

G6801423

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



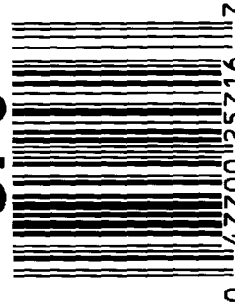
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801423

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801423

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SPD
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SPD
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-23-09	RP
475	DRILL AND TAP SIGHT HOLES	MAR 20 2009	3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/25/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/26/09	RP
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	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-3-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

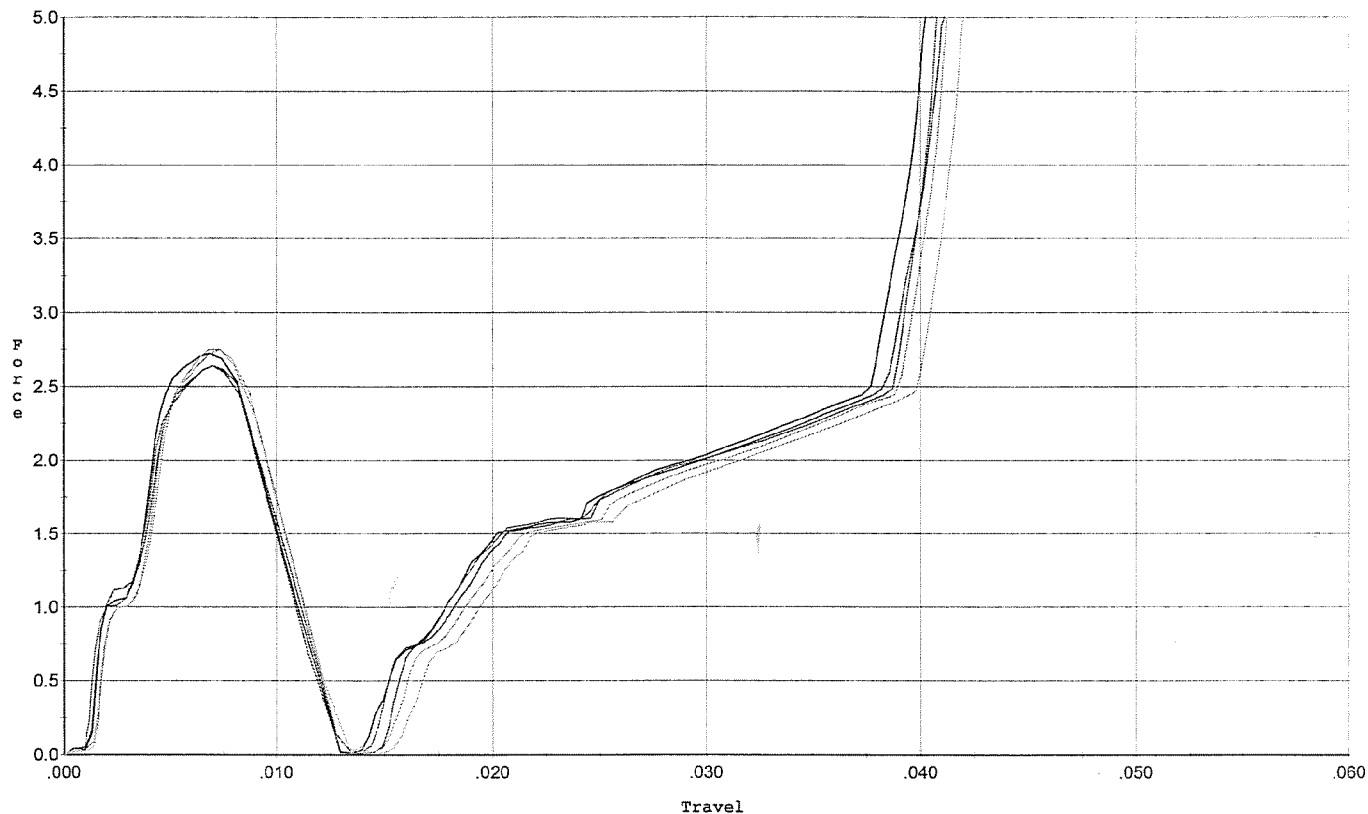
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>6</u> <u>6</u>	4-16-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-16-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	4-16-09	W/W
	J) ASSEMBLE STOCK		4-3-09	R.W.
	K) ASSEMBLE SWIVEL STUDS		4-16-09	W/W
	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	4-7-09	W/W
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-7-09	TQR
670	FINAL INSPECTION A) HEADSPACE		4-16-09	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.62</u> <u>2.82</u> <u>2.68</u> <u>2.71</u>	4-14-09	W/W
	C) FUNCTION		4-16-09	W/W
690	PACK		5-29-09	W/W

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



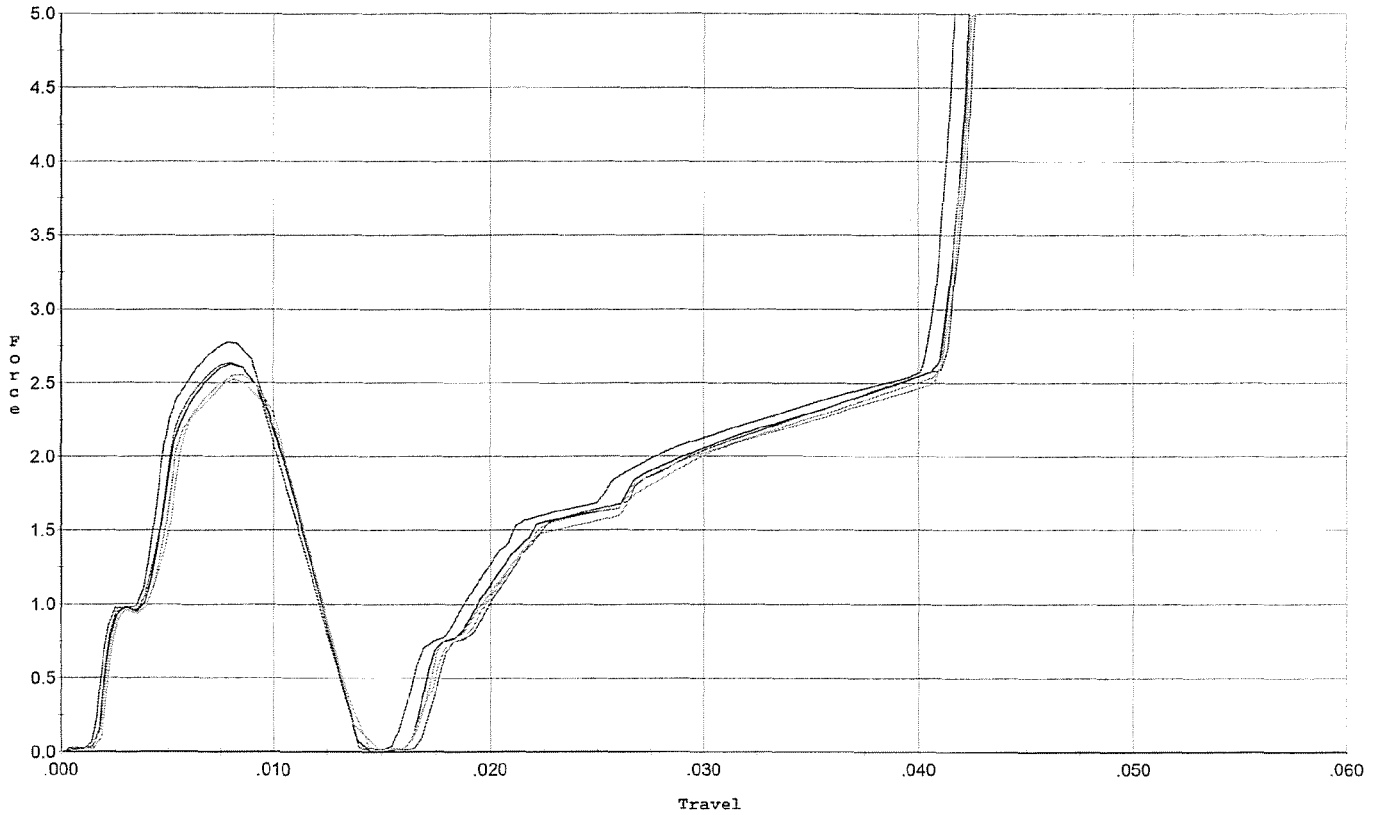
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.641	0.010	0.00	0.035	0.016		Set Trigger
2	2.722	0.008	0.00	0.035	0.013		Set Trigger
3	2.640	0.008	0.00	0.035	0.013		Set Trigger
4	2.747	0.009	0.00	0.036	0.014		Set Trigger
5	2.748	0.009	0.00	0.035	0.014		Set Trigger

A-2.70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



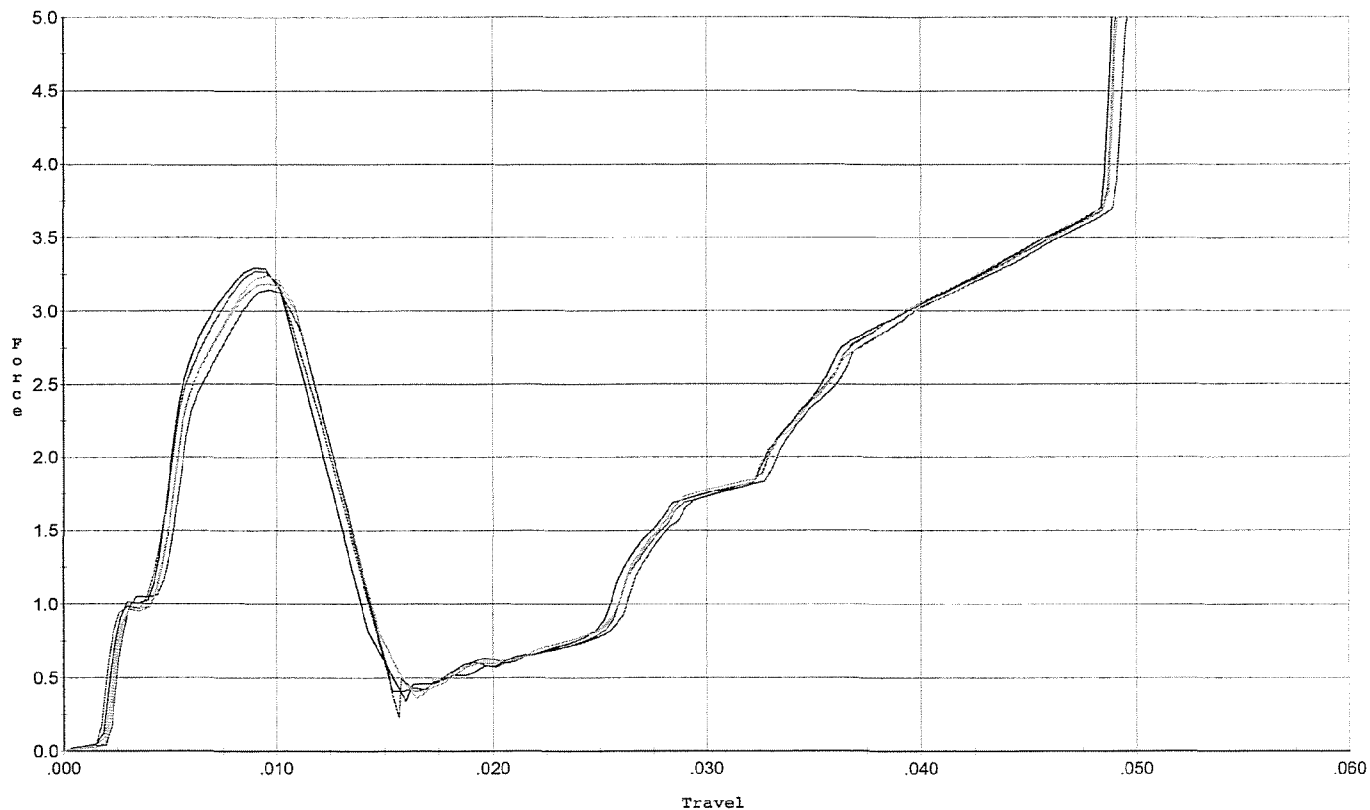
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.776	0.011	0.00	0.034	0.017		Set Trigger
2	2.631	0.011	0.00	0.035	0.016		Set Trigger
3	2.641	0.011	0.00	0.035	0.017		Set Trigger
4	2.529	0.010	0.00	0.035	0.015		Set Trigger
5	2.551	0.010	0.002	0.035	0.014		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



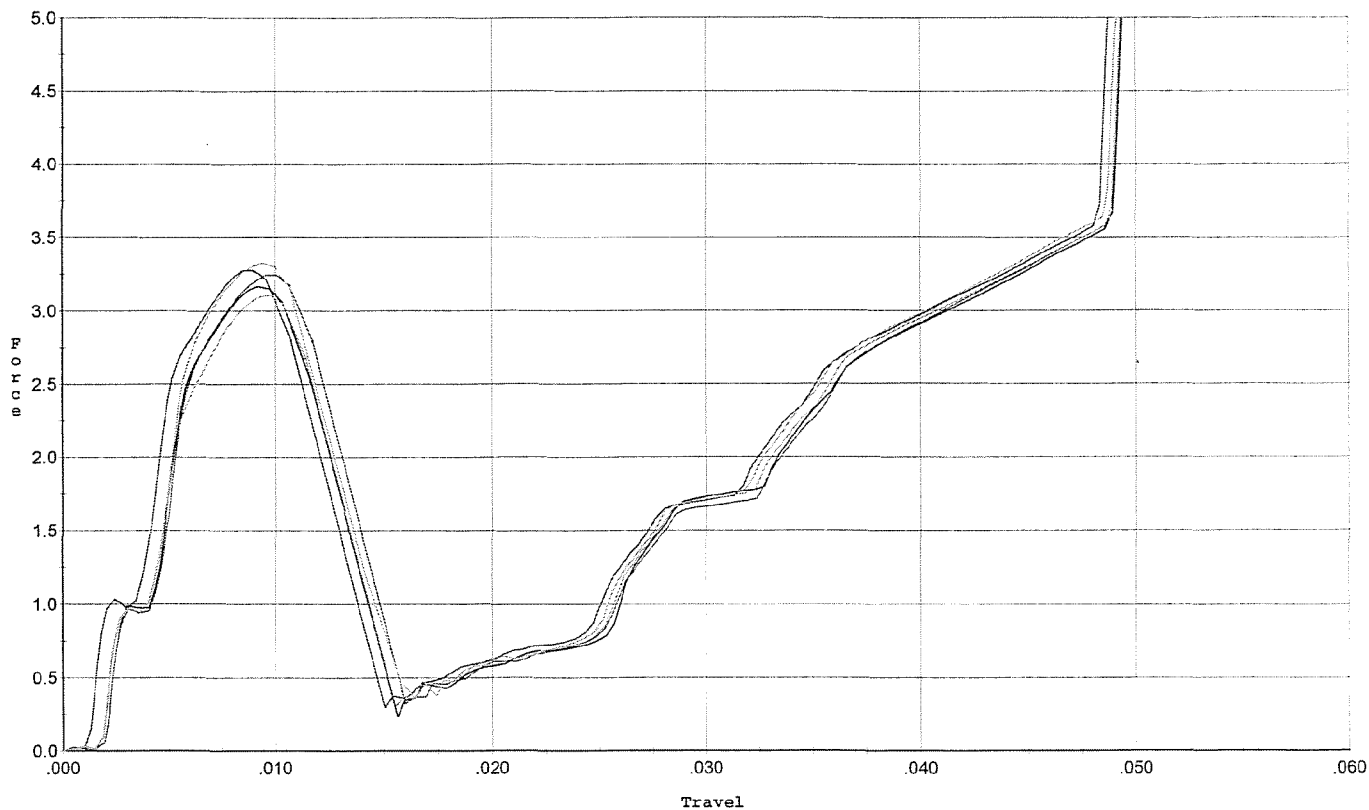
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.144	0.011	0.00	0.039	0.019		Set Trigger
2	3.290	0.010	0.00	0.039	0.019		Set Trigger
3	3.266	0.012	0.00	0.039	0.022		Set Trigger
4	3.186	0.011	0.00	0.039	0.019		Set Trigger
5	3.239	0.011	0.002	0.039	0.019		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



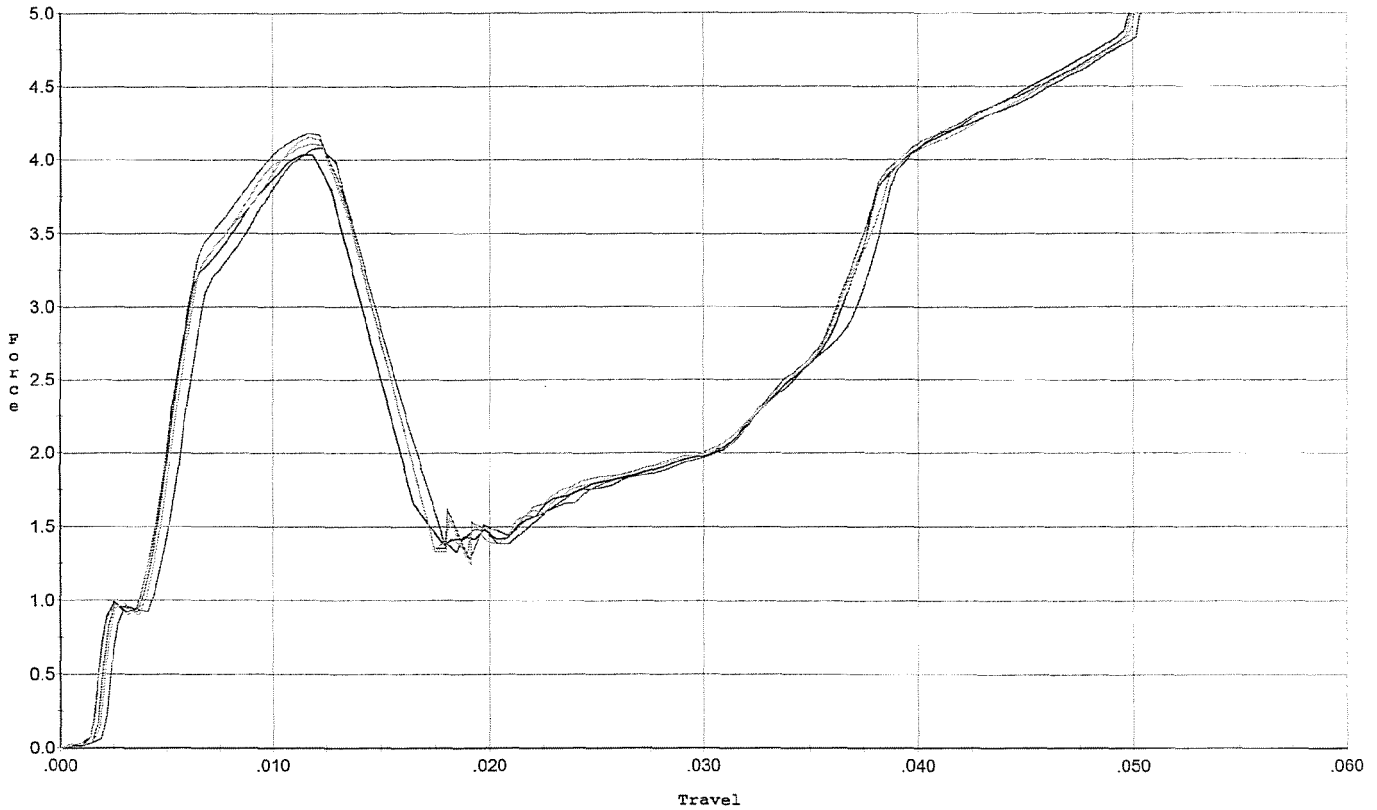
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.275	0.011	0.00	0.039	0.020		Set Trigger
2	3.168	0.012	0.002	0.039	0.021		Set Trigger
3	3.245	0.012	0.002	0.039	0.021		Set Trigger
4	3.327	0.011	0.00	0.039	0.020		Set Trigger
5	3.107	0.011	0.00	0.039	0.020		Set Trigger

A-3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



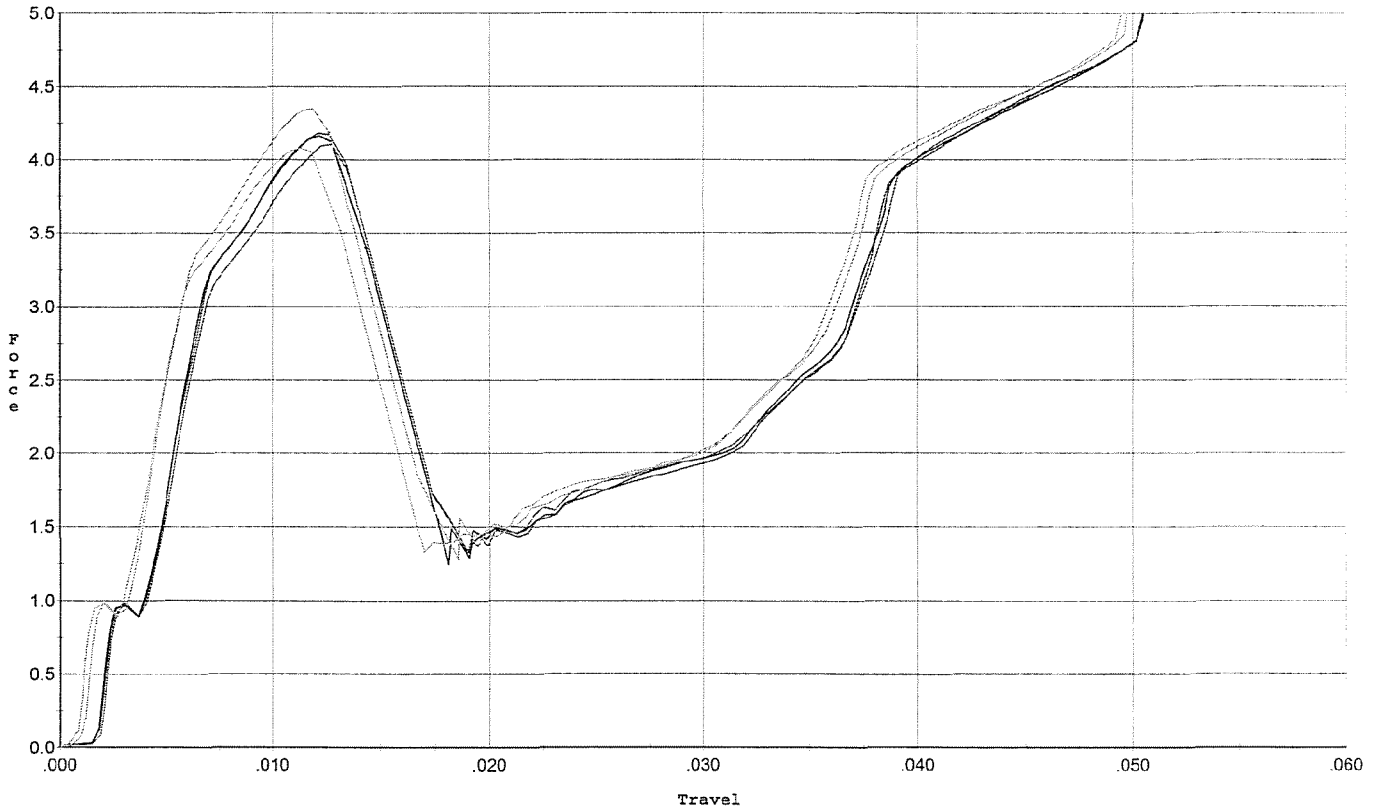
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.080	0.013	0.004	0.037	0.029		Set Trigger
2	4.033	0.013	0.00	0.036	0.030		Set Trigger
3	4.179	0.013	0.004	0.036	0.032		Set Trigger
4	4.109	0.013	0.00	0.036	0.031		Set Trigger
5	4.154	0.013	0.00	0.036	0.032		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



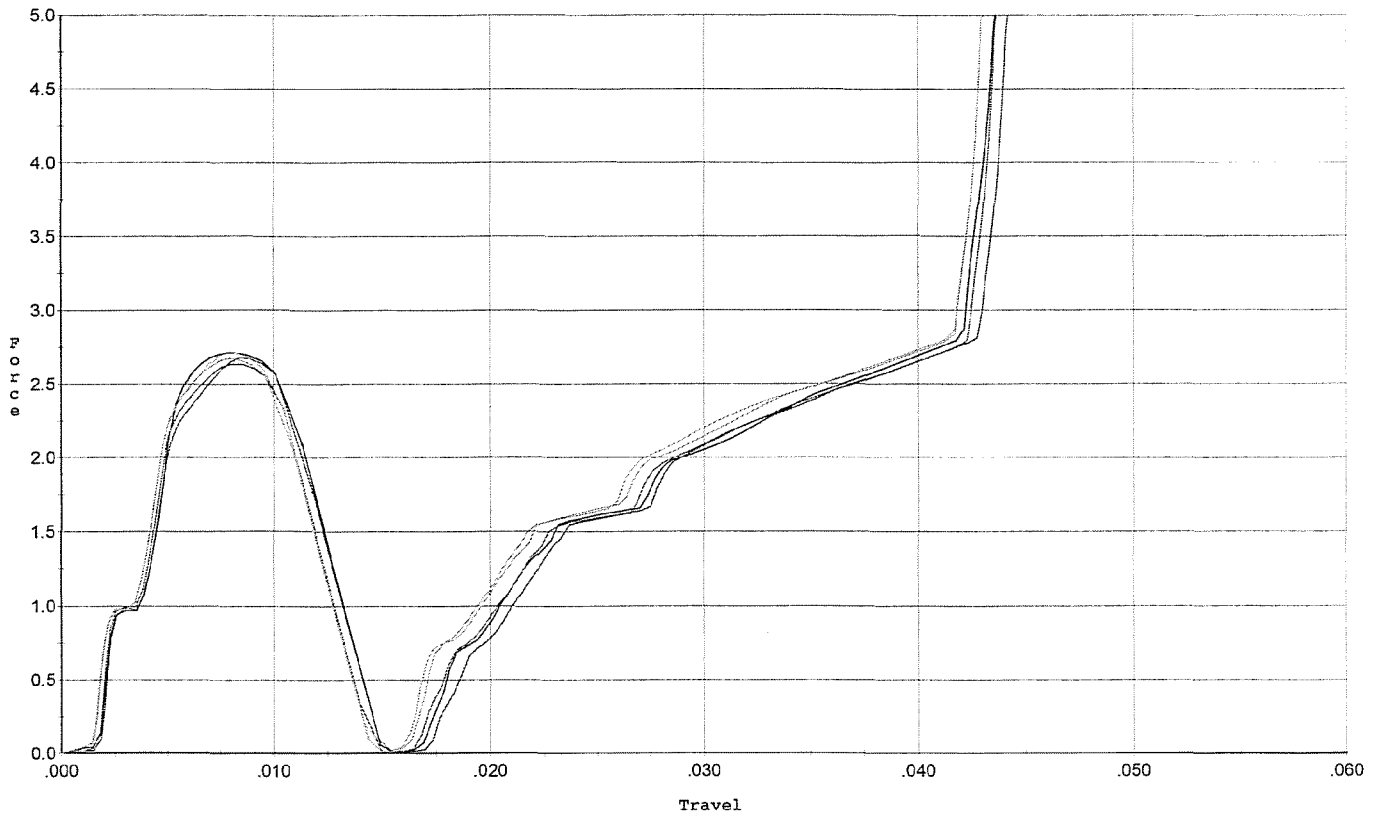
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.180	0.013	0.00	0.036	0.032		Set Trigger
2	4.164	0.014	0.00	0.036	0.034		Set Trigger
3	4.105	0.014	0.00	0.036	0.031		Set Trigger
4	4.080	0.013	0.00	0.036	0.032		Set Trigger
5	4.349	0.013	0.00	0.036	0.032		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

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



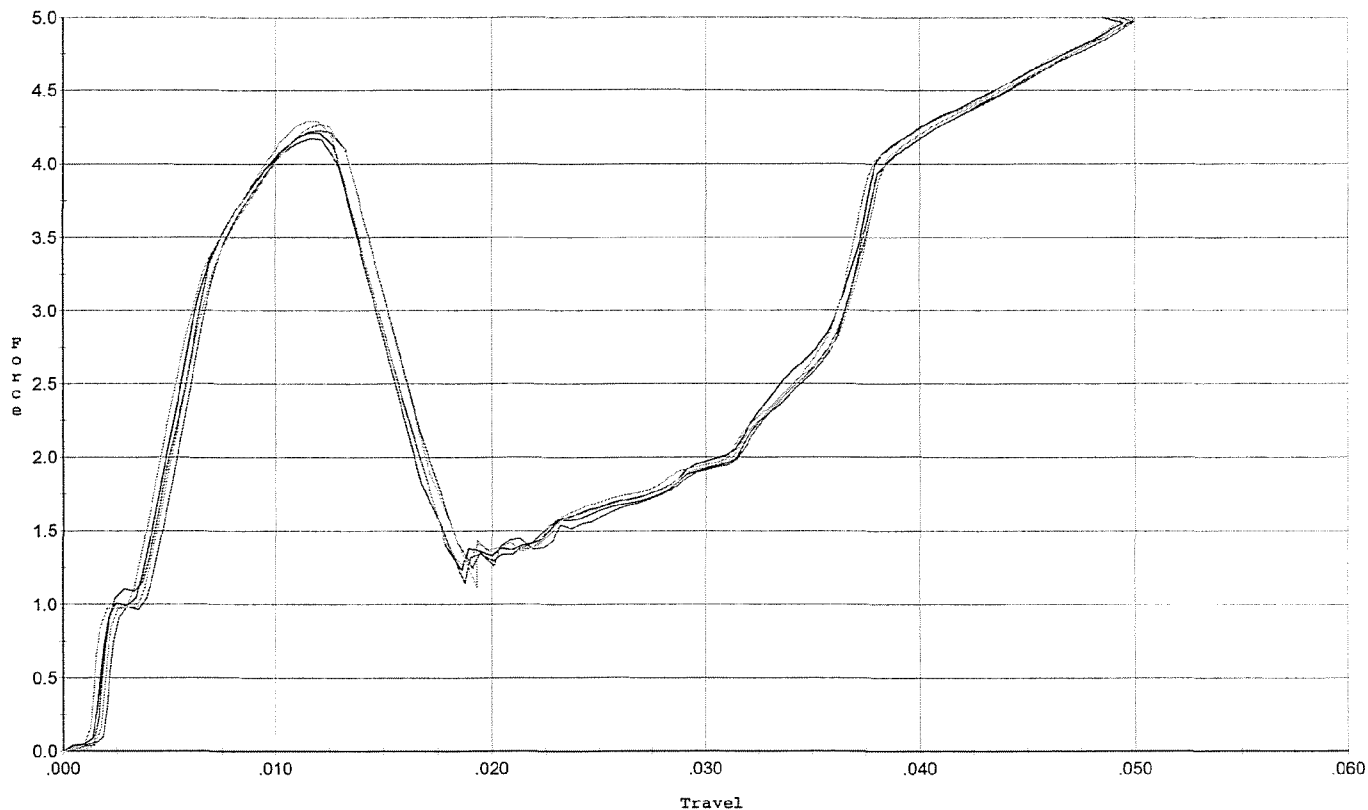
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.682	0.012	0.00	0.036	0.019		Set Trigger
2	2.710	0.011	0.00	0.035	0.018		Set Trigger
3	2.634	0.010	0.00	0.036	0.016		Set Trigger
4	2.712	0.010	0.00	0.035	0.017		Set Trigger
5	2.677	0.011	0.00	0.035	0.017		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/27/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for final test



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.170	0.013	0.00	0.036	0.031		Set Trigger
2	4.211	0.013	0.00	0.036	0.031		Set Trigger
3	4.225	0.013	0.00	0.036	0.032		Set Trigger
4	4.267	0.013	0.00	0.036	0.032		Set Trigger
5	4.291	0.013	0.00	0.036	0.031		Set Trigger

A- 4.23