

G6801343

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



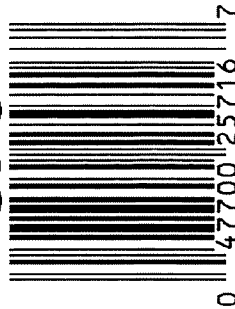
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801343

UPC



GUN SERIAL # G 6801343

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RJZ
430	ASSEMBLE TO STOCK		3-6-09	RJZ
440	PROOF		3-6-09	TE
460	CHECK HEADSPACE		3-6-09	TE
470	DIS-ASSEMBLE ACTION		3-6-09	RJZ
472	SERIALIZE BOLT HANDLE		3-6-09	RJZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION	(D)	3/9/09	(D)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	my
542	APPLY COATINGS (BARREL ACTION)		3-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-24-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

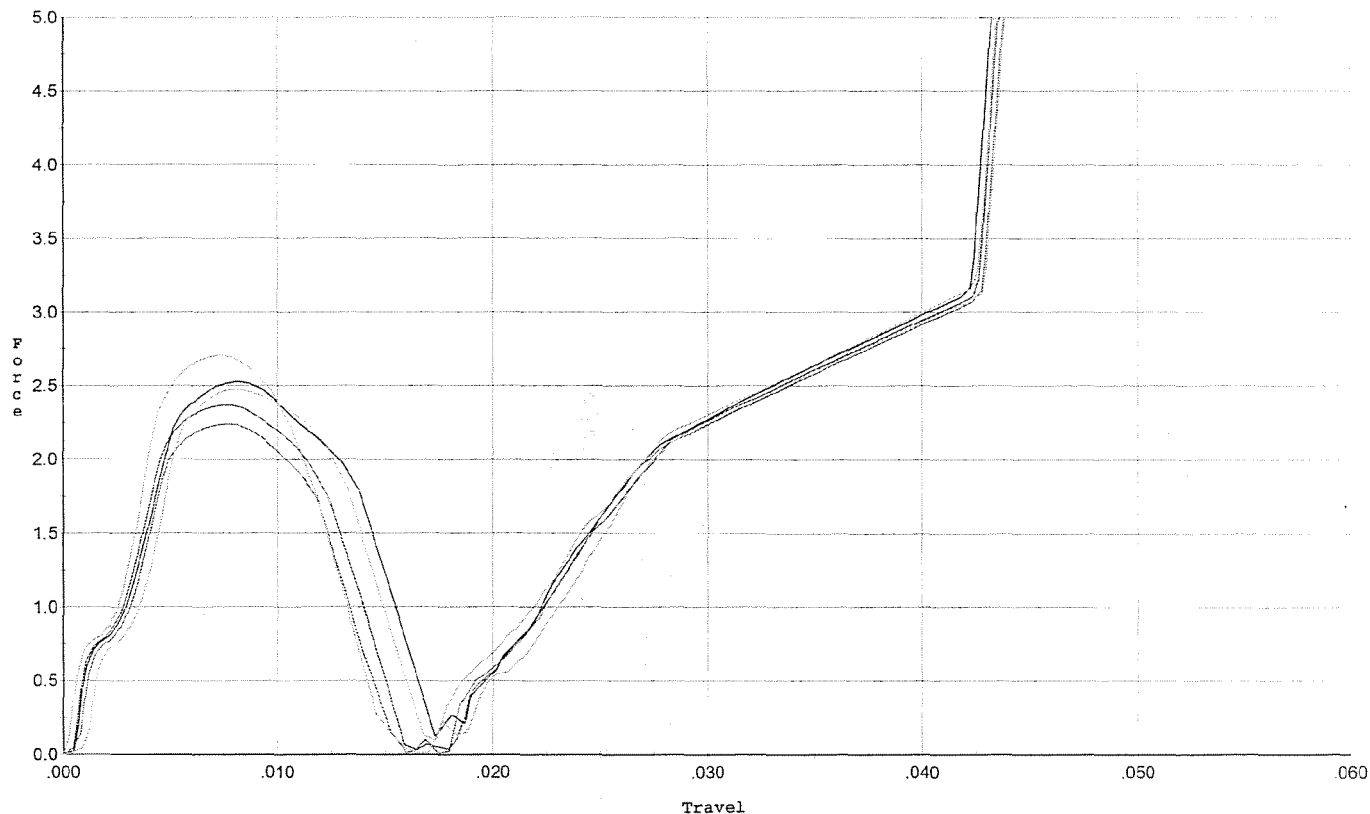
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	3-26-09	S.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	3-26-09	S.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.028</u> <u>.027</u>	3-26-09	S.P.D.
	J) ASSEMBLE STOCK		3-24-09	WV
	K) ASSEMBLE SWIVEL STUDS		3-26-09	S.P.D.
	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	3-25-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-26-09	S.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.35</u> <u>2.38</u> <u>2.42</u> <u>2.36</u>	3-25-09	TC
	C) FUNCTION		3-26-09	S.P.D.
690	PACK		3/27/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



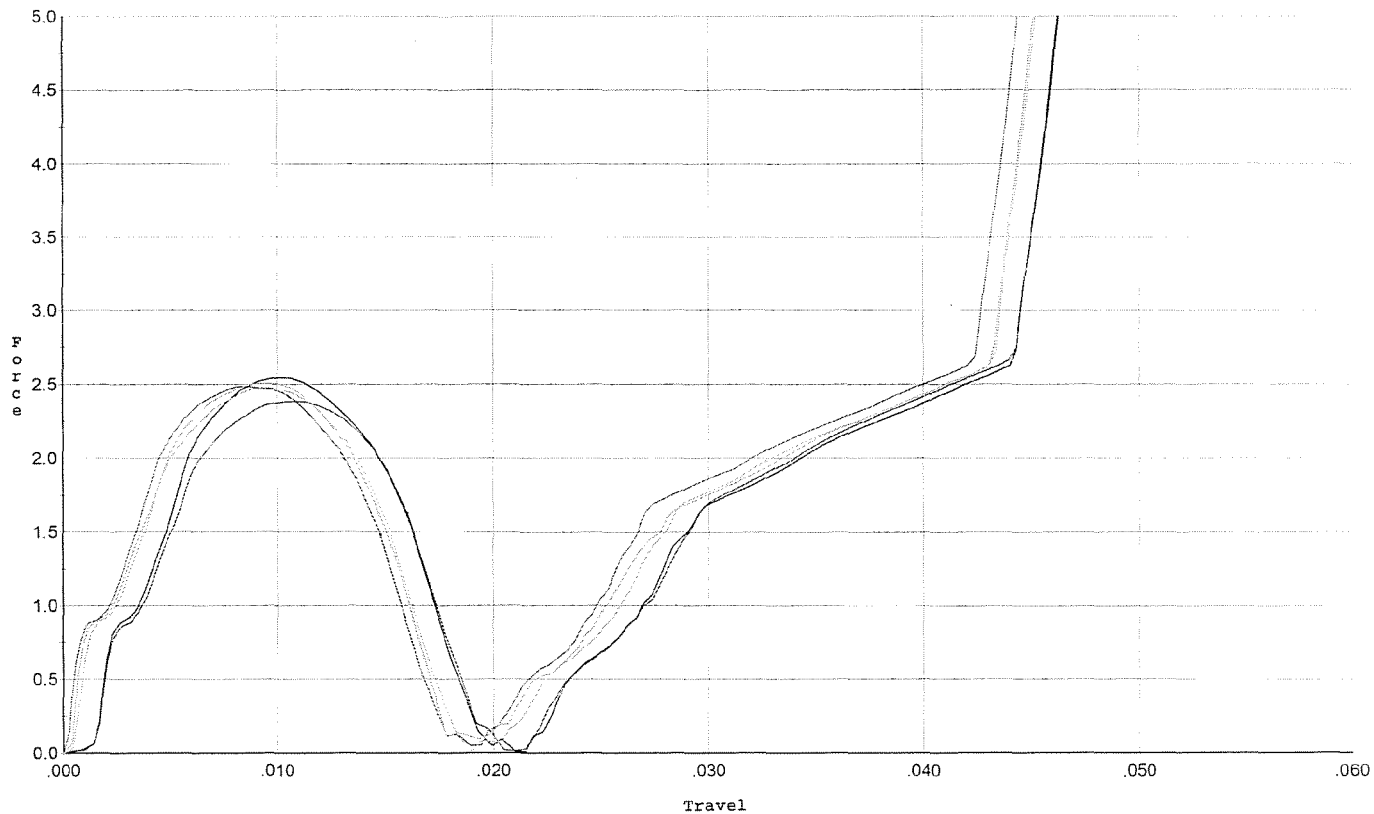
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.367	0.014	0.00	0.034	0.022		Set Trigger
2	2.528	0.015	0.00	0.032	0.026		Set Trigger
3	2.239	0.012	0.00	0.035	0.018		Set Trigger
4	2.474	0.013	0.00	0.034	0.021		Set Trigger
5	2.708	0.012	0.00	0.035	0.021		Set Trigger

A 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



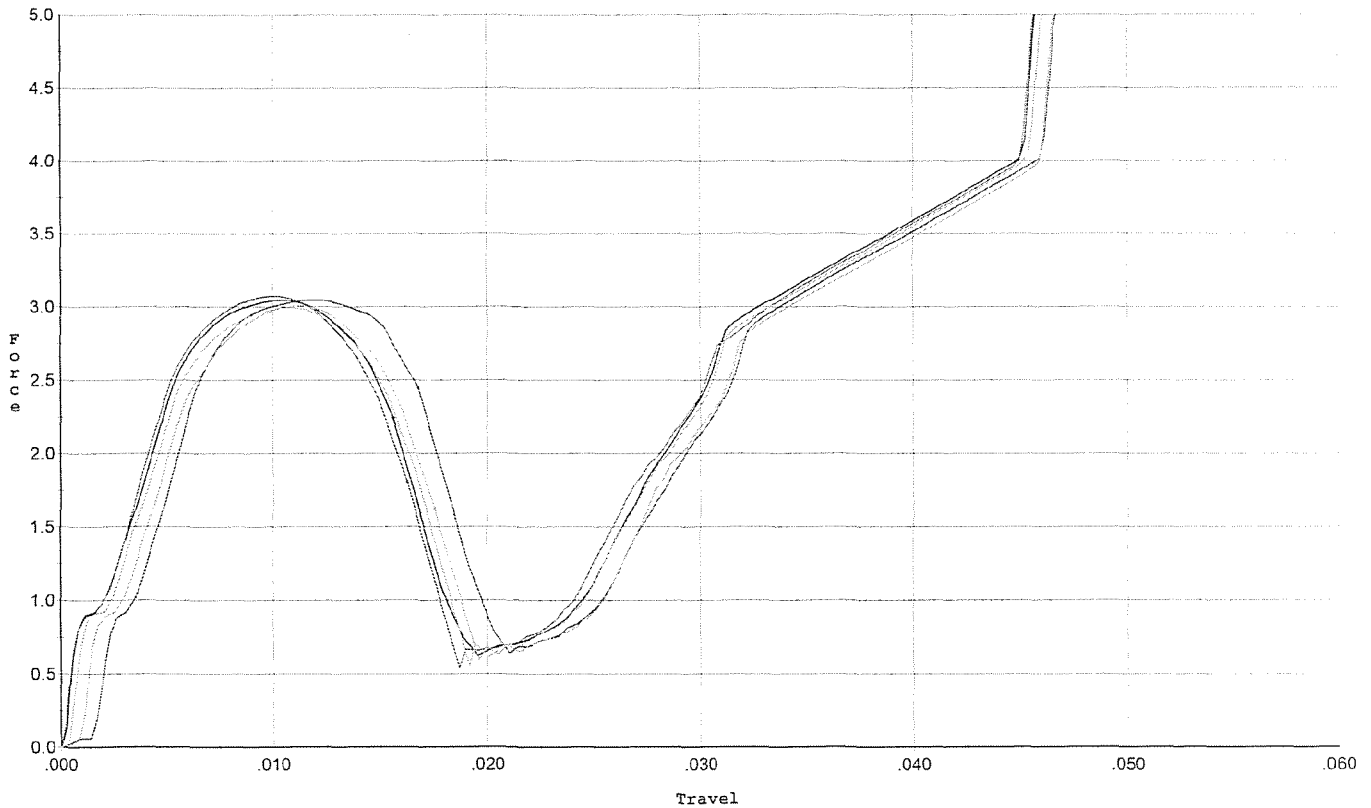
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.385	0.016	0.00	0.034	0.025		Set Trigger
2	2.545	0.016	0.00	0.034	0.027		Set Trigger
3	2.485	0.015	0.00	0.034	0.026		Set Trigger
4	2.509	0.015	0.00	0.034	0.026		Set Trigger
5	2.475	0.015	0.00	0.034	0.027		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



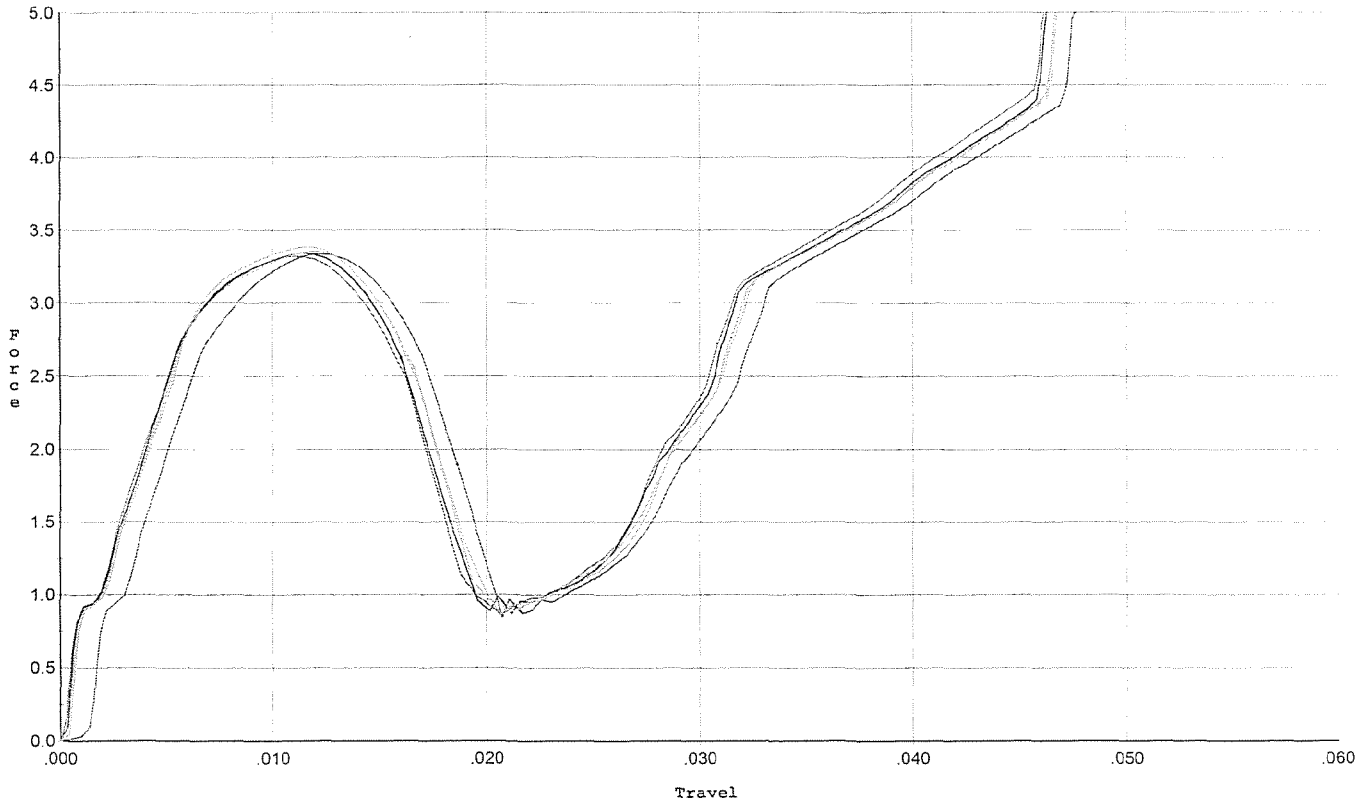
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.047	0.017	0.00	0.032	0.034		Set Trigger
2	3.047	0.016	0.00	0.032	0.033		Set Trigger
3	3.071	0.016	0.00	0.032	0.035		Set Trigger
4	2.994	0.017	0.00	0.032	0.034		Set Trigger
5	3.007	0.018	0.00	0.032	0.035		Set Trigger

A-3-03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



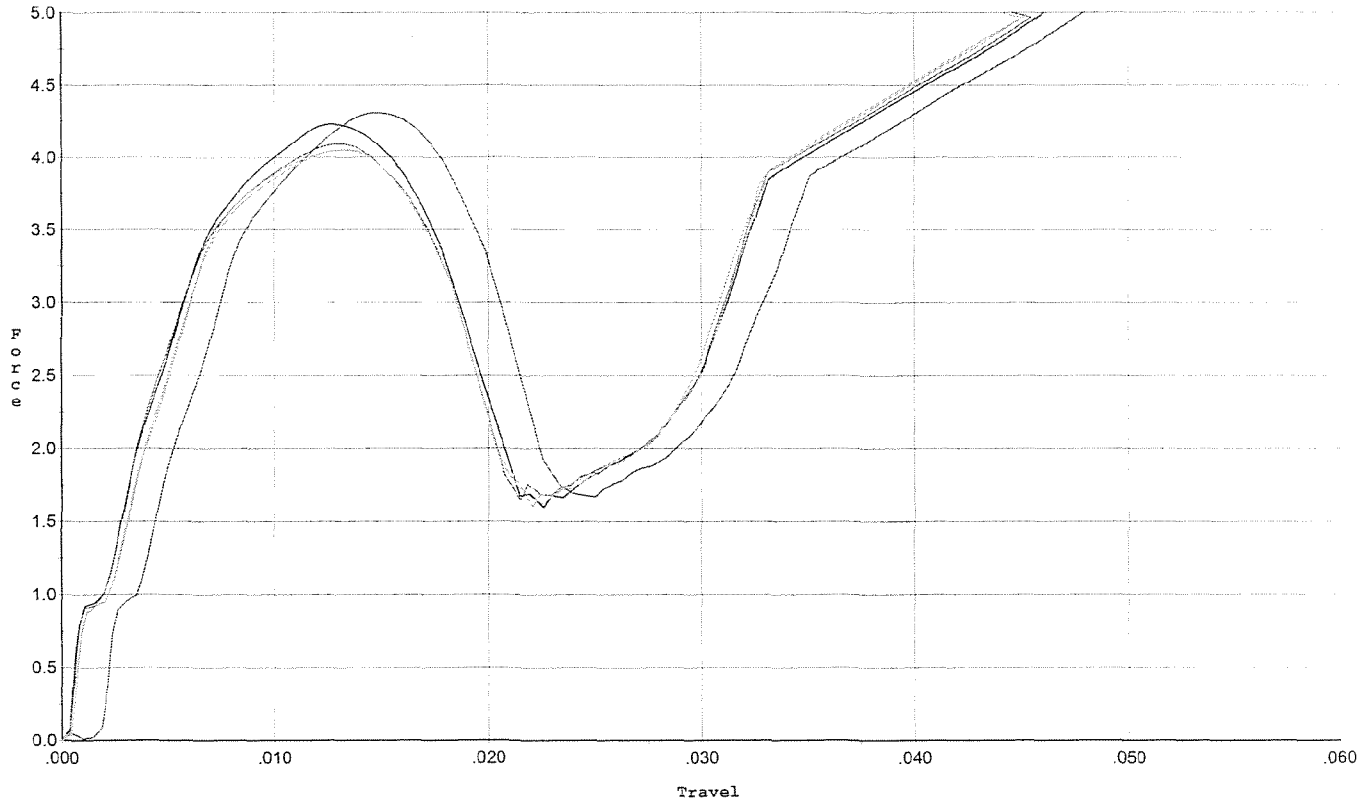
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.335	0.019	0.00	0.032	0.041		Set Trigger
2	3.343	0.016	0.00	0.032	0.037		Set Trigger
3	3.320	0.016	0.00	0.031	0.038		Set Trigger
4	3.355	0.017	0.00	0.032	0.039		Set Trigger
5	3.384	0.017	0.00	0.032	0.039		Set Trigger

A-3.34

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



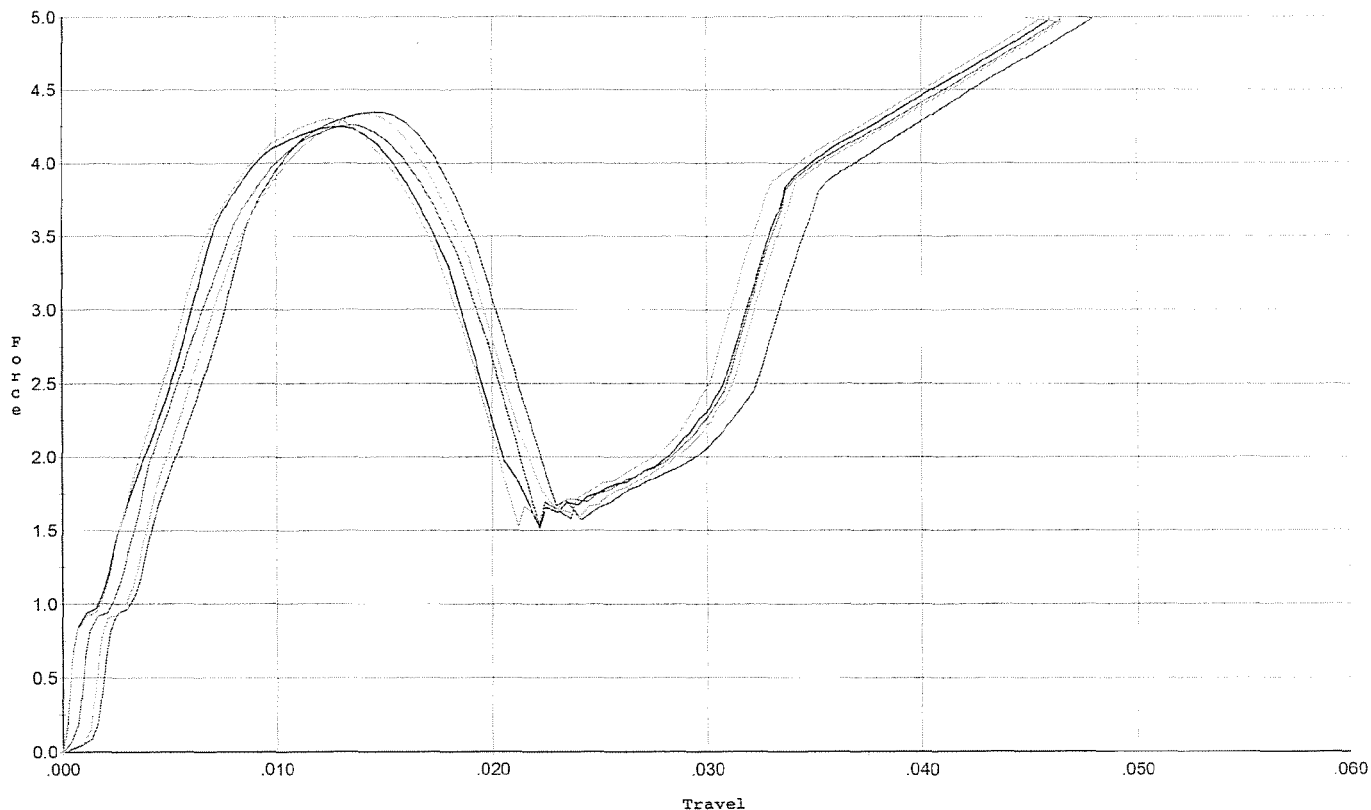
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.307	0.020	0.00	0.031	0.054		Set Trigger
2	4.232	0.018	0.00	0.030	0.051		Set Trigger
3	4.092	0.018	0.00	0.030	0.051		Set Trigger
4	4.059	0.018	0.00	0.030	0.050		Set Trigger
5	4.049	0.018	0.00	0.030	0.050		Set Trigger

A-4-14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schultz 3/23/2009

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



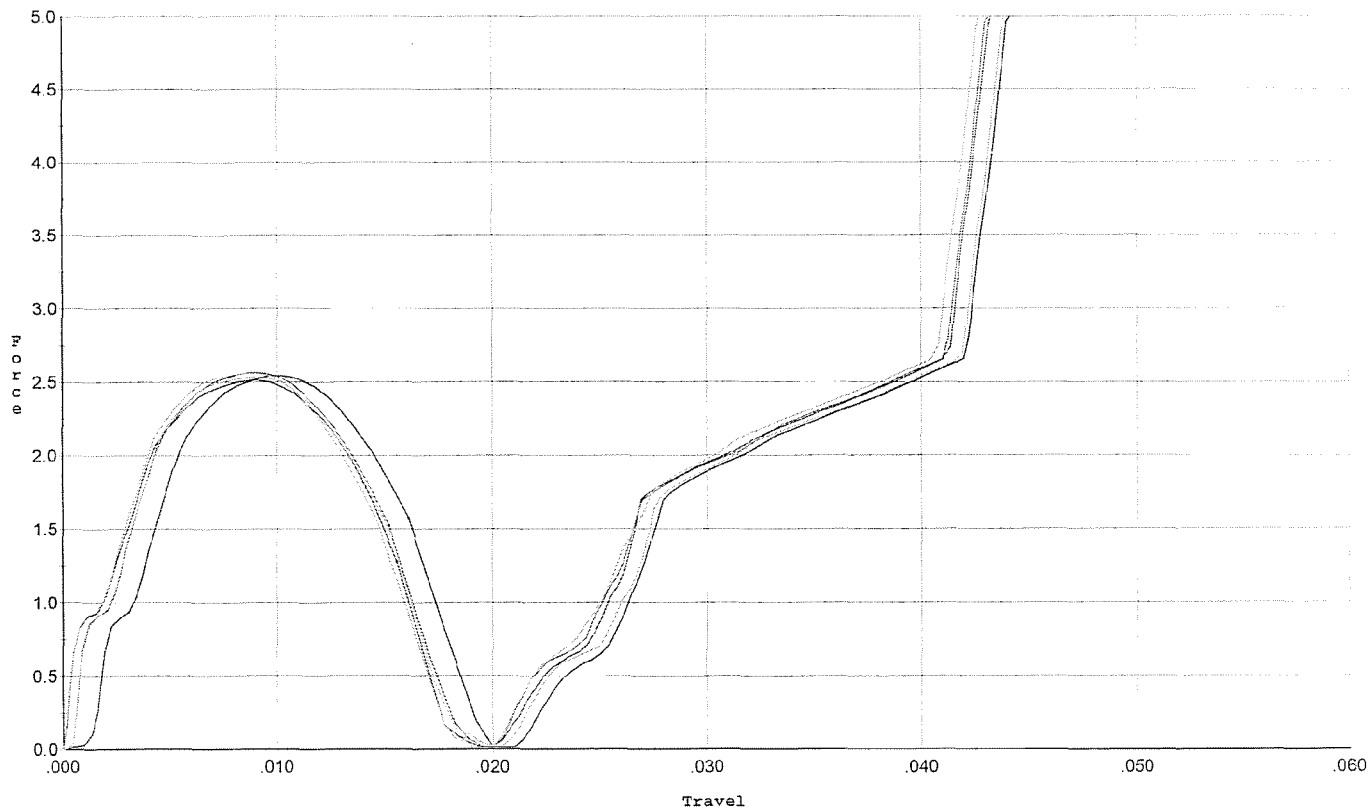
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.345	0.019	0.00	0.031	0.053		Set Trigger
2	4.247	0.018	0.00	0.030	0.052		Set Trigger
3	4.258	0.020	0.00	0.030	0.055		Set Trigger
4	4.334	0.019	0.00	0.030	0.052		Set Trigger
5	4.304	0.019	0.00	0.029	0.054		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



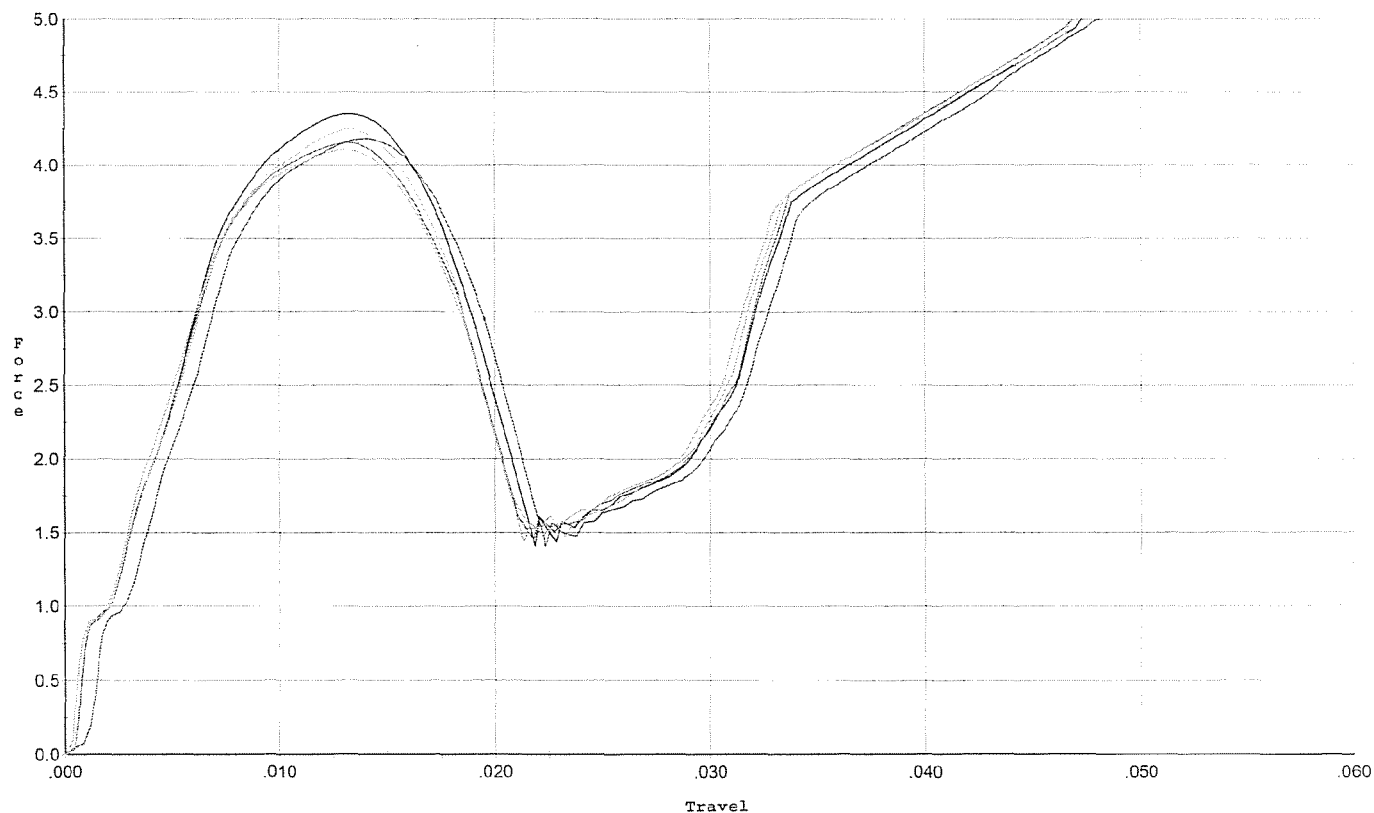
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.513	0.016	0.00	0.032	0.028		Set Trigger
2	2.544	0.016	0.00	0.032	0.027		Set Trigger
3	2.565	0.015	0.00	0.032	0.027		Set Trigger
4	2.535	0.015	0.00	0.032	0.027		Set Trigger
5	2.562	0.016	0.00	0.033	0.029		Set Trigger

A-254

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.181	0.020	0.00	0.031	0.053		Set Trigger
2	4.348	0.019	0.00	0.030	0.055		Set Trigger
3	4.154	0.018	0.00	0.030	0.050		Set Trigger
4	4.243	0.018	0.00	0.030	0.050		Set Trigger
5	4.107	0.019	0.00	0.030	0.051		Set Trigger

A-4-20