

G6861337

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



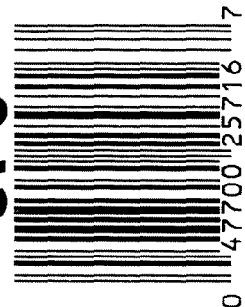
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801337

UPC



GUN SERIAL #

G 6801337

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	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
490	MAGNAFLUX BOLT			
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)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-28-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

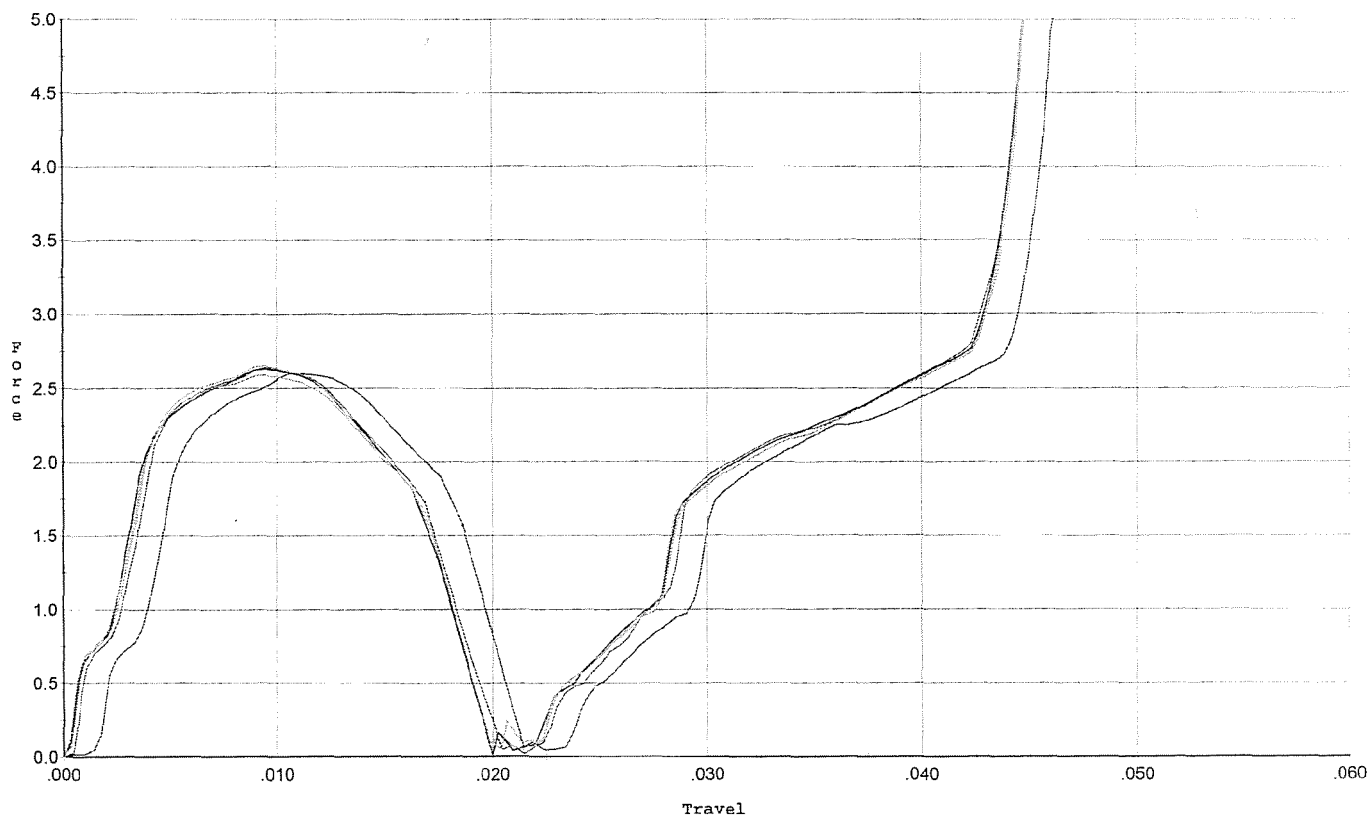
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6-5</u>	4-1-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	4-1-09	WV
	J) ASSEMBLE STOCK		3-28-09	RPD
	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-31-09	RPD
	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>2.21</u> <u>2.17</u> <u>2.14</u> <u>2.21</u> <u>2.20</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		5/28/09	Fy

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



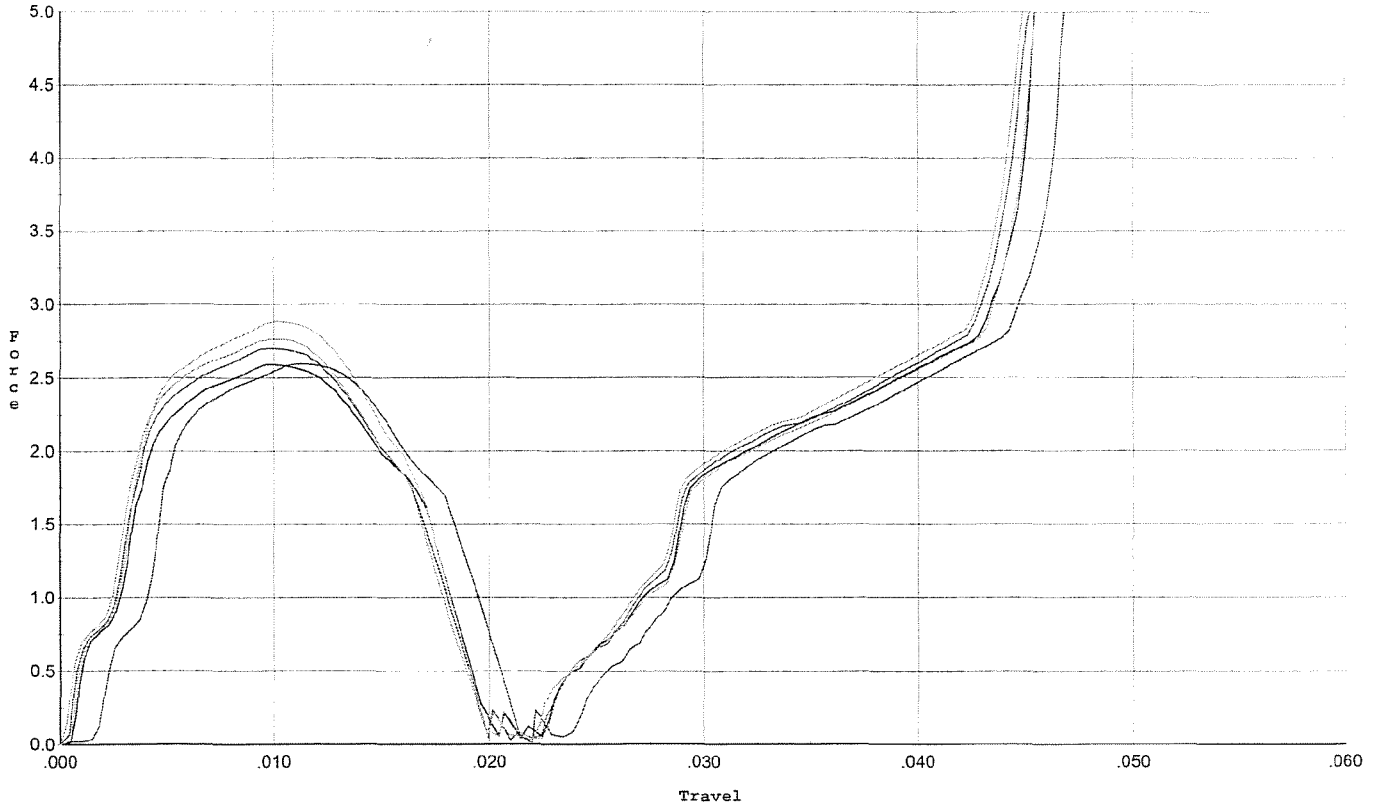
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.019	0.00	0.032	0.033		Set Trigger
2	2.631	0.017	0.00	0.032	0.033		Set Trigger
3	2.642	0.017	0.00	0.032	0.032		Set Trigger
4	2.653	0.017	0.00	0.032	0.032		Set Trigger
5	2.588	0.017	0.00	0.032	0.032		Set Trigger

1A-2-62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/28/2009

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



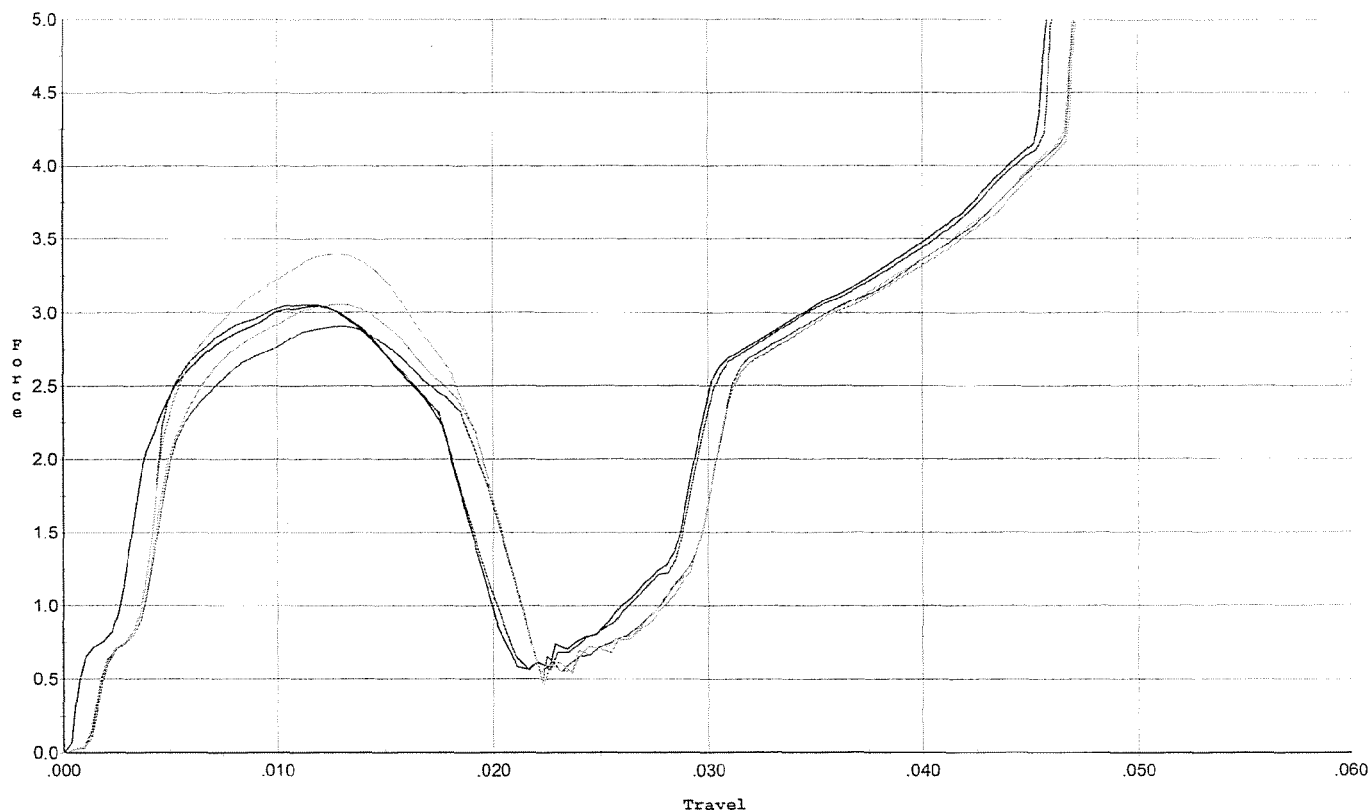
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.596	0.019	0.00	0.033	0.033		Set Trigger
2	2.589	0.017	0.00	0.033	0.031		Set Trigger
3	2.699	0.018	0.00	0.032	0.034		Set Trigger
4	2.886	0.017	0.00	0.032	0.034		Set Trigger
5	2.766	0.016	0.00	0.032	0.032		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



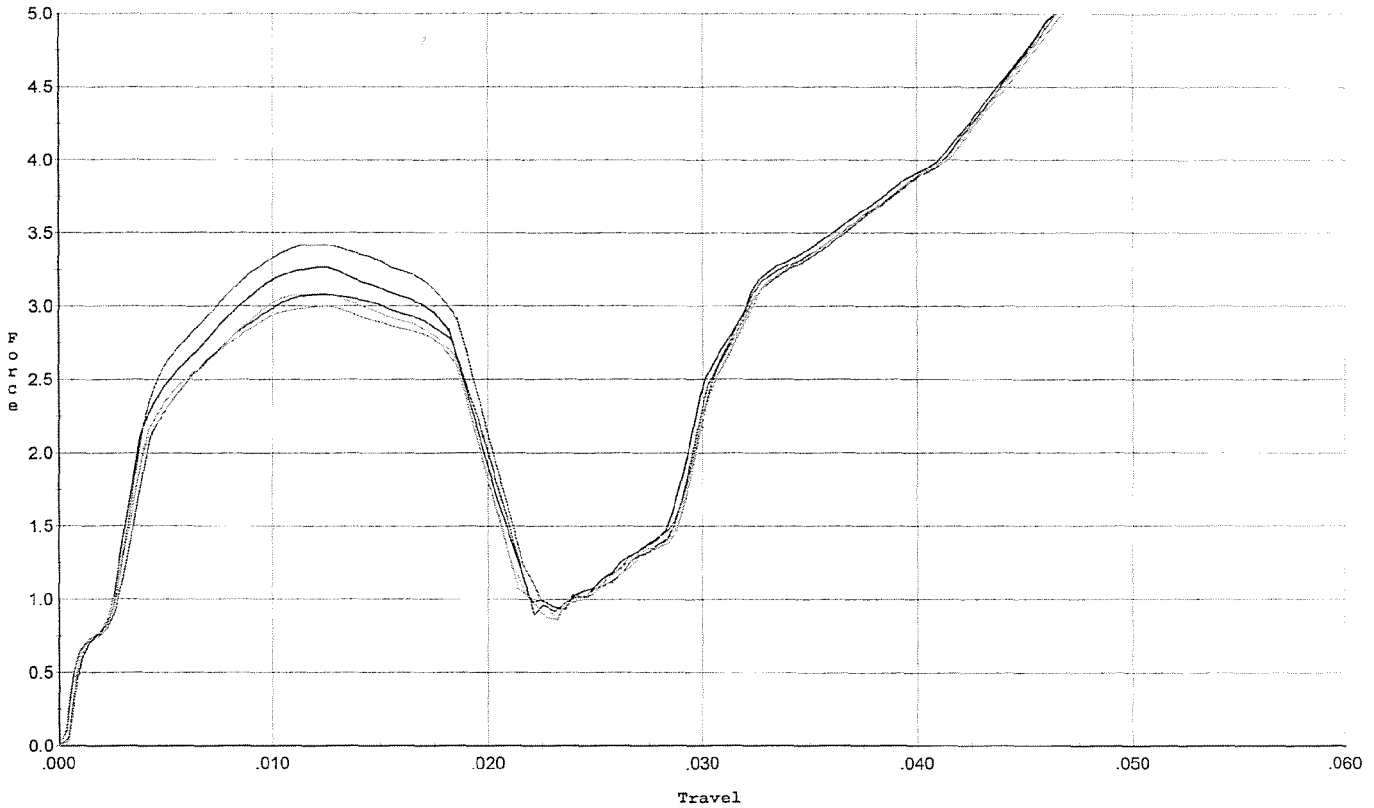
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.055	0.017	0.00	0.031	0.036		Set Trigger
2	3.045	0.018	0.00	0.031	0.038		Set Trigger
3	2.907	0.020	0.00	0.031	0.039		Set Trigger
4	3.398	0.019	0.00	0.031	0.043		Set Trigger
5	3.057	0.019	0.00	0.031	0.040		Set Trigger

A-3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/28/2009

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



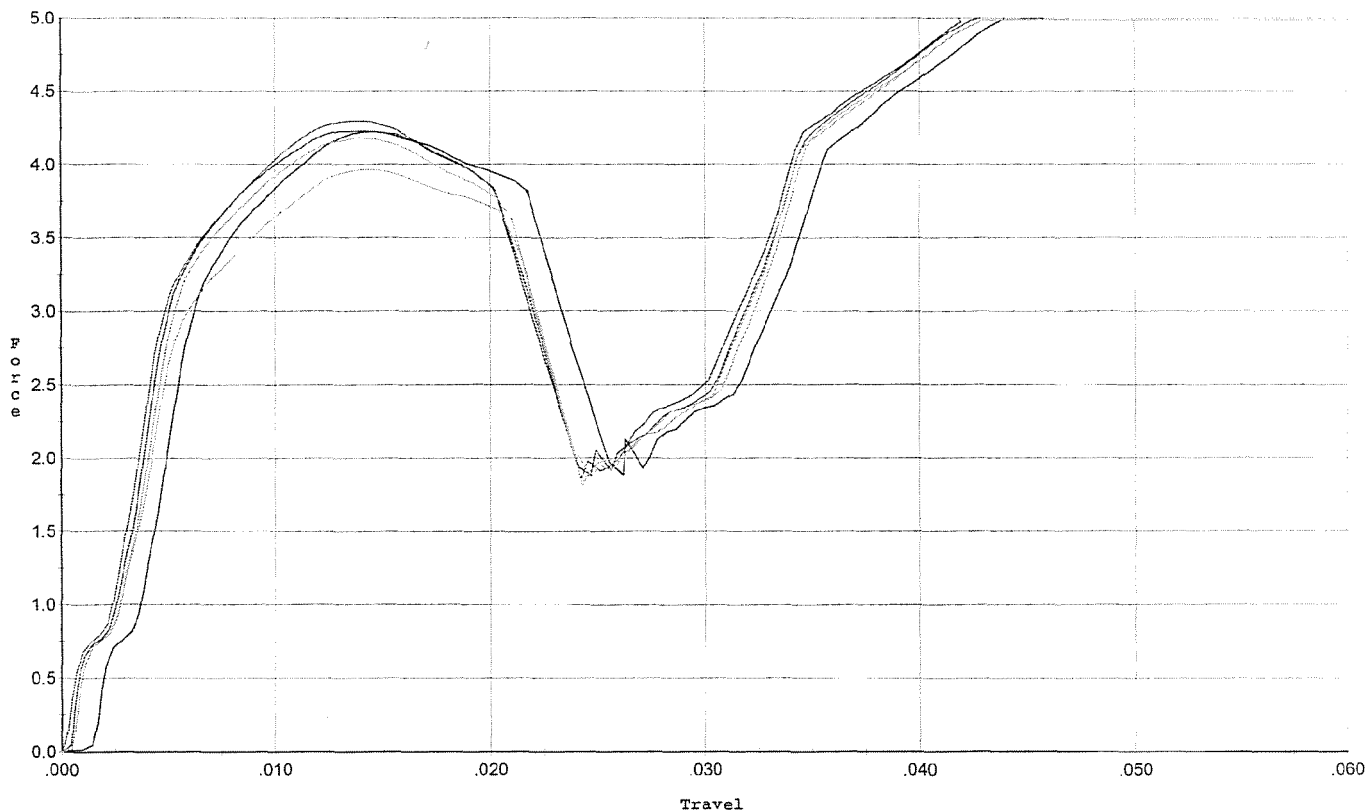
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.080	0.020	0.00	0.030	0.044		Set Trigger
2	3.267	0.018	0.00	0.030	0.043		Set Trigger
3	3.418	0.019	0.00	0.030	0.046		Set Trigger
4	3.090	0.018	0.00	0.030	0.041		Set Trigger
5	3.002	0.019	0.00	0.030	0.041		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



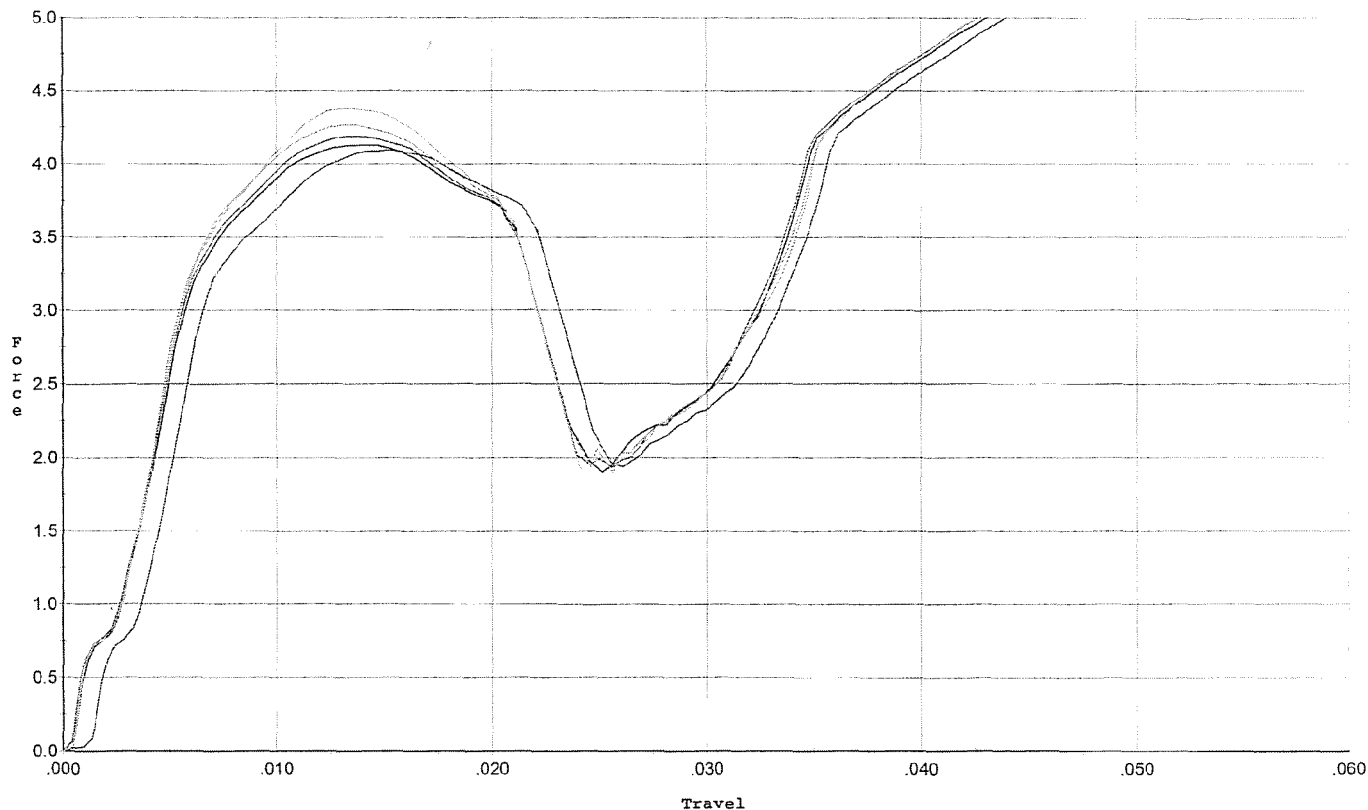
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.229	0.020	0.00	0.027	0.061		Set Trigger
2	4.223	0.022	0.00	0.028	0.063		Set Trigger
3	4.296	0.022	0.00	0.027	0.067		Set Trigger
4	3.962	0.021	0.00	0.028	0.060		Set Trigger
5	4.178	0.021	0.00	0.028	0.062		Set Trigger

A-4-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



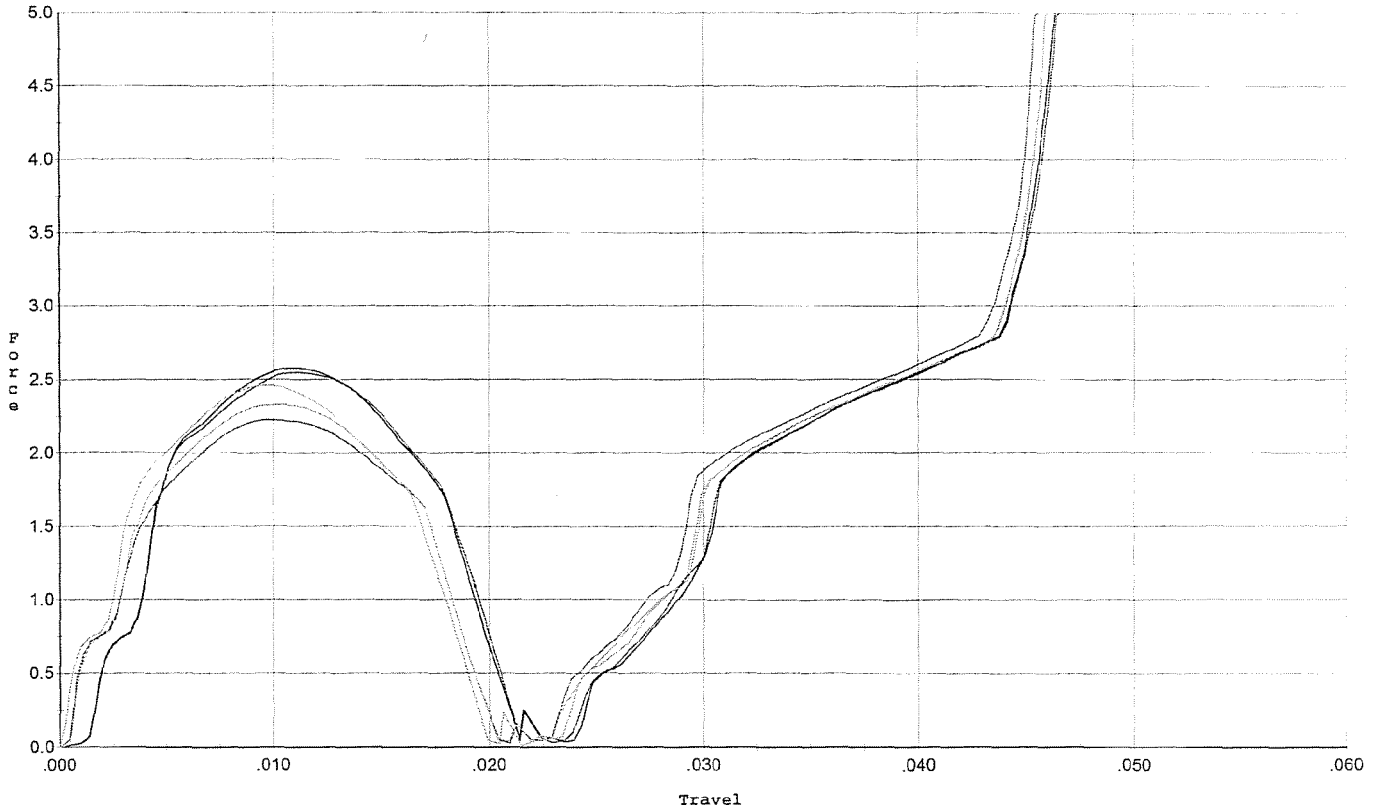
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.022	0.00	0.028	0.062		Set Trigger
2	4.127	0.021	0.00	0.028	0.061		Set Trigger
3	4.188	0.021	0.00	0.028	0.062		Set Trigger
4	4.383	0.021	0.00	0.028	0.064		Set Trigger
5	4.266	0.021	0.00	0.028	0.063		Set Trigger

A. 4.21

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/28/2009

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



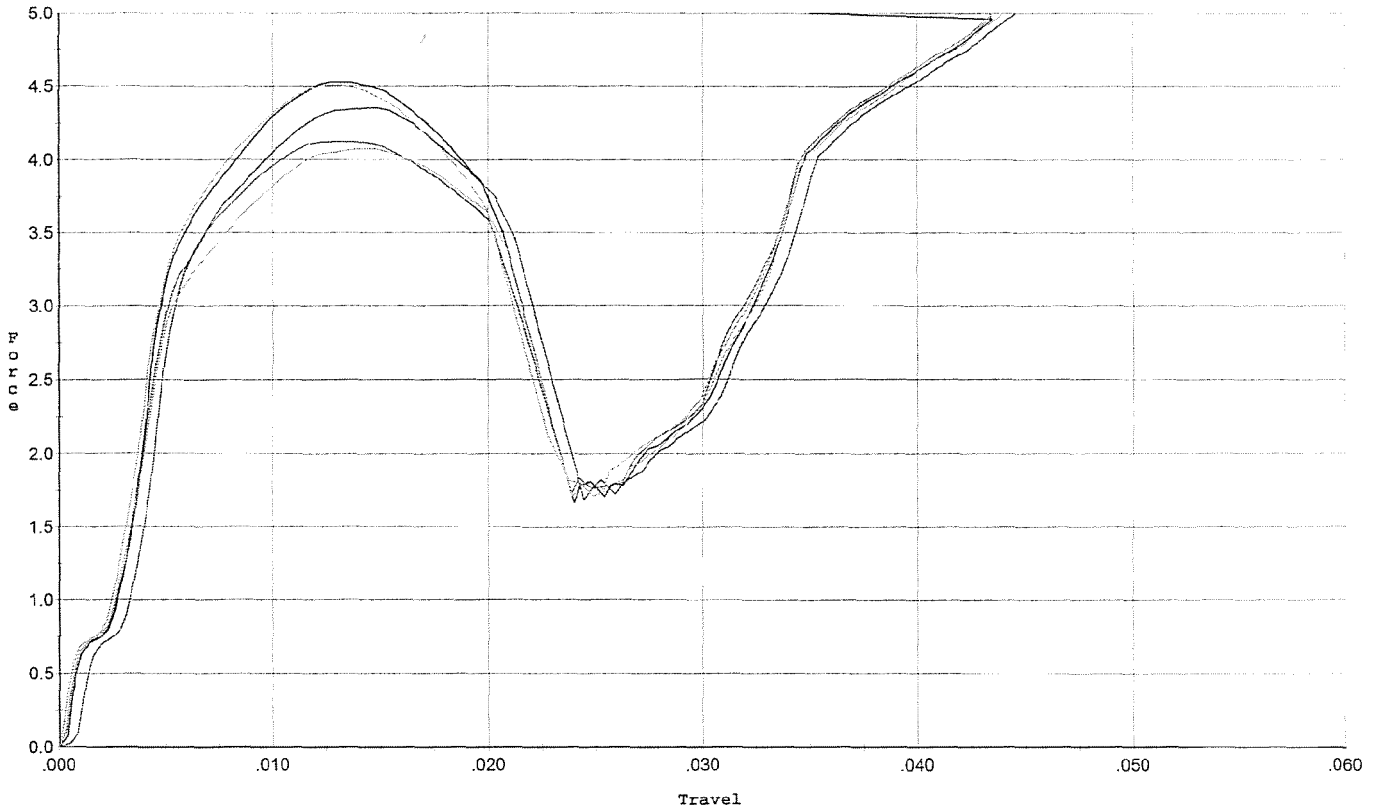
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.019	0.00	0.032	0.033		Set Trigger
2	2.579	0.018	0.00	0.033	0.031		Set Trigger
3	2.226	0.017	0.00	0.033	0.028		Set Trigger
4	2.461	0.018	0.00	0.033	0.032		Set Trigger
5	2.329	0.017	0.00	0.033	0.029		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/28/2009

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	4.351	0.021	0.00	0.028	0.063		Set Trigger
2	4.526	0.021	0.00	0.028	0.065		Set Trigger
3	4.120	0.022	0.00	0.028	0.063		Set Trigger
4	4.076	0.021	0.00	0.028	0.060		Set Trigger
5	4.507	0.020	0.00	0.028	0.062		Set Trigger

A-4.31