

G6784741

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



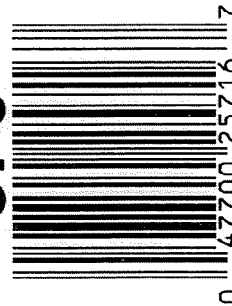
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6784741

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6784741

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	RIZ
475	DRILL AND TAP SIGHT HOLES		9-11-08	SP
480	MAGNAFLUX BBL ACTION		9-12-08	BH
490	MAGNAFLUX BOLT		9/9/08	mk
500	ROLLMARK CALIBER		9/12/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		9/6	cr
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-20-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-20-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-20-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	RBN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

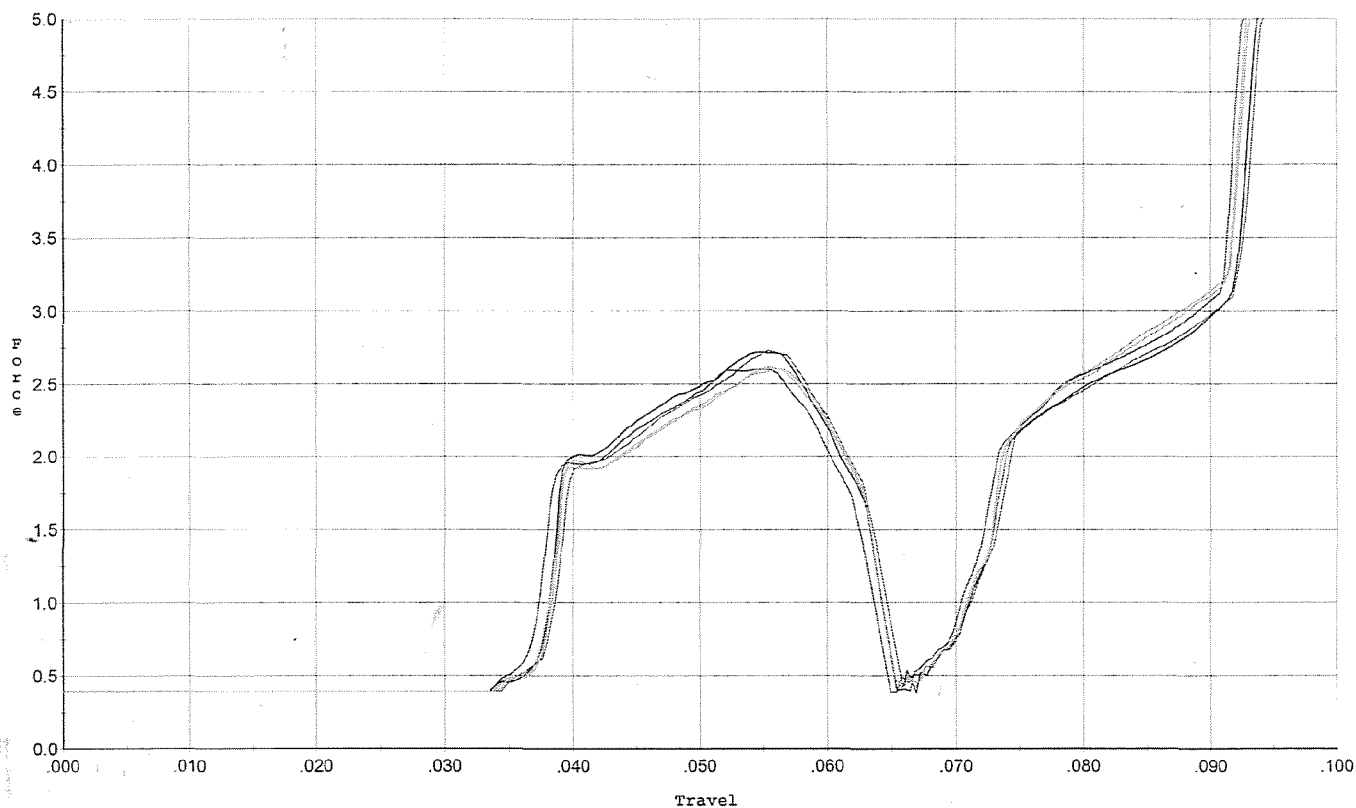
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4</u> <u>4</u>	11-17-08	TL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	11-17-08	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-17-08	TL
	J) ASSEMBLE STOCK		11-12-08	ESM
	K) ASSEMBLE SWIVEL STUDS		11-17-08	TL
	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	11-13-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-13-08	JR
670	FINAL INSPECTION A) HEADSPACE		11-17-08	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.70</u> <u>2.75</u> <u>2.69</u> <u>2.71</u>	11-17-08	TL
	C) FUNCTION		11-17-08	TL
690	PACK		12-1-08	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



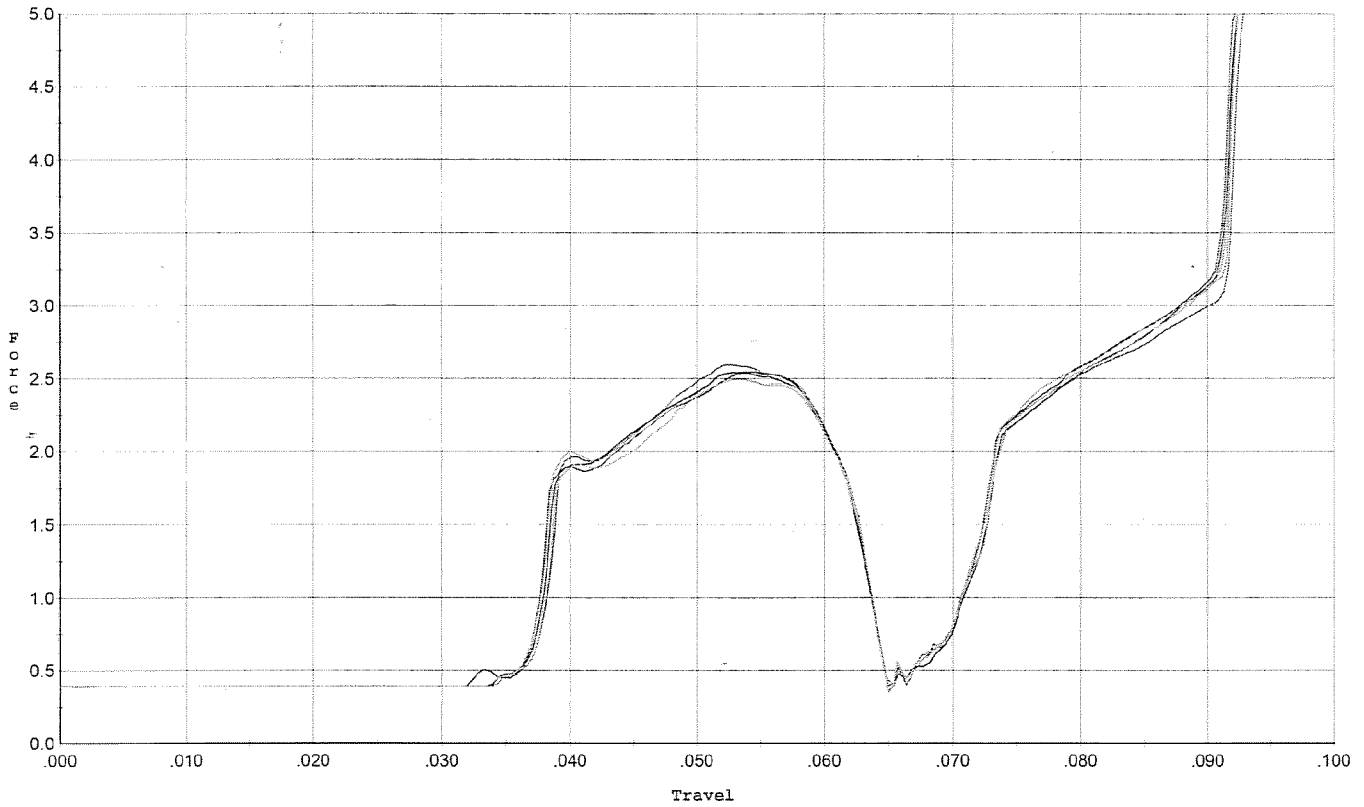
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.603	0.063	0.036	0.037	0.071		Set Trigger
2	2.721	0.063	0.037	0.037	0.072		Set Trigger
3	2.730	0.064	0.038	0.037	0.072		Set Trigger
4	2.603	0.063	0.037	0.037	0.070		Set Trigger
5	2.618	0.063	0.037	0.037	0.070		Set Trigger

A-2-65

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



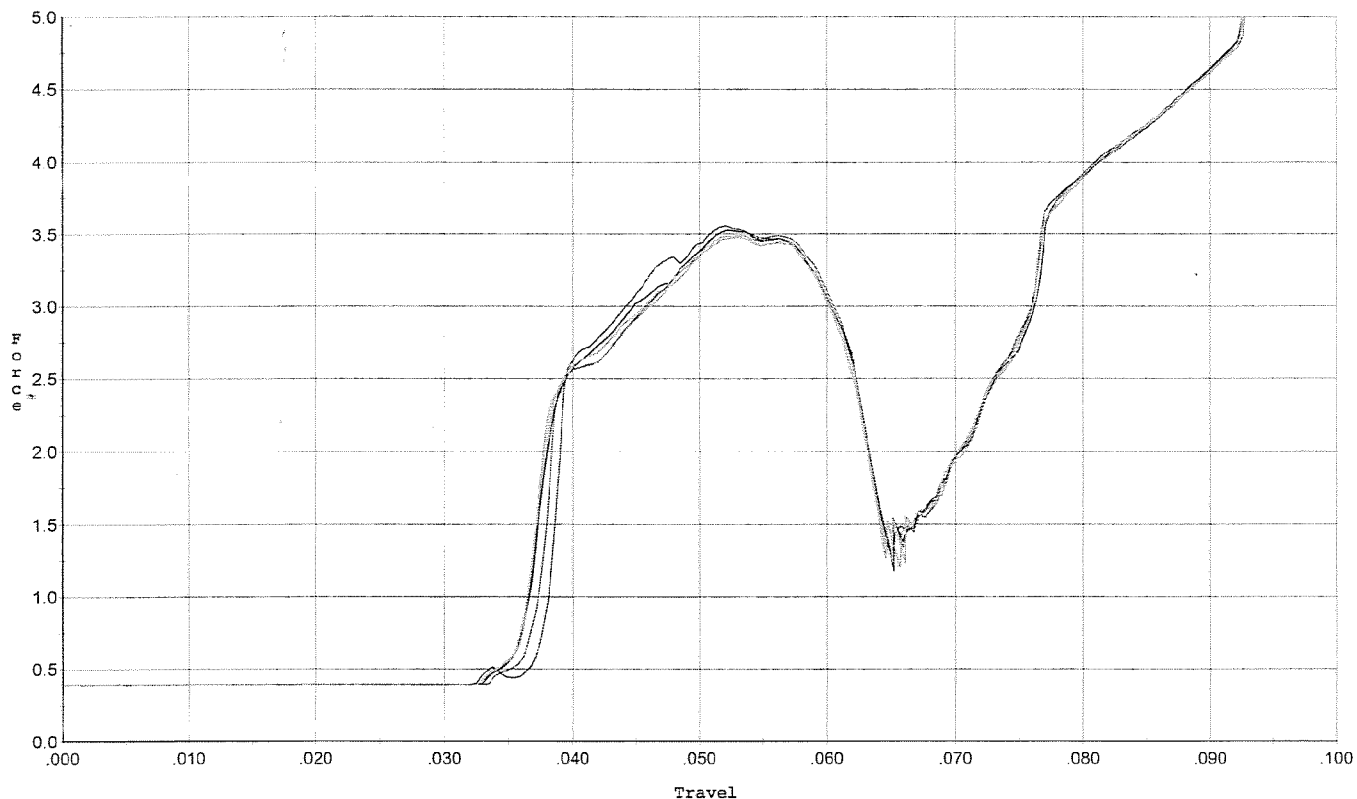
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.536	0.063	0.037	0.036	0.070		Set Trigger
2	2.542	0.063	0.037	0.037	0.070		Set Trigger
3	2.595	0.063	0.037	0.037	0.070		Set Trigger
4	2.489	0.063	0.037	0.037	0.070		Set Trigger
5	2.496	0.063	0.037	0.037	0.068		Set Trigger

A-2.53

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



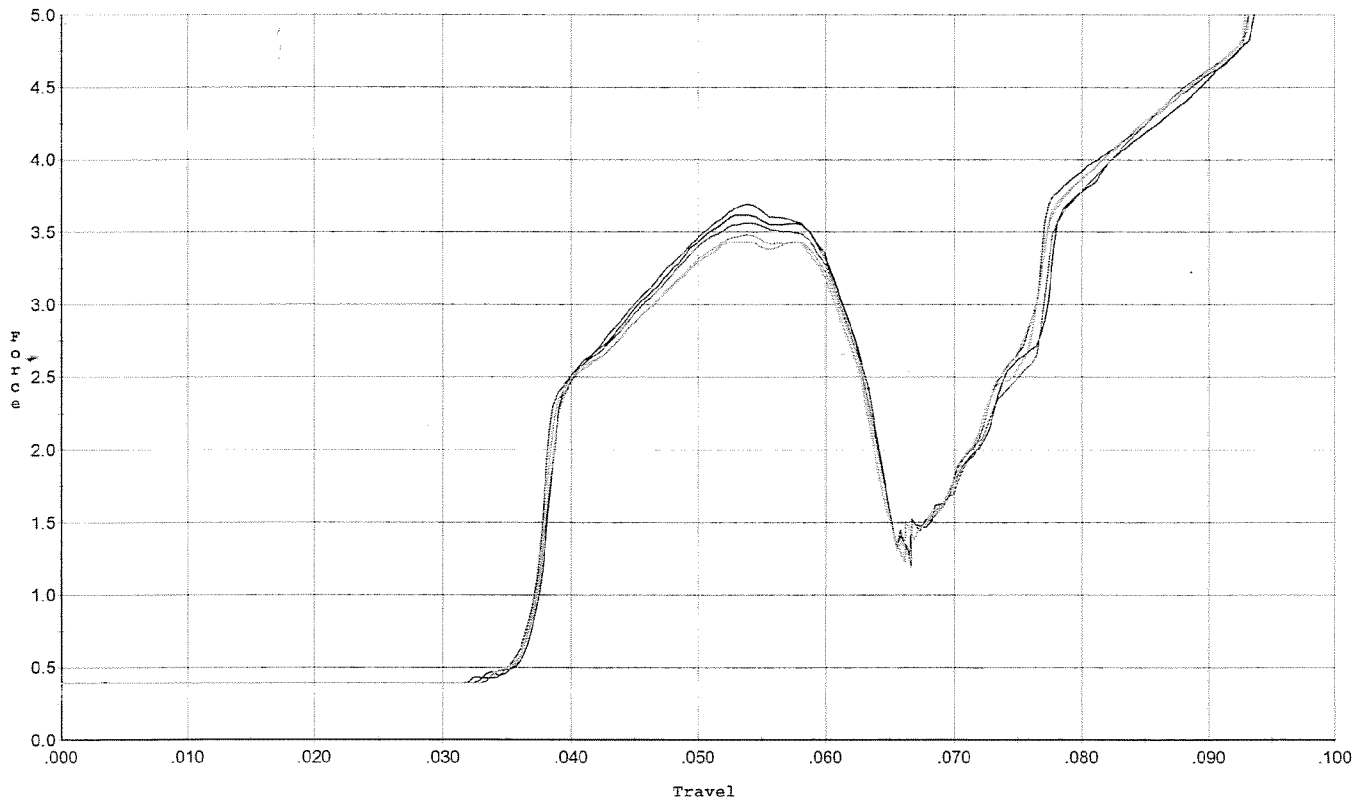
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.558	0.062	0.037	0.036	0.090		Set Trigger
2	3.531	0.062	0.036	0.035	0.092		Set Trigger
3	3.529	0.062	0.036	0.036	0.090		Set Trigger
4	3.491	0.062	0.036	0.035	0.092		Set Trigger
5	3.480	0.062	0.033	0.036	0.091		Set Trigger

A-3-S1

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



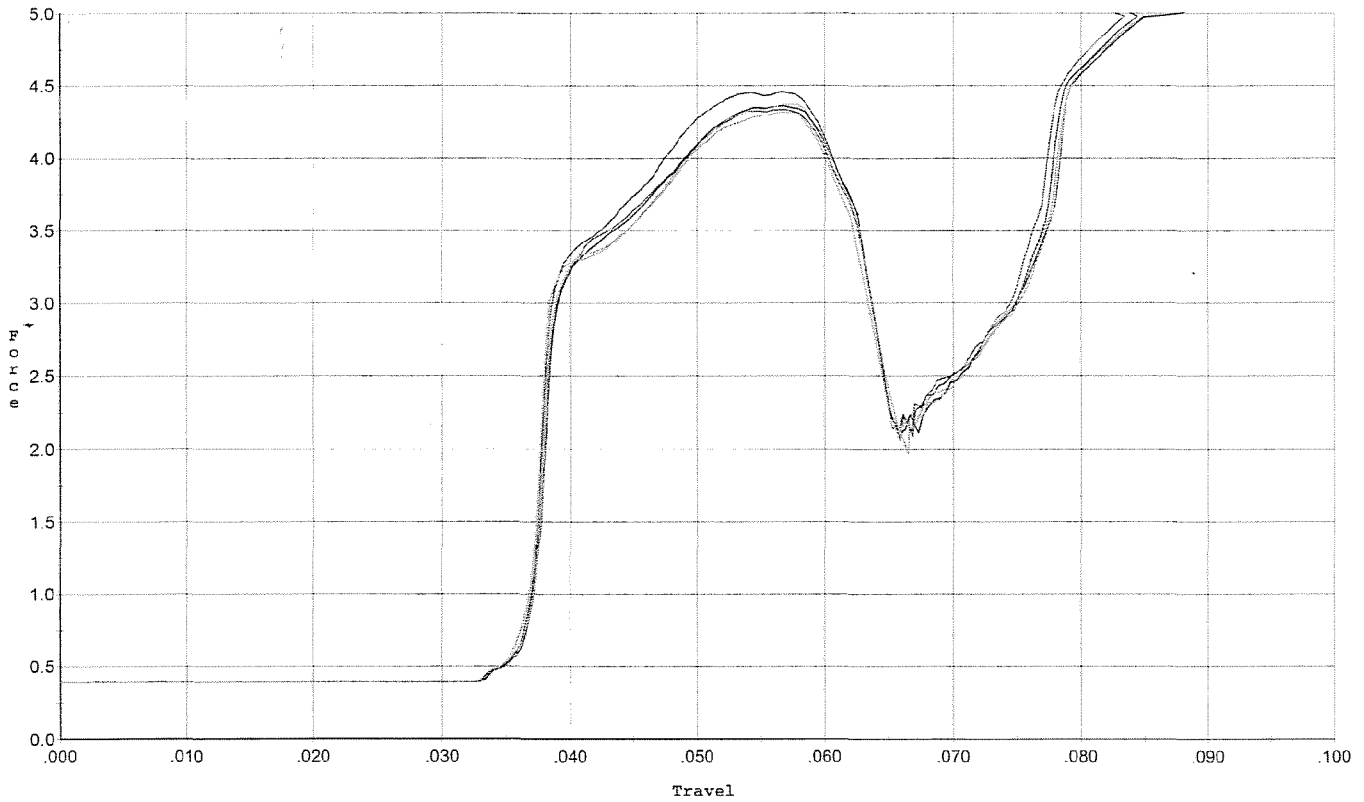
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.694	0.064	0.036	0.035	0.096		Set Trigger
2	3.621	0.063	0.037	0.036	0.095		Set Trigger
3	3.561	0.064	0.036	0.035	0.094		Set Trigger
4	3.431	0.063	0.036	0.035	0.091		Set Trigger
5	3.478	0.064	0.036	0.035	0.093		Set Trigger

A-355

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 lbs



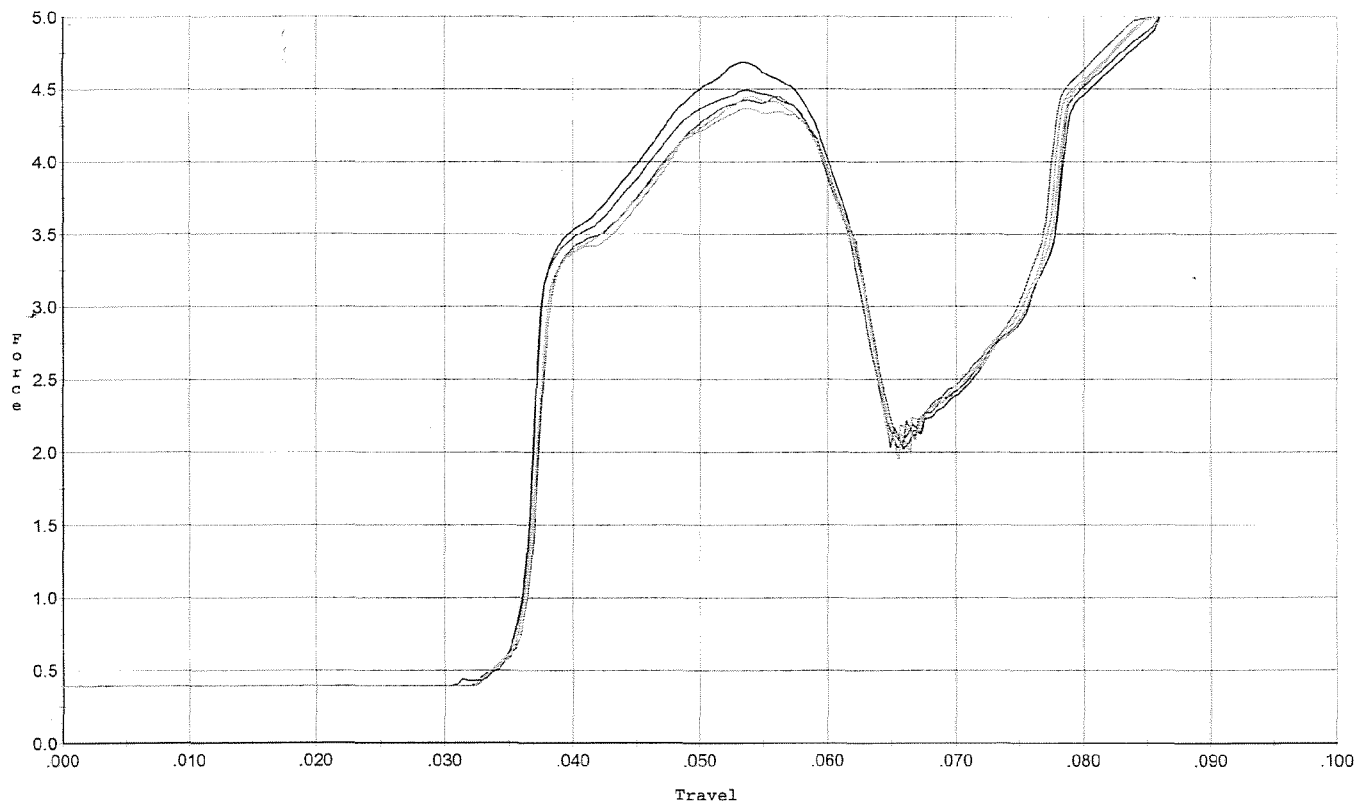
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.458	0.063	0.036	0.029	0.115		Set Trigger
2	4.360	0.063	0.036	0.030	0.112		Set Trigger
3	4.335	0.063	0.036	0.029	0.113		Set Trigger
4	4.373	0.063	0.036	0.030	0.112		Set Trigger
5	4.317	0.064	0.036	0.030	0.114		Set Trigger

A-436

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 lbs



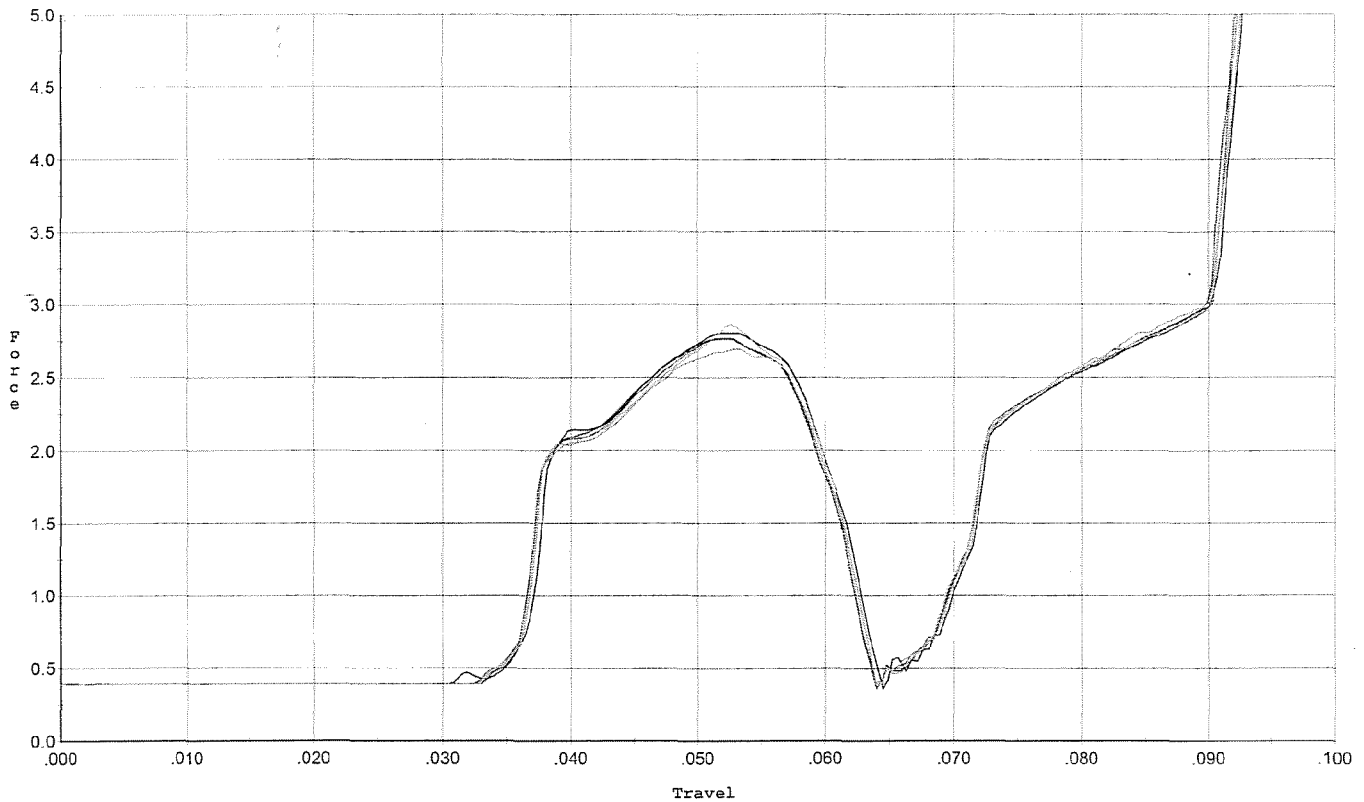
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.493	0.062	0.035	0.030	0.115		Set Trigger
2	4.686	0.062	0.035	0.030	0.120		Set Trigger
3	4.448	0.062	0.036	0.029	0.114		Set Trigger
4	4.447	0.063	0.035	0.029	0.115		Set Trigger
5	4.367	0.062	0.036	0.029	0.114		Set Trigger

A-4.48

Trigger Profile [lbs,inch]

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

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



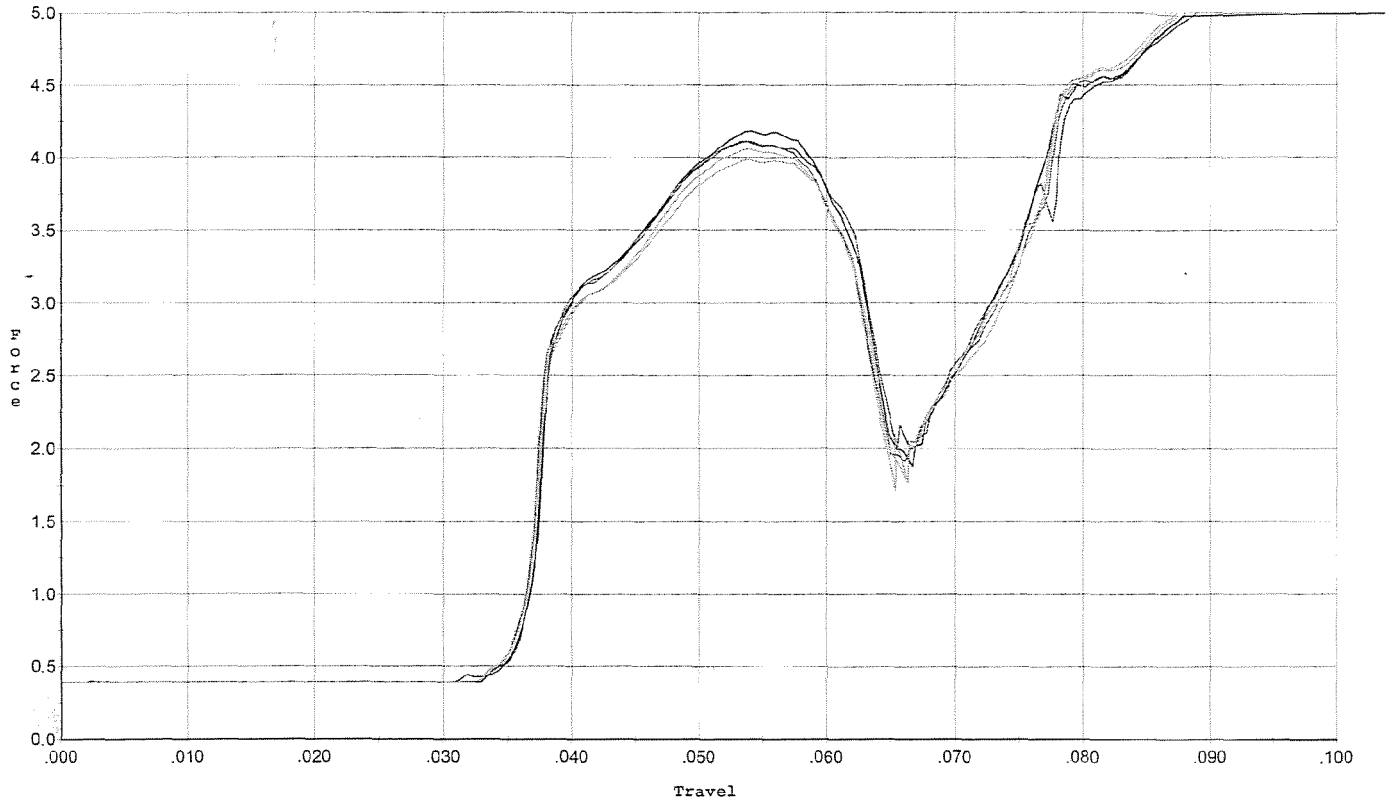
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.769	0.061	0.036	0.037	0.072		Set Trigger
2	2.805	0.062	0.036	0.037	0.073		Set Trigger
3	2.764	0.061	0.036	0.037	0.072		Set Trigger
4	2.862	0.062	0.036	0.037	0.073		Set Trigger
5	2.696	0.062	0.036	0.037	0.072		Set Trigger

A-2.77

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	4.111	0.062	0.036	0.034	0.107		Set Trigger
2	4.180	0.063	0.036	0.034	0.108		Set Trigger
3	4.111	0.062	0.035	0.034	0.106		Set Trigger
4	3.987	0.063	0.035	0.034	0.106		Set Trigger
5	4.061	0.062	0.035	0.034	0.104		Set Trigger

A. 4.09