

G6801494

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



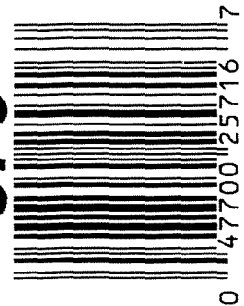
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801494

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 1494

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	R12
480	MAGNAFLUX BBL ACTION	(D)	3/9/09	(D)
490	MAGNAFLUX BOLT		3/9/09	AK
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		2-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/18	—
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		3-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

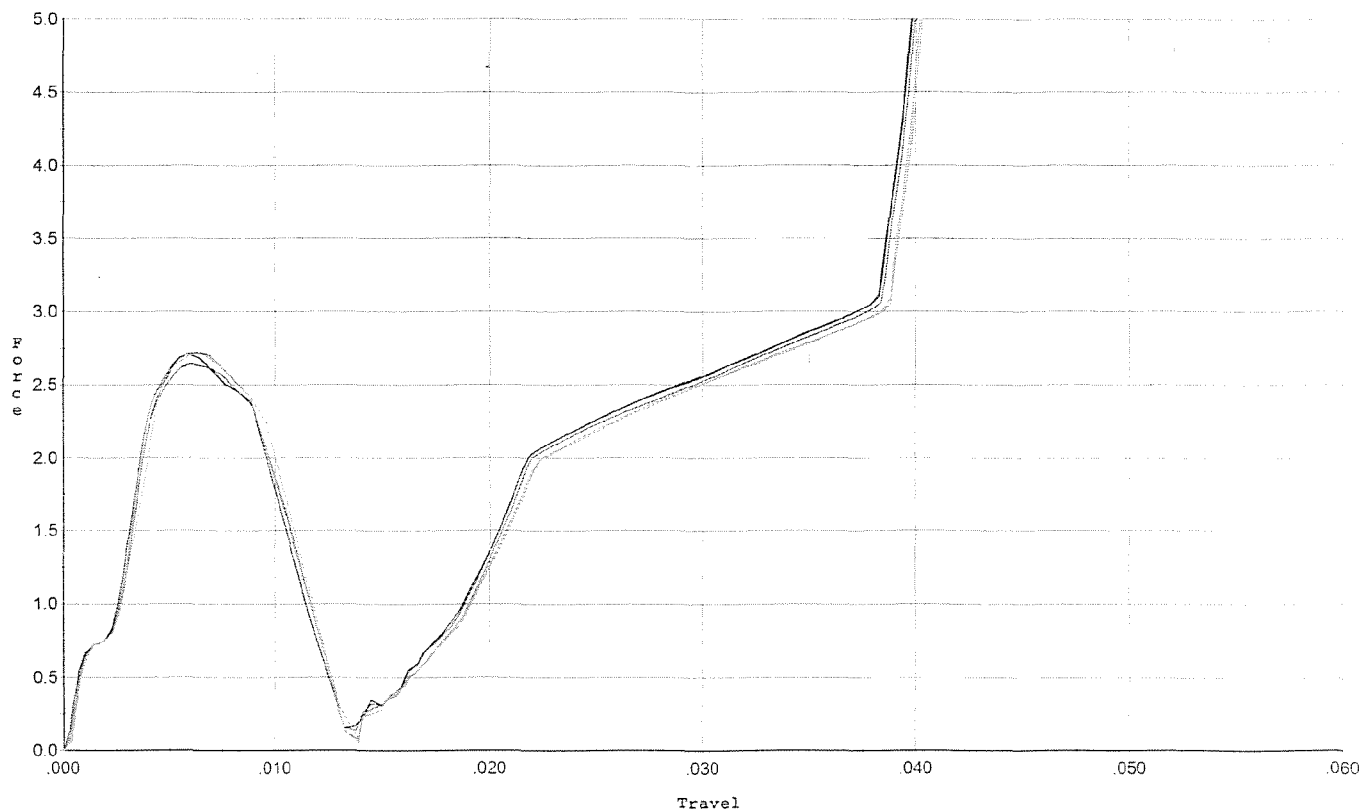
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-25-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-25-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	3-25-09	WN
	J) ASSEMBLE STOCK		3-20-09	DN
	K) ASSEMBLE SWIVEL STUDS		3-25-09	WN
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	3-24-09	TC
650	TARGET	<u>PASS</u> FAIL	3-23-09	TC
	MALFUNCTION <i>BAC</i>	CORRECTION	3-24-09	TC
	MALFUNCTION <i>OH</i>	CORRECTION	3-24-09	TC
	MALFUNCTION <i>no</i>	CORRECTION <i>no</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WN
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.59</u> <u>2.54</u> <u>2.46</u> <u>2.40</u>	3-24-09	TC
	C) FUNCTION		3-25-09	WN
690	PACK		3-25-09	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



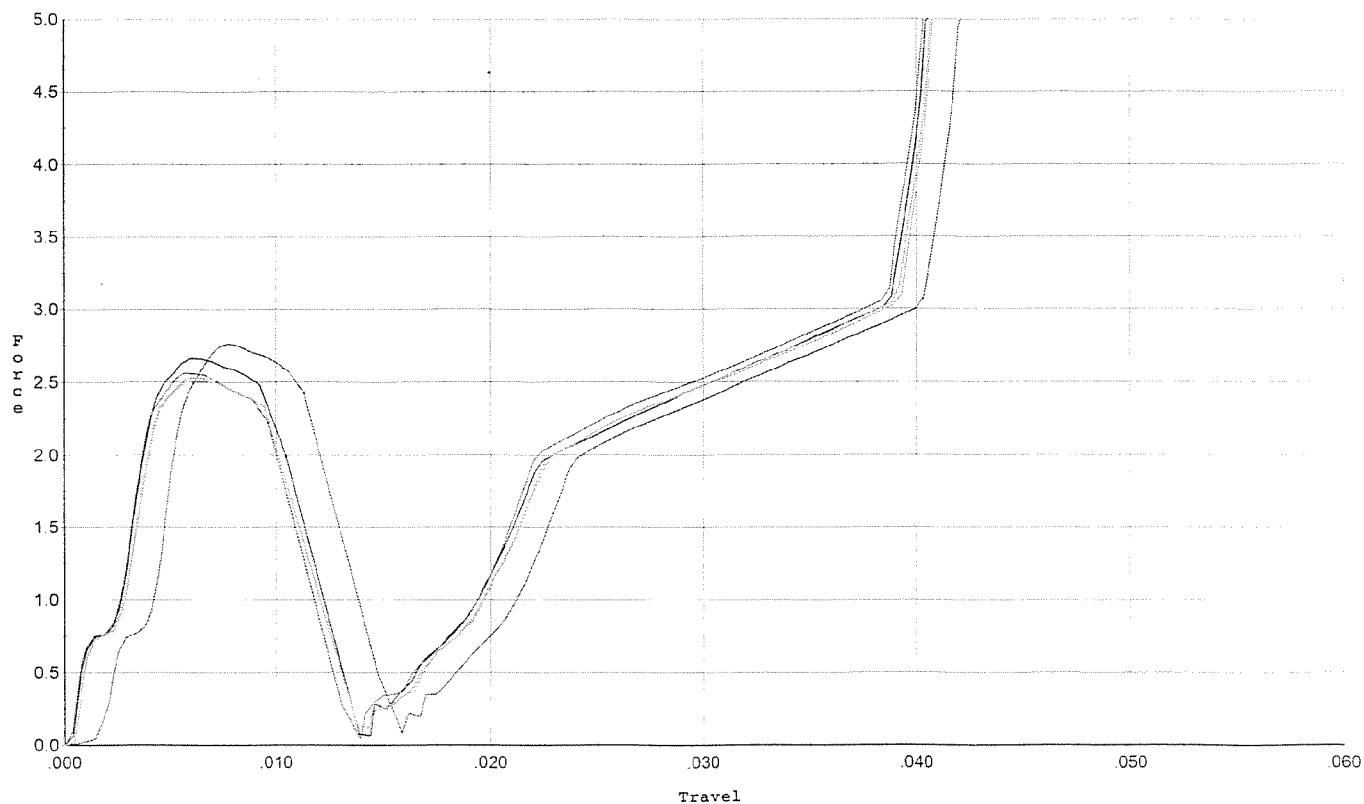
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.718	0.011	0.00	0.032	0.018		Set Trigger
2	2.712	0.009	0.00	0.033	0.015		Set Trigger
3	2.639	0.010	0.00	0.033	0.018		Set Trigger
4	2.716	0.010	0.00	0.033	0.016		Set Trigger
5	2.710	0.010	0.00	0.033	0.018		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



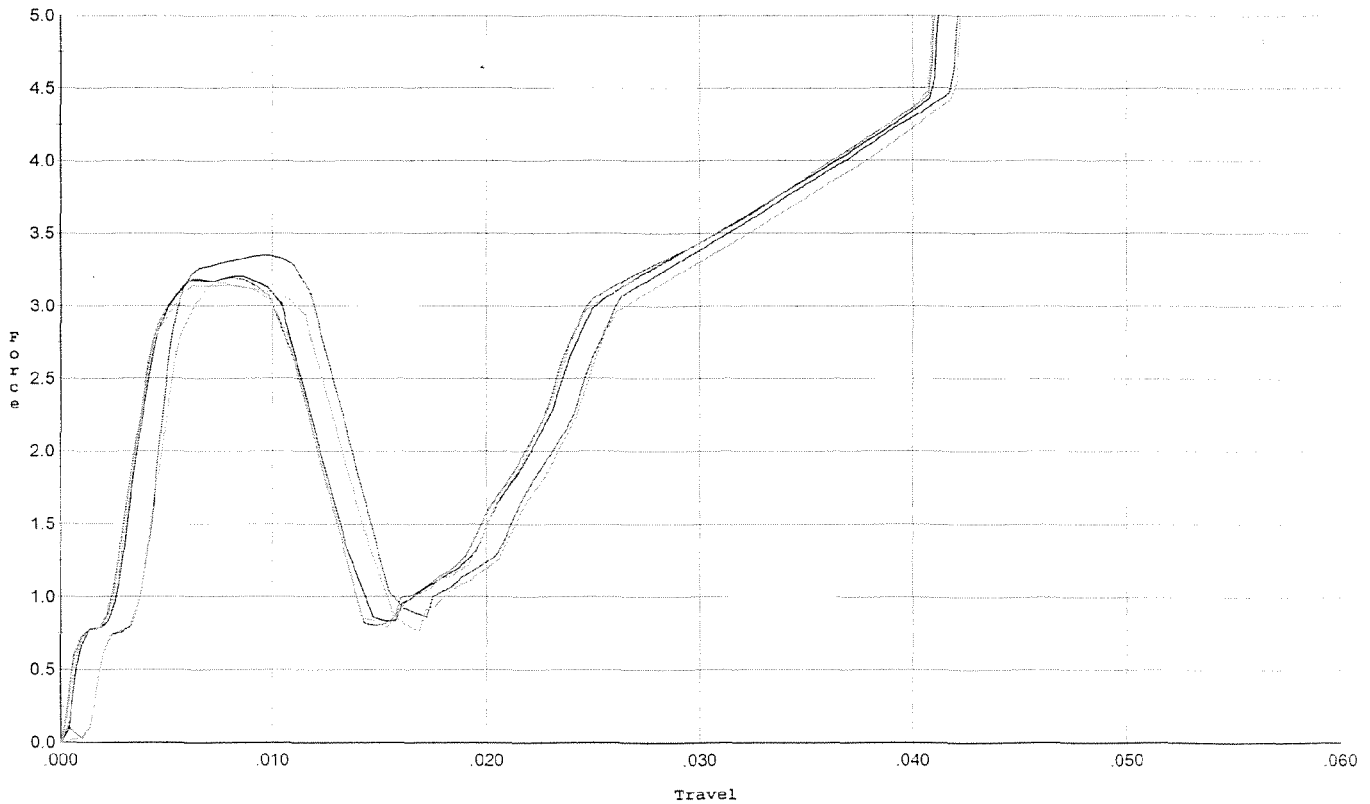
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.760	0.011	0.00	0.033	0.018		Set Trigger
2	2.664	0.010	0.00	0.033	0.018		Set Trigger
3	2.561	0.010	0.00	0.033	0.016		Set Trigger
4	2.507	0.009	0.00	0.033	0.015		Set Trigger
5	2.532	0.009	0.00	0.033	0.016		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



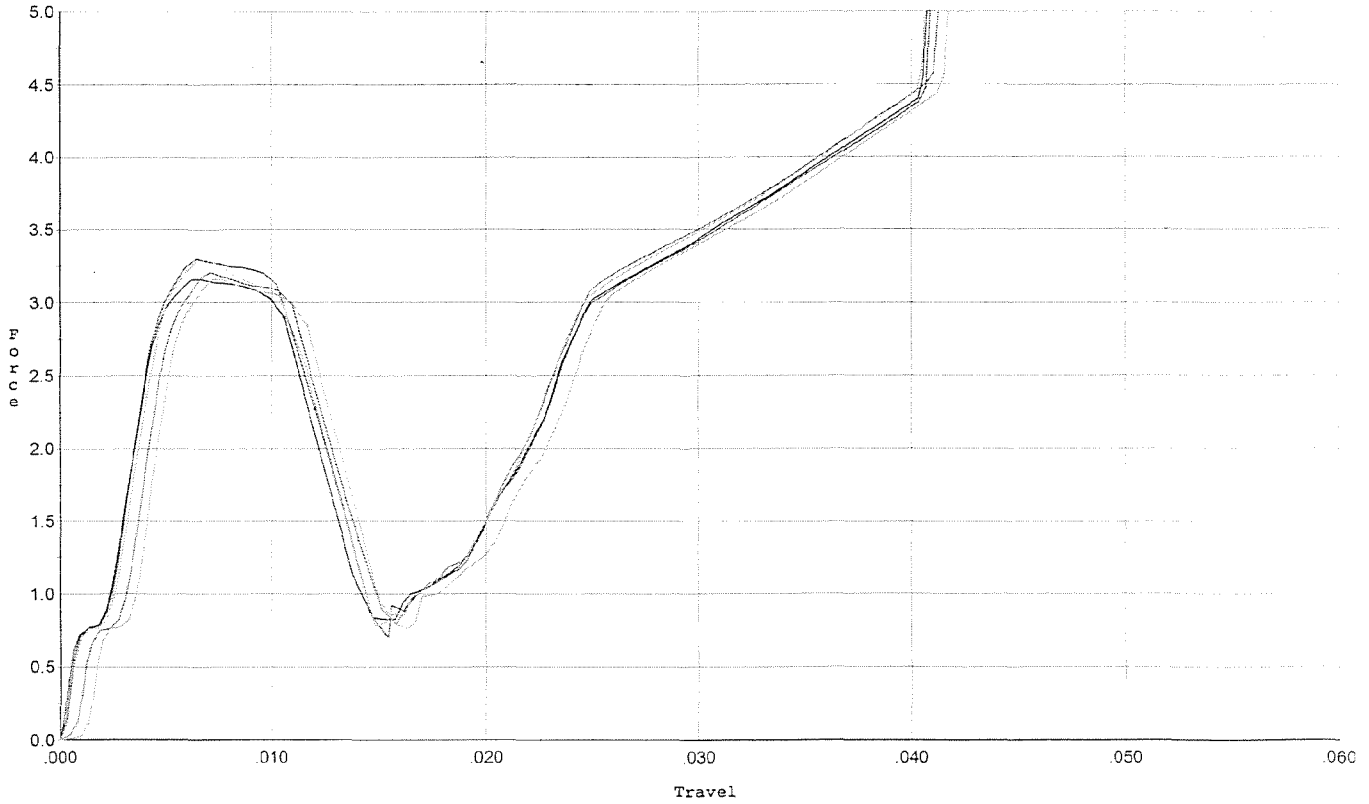
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.347	0.012	0.00	0.030	0.024		Set Trigger
2	3.203	0.010	0.00	0.031	0.022		Set Trigger
3	3.193	0.011	0.00	0.031	0.023		Set Trigger
4	3.142	0.011	0.00	0.030	0.022		Set Trigger
5	3.158	0.012	0.00	0.031	0.022		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



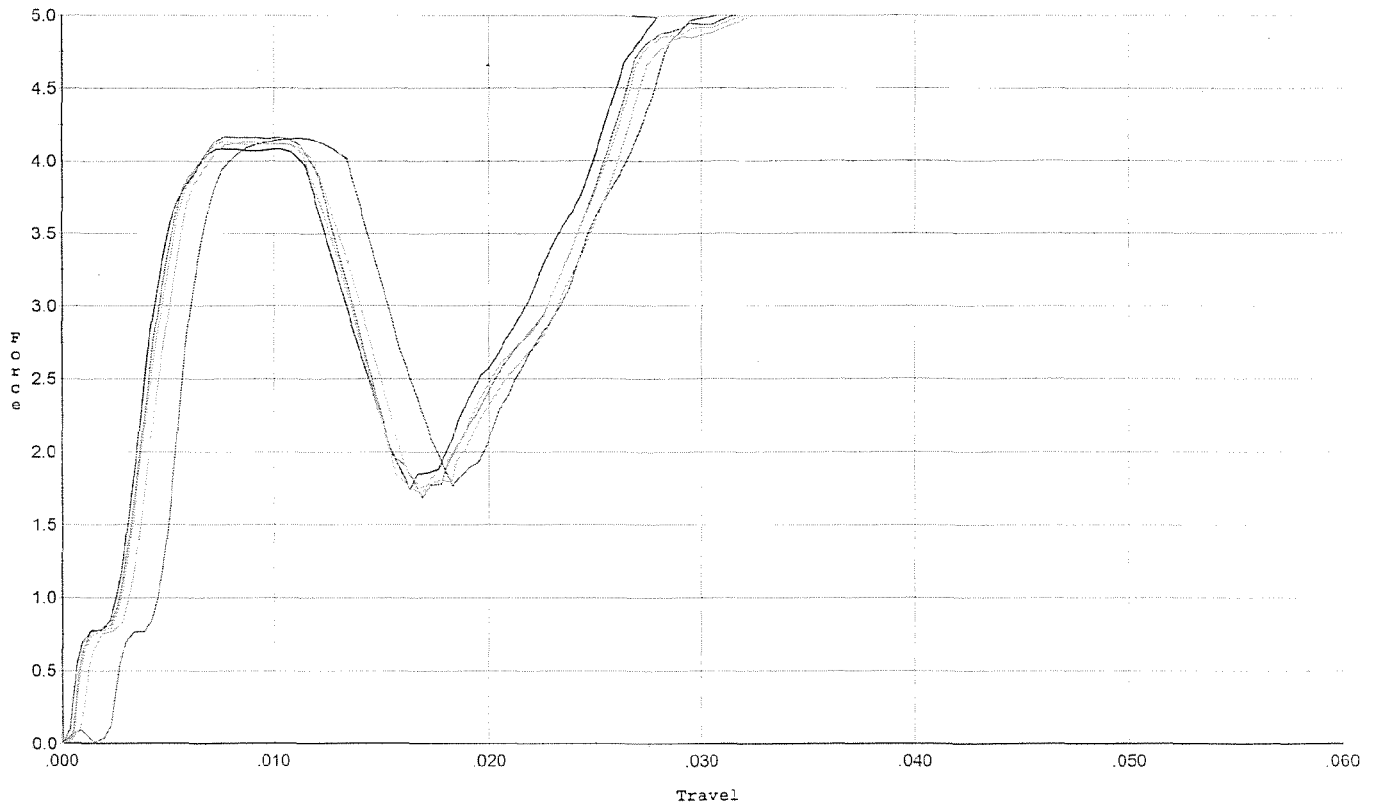
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.301	0.012	0.00	0.030	0.026		Set Trigger
2	3.156	0.011	0.00	0.030	0.022		Set Trigger
3	3.207	0.011	0.00	0.030	0.022		Set Trigger
4	3.292	0.012	0.00	0.030	0.025		Set Trigger
5	3.161	0.012	0.00	0.030	0.023		Set Trigger

A.3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



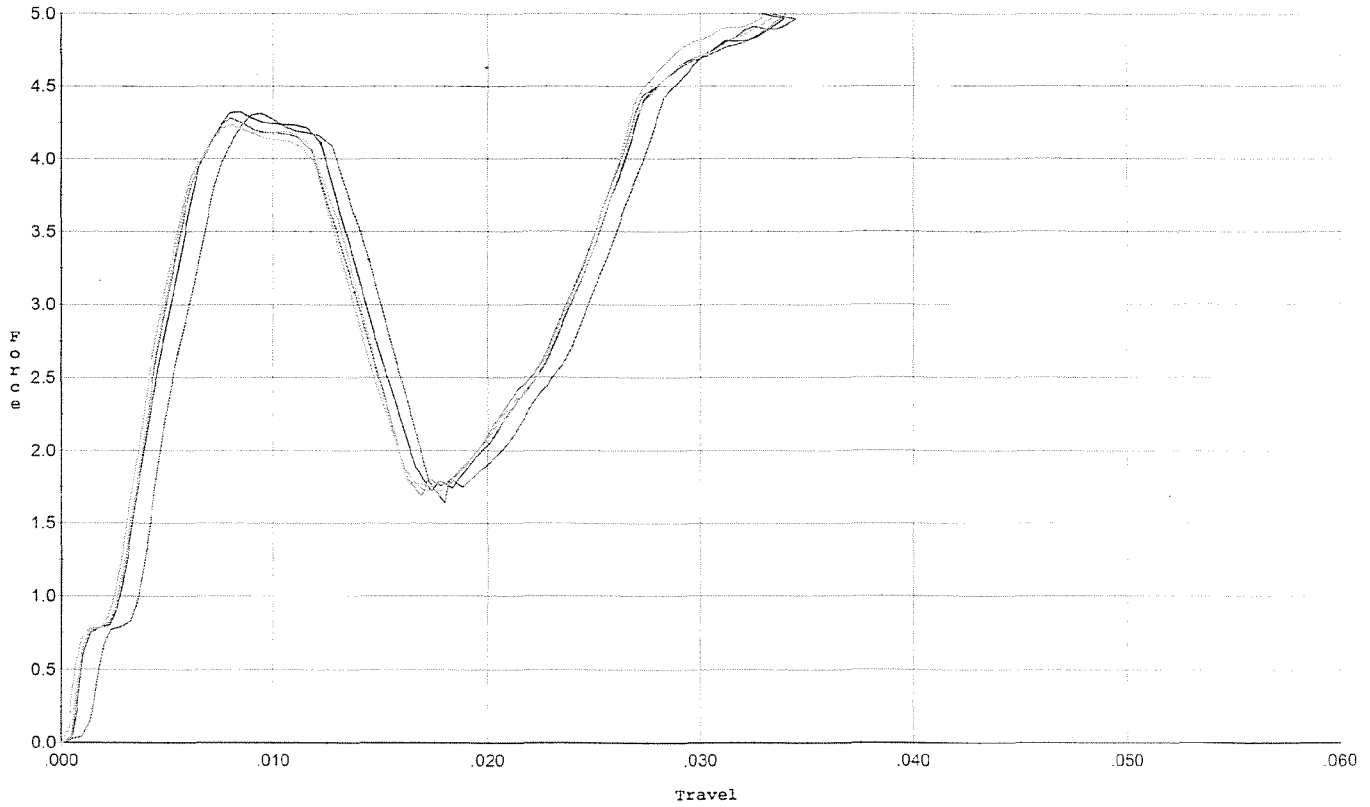
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.013	0.00	0.027	0.032		Set Trigger
2	4.085	0.011	0.00	0.026	0.030		Set Trigger
3	4.167	0.012	0.00	0.026	0.032		Set Trigger
4	4.135	0.013	0.00	0.026	0.033		Set Trigger
5	4.131	0.013	0.00	0.027	0.035		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



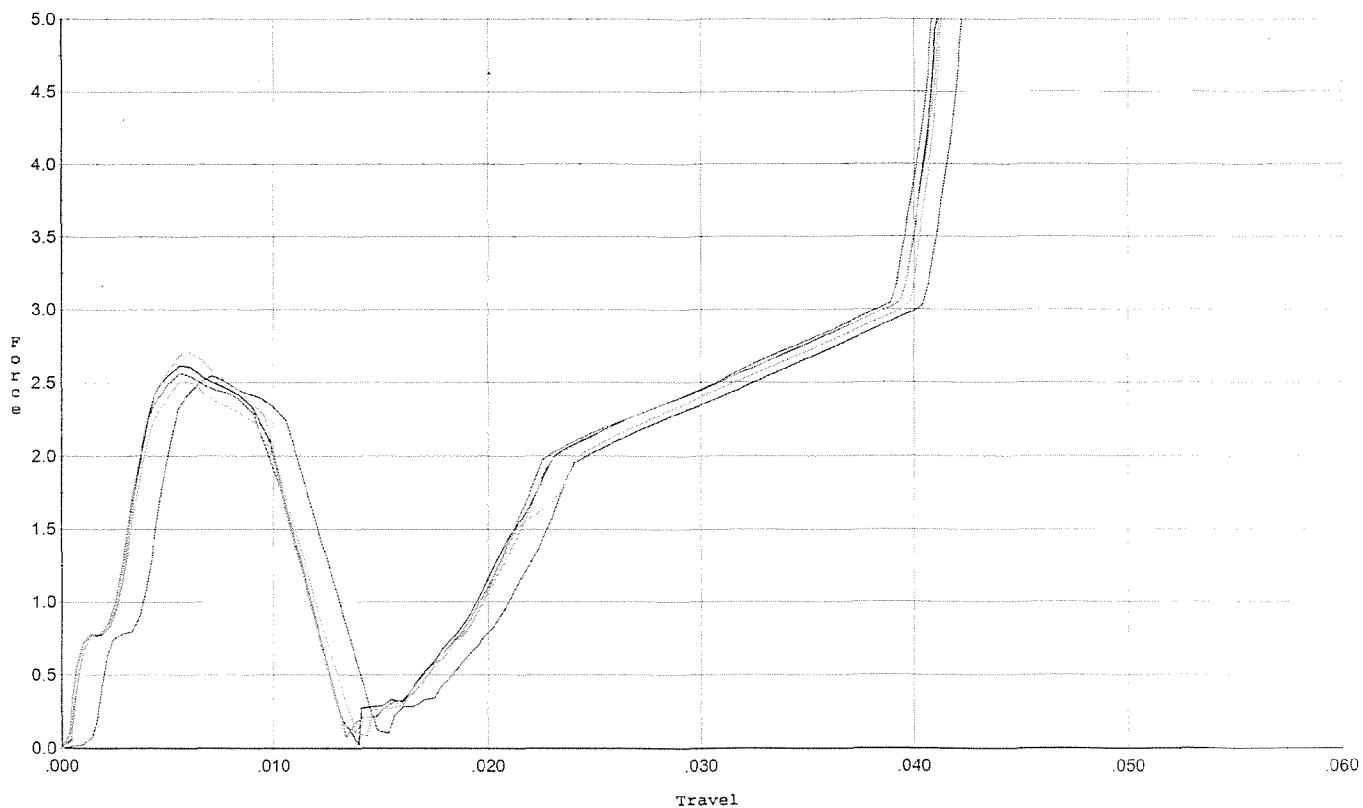
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.311	0.014	0.00	0.027	0.037		Set Trigger
2	4.324	0.012	0.00	0.027	0.033		Set Trigger
3	4.281	0.014	0.00	0.027	0.037		Set Trigger
4	4.234	0.013	0.00	0.027	0.035		Set Trigger
5	4.232	0.012	0.00	0.027	0.032		Set Trigger

A-4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



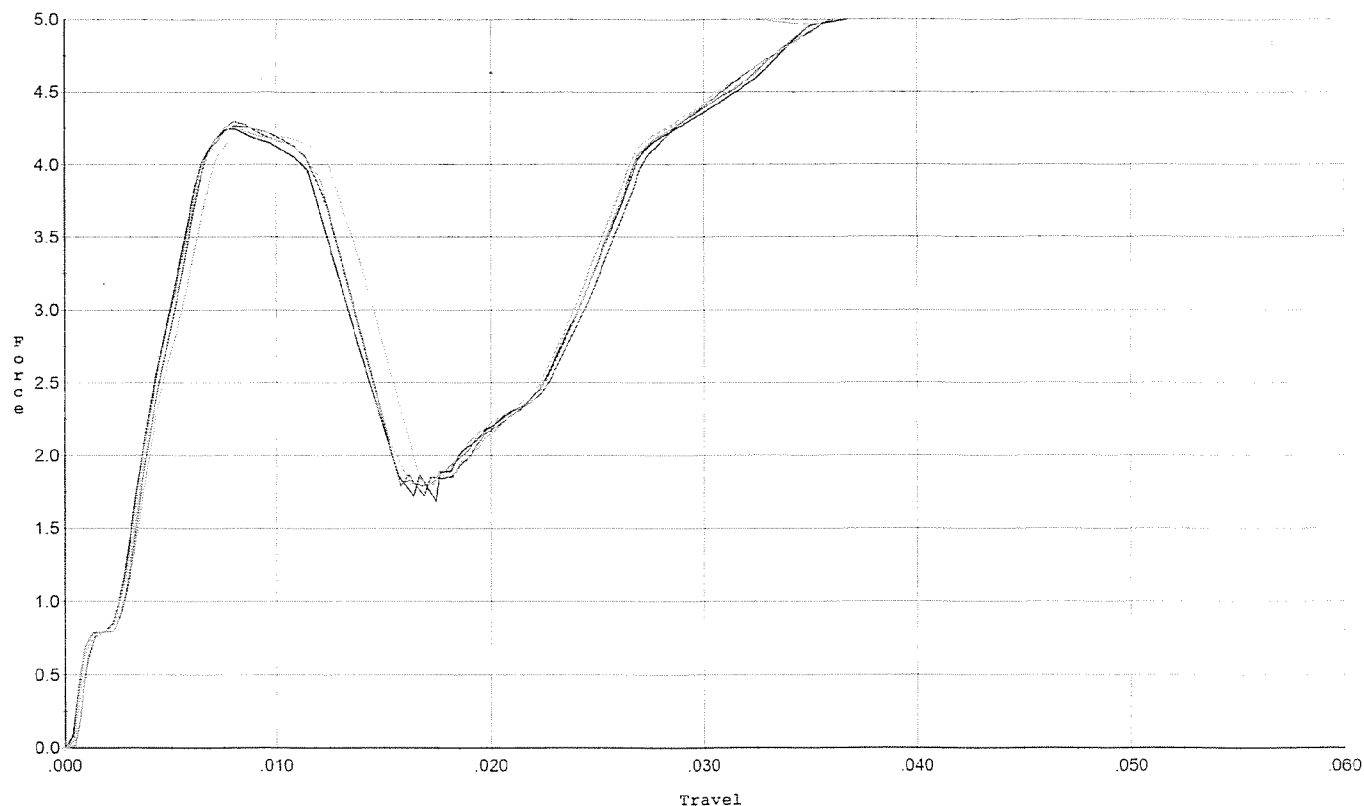
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.013	0.00	0.034	0.019		Set Trigger
2	2.612	0.010	0.00	0.034	0.017		Set Trigger
3	2.564	0.010	0.00	0.033	0.017		Set Trigger
4	2.719	0.010	0.00	0.034	0.016		Set Trigger
5	2.515	0.010	0.00	0.034	0.016		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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	4.269	0.012	0.00	0.028	0.032		Set Trigger
2	4.245	0.011	0.00	0.028	0.030		Set Trigger
3	4.298	0.012	0.00	0.027	0.032		Set Trigger
4	4.261	0.012	0.00	0.027	0.032		Set Trigger
5	4.253	0.014	0.00	0.027	0.037		Set Trigger

A - 4.26