

66794593

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



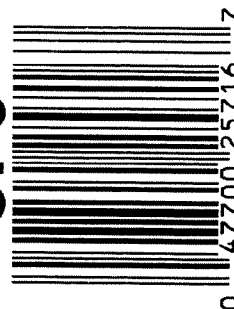
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794593

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794593

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	SP
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10-29-08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		11/3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-4-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-4-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-4-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

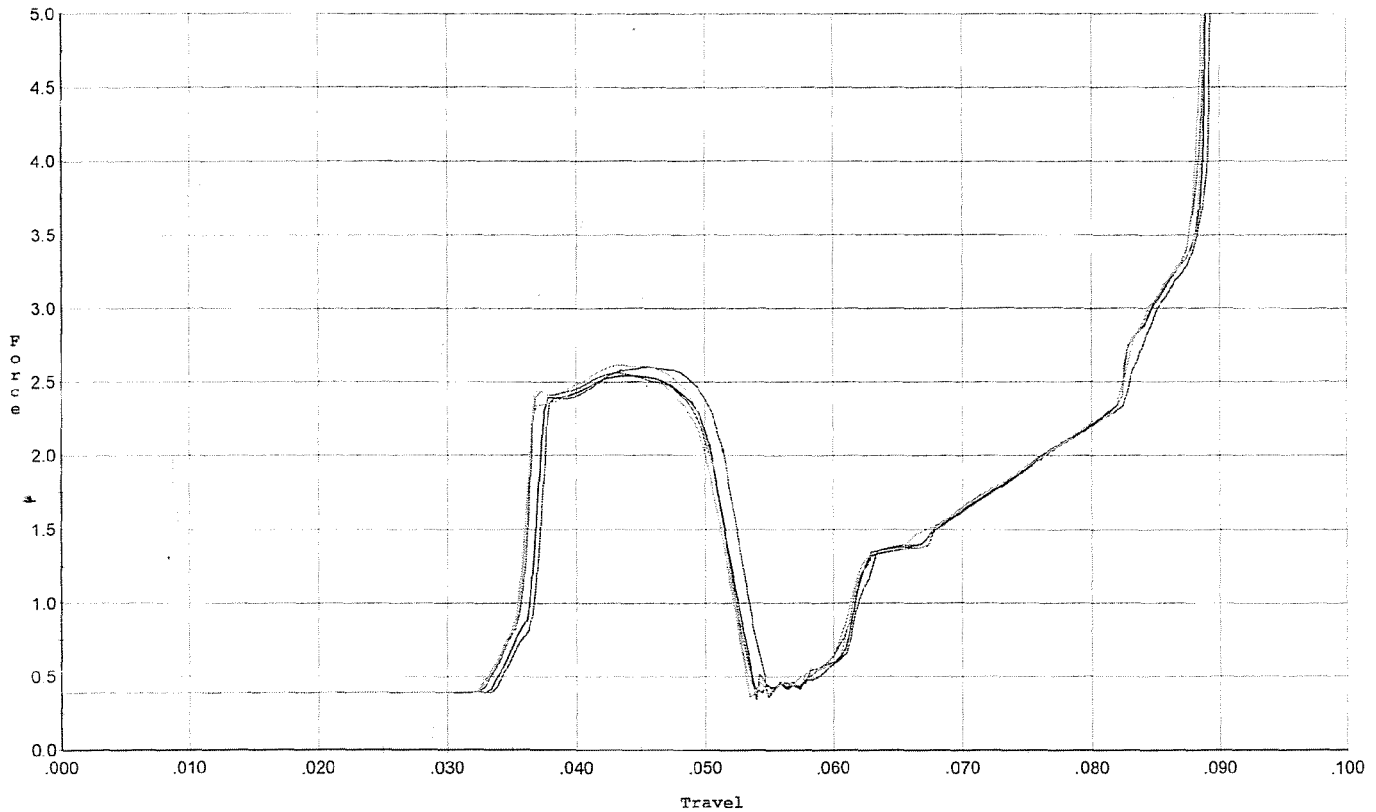
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-14-08	LH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	11-14-08	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-14-08	RP
	J) ASSEMBLE STOCK		11-10-08	RP
	K) ASSEMBLE SWIVEL STUDS		11-14-08	LH
	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	J
670	FINAL INSPECTION A) HEADSPACE		11-14-08	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.24</u> <u>2.33</u> <u>2.34</u> <u>2.31</u> <u>2.34</u>	11-11-08	TL
	C) FUNCTION		11-14-08	RP
690	PACK		11/17/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



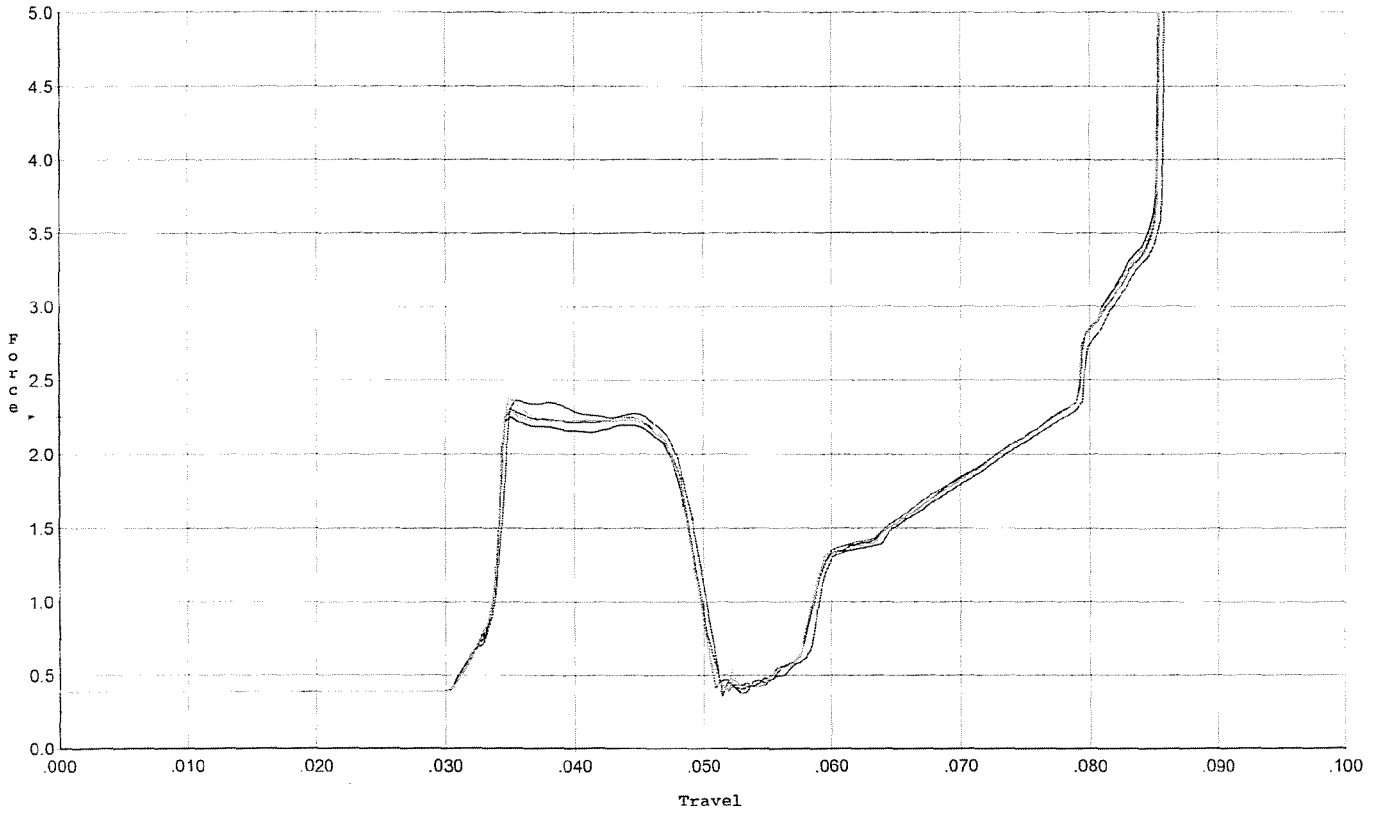
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.602	0.051	0.034	0.041	0.051		Set Trigger
2	2.542	0.050	0.034	0.041	0.049		Set Trigger
3	2.560	0.051	0.033	0.041	0.050		Set Trigger
4	2.613	0.051	0.033	0.041	0.051		Set Trigger
5	2.507	0.051	0.033	0.041	0.051		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/10/08

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



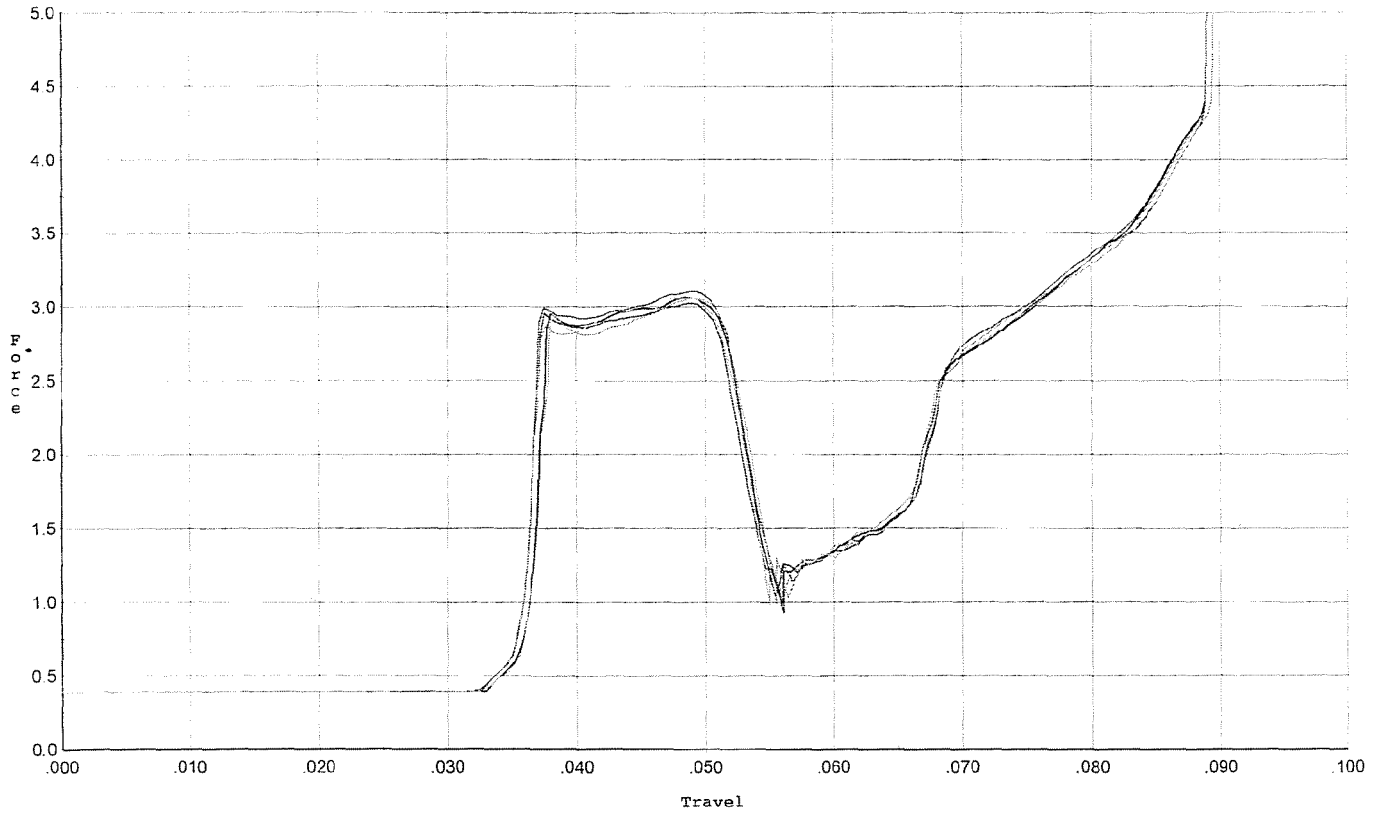
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.364	0.049	0.031	0.041	0.047		Set Trigger
2	2.253	0.048	0.031	0.041	0.045		Set Trigger
3	2.306	0.048	0.031	0.041	0.046		Set Trigger
4	2.295	0.048	0.031	0.041	0.046		Set Trigger
5	2.376	0.048	0.031	0.041	0.046		Set Trigger

Avg 2.31

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



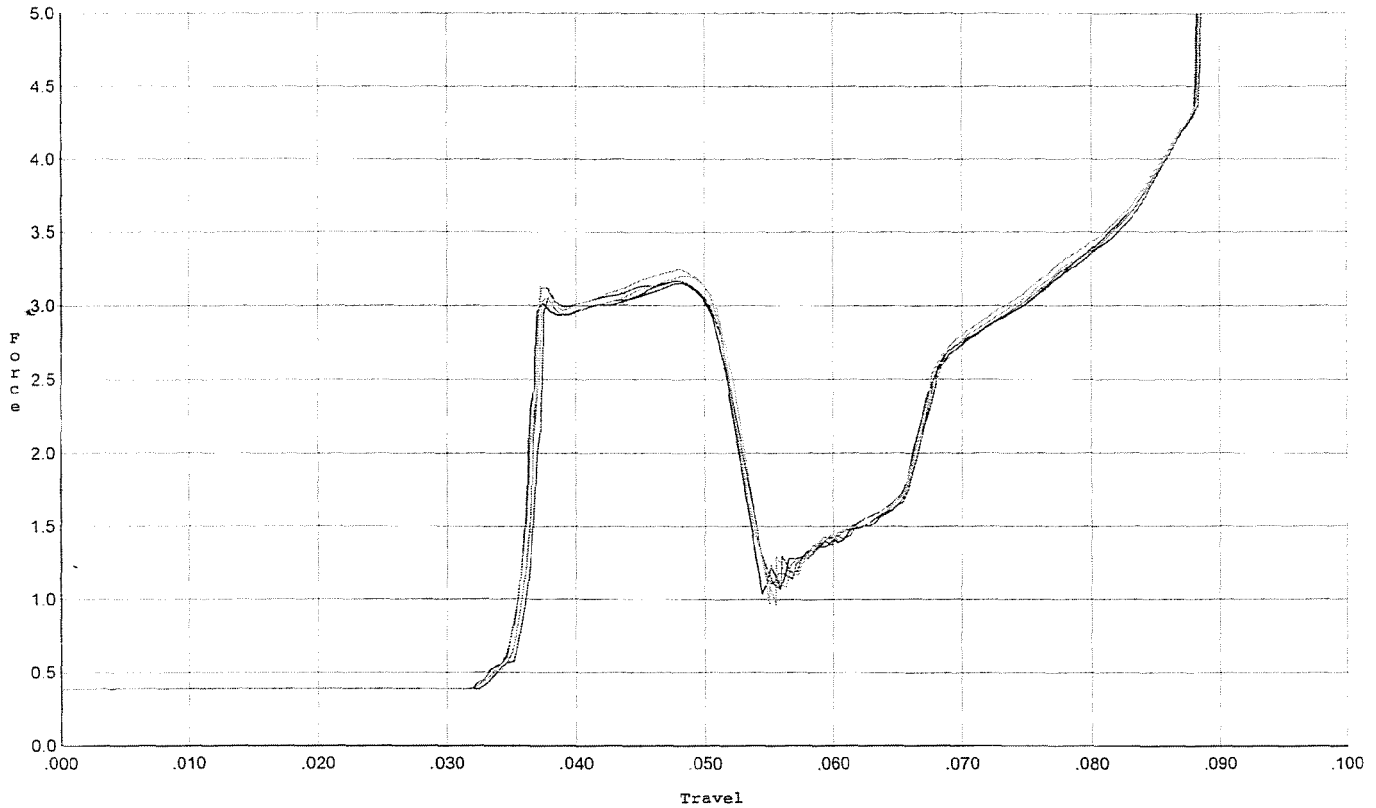
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.023	0.051	0.035	0.039	0.060		Set Trigger
2	3.064	0.052	0.035	0.038	0.061		Set Trigger
3	3.105	0.052	0.035	0.038	0.062		Set Trigger
4	3.074	0.052	0.035	0.038	0.062		Set Trigger
5	3.059	0.053	0.036	0.038	0.062		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putrch 11/10/08

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



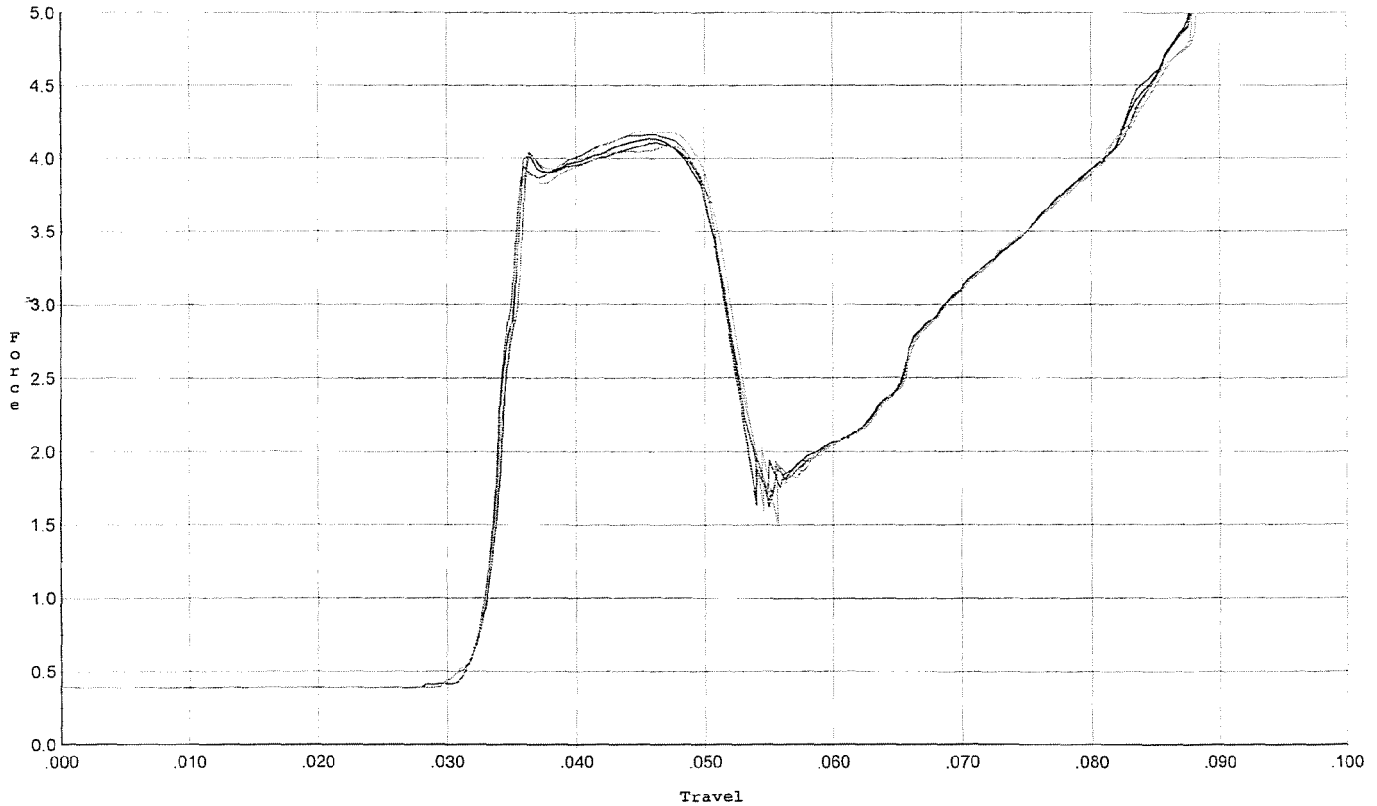
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.154	0.051	0.035	0.038	0.061		Set Trigger
2	3.164	0.052	0.035	0.038	0.062		Set Trigger
3	3.169	0.051	0.035	0.038	0.062		Set Trigger
4	3.201	0.052	0.035	0.037	0.063		Set Trigger
5	3.249	0.051	0.035	0.038	0.063		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



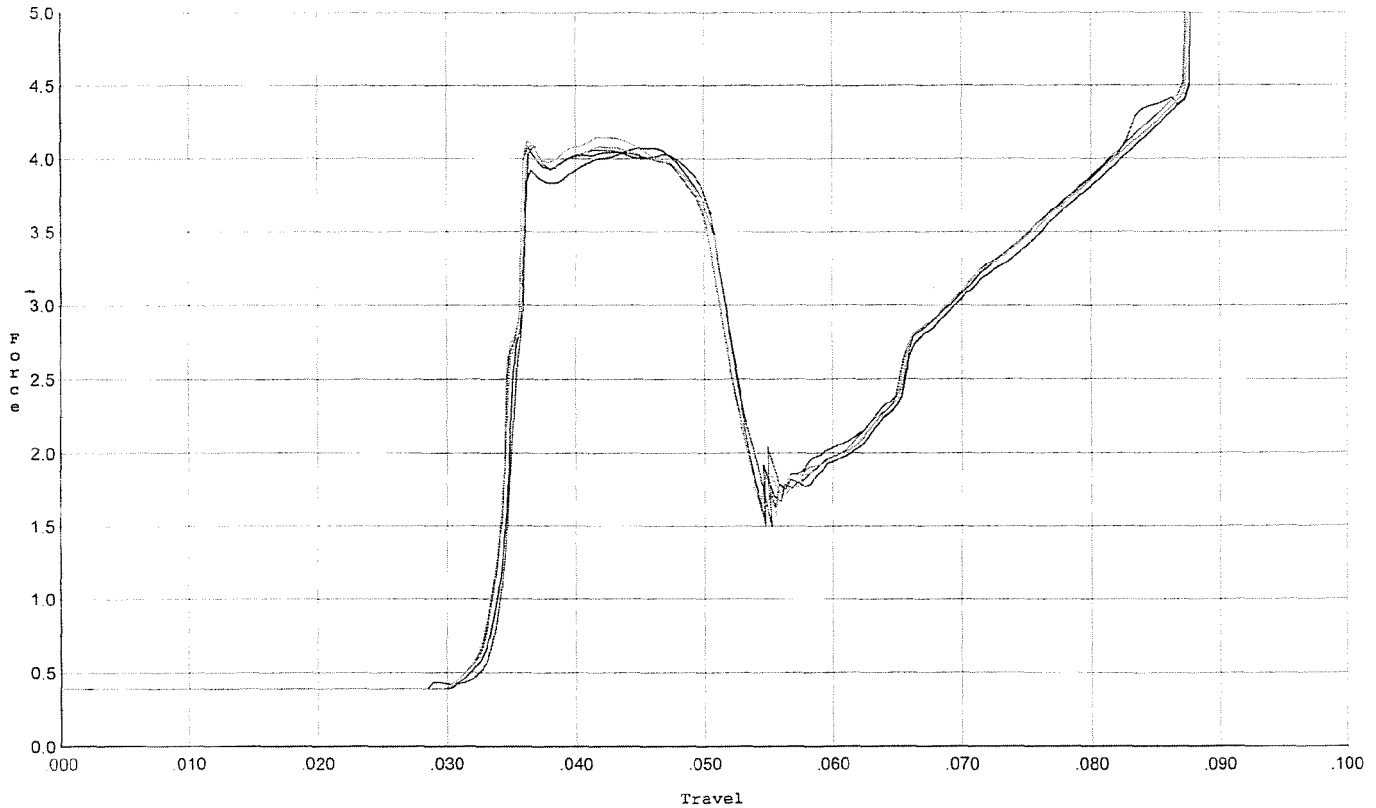
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.050	0.032	0.036	0.080		Set Trigger
2	4.133	0.051	0.032	0.036	0.082		Set Trigger
3	4.161	0.051	0.032	0.036	0.082		Set Trigger
4	4.178	0.051	0.032	0.036	0.084		Set Trigger
5	4.088	0.050	0.032	0.036	0.080		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putrch 11/10/08

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



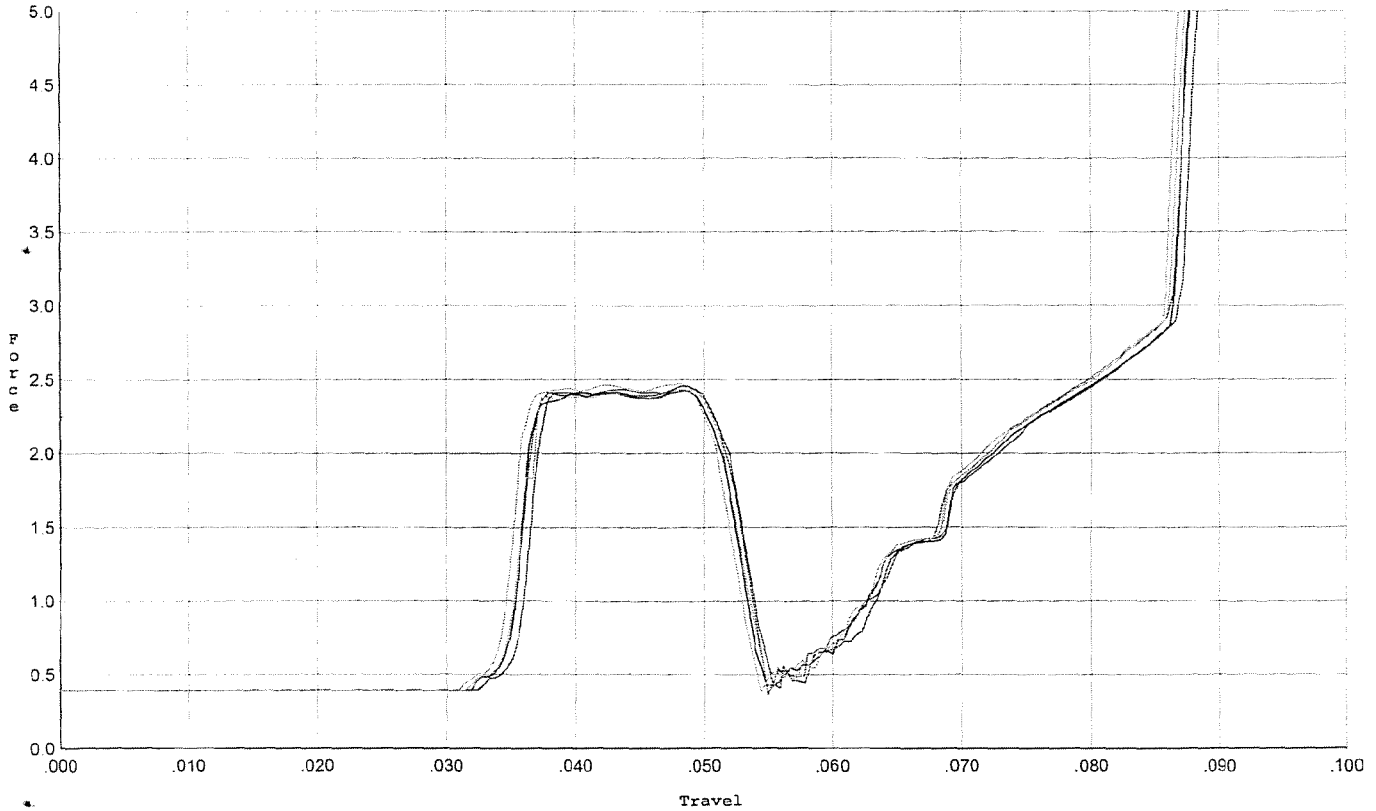
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.050	0.033	0.036	0.078		Set Trigger
2	4.069	0.051	0.033	0.036	0.078		Set Trigger
3	4.081	0.050	0.033	0.036	0.078		Set Trigger
4	4.146	0.050	0.033	0.036	0.078		Set Trigger
5	4.089	0.051	0.033	0.036	0.079		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/10/08

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



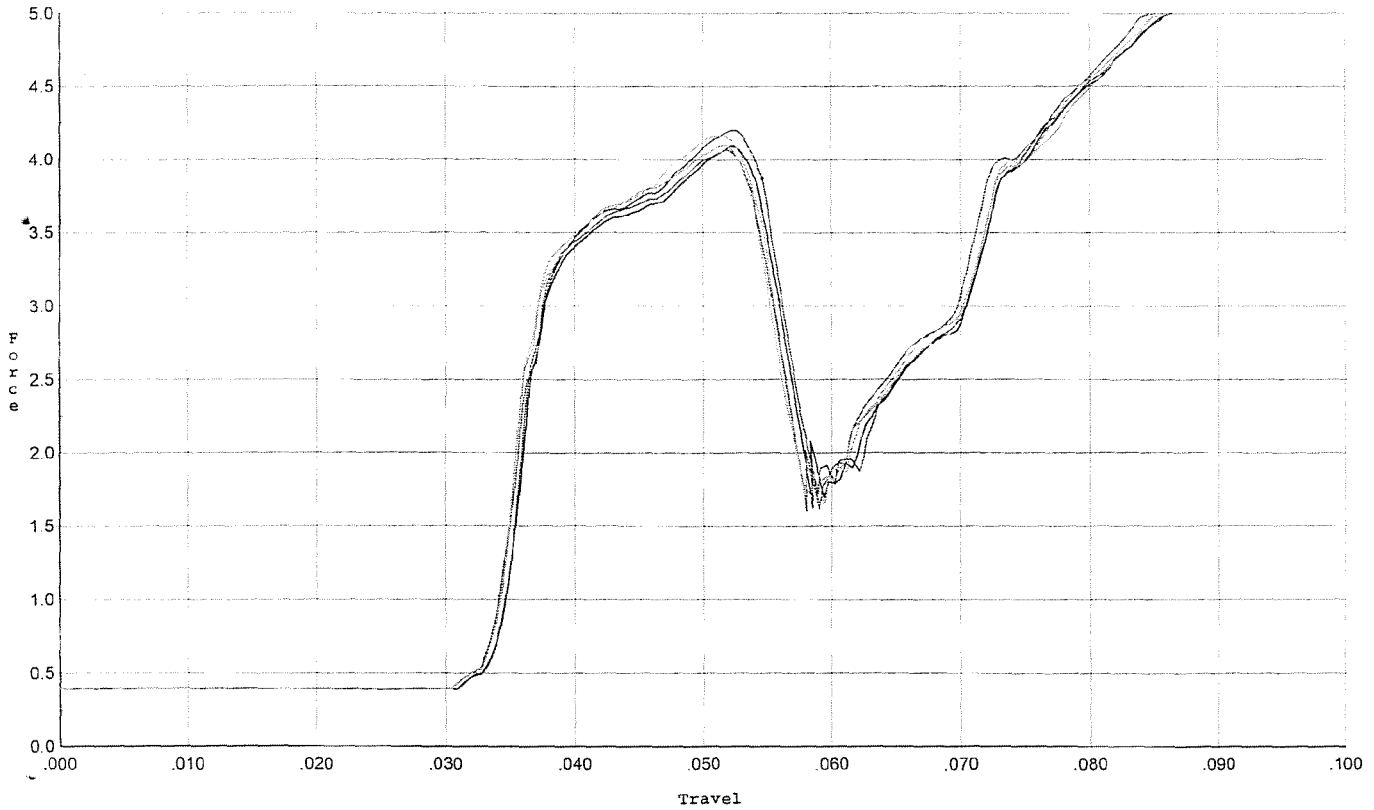
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.455	0.052	0.035	0.040	0.052		Set Trigger
2	2.422	0.052	0.034	0.040	0.052		Set Trigger
3	2.434	0.052	0.034	0.039	0.054		Set Trigger
4	2.431	0.051	0.035	0.040	0.052		Set Trigger
5	2.473	0.051	0.034	0.040	0.053		Set Trigger

Aug 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/10/08

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	4.200	0.055	0.034	0.036	0.088		Set Trigger
2	4.097	0.056	0.034	0.036	0.088		Set Trigger
3	4.069	0.055	0.033	0.036	0.087		Set Trigger
4	4.163	0.055	0.033	0.036	0.088		Set Trigger
5	4.101	0.054	0.033	0.036	0.085		Set Trigger

Aug 4.12