

G 6801354

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



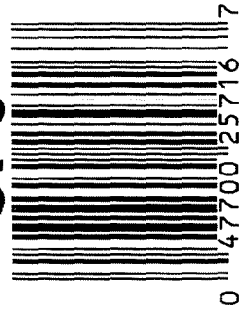
ORDER NO. **25716**

BARREL LENGTH **24"**

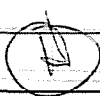
CAPACITY **6**

G6801354

UPC



GUN SERIAL # G 680 1354

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RP
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/25/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TC
	D) OIL FIRING PIN ASSEMBLY		4-2-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

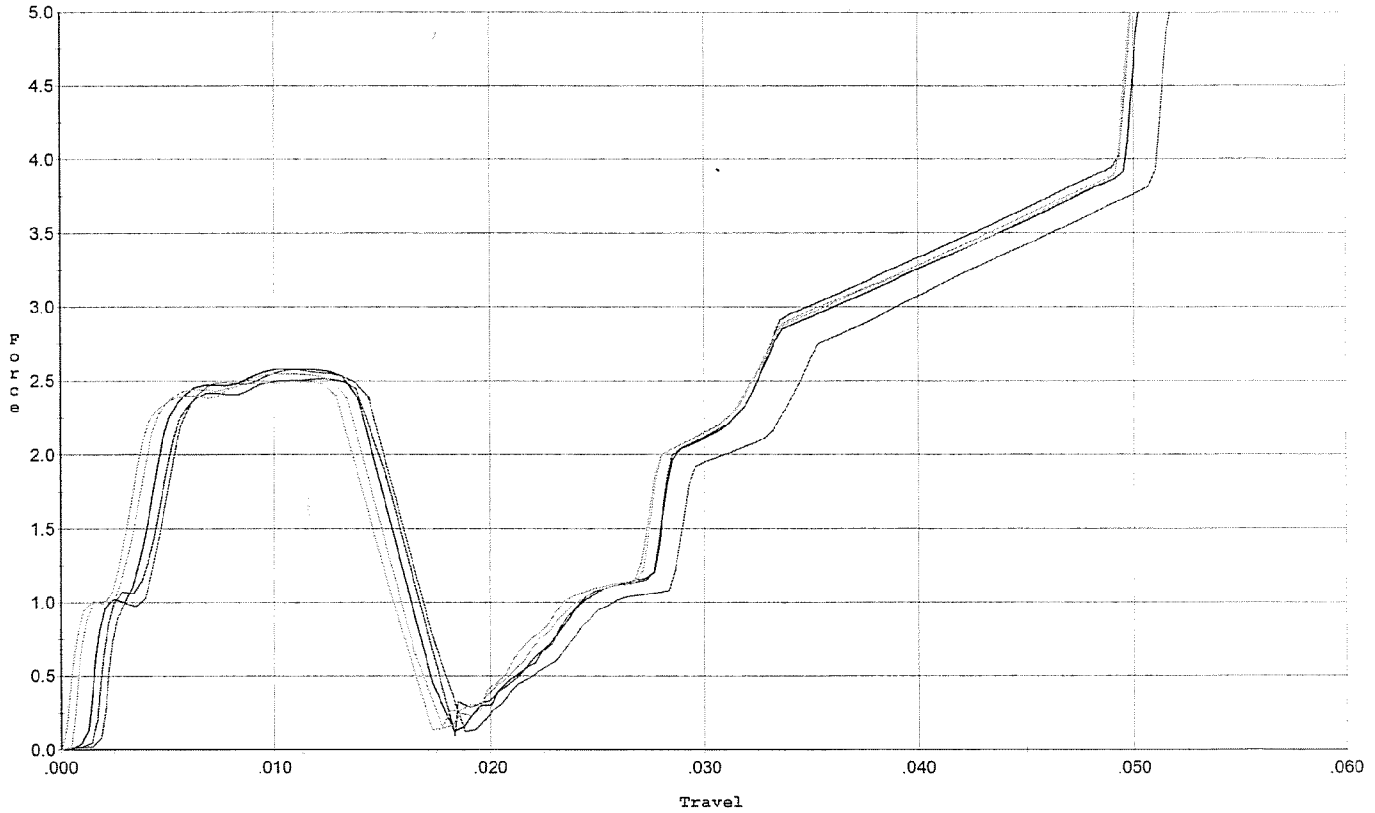
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>4.5</u>	4-13-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4</u> <u>3.5</u>	4-13-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	4-13-09	WW
	J) ASSEMBLE STOCK		4-20-09	RPD
	K) ASSEMBLE SWIVEL STUDS		4-13-09	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	PASS FAIL PASS FAIL	4-4-09	RPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-4-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-13-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.25</u> <u>2.22</u> <u>2.36</u> <u>2.29</u>	4-7-09	RP
	C) FUNCTION		4-13-09	WW
690	PACK		4-4-09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



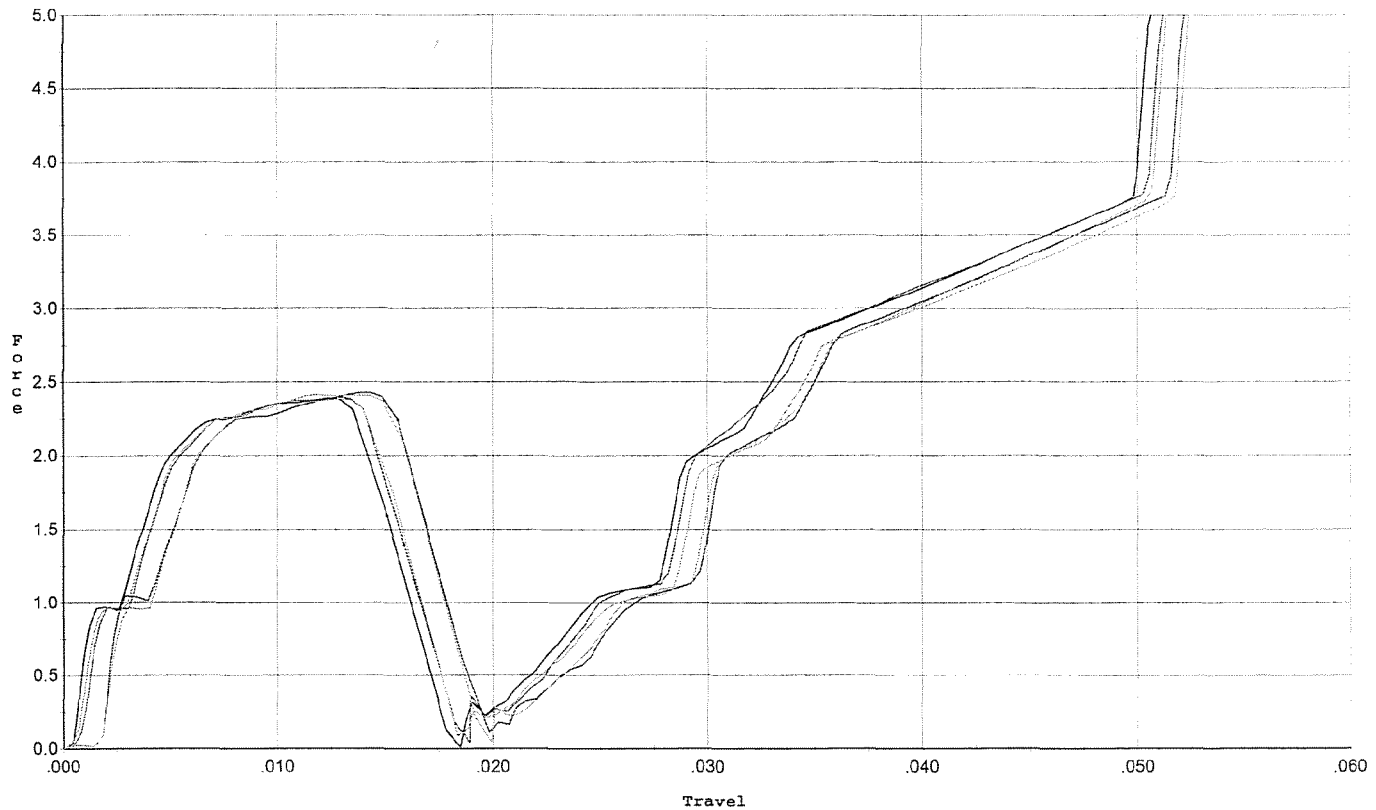
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.015	0.00	0.037	0.026		Set Trigger
2	2.580	0.014	0.00	0.038	0.025		Set Trigger
3	2.573	0.014	0.002	0.039	0.025		Set Trigger
4	2.494	0.013	0.00	0.039	0.024		Set Trigger
5	2.545	0.013	0.00	0.038	0.025		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



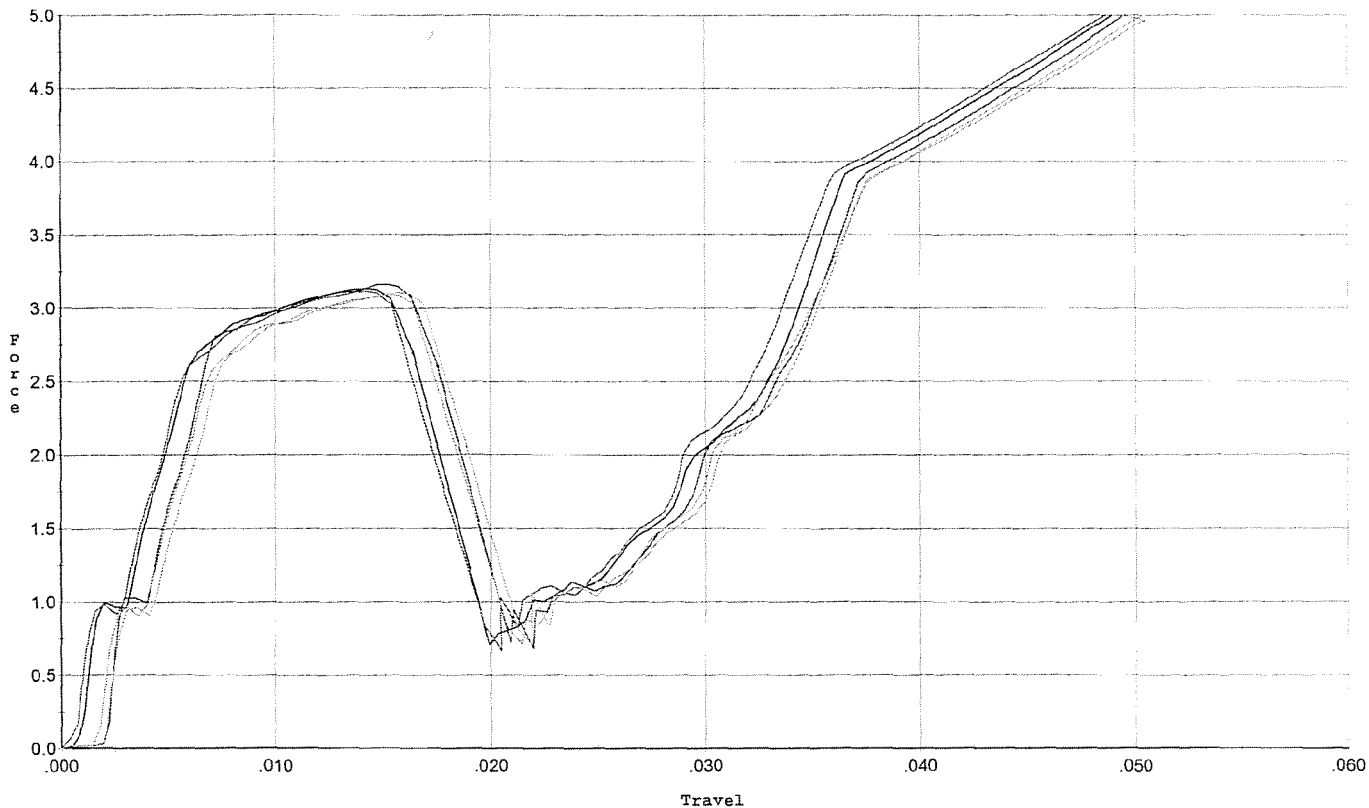
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.427	0.016	0.002	0.039	0.026		Set Trigger
2	2.389	0.015	0.00	0.038	0.026		Set Trigger
3	2.396	0.016	0.003	0.038	0.027		Set Trigger
4	2.412	0.016	0.002	0.039	0.026		Set Trigger
5	2.385	0.015	0.00	0.039	0.026		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



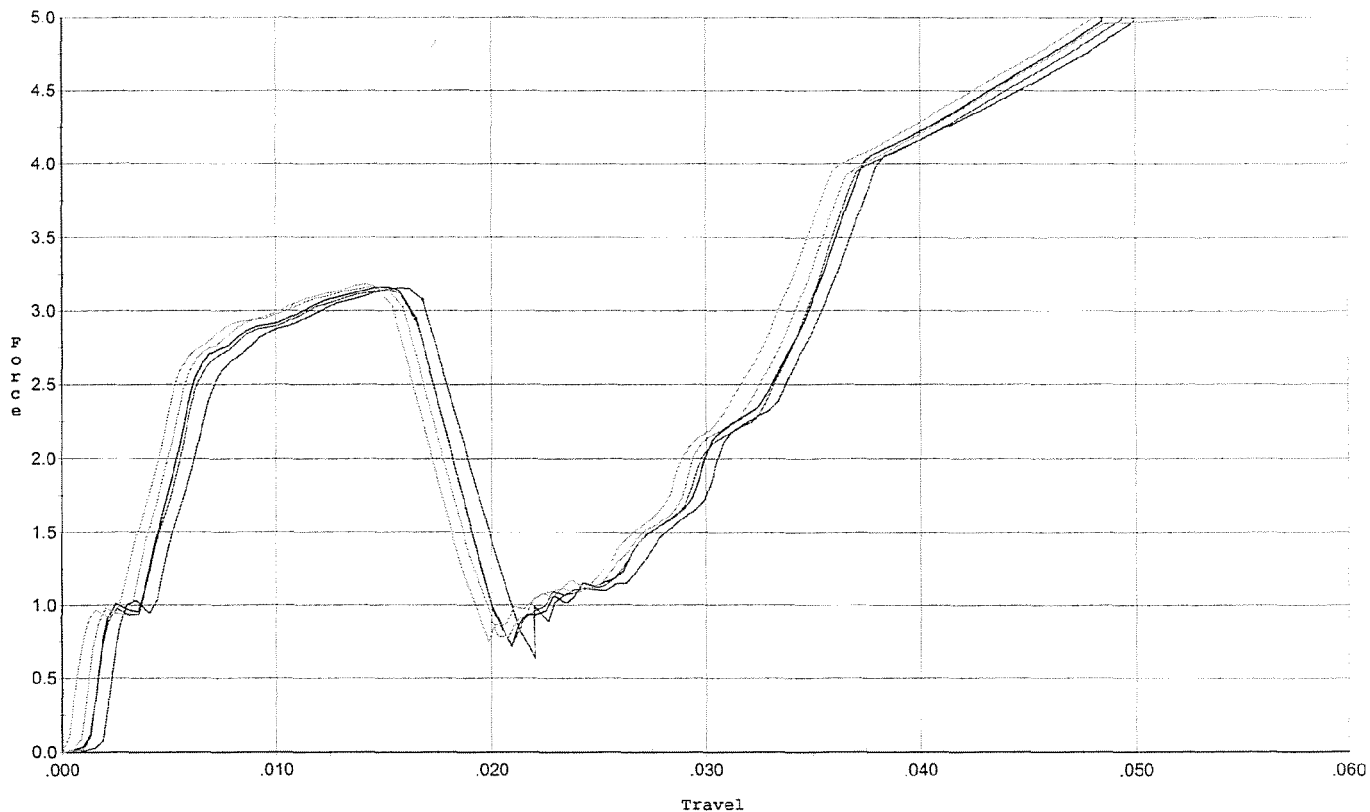
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.159	0.018	0.002	0.035	0.036		Set Trigger
2	3.132	0.016	0.003	0.035	0.035		Set Trigger
3	3.115	0.015	0.00	0.035	0.033		Set Trigger
4	3.104	0.019	0.002	0.036	0.038		Set Trigger
5	3.087	0.018	0.002	0.036	0.037		Set Trigger

A.3.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



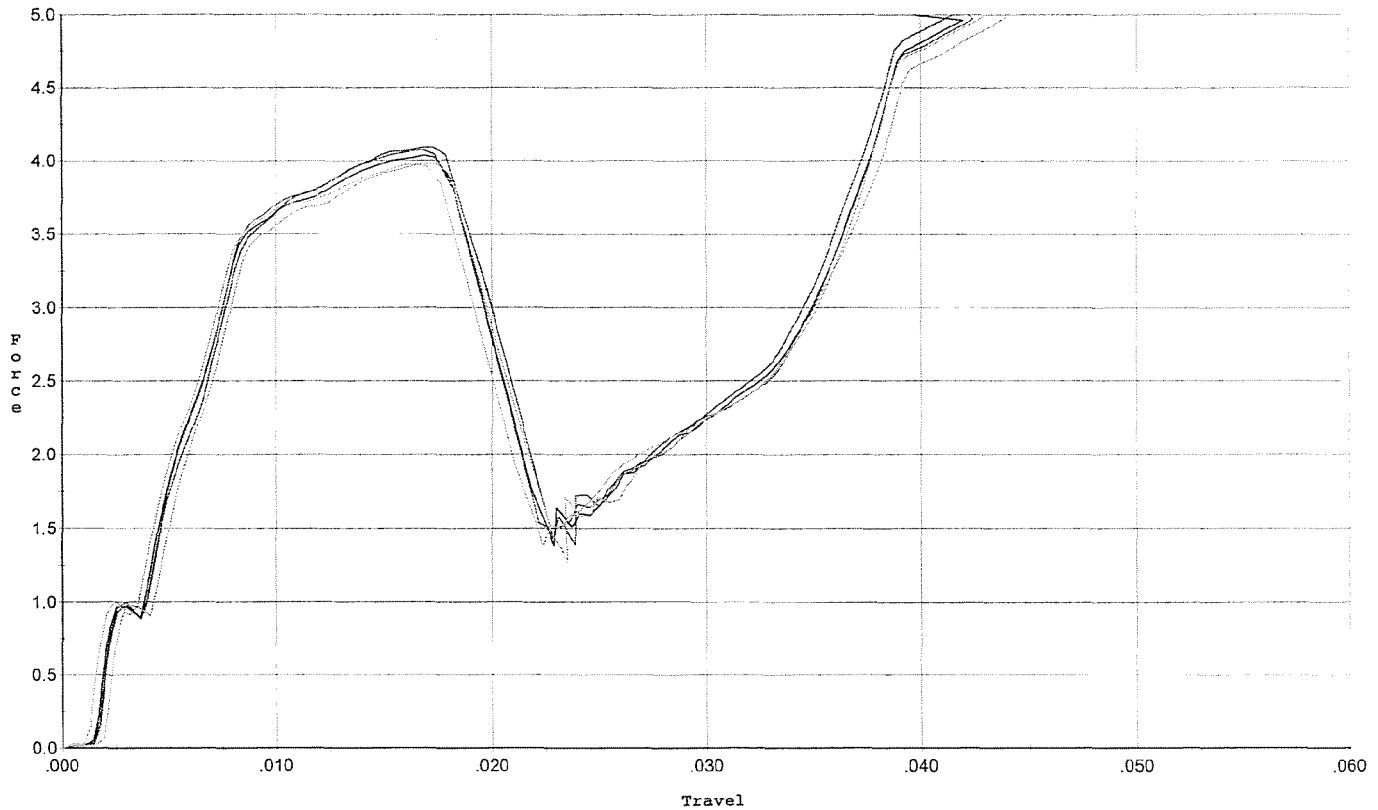
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.155	0.017	0.00	0.036	0.034		Set Trigger
2	3.164	0.017	0.004	0.036	0.035		Set Trigger
3	3.145	0.017	0.004	0.035	0.035		Set Trigger
4	3.182	0.015	0.00	0.035	0.034		Set Trigger
5	3.164	0.016	0.003	0.035	0.034		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



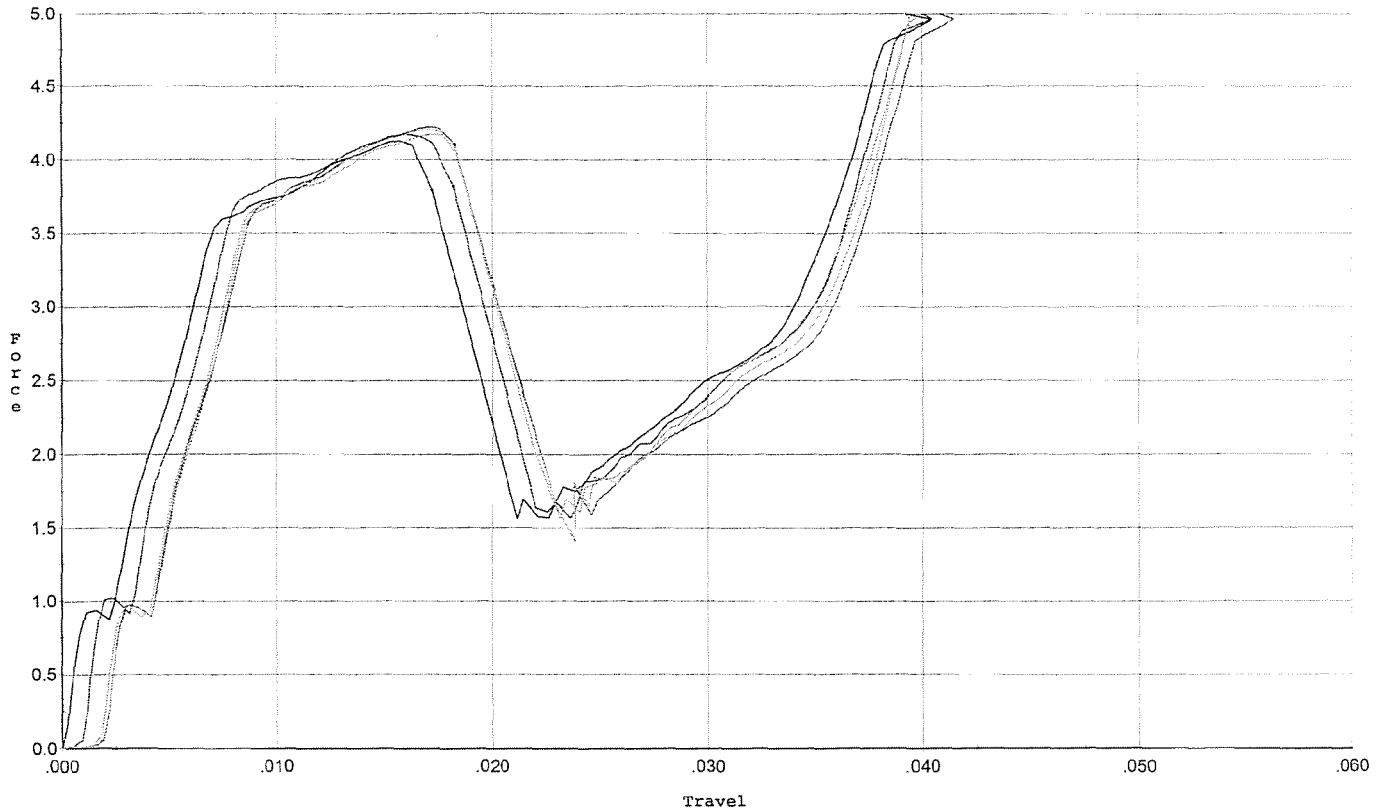
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.020	0.00	0.034	0.051		Set Trigger
2	4.036	0.018	0.004	0.034	0.047		Set Trigger
3	4.073	0.018	0.00	0.034	0.047		Set Trigger
4	3.975	0.018	0.00	0.035	0.046		Set Trigger
5	3.981	0.018	0.002	0.035	0.045		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



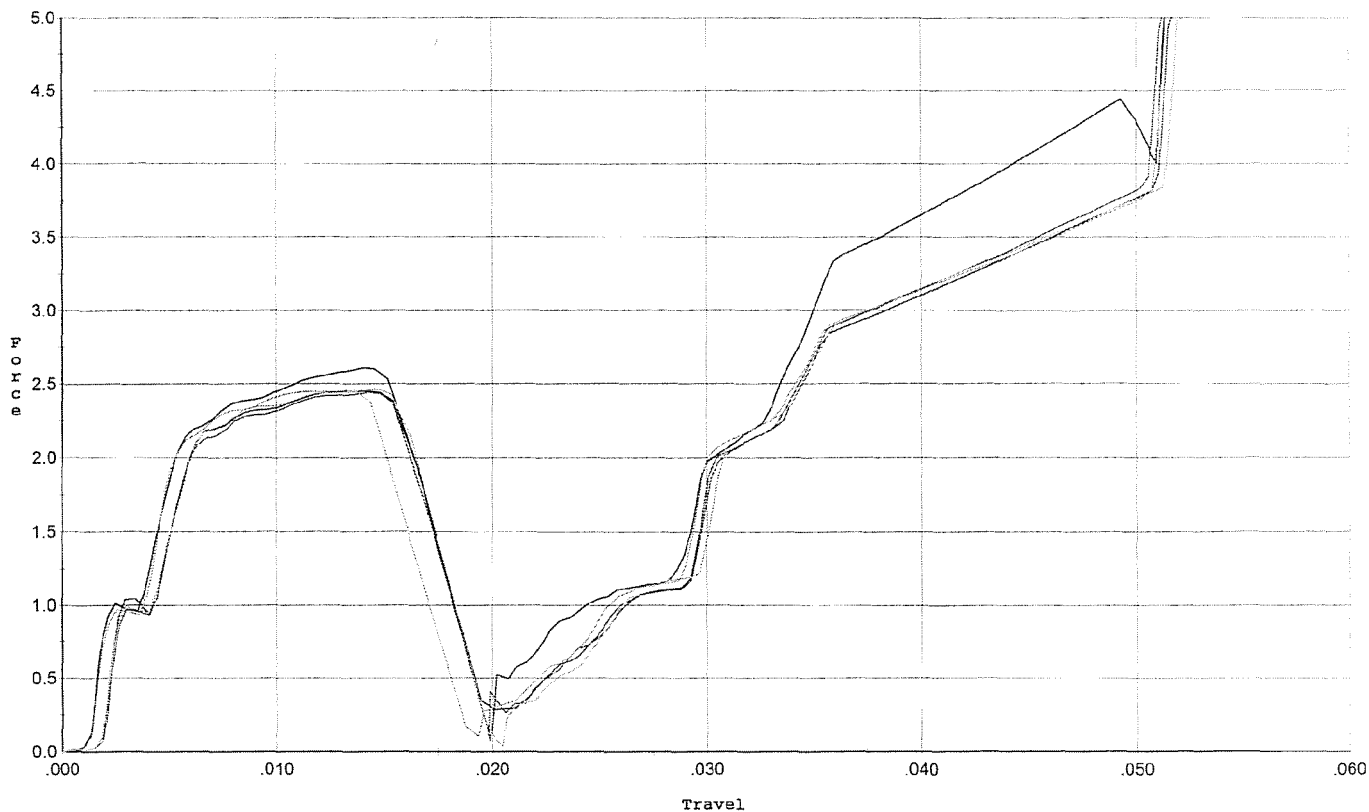
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.166	0.018	0.00	0.033	0.050		Set Trigger
2	4.125	0.017	0.00	0.034	0.048		Set Trigger
3	4.221	0.018	0.002	0.033	0.048		Set Trigger
4	4.207	0.018	0.00	0.032	0.048		Set Trigger
5	4.169	0.018	0.002	0.032	0.048		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



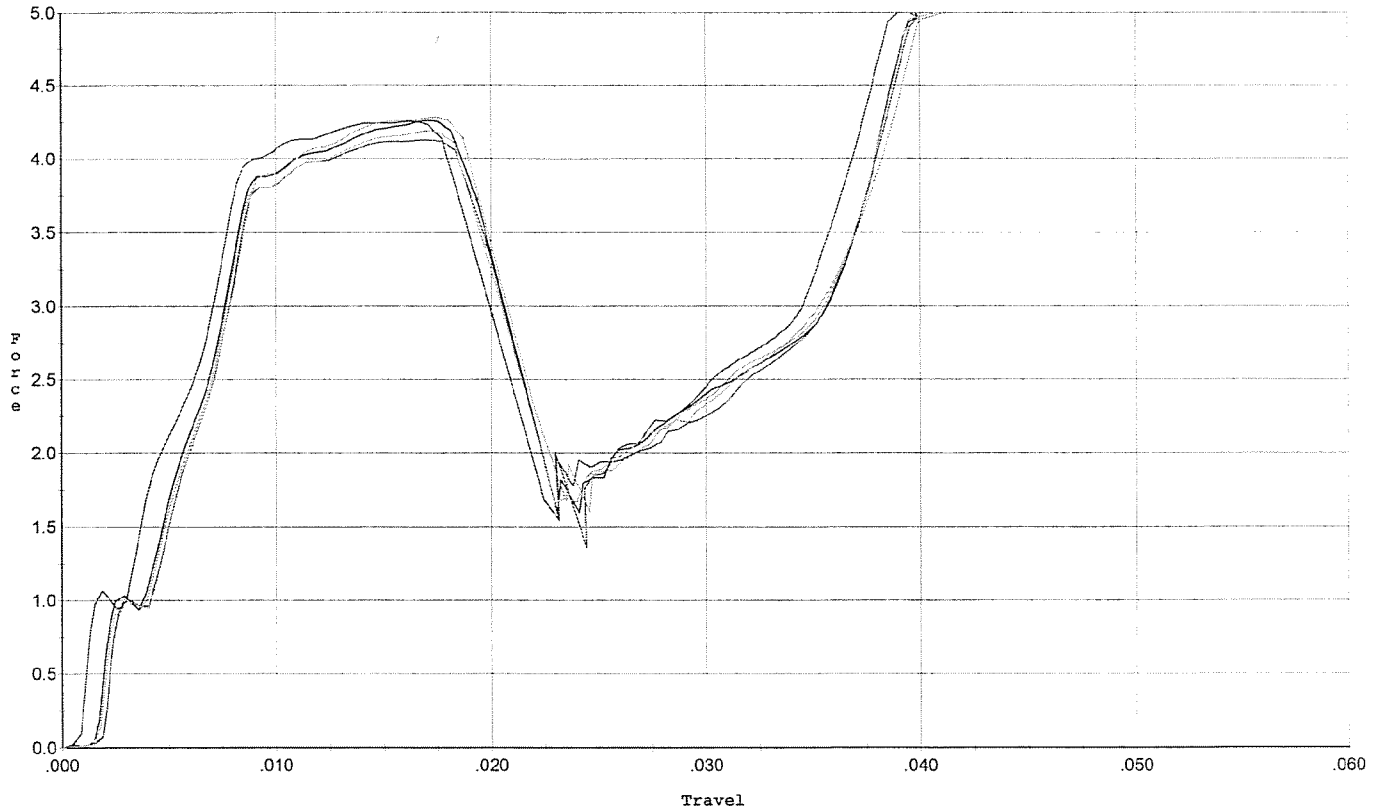
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.452	0.017	0.004	0.038	0.028		Set Trigger
2	2.609	0.017	0.004	0.036	0.030		Set Trigger
3	2.441	0.017	0.004	0.037	0.028		Set Trigger
4	2.464	0.016	0.004	0.038	0.027		Set Trigger
5	2.449	0.014	0.004	0.039	0.024		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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	4.253	0.020	0.00	0.031	0.057		Set Trigger
2	4.260	0.019	0.00	0.033	0.053		Set Trigger
3	4.126	0.020	0.004	0.032	0.052		Set Trigger
4	4.189	0.020	0.00	0.032	0.054		Set Trigger
5	4.283	0.019	0.004	0.033	0.050		Set Trigger

A-4.22