

G-6801356

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



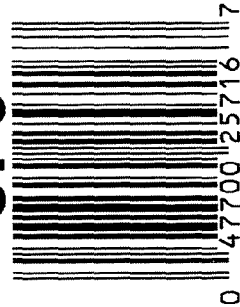
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801356

UPC



GUN SERIAL #

G6801356

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION		3-27-09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-27	BT
542	APPLY COATINGS (BARREL ACTION)		3-24	
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		4-22-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

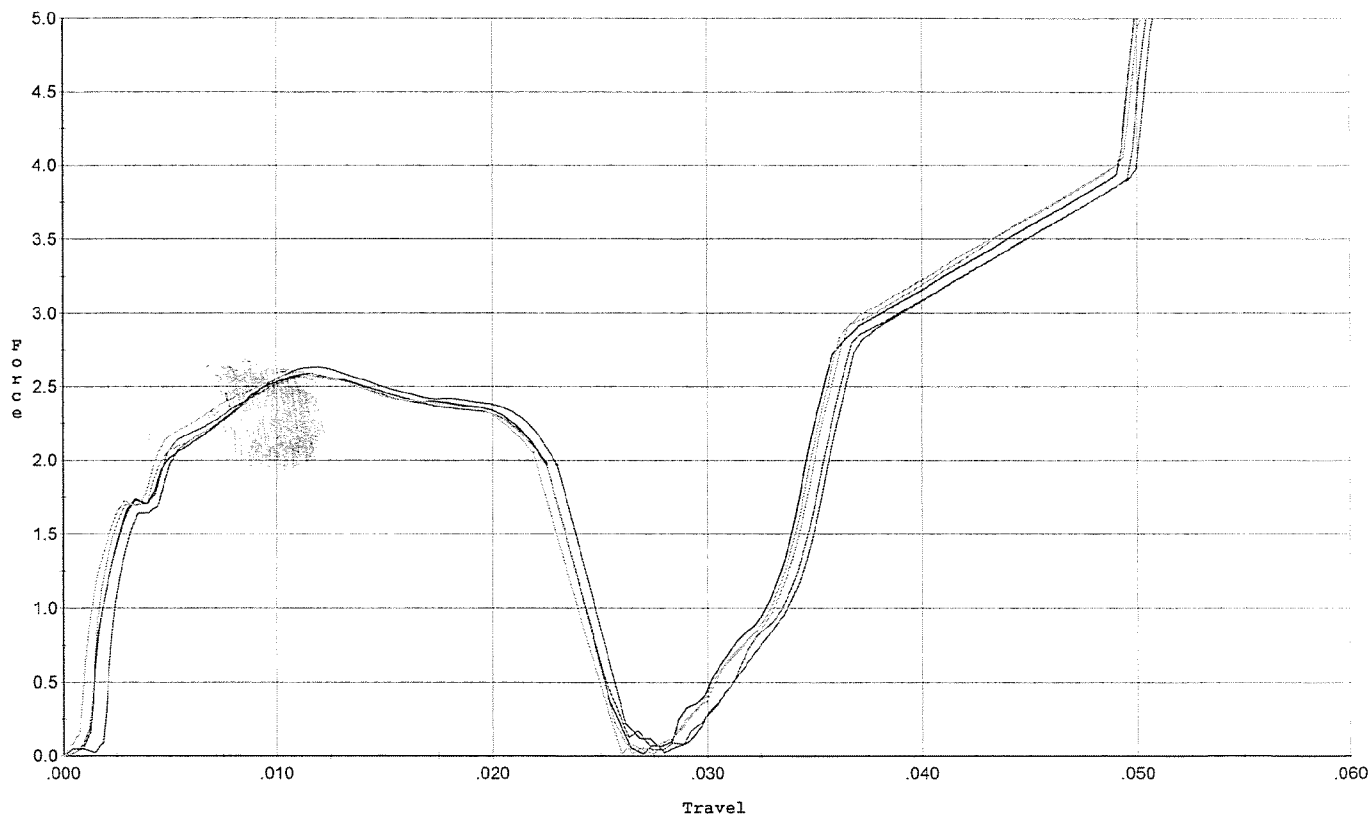
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>30</u>	5-6-09	LJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	5-6-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-6-09	LJ
	J) ASSEMBLE STOCK		4-22-09	LJ
	K) ASSEMBLE SWIVEL STUDS		5-6-09	LJ
	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	PASS FAIL PASS FAIL	4-27-09	WZ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-27-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE		5-6-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.22</u> <u>2.64</u> <u>2.61</u> <u>2.65</u>	4-28-09	WZ
	C) FUNCTION		5-6-09	LJ
690	PACK		5-29-09	WZ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



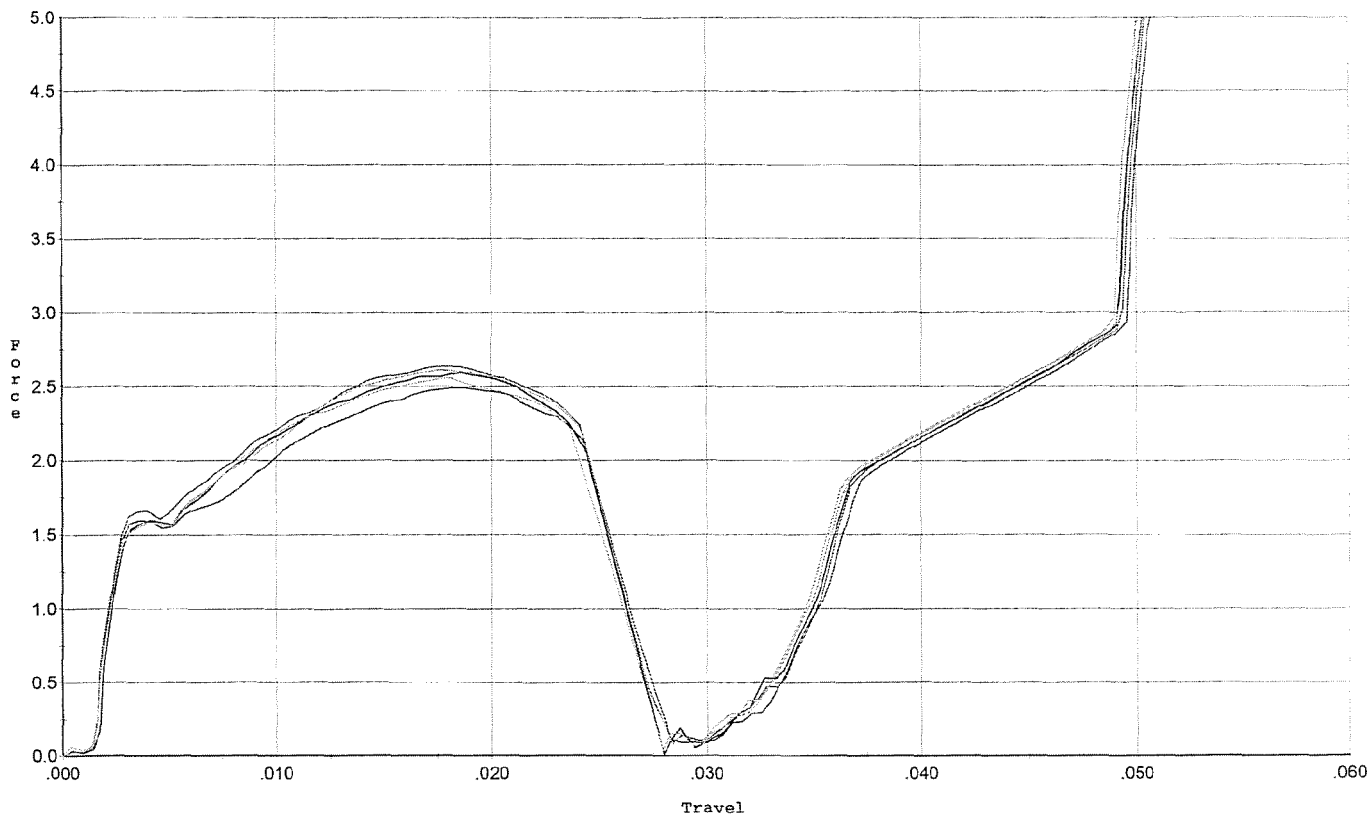
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.632	0.023	0.002	0.034	0.045		Set Trigger
2	2.590	0.022	0.00	0.033	0.045		Set Trigger
3	2.574	0.022	0.00	0.033	0.045		Set Trigger
4	2.601	0.022	0.00	0.033	0.045		Set Trigger
5	2.572	0.023	0.00	0.033	0.045		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



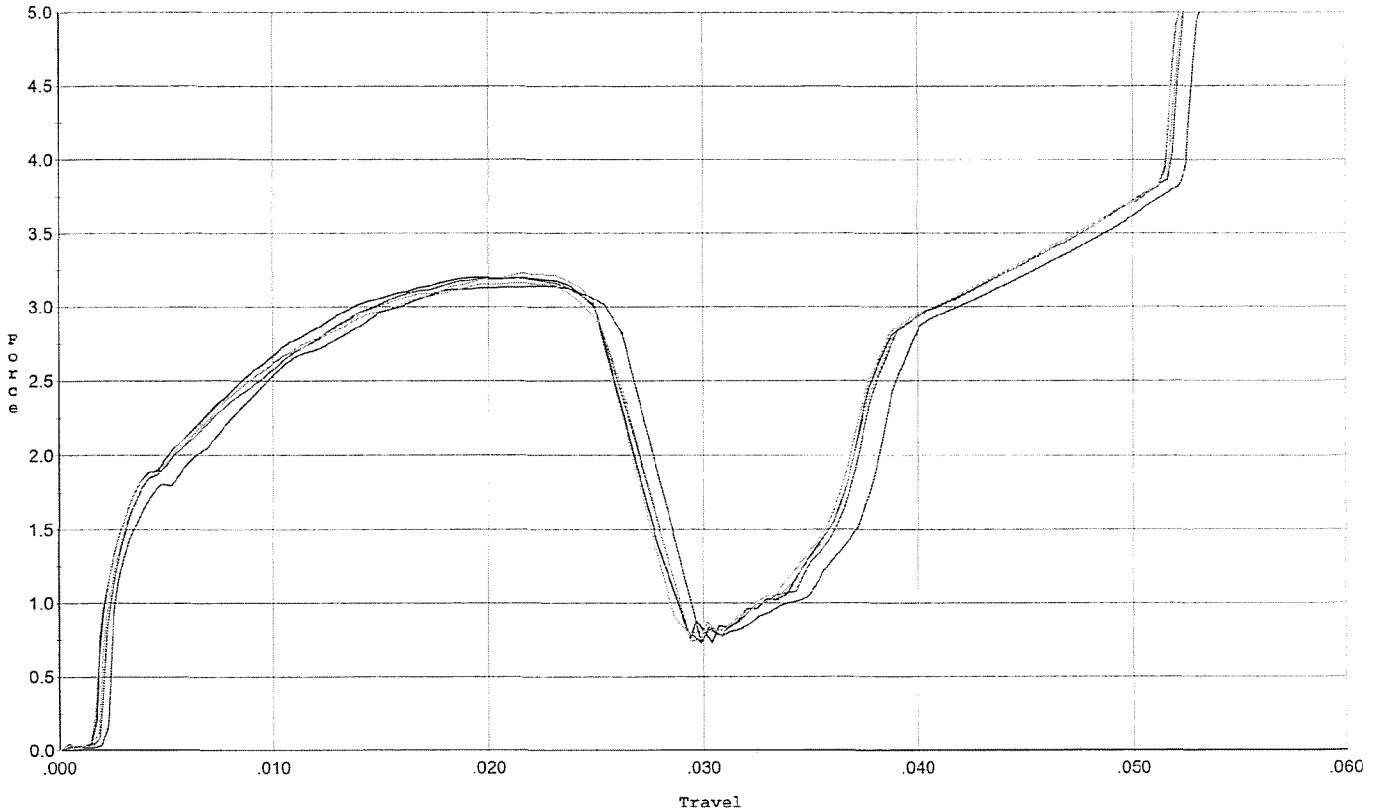
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.492	0.024	0.00	0.033	0.045		Set Trigger
2	2.596	0.024	0.005	0.032	0.047		Set Trigger
3	2.638	0.024	0.005	0.032	0.047		Set Trigger
4	2.556	0.025	0.006	0.032	0.048		Set Trigger
5	2.612	0.024	0.005	0.032	0.047		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



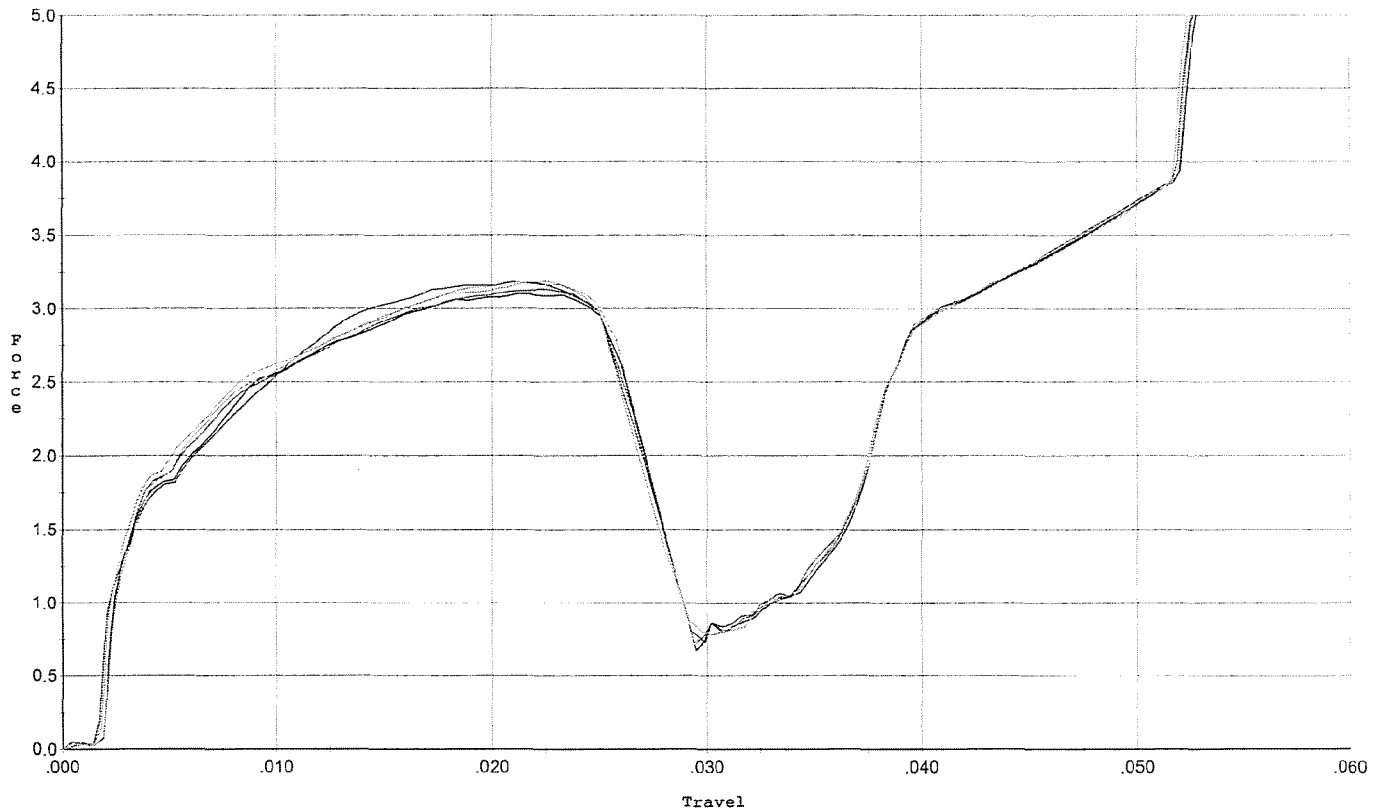
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.026	0.002	0.031	0.060		Set Trigger
2	3.202	0.025	0.00	0.031	0.059		Set Trigger
3	3.199	0.027	0.002	0.031	0.062		Set Trigger
4	3.165	0.025	0.00	0.031	0.059		Set Trigger
5	3.228	0.026	0.002	0.031	0.062		Set Trigger

Aug 3.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



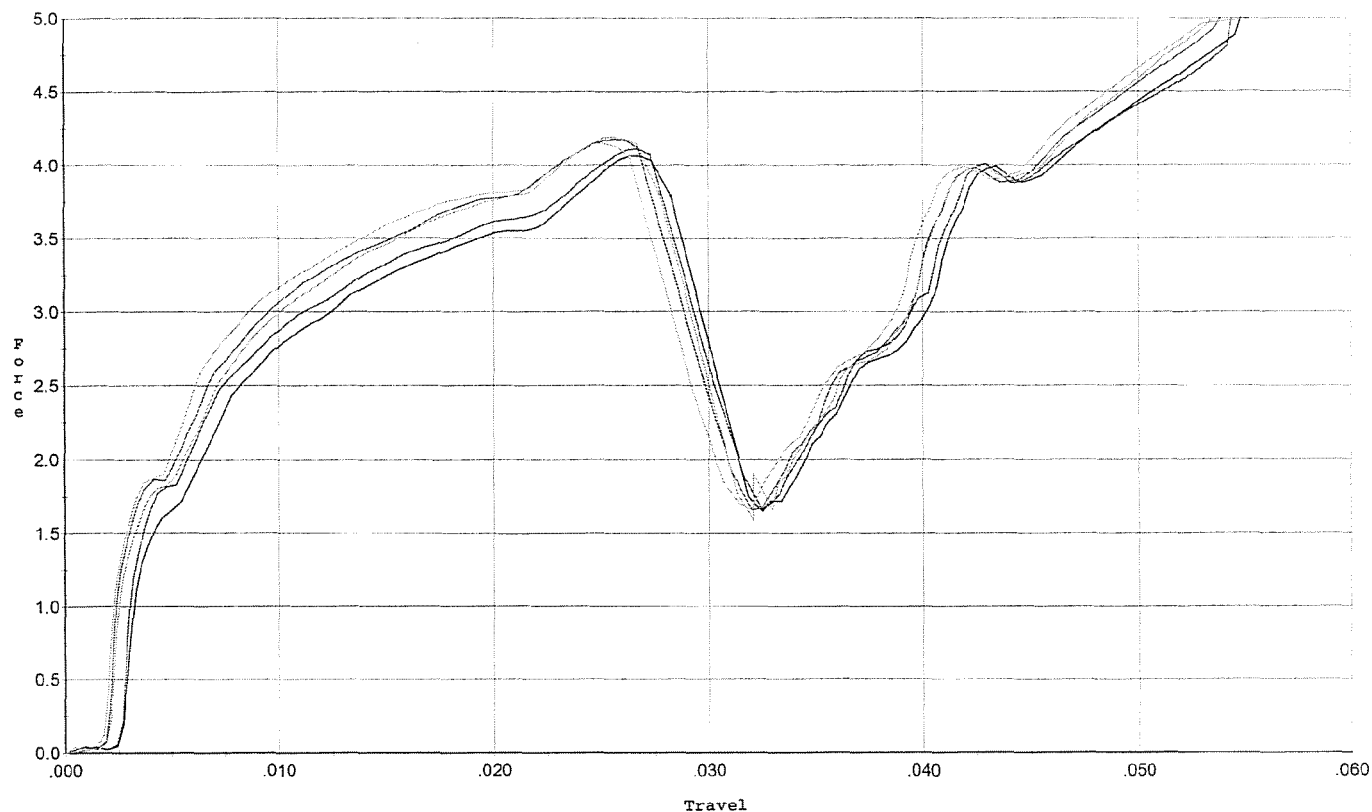
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.184	0.027	0.002	0.031	0.062		Set Trigger
2	3.103	0.026	0.00	0.031	0.059		Set Trigger
3	3.136	0.026	0.00	0.031	0.061		Set Trigger
4	3.174	0.025	0.002	0.032	0.058		Set Trigger
5	3.185	0.026	0.00	0.031	0.060		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



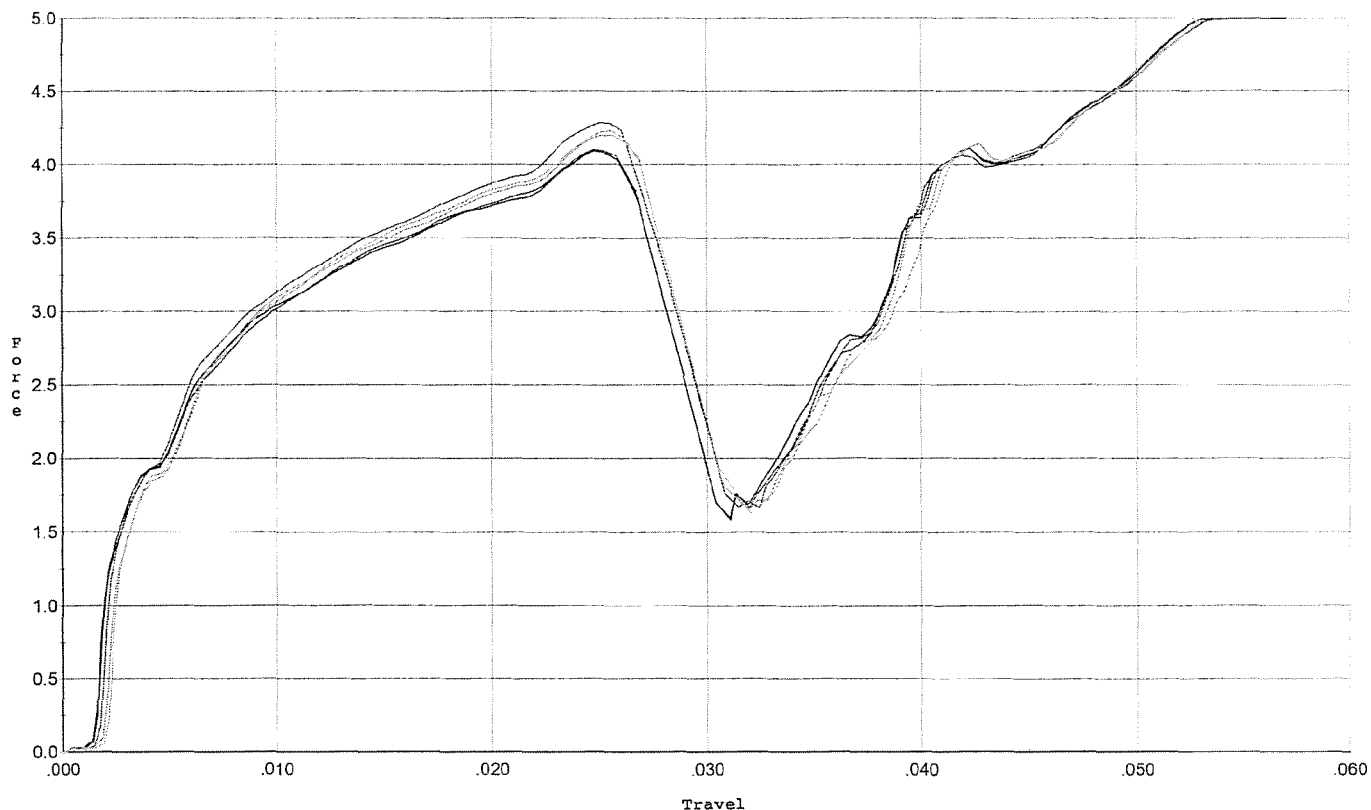
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.112	0.027	0.00	0.025	0.074		Set Trigger
2	4.062	0.028	0.003	0.025	0.074		Set Trigger
3	4.180	0.027	0.00	0.024	0.076		Set Trigger
4	4.147	0.026	0.00	0.024	0.075		Set Trigger
5	4.193	0.028	0.00	0.024	0.078		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



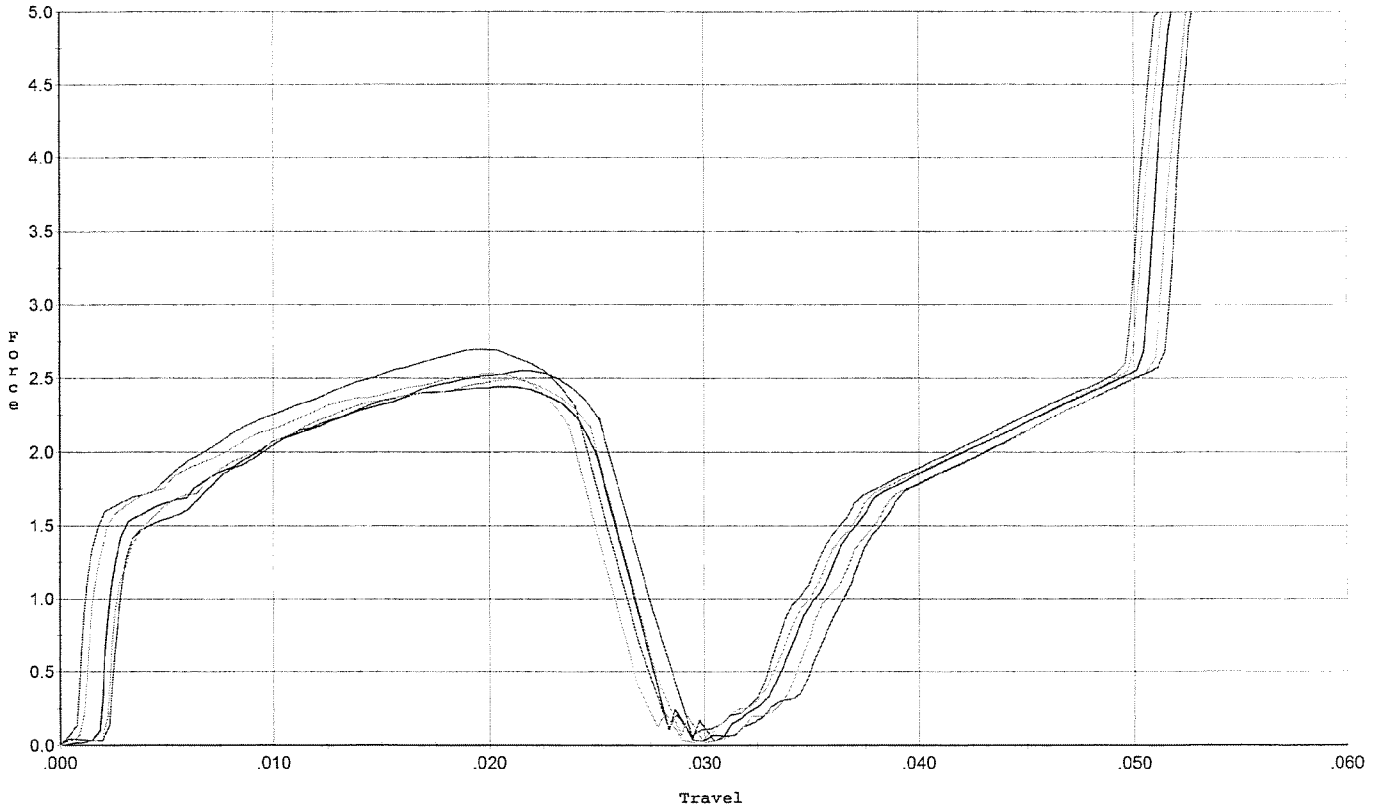
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.027	0.00	0.024	0.075		Set Trigger
2	4.091	0.027	0.00	0.024	0.075		Set Trigger
3	4.284	0.028	0.00	0.024	0.080		Set Trigger
4	4.231	0.027	0.00	0.024	0.076		Set Trigger
5	4.202	0.027	0.00	0.024	0.076		Set Trigger

Aug 4.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



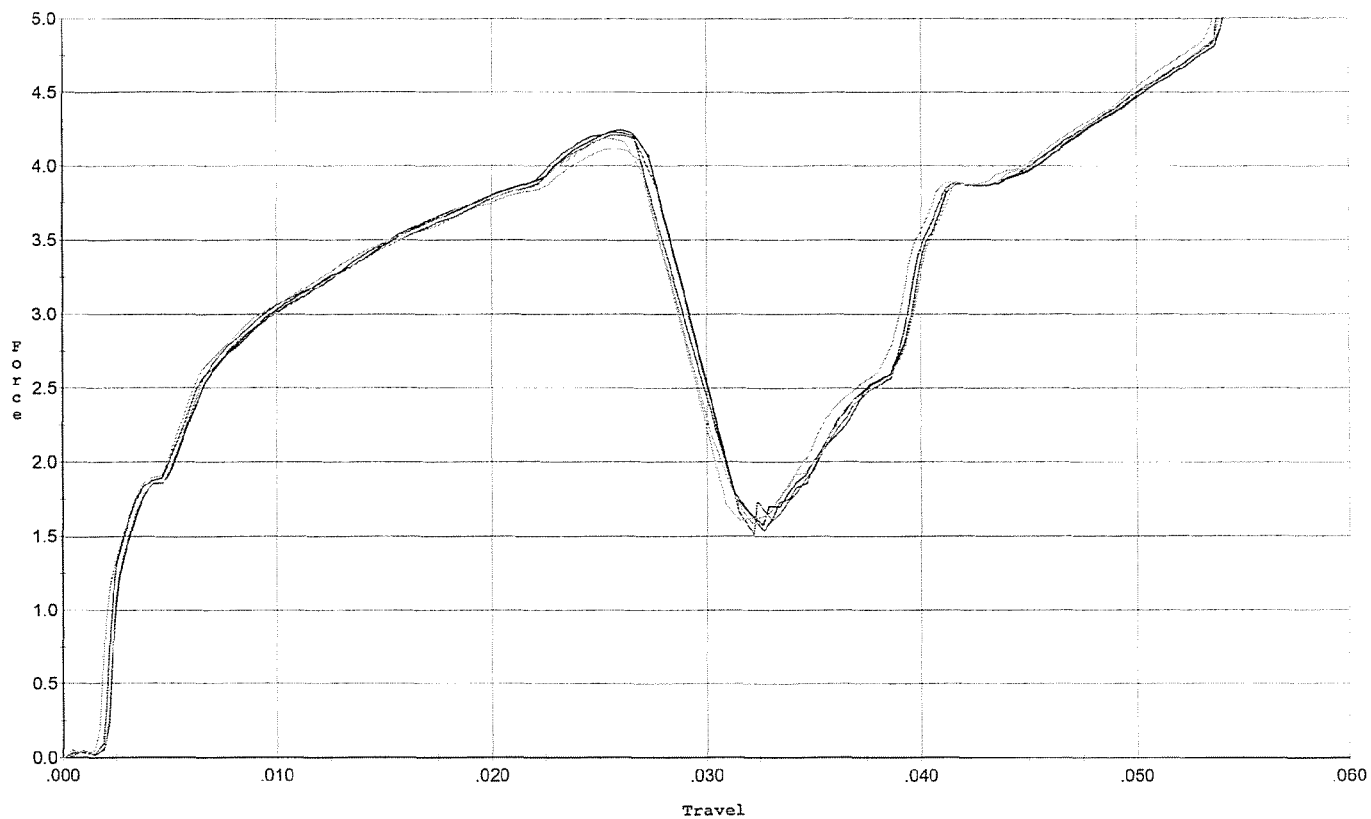
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.551	0.025	0.002	0.034	0.047		Set Trigger
2	2.445	0.025	0.00	0.033	0.046		Set Trigger
3	2.696	0.024	0.00	0.033	0.050		Set Trigger
4	2.534	0.024	0.00	0.034	0.046		Set Trigger
5	2.492	0.025	0.00	0.034	0.046		Set Trigger

Aug 2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.230	0.027	0.002	0.024	0.076		Set Trigger
2	4.245	0.027	0.00	0.024	0.078		Set Trigger
3	4.209	0.028	0.00	0.024	0.078		Set Trigger
4	4.182	0.027	0.00	0.024	0.077		Set Trigger
5	4.118	0.027	0.00	0.024	0.075		Set Trigger

Aug 4.19