

G6794507

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



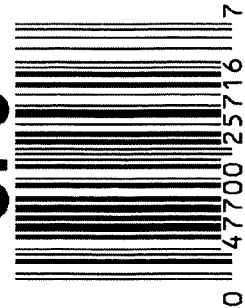
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794507

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6794507

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE		10-28-08	REN
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX OUT 2000	10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/29/08	SP
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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

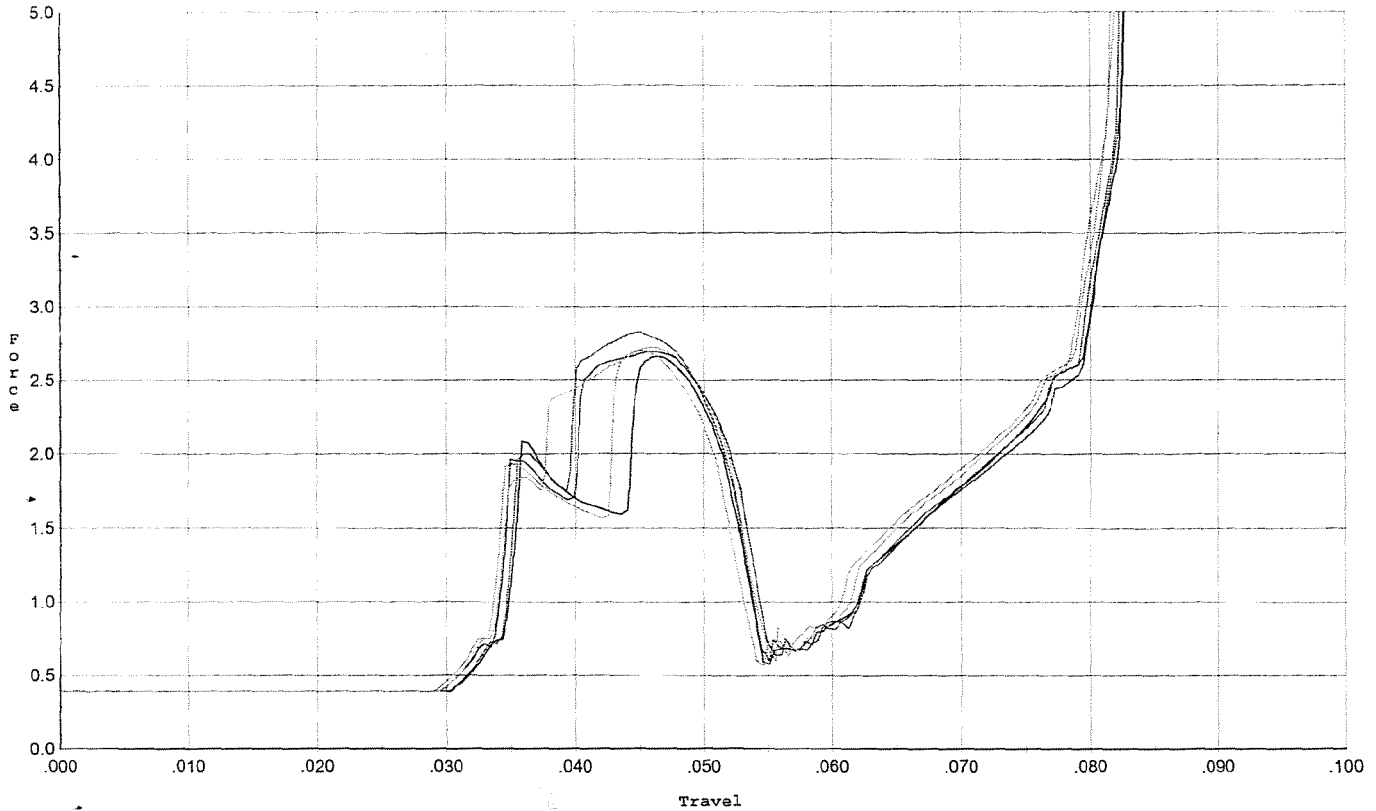
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	11-12-08	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-12-08	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-12-08	L N
	J) ASSEMBLE STOCK		11-5-08	LA
	K) ASSEMBLE SWIVEL STUDS		11-12-08	L N
	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		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-6-08	L N
670	FINAL INSPECTION A) HEADSPACE		11-12-08	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.59</u> <u>2.54</u> <u>2.55</u> <u>2.58</u>	11-6-08	TC
	C) FUNCTION		11-12-08	L N
690	PACK		11/13/08	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



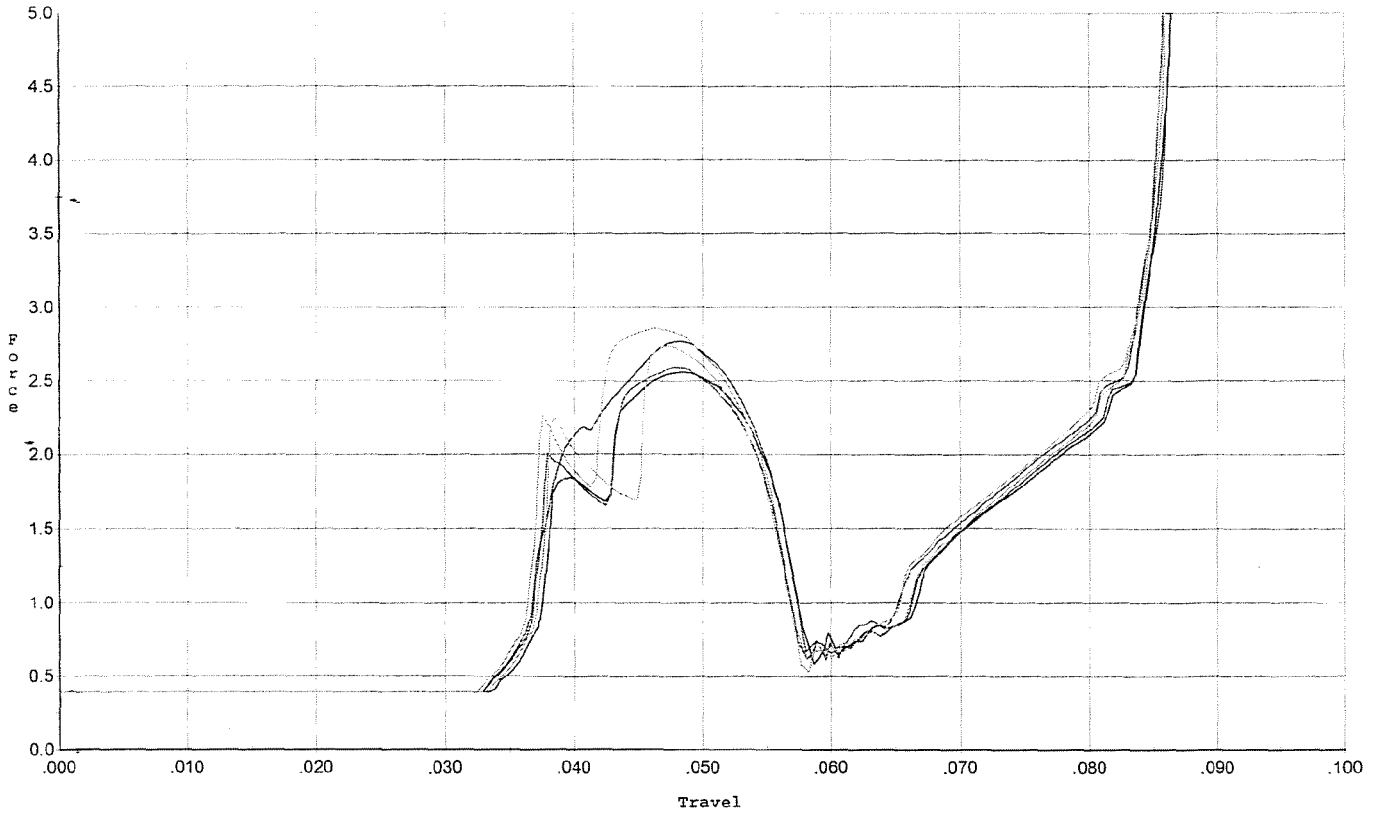
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.696	0.053	0.032	0.035	0.057		Set Trigger
2	2.662	0.053	0.033	0.035	0.051		Set Trigger
3	2.823	0.052	0.033	0.035	0.056		Set Trigger
4	2.727	0.052	0.032	0.034	0.057		Set Trigger
5	2.699	0.051	0.032	0.035	0.051		Set Trigger

A-2-72

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



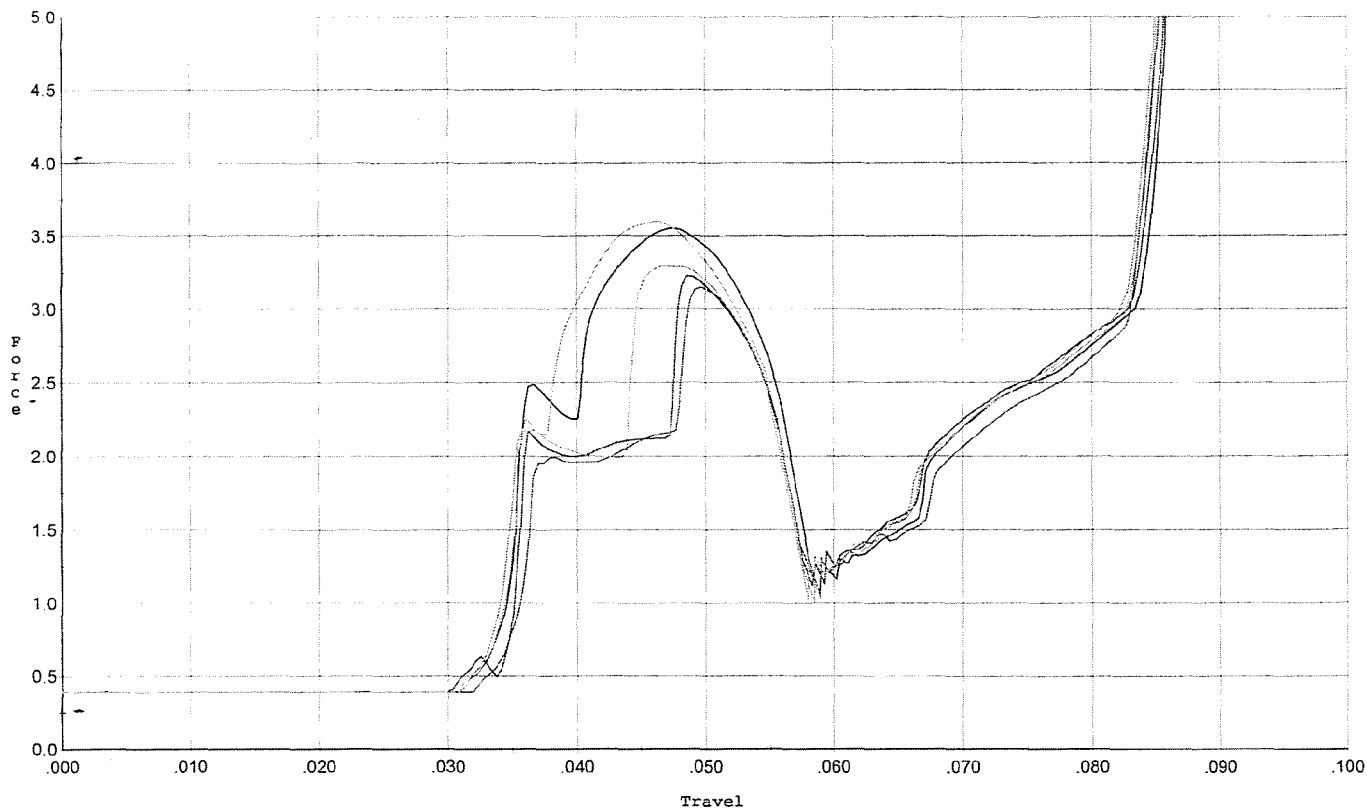
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.768	0.056	0.035	0.036	0.060		Set Trigger
2	2.558	0.056	0.034	0.036	0.055		Set Trigger
3	2.592	0.056	0.035	0.036	0.056		Set Trigger
4	2.737	0.056	0.034	0.036	0.055		Set Trigger
5	2.855	0.055	0.035	0.036	0.060		Set Trigger

A-2.70

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



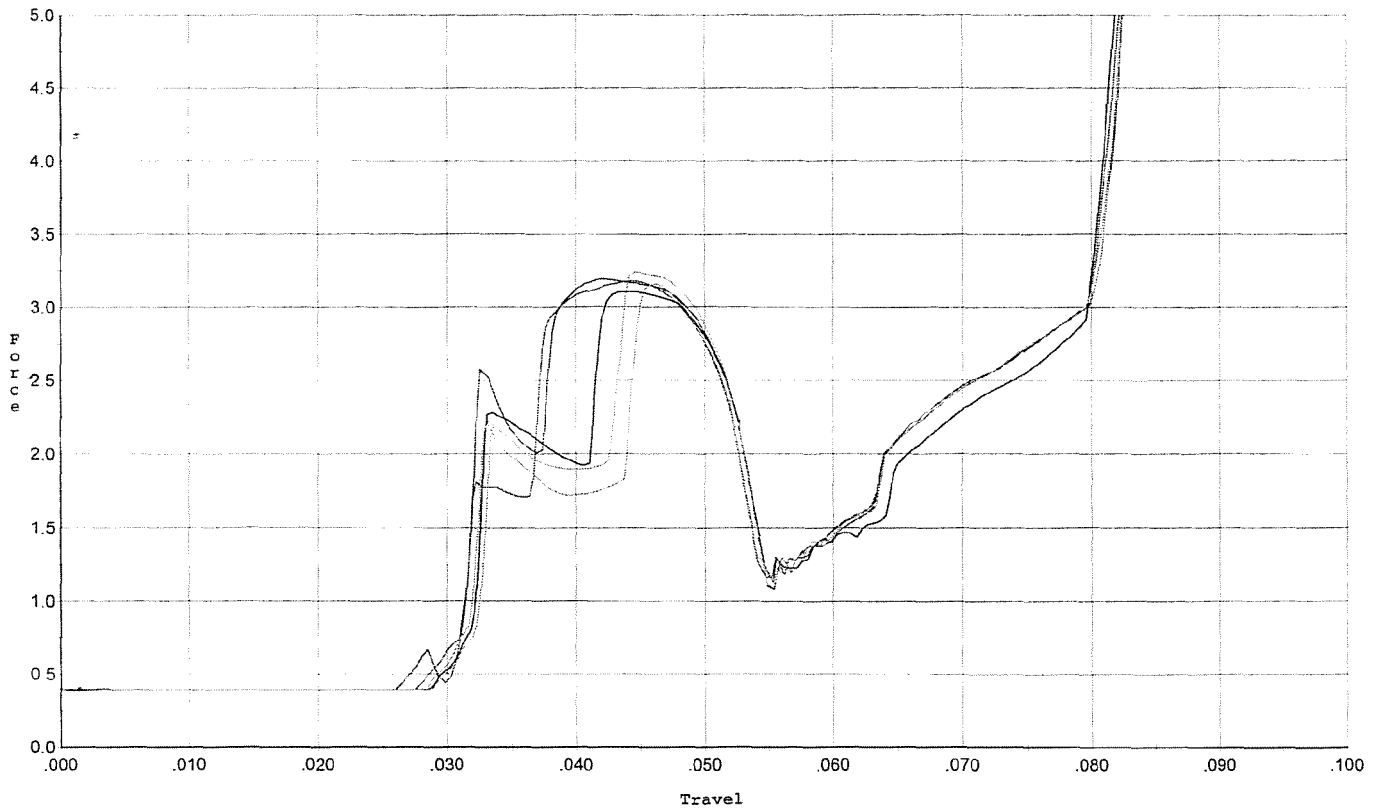
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.231	0.056	0.031	0.035	0.064		Set Trigger
2	3.552	0.056	0.033	0.035	0.077		Set Trigger
3	3.146	0.056	0.034	0.035	0.062		Set Trigger
4	3.293	0.056	0.033	0.034	0.069		Set Trigger
5	3.597	0.056	0.031	0.034	0.078		Set Trigger

A 3-36

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



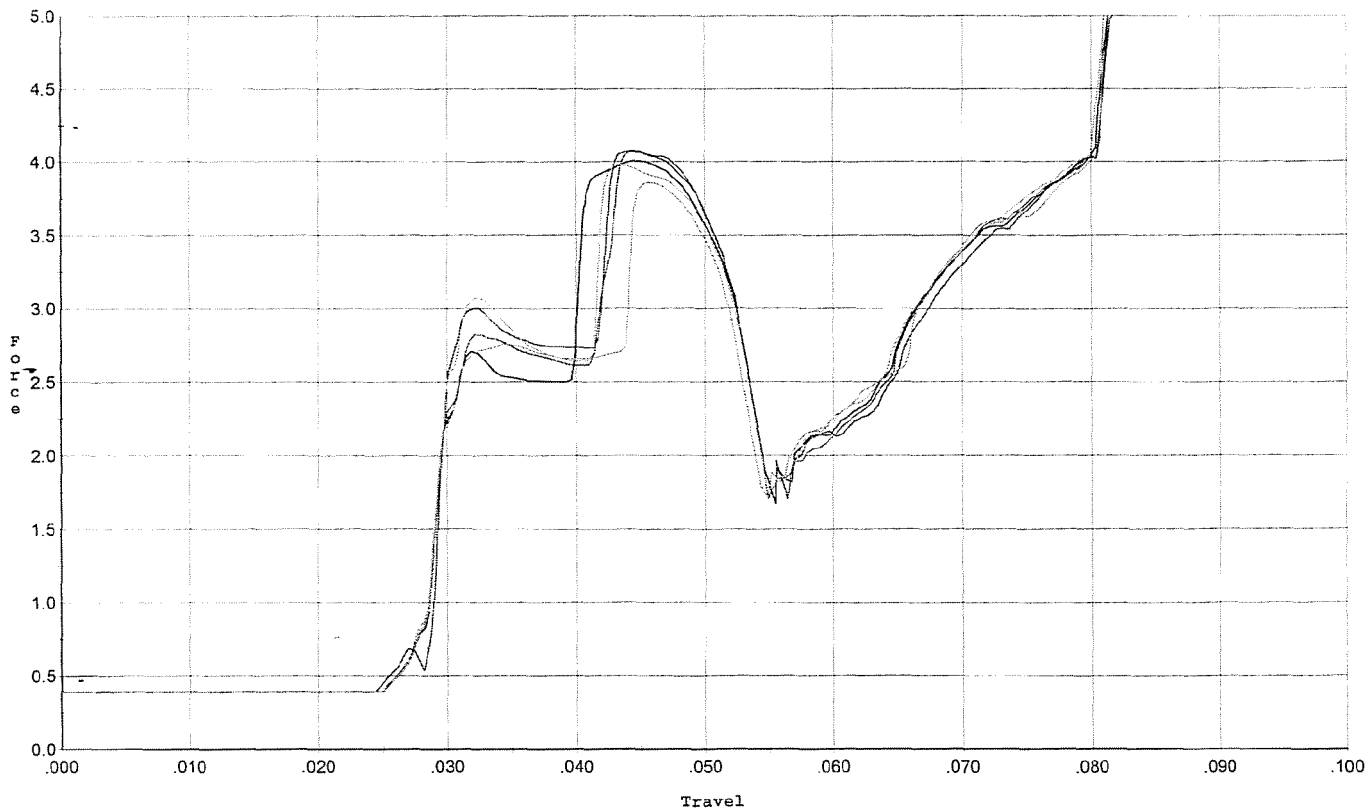
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.196	0.053	0.028	0.032	0.071		Set Trigger
2	3.107	0.053	0.029	0.033	0.065		Set Trigger
3	3.179	0.052	0.030	0.034	0.068		Set Trigger
4	3.242	0.053	0.029	0.033	0.063		Set Trigger
5	3.161	0.052	0.029	0.033	0.059		Set Trigger

A-3-17

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 lbs



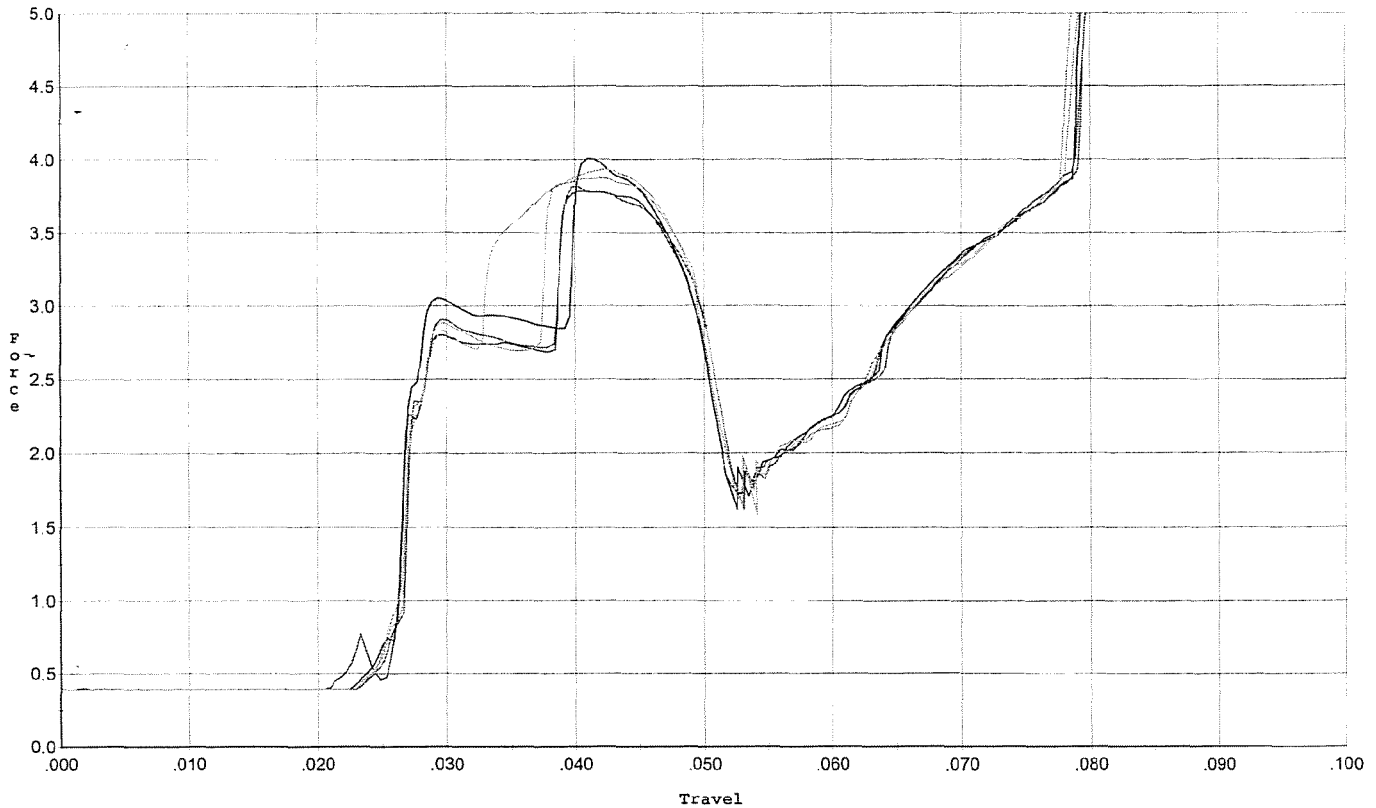
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.066	0.052	0.027	0.030	0.087		Set Trigger
2	4.007	0.052	0.027	0.030	0.087		Set Trigger
3	4.075	0.052	0.026	0.030	0.086		Set Trigger
4	3.978	0.053	0.027	0.030	0.088		Set Trigger
5	3.861	0.052	0.027	0.031	0.081		Set Trigger

A-399

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 lbs



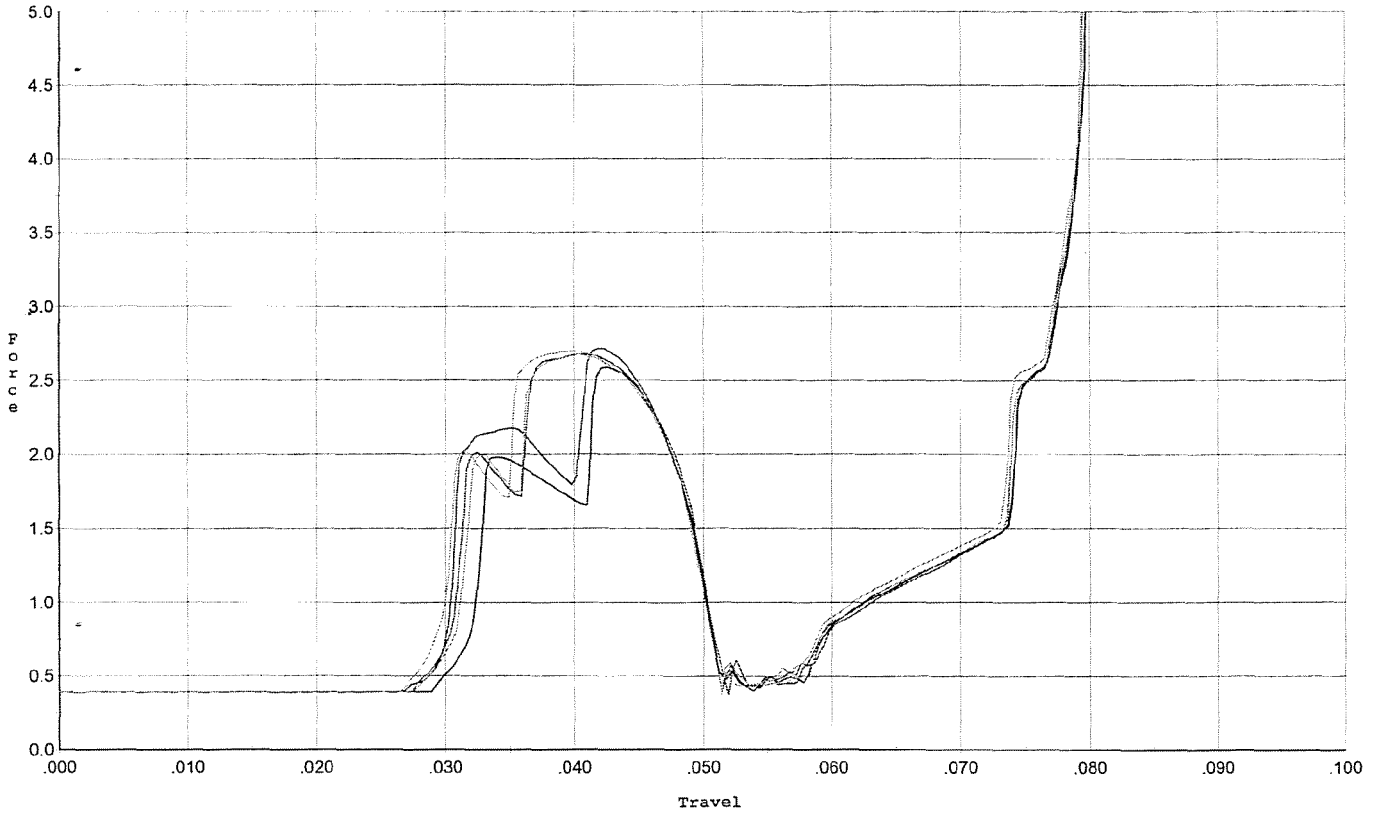
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.781	0.050	0.023	0.031	0.083		Set Trigger
2	4.007	0.050	0.025	0.030	0.085		Set Trigger
3	3.815	0.050	0.025	0.031	0.084		Set Trigger
4	3.934	0.050	0.025	0.030	0.090		Set Trigger
5	3.874	0.049	0.025	0.030	0.084		Set Trigger

A-3.88

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



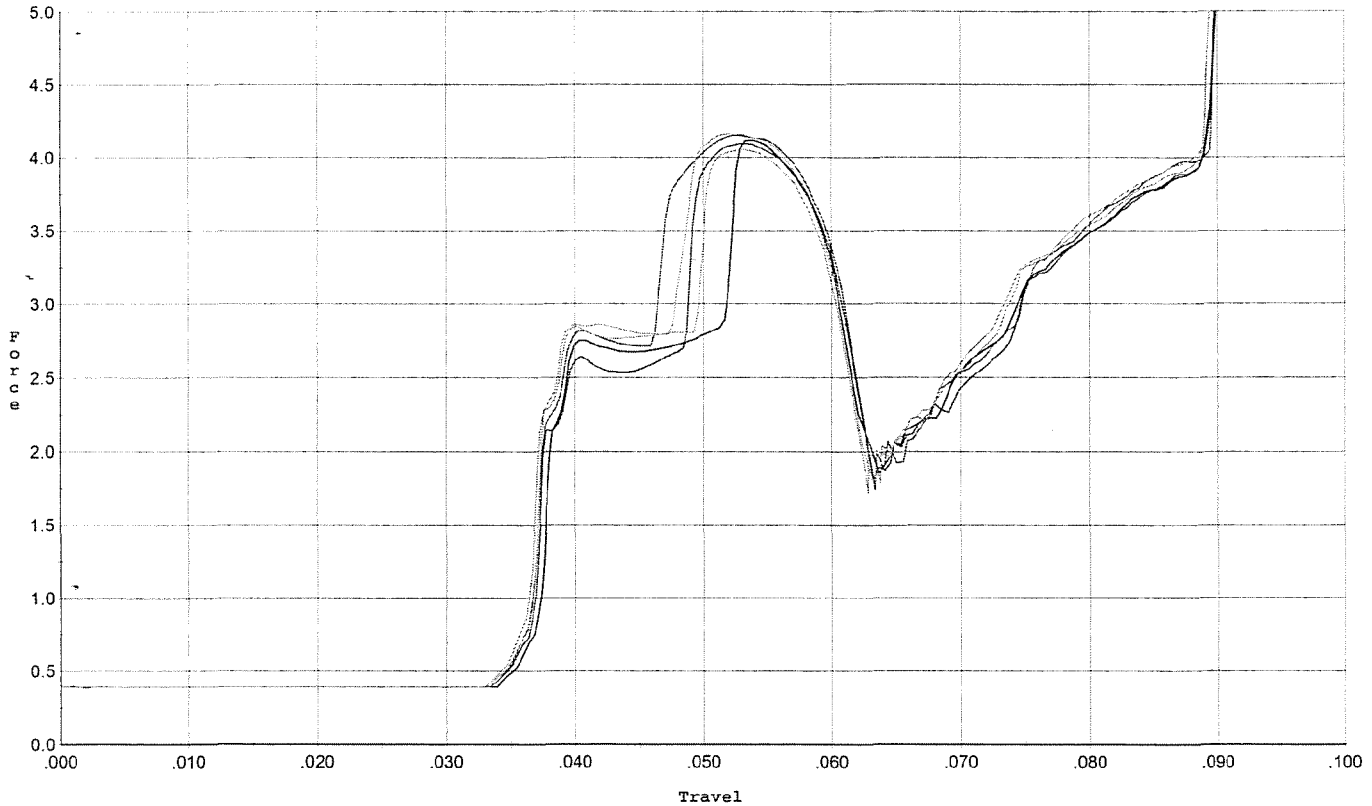
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.716	0.049	0.030	0.035	0.053		Set Trigger
2	2.587	0.049	0.031	0.035	0.047		Set Trigger
3	2.676	0.049	0.028	0.035	0.054		Set Trigger
4	2.696	0.050	0.029	0.035	0.056		Set Trigger
5	2.674	0.050	0.030	0.035	0.053		Set Trigger

A-267

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	4.096	0.061	0.036	0.033	0.092		Set Trigger
2	4.120	0.060	0.036	0.034	0.087		Set Trigger
3	4.151	0.061	0.035	0.033	0.097		Set Trigger
4	4.162	0.060	0.036	0.033	0.094		Set Trigger
5	4.057	0.061	0.035	0.033	0.092		Set Trigger

A 4.11