

G6785062

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



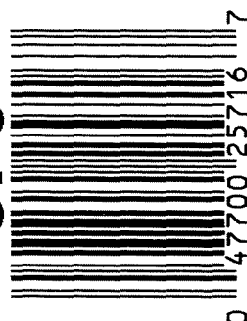
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785062

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 678 5062

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SP
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SP
460	CHECK HEADSPACE		9-19-08	SP
470	DIS-ASSEMBLE ACTION		9-19-08	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-7-08	RT
475	DRILL AND TAP SIGHT HOLES	ULI V 0 200H	10-7-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/8/08	
490	MAGNAFLUX BOLT		9/19/08	MR
500	ROLLMARK CALIBER		10/8/08	RT
520	GOFF BLAST BBL / REC		10/9/08	RG
542	APPLY COATINGS (BARREL ACTION)		10/3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/13/08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/13/08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/13/08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

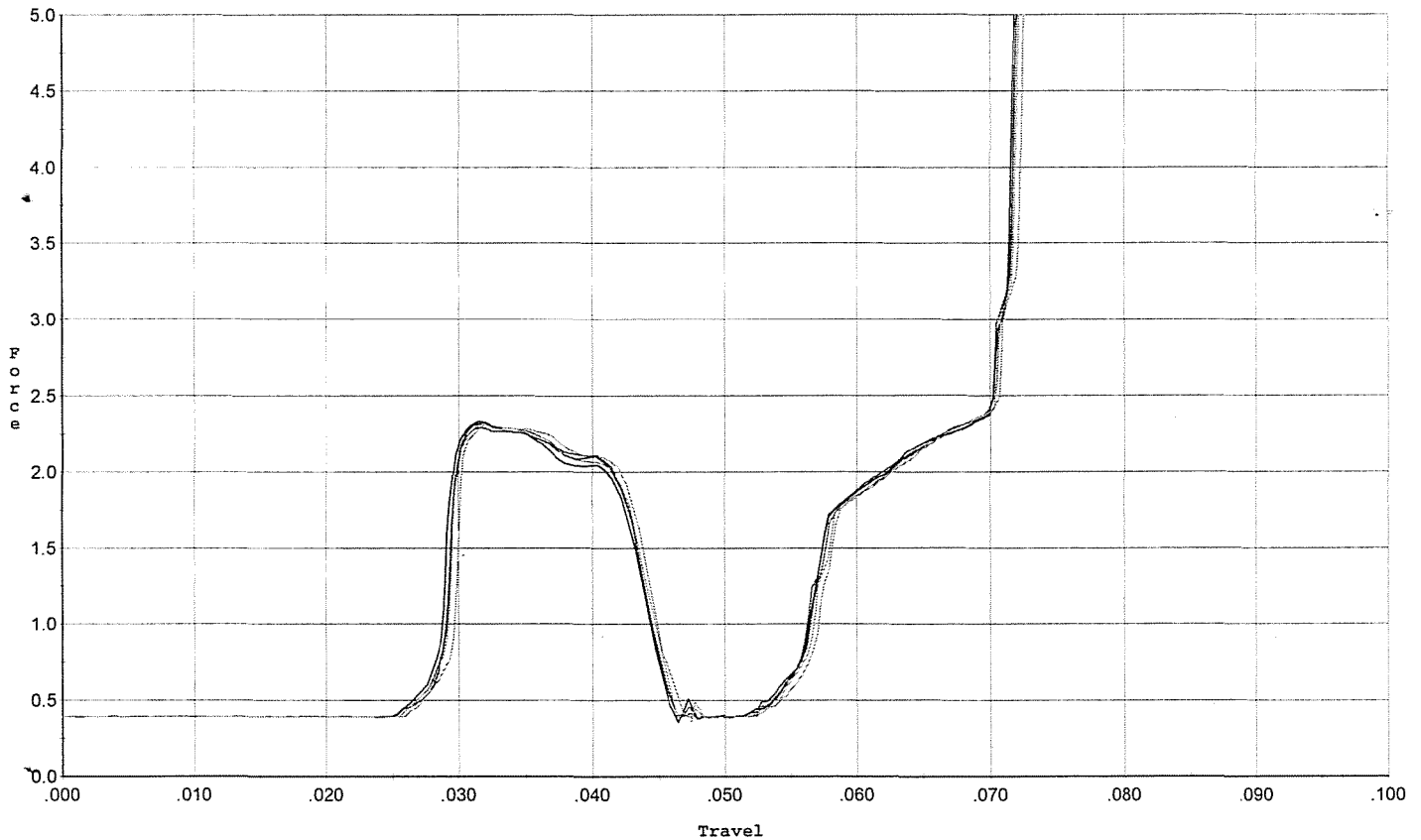
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>3.0</u> <u>3.0</u>	11-20-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-20-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>-.024</u> <u>.024</u> <u>.024</u>	11-20-08	LJ
	J) ASSEMBLE STOCK		11-12-08	TC
	K) ASSEMBLE SWIVEL STUDS		11-20-08	LJ
	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	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-13-08	JJ
670	FINAL INSPECTION A) HEADSPACE		11-20-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.39</u> <u>2.42</u> <u>2.43</u> <u>2.32</u>	11-20-08	TC
	C) FUNCTION		11-20-08	LJ
690	PACK		12-2-08	TC

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	2.321	0.043	0.028	0.033	0.042		Set Trigger
2	2.333	0.043	0.028	0.032	0.042		Set Trigger
3	2.293	0.043	0.028	0.033	0.042		Set Trigger
4	2.316	0.043	0.028	0.033	0.041		Set Trigger
5	2.315	0.044	0.029	0.032	0.042		Set Trigger

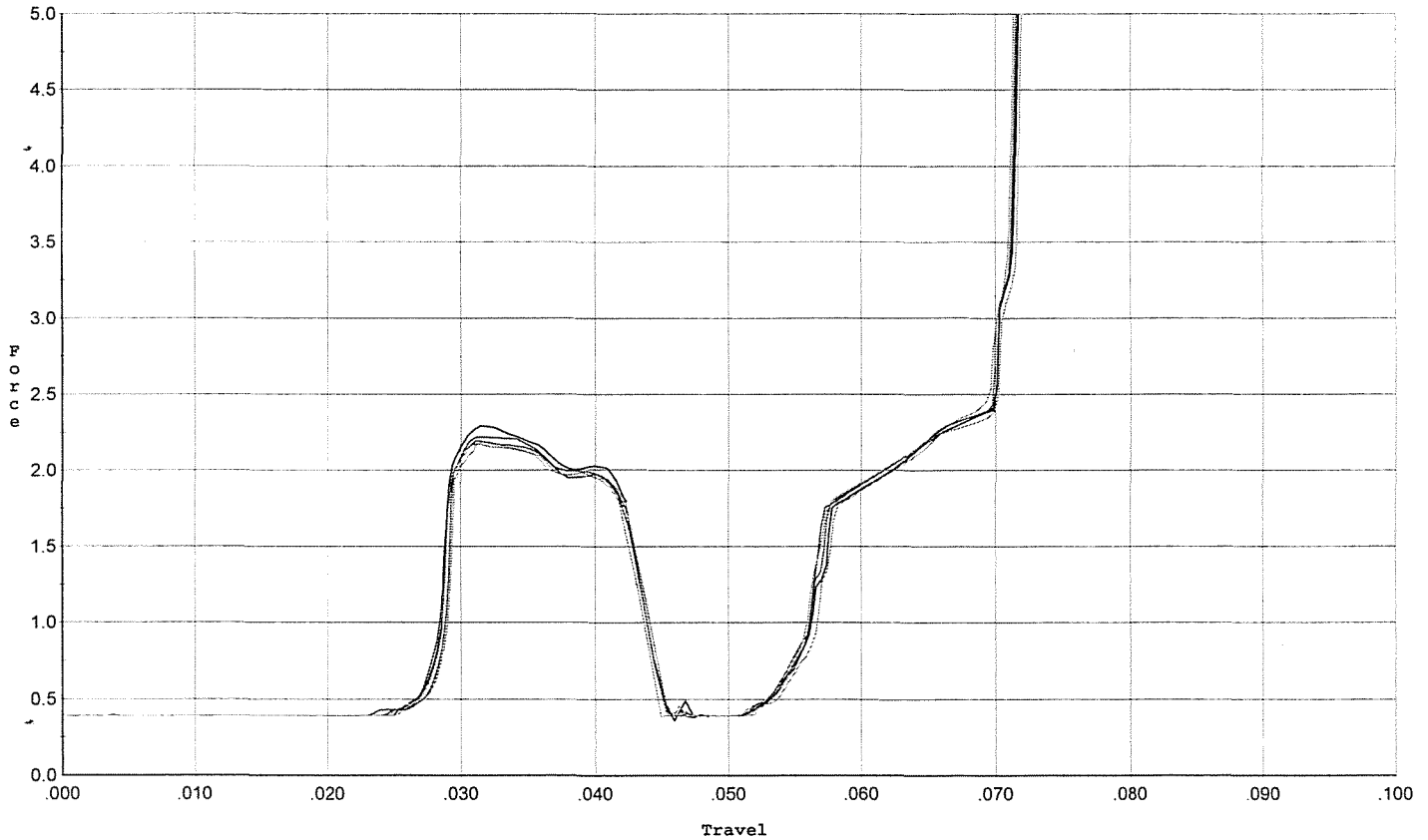
A-2-31

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

After 50 cycles



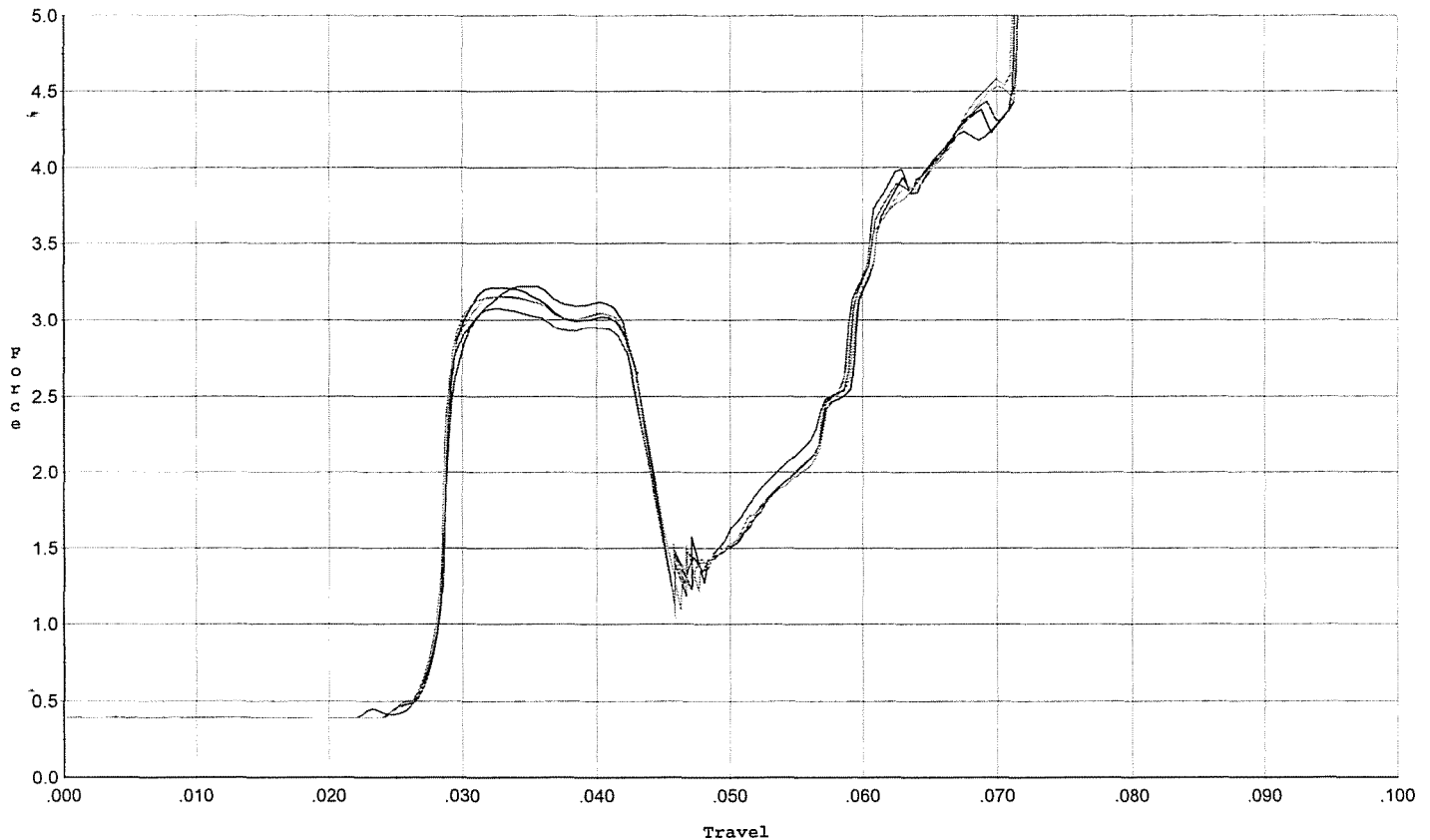
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.218	0.043	0.027	0.033	0.040		Set Trigger
2	2.294	0.042	0.028	0.033	0.041		Set Trigger
3	2.195	0.042	0.028	0.033	0.040		Set Trigger
4	2.191	0.044	0.028	0.033	0.041		Set Trigger
5	2.176	0.043	0.028	0.033	0.040		Set Trigger

A-2-21

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



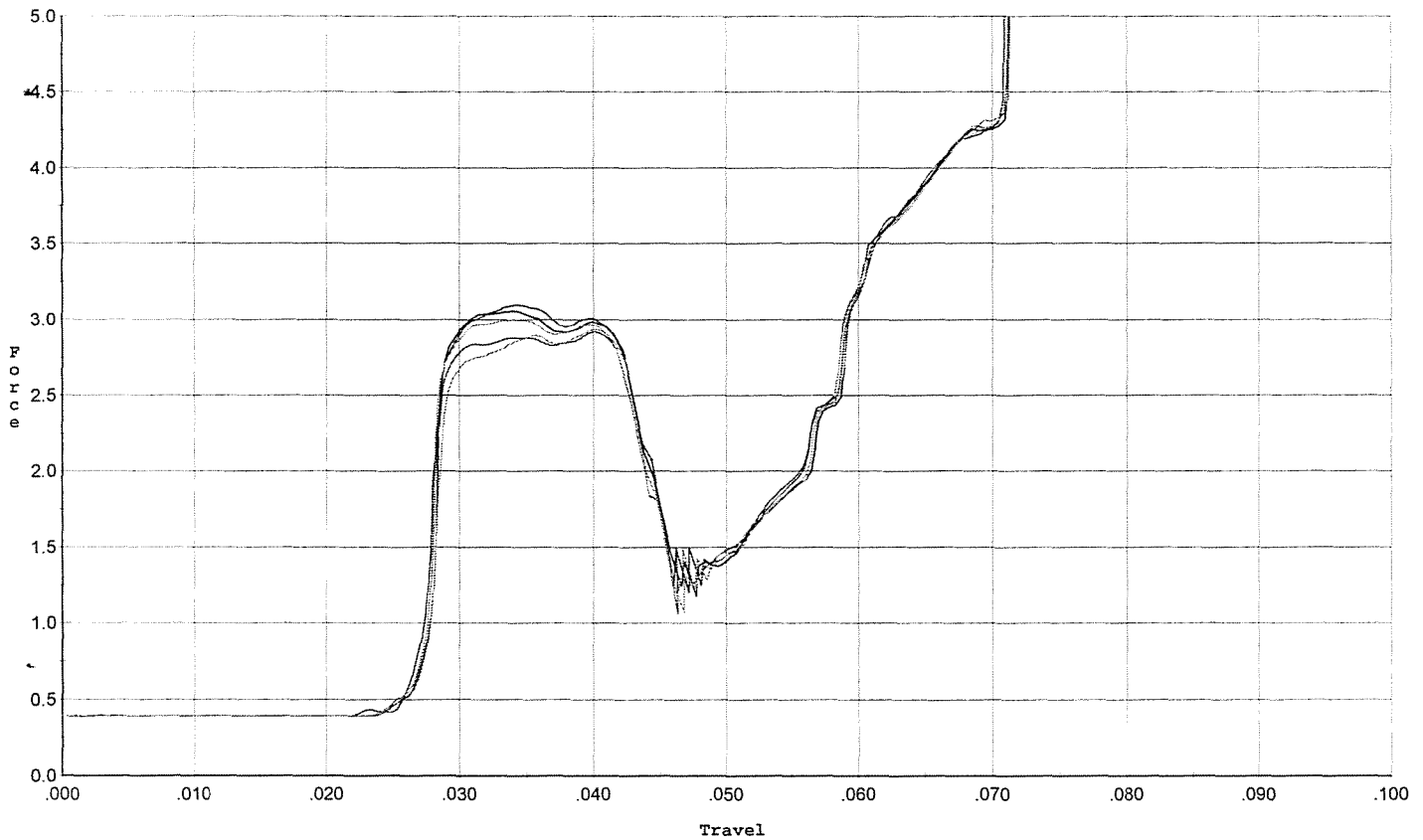
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.218	0.043	0.027	0.030	0.056		Set Trigger
2	3.207	0.043	0.027	0.030	0.056		Set Trigger
3	3.074	0.044	0.027	0.030	0.056		Set Trigger
4	3.150	0.043	0.027	0.030	0.056		Set Trigger
5	3.155	0.044	0.027	0.030	0.057		Set Trigger

A-3-16

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



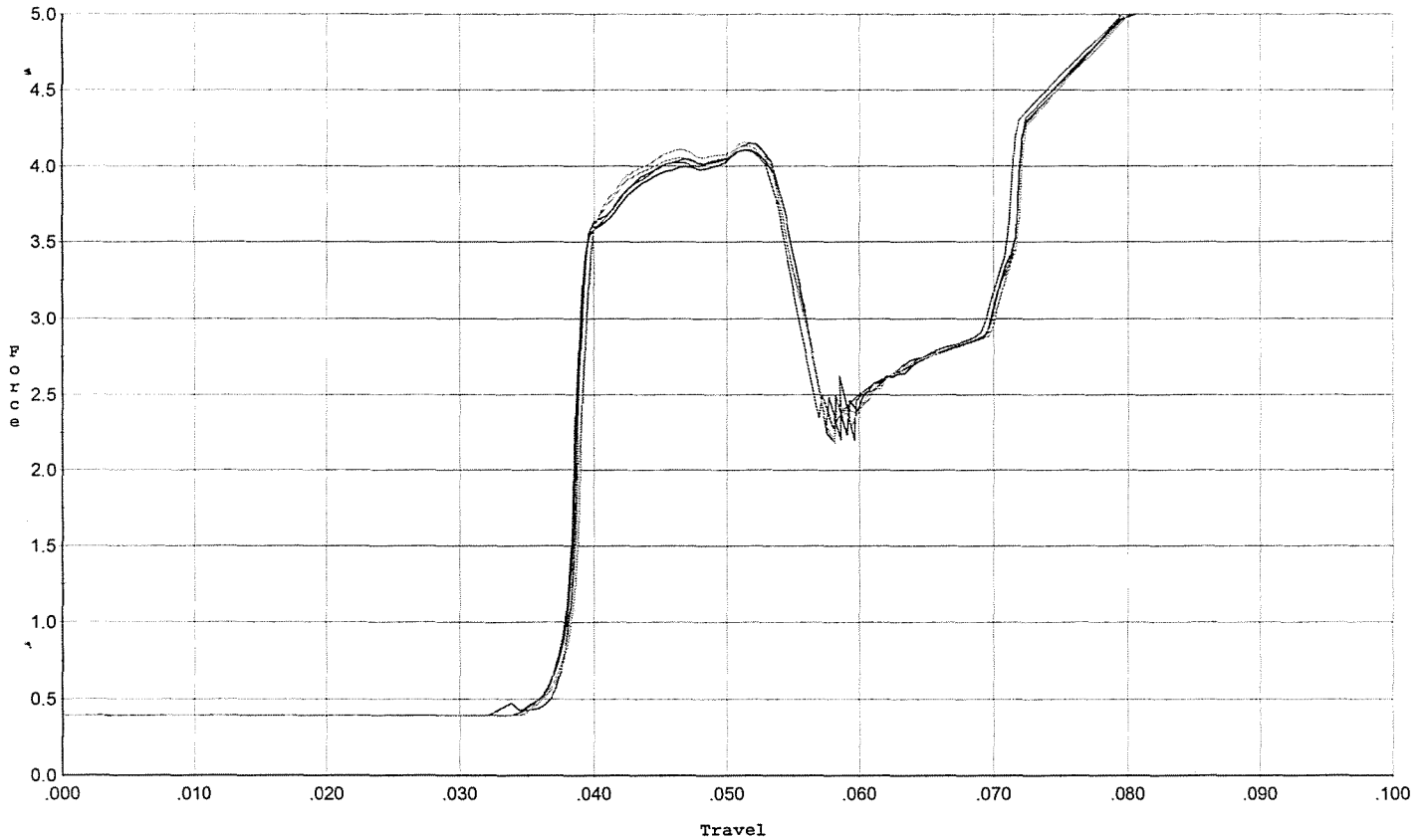
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.097	0.044	0.026	0.029	0.059		Set Trigger
2	3.059	0.042	0.027	0.030	0.055		Set Trigger
3	2.920	0.045	0.027	0.029	0.057		Set Trigger
4	3.002	0.045	0.027	0.029	0.058		Set Trigger
5	2.936	0.042	0.027	0.030	0.053		Set Trigger

A-3.00

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



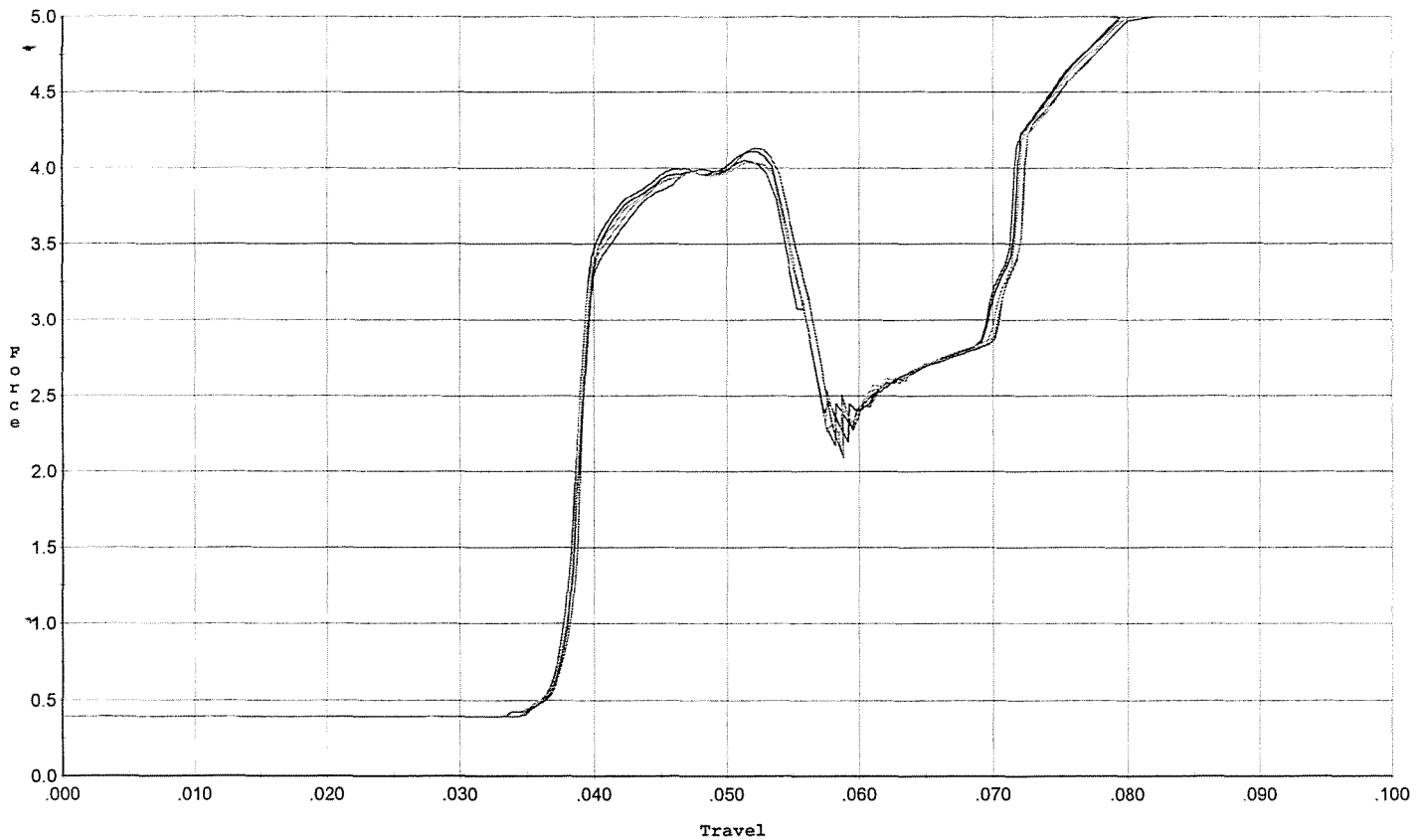
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.150	0.056	0.037	0.031	0.083		Set Trigger
2	4.105	0.056	0.037	0.031	0.083		Set Trigger
3	4.108	0.054	0.037	0.031	0.079		Set Trigger
4	4.131	0.056	0.037	0.031	0.083		Set Trigger
5	4.156	0.056	0.037	0.031	0.083		Set Trigger

A-4.B

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



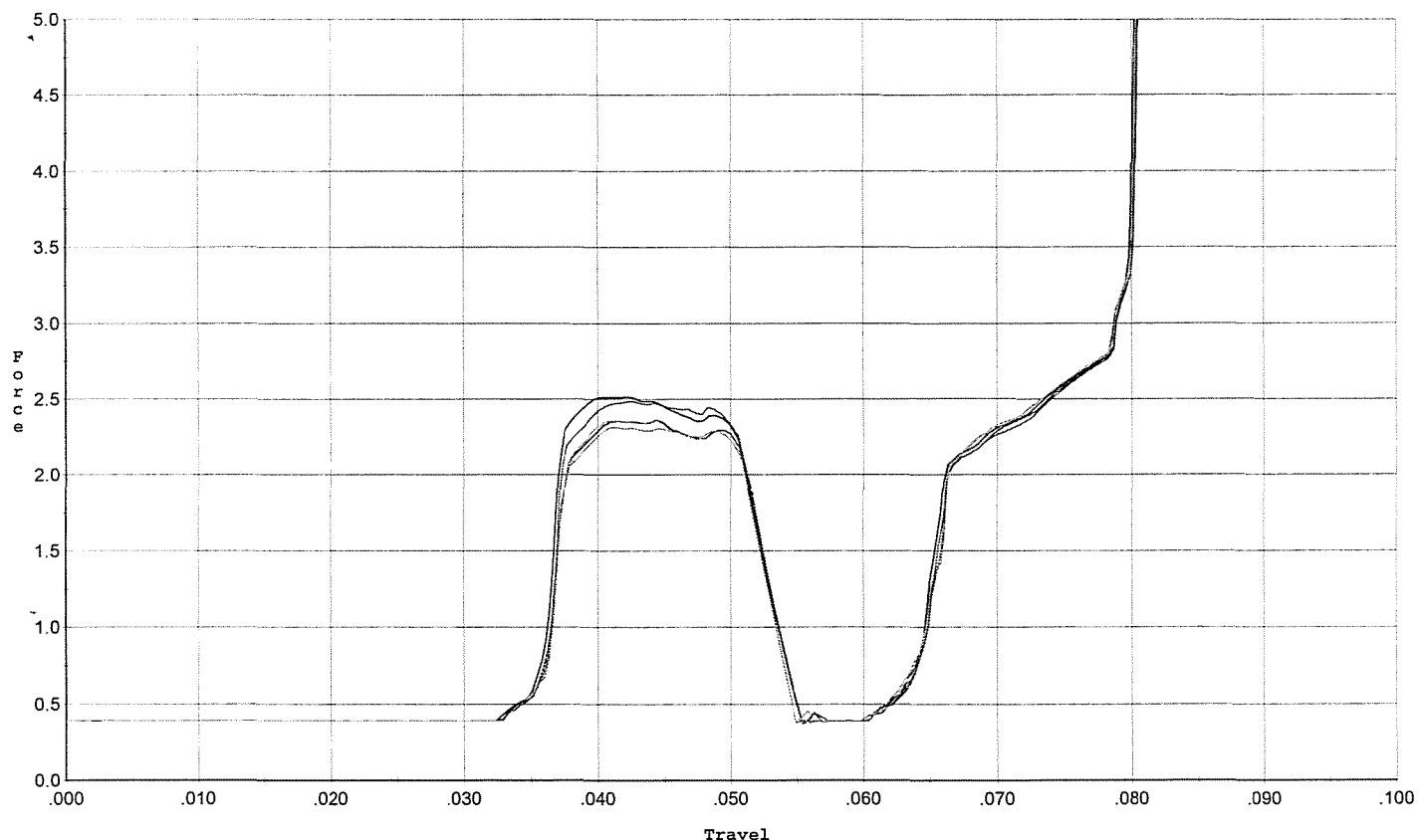
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.050	0.056	0.037	0.031	0.082		Set Trigger
2	4.111	0.056	0.037	0.031	0.082		Set Trigger
3	4.131	0.056	0.037	0.031	0.083		Set Trigger
4	4.034	0.056	0.037	0.031	0.082		Set Trigger
5	4.036	0.056	0.037	0.031	0.082		Set Trigger

A-41.07

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



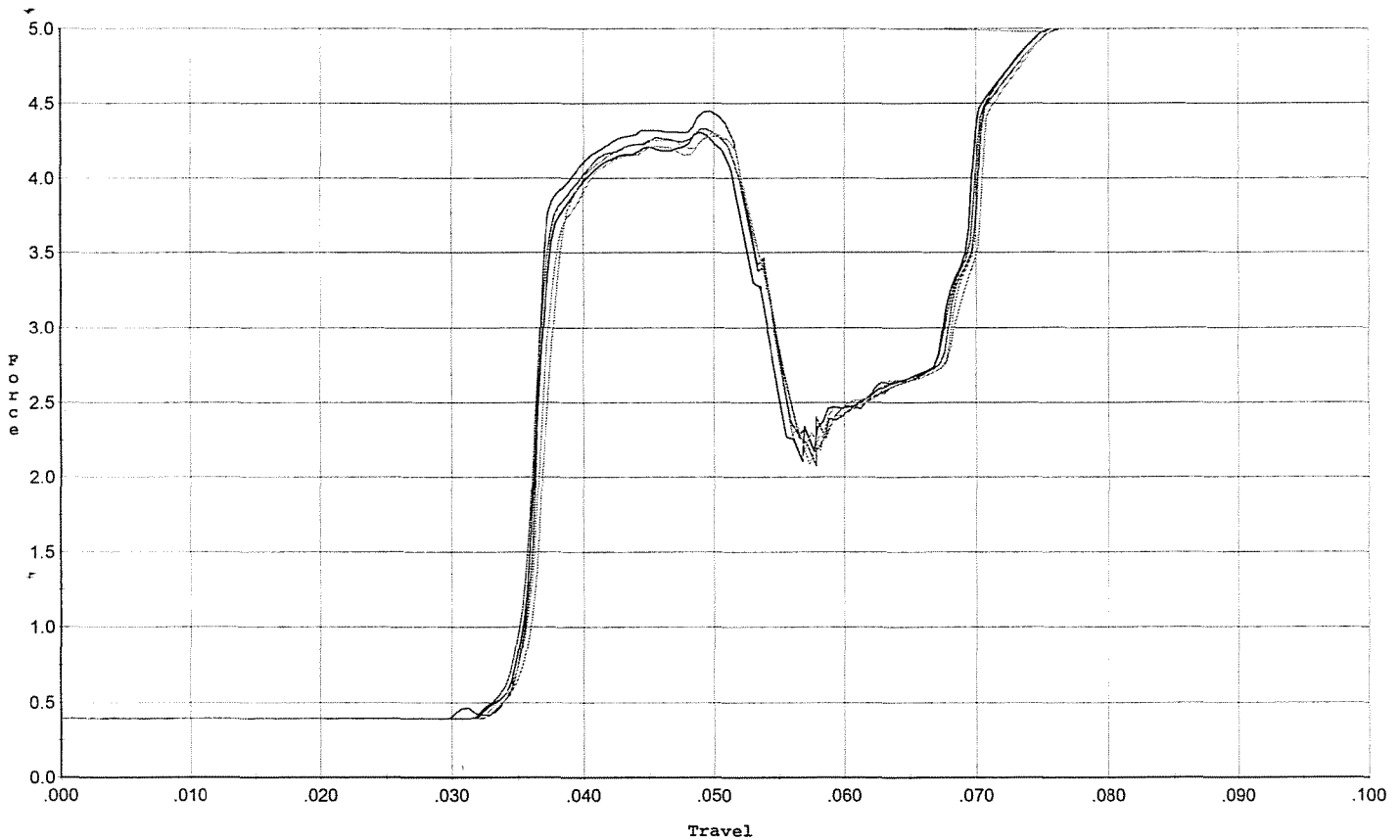
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.364	0.052	0.036	0.035	0.049		Set Trigger
2	2.515	0.052	0.035	0.035	0.052		Set Trigger
3	2.485	0.052	0.036	0.035	0.051		Set Trigger
4	2.367	0.052	0.036	0.035	0.049		Set Trigger
5	2.315	0.051	0.036	0.035	0.047		Set Trigger

A-2.40

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 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.448	0.054	0.035	0.027	0.089		Set Trigger
2	4.307	0.054	0.035	0.028	0.085		Set Trigger
3	4.328	0.054	0.034	0.028	0.088		Set Trigger
4	4.303	0.054	0.035	0.028	0.086		Set Trigger
5	4.279	0.054	0.035	0.028	0.086		Set Trigger

A 4.33