049	0.029	0.032	0.048		Set Trigger

A-2.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lbs for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.055	0.031	0.030	0.093		Set Trigger
2	4.096	0.054	0.030	0.030	0.092		Set Trigger
3	4.185	0.054	0.028	0.030	0.095		Set Trigger
4	4.150	0.055	0.031	0.030	0.095		Set Trigger
5	4.123	0.054	0.030	0.030	0.092		Set Trigger

A-4.14