

G6845261

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



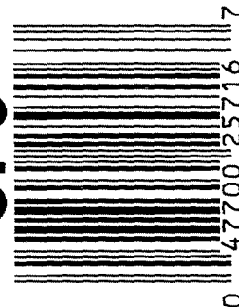
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6845261

UPC



GUN SERIAL # G6845261

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	RPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	RPD
460	CHECK HEADSPACE		3-17-09	RPD
470	DIS-ASSEMBLE ACTION		3-17-09	RPD
472	SERIALIZE BOLT HANDLE		3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-19-09	SP
480	MAGNAFLUX BBL ACTION		3-20-09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-27	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		3-30-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

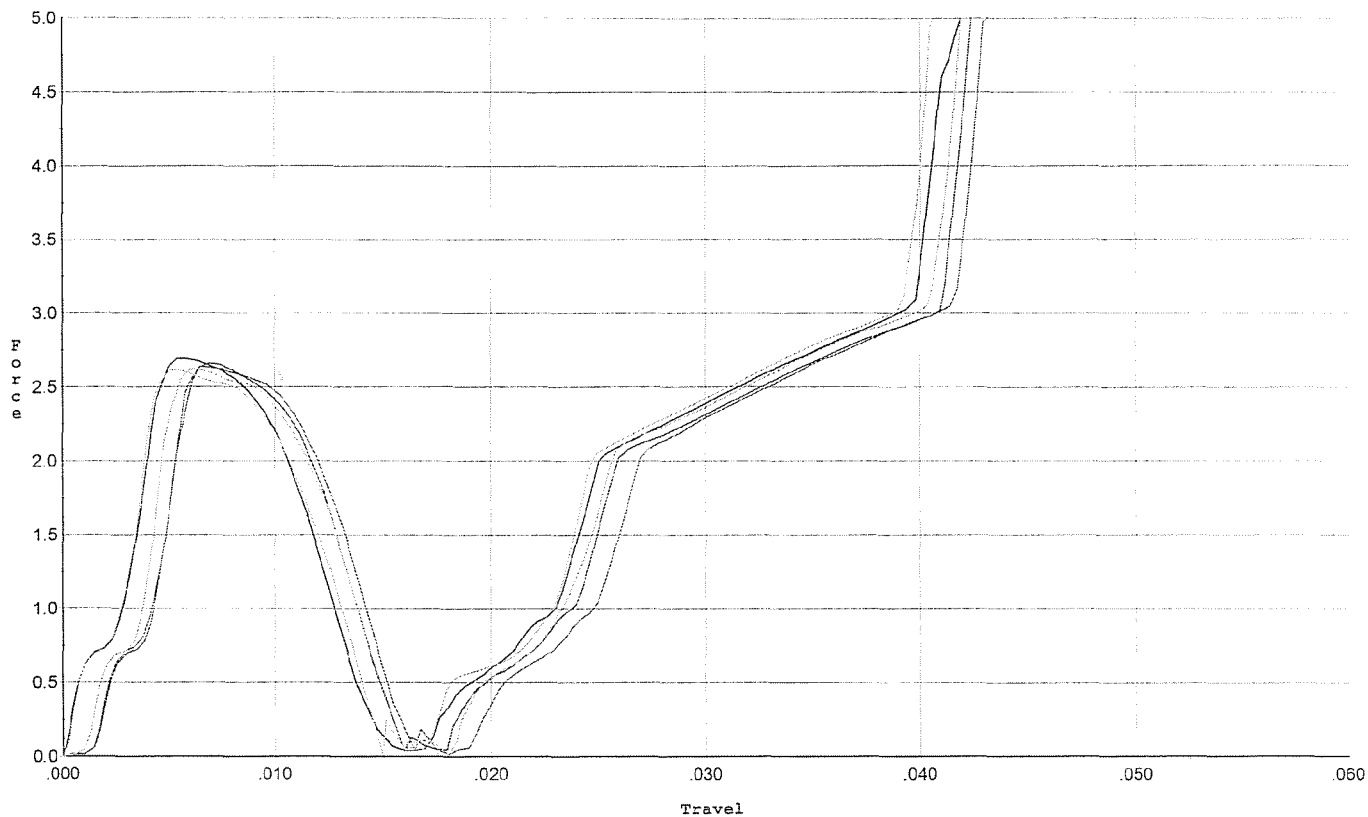
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>5.5</u> <u>5.5</u>	4-1-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	4-1-09	WV
	J) ASSEMBLE STOCK		3-31-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		4-1-09	WV
	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	3-31-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.70</u> <u>2.63</u> <u>2.75</u> <u>2.60</u> <u>2.55</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		6/1/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



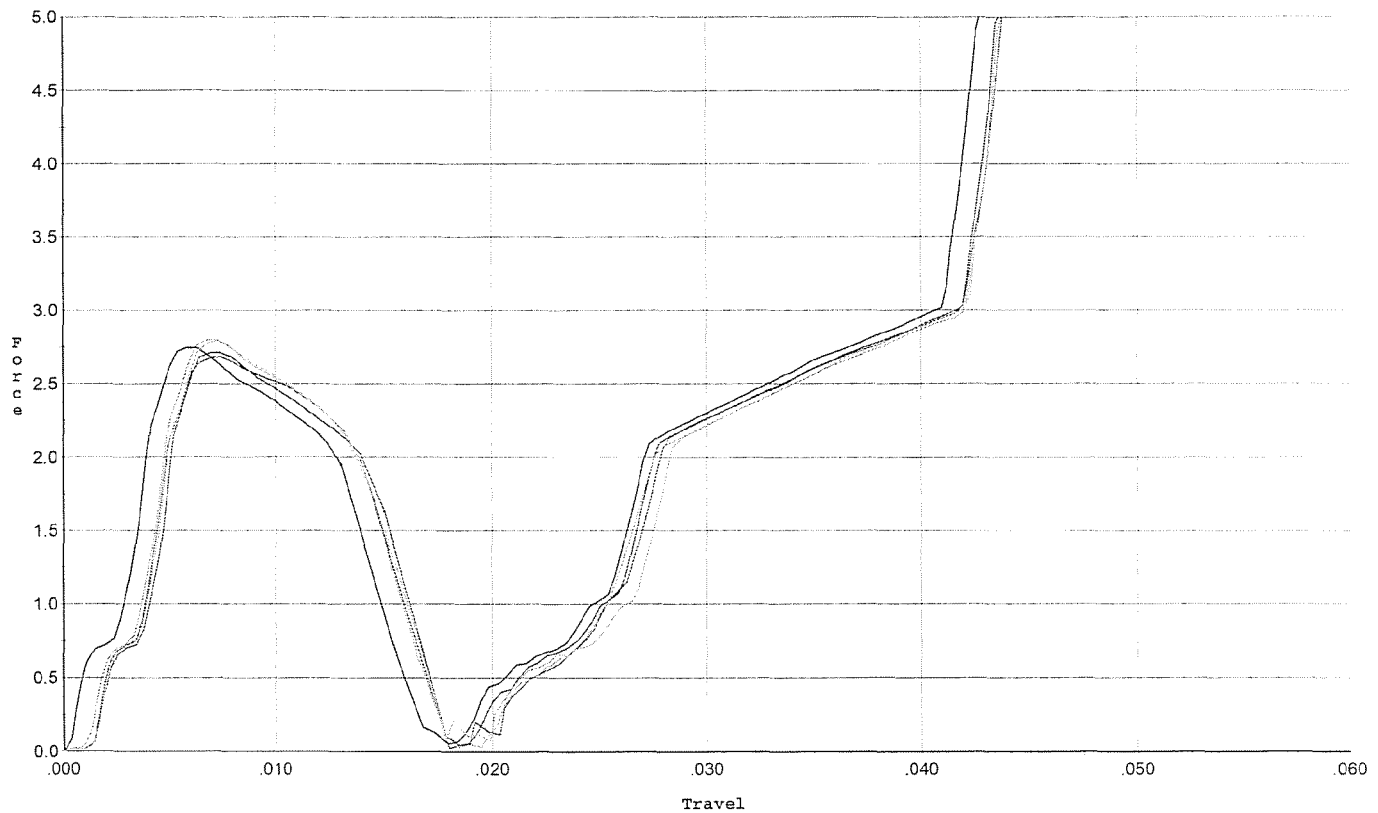
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.012	0.00	0.034	0.019		Set Trigger
2	2.691	0.012	0.00	0.034	0.020		Set Trigger
3	2.638	0.013	0.00	0.034	0.020		Set Trigger
4	2.616	0.013	0.00	0.032	0.021		Set Trigger
5	2.618	0.012	0.00	0.033	0.020		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



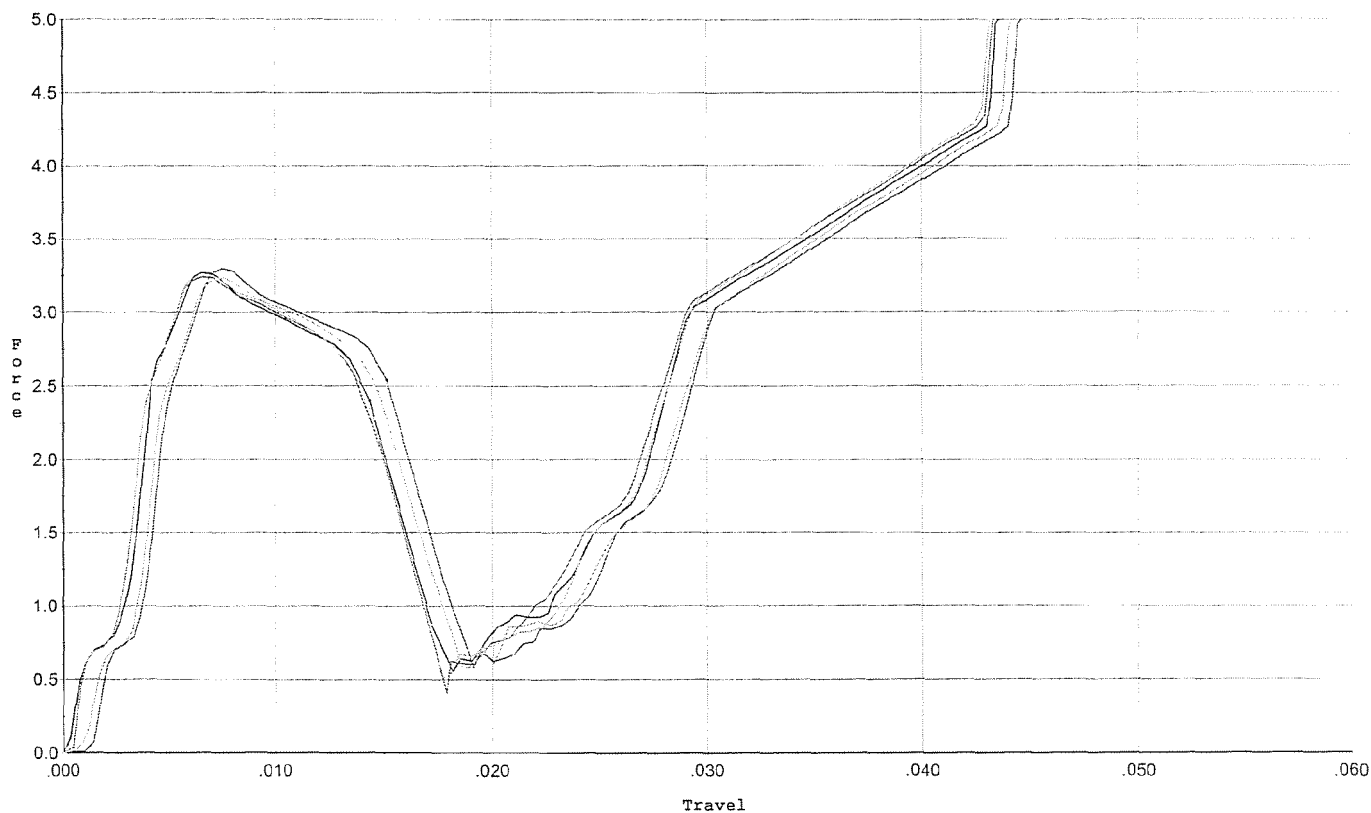
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.714	0.015	0.00	0.032	0.025		Set Trigger
2	2.747	0.013	0.00	0.033	0.023		Set Trigger
3	2.685	0.014	0.00	0.033	0.024		Set Trigger
4	2.793	0.016	0.00	0.033	0.026		Set Trigger
5	2.803	0.014	0.00	0.033	0.025		Set Trigger

A2-74

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



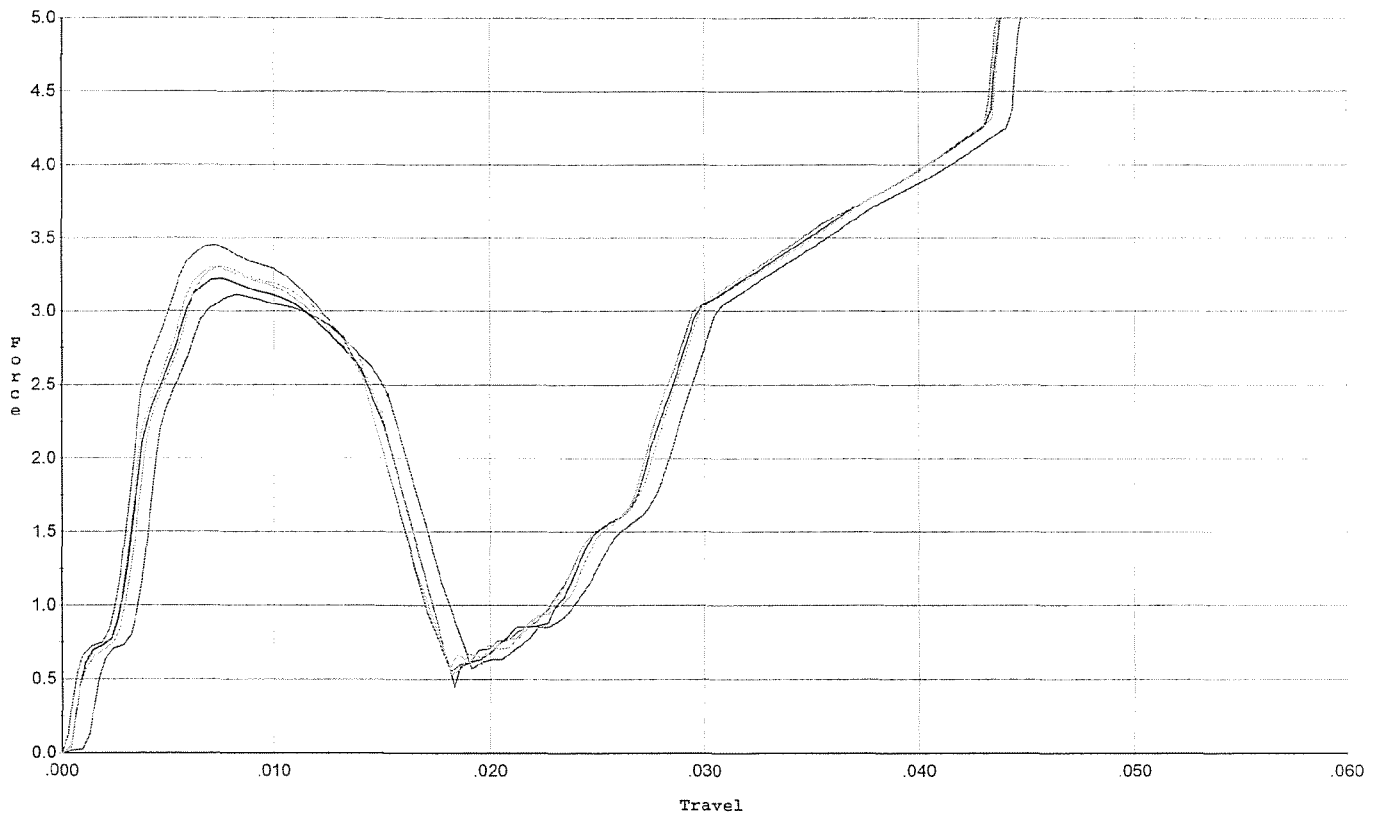
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.298	0.015	0.00	0.031	0.031		Set Trigger
2	3.267	0.014	0.00	0.031	0.031		Set Trigger
3	3.240	0.015	0.00	0.031	0.032		Set Trigger
4	3.272	0.015	0.00	0.030	0.032		Set Trigger
5	3.235	0.015	0.00	0.031	0.031		Set Trigger

A-3-26

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



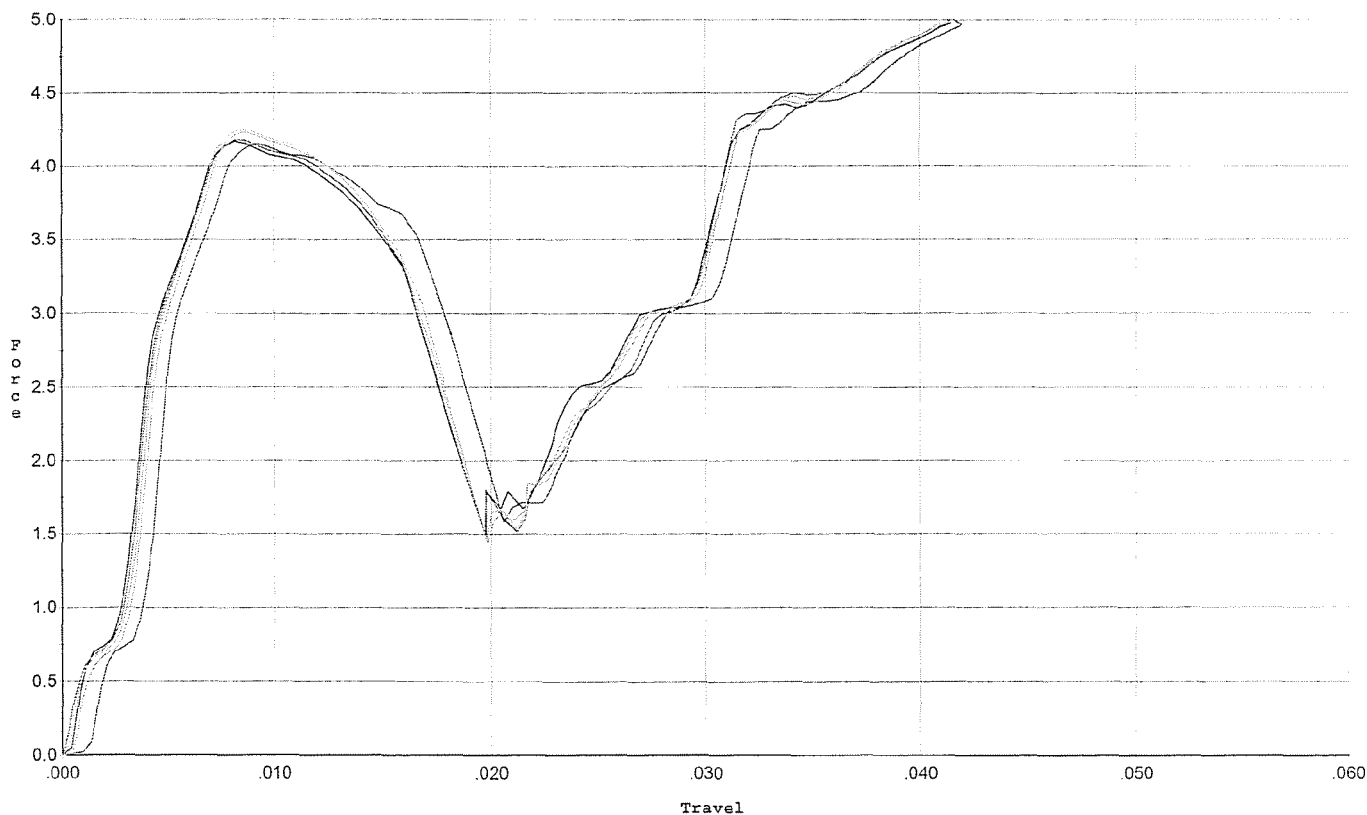
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.113	0.015	0.00	0.031	0.031		Set Trigger
2	3.223	0.015	0.00	0.031	0.033		Set Trigger
3	3.453	0.014	0.00	0.031	0.033		Set Trigger
4	3.298	0.014	0.00	0.031	0.031		Set Trigger
5	3.309	0.015	0.00	0.031	0.033		Set Trigger

A-3-27

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



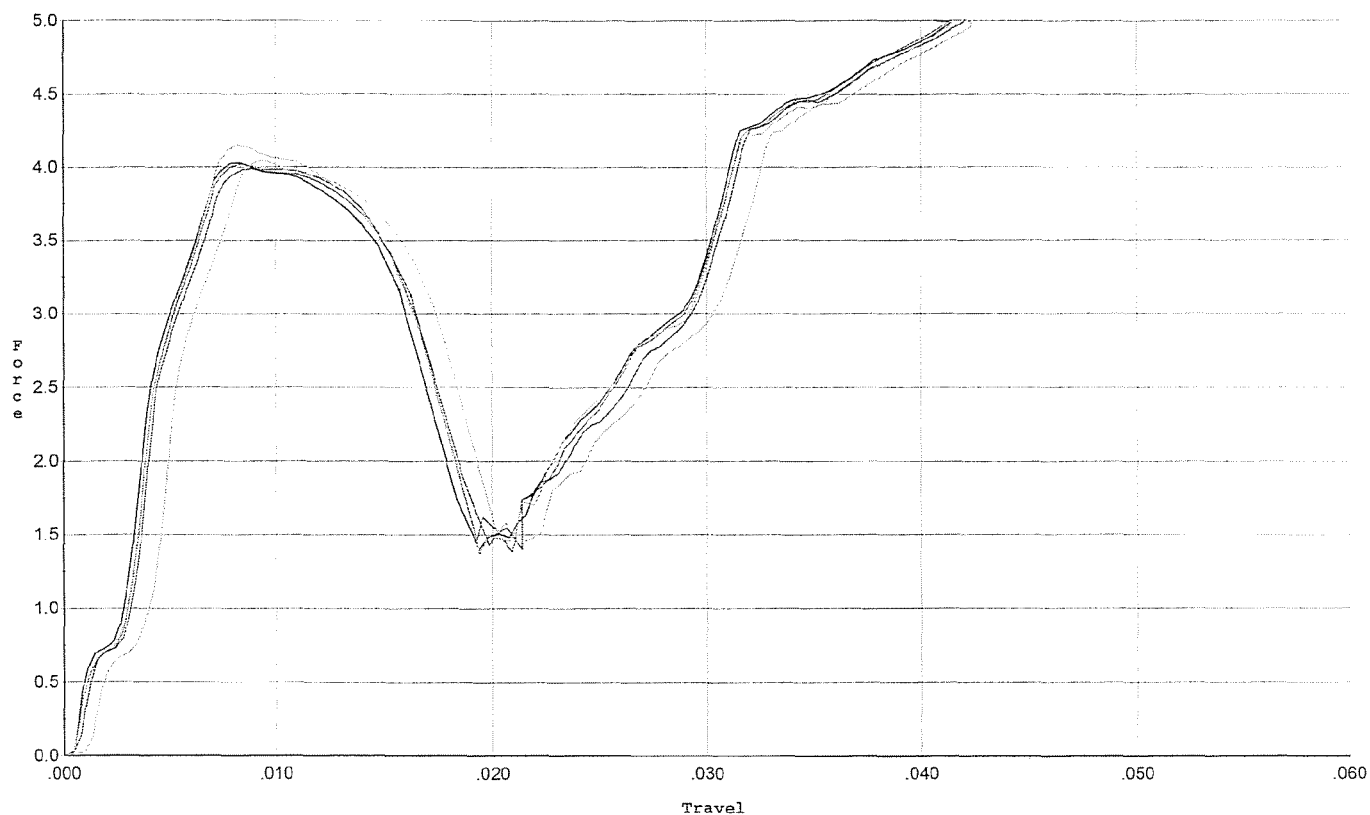
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.018	0.00	0.028	0.048		Set Trigger
2	4.172	0.016	0.00	0.028	0.044		Set Trigger
3	4.182	0.016	0.00	0.028	0.044		Set Trigger
4	4.255	0.017	0.00	0.028	0.048		Set Trigger
5	4.236	0.017	0.00	0.028	0.046		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



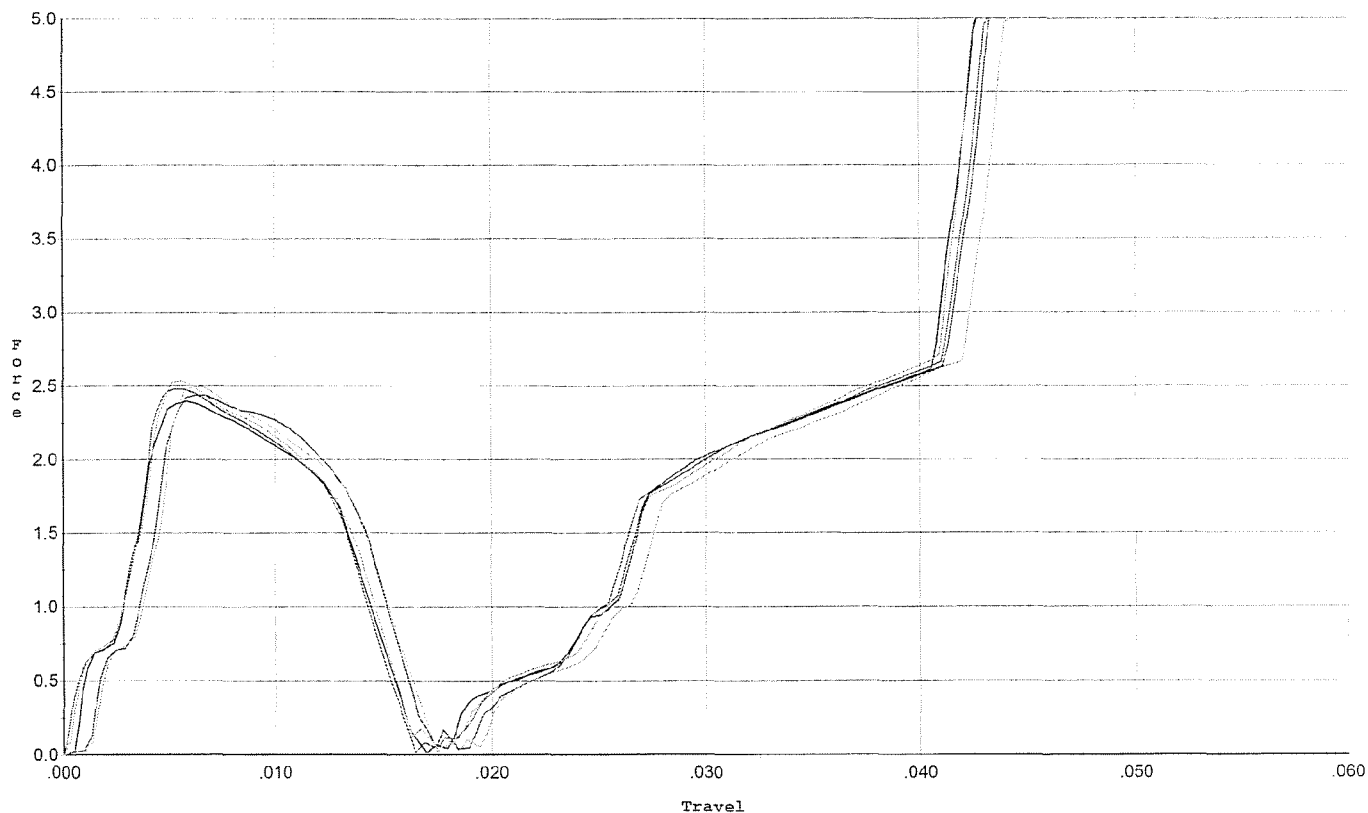
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.989	0.016	0.00	0.029	0.043		Set Trigger
2	4.029	0.016	0.00	0.029	0.042		Set Trigger
3	4.021	0.016	0.00	0.029	0.044		Set Trigger
4	4.049	0.017	0.00	0.029	0.044		Set Trigger
5	4.154	0.017	0.00	0.029	0.044		Set Trigger

A-4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



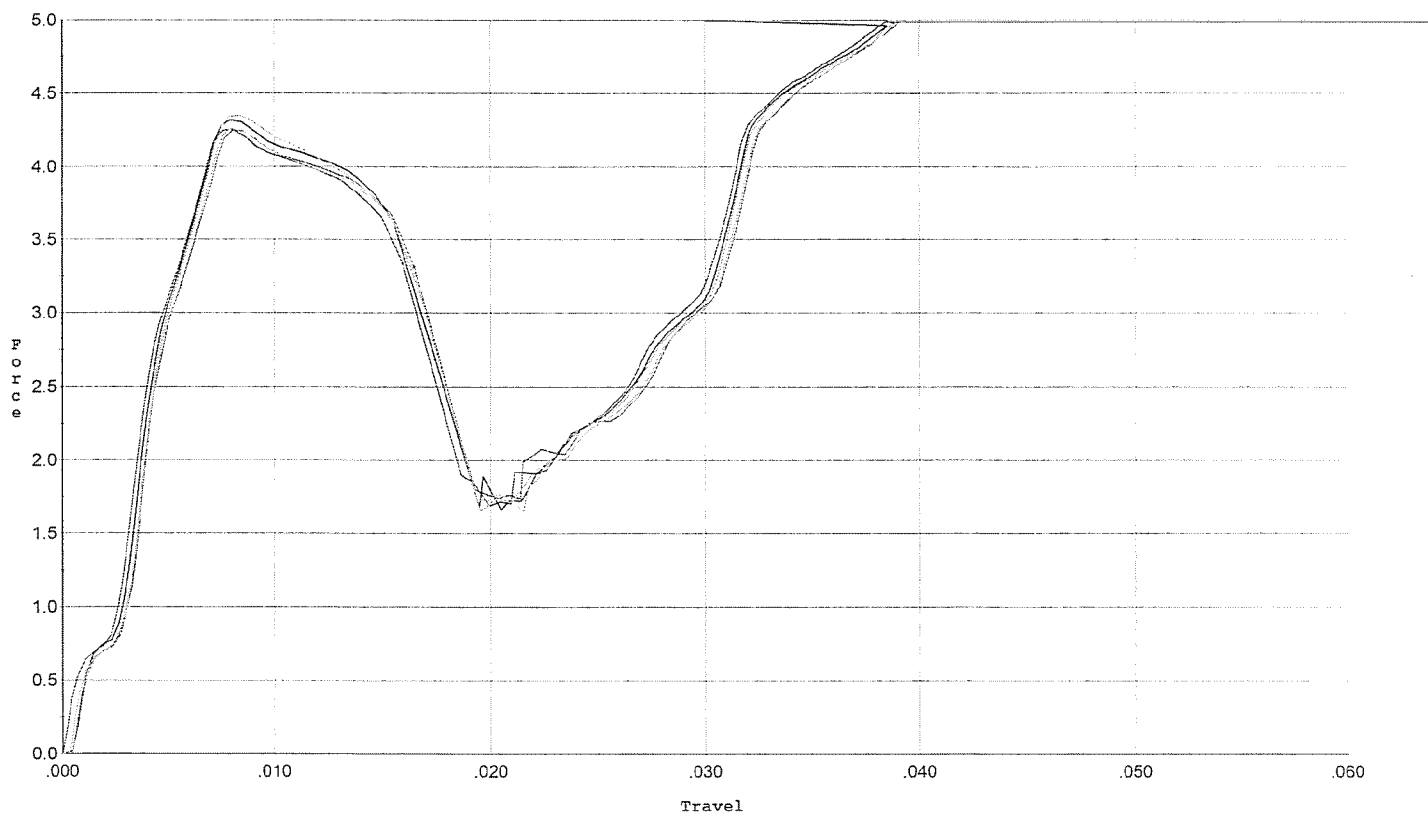
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.437	0.014	0.00	0.034	0.022		Set Trigger
2	2.400	0.013	0.00	0.034	0.021		Set Trigger
3	2.478	0.013	0.00	0.034	0.022		Set Trigger
4	2.499	0.014	0.00	0.034	0.022		Set Trigger
5	2.534	0.014	0.00	0.033	0.023		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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	4.257	0.016	0.00	0.029	0.045		Set Trigger
2	4.318	0.017	0.00	0.029	0.049		Set Trigger
3	4.248	0.016	0.00	0.029	0.045		Set Trigger
4	4.268	0.017	0.00	0.029	0.046		Set Trigger
5	4.350	0.017	0.00	0.029	0.047		Set Trigger

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