

G6789962

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



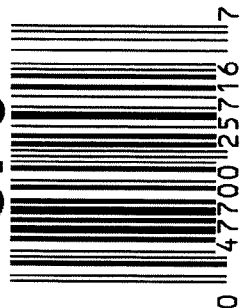
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6789962

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6789962

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-8-08	RSN
475	DRILL AND TAP SIGHT HOLES	UCI 1 2008	10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (B)	10/11/08	(B)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10/15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-15-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-15-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-15-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	LTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

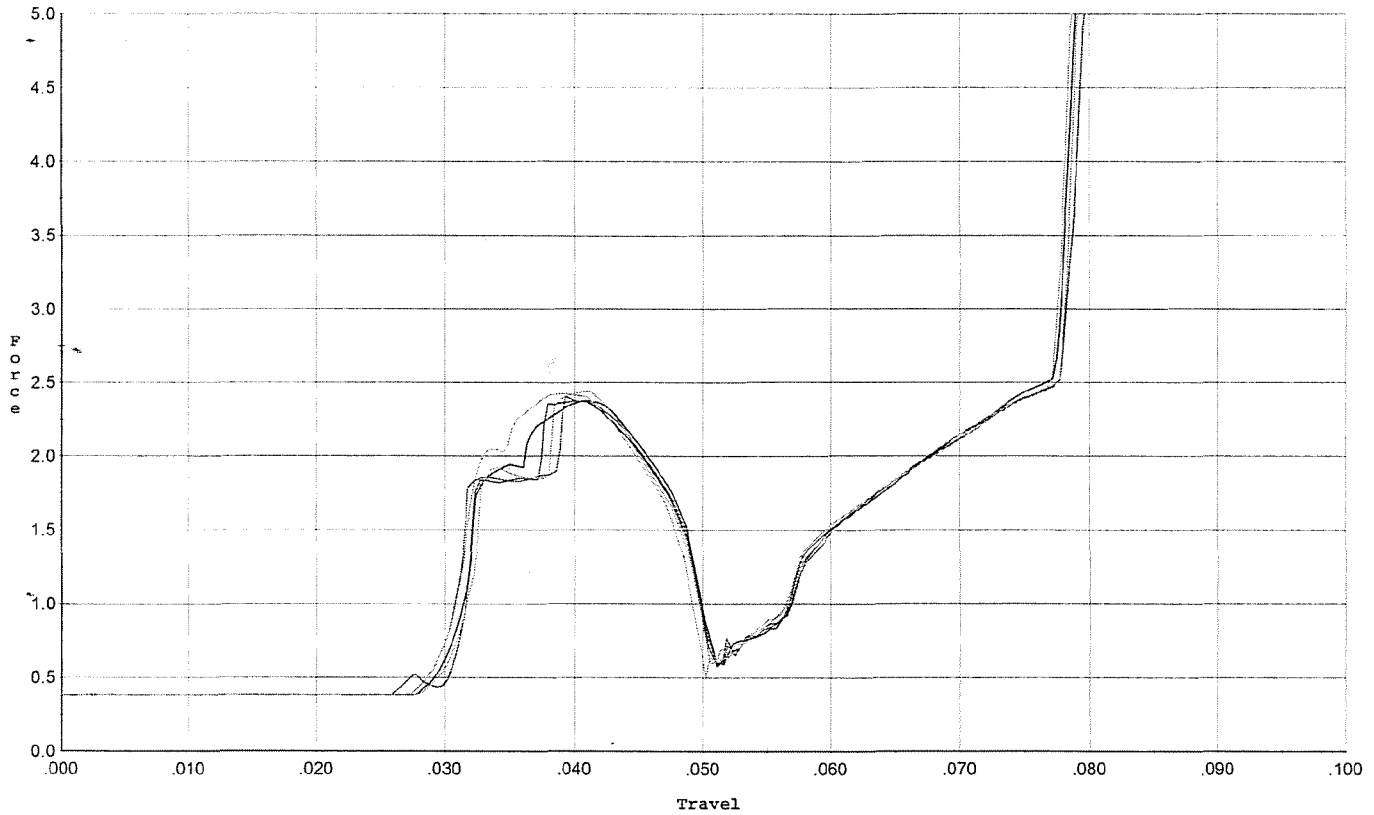
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>49</u> <u>49</u> <u>50</u>	11-13-08	LQ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-13-08	LQ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>-0.03</u> <u>.023</u> <u>.023</u>	11-13-08	LQ
	J) ASSEMBLE STOCK		11-10-08	TL
	K) ASSEMBLE SWIVEL STUDS		11-13-08	LQ
	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	11-11-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-11-08	JS
670	FINAL INSPECTION A) HEADSPACE		11-13-08	LQ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.53</u> <u>2.61</u> <u>2.48</u> <u>2.54</u>	11-12-08	TL
	C) FUNCTION		11-13-08	LQ
690	PACK		11/14/08	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



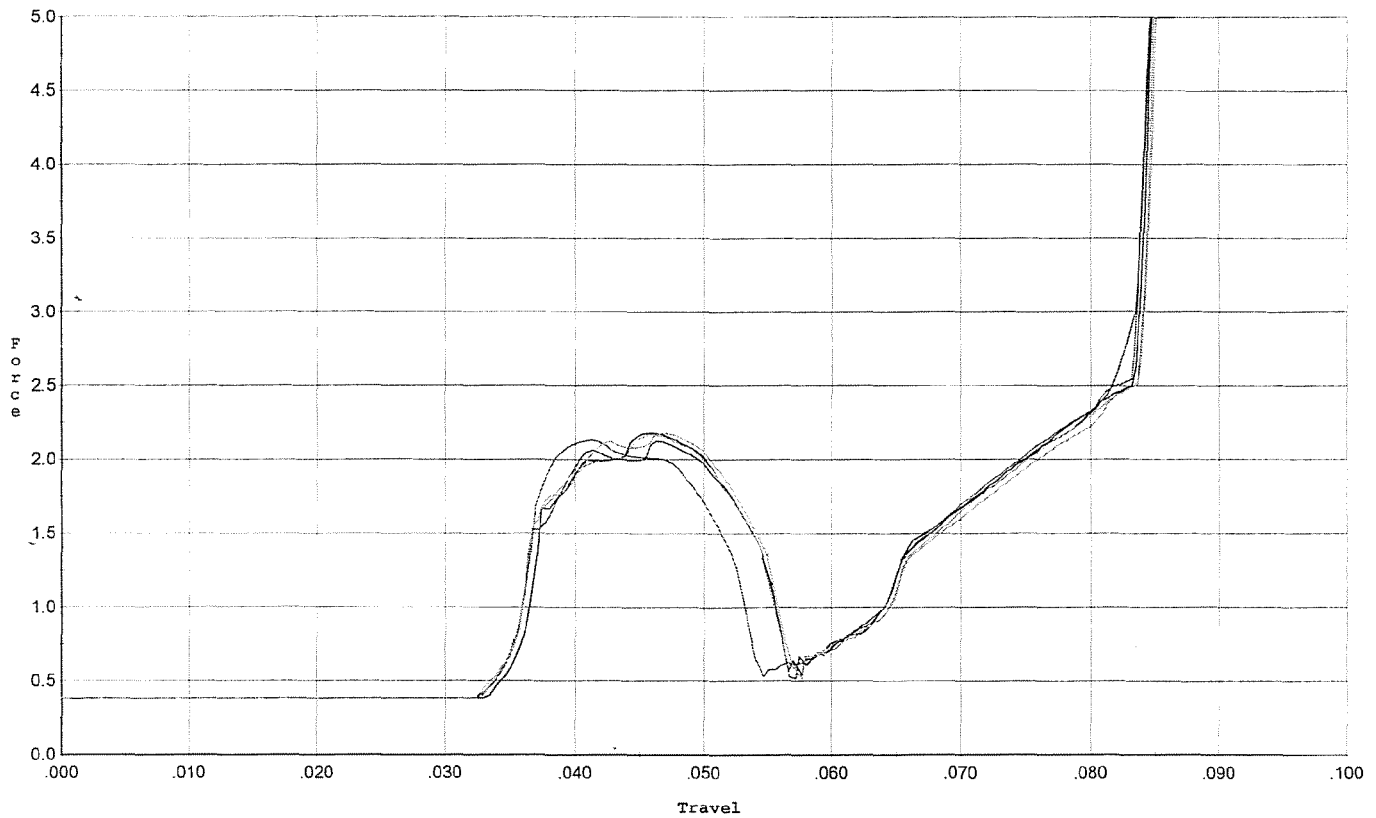
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.372	0.049	0.031	0.036	0.047		Set Trigger
2	2.377	0.049	0.030	0.035	0.048		Set Trigger
3	2.408	0.049	0.030	0.035	0.048		Set Trigger
4	2.442	0.049	0.030	0.035	0.047		Set Trigger
5	2.423	0.048	0.030	0.035	0.049		Set Trigger

A-2-10

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



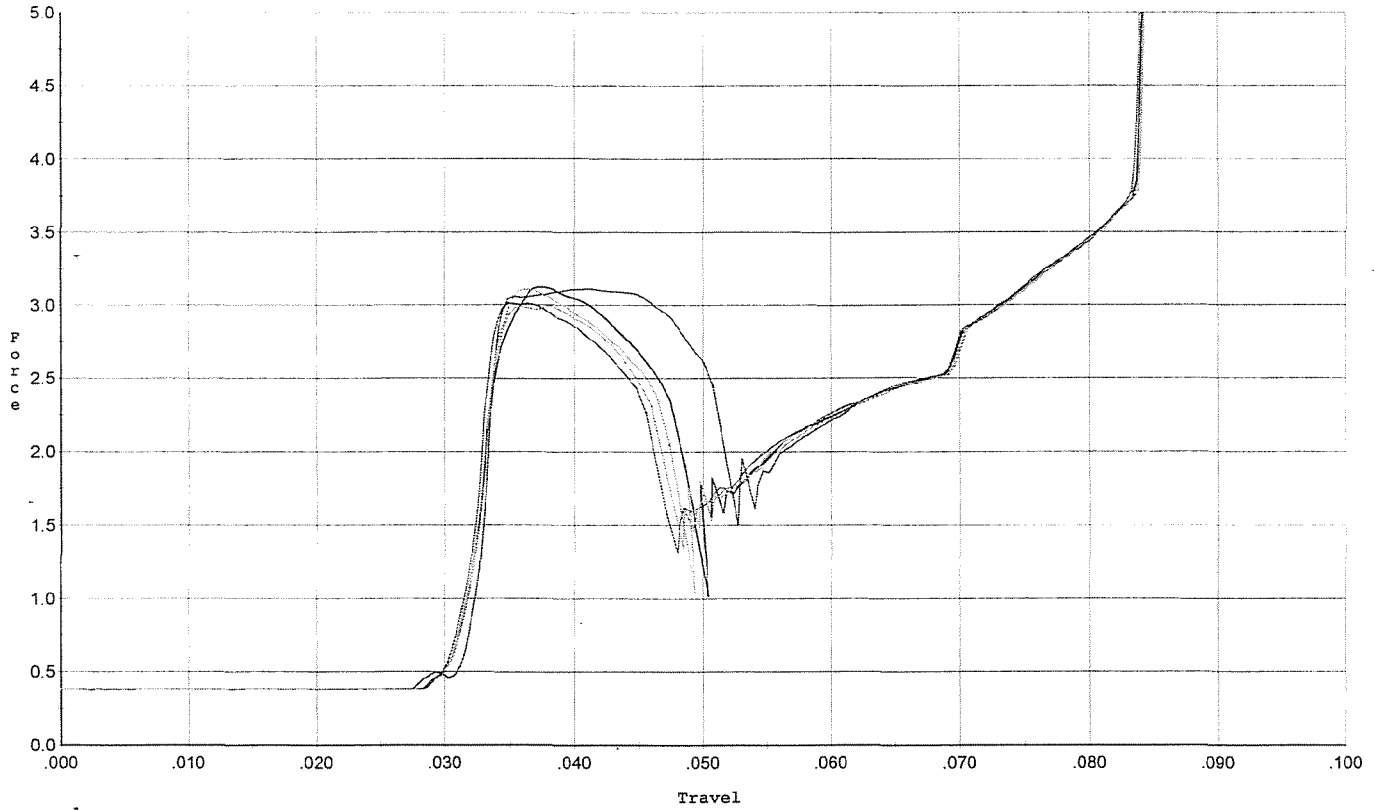
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.126	0.055	0.035	0.036	0.050		Set Trigger
2	2.180	0.055	0.034	0.036	0.050		Set Trigger
3	2.134	0.053	0.035	0.037	0.046		Set Trigger
4	2.177	0.055	0.034	0.036	0.050		Set Trigger
5	2.167	0.055	0.035	0.036	0.051		Set Trigger

A-2.15

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



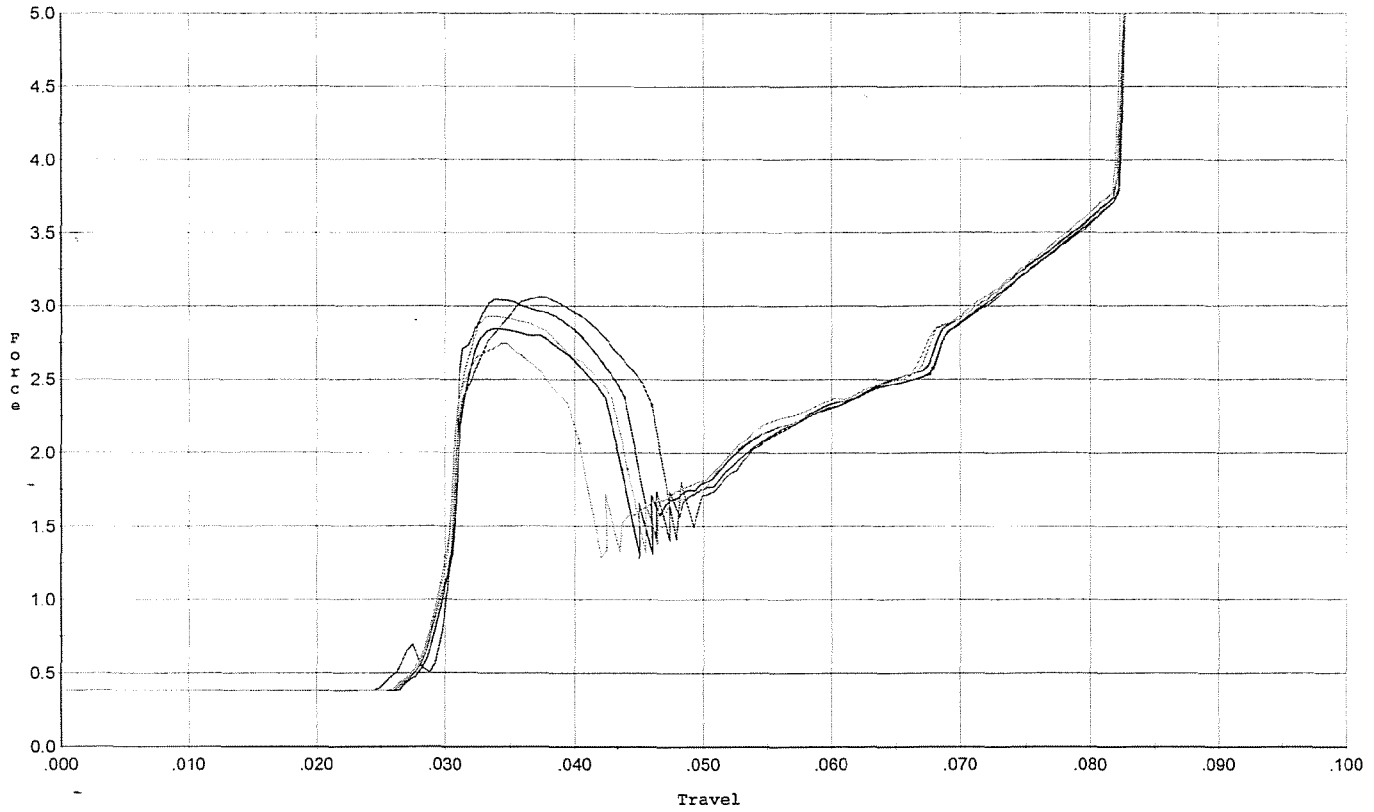
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.110	0.051	0.031	0.035	0.067		Set Trigger
2	3.128	0.049	0.031	0.038	0.058		Set Trigger
3	3.014	0.046	0.030	0.041	0.050		Set Trigger
4	3.108	0.047	0.031	0.039	0.055		Set Trigger
5	2.996	0.046	0.031	0.040	0.051		Set Trigger

A-3.07

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 after 20 cycles+/- .75 lbs



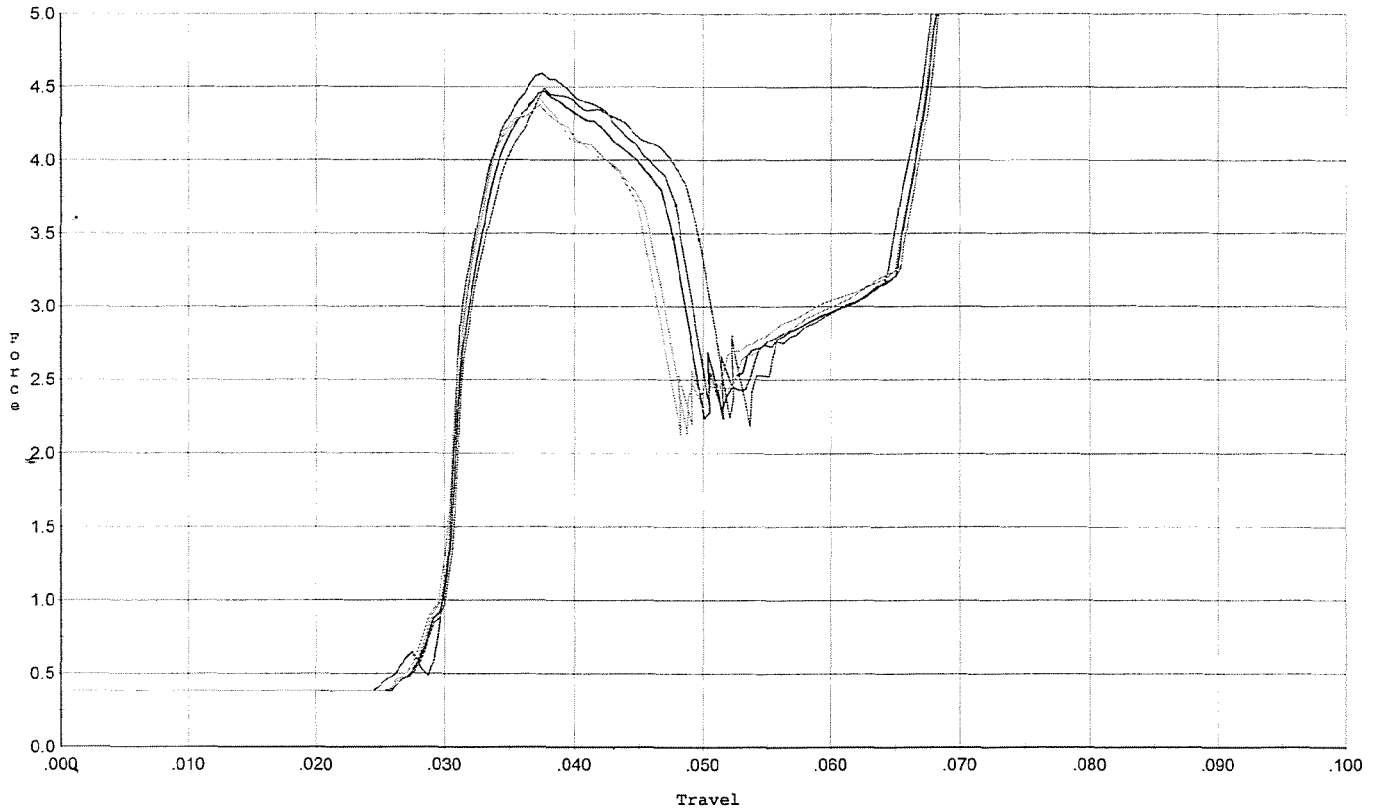
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.046	0.044	0.027	0.041	0.051		Set Trigger
2	2.845	0.044	0.029	0.042	0.047		Set Trigger
3	3.062	0.046	0.028	0.038	0.056		Set Trigger
4	2.929	0.044	0.028	0.042	0.049		Set Trigger
5	2.744	0.040	0.028	0.046	0.039		Set Trigger

A-2-92

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 ini +/- 1.0 lb



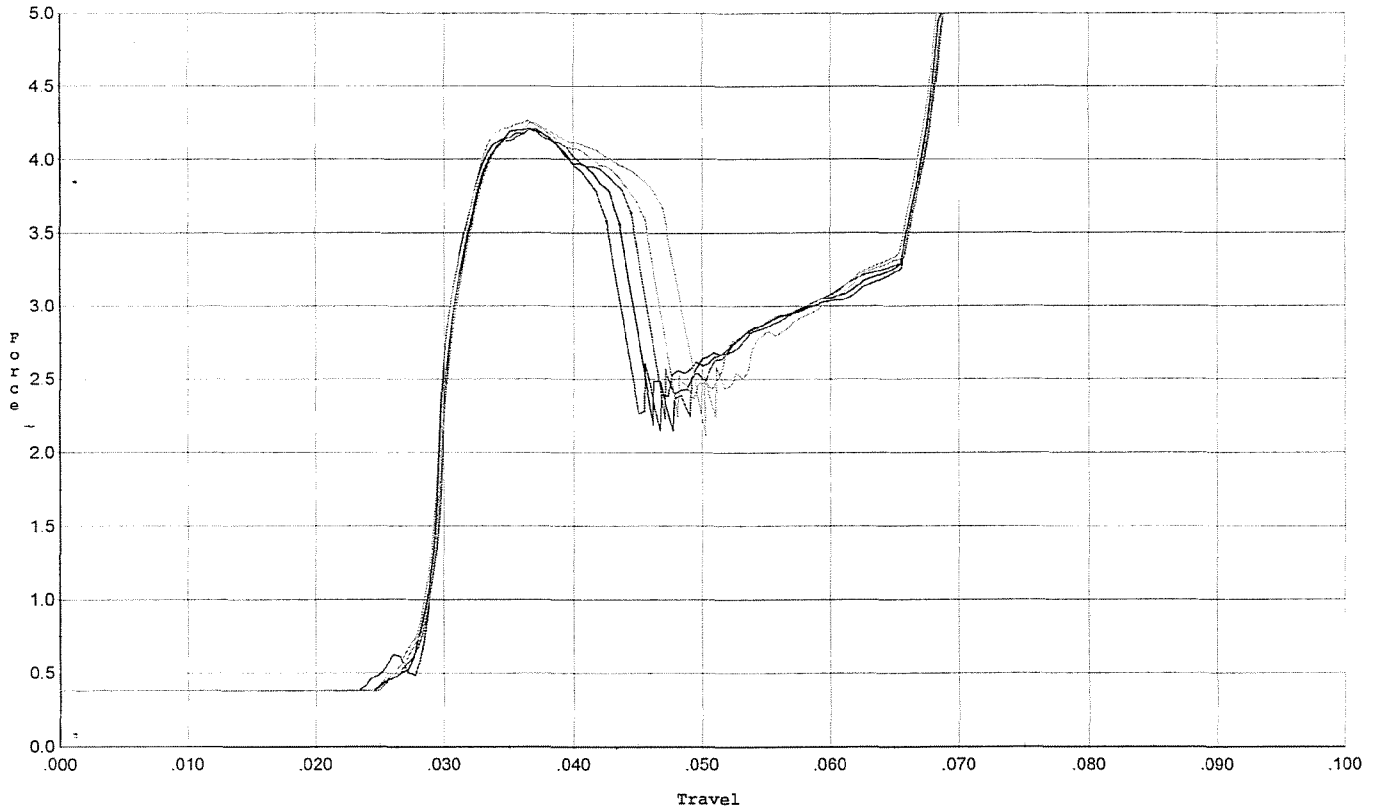
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.591	0.048	0.027	0.024	0.086		Set Trigger
2	4.469	0.048	0.028	0.025	0.082		Set Trigger
3	4.487	0.050	0.028	0.023	0.089		Set Trigger
4	4.422	0.047	0.028	0.026	0.077		Set Trigger
5	4.380	0.046	0.028	0.027	0.075		Set Trigger

A-4147

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note:

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



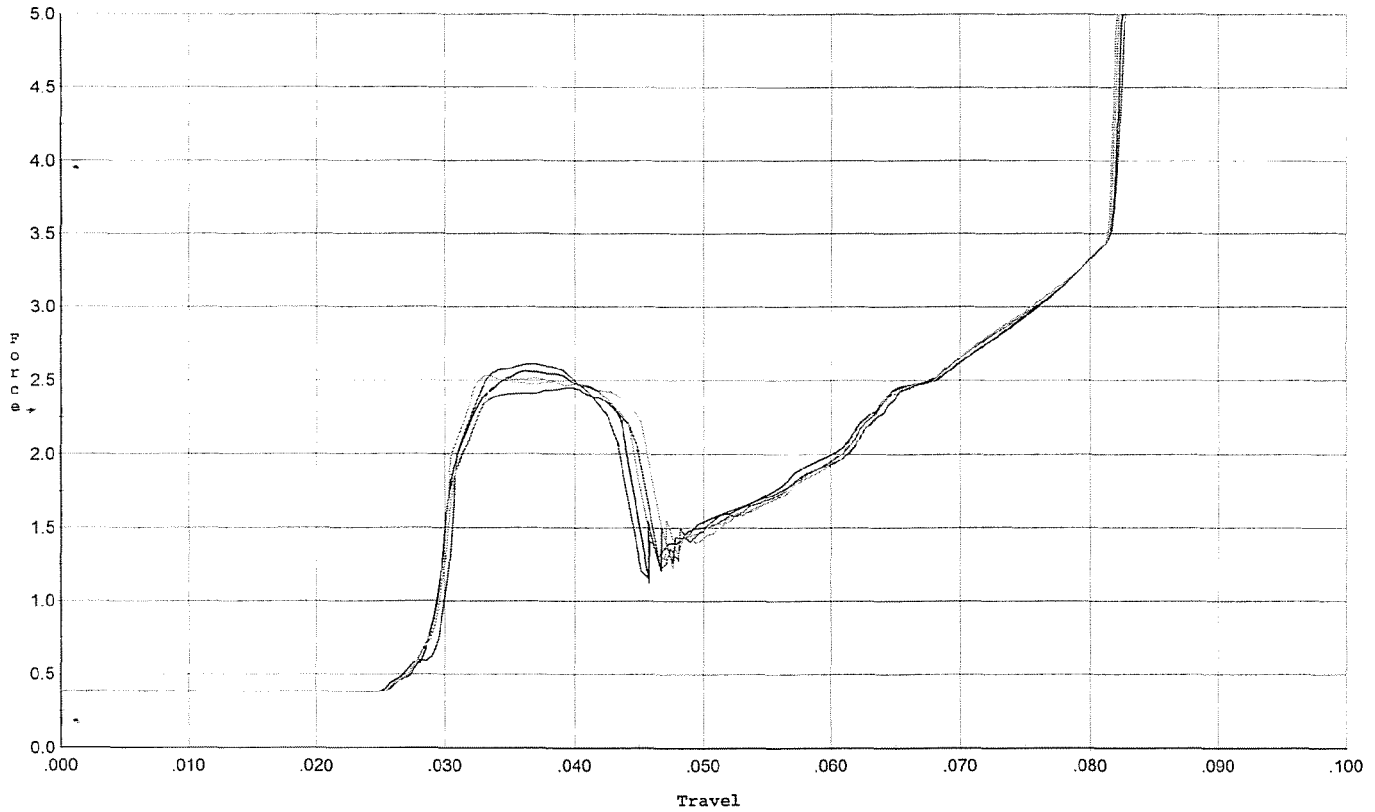
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.210	0.043	0.026	0.029	0.065		Set Trigger
2	4.213	0.044	0.028	0.028	0.069		Set Trigger
3	4.202	0.044	0.028	0.028	0.071		Set Trigger
4	4.253	0.047	0.027	0.026	0.081		Set Trigger
5	4.266	0.046	0.027	0.027	0.077		Set Trigger

A4-22

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



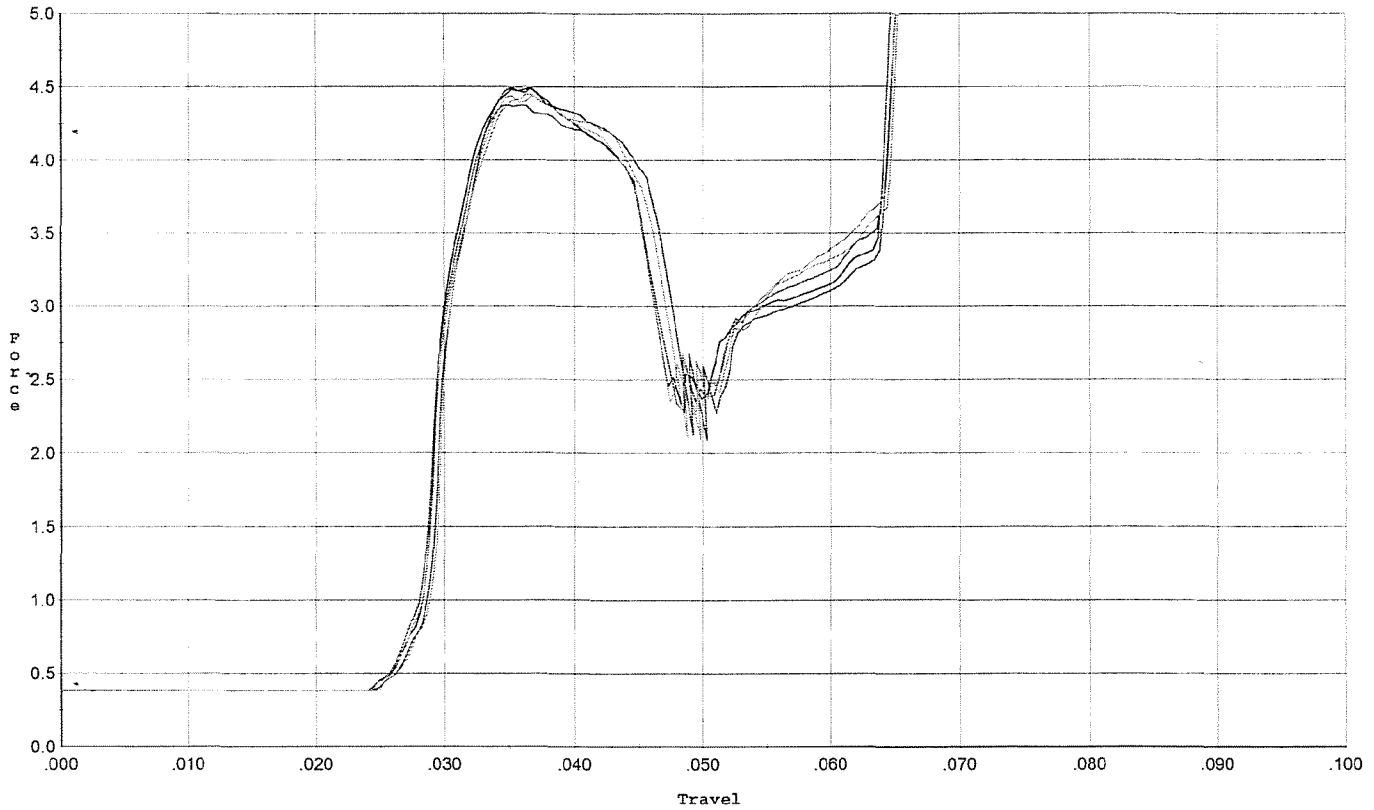
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.043	0.028	0.043	0.045		Set Trigger
2	2.560	0.044	0.028	0.042	0.046		Set Trigger
3	2.450	0.045	0.028	0.040	0.047		Set Trigger
4	2.512	0.045	0.028	0.040	0.049		Set Trigger
5	2.534	0.044	0.028	0.041	0.047		Set Trigger

A-253

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C. Schultz 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	4.499	0.047	0.027	0.022	0.083		Set Trigger
2	4.495	0.045	0.027	0.023	0.078		Set Trigger
3	4.384	0.045	0.026	0.023	0.077		Set Trigger
4	4.440	0.045	0.027	0.024	0.076		Set Trigger
5	4.447	0.046	0.027	0.023	0.082		Set Trigger

A 4.45