

6680 1491

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



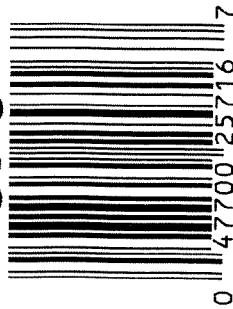
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801491

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801491

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	K12
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		5/18	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/19/09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

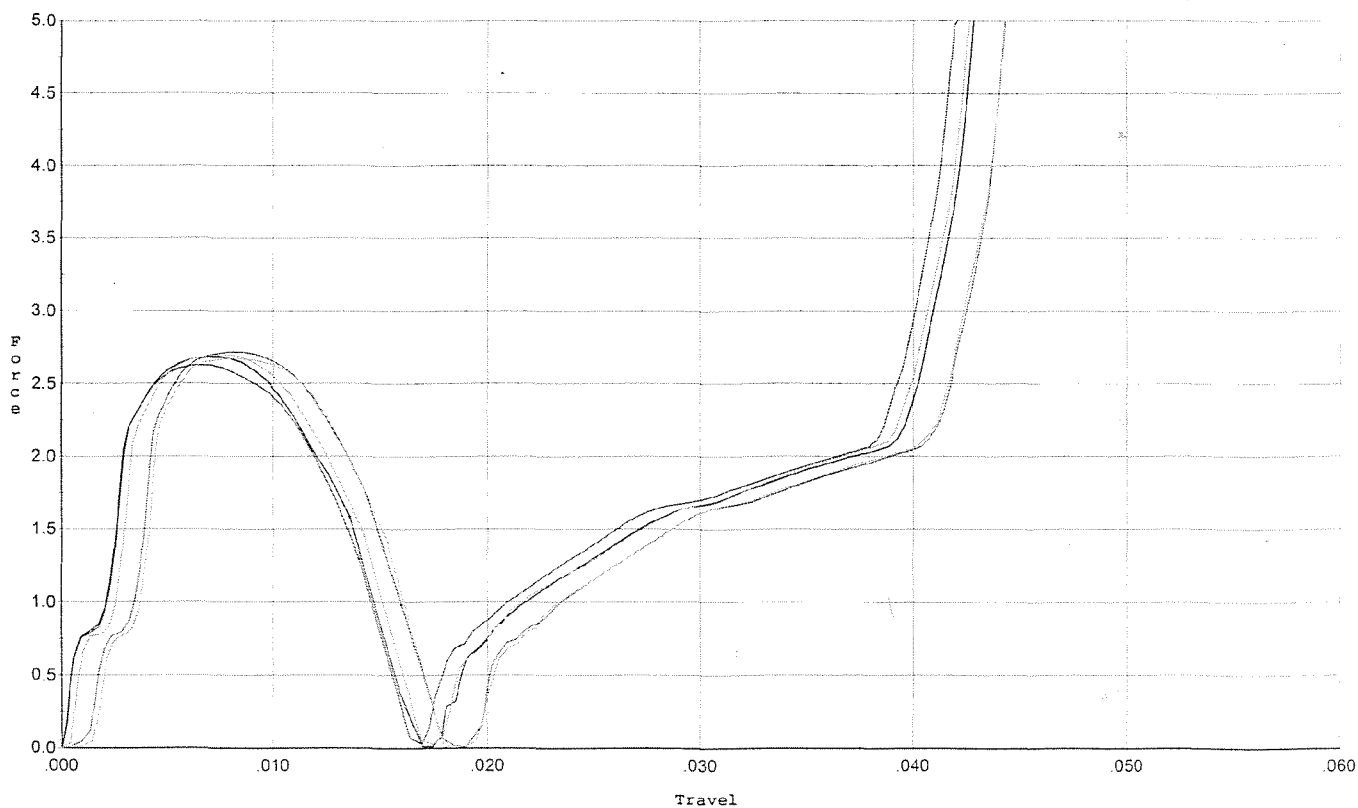
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-25-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3</u>	3-25-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-25-09	WV
	J) ASSEMBLE STOCK		3-23-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		3-25-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-24-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.54</u> <u>2.59</u> <u>2.48</u> <u>2.49</u>	3-24-09	TK
	C) FUNCTION		3-25-09	WV
690	PACK		3-27-09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



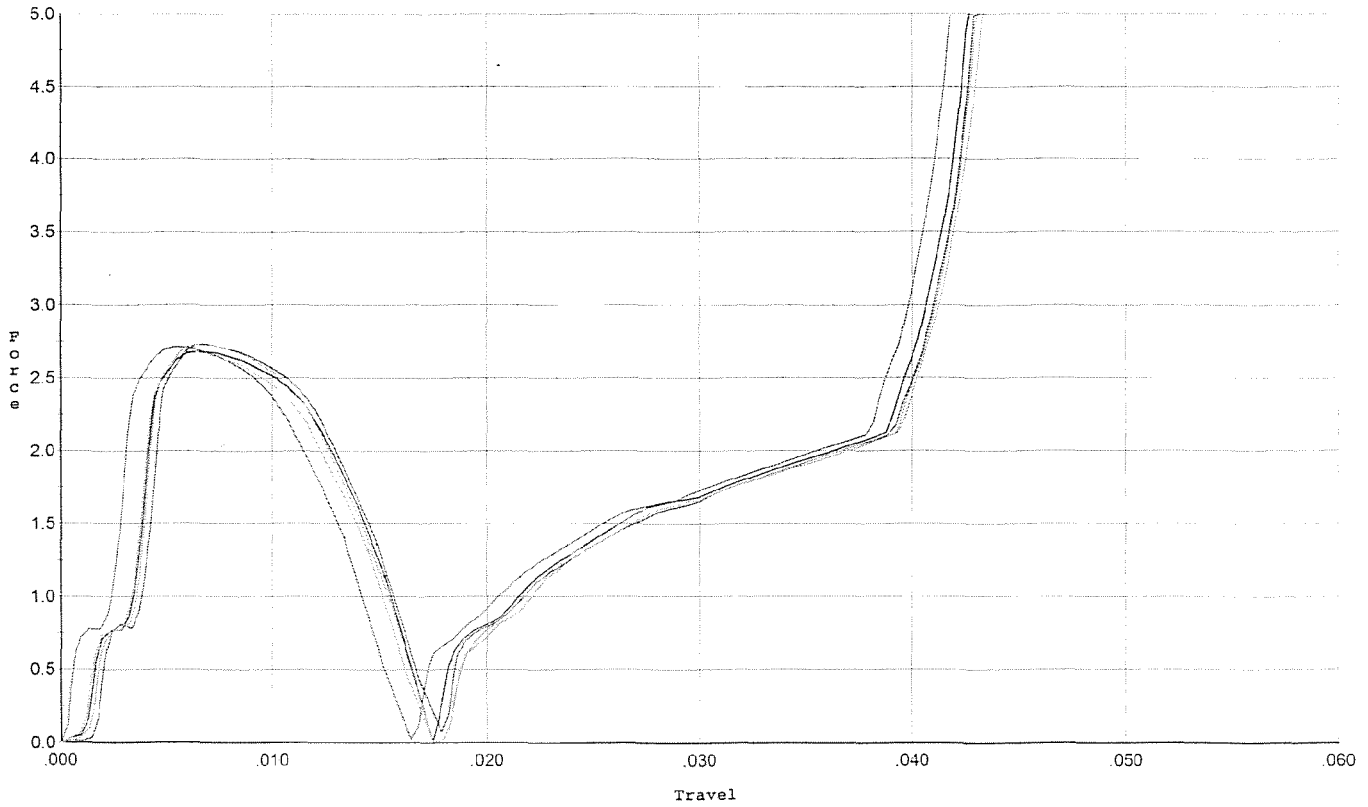
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.628	0.014	0.00	0.033	0.026		Set Trigger
2	2.687	0.014	0.00	0.034	0.026		Set Trigger
3	2.717	0.016	0.00	0.034	0.028		Set Trigger
4	2.673	0.015	0.00	0.034	0.027		Set Trigger
5	2.697	0.014	0.00	0.033	0.027		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs after 20 cycles+/- .50 lb



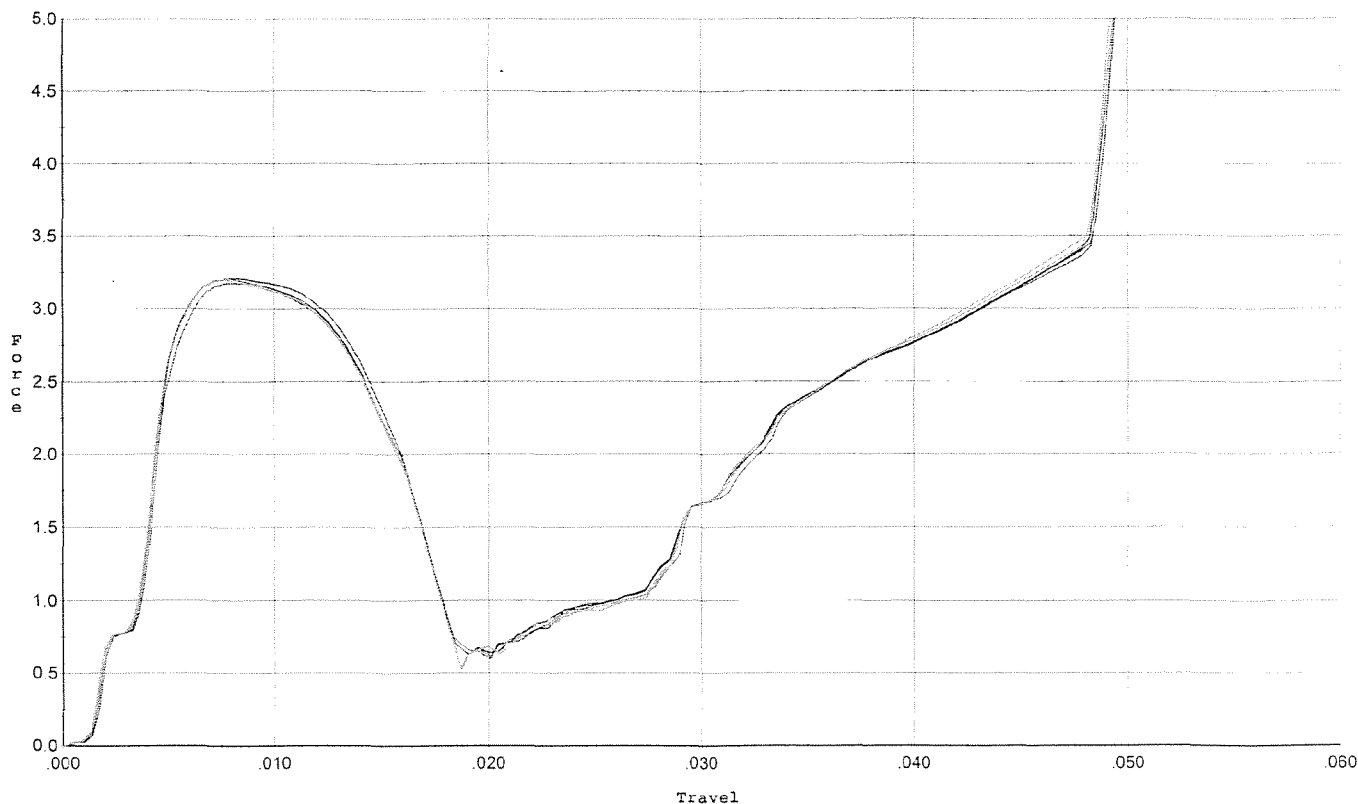
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.731	0.015	0.00	0.033	0.026		Set Trigger
2	2.680	0.015	0.00	0.033	0.026		Set Trigger
3	2.712	0.013	0.00	0.034	0.025		Set Trigger
4	2.682	0.014	0.00	0.034	0.025		Set Trigger
5	2.728	0.016	0.00	0.033	0.027		Set Trigger

A. 2.70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



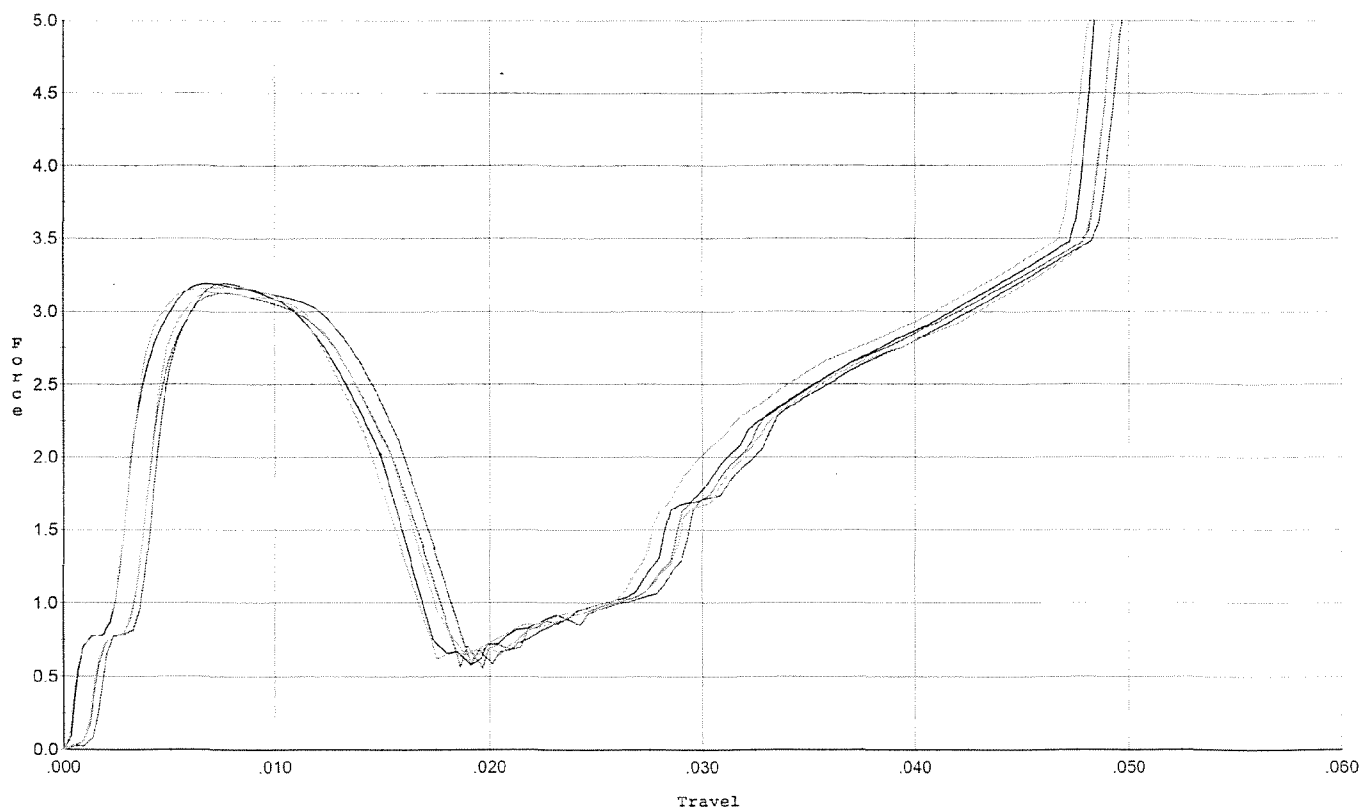
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.209	0.016	0.00	0.036	0.033		Set Trigger
2	3.199	0.016	0.00	0.036	0.033		Set Trigger
3	3.174	0.016	0.00	0.037	0.033		Set Trigger
4	3.196	0.016	0.00	0.036	0.033		Set Trigger
5	3.203	0.016	0.00	0.036	0.033		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



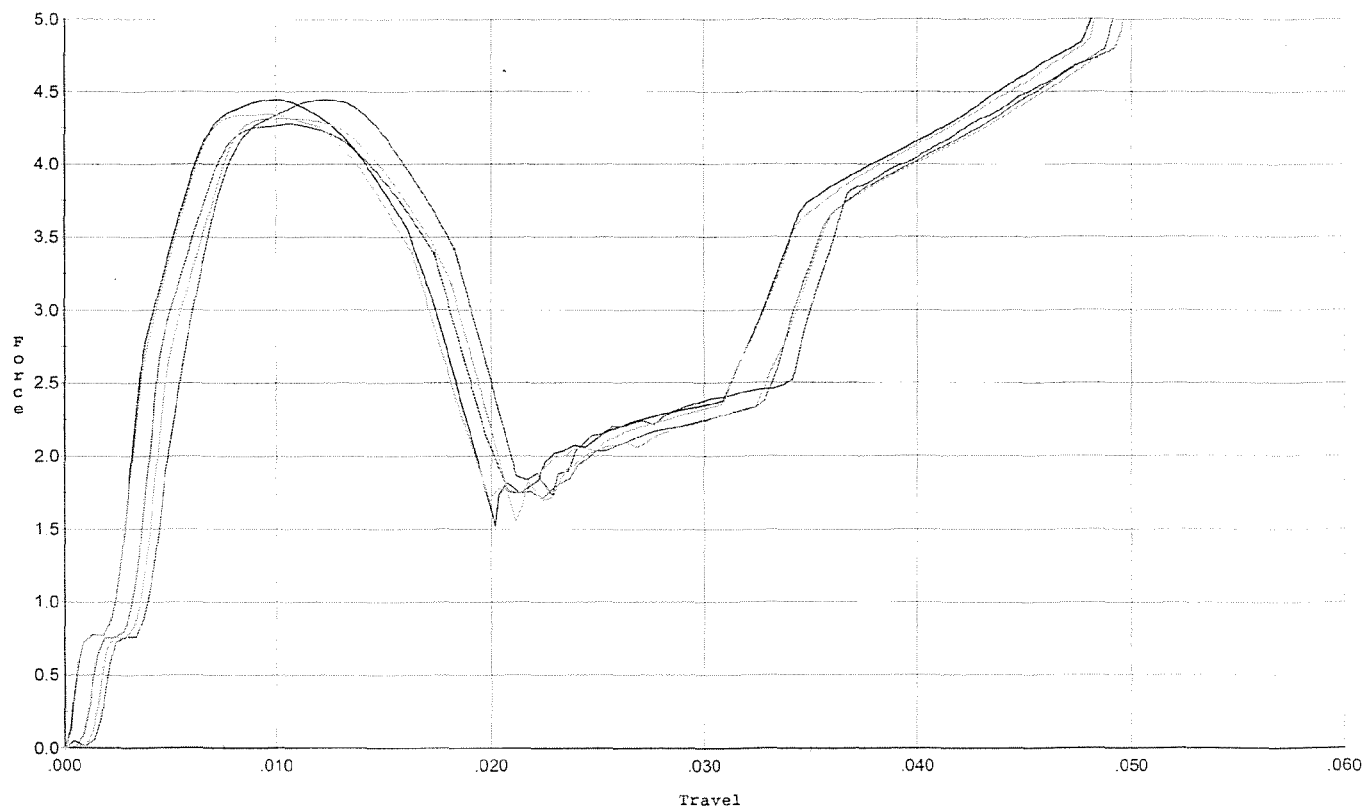
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.192	0.017	0.00	0.036	0.036		Set Trigger
2	3.193	0.015	0.00	0.036	0.033		Set Trigger
3	3.125	0.017	0.00	0.036	0.035		Set Trigger
4	3.131	0.015	0.00	0.037	0.032		Set Trigger
5	3.166	0.014	0.00	0.036	0.032		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



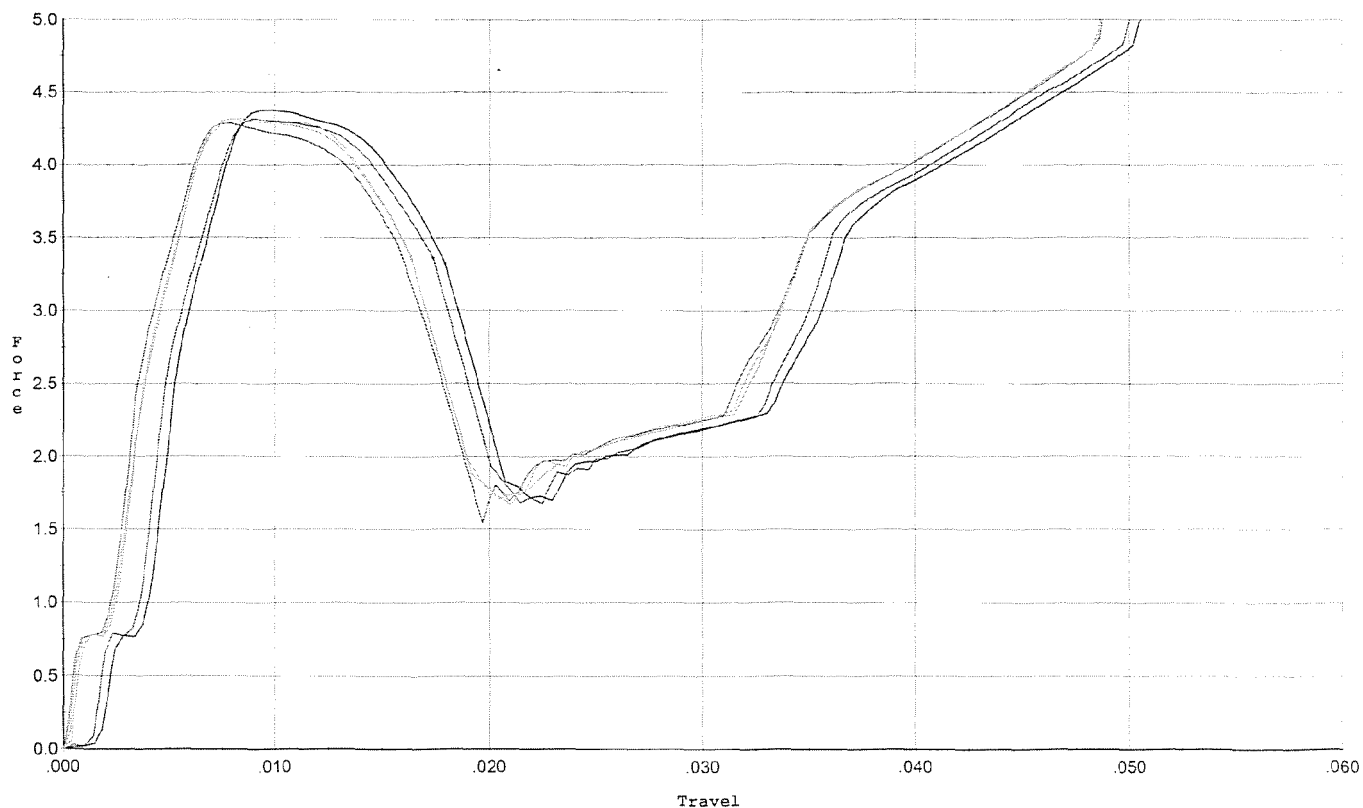
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.445	0.018	0.00	0.032	0.051		Set Trigger
2	4.449	0.017	0.00	0.032	0.052		Set Trigger
3	4.274	0.017	0.00	0.033	0.049		Set Trigger
4	4.345	0.016	0.00	0.032	0.048		Set Trigger
5	4.315	0.018	0.00	0.033	0.051		Set Trigger

A. 4.36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



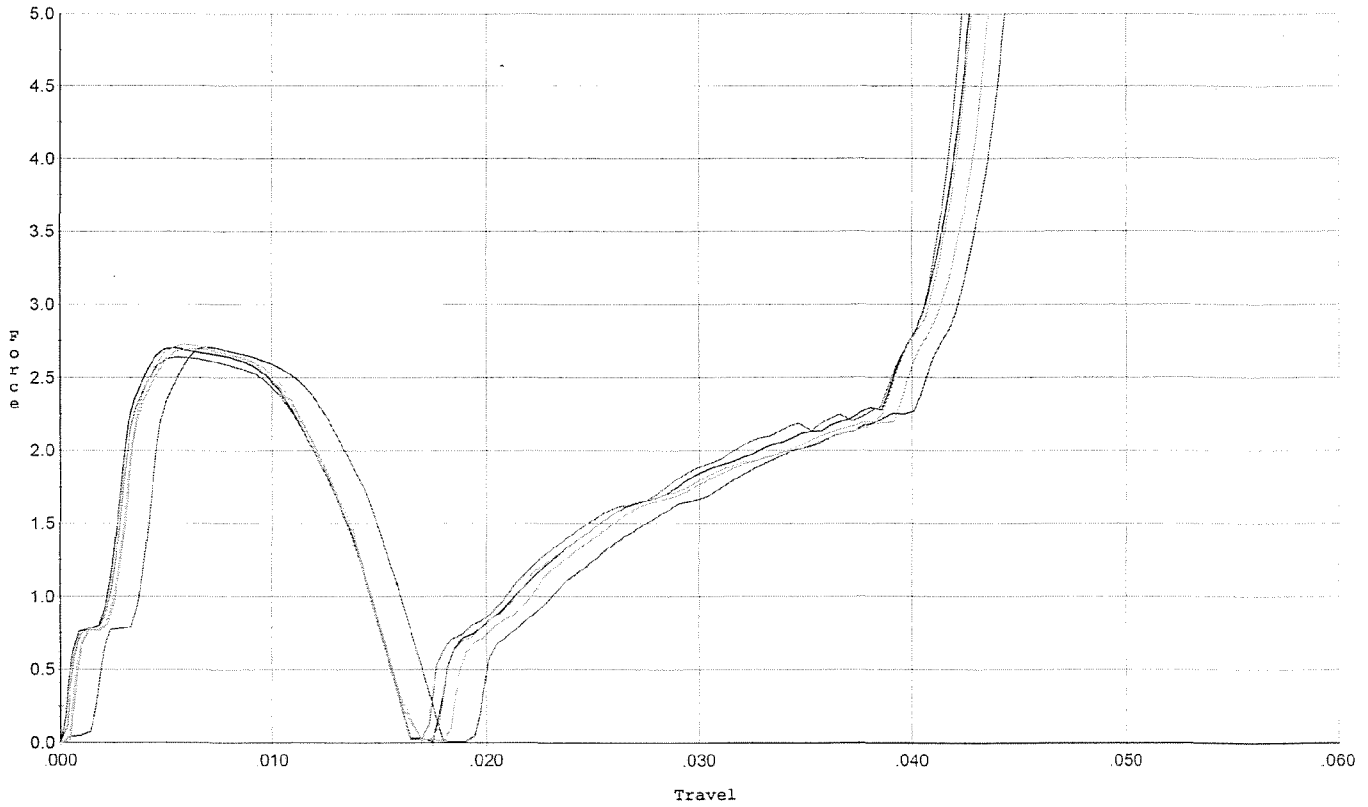
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.309	0.017	0.00	0.034	0.048		Set Trigger
2	4.377	0.018	0.00	0.034	0.049		Set Trigger
3	4.285	0.017	0.00	0.033	0.050		Set Trigger
4	4.317	0.016	0.00	0.033	0.048		Set Trigger
5	4.298	0.016	0.00	0.033	0.048		Set Trigger

A. 4.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



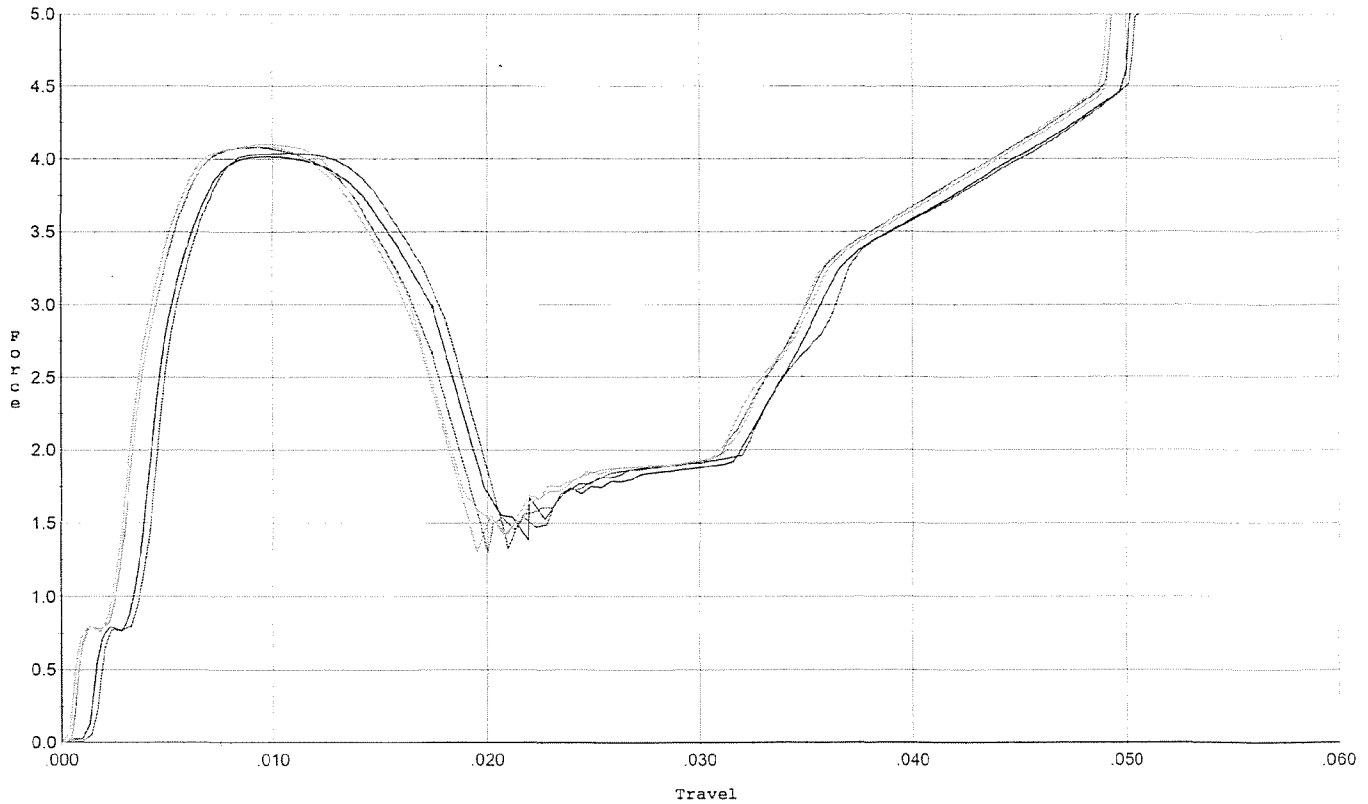
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.713	0.016	0.00	0.034	0.027		Set Trigger
2	2.704	0.014	0.00	0.033	0.026		Set Trigger
3	2.644	0.014	0.00	0.033	0.026		Set Trigger
4	2.726	0.014	0.00	0.034	0.026		Set Trigger
5	2.696	0.014	0.00	0.034	0.026		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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	4.038	0.018	0.00	0.034	0.048		Set Trigger
2	4.016	0.017	0.00	0.034	0.046		Set Trigger
3	4.082	0.017	0.00	0.034	0.049		Set Trigger
4	4.099	0.016	0.00	0.034	0.046		Set Trigger
5	4.088	0.017	0.00	0.034	0.047		Set Trigger

A-4.06