

G6794643

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

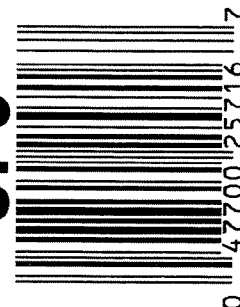
24"

CAPACITY

6

G6794643

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794643

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-27-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE		9-30-08	PSV
475	DRILL AND TAP SIGHT HOLES		10/1/08	FM
480	MAGNAFLUX BBL ACTION	MAGNA-FLUX VUT 1500 OPERATOR 	10/2/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/2/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-3	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-15-08	PSV
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

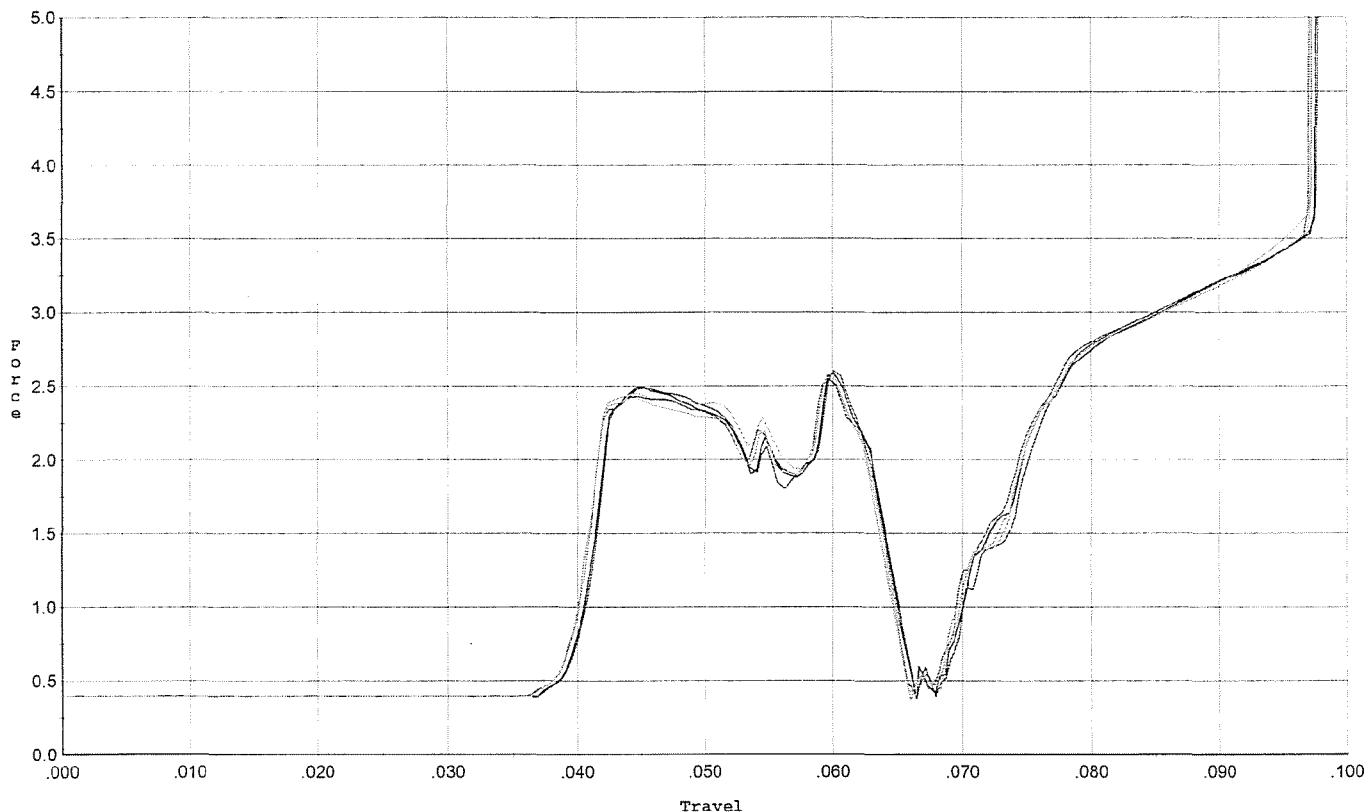
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>4.5</u>	10-27-08	LD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.5</u>	10-27-08	LD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-27-08	LD
	J) ASSEMBLE STOCK		10-15-08	LD
	K) ASSEMBLE SWIVEL STUDS		10-27-08	LD
	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	10-23-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-08	LD
670	FINAL INSPECTION A) HEADSPACE		10-27-08	LD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.53</u> <u>2.55</u> <u>2.54</u> <u>2.55</u>	10-24-08	LD
	C) FUNCTION		10-27-08	LD
690	PACK		10/29/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



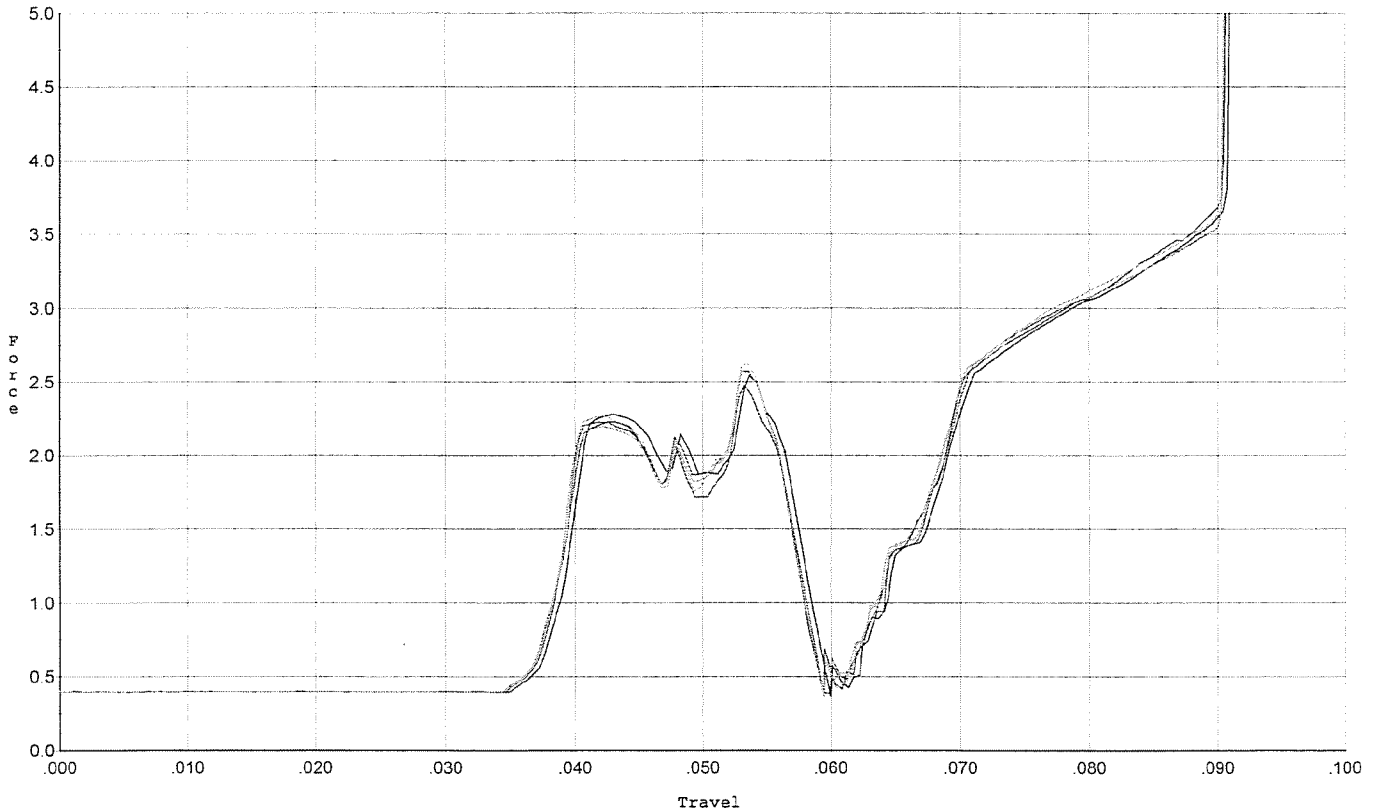
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.603	0.063	0.040	0.040	0.066		Set Trigger
2	2.587	0.063	0.039	0.040	0.066		Set Trigger
3	2.544	0.063	0.039	0.039	0.067		Set Trigger
4	2.583	0.064	0.039	0.040	0.068		Set Trigger
5	2.578	0.063	0.039	0.040	0.068		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

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

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



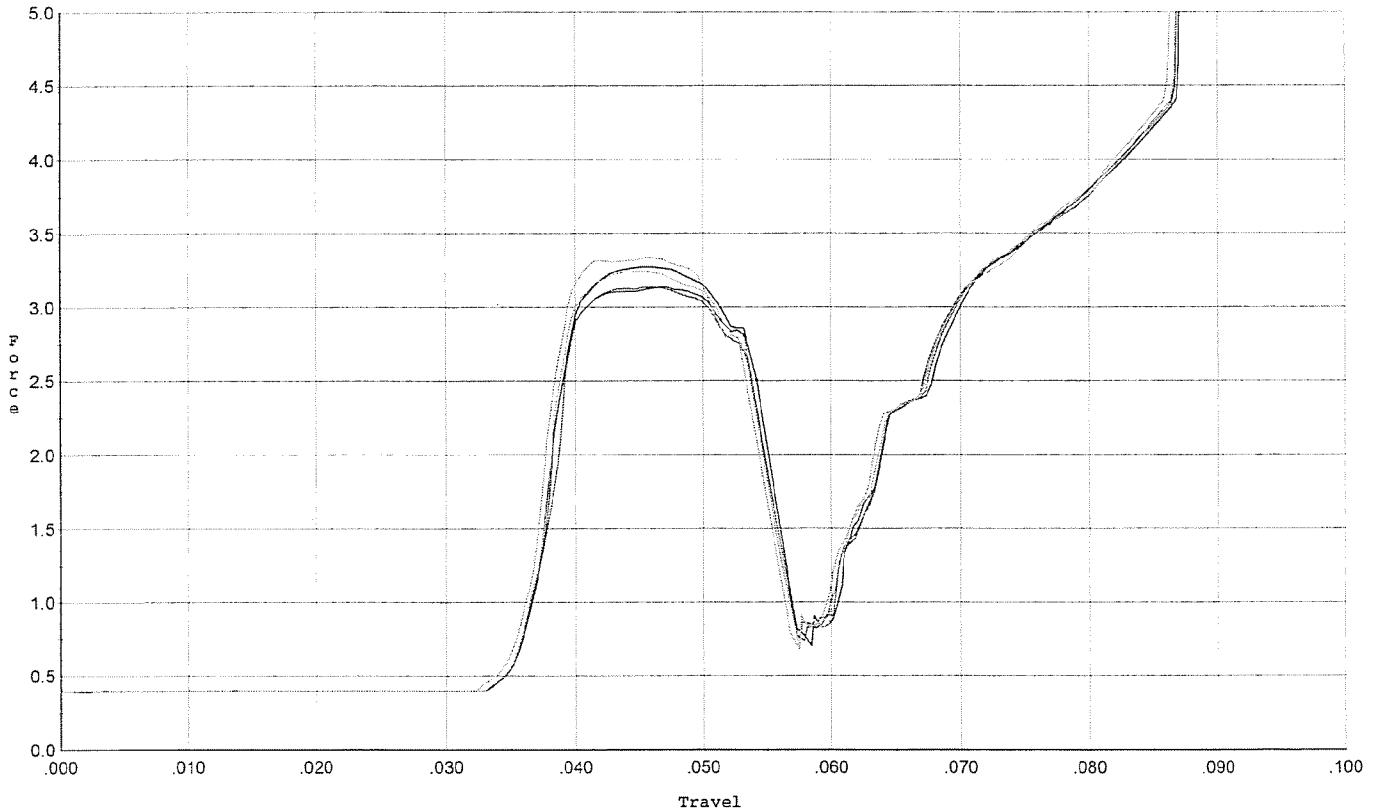
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.476	0.056	0.037	0.039	0.052		Set Trigger
2	2.545	0.056	0.038	0.039	0.053		Set Trigger
3	2.573	0.056	0.037	0.039	0.053		Set Trigger
4	2.625	0.056	0.037	0.039	0.053		Set Trigger
5	2.576	0.056	0.037	0.039	0.053		Set Trigger

Aug 2.55

Trigger Profile [lbs,inch]

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

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



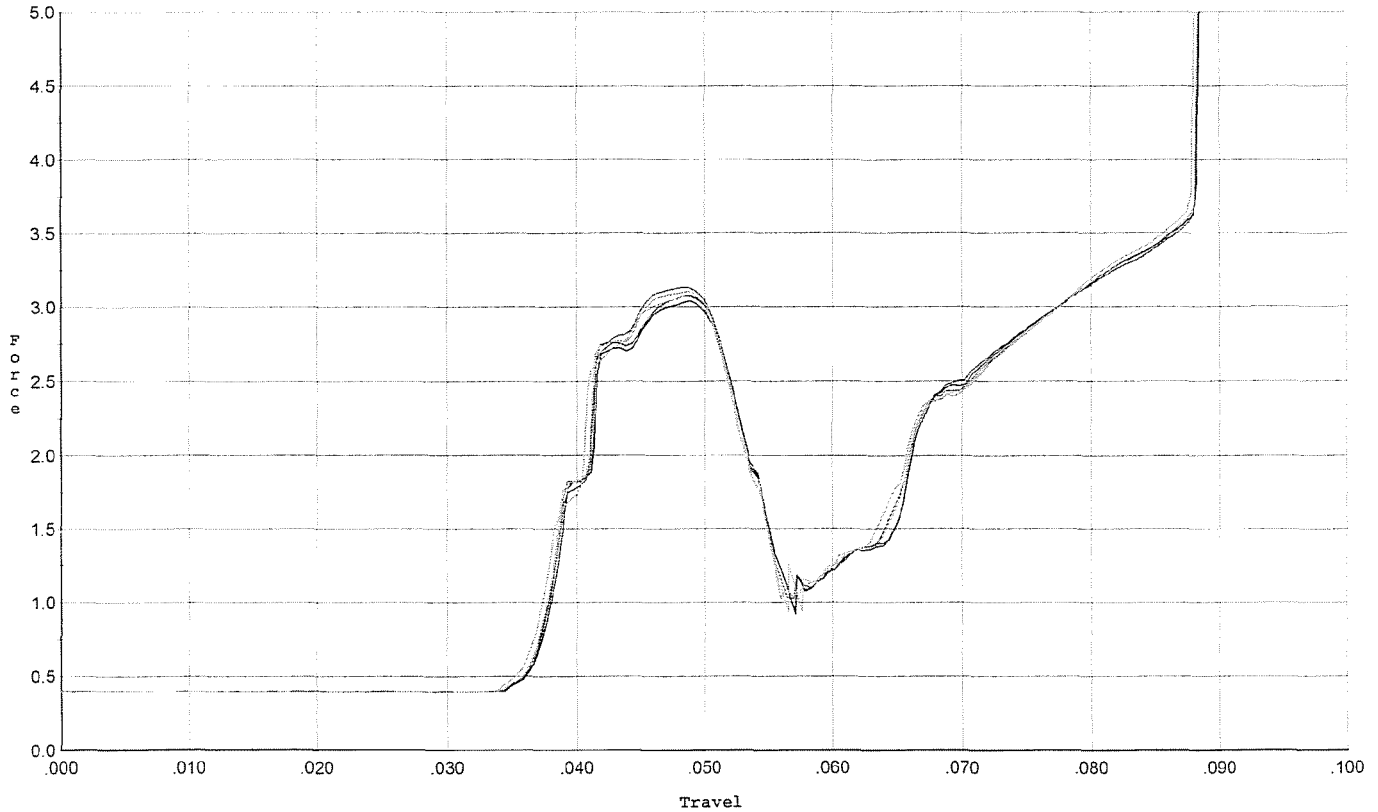
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.138	0.053	0.035	0.037	0.064		Set Trigger
2	3.278	0.054	0.036	0.037	0.067		Set Trigger
3	3.136	0.053	0.035	0.037	0.064		Set Trigger
4	3.247	0.053	0.035	0.037	0.065		Set Trigger
5	3.337	0.055	0.035	0.037	0.069		Set Trigger

Aug 3.22

Trigger Profile [lbs,inch]

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

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



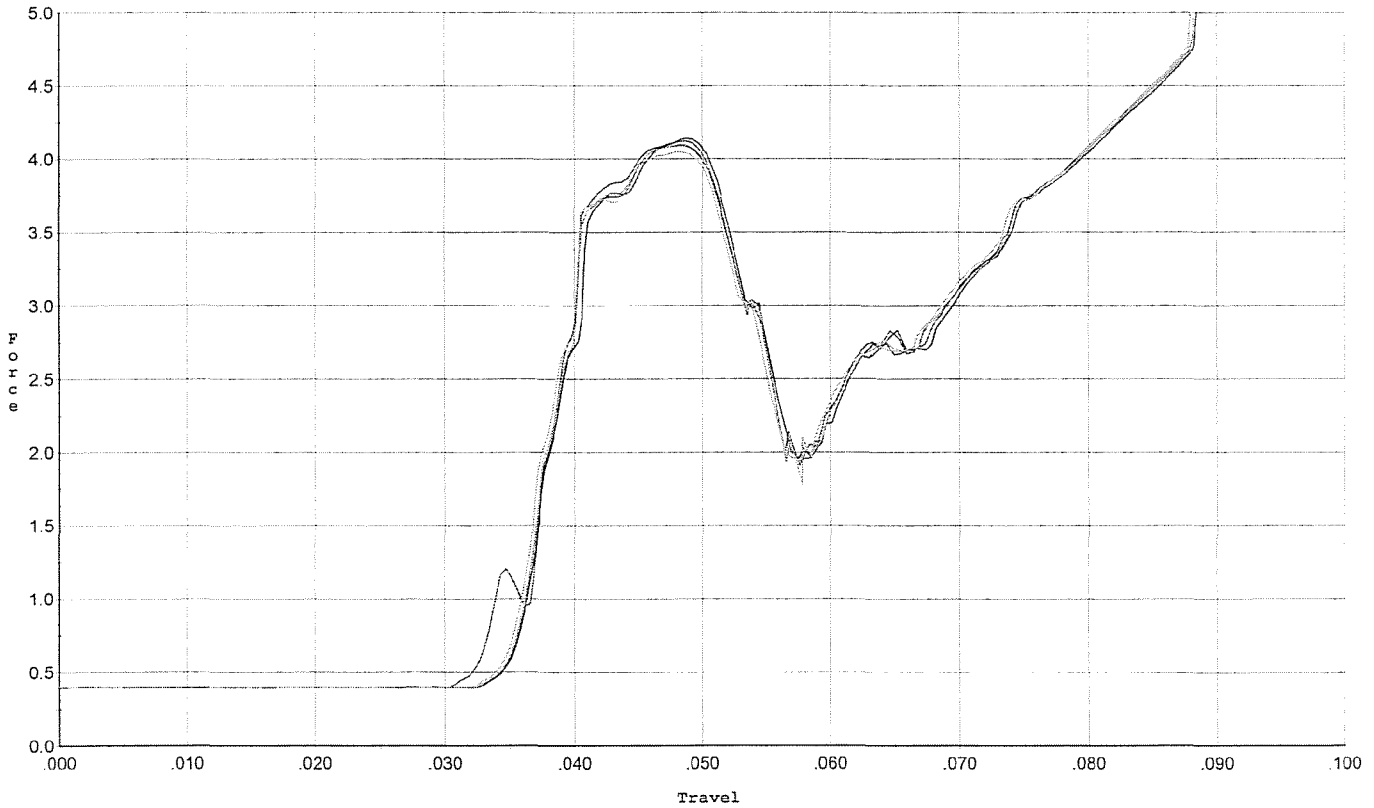
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.078	0.054	0.037	0.039	0.057		Set Trigger
2	3.039	0.054	0.037	0.039	0.056		Set Trigger
3	3.131	0.054	0.037	0.039	0.058		Set Trigger
4	3.104	0.054	0.037	0.039	0.058		Set Trigger
5	3.074	0.054	0.036	0.038	0.058		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

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

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



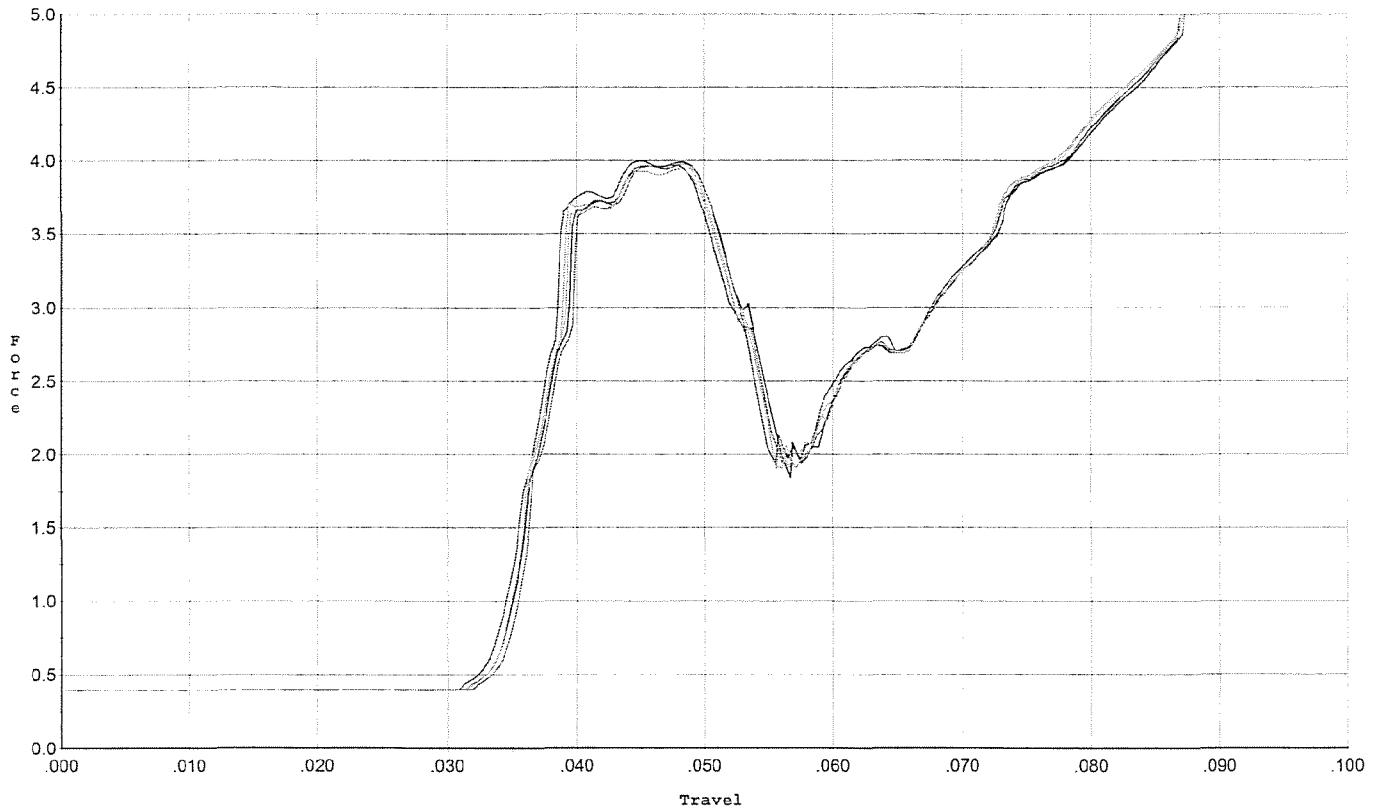
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.054	0.033	0.037	0.080		Set Trigger
2	4.140	0.054	0.035	0.037	0.077		Set Trigger
3	4.091	0.055	0.035	0.037	0.078		Set Trigger
4	4.047	0.054	0.035	0.037	0.077		Set Trigger
5	4.100	0.055	0.035	0.037	0.078		Set Trigger

Aug 4.10

Trigger Profile [lbs,inch]

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

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



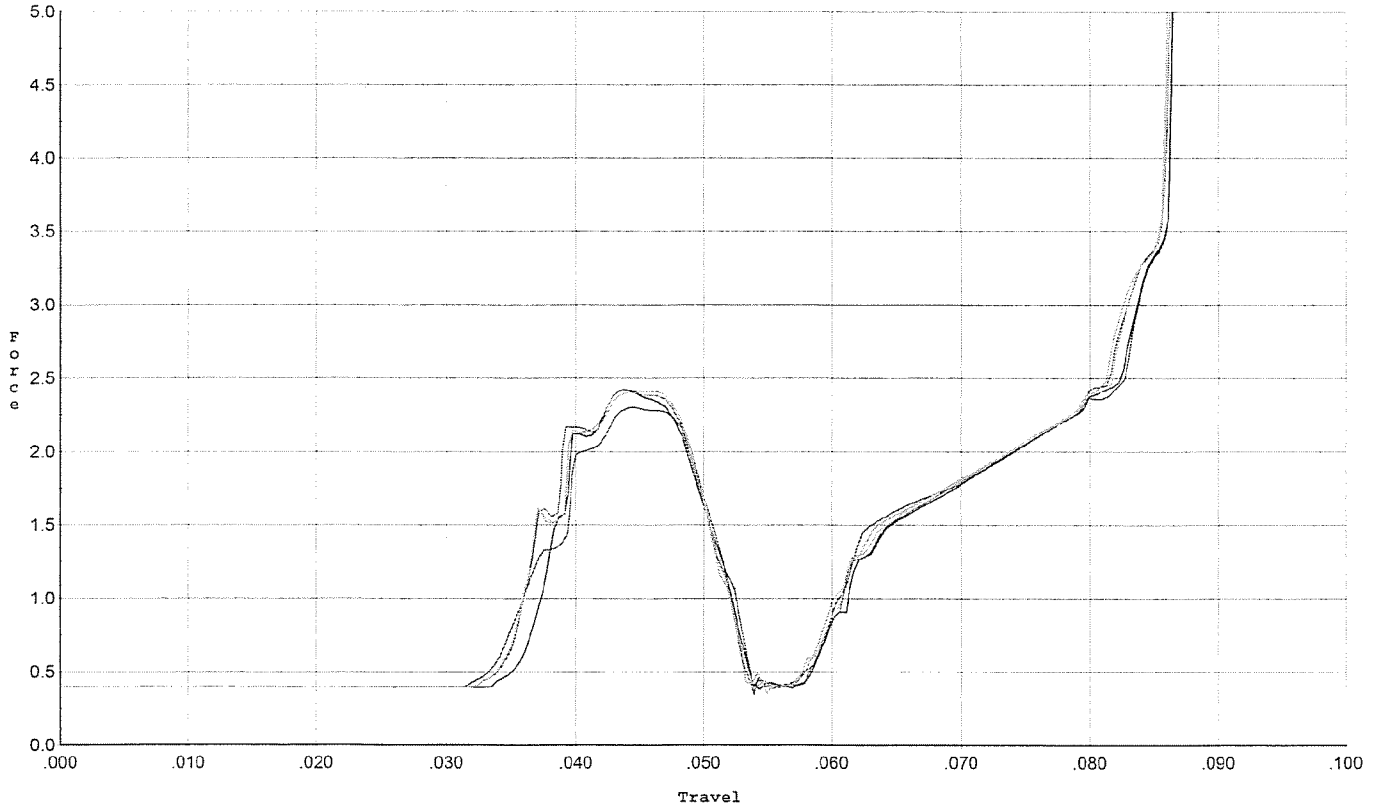
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.999	0.053	0.033	0.036	0.077		Set Trigger
2	3.990	0.053	0.034	0.036	0.077		Set Trigger
3	3.979	0.054	0.034	0.036	0.076		Set Trigger
4	3.940	0.054	0.034	0.036	0.078		Set Trigger
5	3.980	0.054	0.034	0.036	0.077		Set Trigger

Avg 3.97

Trigger Profile [lbs,inch]

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

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



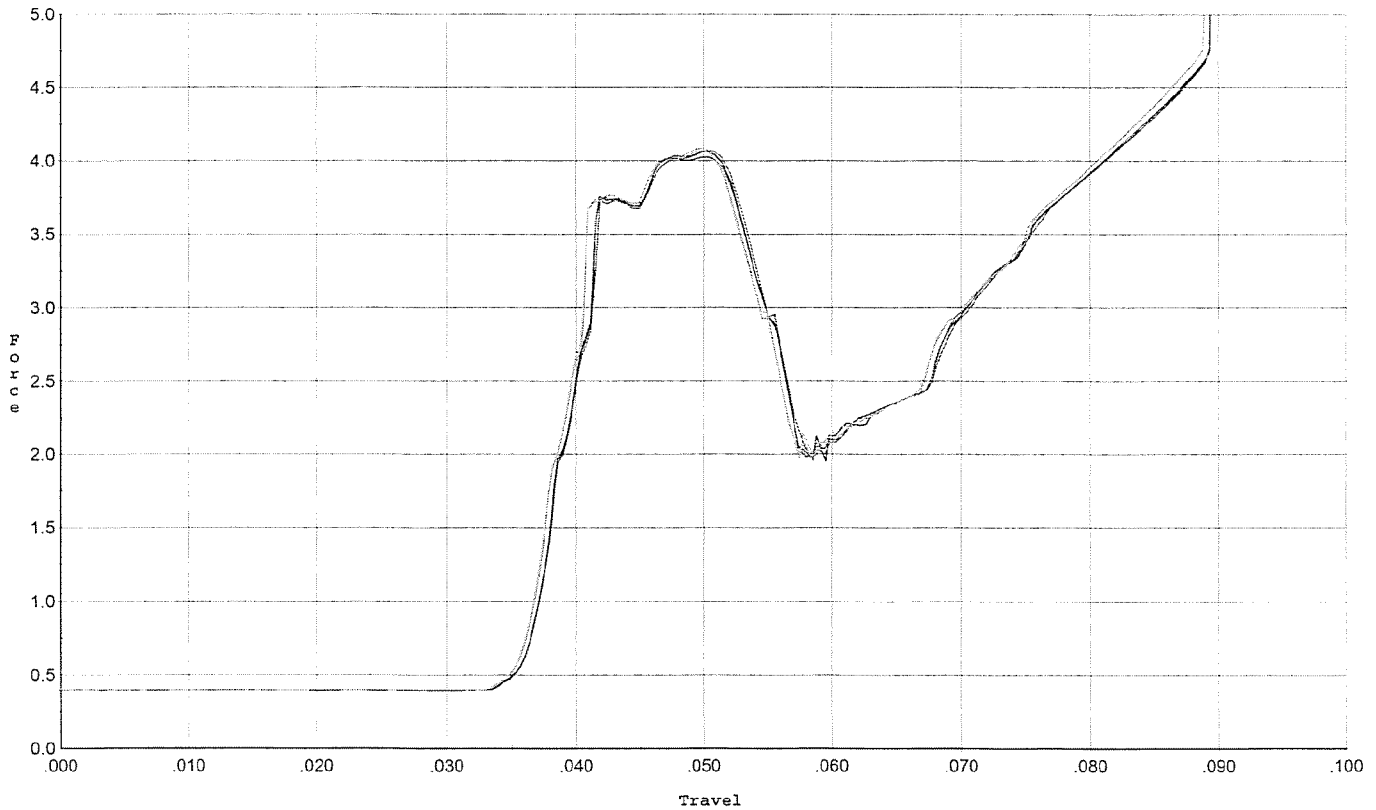
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.305	0.052	0.034	0.040	0.045		Set Trigger
2	2.423	0.052	0.036	0.040	0.044		Set Trigger
3	2.428	0.052	0.035	0.039	0.046		Set Trigger
4	2.404	0.050	0.035	0.040	0.044		Set Trigger
5	2.425	0.052	0.035	0.039	0.046		Set Trigger

Aug 2.39

Trigger Profile [lbs,inch]

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

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	4.026	0.056	0.036	0.037	0.078		Set Trigger
2	4.062	0.056	0.036	0.037	0.079		Set Trigger
3	4.071	0.056	0.036	0.037	0.079		Set Trigger
4	4.069	0.055	0.036	0.037	0.078		Set Trigger
5	4.085	0.055	0.036	0.037	0.078		Set Trigger

Aug 4.06