

G6794505

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



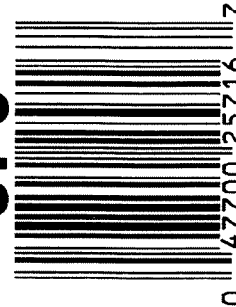
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794505

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794505

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SP
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SP
460	CHECK HEADSPACE		11-3-08	SP
470	DIS-ASSEMBLE ACTION		11-3-08	SP
472	SERIALIZE BOLT HANDLE		11-4-08	RTZ
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION		11/6/08	MR
490	MAGNAFLUX BOLT		11/6/08	RT
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DC
542	APPLY COATINGS (BARREL ACTION)		11/15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-19-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

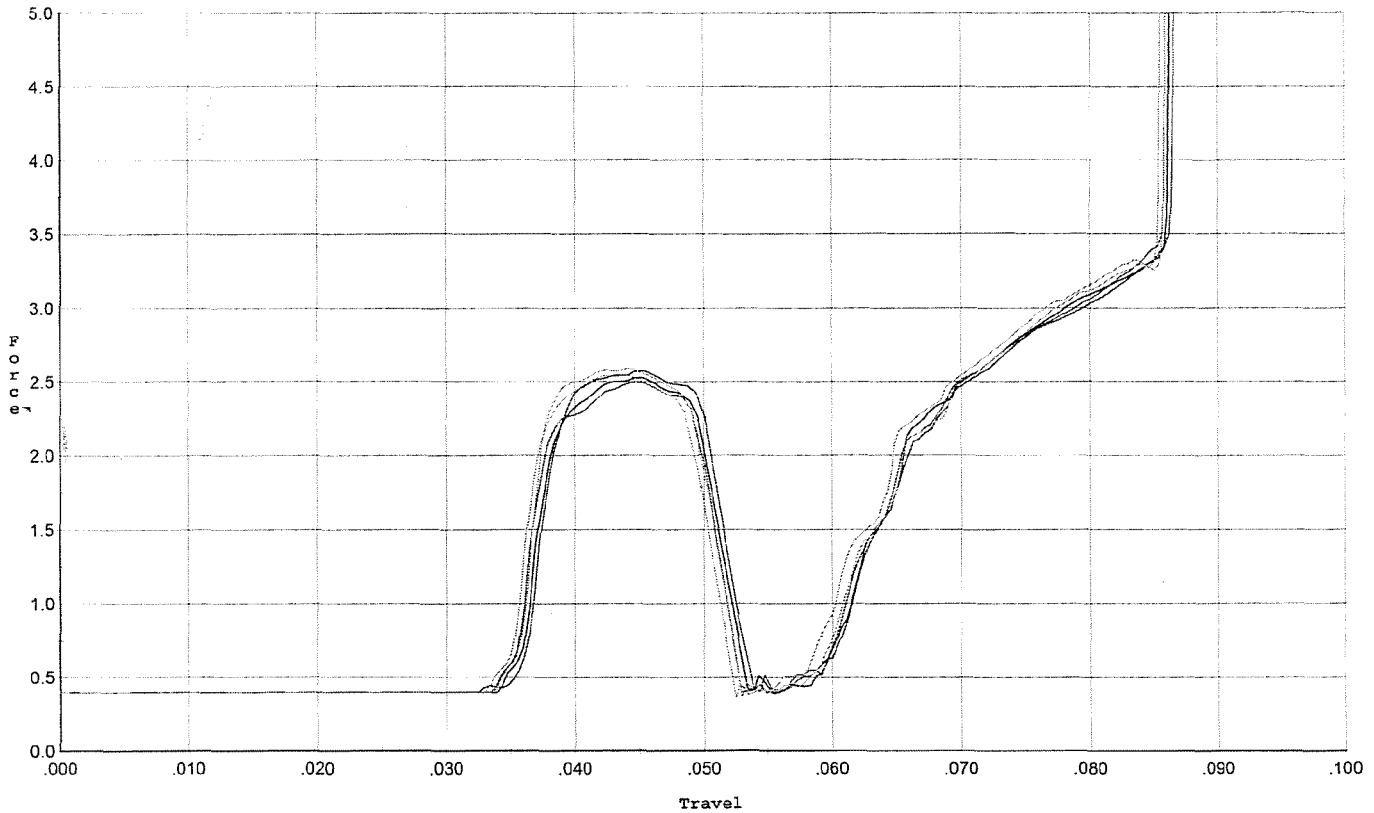
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-20-08	RJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-20-08	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-20-08	RJ
	J) ASSEMBLE STOCK		11-19-08	FTZ
	K) ASSEMBLE SWIVEL STUDS		11-20-08	RJ
	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	11-19-08	RJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-20-08	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.52</u> <u>2.47</u> <u>2.59</u> <u>2.57</u>	11-20-08	TC
	C) FUNCTION		11-20-08	RJ
690	PACK		12-2-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 11/13/08

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



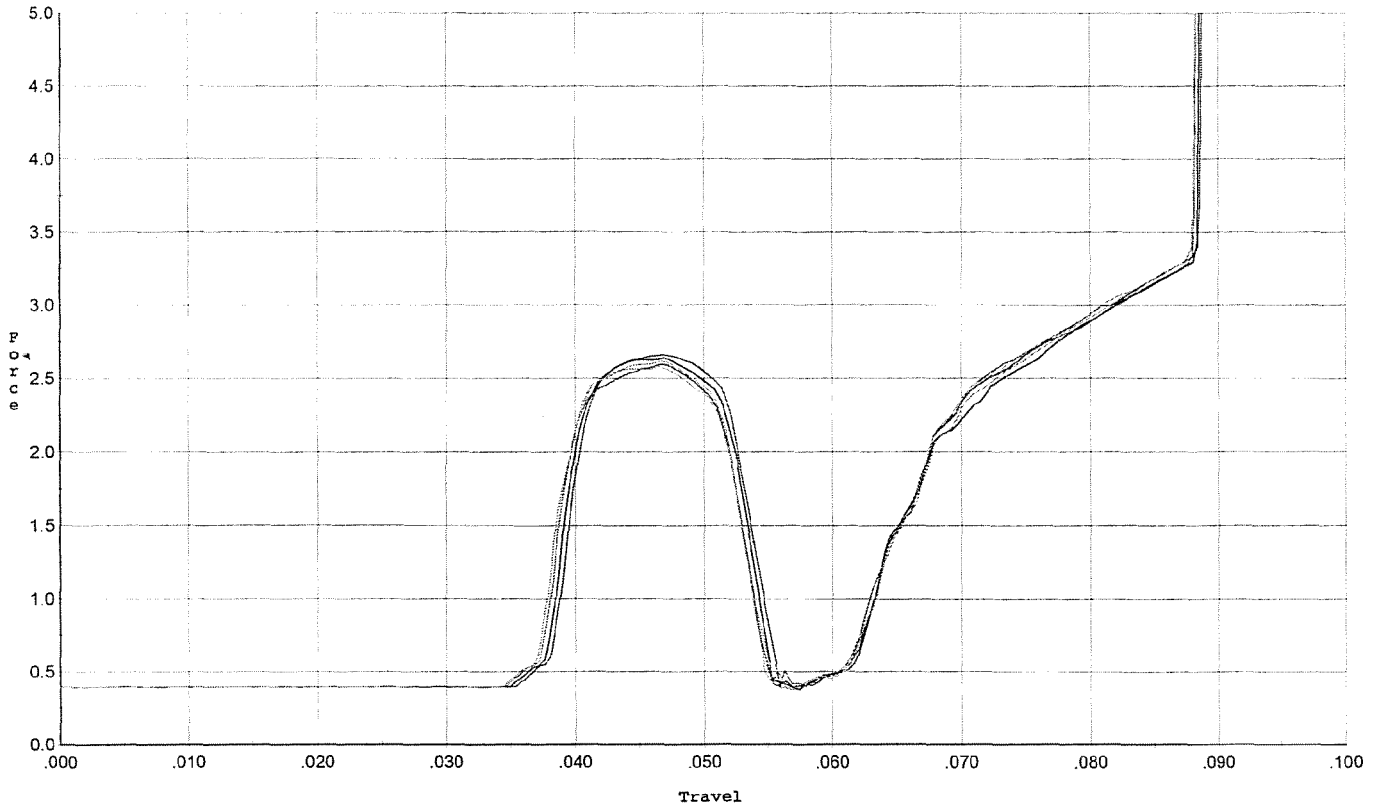
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.578	0.050	0.036	0.039	0.048		Set Trigger
2	2.527	0.050	0.035	0.040	0.046		Set Trigger
3	2.496	0.050	0.034	0.039	0.047		Set Trigger
4	2.588	0.050	0.034	0.039	0.049		Set Trigger
5	2.542	0.050	0.034	0.039	0.047		Set Trigger

Avg 2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

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



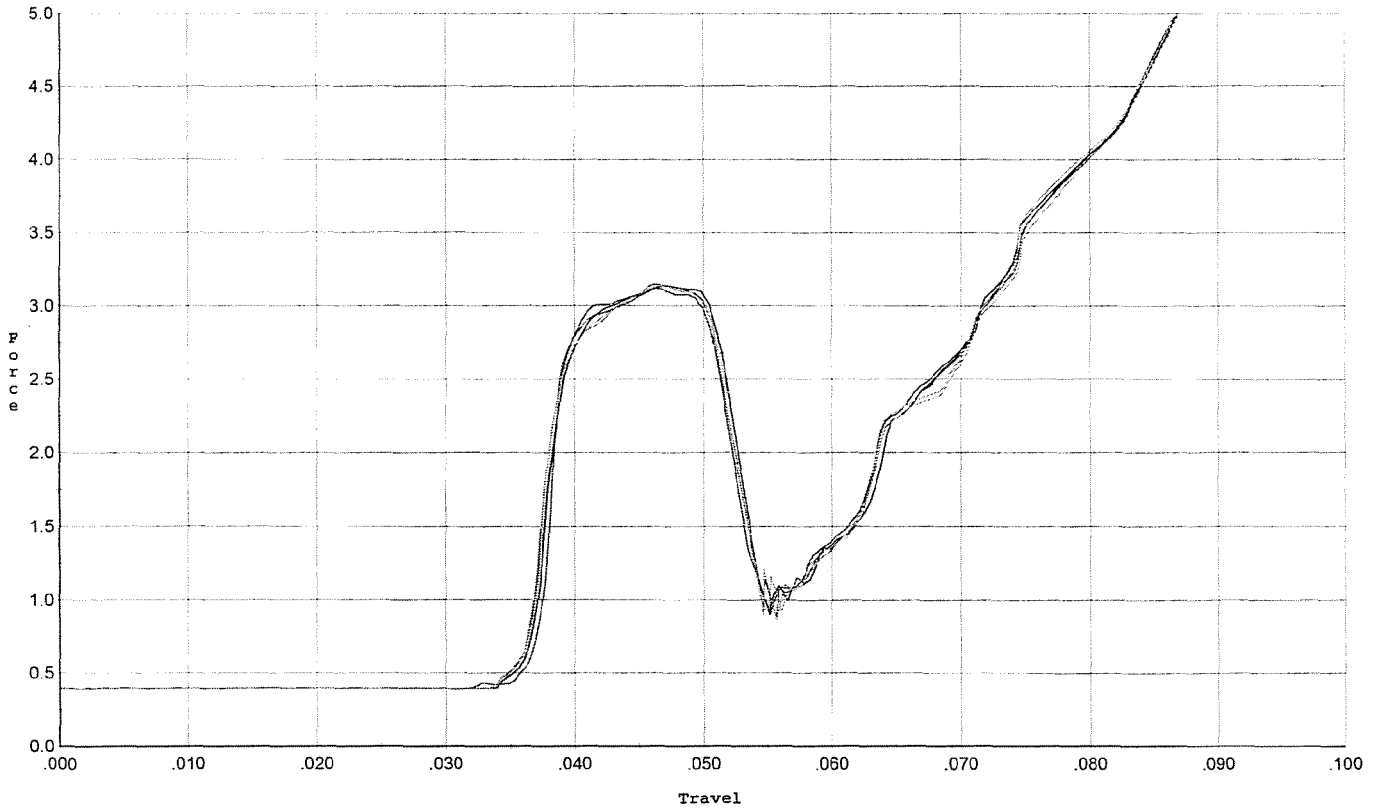
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.658	0.054	0.038	0.040	0.051		Set Trigger
2	2.639	0.053	0.038	0.040	0.050		Set Trigger
3	2.594	0.052	0.037	0.040	0.049		Set Trigger
4	2.616	0.052	0.037	0.040	0.049		Set Trigger
5	2.580	0.052	0.037	0.040	0.049		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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



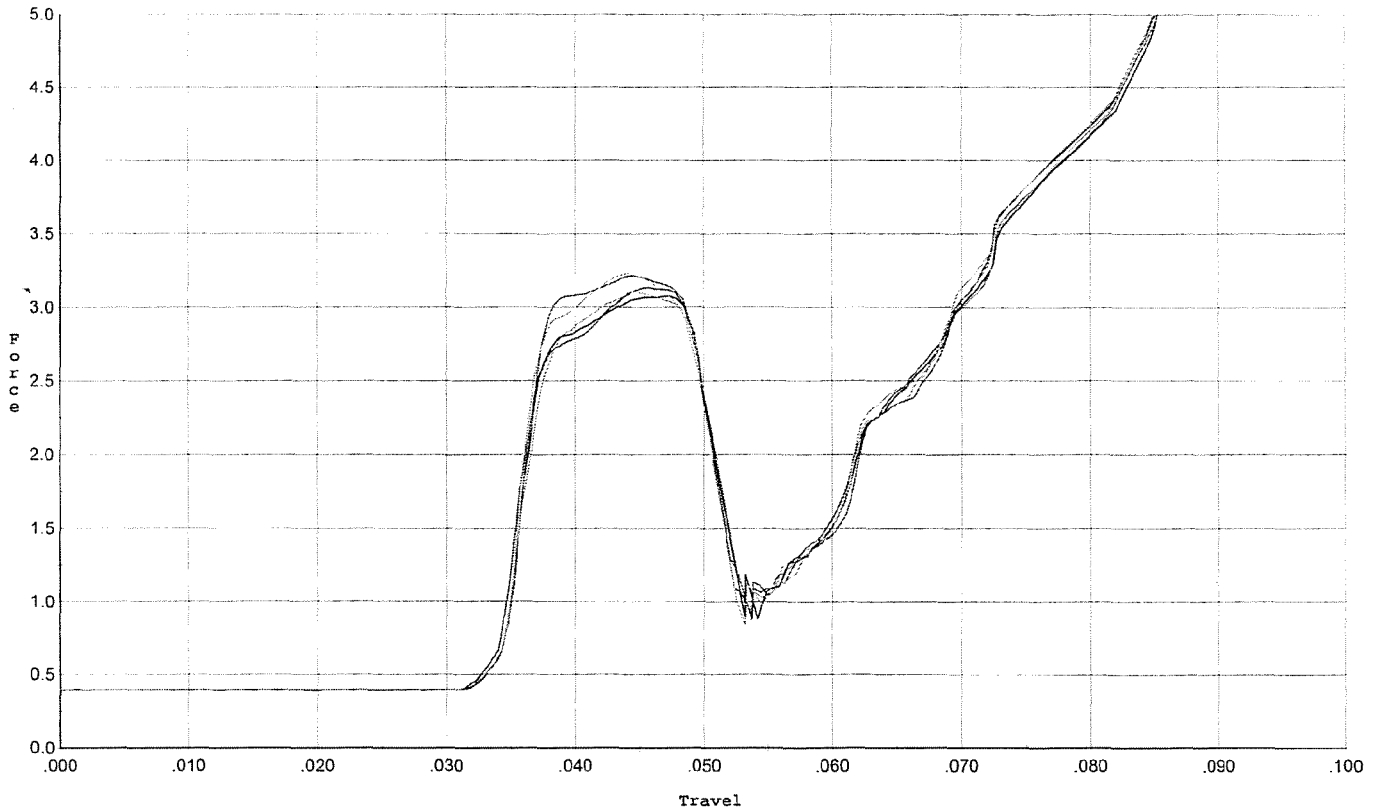
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.051	0.037	0.038	0.055		Set Trigger
2	3.136	0.051	0.036	0.038	0.057		Set Trigger
3	3.147	0.053	0.036	0.038	0.059		Set Trigger
4	3.139	0.052	0.036	0.038	0.058		Set Trigger
5	3.132	0.051	0.036	0.038	0.056		Set Trigger

Avg 3.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 11/13/08

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



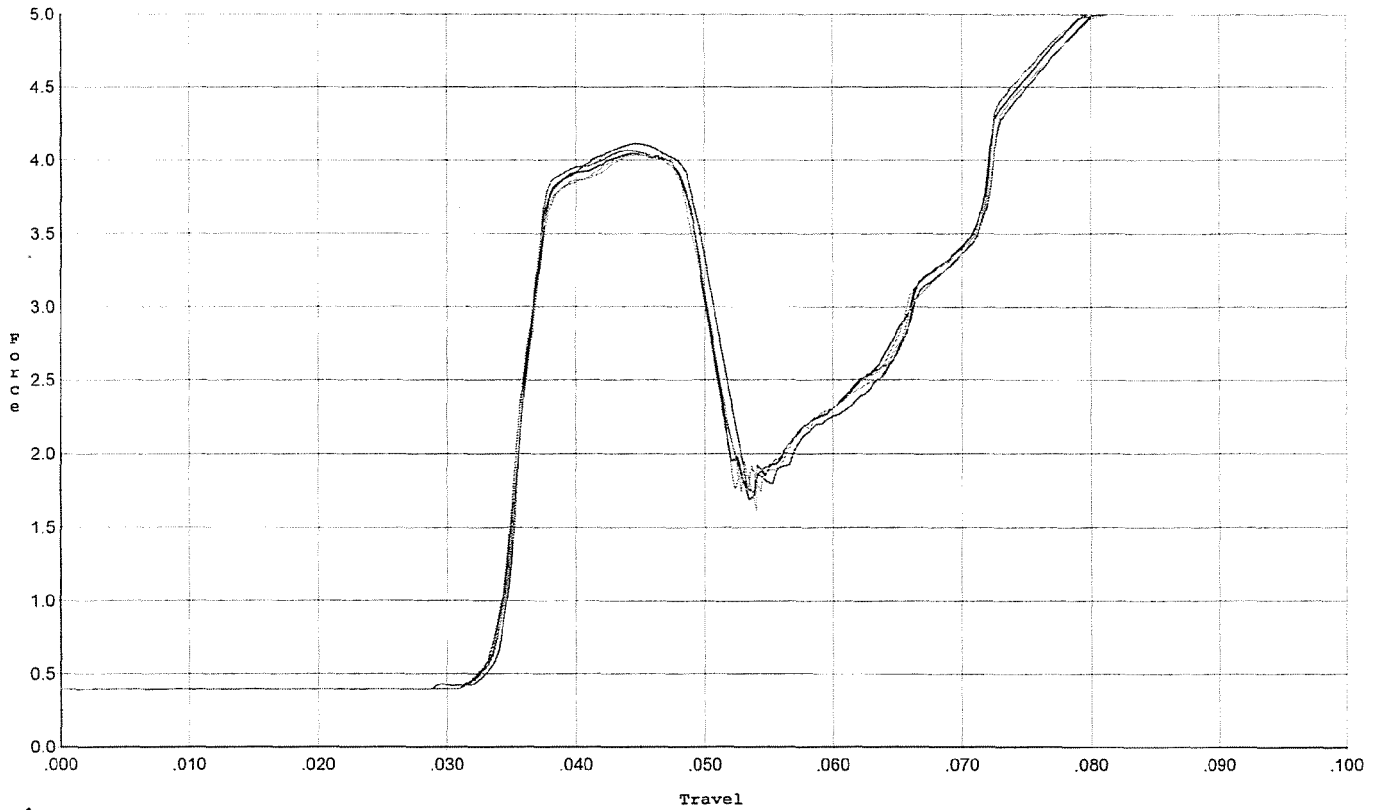
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.049	0.034	0.037	0.056		Set Trigger
2	3.078	0.049	0.034	0.038	0.056		Set Trigger
3	3.215	0.049	0.034	0.037	0.057		Set Trigger
4	3.232	0.050	0.034	0.037	0.058		Set Trigger
5	3.104	0.051	0.034	0.037	0.058		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 11/13/08

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



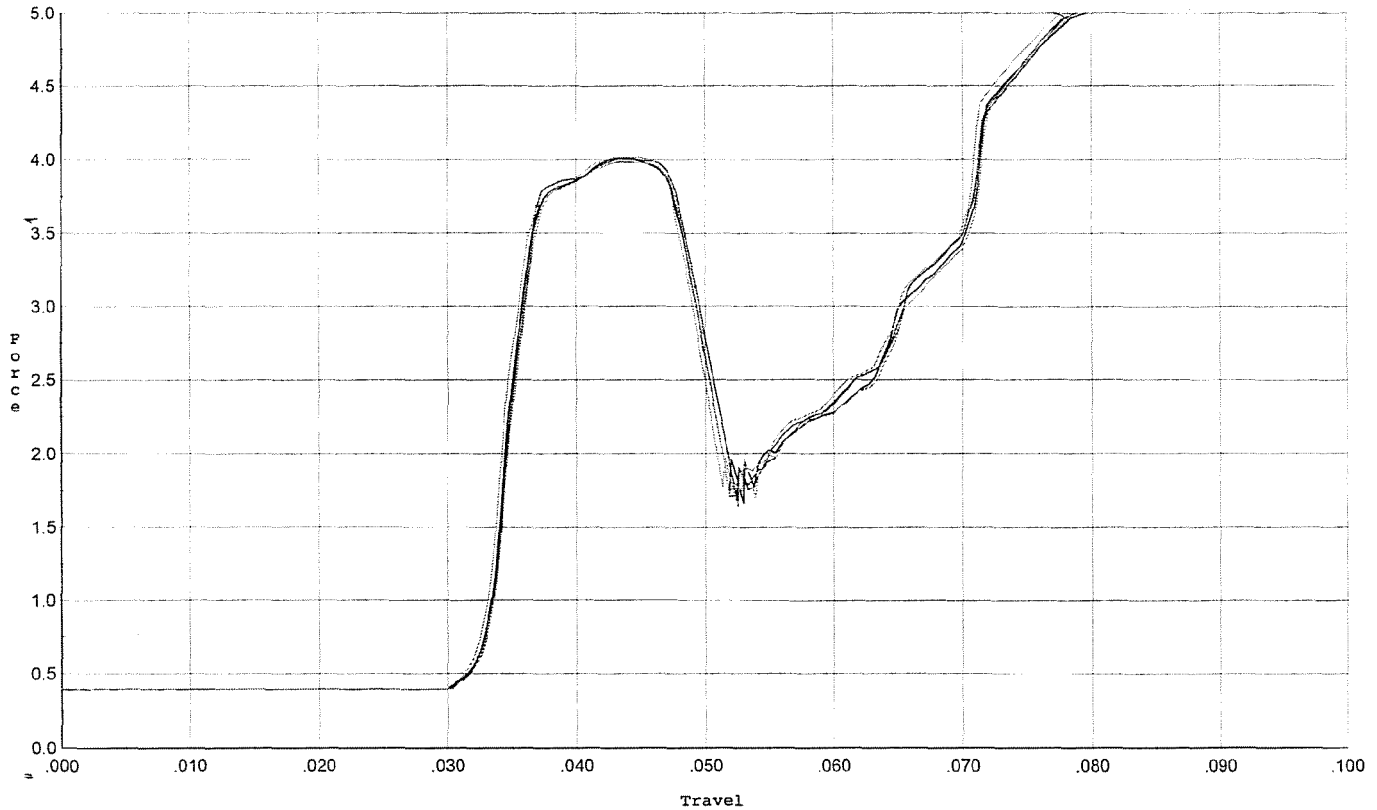
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.112	0.050	0.034	0.036	0.072		Set Trigger
2	4.043	0.049	0.033	0.036	0.070		Set Trigger
3	4.055	0.049	0.034	0.036	0.070		Set Trigger
4	4.036	0.049	0.034	0.036	0.069		Set Trigger
5	4.028	0.049	0.033	0.036	0.071		Set Trigger

Aug 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

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



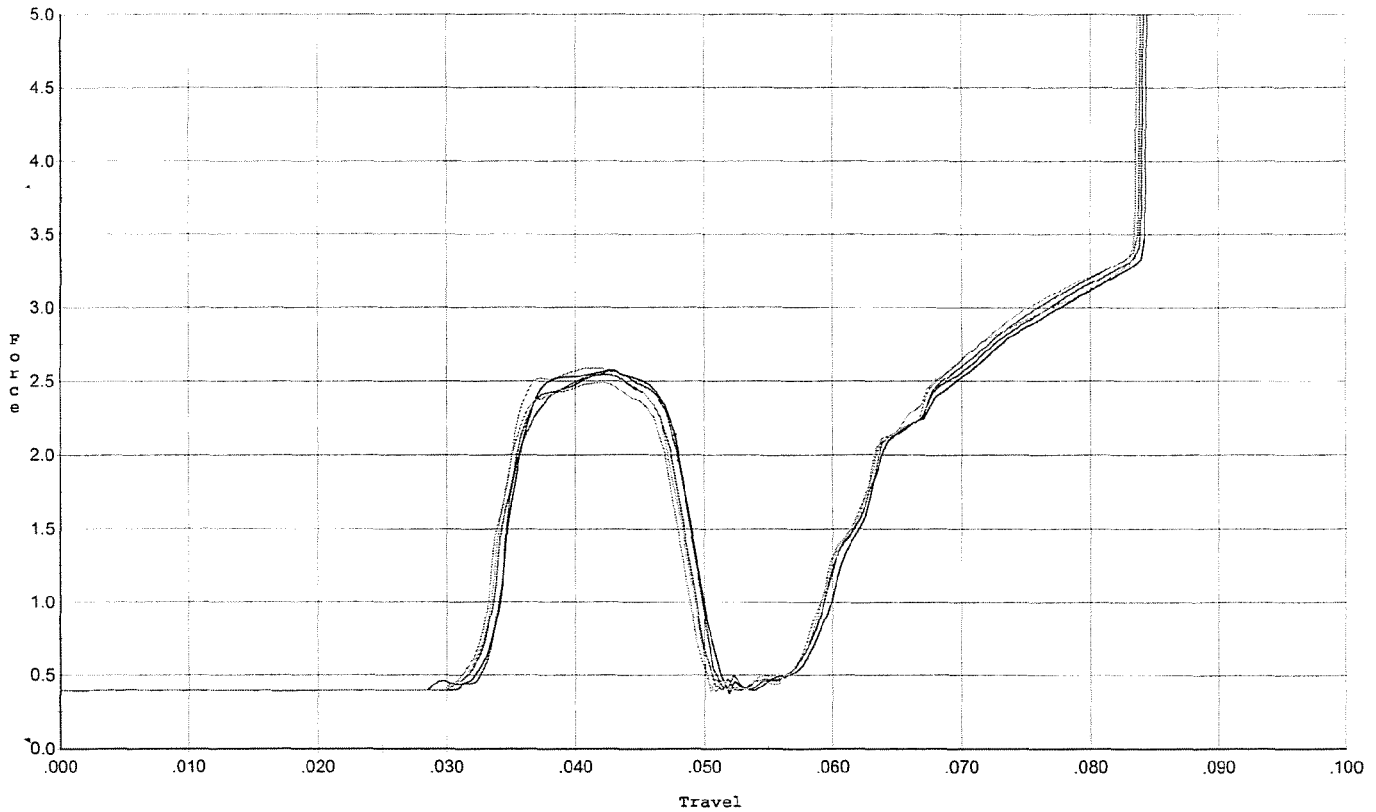
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.009	0.049	0.033	0.035	0.071		Set Trigger
2	4.012	0.050	0.032	0.035	0.072		Set Trigger
3	3.988	0.050	0.032	0.035	0.072		Set Trigger
4	3.982	0.050	0.032	0.036	0.071		Set Trigger
5	4.015	0.049	0.032	0.035	0.070		Set Trigger

Aug 4.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

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



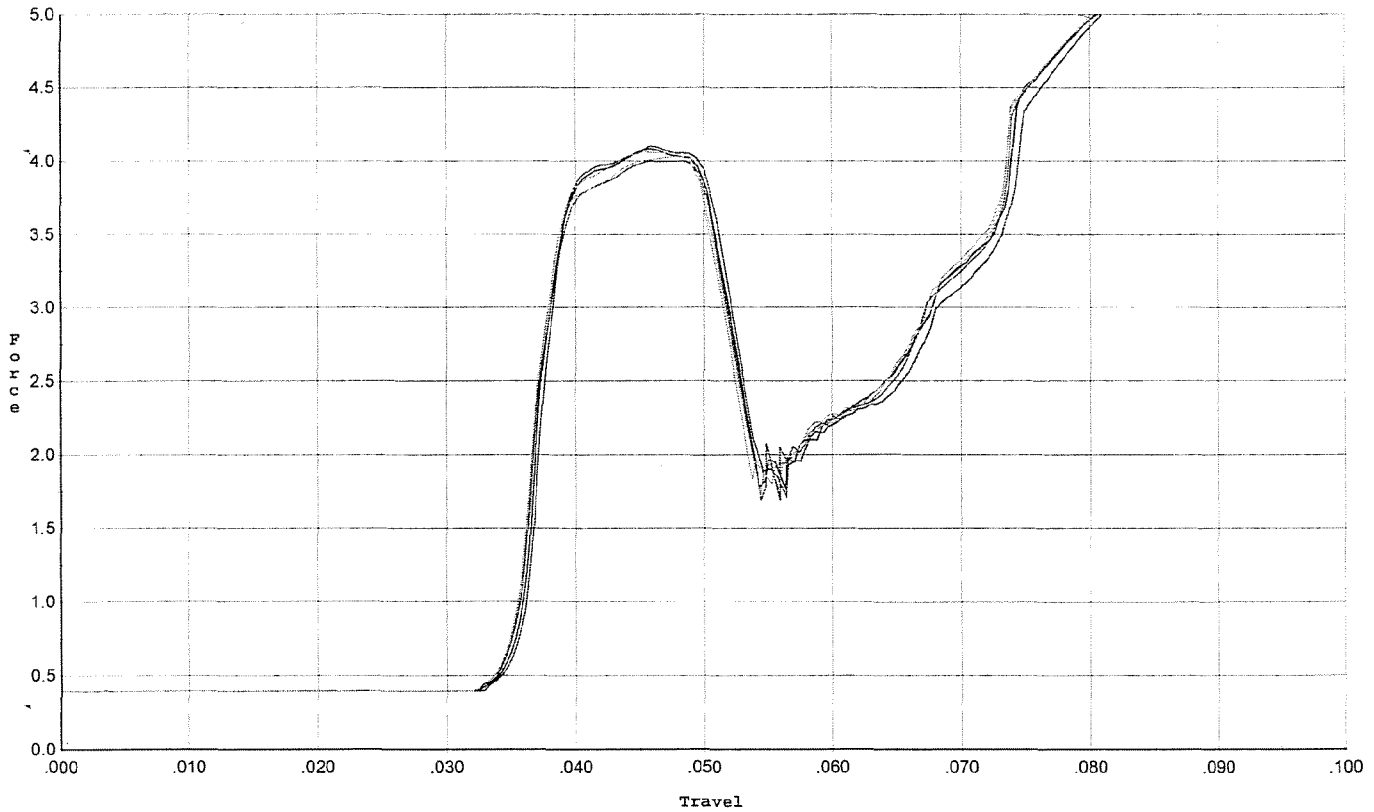
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.048	0.033	0.039	0.047		Set Trigger
2	2.574	0.048	0.033	0.039	0.047		Set Trigger
3	2.545	0.047	0.032	0.039	0.046		Set Trigger
4	2.587	0.048	0.032	0.039	0.048		Set Trigger
5	2.492	0.047	0.032	0.039	0.046		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

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	4.101	0.051	0.035	0.037	0.072		Set Trigger
2	4.084	0.052	0.035	0.037	0.074		Set Trigger
3	4.001	0.050	0.034	0.037	0.070		Set Trigger
4	4.030	0.051	0.034	0.037	0.072		Set Trigger
5	4.062	0.051	0.034	0.037	0.072		Set Trigger

Aug 4.05