

G6794504

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



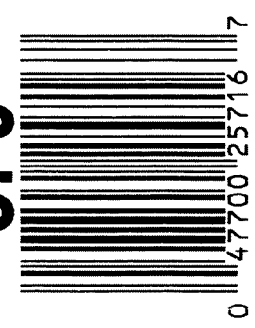
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794504

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794504

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE		10-28-08	ESN
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX NOV 24 2008	10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/28/08	KB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10 30	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-5-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

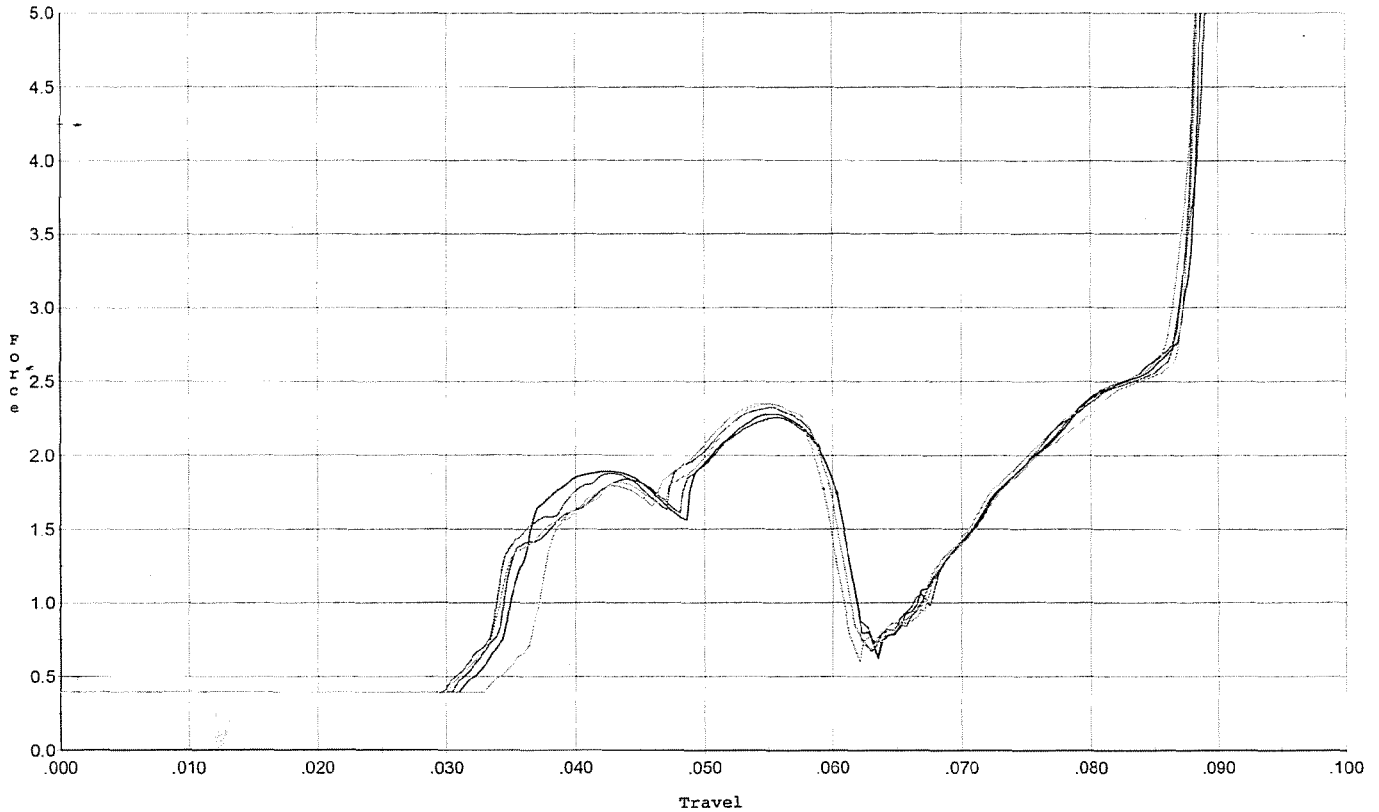
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>30</u> <u>30</u>	11-10-08	R.D.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-10-08	R.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-10-08	R.D.
	J) ASSEMBLE STOCK		11-5-08	R.P.D.
	K) ASSEMBLE SWIVEL STUDS		11-11-08	R.D.
	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	11-6-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-6-08	R.D.
670	FINAL INSPECTION A) HEADSPACE		11-10-08	R.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.25</u> <u>2.32</u> <u>2.35</u> <u>2.25</u>	11-6-08	TC
	C) FUNCTION		11-10-08	R.D.
690	PACK		11/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



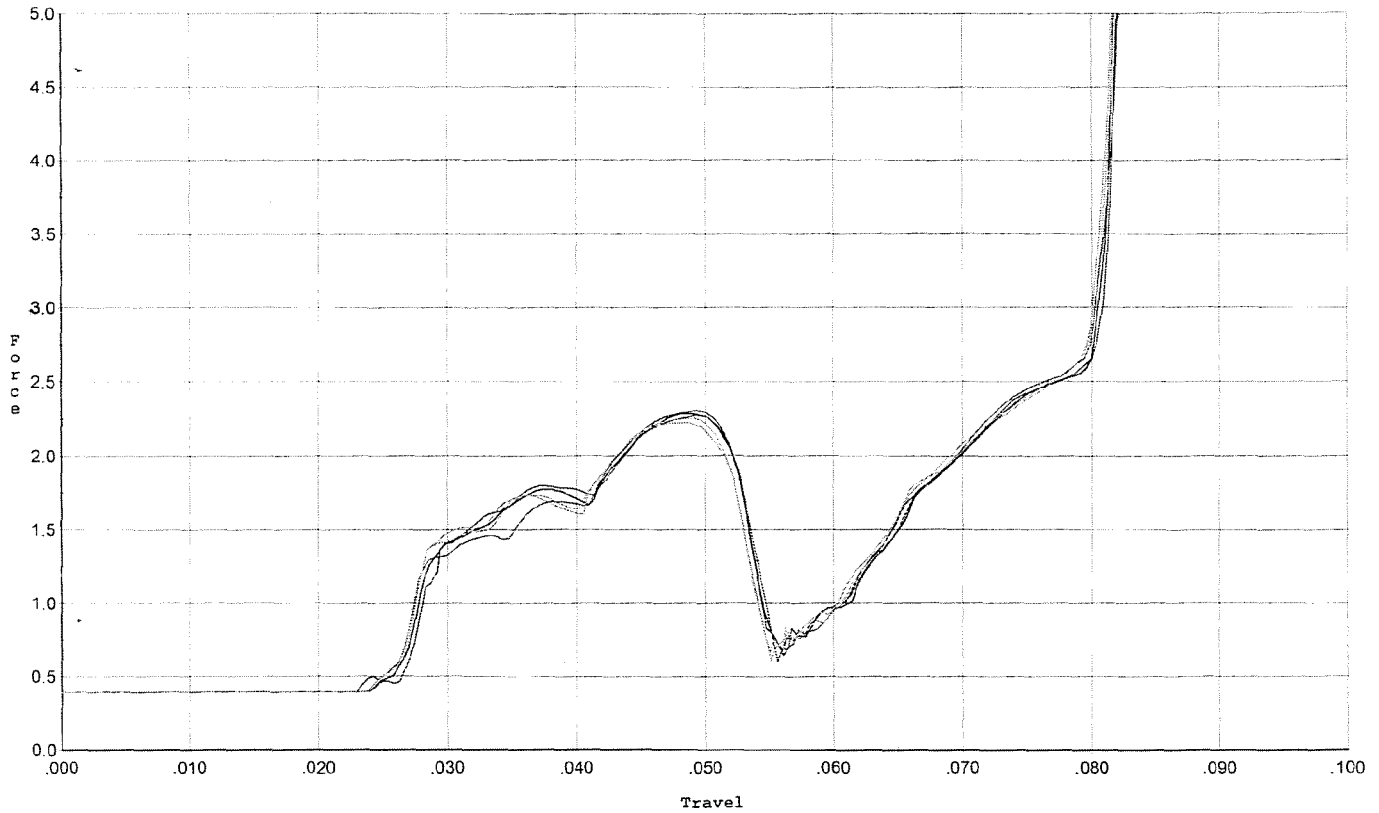
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.257	0.060	0.031	0.034	0.062		Set Trigger
2	2.280	0.060	0.034	0.034	0.063		Set Trigger
3	2.320	0.060	0.030	0.034	0.063		Set Trigger
4	2.342	0.060	0.034	0.034	0.062		Set Trigger
5	2.350	0.059	0.037	0.035	0.059		Set Trigger

A-2-31

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



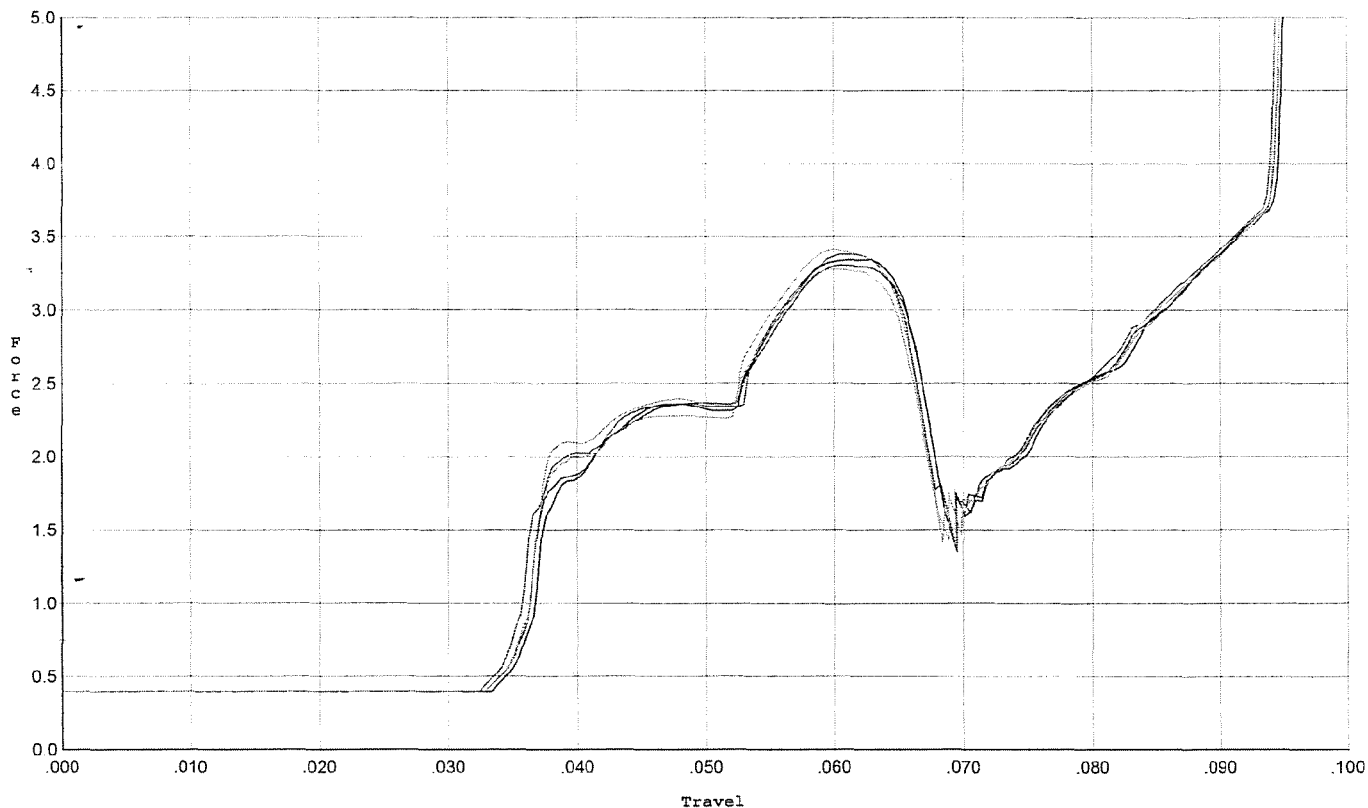
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.304	0.053	0.027	0.034	0.058		Set Trigger
2	2.282	0.053	0.026	0.034	0.057		Set Trigger
3	2.272	0.054	0.024	0.034	0.058		Set Trigger
4	2.255	0.052	0.027	0.034	0.056		Set Trigger
5	2.222	0.052	0.024	0.034	0.056		Set Trigger

A2-26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



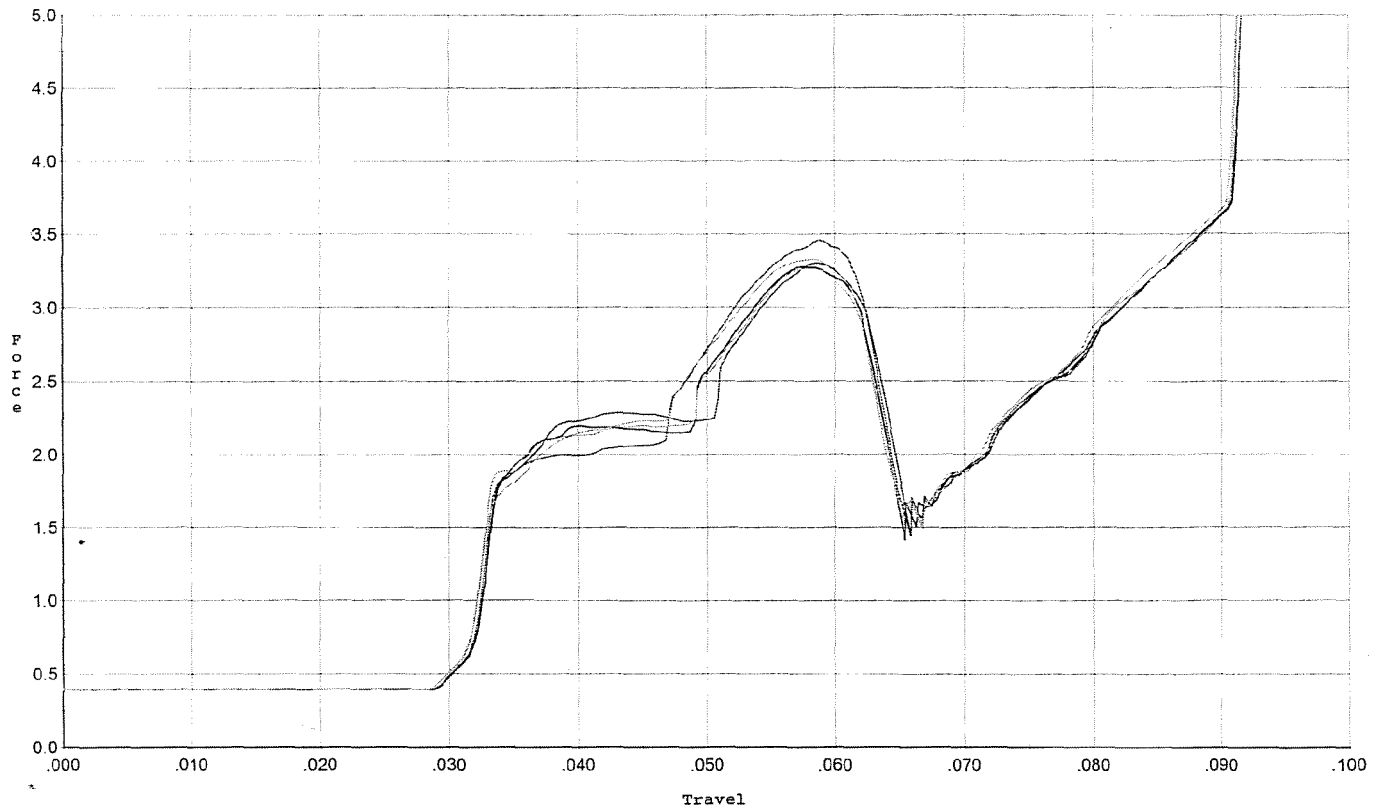
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.304	0.066	0.035	0.033	0.092		Set Trigger
2	3.342	0.066	0.036	0.033	0.092		Set Trigger
3	3.376	0.066	0.035	0.033	0.092		Set Trigger
4	3.278	0.066	0.035	0.034	0.091		Set Trigger
5	3.409	0.066	0.035	0.033	0.093		Set Trigger

A-334

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



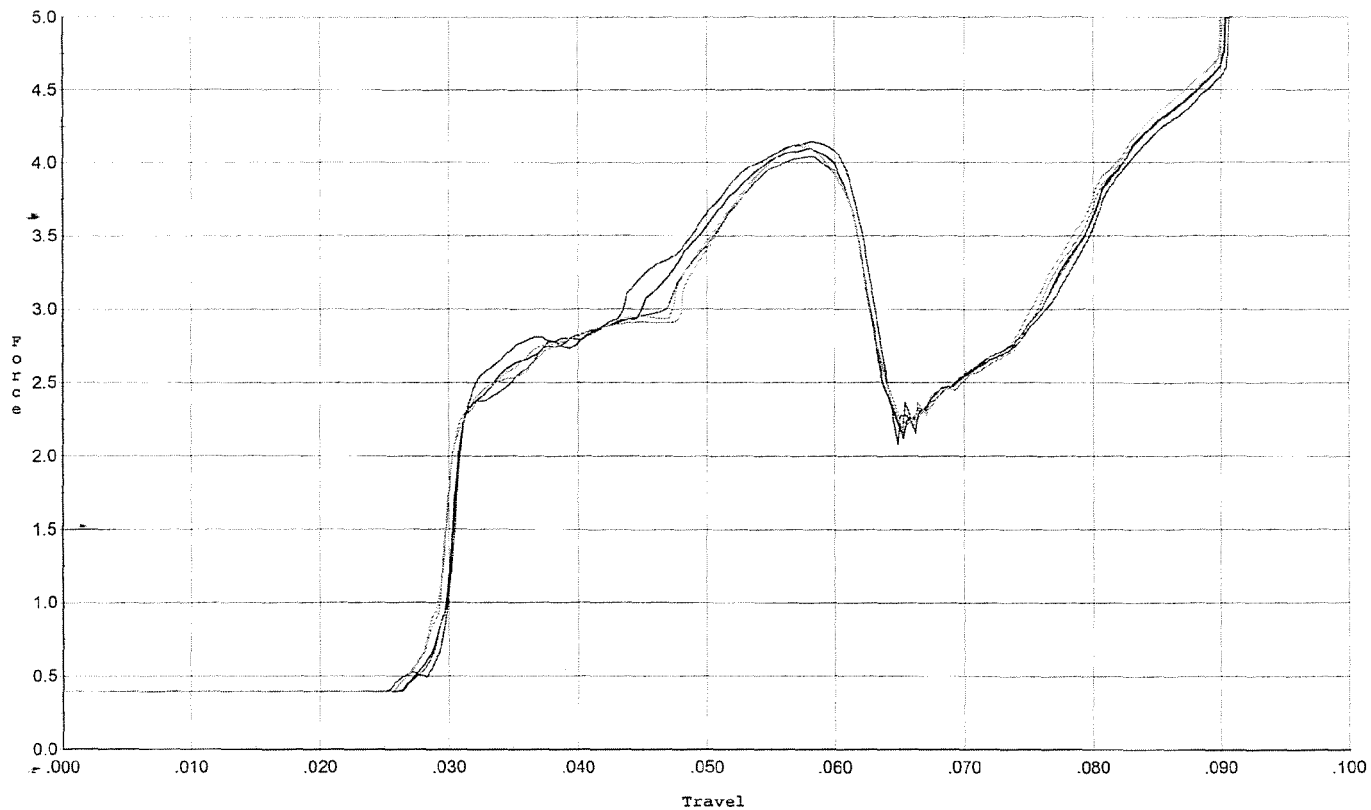
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.300	0.064	0.032	0.033	0.092		Set Trigger
2	3.278	0.063	0.032	0.033	0.090		Set Trigger
3	3.455	0.063	0.032	0.033	0.091		Set Trigger
4	3.326	0.062	0.031	0.033	0.089		Set Trigger
5	3.263	0.062	0.031	0.033	0.088		Set Trigger

A 3-30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



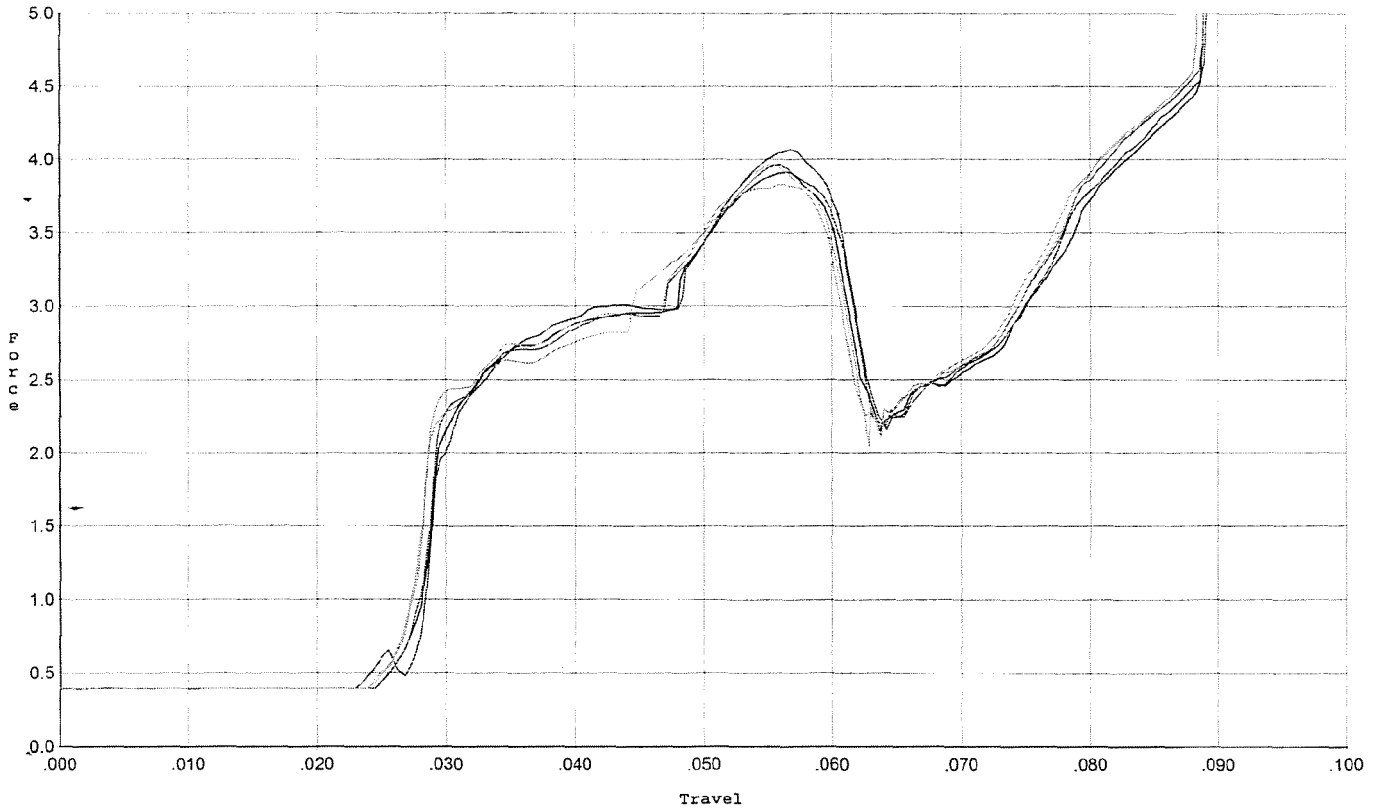
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.142	0.062	0.029	0.030	0.119		Set Trigger
2	4.091	0.061	0.029	0.030	0.114		Set Trigger
3	4.039	0.061	0.029	0.031	0.113		Set Trigger
4	4.115	0.061	0.028	0.030	0.114		Set Trigger
5	4.128	0.061	0.028	0.030	0.114		Set Trigger

A-4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



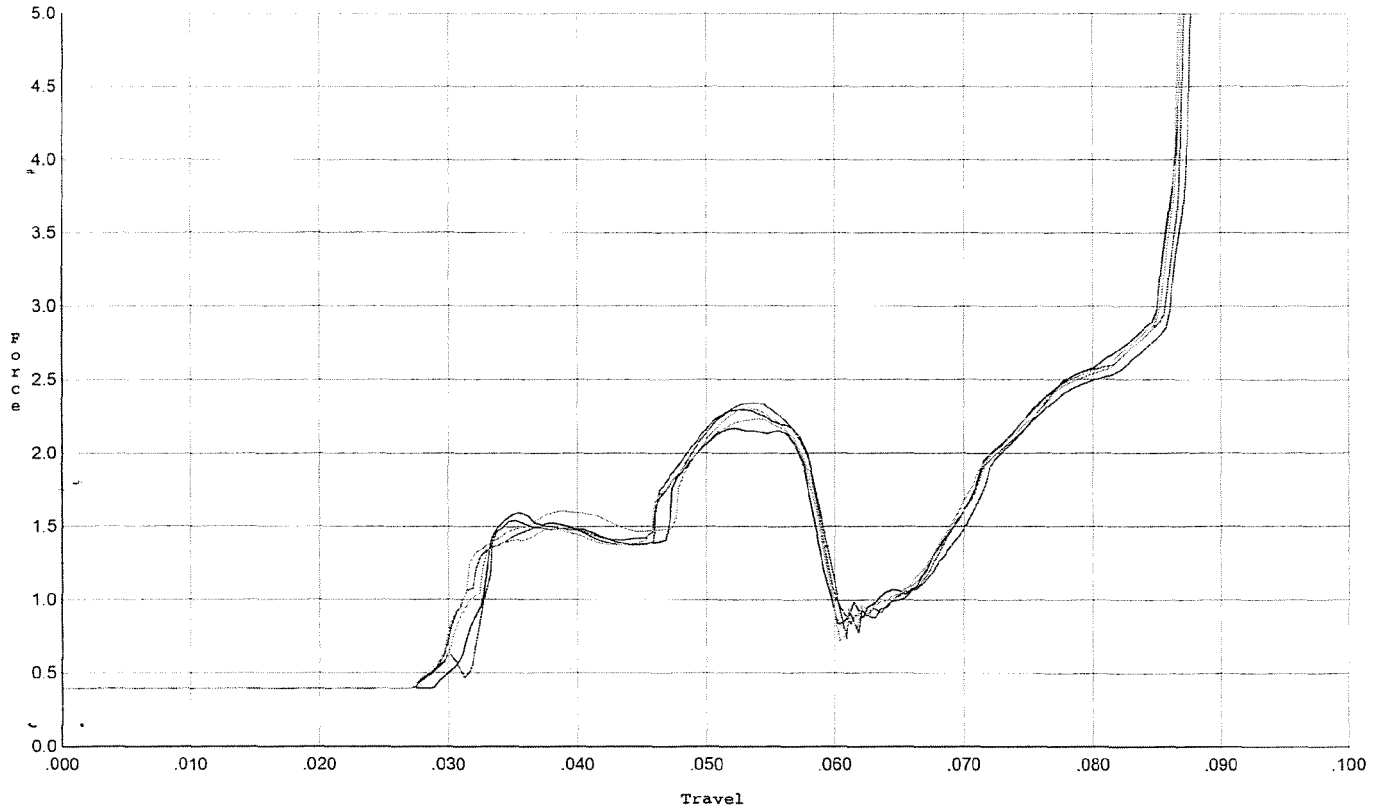
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.069	0.060	0.025	0.030	0.113		Set Trigger
2	3.917	0.060	0.027	0.030	0.110		Set Trigger
3	3.961	0.061	0.027	0.029	0.113		Set Trigger
4	3.963	0.061	0.026	0.029	0.113		Set Trigger
5	3.830	0.060	0.026	0.029	0.110		Set Trigger

A-3.94

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



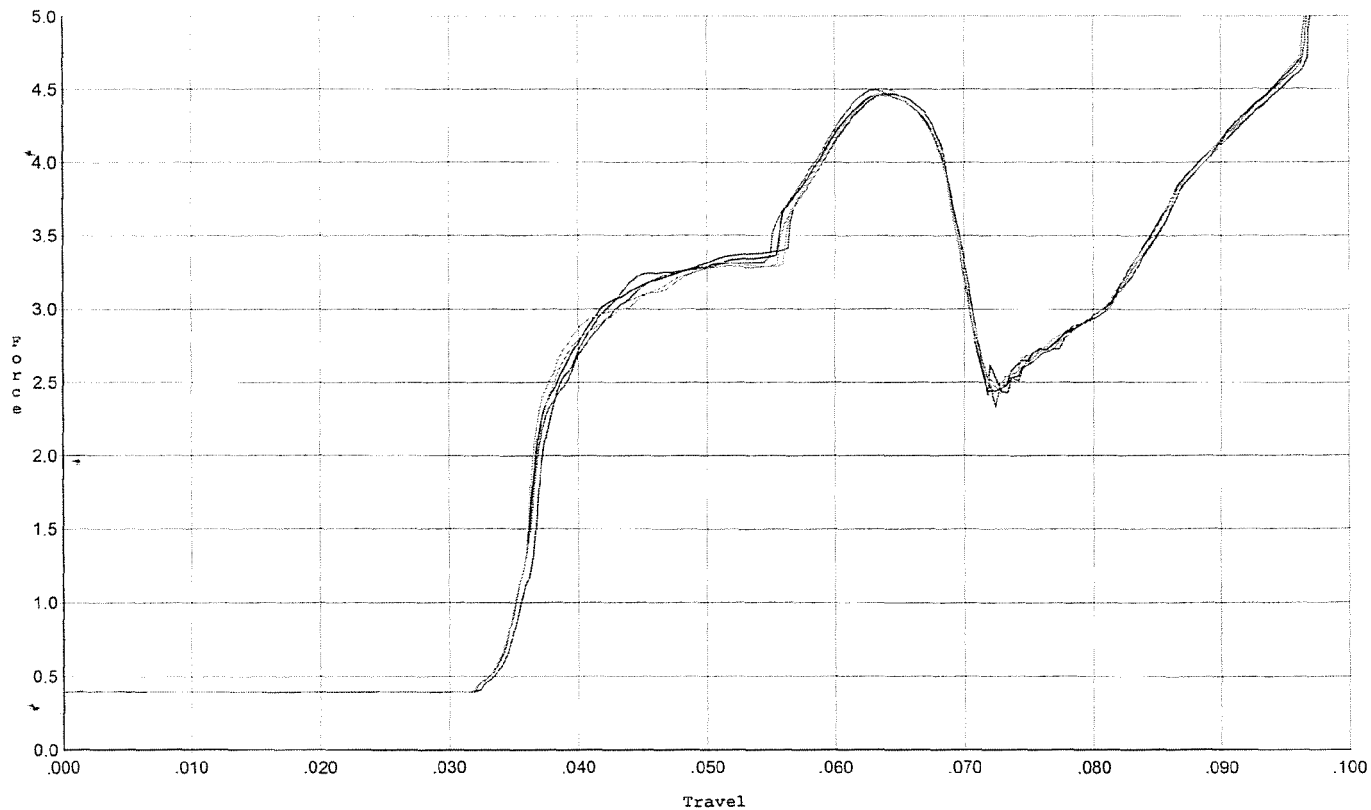
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.296	0.059	0.030	0.034	0.060		Set Trigger
2	2.170	0.058	0.031	0.034	0.057		Set Trigger
3	2.340	0.058	0.030	0.034	0.060		Set Trigger
4	2.233	0.058	0.030	0.033	0.059		Set Trigger
5	2.306	0.058	0.030	0.033	0.061		Set Trigger

A-2-26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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	4.471	0.070	0.034	0.031	0.132		Set Trigger
2	4.459	0.068	0.034	0.031	0.130		Set Trigger
3	4.496	0.068	0.034	0.031	0.130		Set Trigger
4	4.497	0.068	0.034	0.031	0.130		Set Trigger
5	4.464	0.068	0.034	0.031	0.129		Set Trigger

A-4.47