

G6794535

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



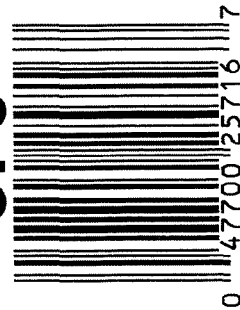
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794535

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794535

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	MAGNA FLUX 2/10/08 OPERATOR 	11/6/08	
490	MAGNAFLUX BOLT		11/3/08	SP
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/6/08	DG
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		11-18-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

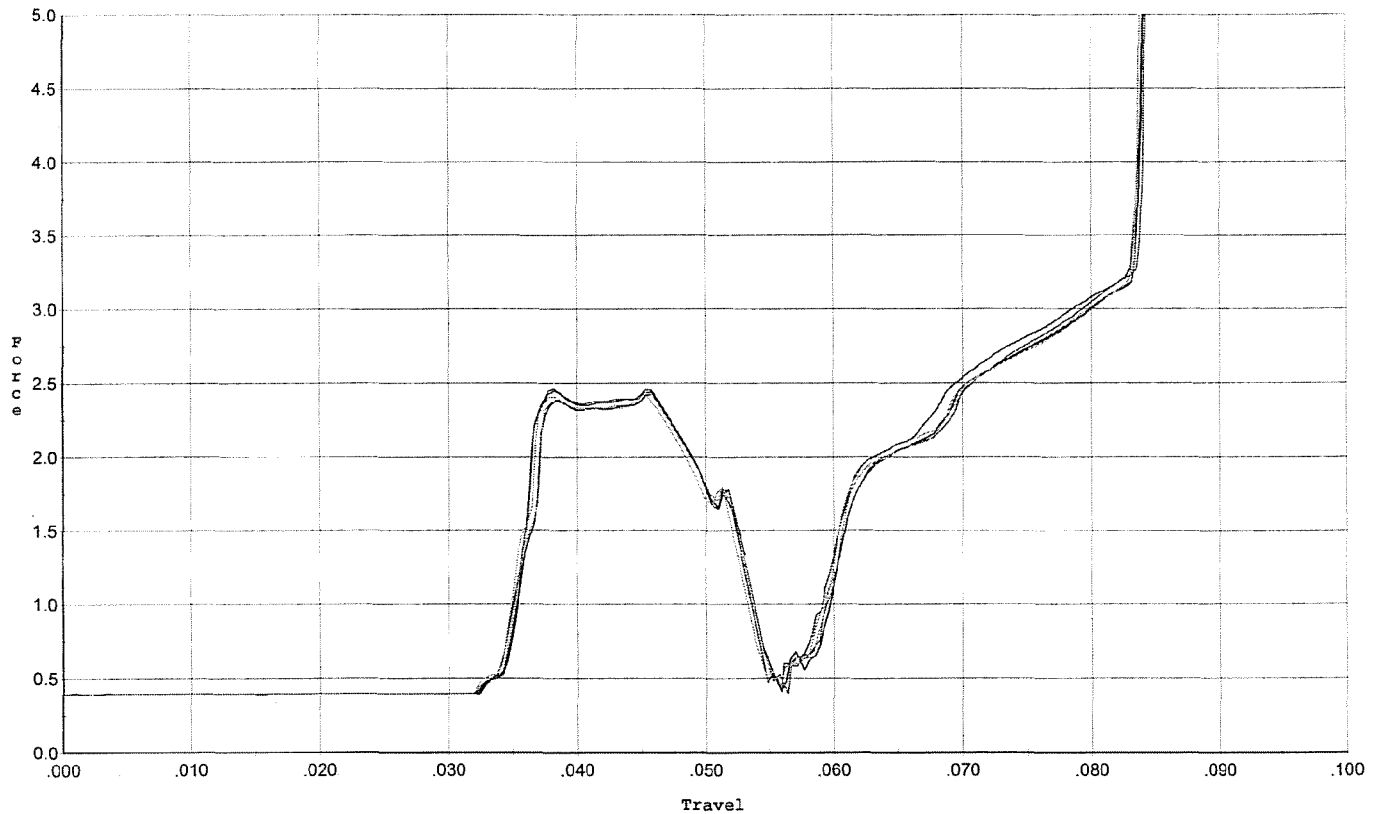
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	12-2-08	R.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	12-2-08	R.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	12-2-08	R.D.
	J) ASSEMBLE STOCK		11-18-08	R.T.
	K) ASSEMBLE SWIVEL STUDS		12-2-08	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	11-19-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	R.D.
670	FINAL INSPECTION A) HEADSPACE		12-2-08	R.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.66</u> <u>2.56</u> <u>2.51</u> <u>2.62</u>	11-26-08	TC
	C) FUNCTION		12-2-08	R.D.
690	PACK		12-3-08	R.S.N.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



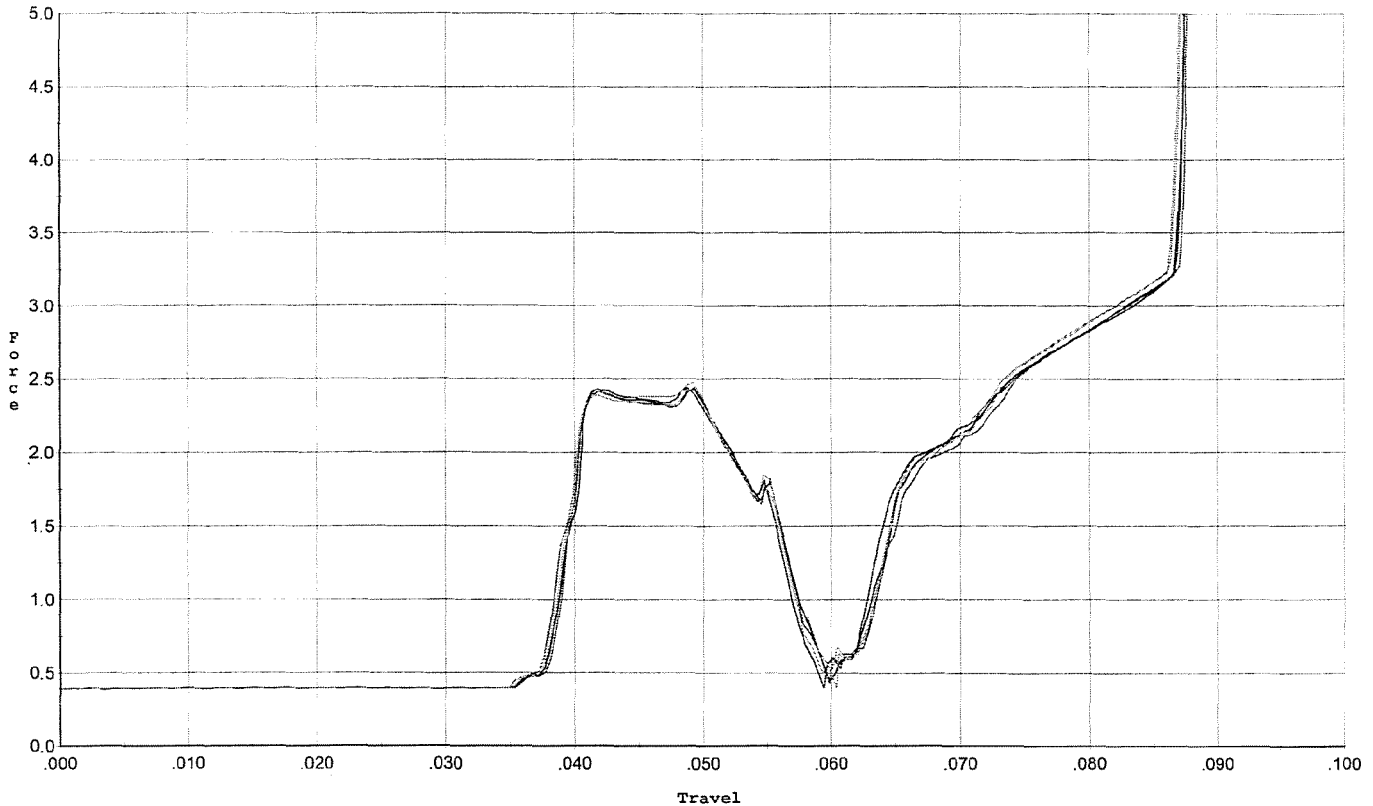
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.449	0.053	0.033	0.036	0.052		Set Trigger
2	2.423	0.053	0.033	0.036	0.051		Set Trigger
3	2.460	0.053	0.033	0.036	0.052		Set Trigger
4	2.420	0.052	0.032	0.036	0.051		Set Trigger
5	2.436	0.053	0.034	0.036	0.051		Set Trigger

AVG 2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



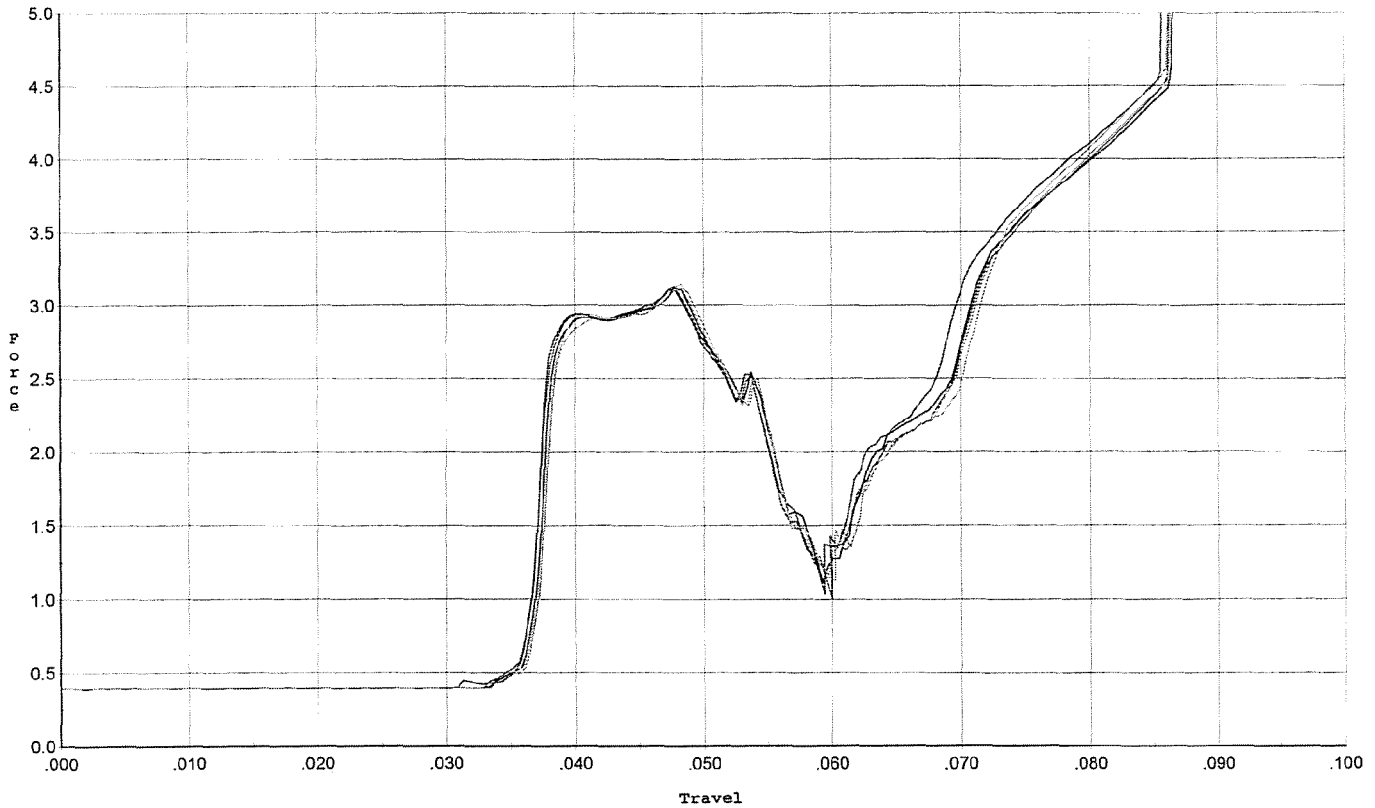
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.443	0.056	0.038	0.038	0.052		Set Trigger
2	2.432	0.055	0.038	0.038	0.052		Set Trigger
3	2.442	0.055	0.038	0.038	0.051		Set Trigger
4	2.428	0.055	0.038	0.038	0.052		Set Trigger
5	2.477	0.055	0.038	0.038	0.052		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



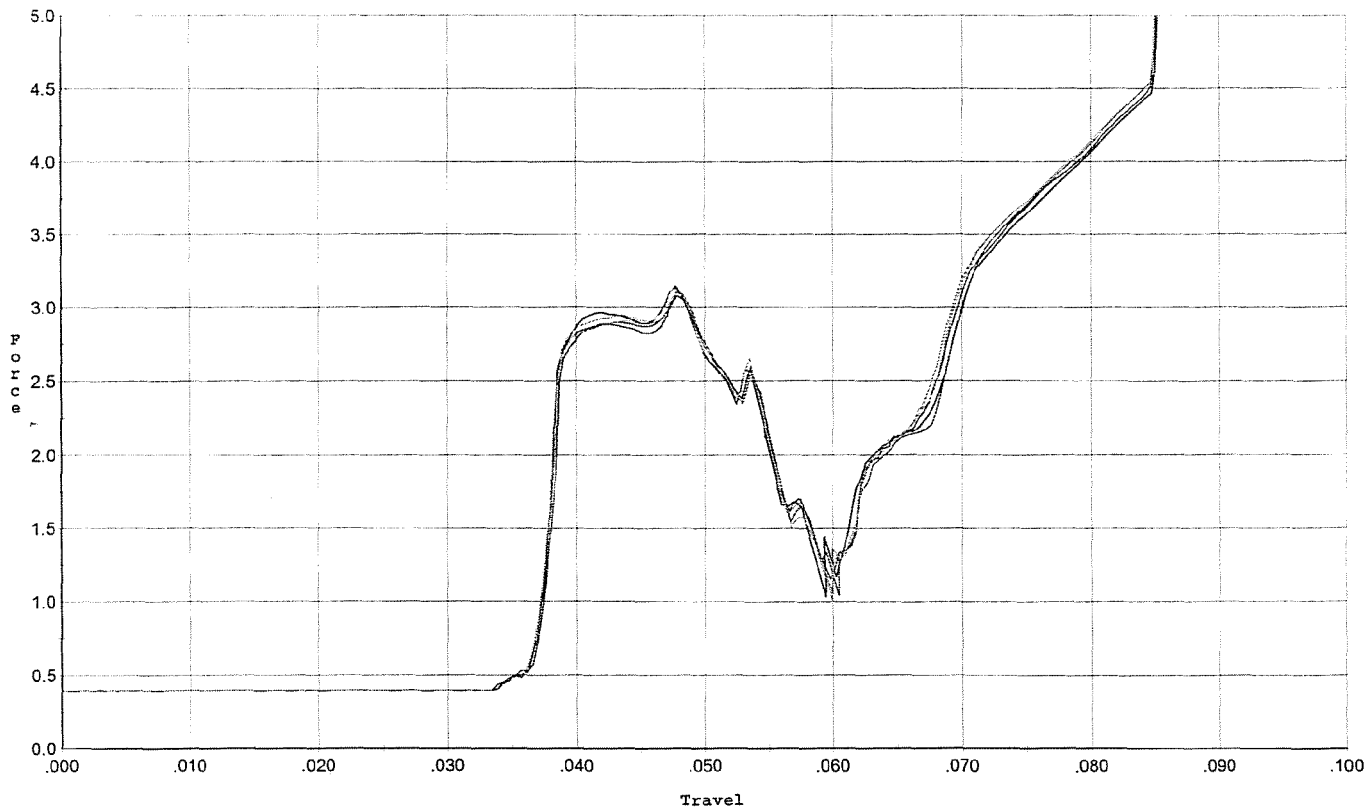
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.111	0.055	0.036	0.036	0.065		Set Trigger
2	3.122	0.055	0.036	0.036	0.065		Set Trigger
3	3.129	0.055	0.036	0.037	0.065		Set Trigger
4	3.117	0.055	0.036	0.036	0.065		Set Trigger
5	3.148	0.055	0.036	0.037	0.065		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

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



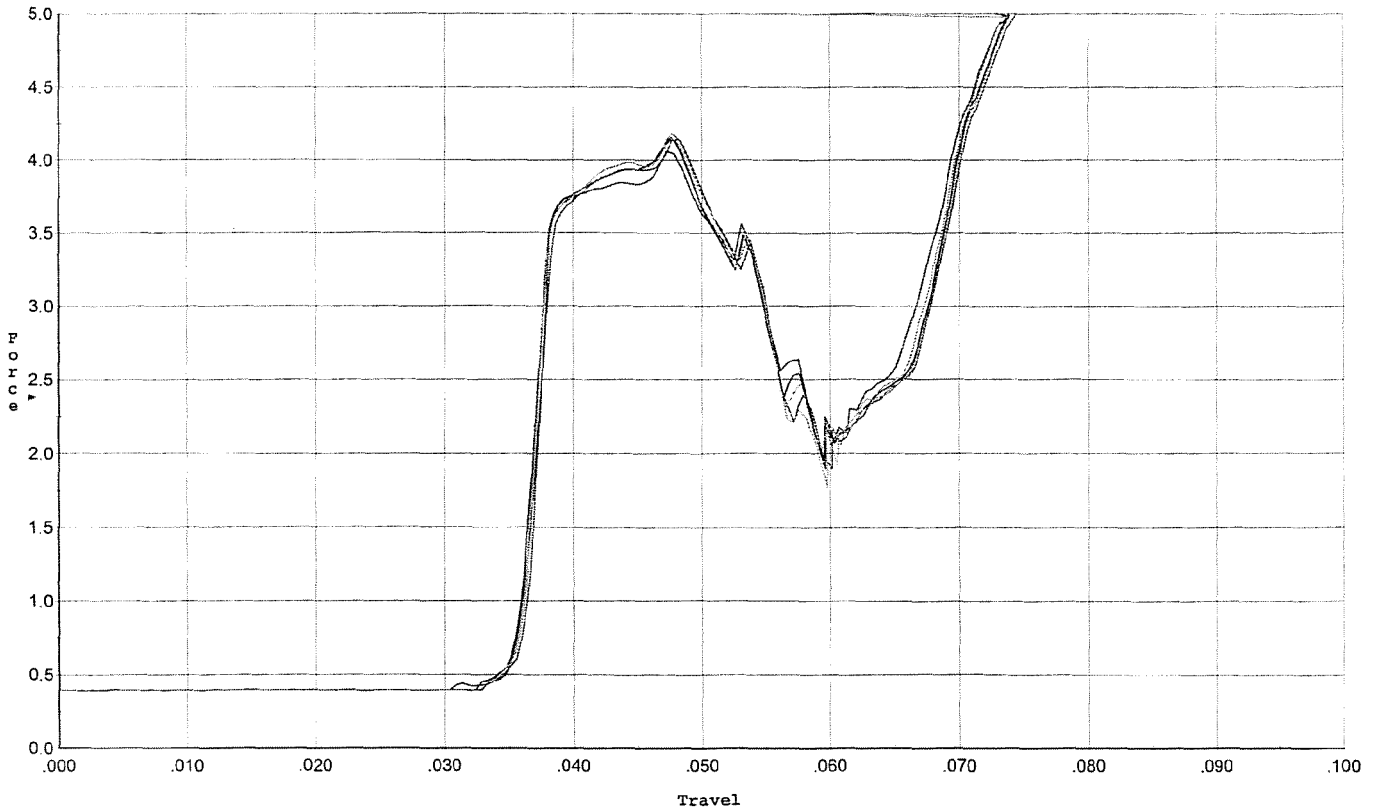
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.080	0.054	0.037	0.036	0.062		Set Trigger
2	3.137	0.055	0.036	0.036	0.063		Set Trigger
3	3.104	0.054	0.037	0.036	0.062		Set Trigger
4	3.148	0.055	0.036	0.036	0.063		Set Trigger
5	3.099	0.054	0.036	0.036	0.062		Set Trigger

Aug 3.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

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



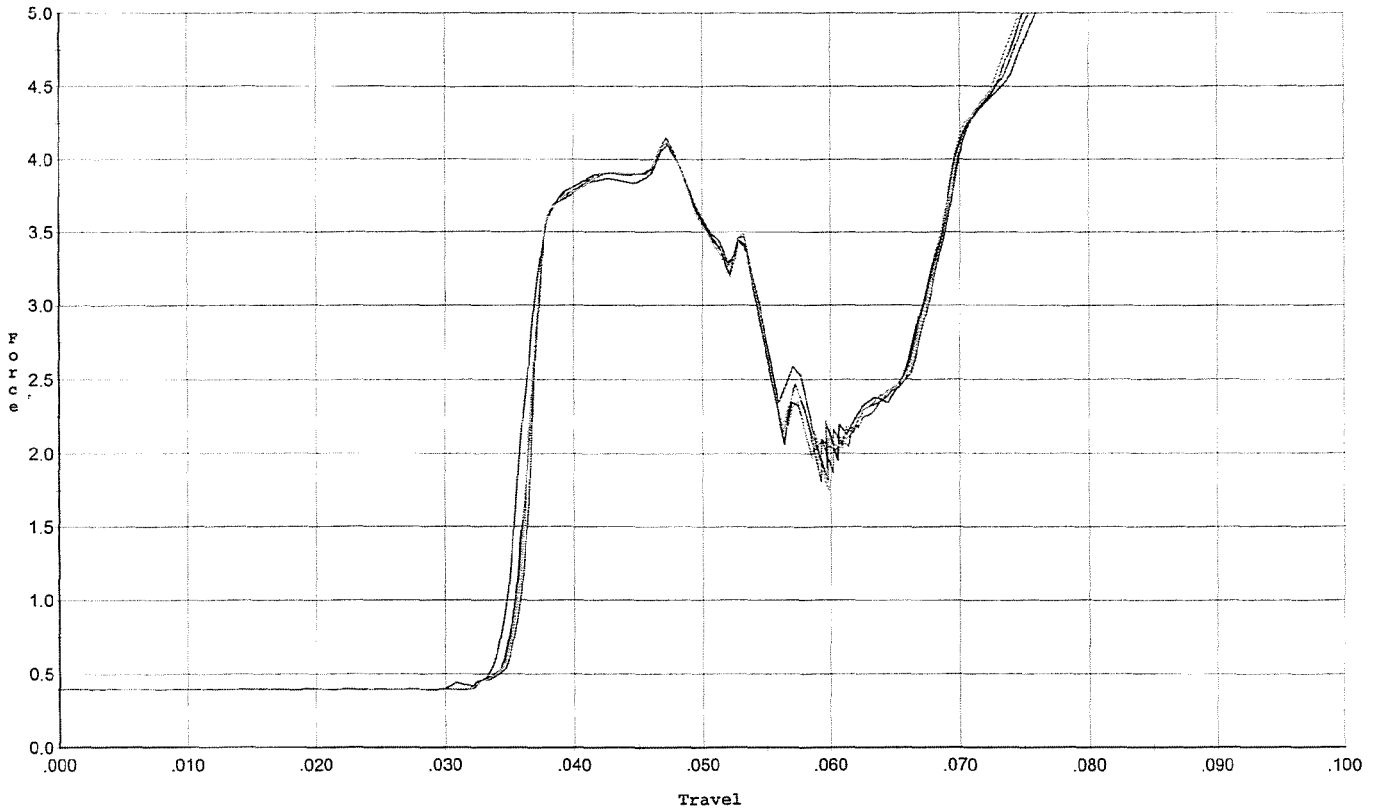
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.058	0.057	0.035	0.031	0.088		Set Trigger
2	4.157	0.054	0.035	0.034	0.081		Set Trigger
3	4.141	0.055	0.036	0.034	0.082		Set Trigger
4	4.154	0.055	0.036	0.033	0.083		Set Trigger
5	4.186	0.055	0.035	0.033	0.083		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

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



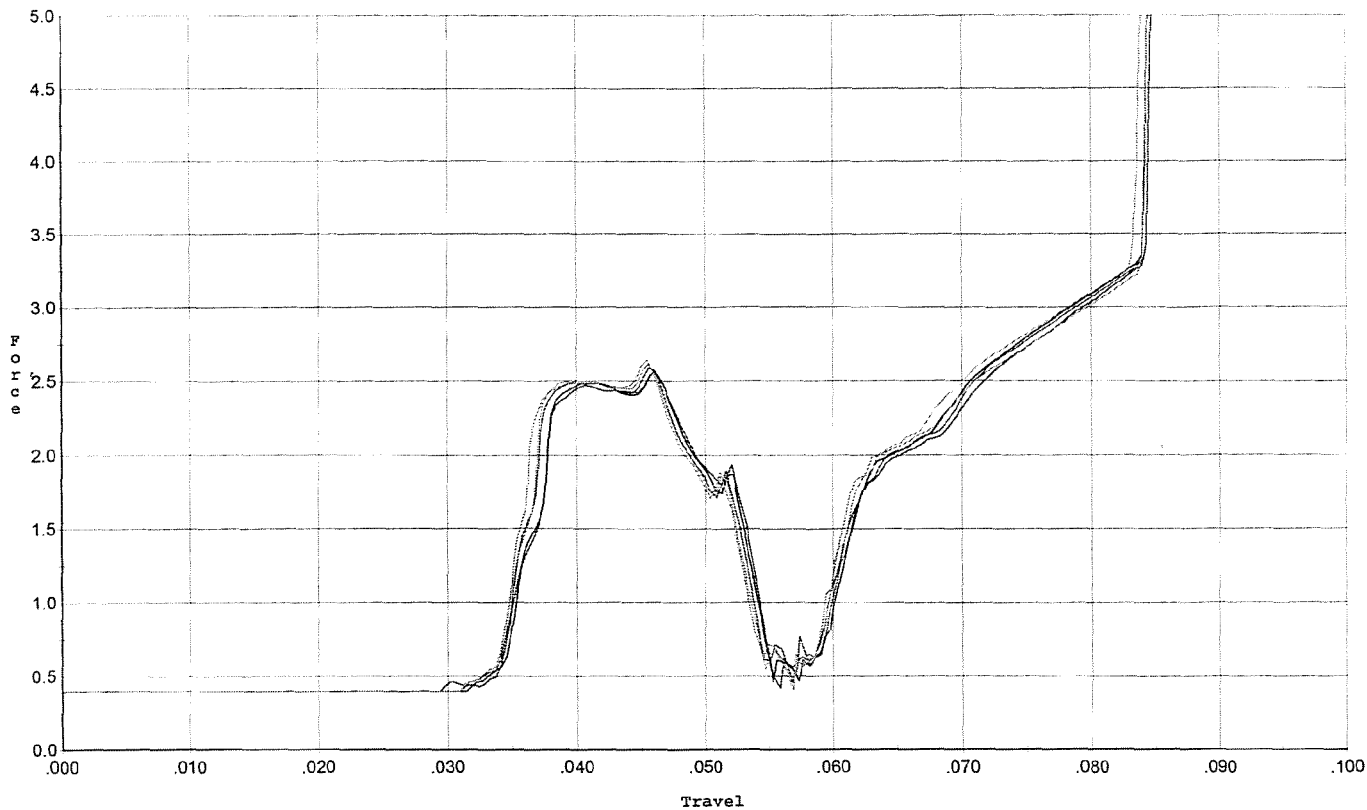
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.098	0.054	0.034	0.034	0.084		Set Trigger
2	4.111	0.053	0.035	0.034	0.080		Set Trigger
3	4.148	0.055	0.035	0.034	0.082		Set Trigger
4	4.134	0.055	0.035	0.034	0.083		Set Trigger
5	4.120	0.055	0.035	0.034	0.083		Set Trigger

AVG 4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



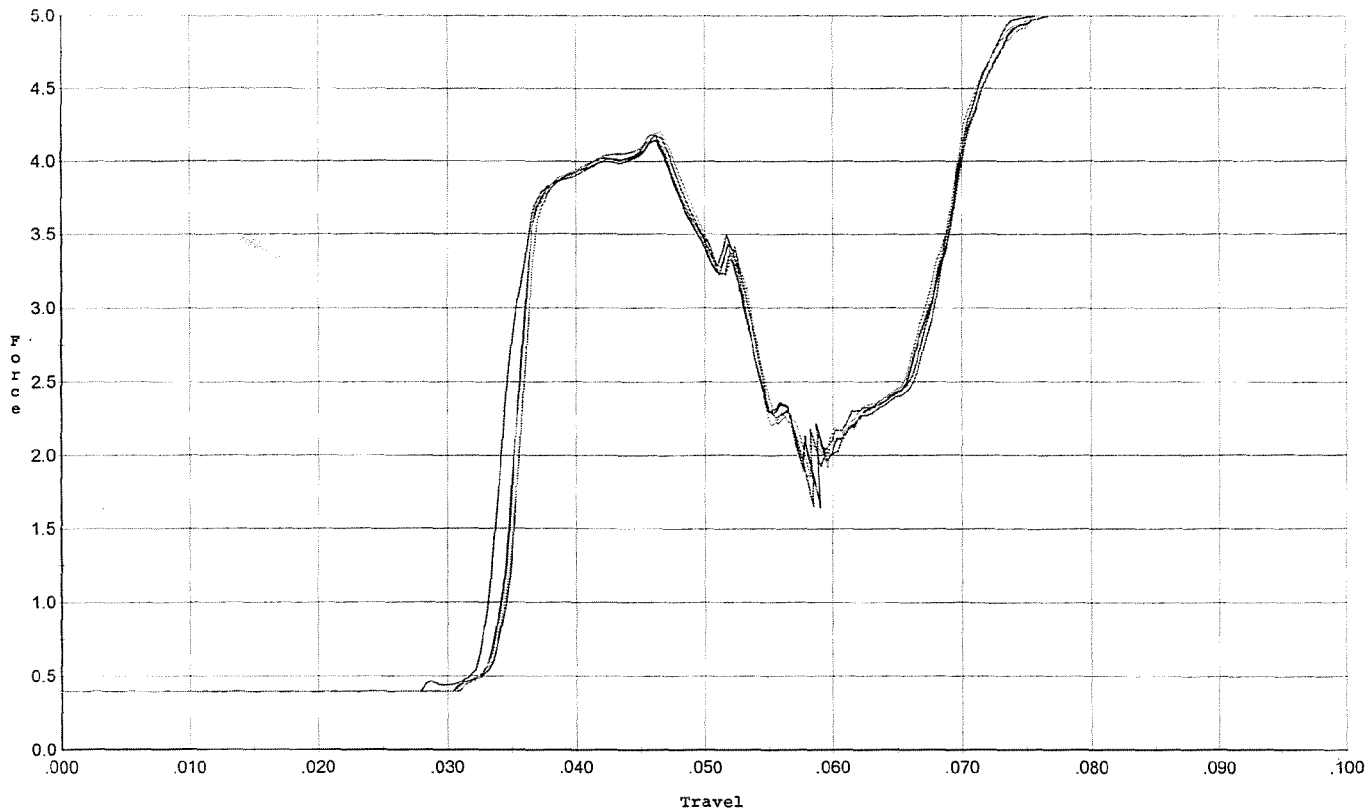
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.563	0.053	0.034	0.037	0.053		Set Trigger
2	2.574	0.054	0.035	0.036	0.053		Set Trigger
3	2.587	0.053	0.034	0.037	0.053		Set Trigger
4	2.612	0.052	0.034	0.037	0.052		Set Trigger
5	2.639	0.052	0.034	0.036	0.052		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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	4.180	0.052	0.033	0.034	0.084		Set Trigger
2	4.143	0.053	0.033	0.035	0.082		Set Trigger
3	4.177	0.054	0.034	0.035	0.083		Set Trigger
4	4.204	0.053	0.034	0.034	0.083		Set Trigger
5	4.196	0.053	0.033	0.034	0.082		Set Trigger

Avg 4.18