

66794661

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



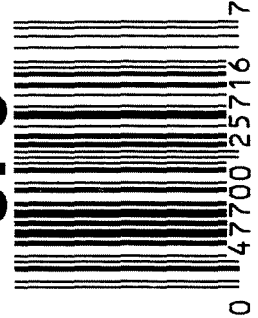
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

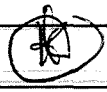
G6794661

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 679 4661

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	MAGNA-FLUX	10-28-08	SP
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/29/08	
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		11-5-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-7-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

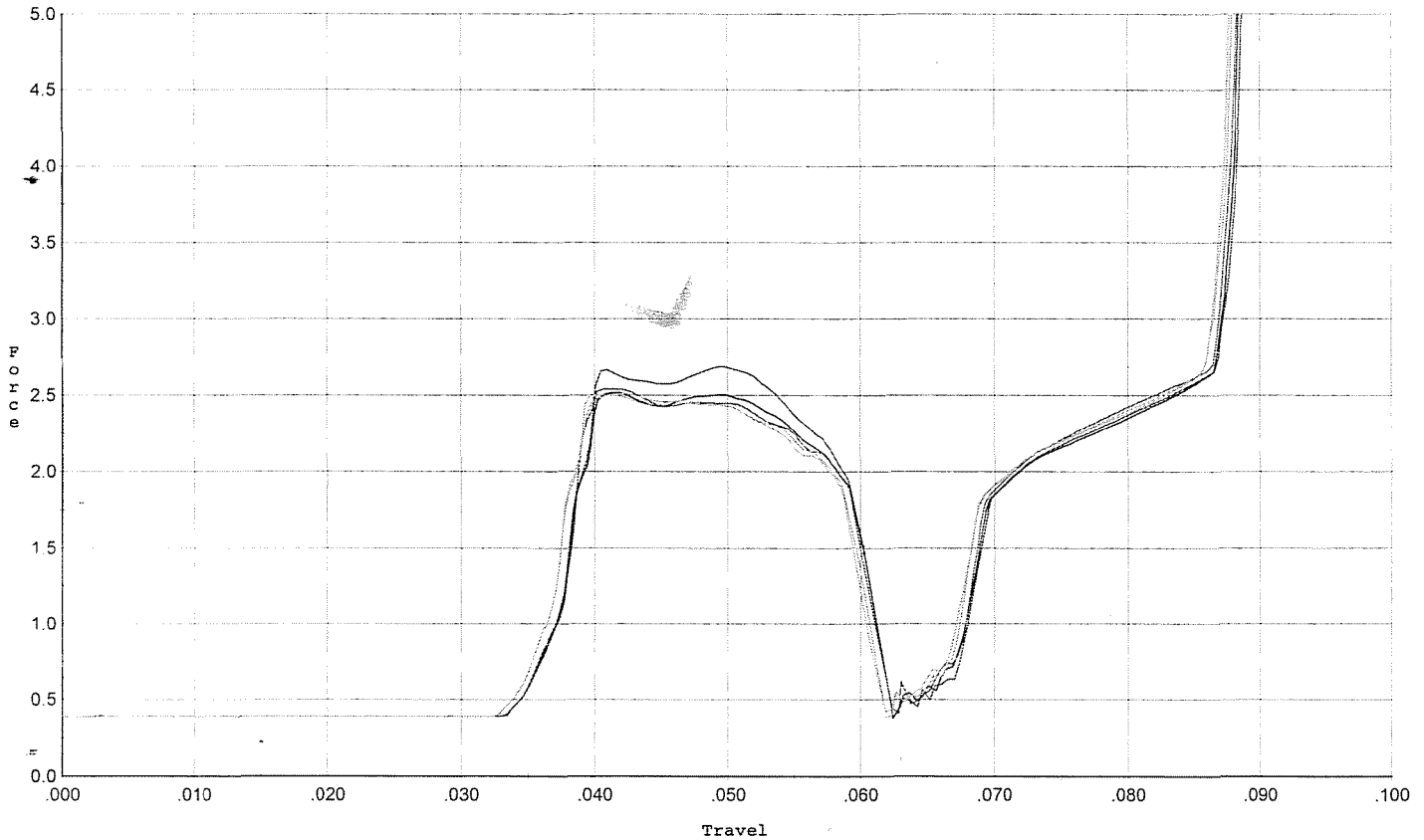
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-13-08	<i>LD</i>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	11-13-08	<i>LD</i>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	<i>LD</i>
	J) ASSEMBLE STOCK		11-7-08	<i>LD</i>
	K) ASSEMBLE SWIVEL STUDS		11-13-08	<i>LD</i>
	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	11-13-08 11-10-08	TC TC
	MALFUNCTION <i>BAC</i>	CORRECTION	11-17-08	TC
	MALFUNCTION <i>OH over live Rd.</i>	CORRECTION	11-13-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-10-08	<i>LD</i>
670	FINAL INSPECTION A) HEADSPACE		11-13-08	<i>LD</i>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.27</u> <u>2.18</u> <u>2.19</u> <u>2.16</u>	11-10-08	TC
	C) FUNCTION		11-13-08	<i>LD</i>
690	PACK		11/17/08	<i>Fm</i>

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



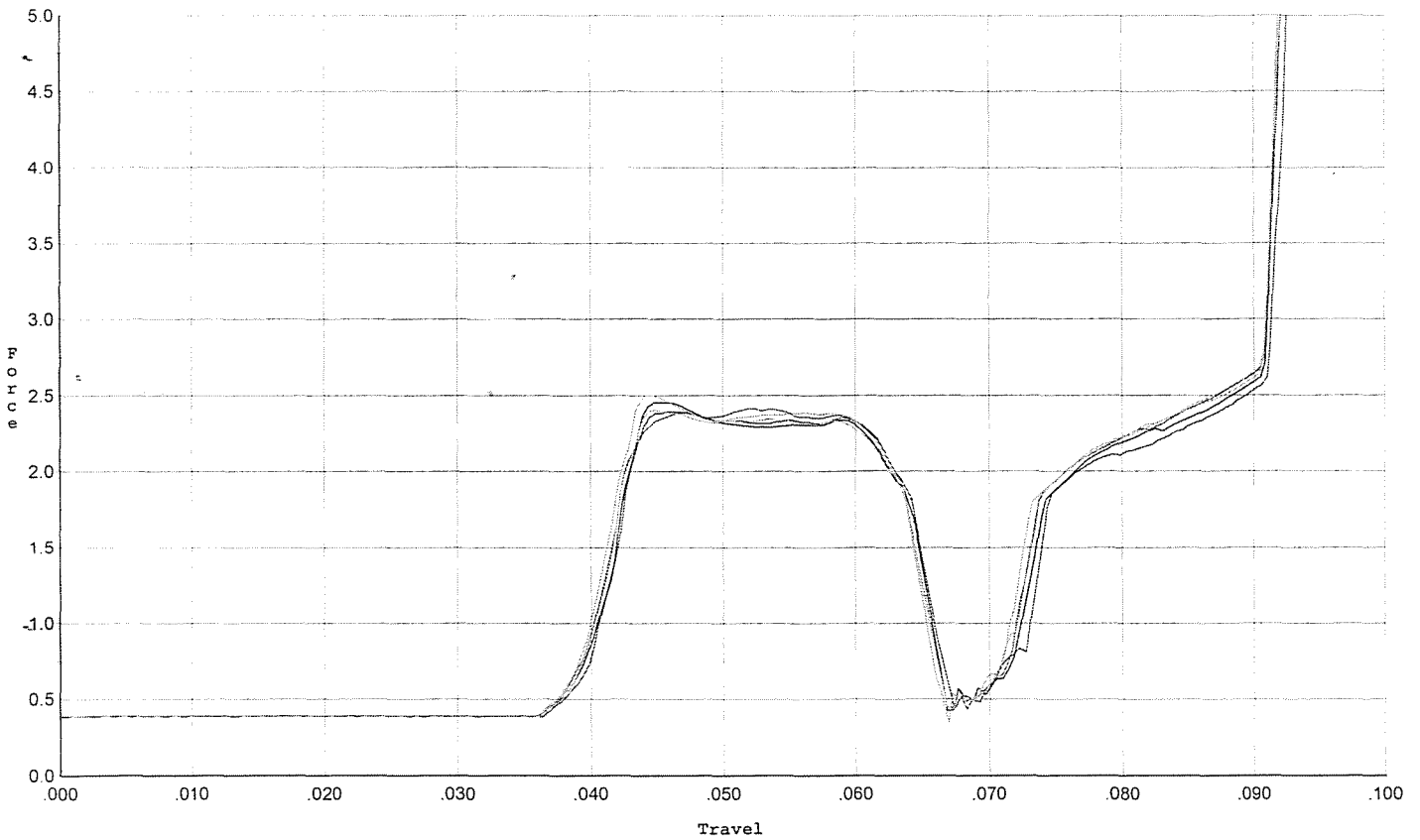
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.689	0.060	0.035	0.035	0.070		Set Trigger
2	2.519	0.060	0.035	0.035	0.067		Set Trigger
3	2.541	0.059	0.035	0.035	0.066		Set Trigger
4	2.506	0.059	0.035	0.035	0.065		Set Trigger
5	2.512	0.060	0.035	0.035	0.067		Set Trigger

A-2-SS

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



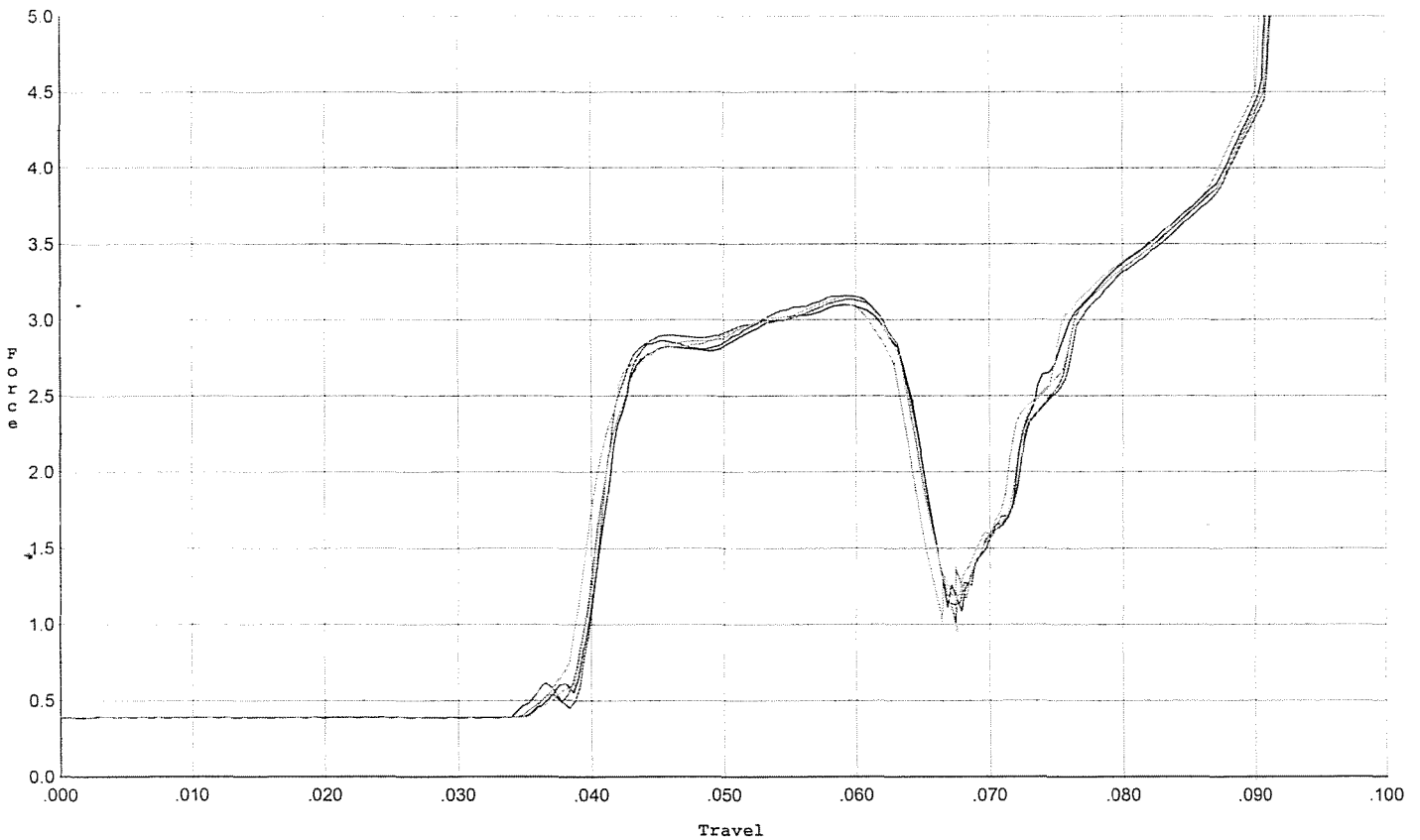
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.395	0.064	0.039	0.035	0.069		Set Trigger
2	2.454	0.064	0.039	0.034	0.069		Set Trigger
3	2.415	0.065	0.039	0.034	0.071		Set Trigger
4	2.404	0.064	0.039	0.034	0.069		Set Trigger
5	2.500	0.064	0.038	0.034	0.069		Set Trigger

172-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



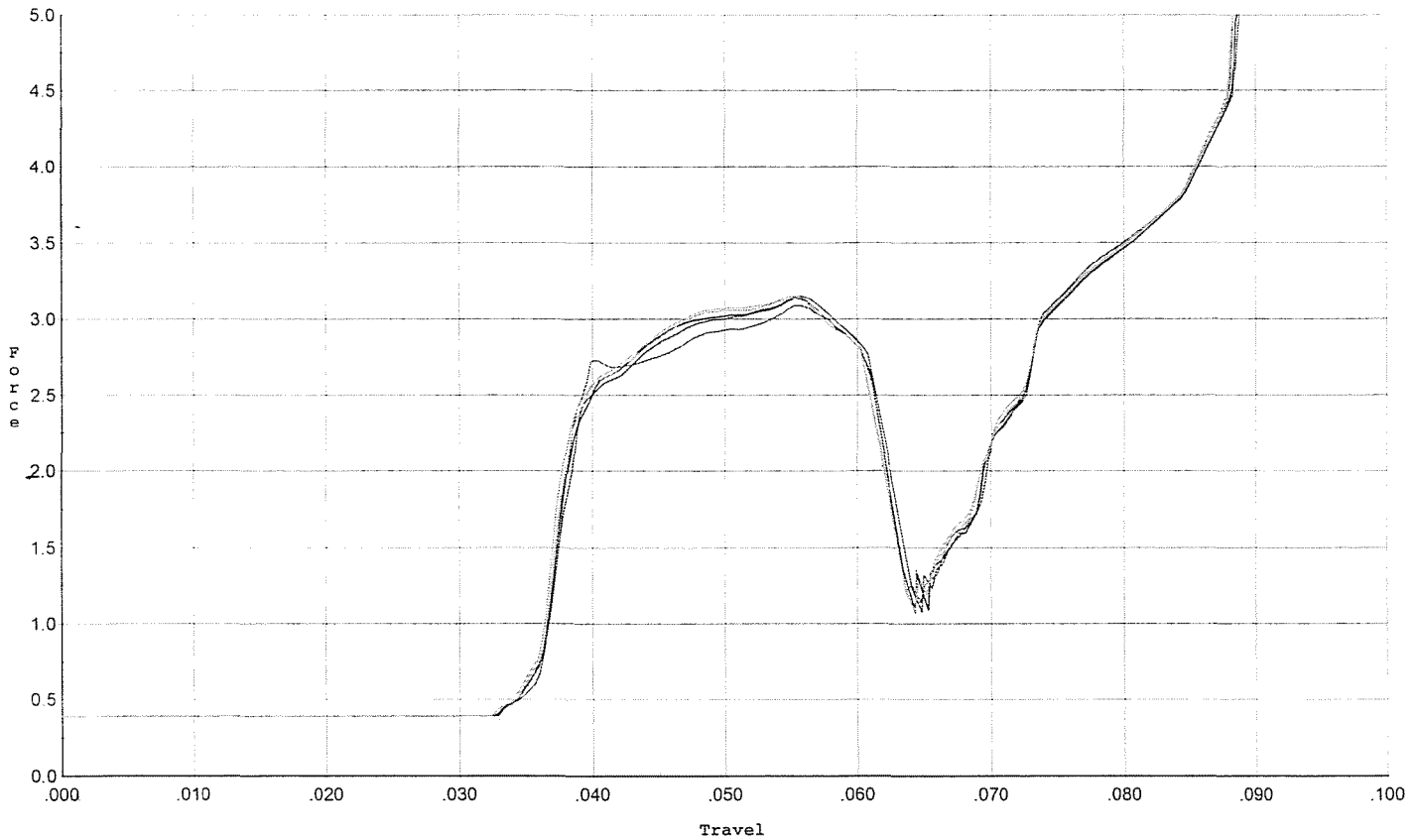
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.162	0.064	0.039	0.032	0.086		Set Trigger
2	3.097	0.064	0.039	0.032	0.085		Set Trigger
3	3.133	0.063	0.039	0.033	0.084		Set Trigger
4	3.159	0.063	0.039	0.032	0.084		Set Trigger
5	3.103	0.063	0.038	0.032	0.084		Set Trigger

A 3-13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



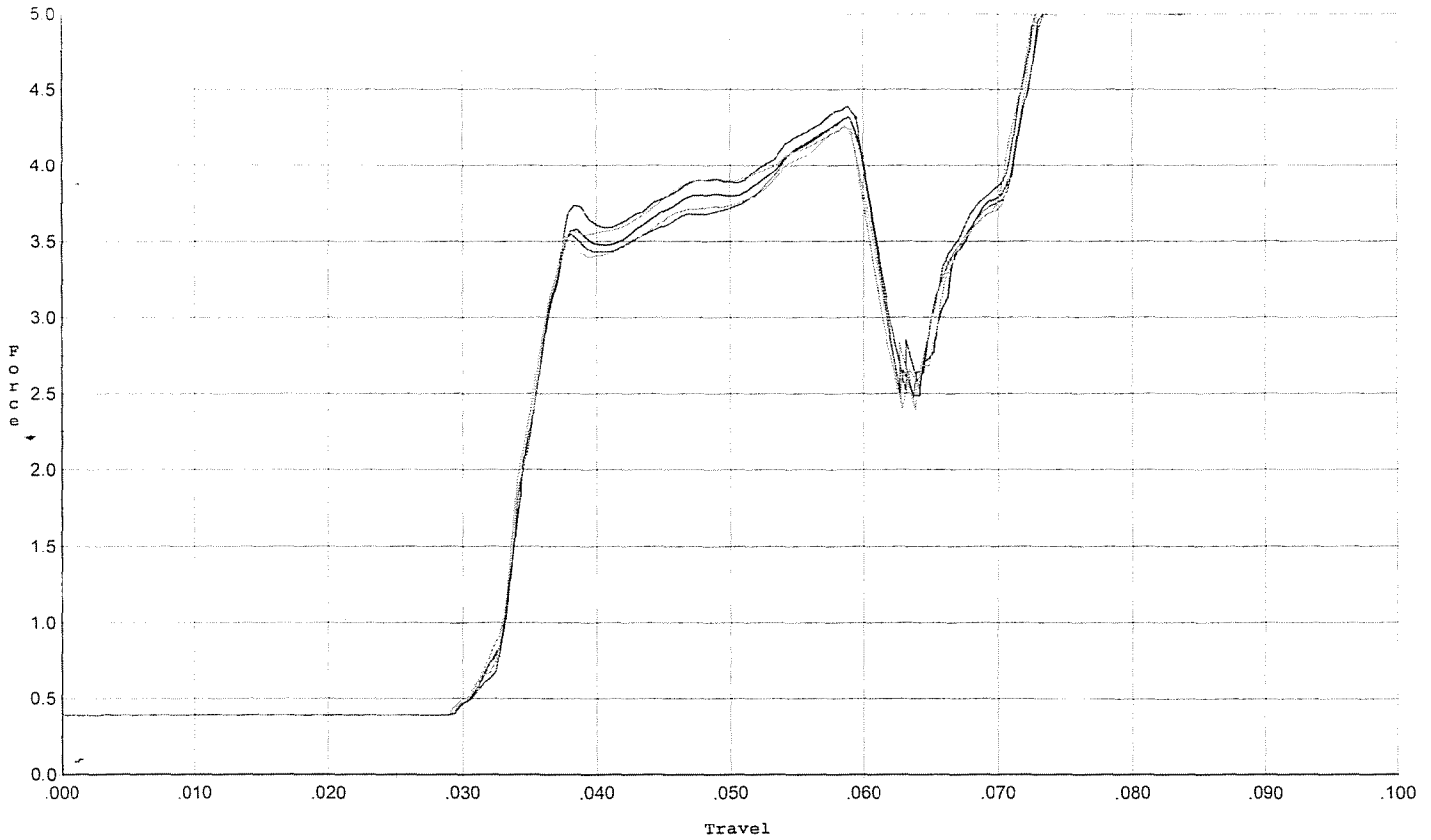
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.152	0.062	0.036	0.032	0.085		Set Trigger
2	3.134	0.061	0.035	0.033	0.084		Set Trigger
3	3.088	0.061	0.035	0.032	0.083		Set Trigger
4	3.152	0.062	0.035	0.032	0.086		Set Trigger
5	3.135	0.062	0.035	0.032	0.085		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



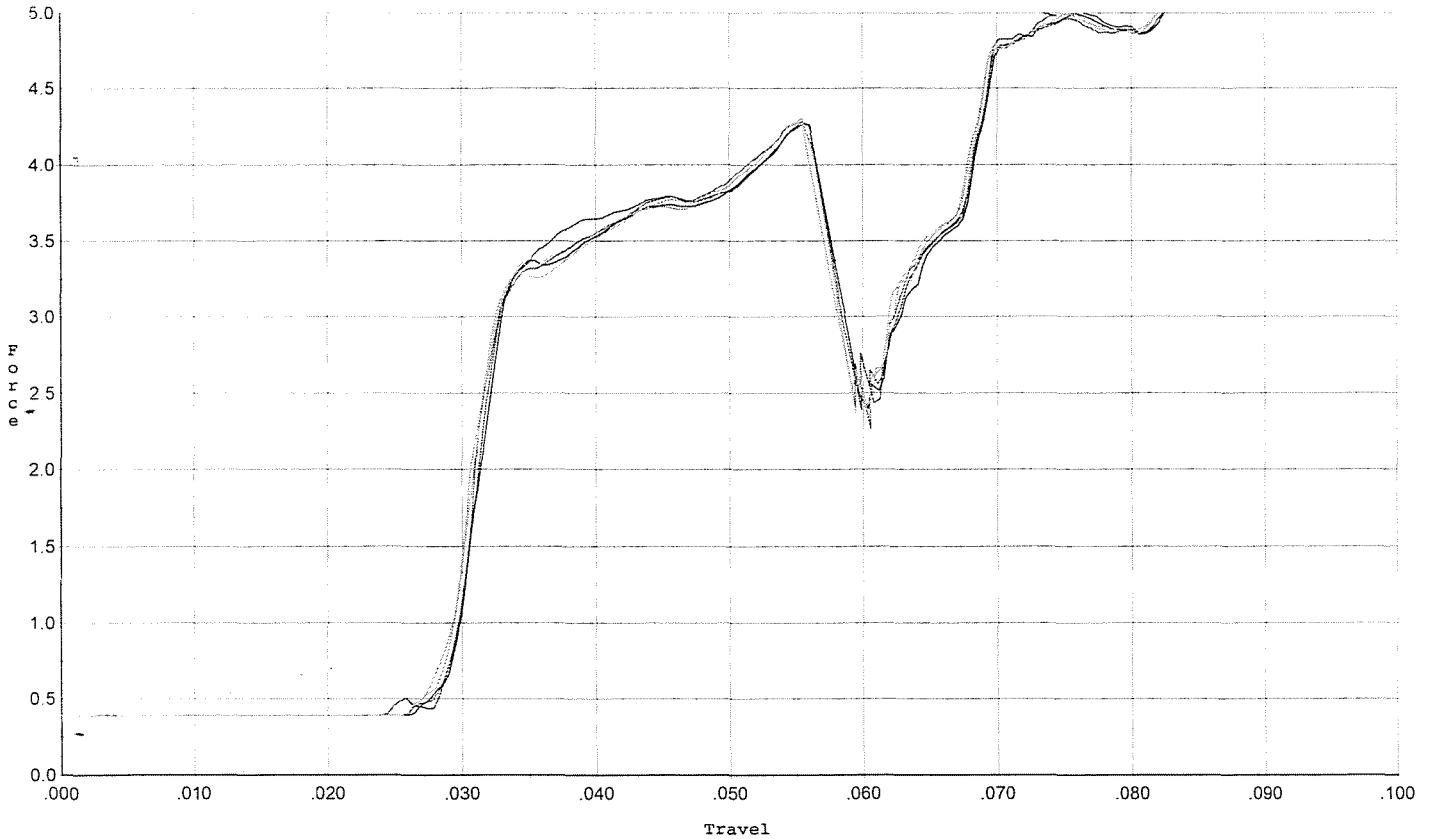
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.393	0.059	0.033	0.028	0.113		Set Trigger
2	4.322	0.060	0.030	0.028	0.112		Set Trigger
3	4.323	0.060	0.031	0.029	0.111		Set Trigger
4	4.253	0.061	0.031	0.028	0.114		Set Trigger
5	4.264	0.059	0.031	0.029	0.109		Set Trigger

A 4-31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



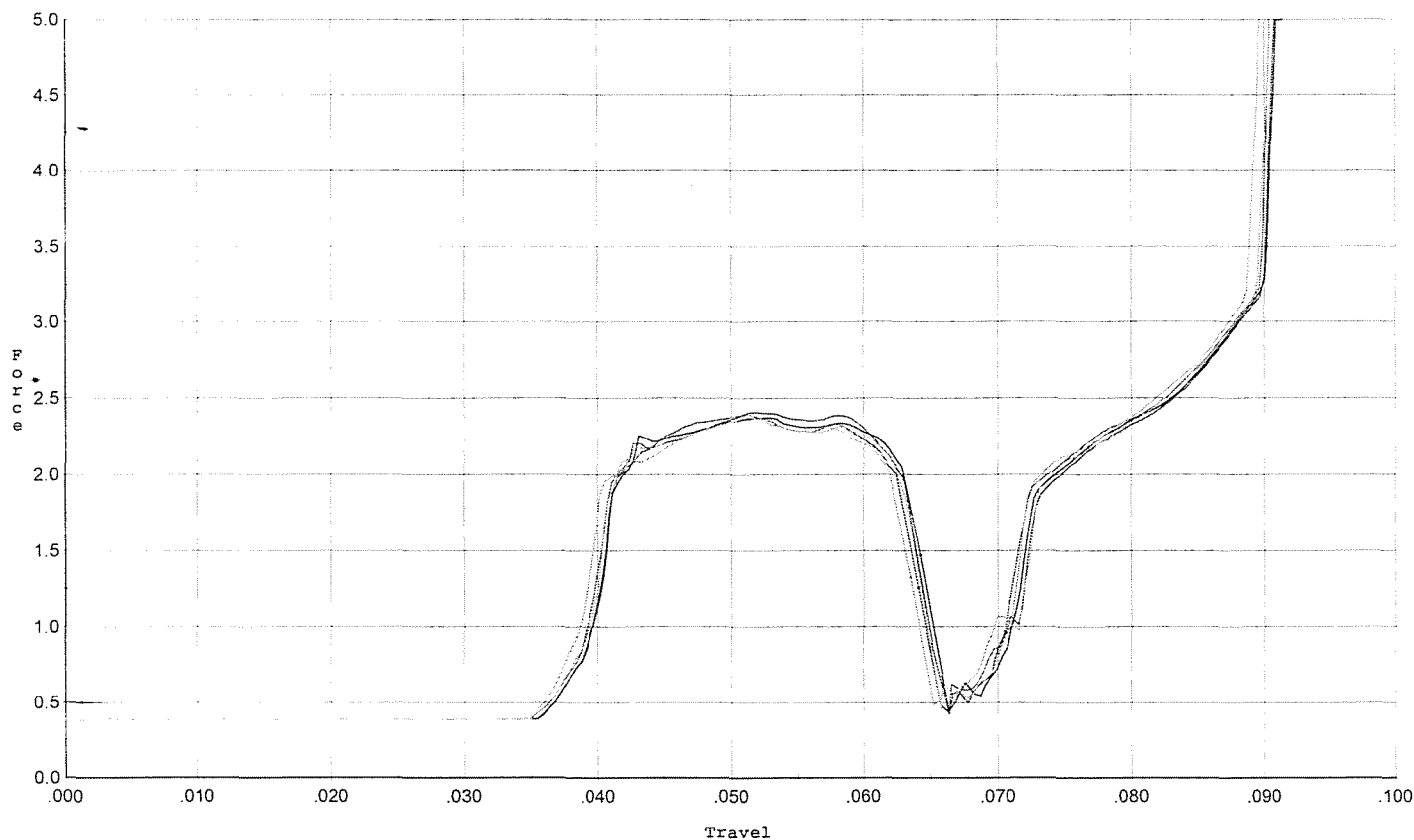
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.286	0.056	0.028	0.029	0.108		Set Trigger
2	4.267	0.058	0.029	0.029	0.111		Set Trigger
3	4.282	0.056	0.028	0.029	0.108		Set Trigger
4	4.304	0.056	0.028	0.028	0.109		Set Trigger
5	4.272	0.056	0.028	0.029	0.106		Set Trigger

A-4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



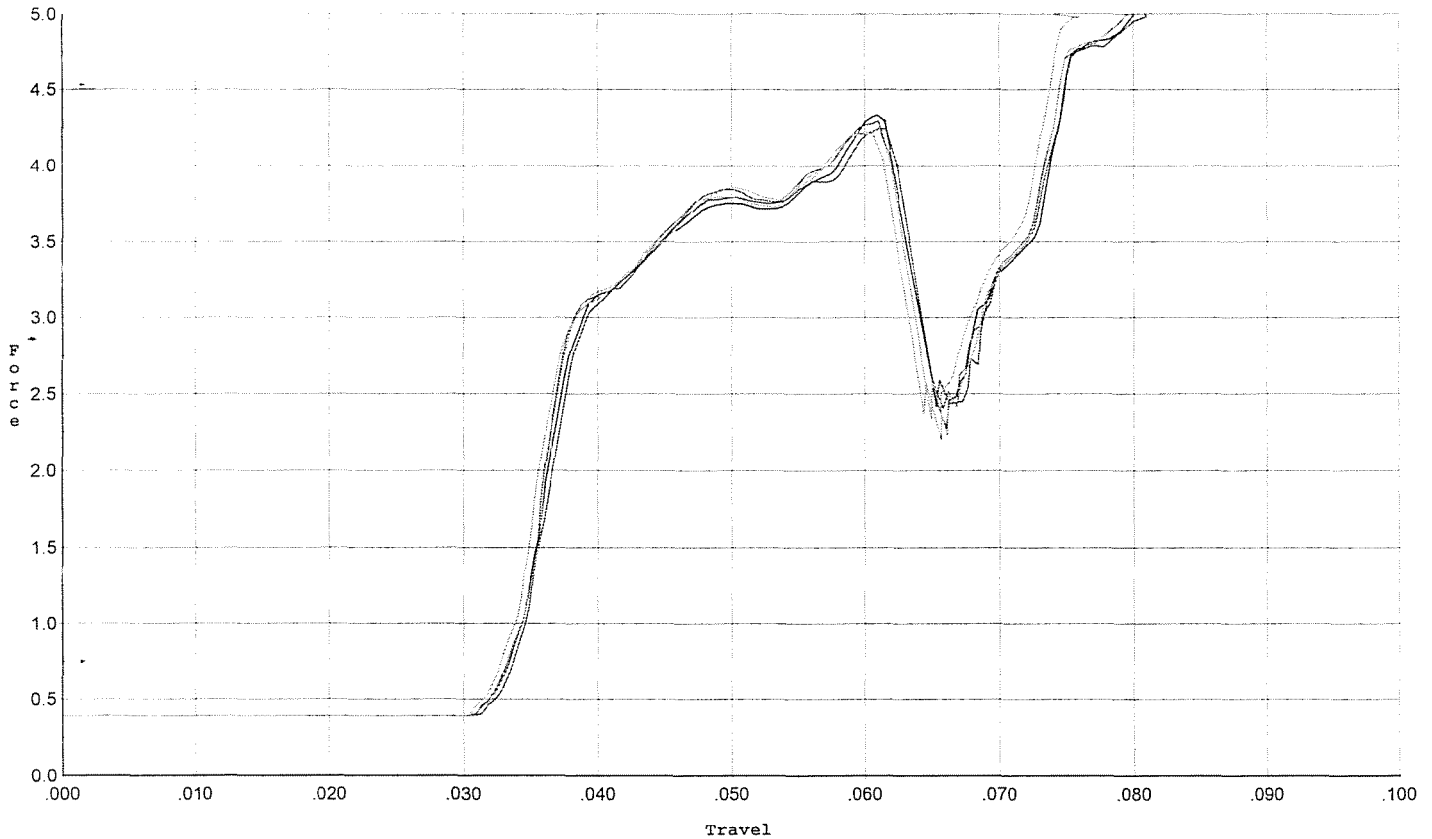
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.405	0.063	0.037	0.034	0.069		Set Trigger
2	2.372	0.064	0.037	0.033	0.070		Set Trigger
3	2.389	0.064	0.037	0.033	0.069		Set Trigger
4	2.373	0.063	0.037	0.033	0.069		Set Trigger
5	2.388	0.063	0.037	0.033	0.069		Set Trigger

A-2-38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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	4.244	0.062	0.033	0.028	0.113		Set Trigger
2	4.333	0.061	0.031	0.029	0.111		Set Trigger
3	4.295	0.062	0.033	0.028	0.113		Set Trigger
4	4.249	0.062	0.033	0.028	0.112		Set Trigger
5	4.217	0.061	0.032	0.029	0.111		Set Trigger

A-426

