

G6784734

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



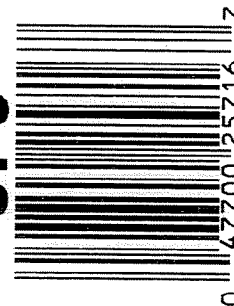
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6784734

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 678 4 734

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-9-08	SPD
430	ASSEMBLE TO STOCK		9-9-08	SP
440	PROOF		9-9-08	SPD
460	CHECK HEADSPACE		9-9-08	SPD
470	DIS-ASSEMBLE ACTION		9-9-08	SPD
472	SERIALIZE BOLT HANDLE		9-10-08	RIC
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX SEP 12 2008	9-11-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BMT	9-12-08	BMT
490	MAGNAFLUX BOLT		9/19/08	MR
500	ROLLMARK CALIBER		9/12/08	RT
520	GOFF BLAST BBL / REC		9/12/08	DS
542	APPLY COATINGS (BARREL ACTION)		9/16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-20-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	ESW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

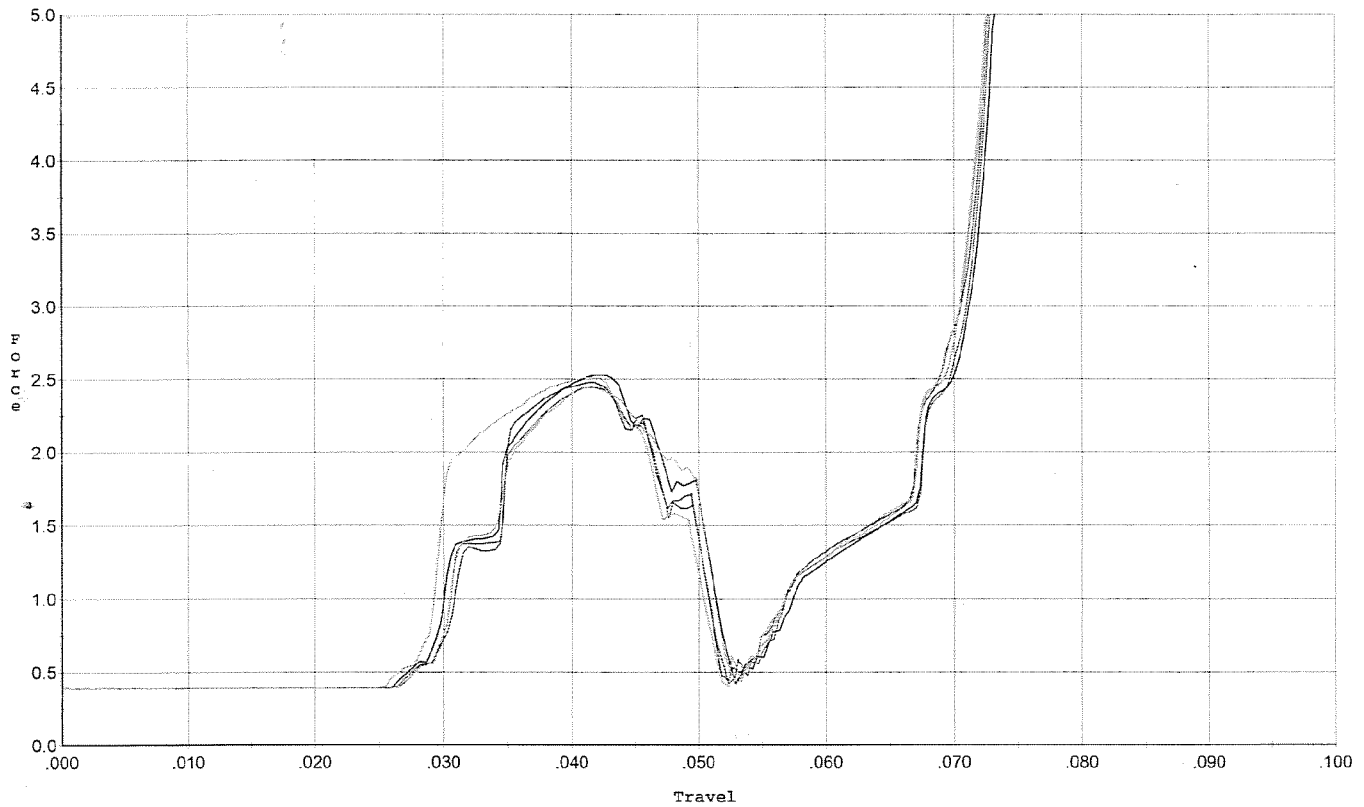
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>39</u> <u>39</u> <u>35</u>	12-2-08	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>55</u> <u>50</u> <u>50</u>	12-2-08	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-2-08	R.N.
	J) ASSEMBLE STOCK		11-12-08	R.N.
	K) ASSEMBLE SWIVEL STUDS		12-2-08	R.N.
	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	11-30-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-13-08	J
670	FINAL INSPECTION A) HEADSPACE		12-2-08	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.31</u> <u>2.34</u> <u>2.25</u> <u>2.31</u>	11-20-08	TL
	C) FUNCTION		12-2-08	R.N.
690	PACK		12-3-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



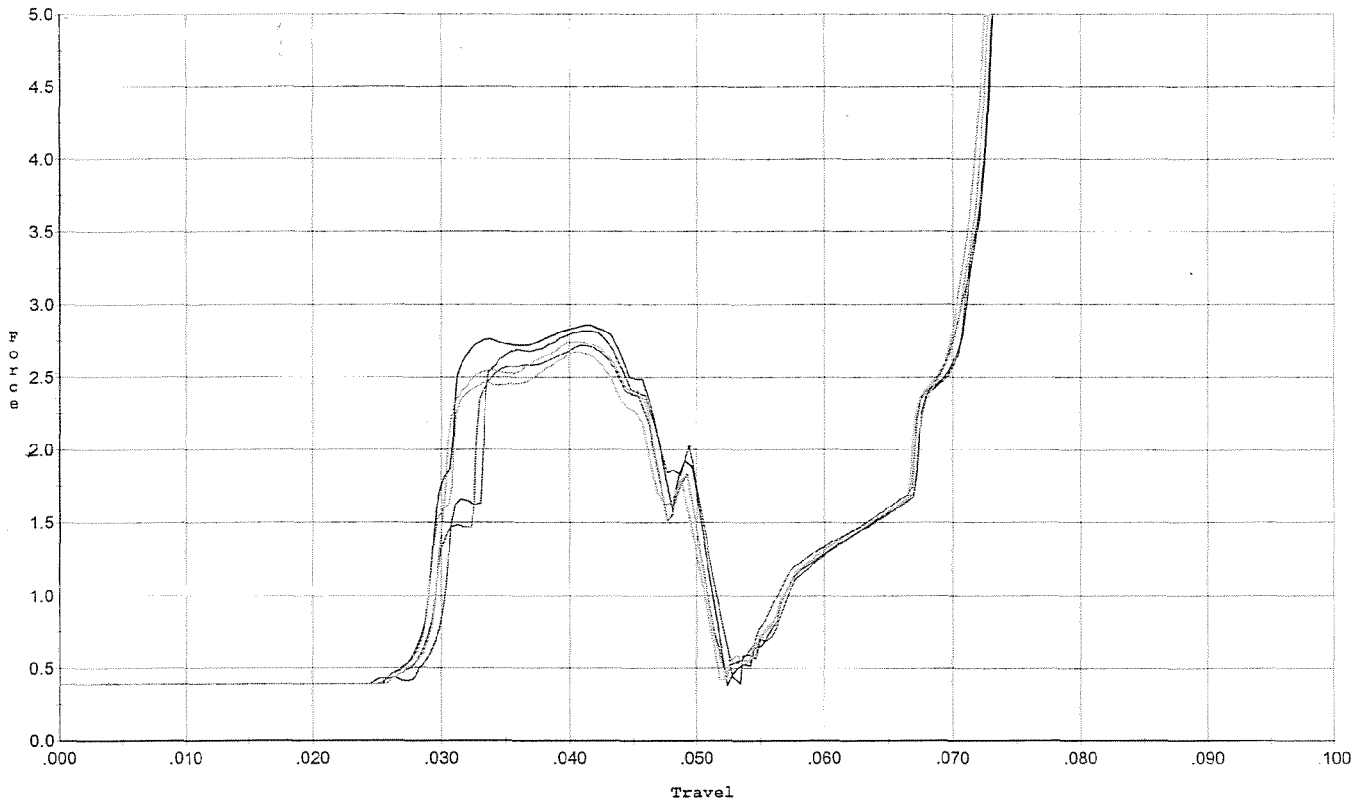
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.049	0.030	0.030	0.050		Set Trigger
2	2.528	0.050	0.029	0.029	0.053		Set Trigger
3	2.445	0.050	0.030	0.030	0.050		Set Trigger
4	2.513	0.049	0.028	0.029	0.054		Set Trigger
5	2.444	0.050	0.030	0.029	0.052		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



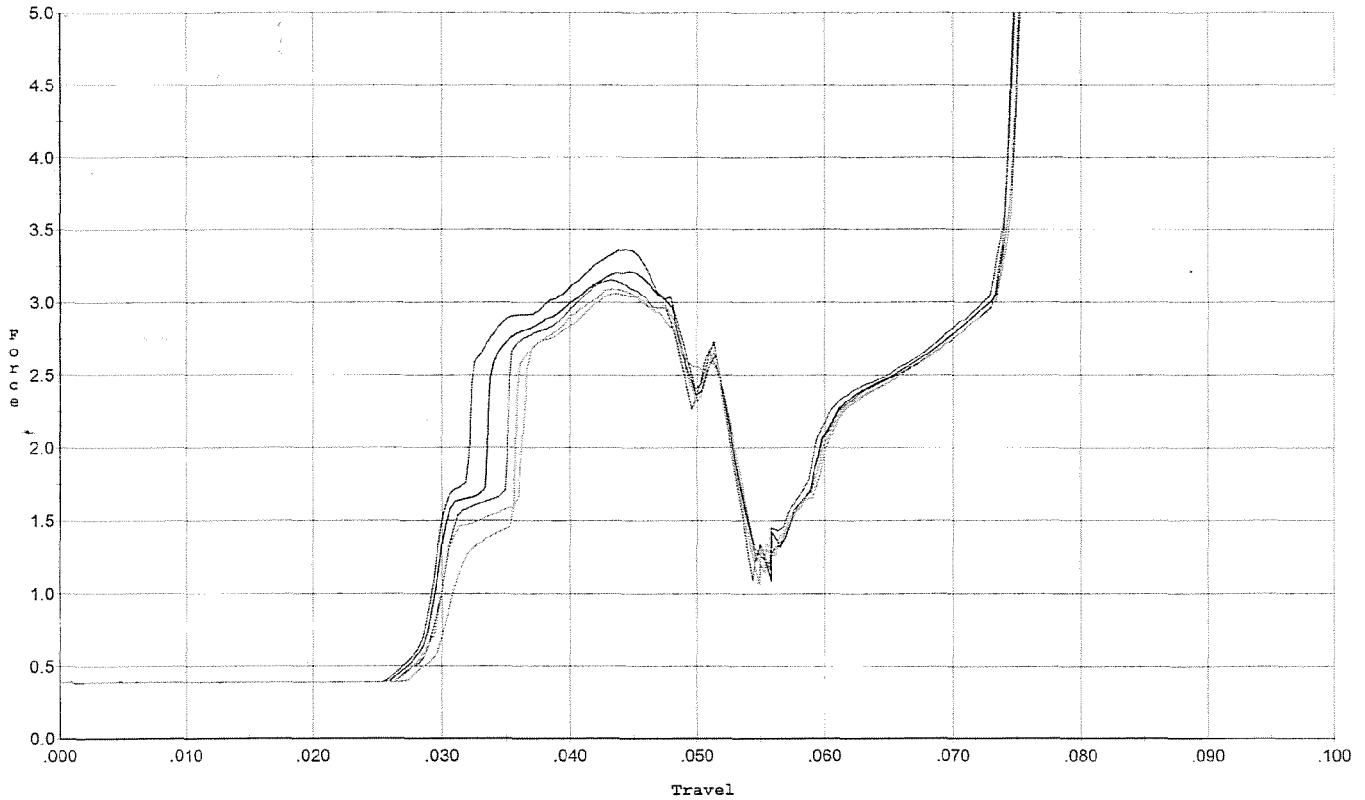
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.819	0.049	0.028	0.029	0.058		Set Trigger
2	2.855	0.050	0.028	0.029	0.063		Set Trigger
3	2.719	0.049	0.029	0.029	0.056		Set Trigger
4	2.744	0.049	0.029	0.029	0.059		Set Trigger
5	2.674	0.050	0.028	0.029	0.058		Set Trigger

A2-76

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



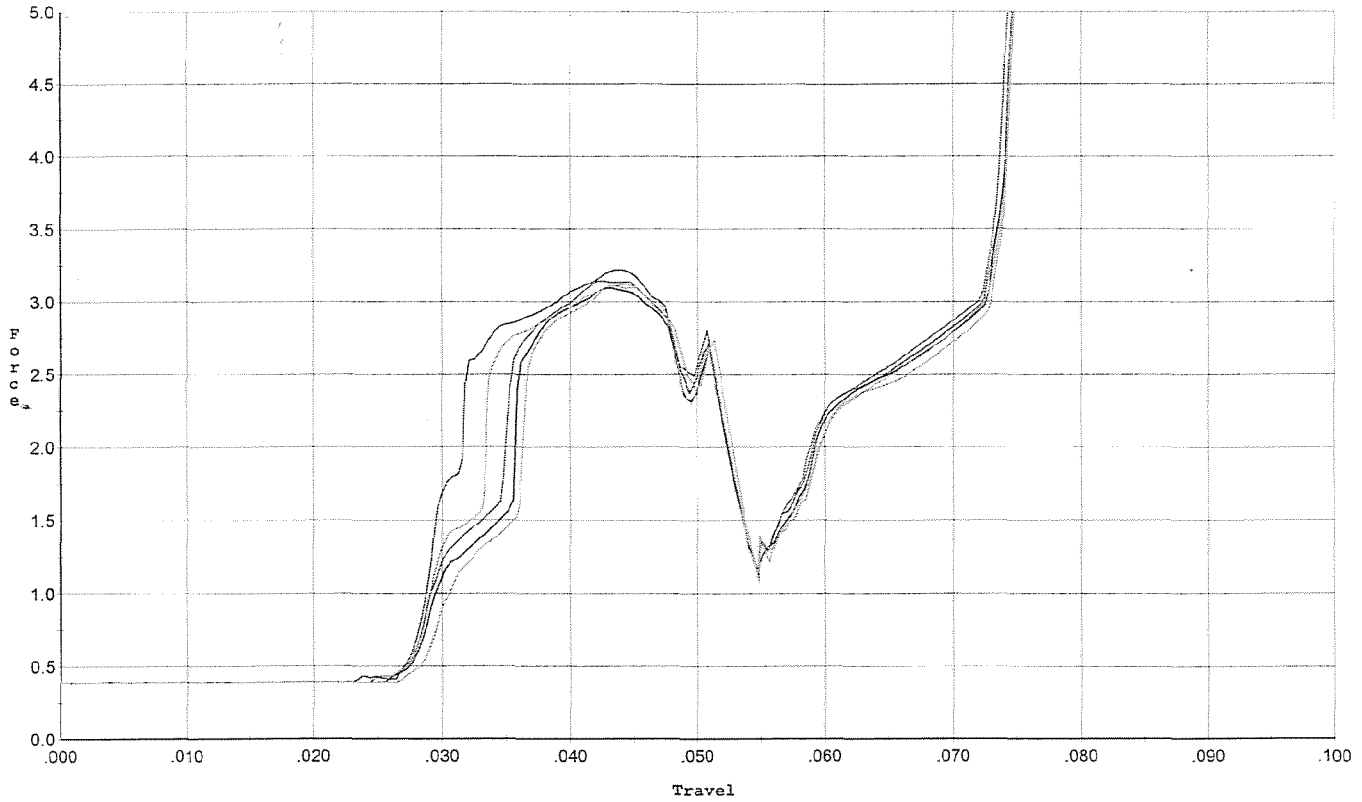
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.364	0.051	0.028	0.028	0.074		Set Trigger
2	3.211	0.051	0.029	0.029	0.071		Set Trigger
3	3.155	0.052	0.029	0.028	0.068		Set Trigger
4	3.058	0.053	0.029	0.028	0.068		Set Trigger
5	3.088	0.052	0.030	0.029	0.065		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



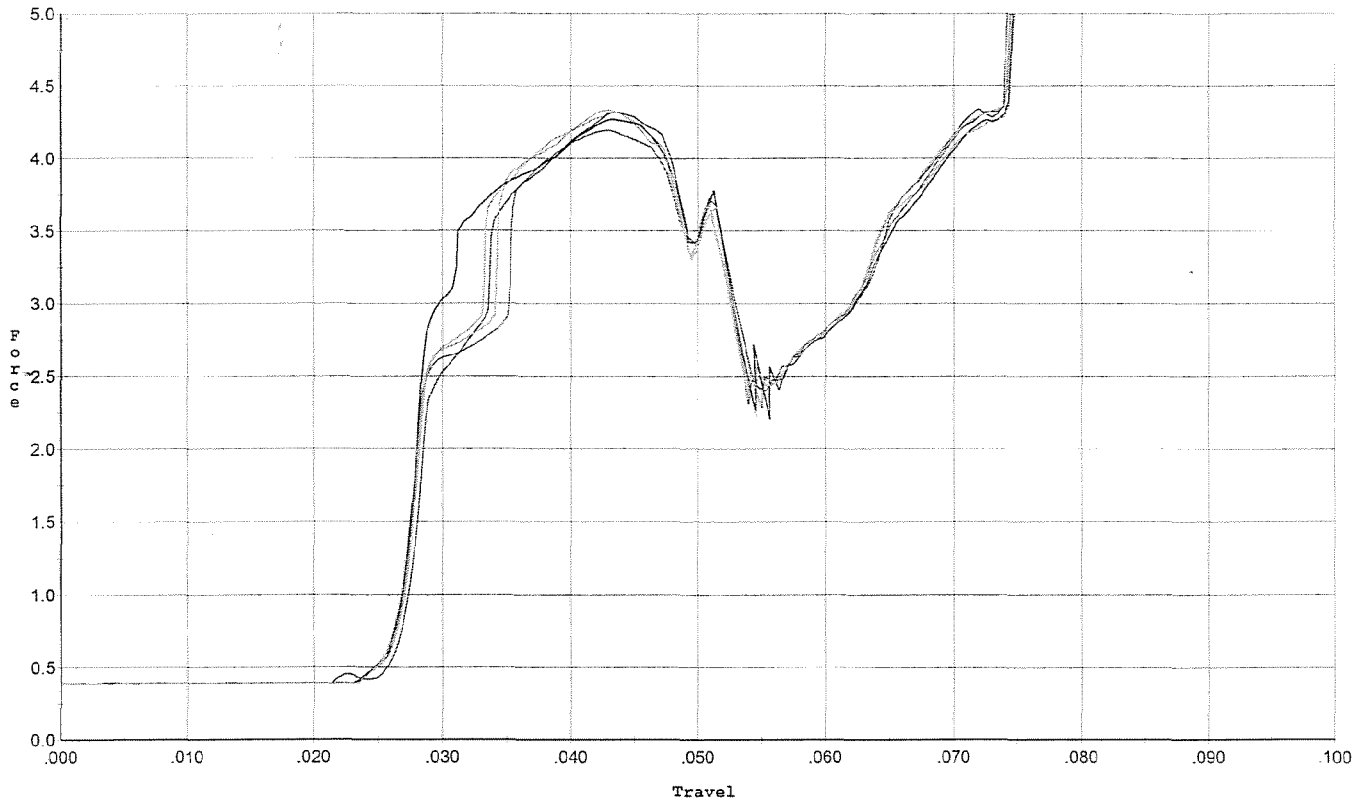
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.221	0.051	0.027	0.028	0.073		Set Trigger
2	3.094	0.051	0.028	0.028	0.065		Set Trigger
3	3.145	0.051	0.028	0.028	0.067		Set Trigger
4	3.116	0.051	0.029	0.028	0.065		Set Trigger
5	3.123	0.051	0.028	0.028	0.069		Set Trigger

A3-14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



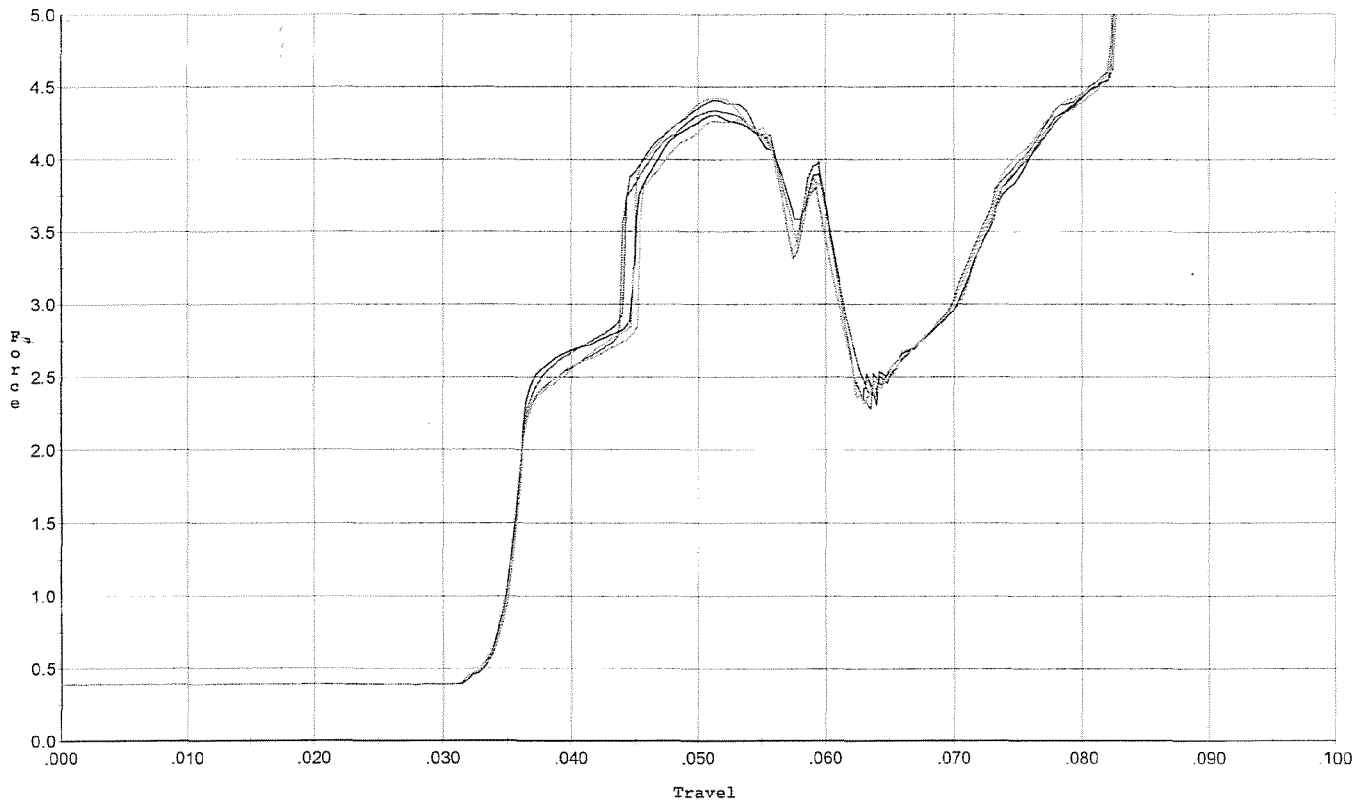
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.320	0.051	0.026	0.026	0.097		Set Trigger
2	4.266	0.051	0.026	0.026	0.101		Set Trigger
3	4.190	0.051	0.026	0.026	0.097		Set Trigger
4	4.321	0.051	0.026	0.026	0.099		Set Trigger
5	4.331	0.052	0.026	0.026	0.101		Set Trigger

A: 4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



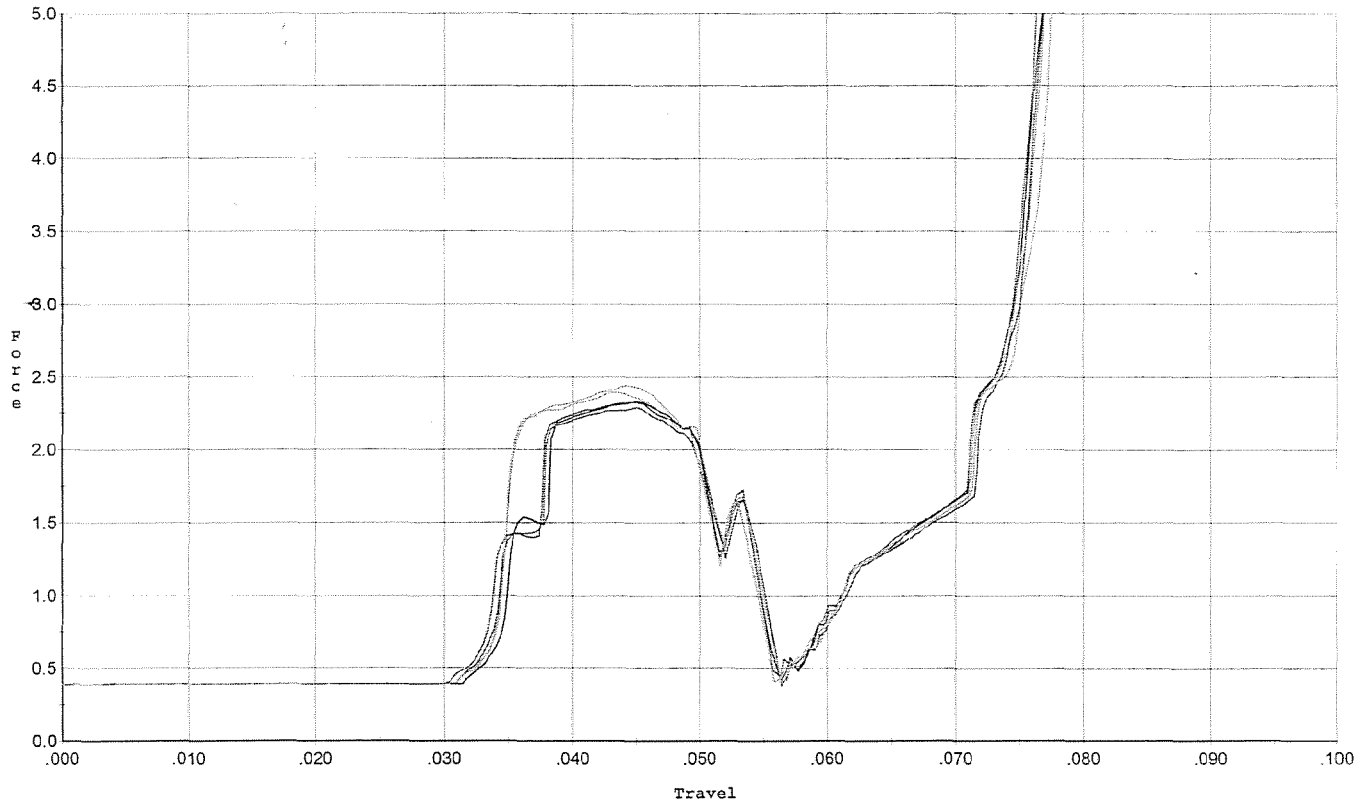
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.411	0.059	0.034	0.026	0.103		Set Trigger
2	4.307	0.060	0.034	0.026	0.101		Set Trigger
3	4.337	0.056	0.034	0.029	0.089		Set Trigger
4	4.422	0.059	0.034	0.027	0.099		Set Trigger
5	4.272	0.060	0.034	0.026	0.100		Set Trigger

A-4.35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



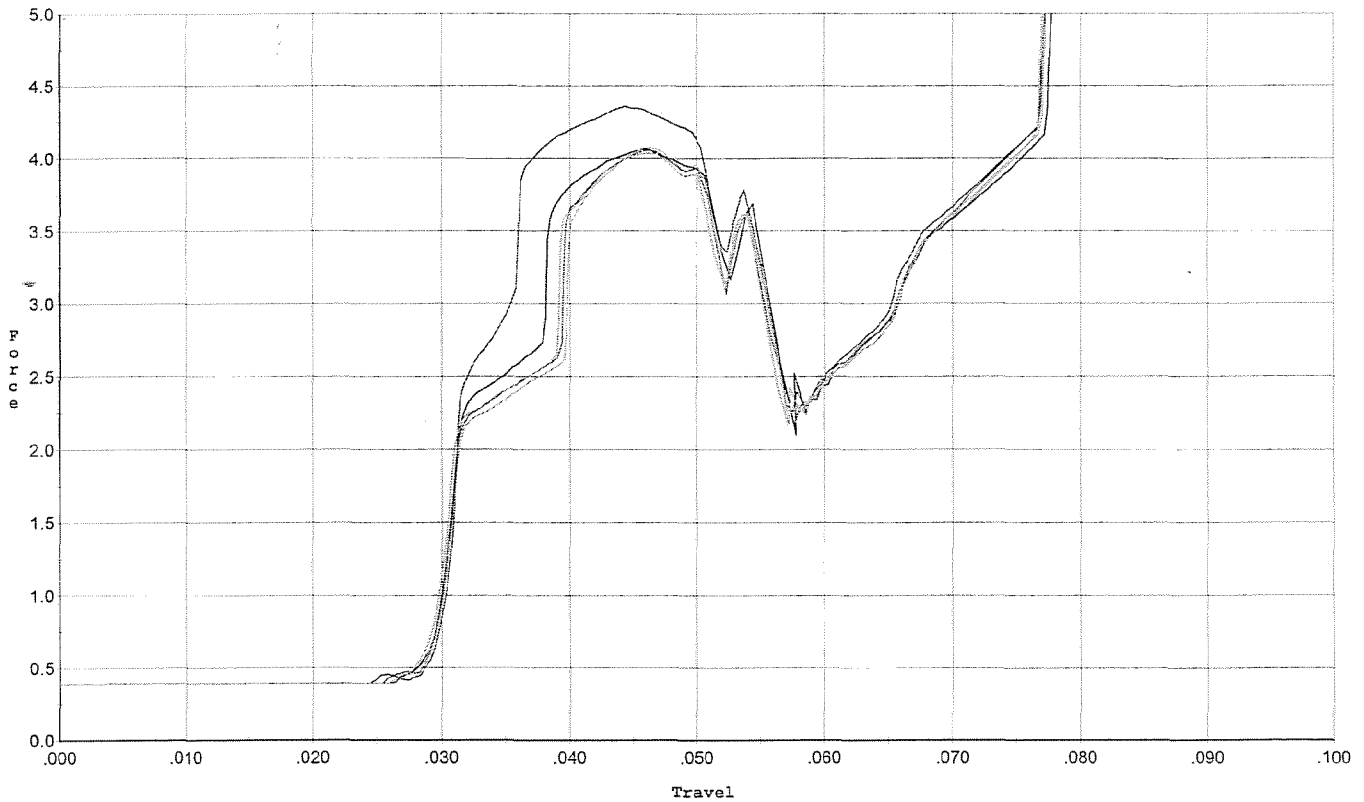
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.323	0.055	0.033	0.030	0.053		Set Trigger
2	2.334	0.053	0.034	0.030	0.051		Set Trigger
3	2.289	0.053	0.033	0.029	0.052		Set Trigger
4	2.393	0.054	0.033	0.030	0.055		Set Trigger
5	2.437	0.053	0.034	0.031	0.055		Set Trigger

A-2.35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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	4.358	0.055	0.029	0.026	0.104		Set Trigger
2	4.064	0.054	0.029	0.027	0.095		Set Trigger
3	4.055	0.054	0.029	0.027	0.091		Set Trigger
4	4.070	0.055	0.029	0.026	0.093		Set Trigger
5	4.034	0.054	0.029	0.026	0.091		Set Trigger

A-4.11