

G-6785048

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

— INSTRUCTION BOOK 3518

BM FORM



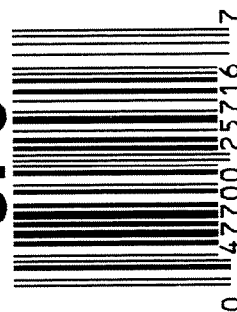
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6785048

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6785048

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SP
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SP
460	CHECK HEADSPACE		9-29-08	SP
470	DIS-ASSEMBLE ACTION		9-29-08	SP
472	SERIALIZE BOLT HANDLE		9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		10/1/08	Fm
480	MAGNAFLUX BBL ACTION		10/2/08	(RB)
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	✓
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		11-03-08	Rgn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

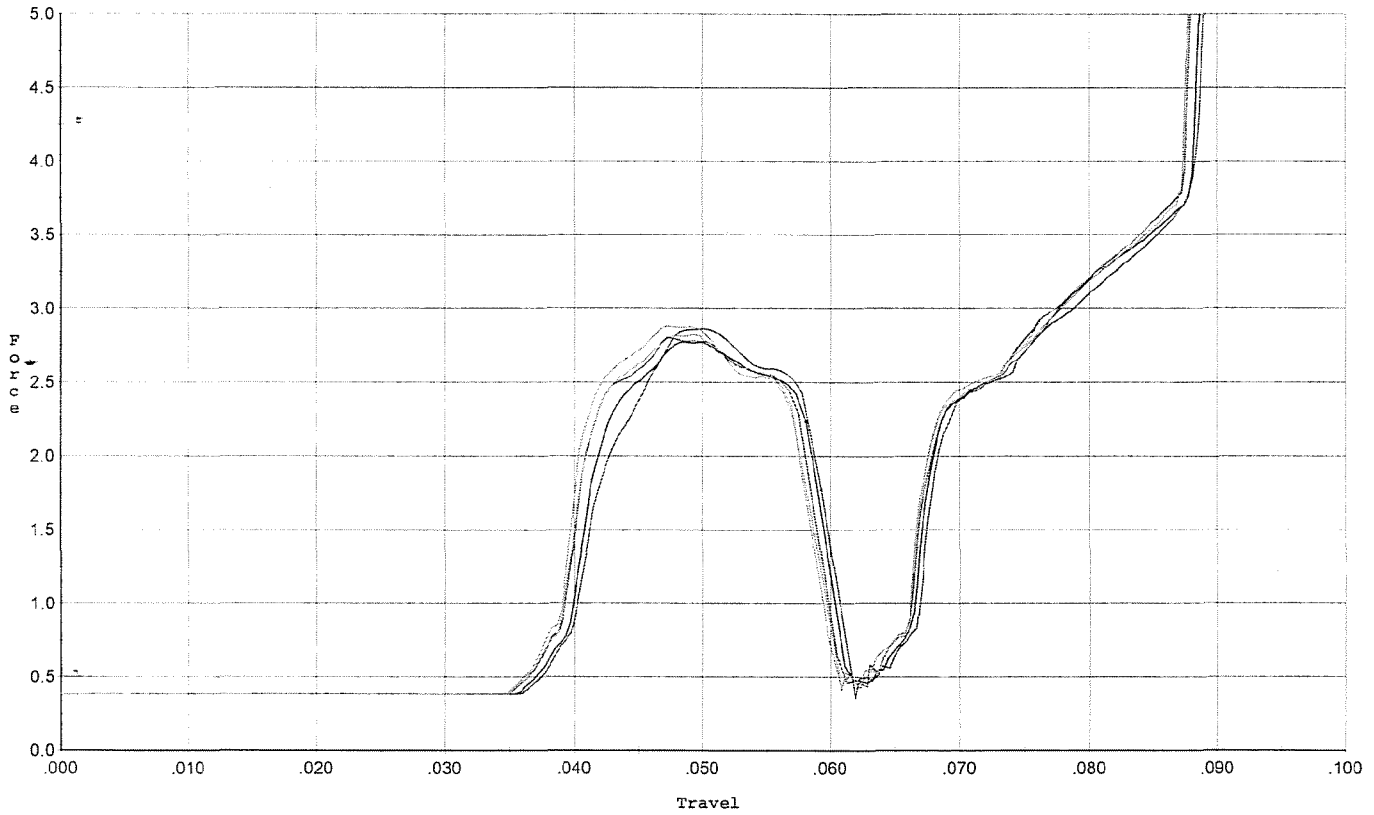
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.0</u>	11-13-08	LJA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-13-08	LJA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	LJA
	J) ASSEMBLE STOCK		11-3-08	RSN
	K) ASSEMBLE SWIVEL STUDS		11-13-08	LJA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	11-12-08	TL
650	TARGET	<u>PASS</u> FAIL	11-5-08	TL
	MALFUNCTION <i>BAC</i>	CORRECTION	11-12-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	RSN
670	FINAL INSPECTION A) HEADSPACE		11-13-08	LJA
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.86</u> <u>2.78</u> <u>2.73</u> <u>2.85</u> <u>2.78</u>	11-6-08	TL
	C) FUNCTION		11-13-08	LJA
690	PACK		11/17/08	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



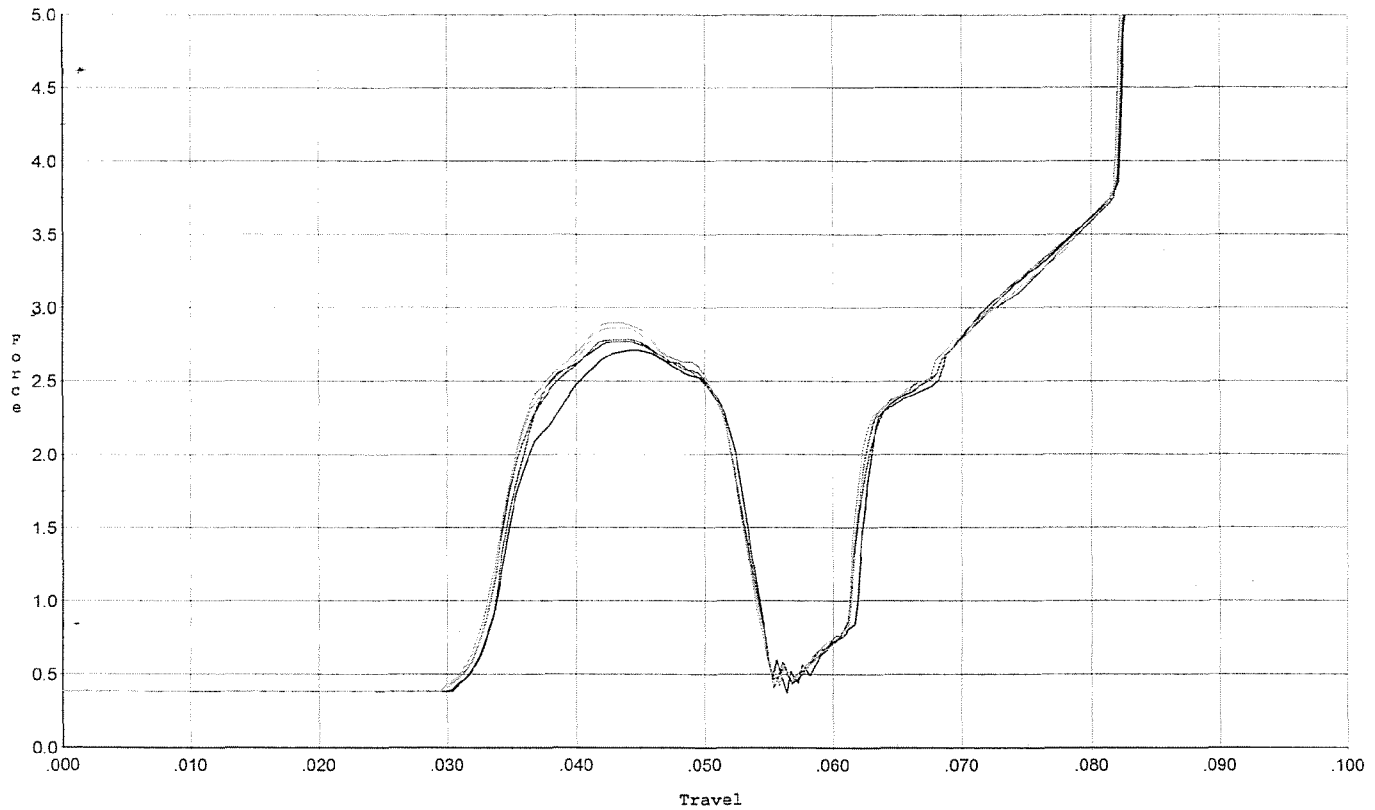
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.865	0.059	0.039	0.036	0.063		Set Trigger
2	2.777	0.058	0.038	0.036	0.062		Set Trigger
3	2.800	0.058	0.038	0.036	0.062		Set Trigger
4	2.823	0.059	0.038	0.036	0.064		Set Trigger
5	2.881	0.057	0.037	0.036	0.063		Set Trigger

A-250

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



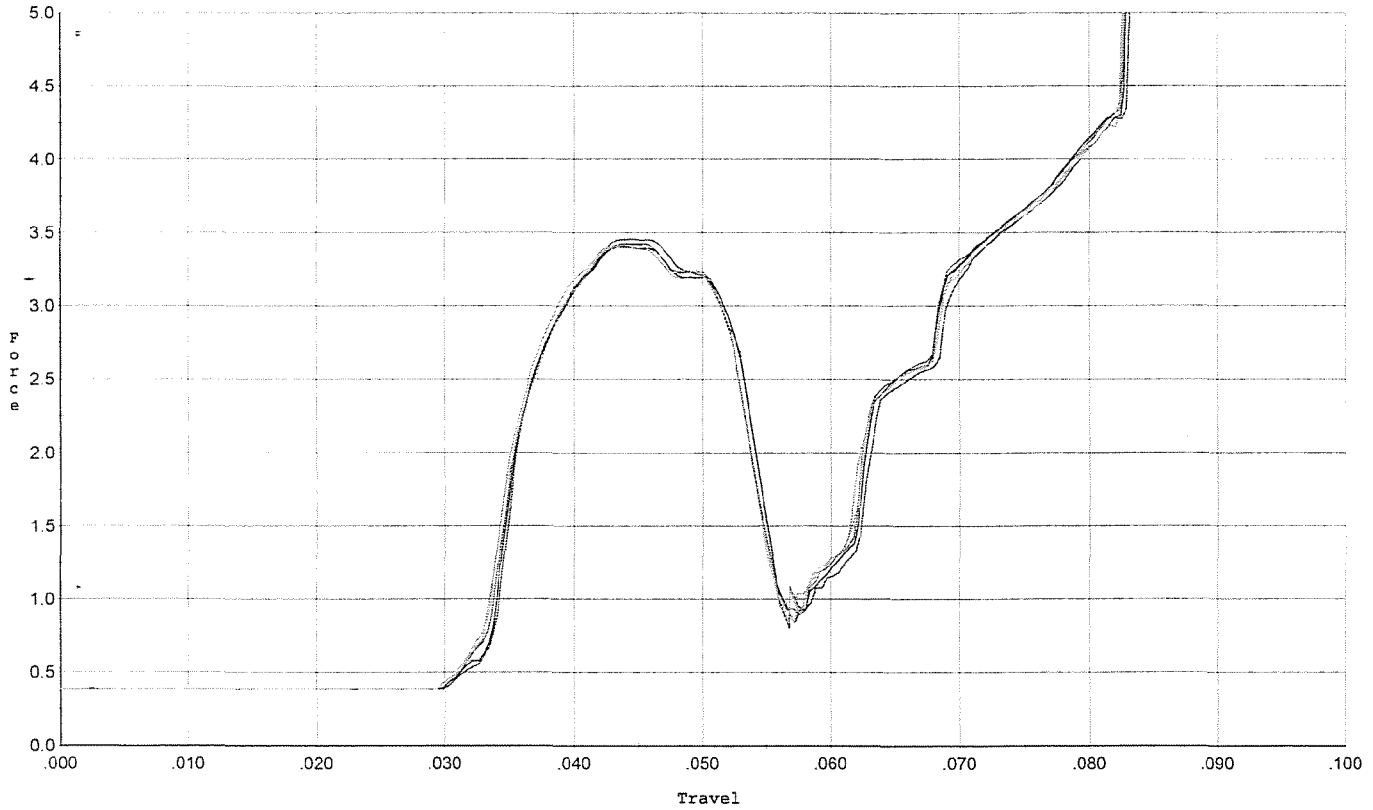
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.766	0.053	0.032	0.035	0.060		Set Trigger
2	2.711	0.052	0.032	0.035	0.058		Set Trigger
3	2.784	0.052	0.032	0.035	0.059		Set Trigger
4	2.861	0.052	0.032	0.034	0.060		Set Trigger
5	2.897	0.052	0.032	0.035	0.060		Set Trigger

2-280

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



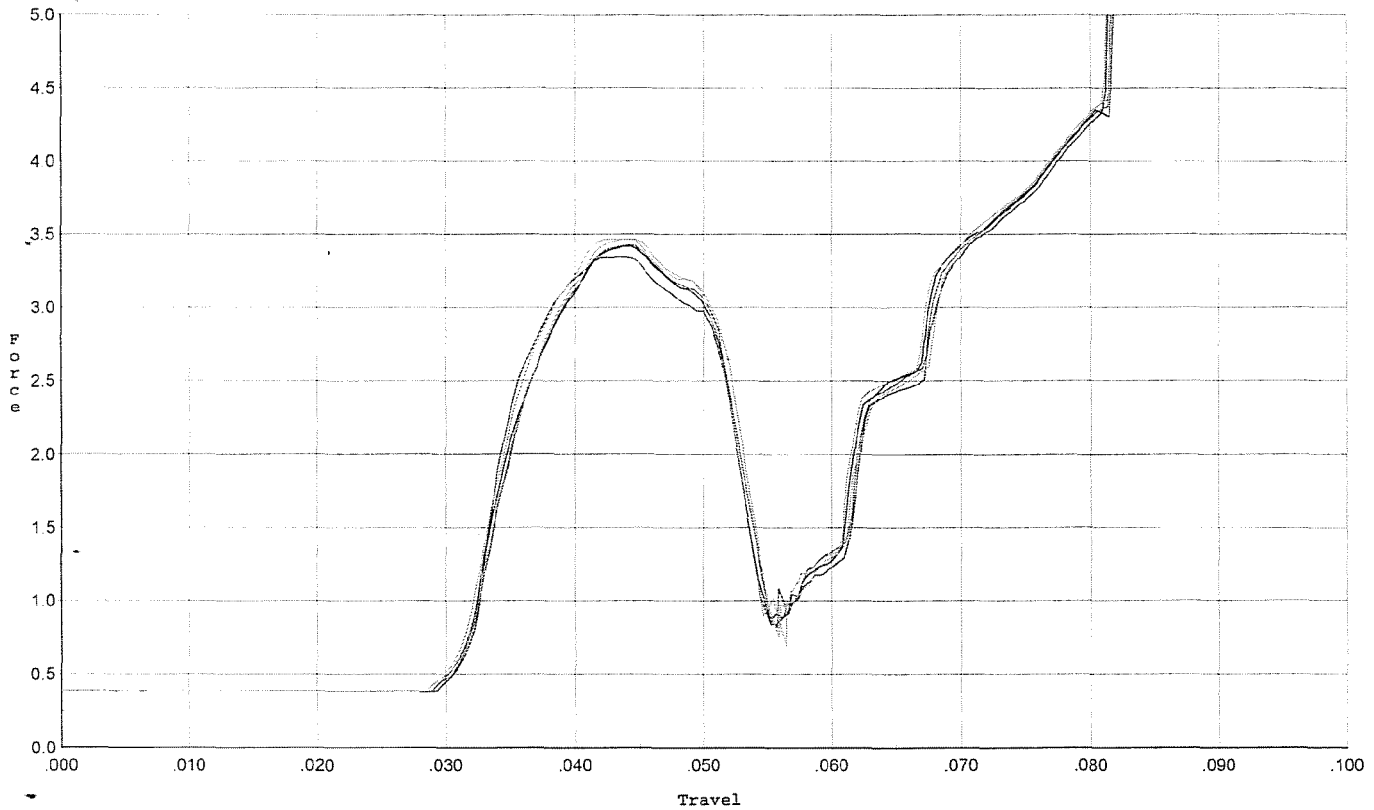
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.455	0.053	0.033	0.034	0.071		Set Trigger
2	3.404	0.053	0.033	0.034	0.071		Set Trigger
3	3.420	0.052	0.033	0.034	0.070		Set Trigger
4	3.414	0.052	0.033	0.034	0.070		Set Trigger
5	3.401	0.052	0.032	0.034	0.070		Set Trigger

4-3.41

Trigger Profile [lbs,inch]

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

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



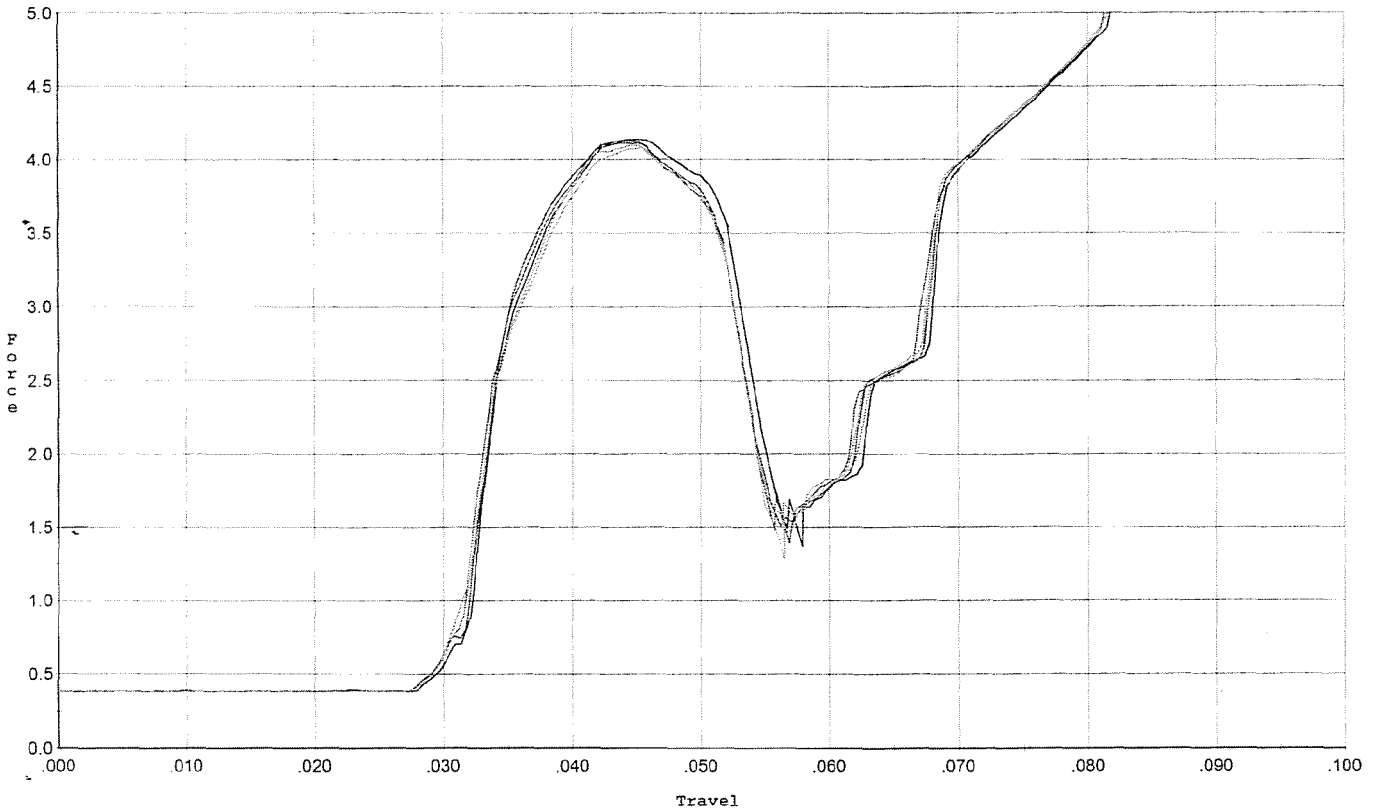
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.346	0.052	0.031	0.034	0.069		Set Trigger
2	3.420	0.051	0.031	0.034	0.068		Set Trigger
3	3.429	0.051	0.031	0.034	0.068		Set Trigger
4	3.466	0.051	0.031	0.033	0.070		Set Trigger
5	3.467	0.052	0.031	0.033	0.070		Set Trigger

ng-42

Trigger Profile [lbs,inch]

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

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



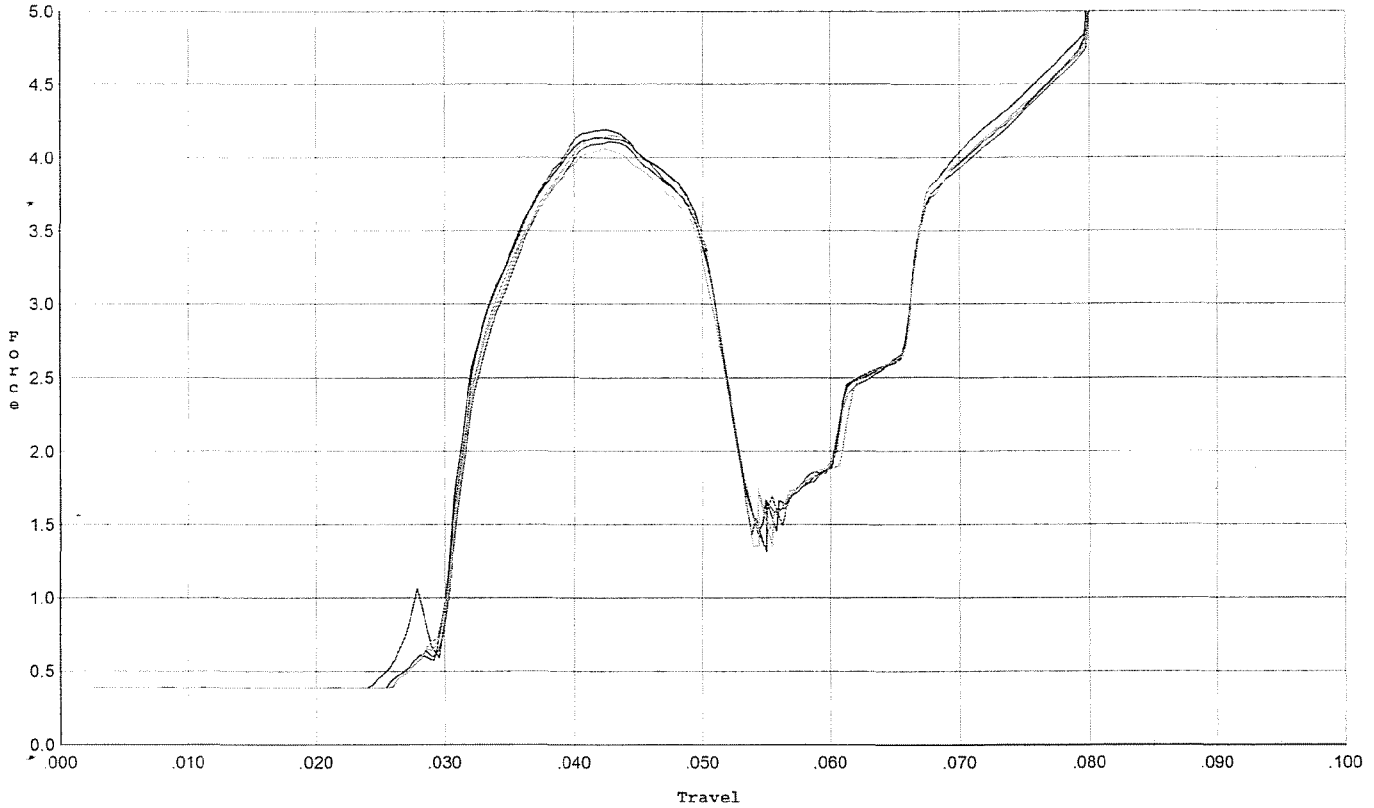
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.129	0.052	0.030	0.032	0.085		Set Trigger
2	4.138	0.052	0.031	0.032	0.086		Set Trigger
3	4.117	0.052	0.030	0.032	0.085		Set Trigger
4	4.081	0.052	0.030	0.032	0.083		Set Trigger
5	4.100	0.052	0.030	0.032	0.085		Set Trigger

A-4.11

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



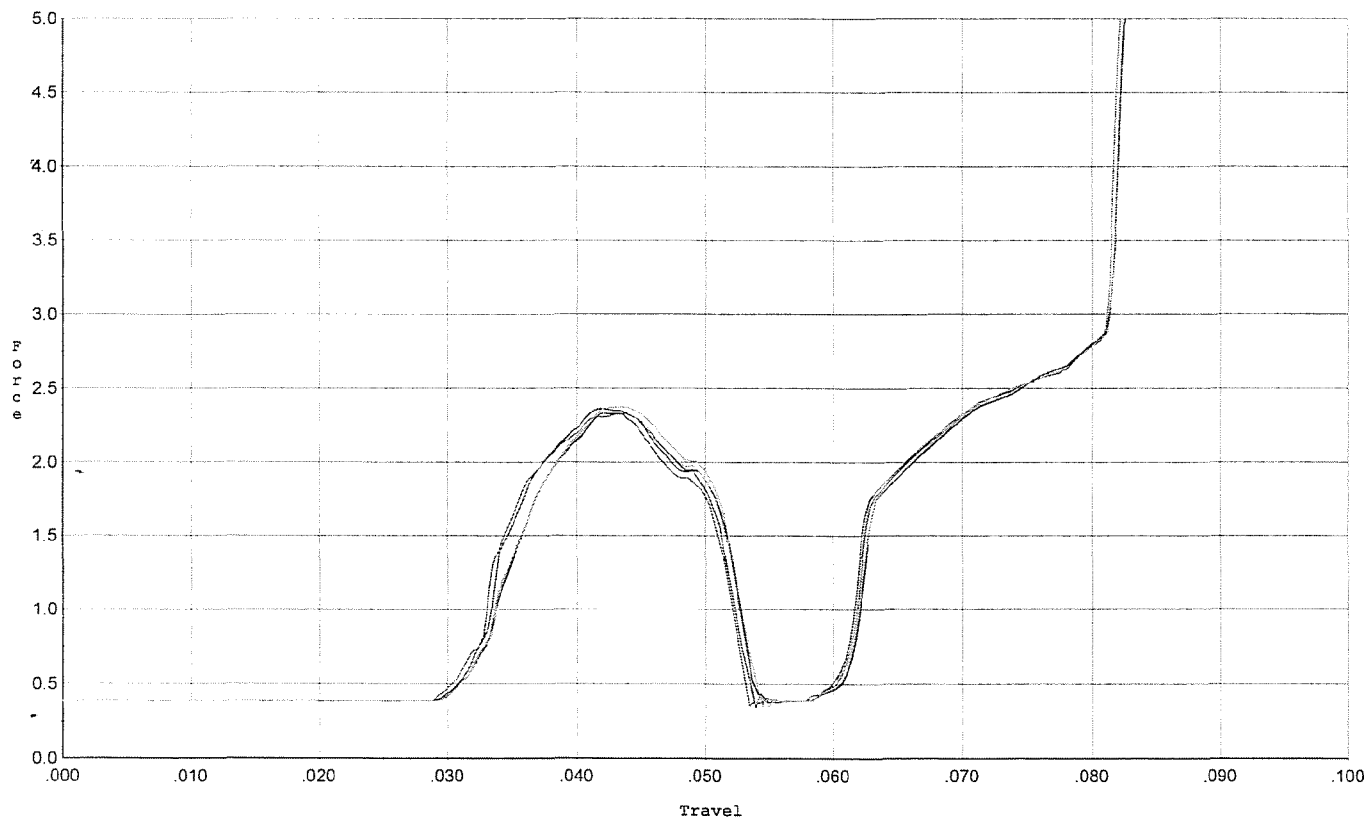
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.191	0.051	0.027	0.031	0.086		Set Trigger
2	4.139	0.050	0.029	0.031	0.086		Set Trigger
3	4.108	0.051	0.030	0.031	0.084		Set Trigger
4	4.061	0.051	0.029	0.031	0.085		Set Trigger
5	4.151	0.050	0.029	0.031	0.084		Set Trigger

A4-13

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 for final test



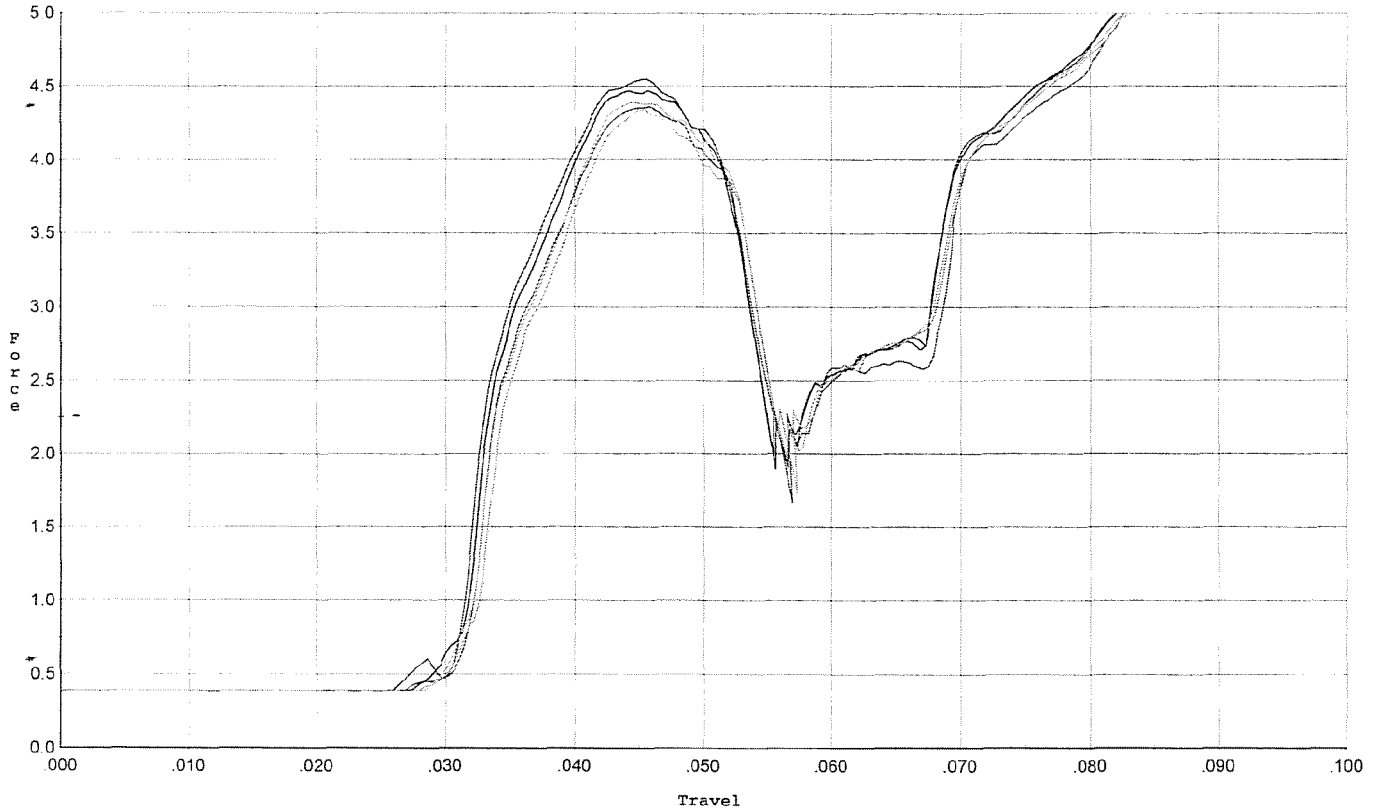
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.364	0.051	0.032	0.036	0.049		Set Trigger
2	2.334	0.052	0.032	0.036	0.049		Set Trigger
3	2.326	0.051	0.031	0.036	0.050		Set Trigger
4	2.374	0.051	0.032	0.036	0.050		Set Trigger
5	2.336	0.052	0.032	0.036	0.049		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 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.553	0.052	0.031	0.032	0.093		Set Trigger
2	4.472	0.053	0.030	0.032	0.092		Set Trigger
3	4.362	0.052	0.031	0.033	0.088		Set Trigger
4	4.389	0.053	0.031	0.032	0.090		Set Trigger
5	4.341	0.053	0.031	0.033	0.088		Set Trigger

A-4-42