

G6807801

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



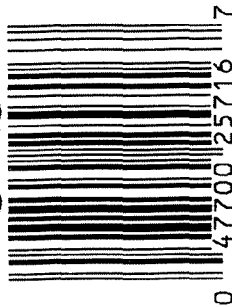
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807801

UPC



GUN SERIAL # G 6807801

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	(D)	3/5/09	(A)
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	MR
540	APPLY COATINGS (BARREL ACTION)		3/9	
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		3-1-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

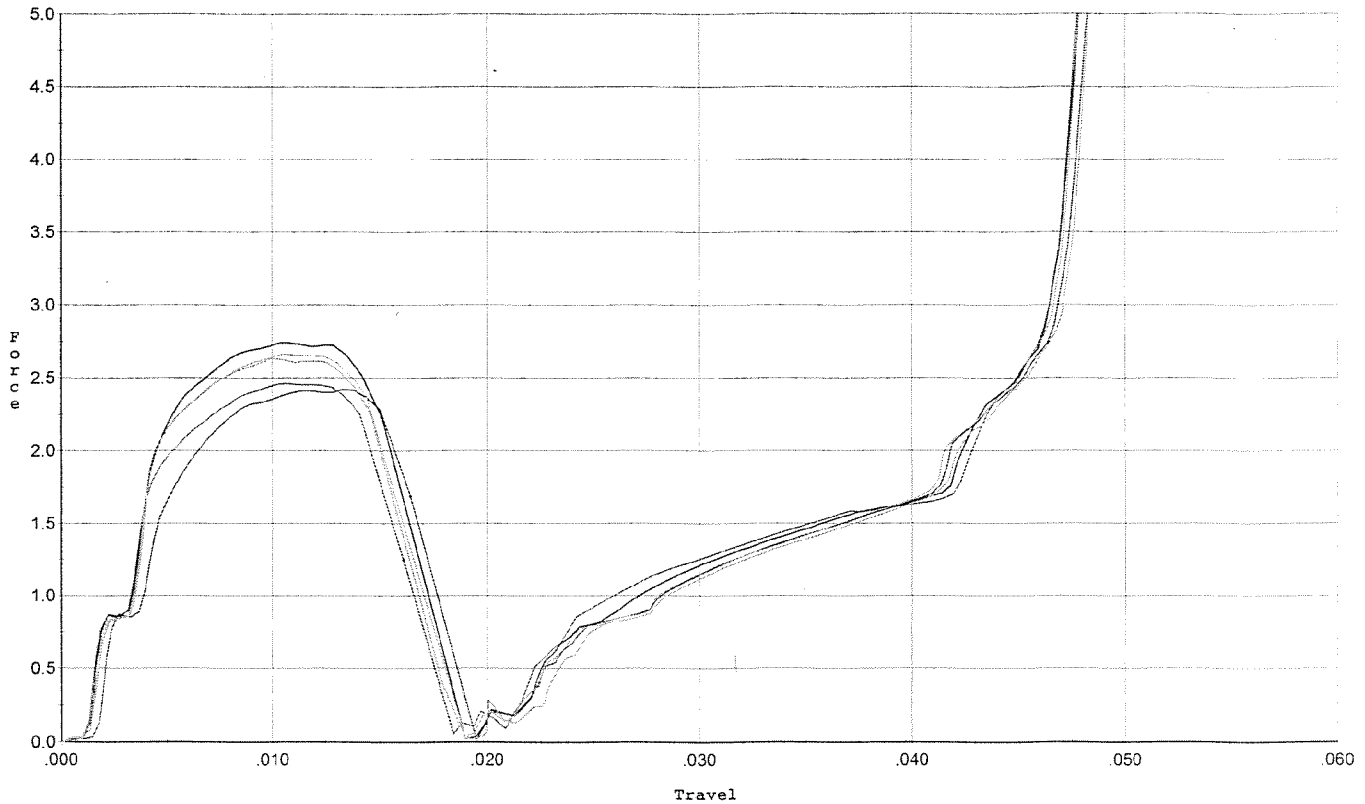
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-18-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-18-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	3-18-09	NW
	J) ASSEMBLE STOCK		3-11-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-19-09	NW
	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	NW
670	FINAL INSPECTION A) HEADSPACE		3-18-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.53</u> <u>2.54</u> <u>2.54</u> <u>2.53</u>	3-18-09	TC
	C) FUNCTION		3-18-09	NW
690	PACK		3/19/09	FM

F004 REV 5/2006

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



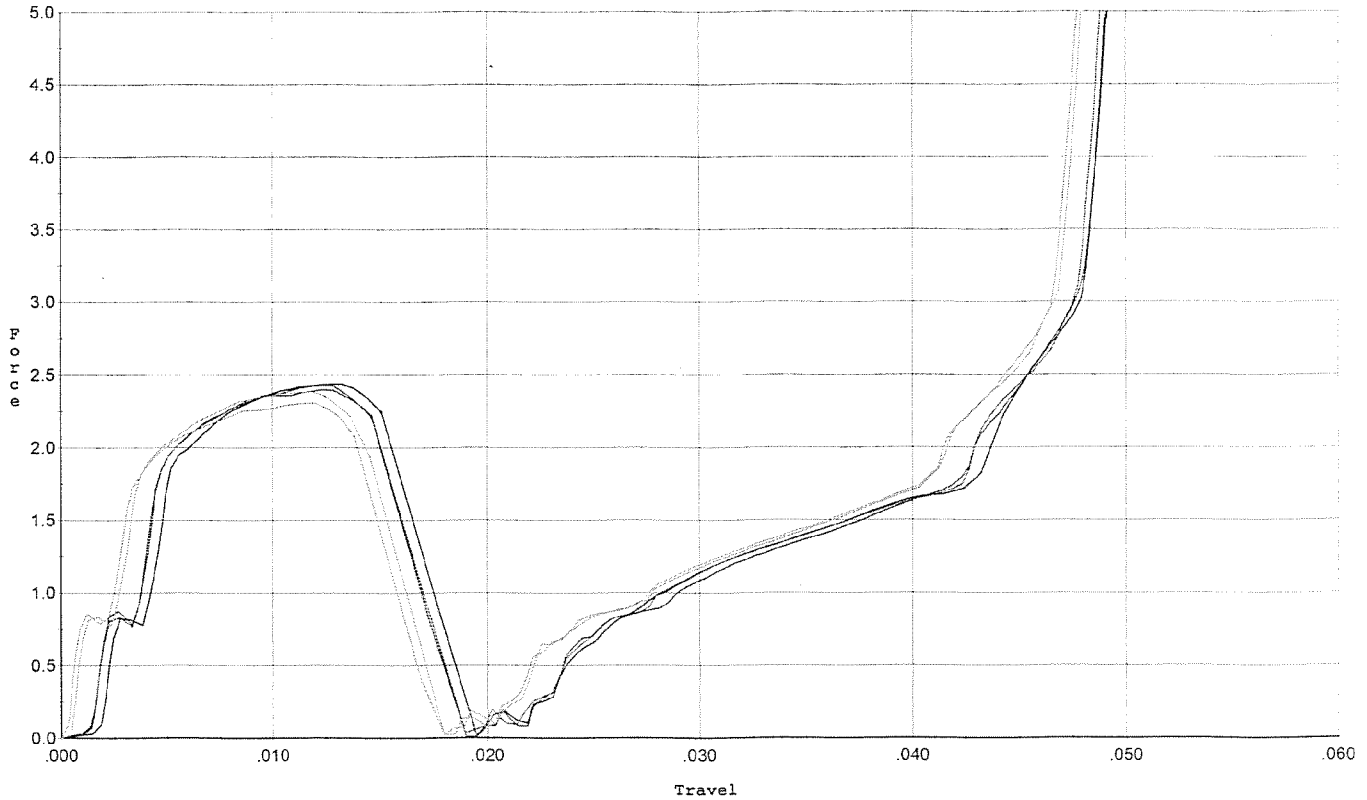
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.016	0.00	0.037	0.027		Set Trigger
2	2.742	0.015	0.00	0.037	0.029		Set Trigger
3	2.462	0.016	0.00	0.037	0.027		Set Trigger
4	2.664	0.014	0.00	0.037	0.026		Set Trigger
5	2.636	0.015	0.00	0.038	0.026		Set Trigger

A-258

Trigger Profile [lbs,inch]

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

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



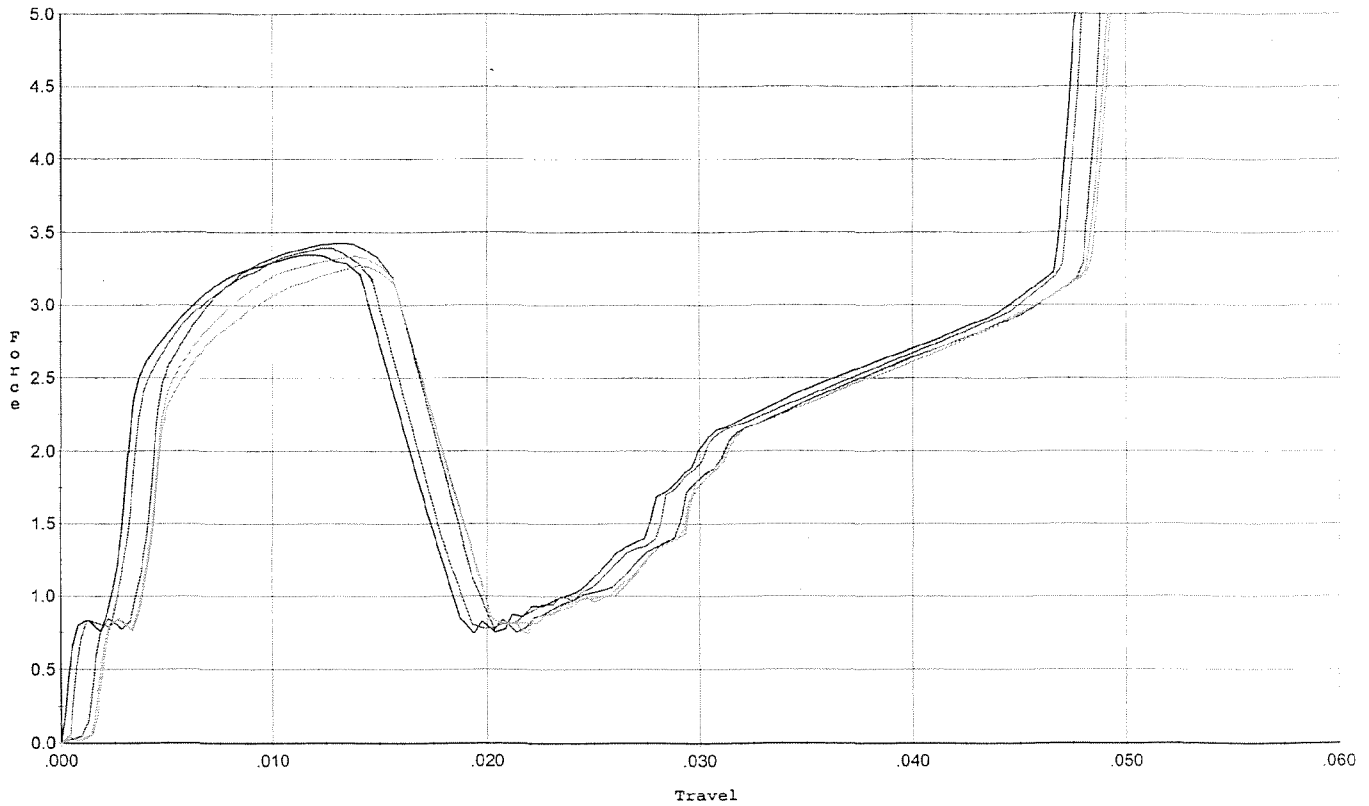
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.434	0.015	0.00	0.039	0.024		Set Trigger
2	2.436	0.015	0.004	0.038	0.025		Set Trigger
3	2.399	0.015	0.00	0.038	0.024		Set Trigger
4	2.384	0.015	0.00	0.038	0.025		Set Trigger
5	2.306	0.014	0.00	0.038	0.024		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

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

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



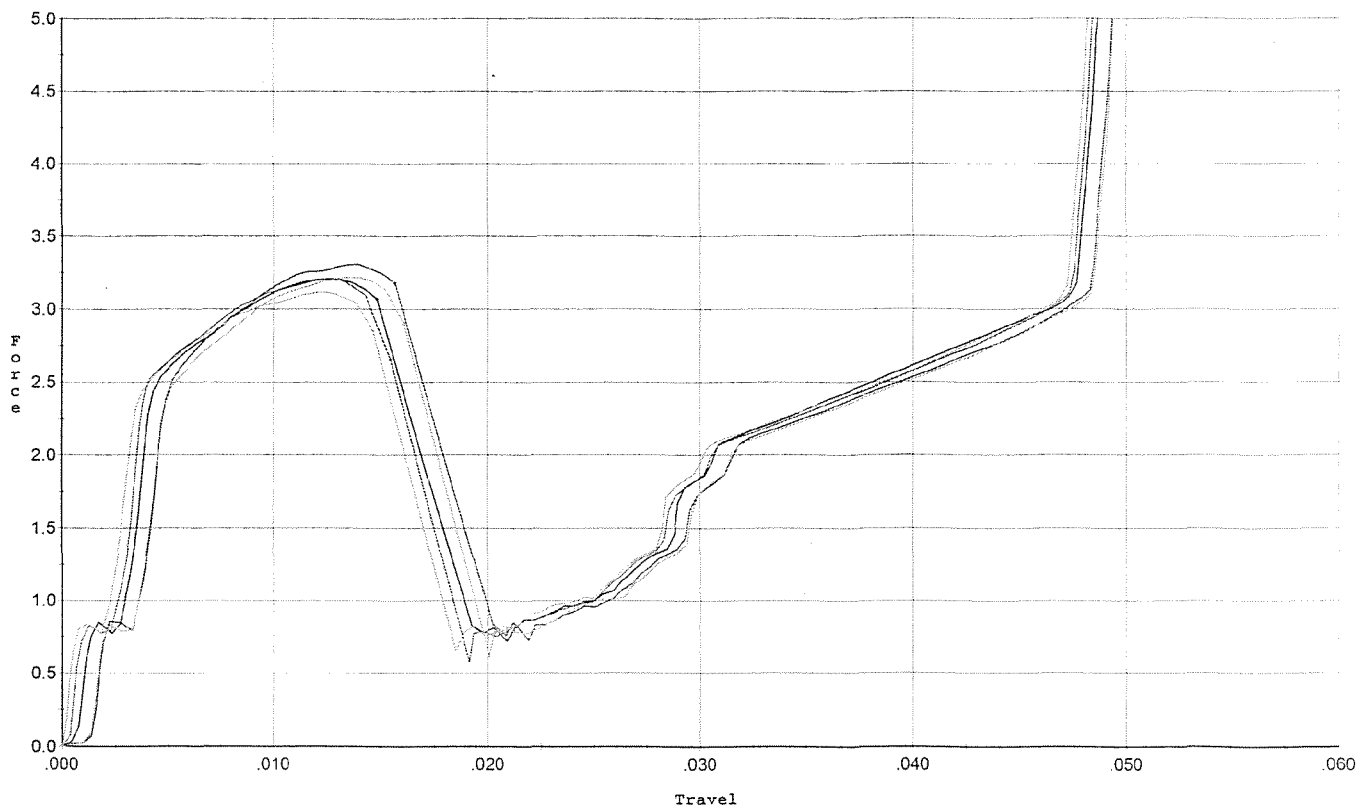
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.424	0.016	0.00	0.034	0.036		Set Trigger
2	3.347	0.014	0.00	0.035	0.034		Set Trigger
3	3.393	0.015	0.003	0.034	0.035		Set Trigger
4	3.339	0.016	0.00	0.035	0.035		Set Trigger
5	3.270	0.016	0.00	0.035	0.034		Set Trigger

A.3.35

Trigger Profile [lbs,inch]

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

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



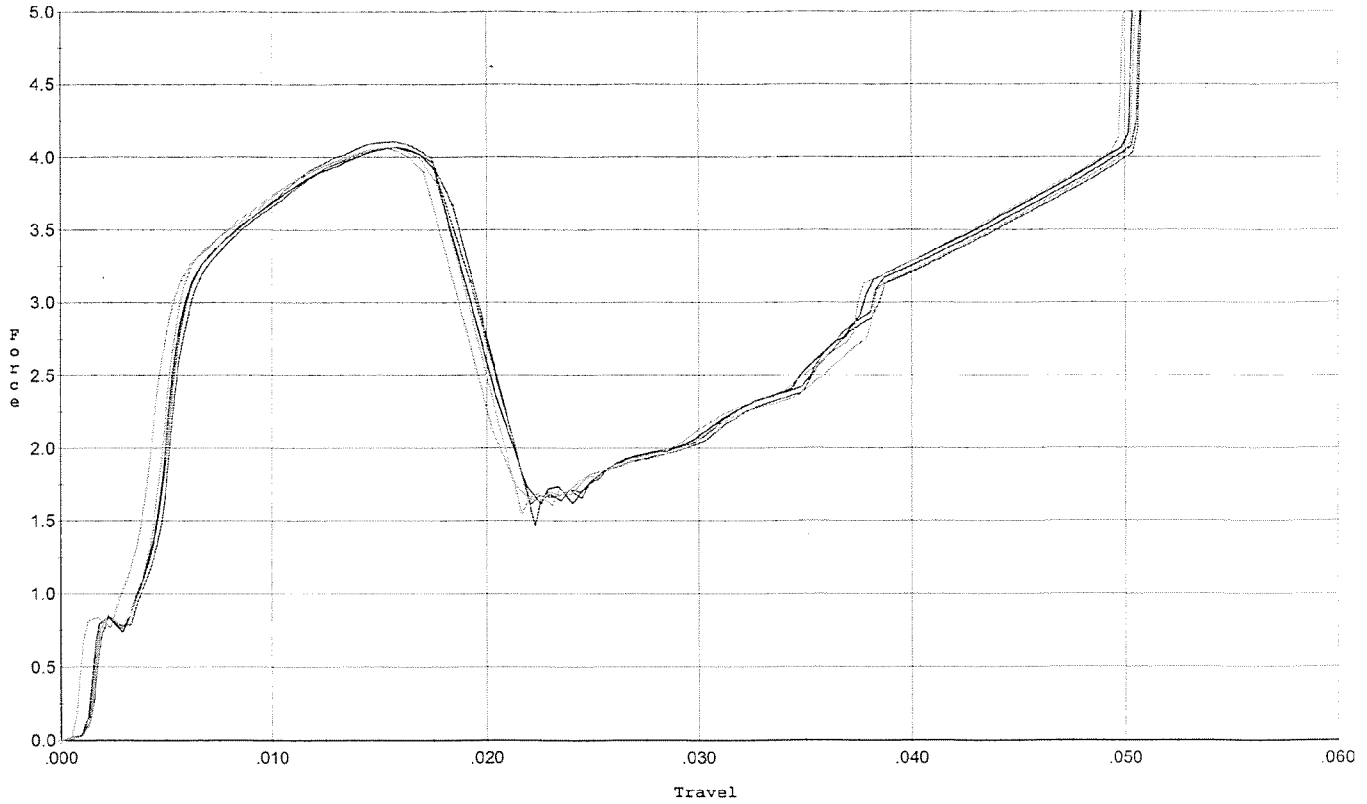
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.307	0.016	0.004	0.035	0.035		Set Trigger
2	3.202	0.015	0.00	0.035	0.033		Set Trigger
3	3.207	0.015	0.00	0.035	0.035		Set Trigger
4	3.217	0.016	0.00	0.035	0.035		Set Trigger
5	3.115	0.015	0.00	0.035	0.033		Set Trigger

A.3.21

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



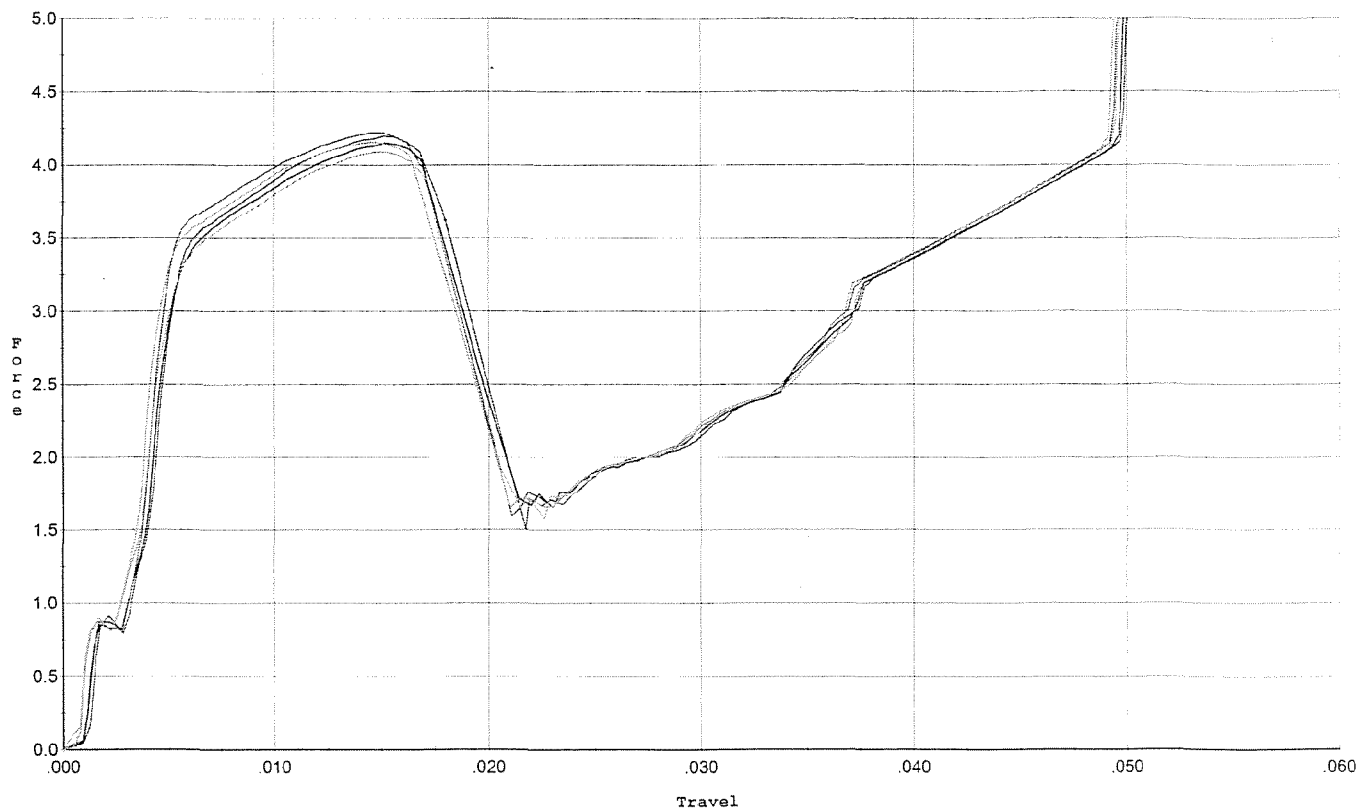
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.063	0.018	0.004	0.033	0.049		Set Trigger
2	4.067	0.018	0.00	0.033	0.047		Set Trigger
3	4.109	0.019	0.00	0.033	0.052		Set Trigger
4	4.069	0.018	0.00	0.033	0.048		Set Trigger
5	4.061	0.017	0.00	0.033	0.047		Set Trigger

A. 4.07

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



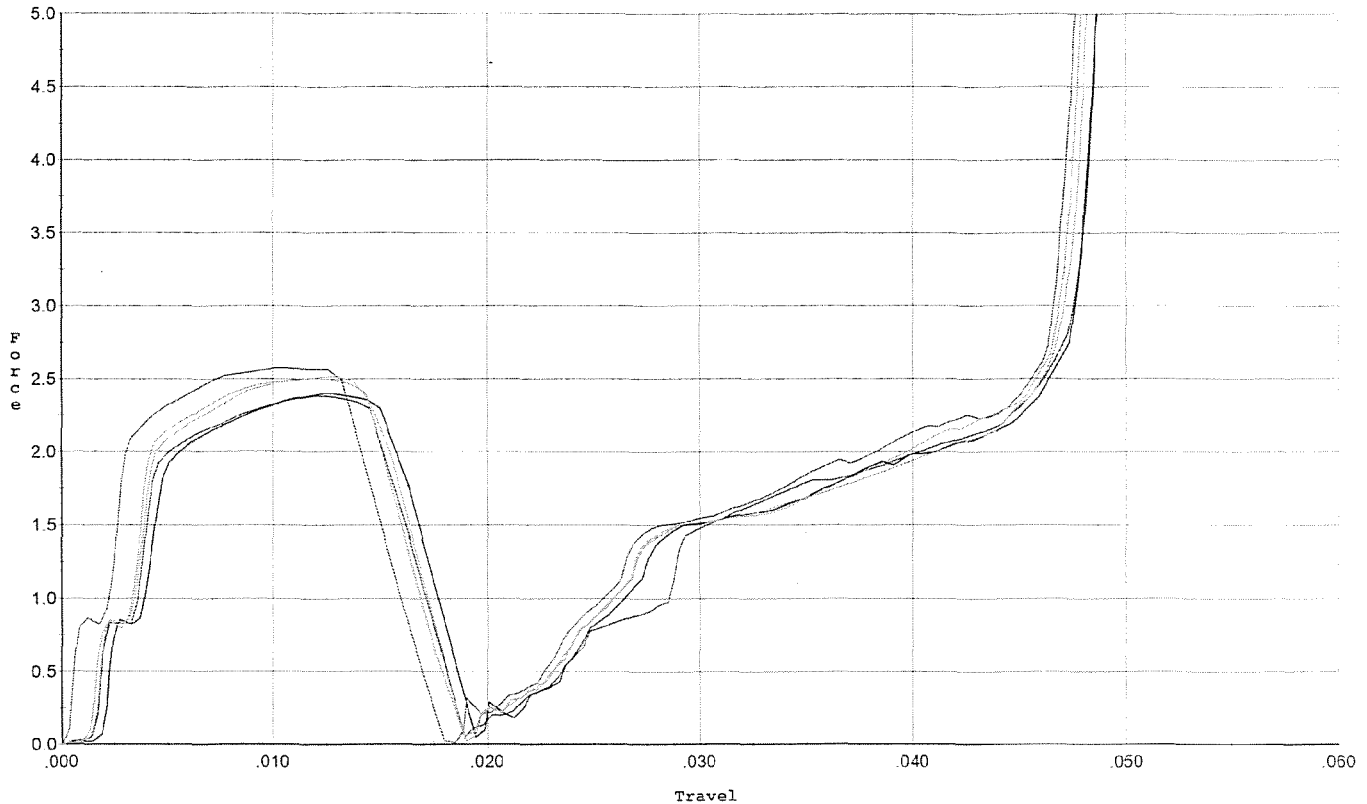
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.198	0.018	0.00	0.032	0.051		Set Trigger
2	4.150	0.017	0.003	0.033	0.047		Set Trigger
3	4.221	0.017	0.003	0.032	0.049		Set Trigger
4	4.089	0.017	0.00	0.033	0.048		Set Trigger
5	4.156	0.018	0.00	0.032	0.052		Set Trigger

A-4.16

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



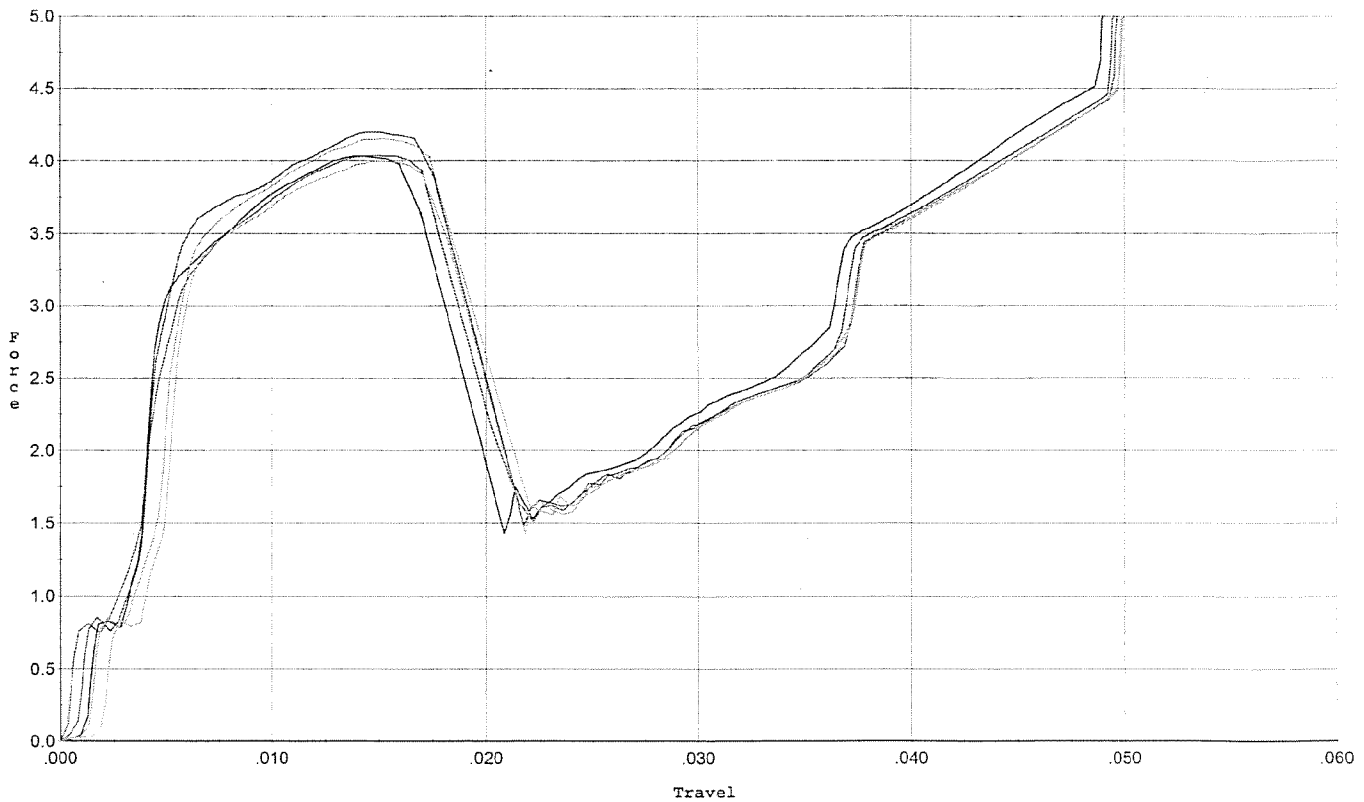
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.384	0.016	0.004	0.037	0.027		Set Trigger
2	2.401	0.016	0.002	0.037	0.027		Set Trigger
3	2.577	0.013	0.00	0.038	0.026		Set Trigger
4	2.504	0.015	0.00	0.036	0.027		Set Trigger
5	2.516	0.014	0.00	0.037	0.026		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: 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	4.201	0.018	0.00	0.032	0.050		Set Trigger
2	4.036	0.017	0.00	0.032	0.046		Set Trigger
3	4.040	0.017	0.00	0.033	0.047		Set Trigger
4	4.000	0.018	0.002	0.032	0.048		Set Trigger
5	4.155	0.017	0.00	0.032	0.048		Set Trigger

A-4.08