

G6801352

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



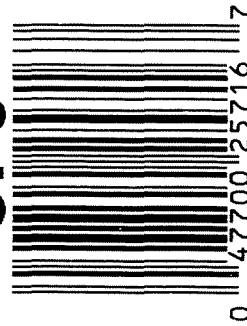
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801352

UPC



GUN SERIAL # G 6801352

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE		2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RIZ
480	MAGNAFLUX BBL ACTION	(N)	3/5/09	(N)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	man
540	APPLY COATINGS (BARREL ACTION)		3/8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-11-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

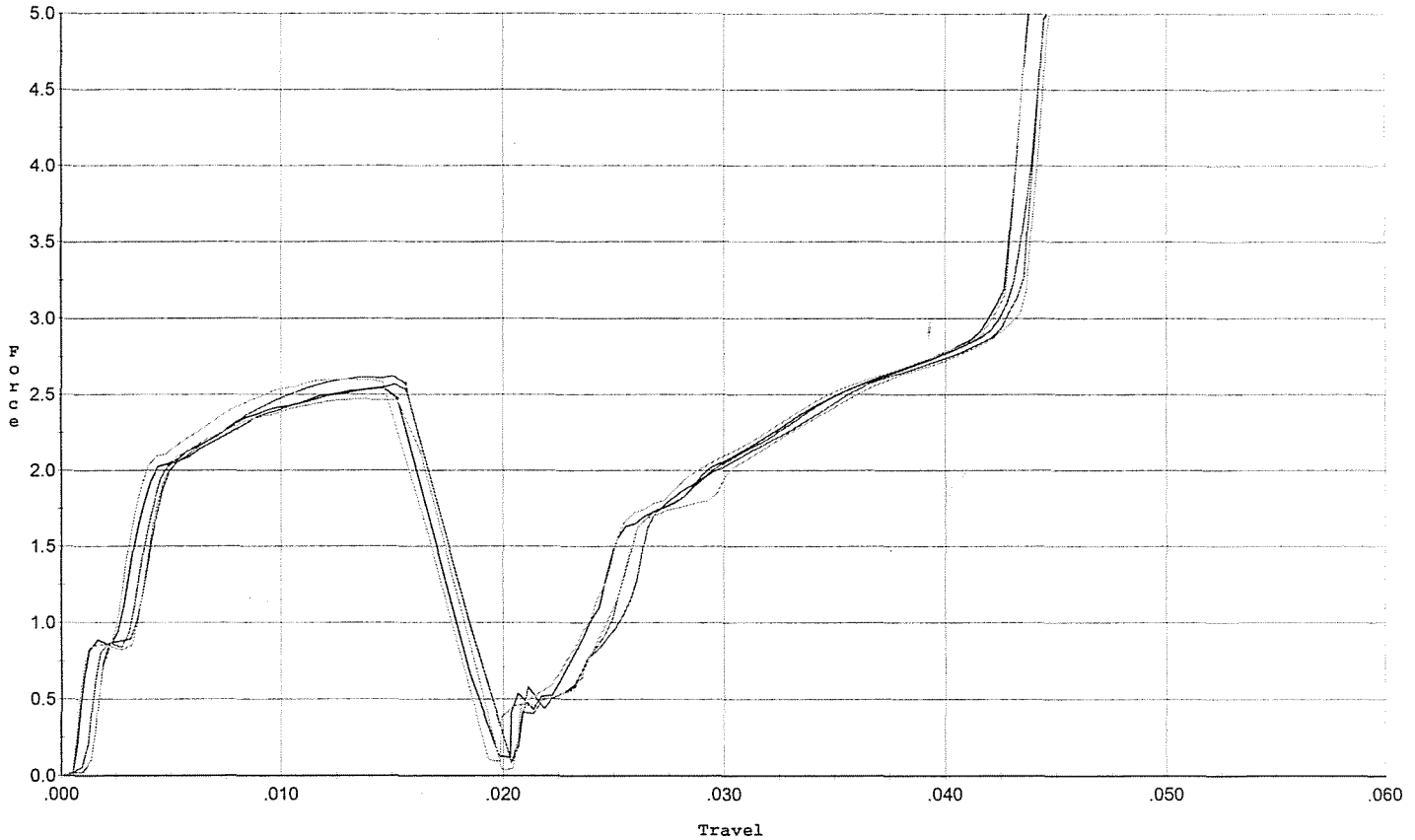
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-18-09	WW
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.5</u> <u>4</u> <u>4</u>	3-18-09	WZ
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.022</u> <u>.021</u>	3-18-09	WW
	J) ASSEMBLE STOCK			3-11-09	WW
	K) ASSEMBLE SWIVEL STUDS			3-19-09	WW
	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	3-16-09	TC
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			3-16-09	WW
670	FINAL INSPECTION A) HEADSPACE			3-18-09	WW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.43</u> <u>2.47</u> <u>2.44</u> <u>2.51</u>	3-18-09	TC
	C) FUNCTION			3-18-09	WW
690	PACK			3-19-09	FW

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



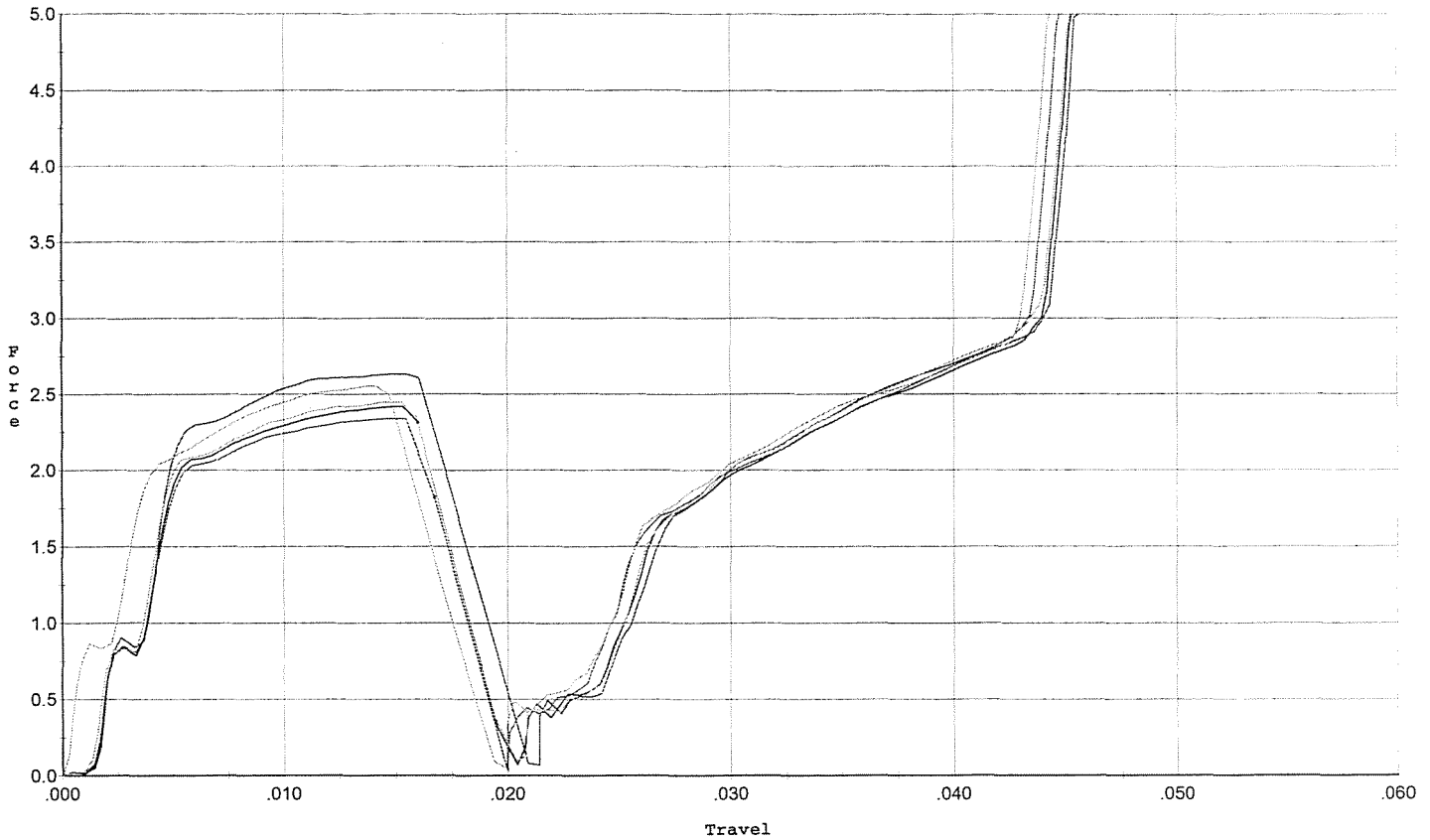
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.016	0.00	0.032	0.028		Set Trigger
2	2.544	0.015	0.00	0.031	0.028		Set Trigger
3	2.622	0.016	0.00	0.032	0.029		Set Trigger
4	2.601	0.017	0.00	0.031	0.031		Set Trigger
5	2.470	0.016	0.00	0.032	0.029		Set Trigger

A.2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



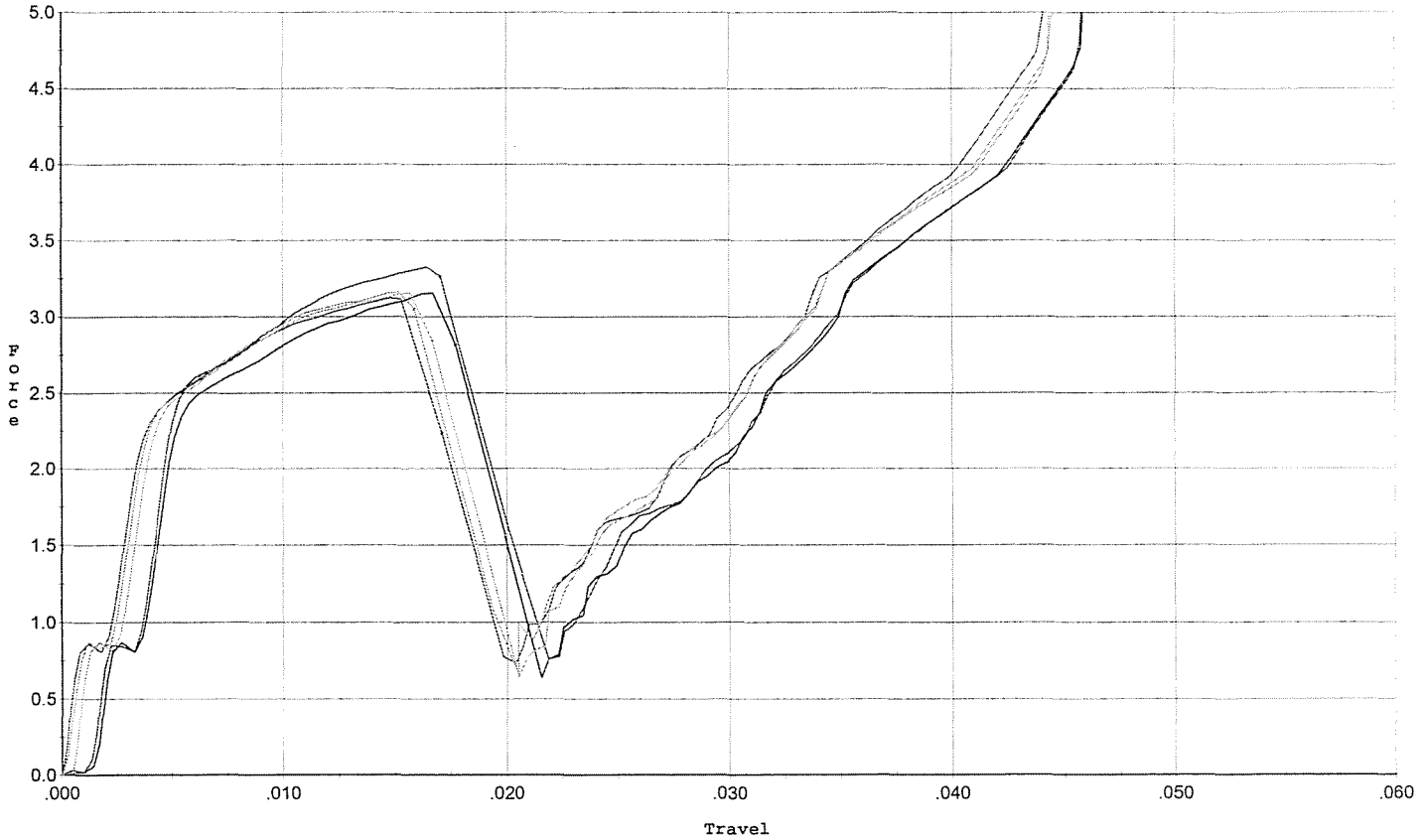
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.634	0.018	0.00	0.032	0.034		Set Trigger
2	2.417	0.016	0.00	0.032	0.027		Set Trigger
3	2.339	0.017	0.00	0.032	0.028		Set Trigger
4	2.448	0.016	0.00	0.032	0.028		Set Trigger
5	2.554	0.015	0.00	0.032	0.028		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



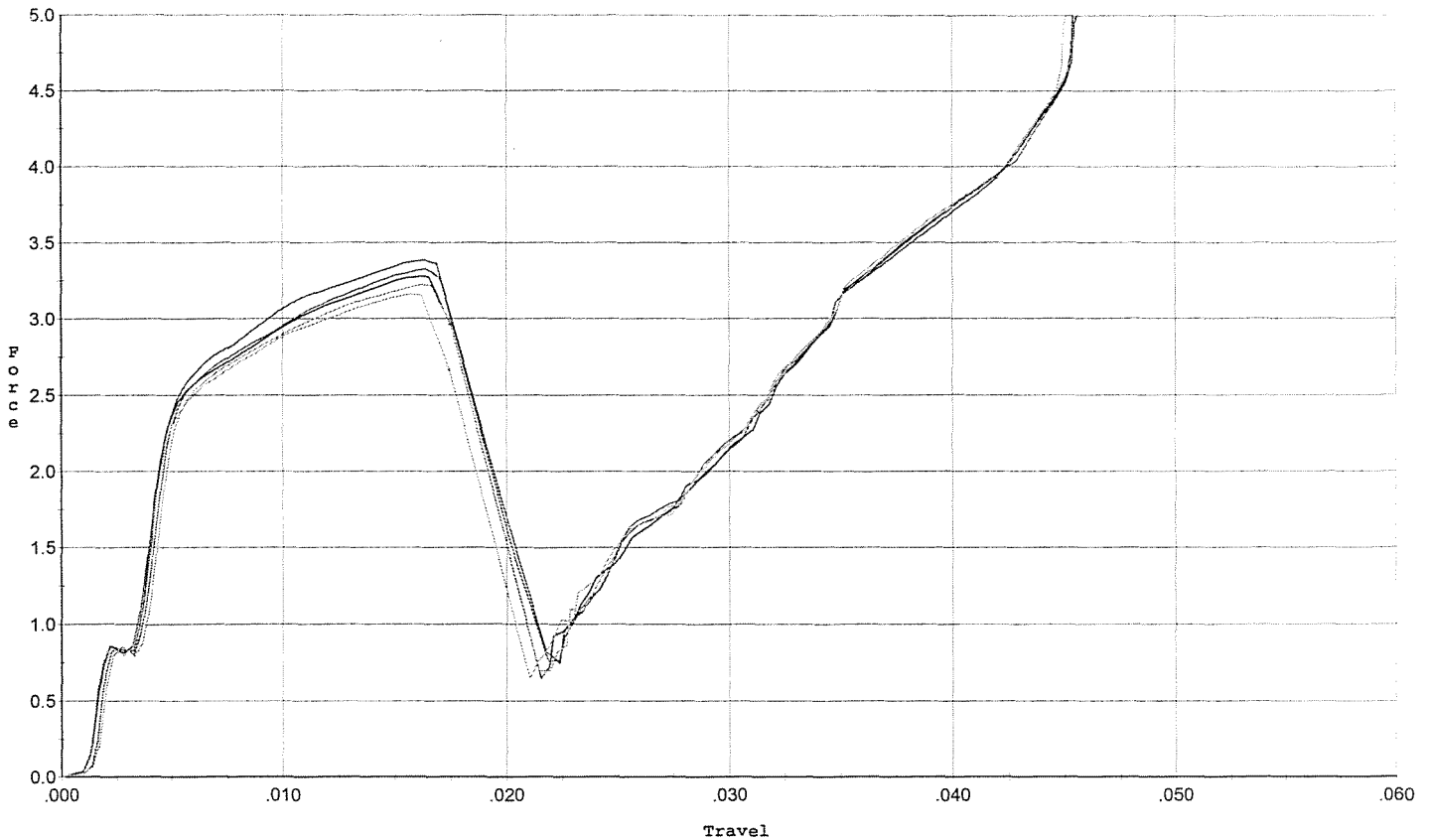
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.017	0.004	0.030	0.038		Set Trigger
2	3.156	0.018	0.00	0.030	0.037		Set Trigger
3	3.123	0.017	0.00	0.030	0.038		Set Trigger
4	3.157	0.017	0.00	0.030	0.037		Set Trigger
5	3.162	0.016	0.00	0.030	0.036		Set Trigger

A-3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



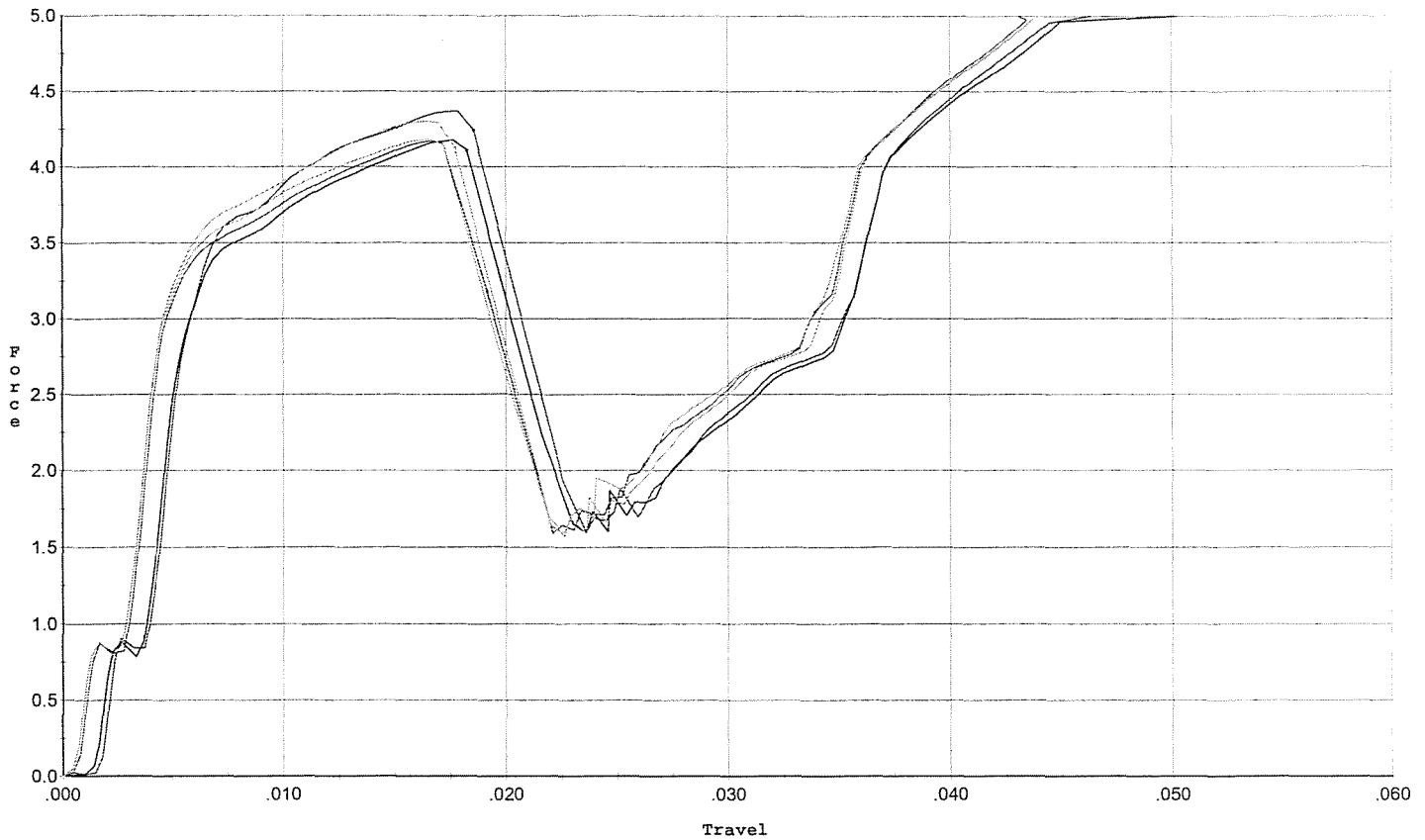
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.383	0.017	0.004	0.030	0.038		Set Trigger
2	3.276	0.017	0.00	0.030	0.039		Set Trigger
3	3.326	0.017	0.00	0.030	0.038		Set Trigger
4	3.161	0.017	0.00	0.030	0.037		Set Trigger
5	3.220	0.017	0.00	0.030	0.038		Set Trigger

A.3.27

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



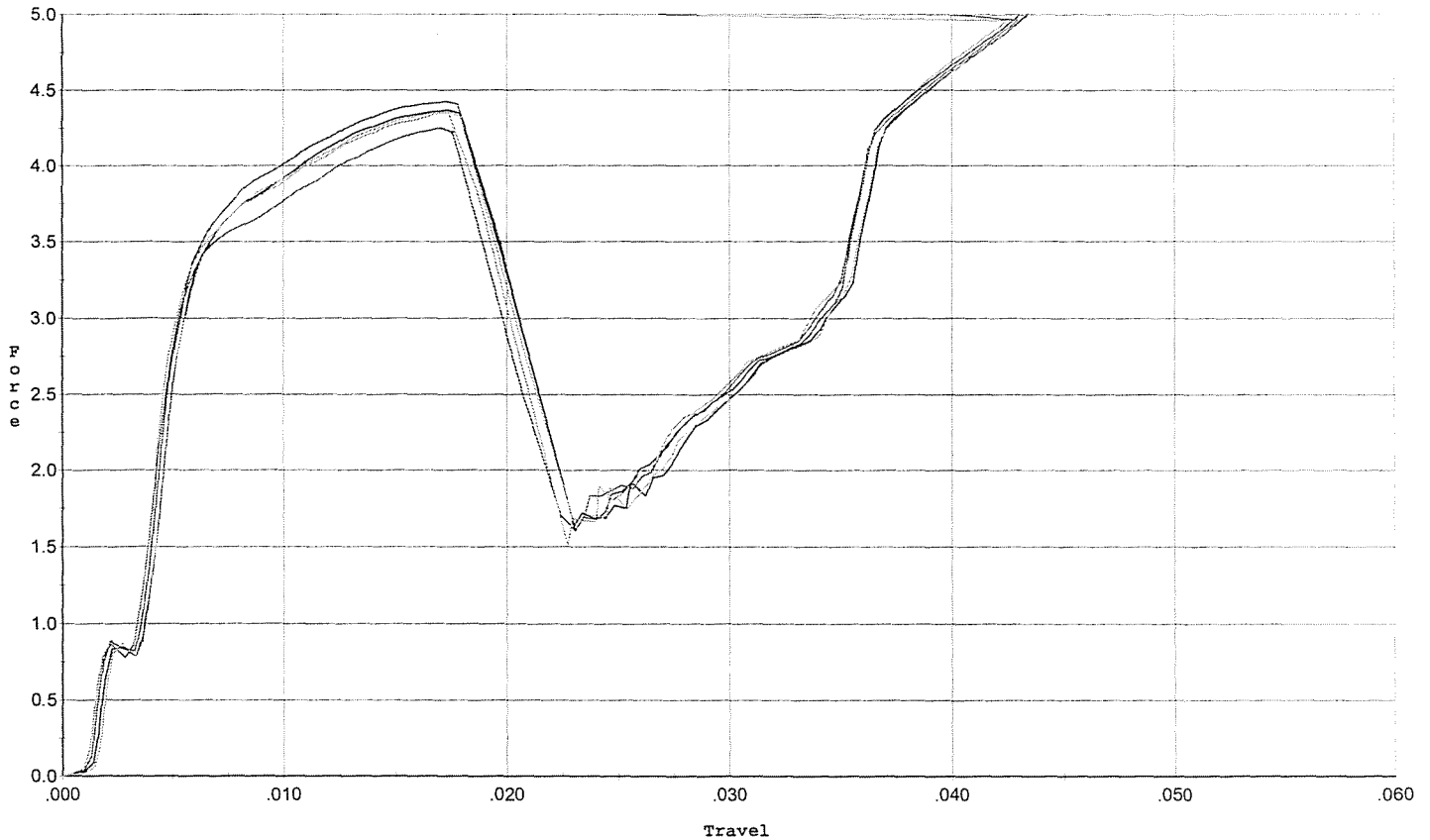
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.369	0.019	0.004	0.028	0.053		Set Trigger
2	4.176	0.018	0.00	0.029	0.050		Set Trigger
3	4.172	0.019	0.00	0.028	0.055		Set Trigger
4	4.181	0.017	0.00	0.028	0.049		Set Trigger
5	4.301	0.018	0.00	0.028	0.052		Set Trigger

A.4.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



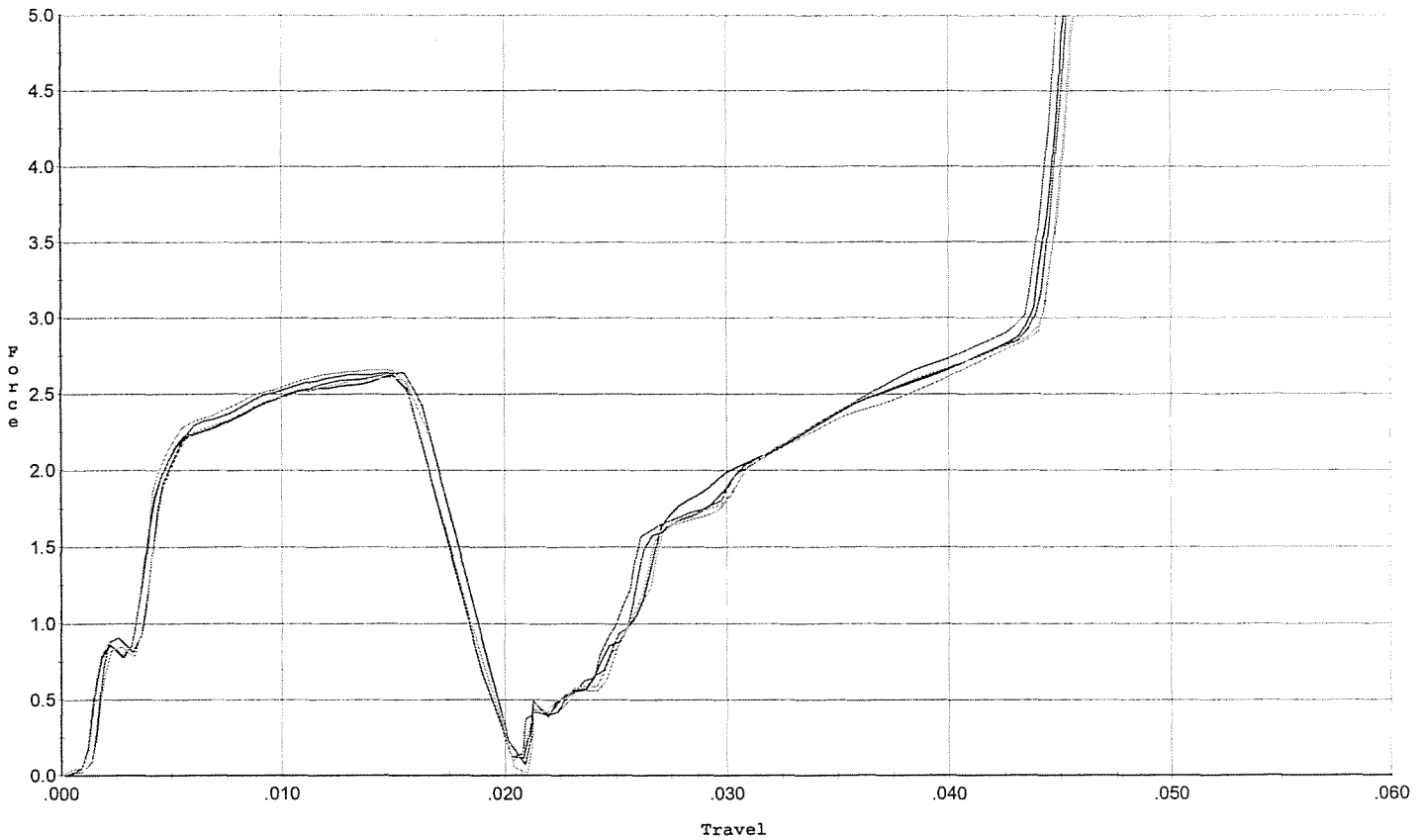
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.427	0.020	0.004	0.027	0.058		Set Trigger
2	4.372	0.020	0.00	0.028	0.057		Set Trigger
3	4.252	0.018	0.00	0.028	0.049		Set Trigger
4	4.361	0.018	0.00	0.028	0.051		Set Trigger
5	4.350	0.019	0.00	0.028	0.054		Set Trigger

A. 4.35

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



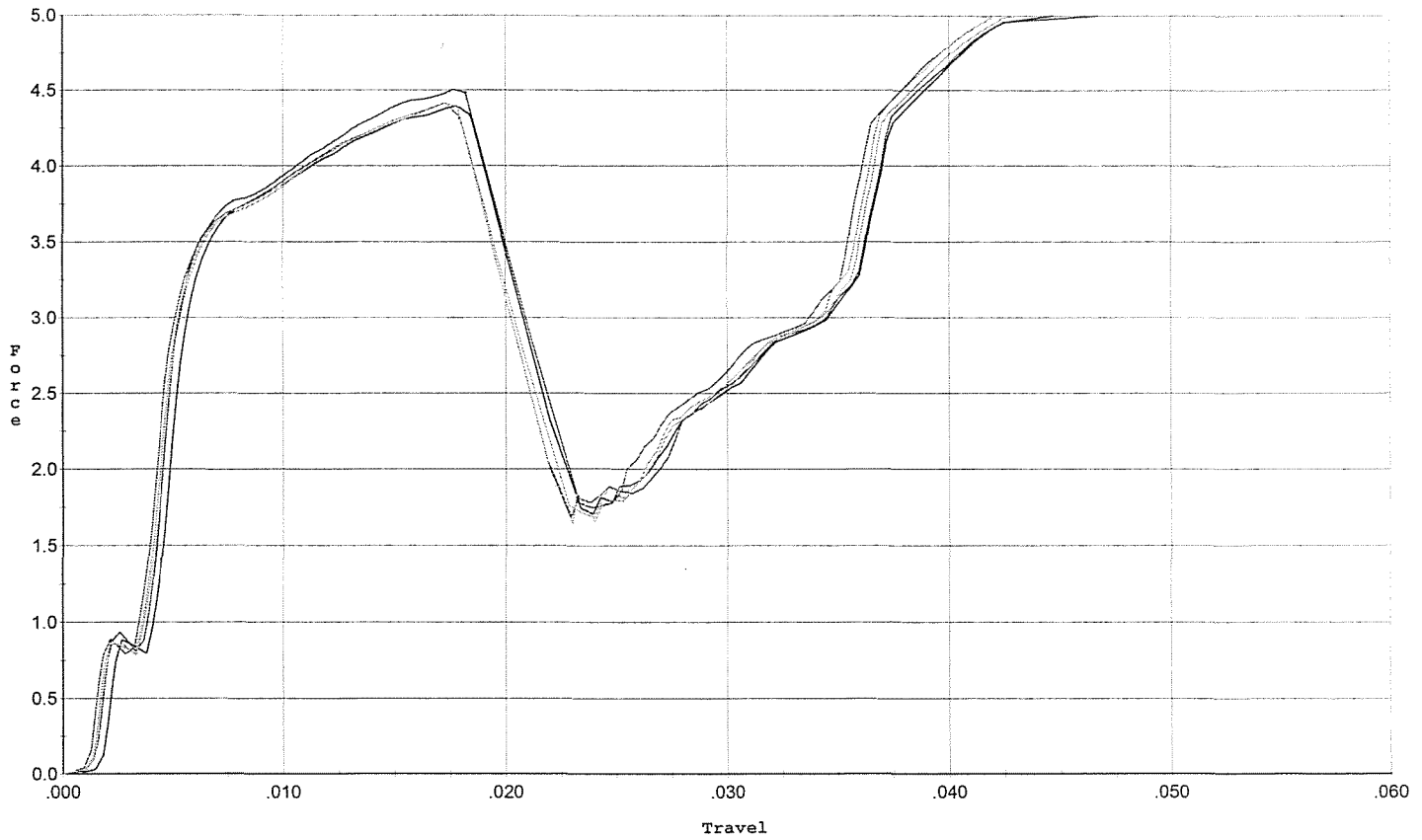
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.639	0.016	0.00	0.032	0.030		Set Trigger
2	2.618	0.016	0.00	0.032	0.029		Set Trigger
3	2.626	0.016	0.00	0.032	0.029		Set Trigger
4	2.604	0.017	0.00	0.032	0.030		Set Trigger
5	2.659	0.016	0.00	0.033	0.029		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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	4.505	0.018	0.00	0.028	0.053		Set Trigger
2	4.396	0.018	0.004	0.028	0.052		Set Trigger
3	4.415	0.018	0.00	0.027	0.052		Set Trigger
4	4.414	0.018	0.004	0.028	0.052		Set Trigger
5	4.414	0.018	0.004	0.028	0.051		Set Trigger

A-4.42