

6678 5025

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



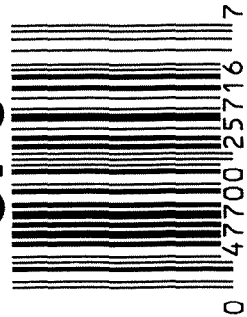
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785025

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6785025

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

F004 REV 5/2006

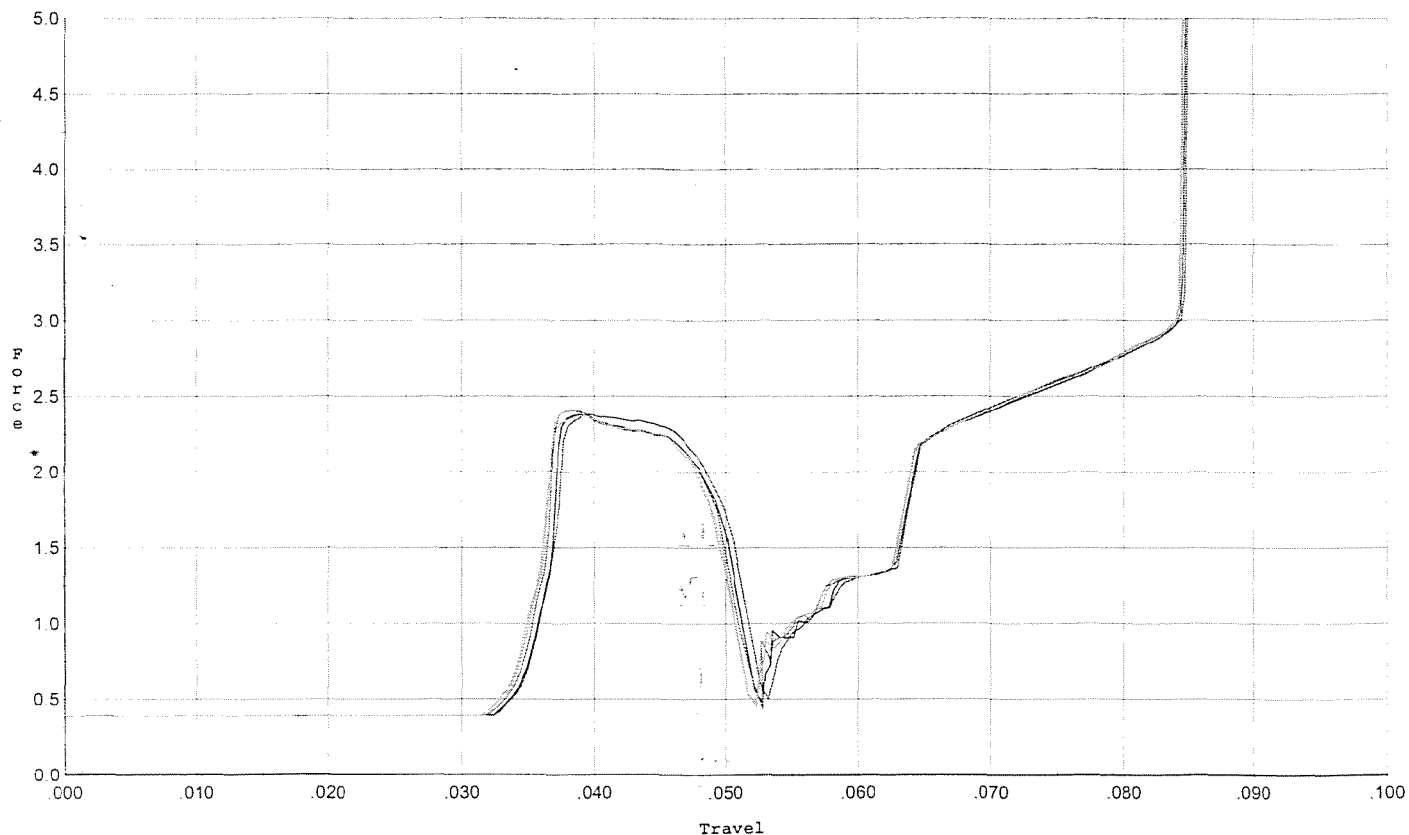
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>4</u> <u>4</u>	11/7/08	DW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	11/7/08	DW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11/7/08	DW
	J) ASSEMBLE STOCK		10-31-08	LIPD
	K) ASSEMBLE SWIVEL STUDS		11/7/08	DW
	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	11-3-08	290
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TC
670	FINAL INSPECTION A) HEADSPACE		11/7/08	DW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.34</u> <u>2.38</u> <u>2.34</u> <u>2.38</u>	11-5-08	Fm
	C) FUNCTION		11/7/08	DW
690	PACK		11/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



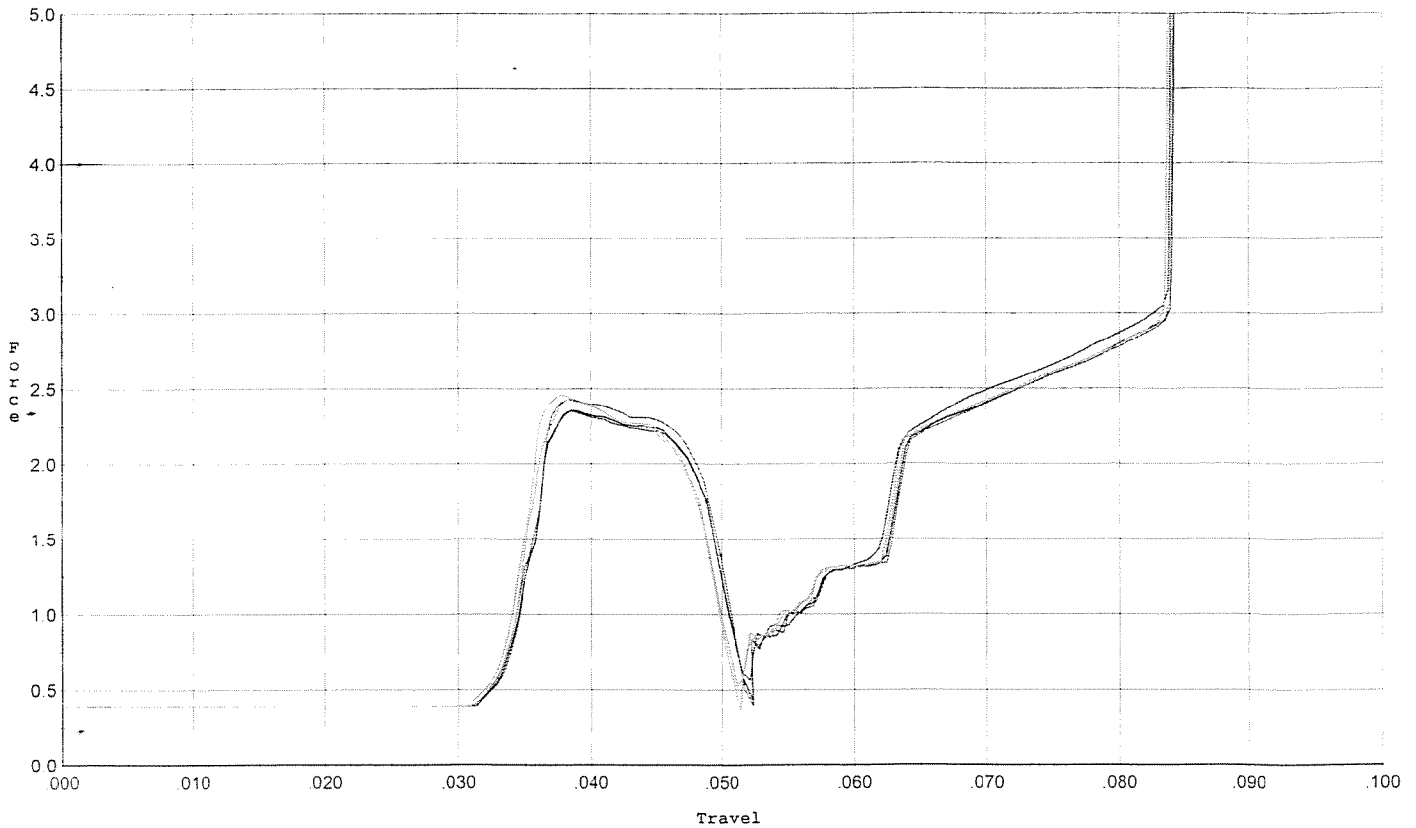
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.383	0.051	0.035	0.038	0.046		Set Trigger
2	2.382	0.050	0.035	0.038	0.045		Set Trigger
3	2.407	0.049	0.034	0.038	0.045		Set Trigger
4	2.404	0.050	0.034	0.038	0.045		Set Trigger
5	2.369	0.050	0.034	0.038	0.046		Set Trigger

Aug 2.38

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



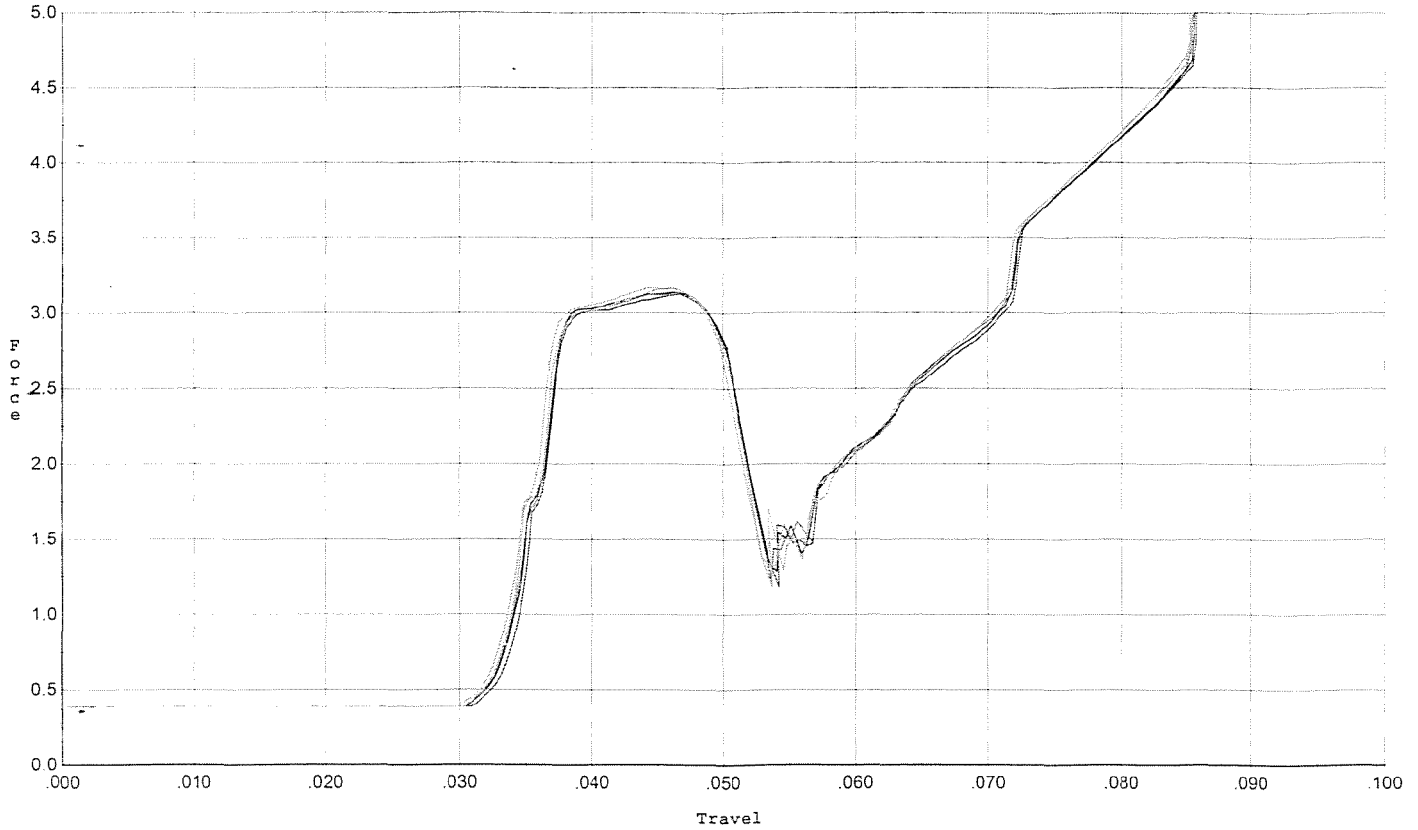
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.353	0.049	0.033	0.038	0.045		Set Trigger
2	2.353	0.049	0.033	0.039	0.045		Set Trigger
3	2.426	0.050	0.034	0.038	0.047		Set Trigger
4	2.458	0.049	0.033	0.039	0.045		Set Trigger
5	2.430	0.048	0.033	0.039	0.045		Set Trigger

Aug 2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



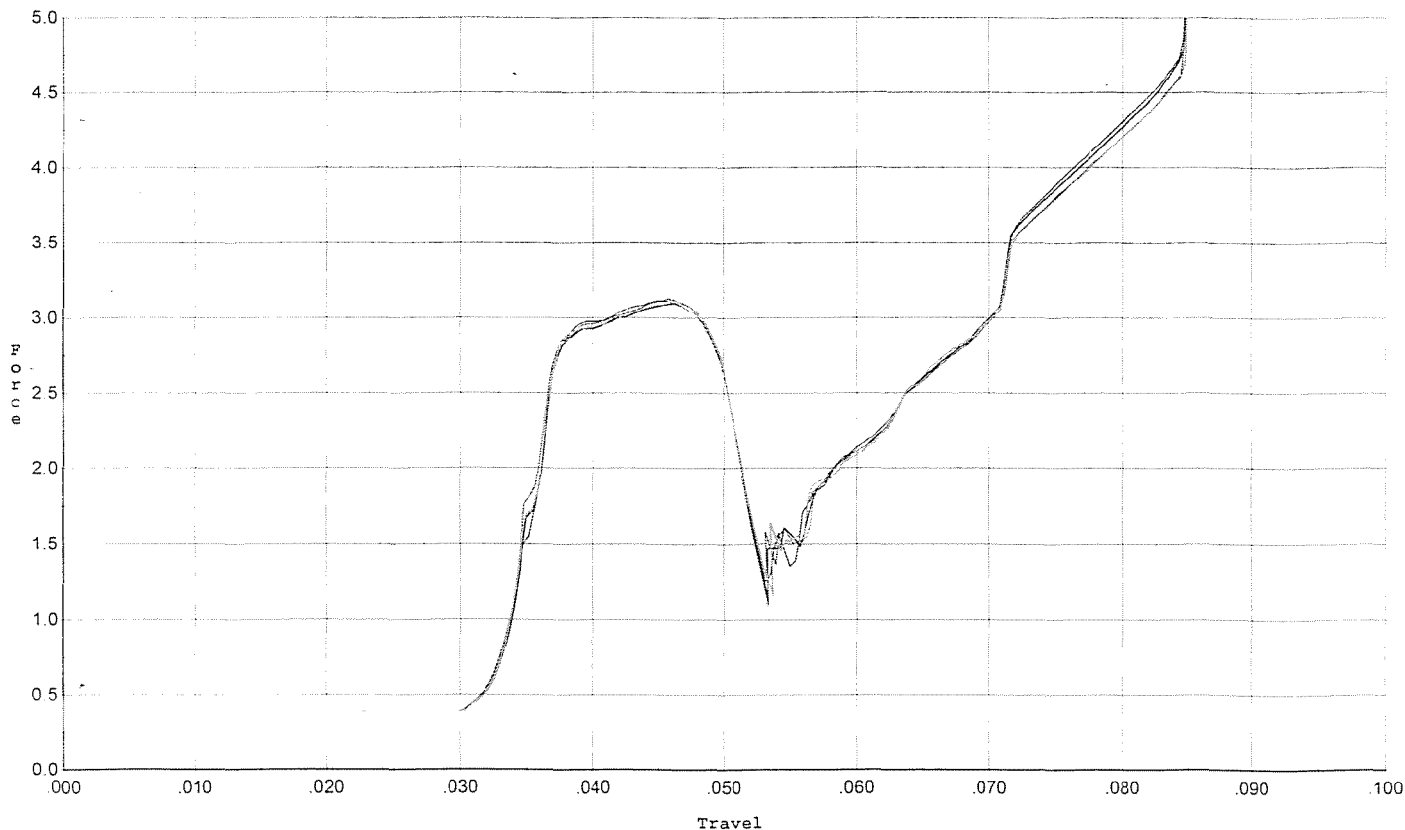
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.125	0.050	0.033	0.037	0.060		Set Trigger
2	3.136	0.050	0.033	0.037	0.061		Set Trigger
3	3.140	0.050	0.033	0.037	0.061		Set Trigger
4	3.166	0.050	0.032	0.037	0.061		Set Trigger
5	3.166	0.051	0.033	0.037	0.061		Set Trigger

Aug 3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



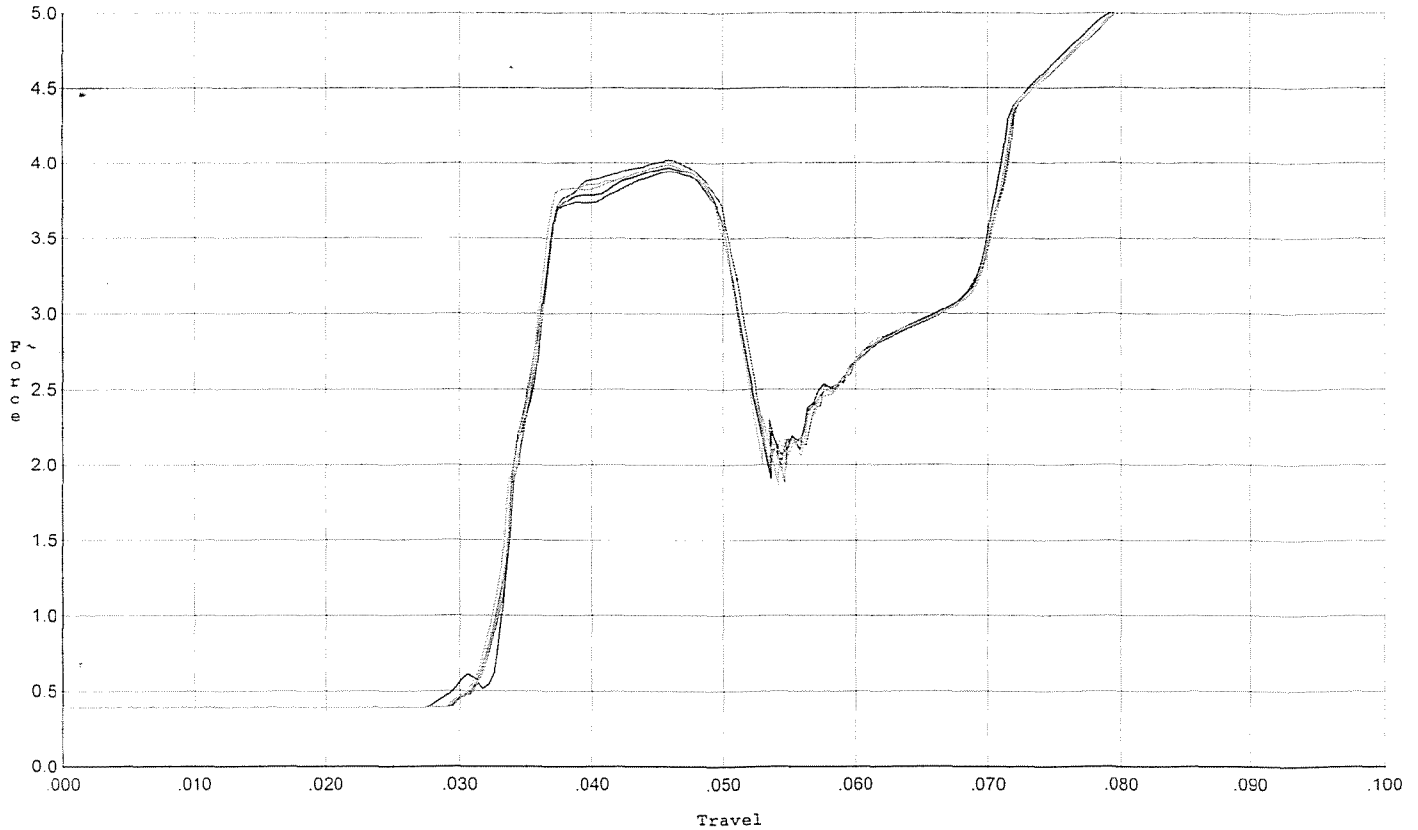
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.109	0.050	0.032	0.037	0.060		Set Trigger
2	3.093	0.050	0.033	0.037	0.059		Set Trigger
3	3.124	0.050	0.033	0.037	0.060		Set Trigger
4	3.111	0.050	0.033	0.037	0.059		Set Trigger
5	3.104	0.050	0.033	0.037	0.059		Set Trigger

Aug 3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



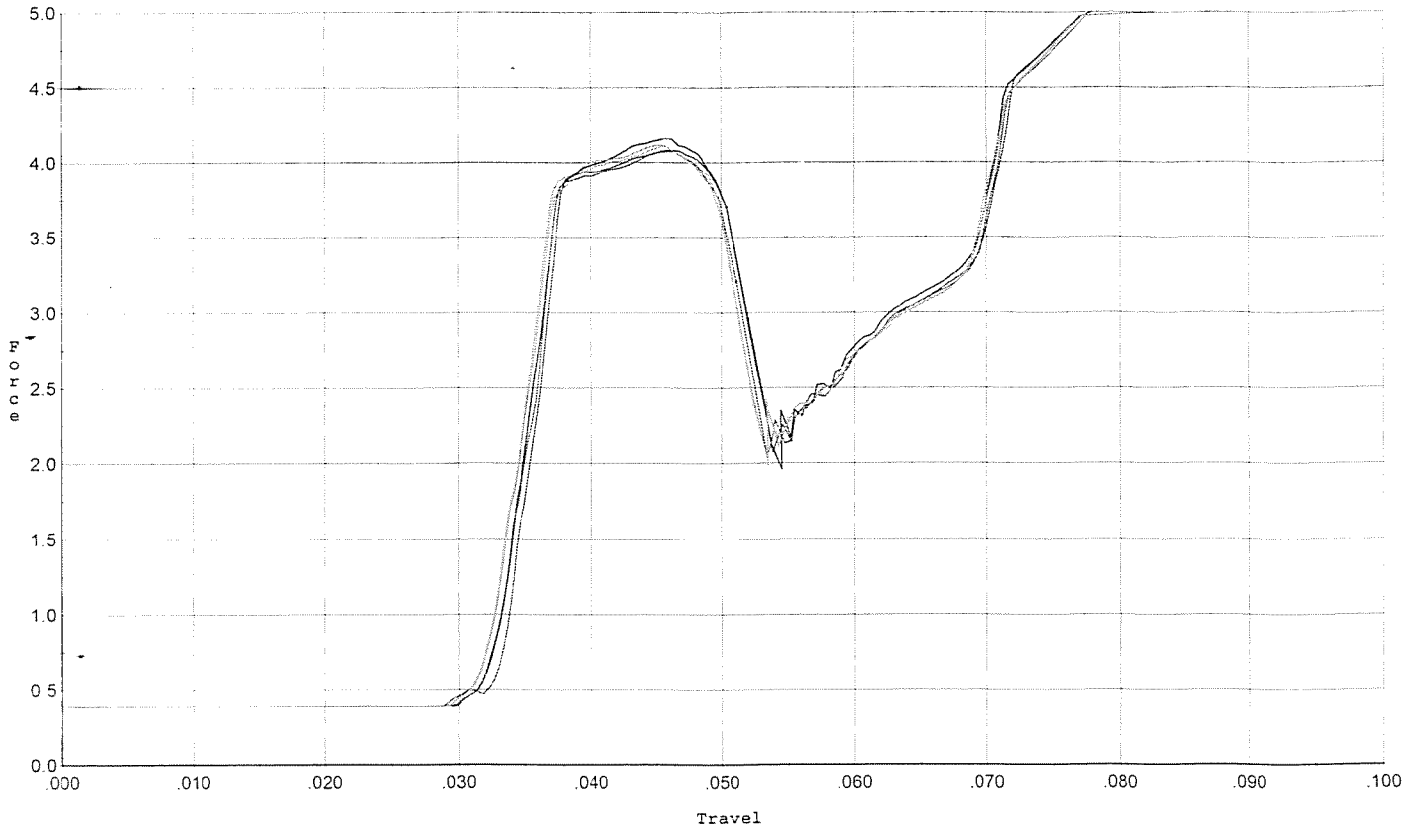
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.943	0.050	0.032	0.035	0.075		Set Trigger
2	3.966	0.050	0.033	0.035	0.076		Set Trigger
3	4.021	0.051	0.031	0.035	0.079		Set Trigger
4	3.989	0.050	0.031	0.035	0.077		Set Trigger
5	3.987	0.050	0.032	0.035	0.076		Set Trigger

Aug 3.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



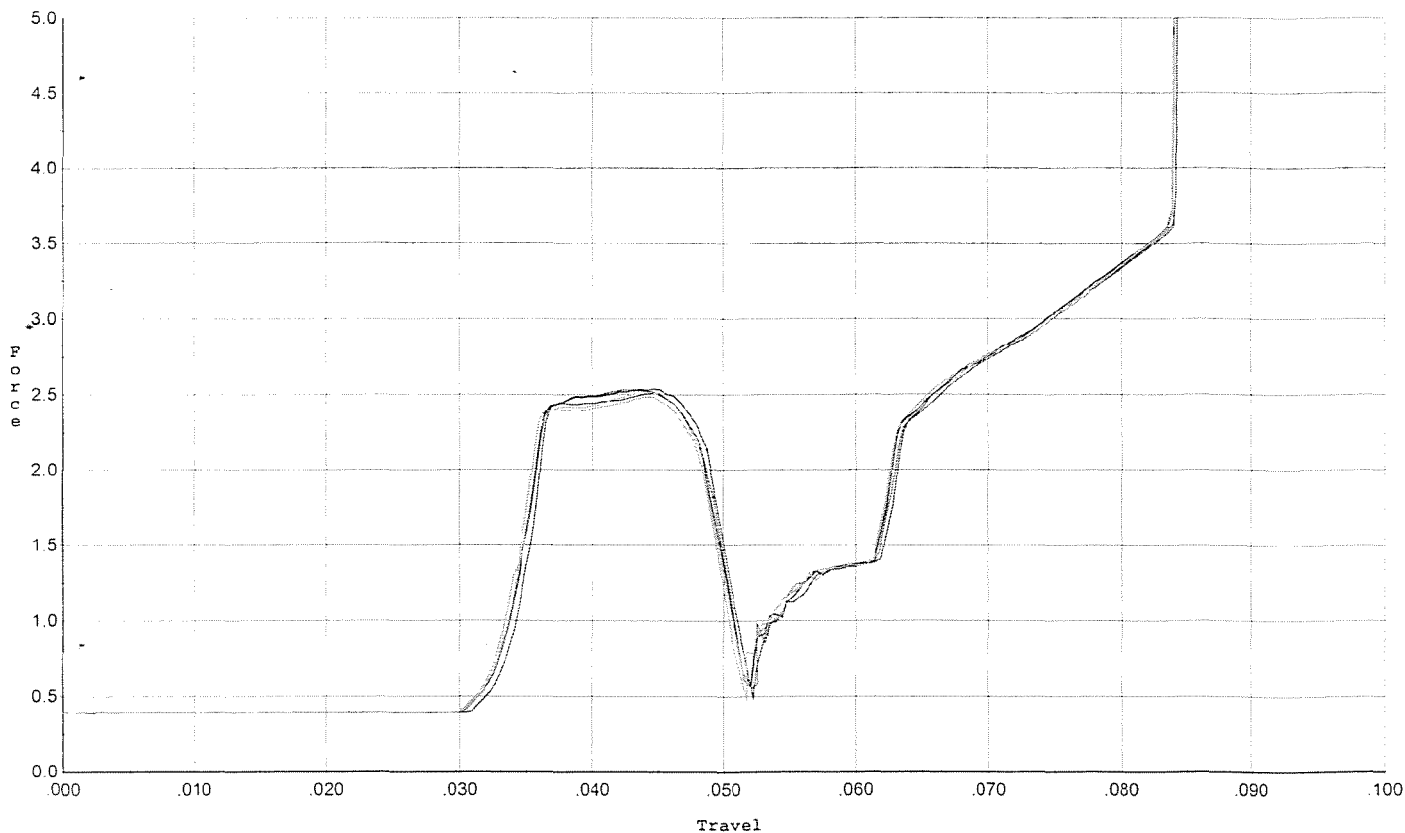
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.081	0.050	0.033	0.036	0.076		Set Trigger
2	4.161	0.052	0.032	0.035	0.081		Set Trigger
3	4.074	0.051	0.032	0.035	0.078		Set Trigger
4	4.107	0.050	0.032	0.035	0.077		Set Trigger
5	4.115	0.050	0.031	0.035	0.077		Set Trigger

Aug 4.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



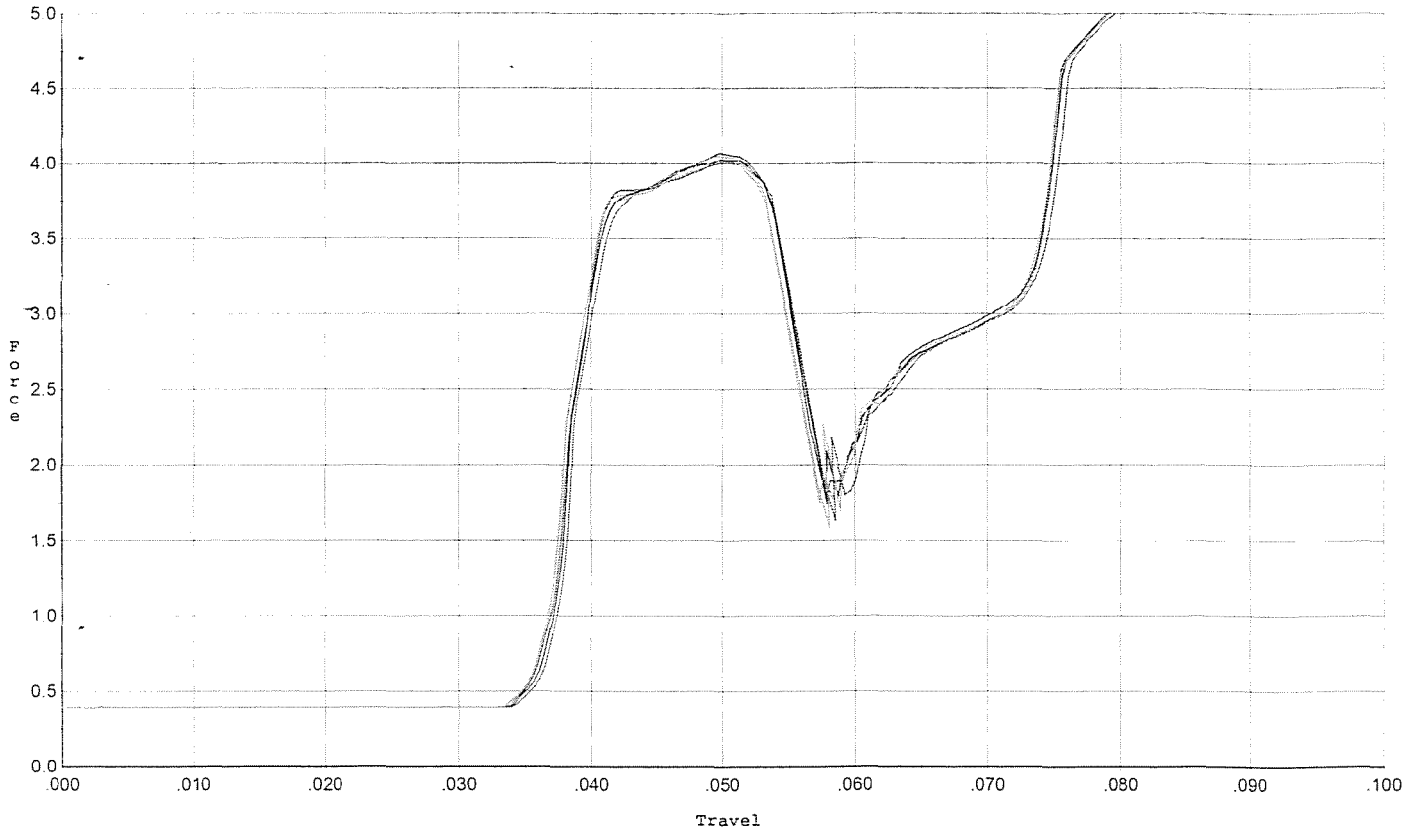
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.537	0.049	0.033	0.038	0.049		Set Trigger
2	2.531	0.050	0.033	0.038	0.050		Set Trigger
3	2.512	0.049	0.033	0.038	0.049		Set Trigger
4	2.485	0.048	0.032	0.038	0.048		Set Trigger
5	2.520	0.048	0.032	0.038	0.048		Set Trigger

Aug. 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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	4.068	0.054	0.036	0.037	0.079		Set Trigger
2	4.023	0.054	0.036	0.037	0.078		Set Trigger
3	4.009	0.056	0.036	0.037	0.080		Set Trigger
4	4.043	0.055	0.036	0.037	0.081		Set Trigger
5	4.017	0.053	0.036	0.037	0.077		Set Trigger

Aug 4.03