

G-6801359

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



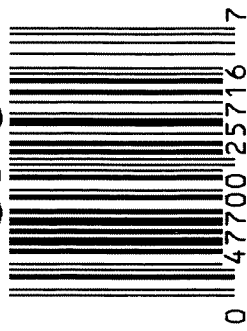
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801359

UPC



GUN SERIAL # G 6801359

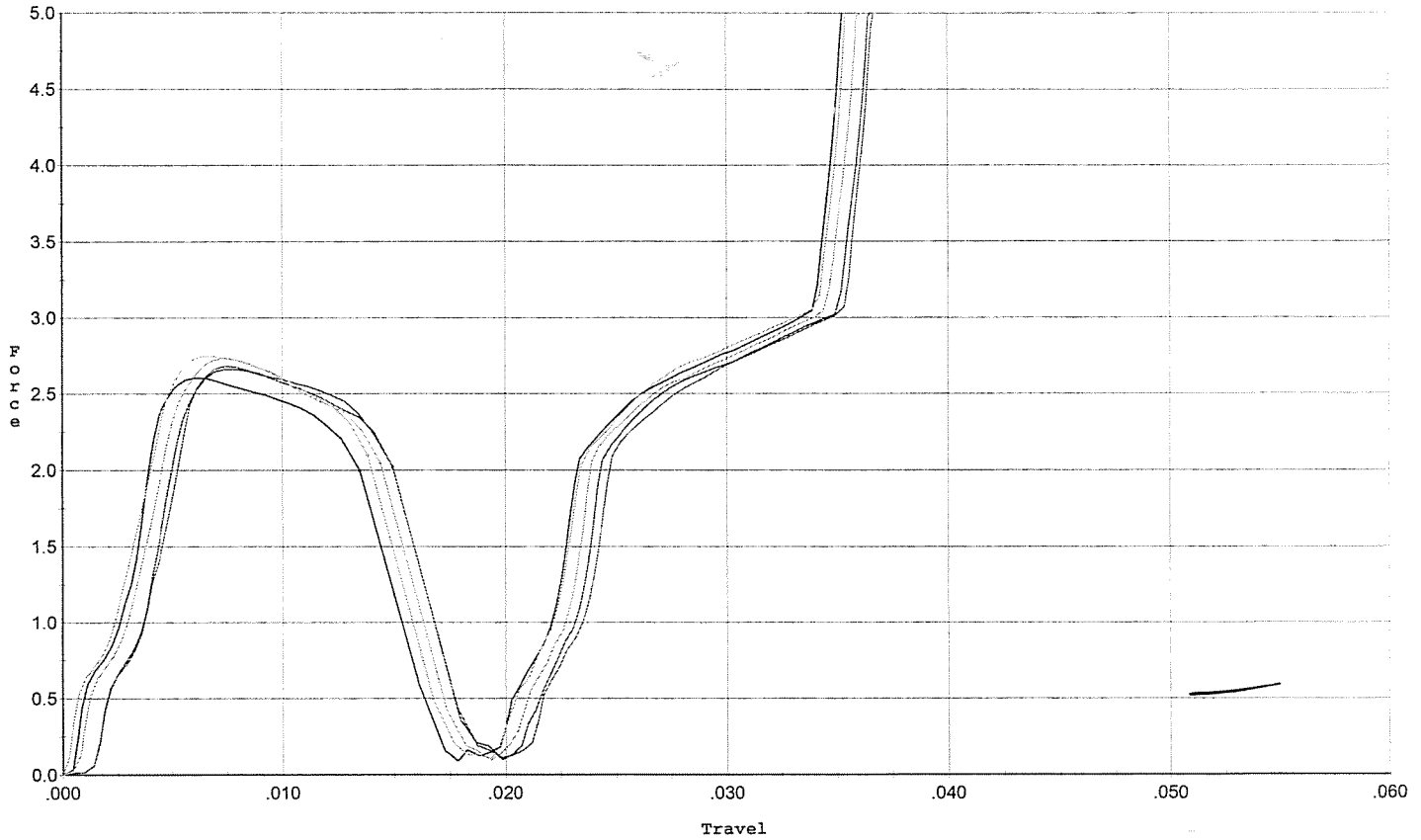
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPH
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPH
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	(1)	3/9/09	(1)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-4	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		3-27-09	SPH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7</u> <u>6.5</u> <u>6.5</u>	3-31-09	W/W
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	3-31-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-31-09	W/W
	J) ASSEMBLE STOCK			3-27-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS			3-31-09	W/W
	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	3-30-09	L.P.D.
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE			3-31-09	W/W
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.75</u> <u>2.72</u> <u>2.65</u> <u>2.64</u>	3-31-09	W/W
	C) FUNCTION			3-31-09	W/W
690	PACK			5-28-09	W/W

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



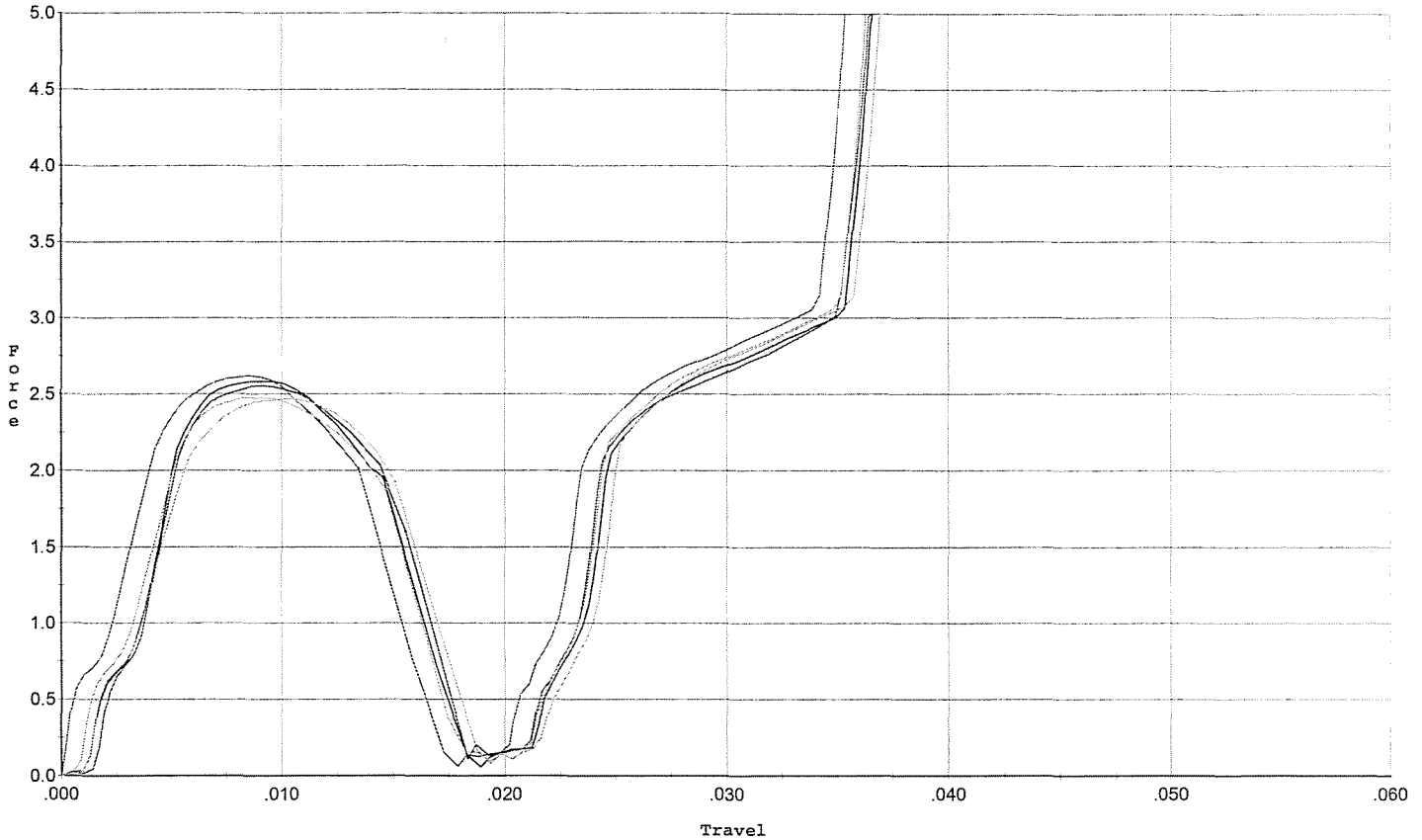
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.015	0.00	0.025	0.026		Set Trigger
2	2.605	0.013	0.00	0.025	0.024		Set Trigger
3	2.682	0.015	0.00	0.025	0.026		Set Trigger
4	2.747	0.014	0.00	0.025	0.027		Set Trigger
5	2.733	0.014	0.00	0.025	0.026		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



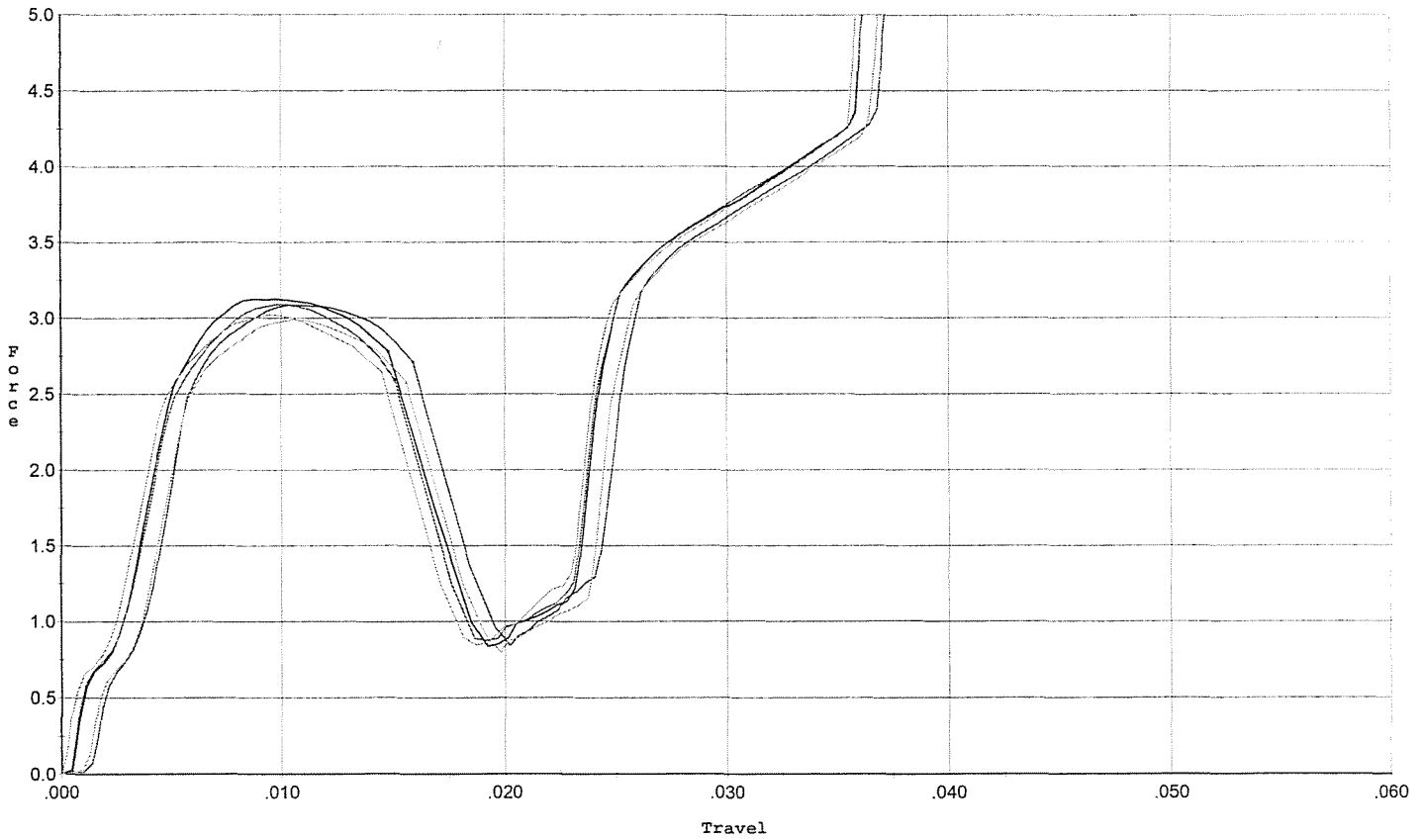
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.016	0.00	0.025	0.026		Set Trigger
2	2.578	0.015	0.00	0.026	0.025		Set Trigger
3	2.617	0.013	0.00	0.025	0.025		Set Trigger
4	2.468	0.015	0.00	0.026	0.025		Set Trigger
5	2.476	0.015	0.00	0.025	0.025		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



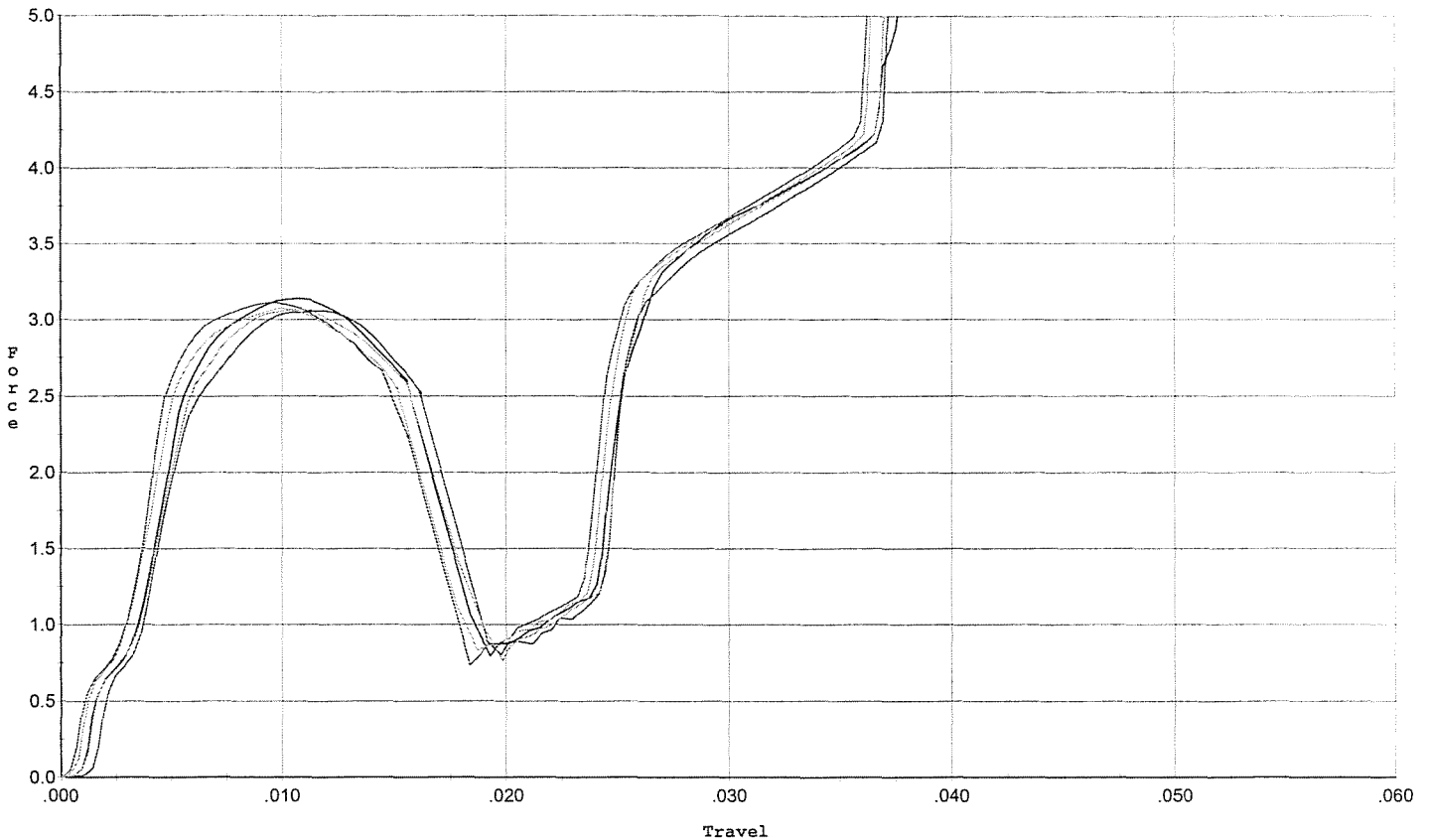
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.085	0.016	0.00	0.024	0.033		Set Trigger
2	3.126	0.015	0.00	0.024	0.032		Set Trigger
3	3.090	0.015	0.00	0.024	0.032		Set Trigger
4	2.988	0.016	0.00	0.024	0.031		Set Trigger
5	3.023	0.014	0.00	0.024	0.031		Set Trigger

A-3-06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



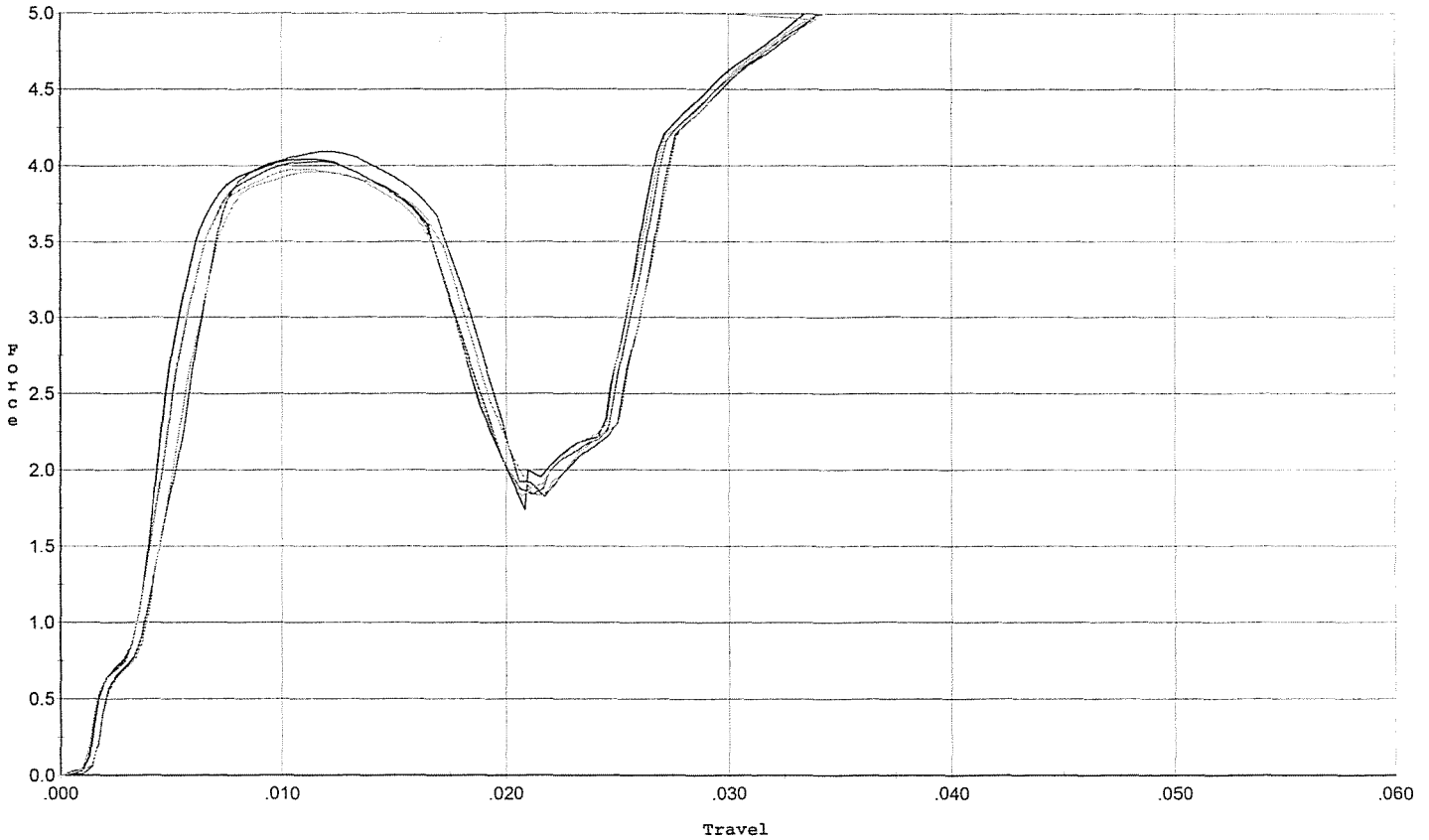
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.059	0.016	0.00	0.025	0.032		Set Trigger
2	3.141	0.016	0.00	0.025	0.032		Set Trigger
3	3.110	0.016	0.00	0.024	0.033		Set Trigger
4	3.075	0.015	0.00	0.024	0.032		Set Trigger
5	3.066	0.016	0.00	0.025	0.032		Set Trigger

A-3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



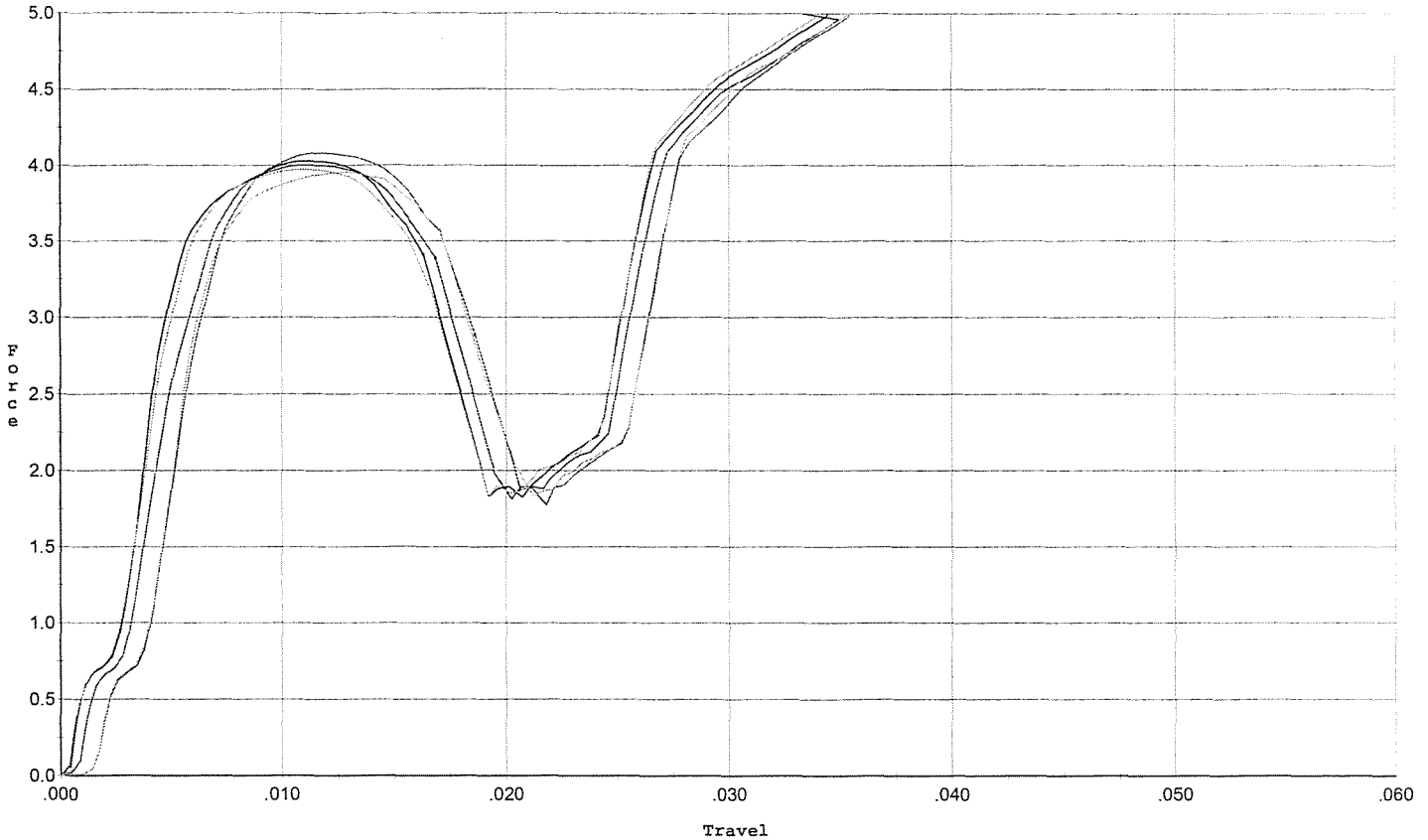
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.093	0.018	0.00	0.022	0.048		Set Trigger
2	4.042	0.017	0.00	0.022	0.044		Set Trigger
3	4.026	0.017	0.00	0.022	0.044		Set Trigger
4	3.976	0.017	0.00	0.022	0.044		Set Trigger
5	3.961	0.017	0.00	0.022	0.044		Set Trigger

A-4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



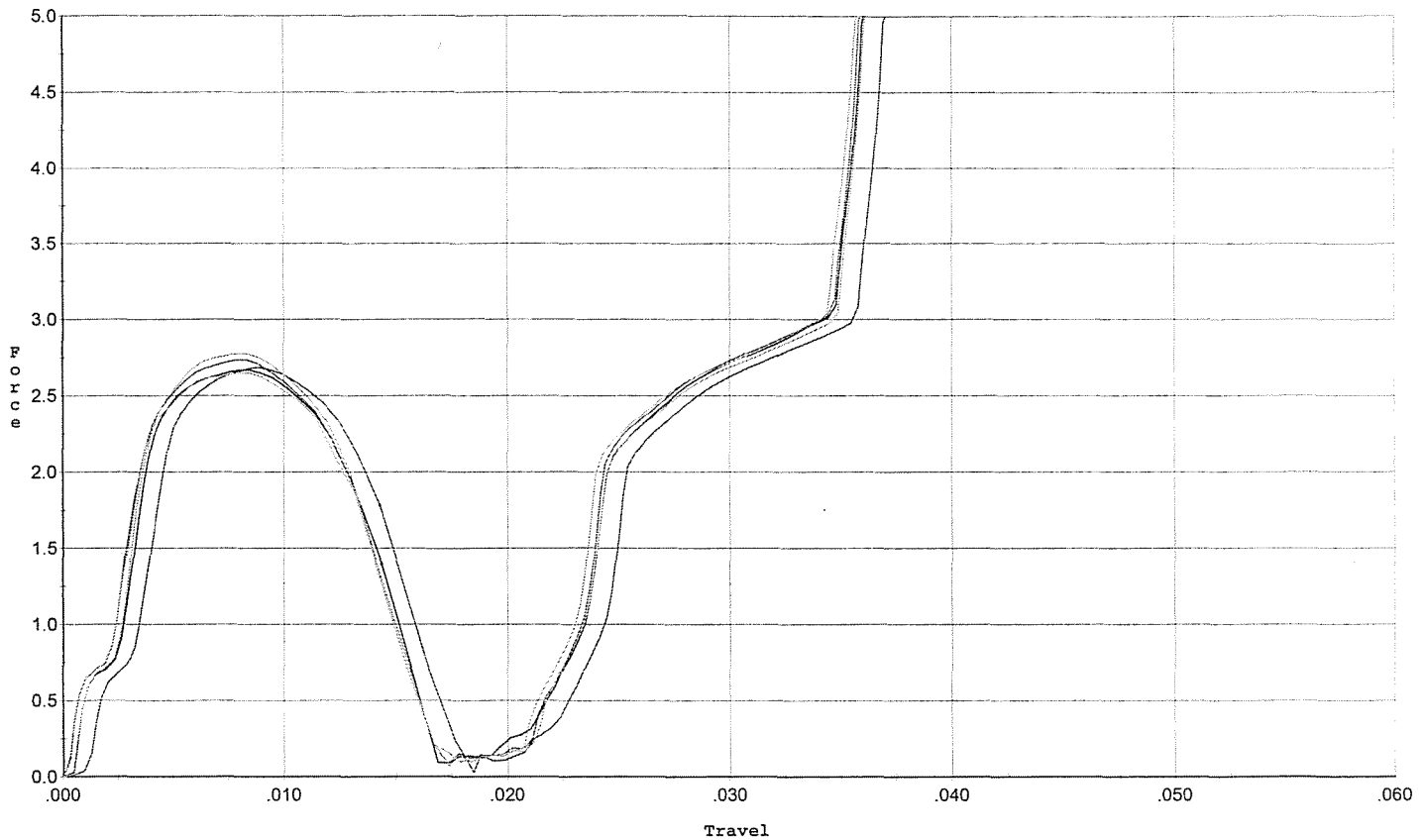
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.001	0.017	0.00	0.022	0.045		Set Trigger
2	4.029	0.016	0.00	0.022	0.045		Set Trigger
3	4.084	0.019	0.00	0.022	0.048		Set Trigger
4	3.954	0.017	0.00	0.022	0.044		Set Trigger
5	3.974	0.017	0.00	0.022	0.045		Set Trigger

A. 4.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



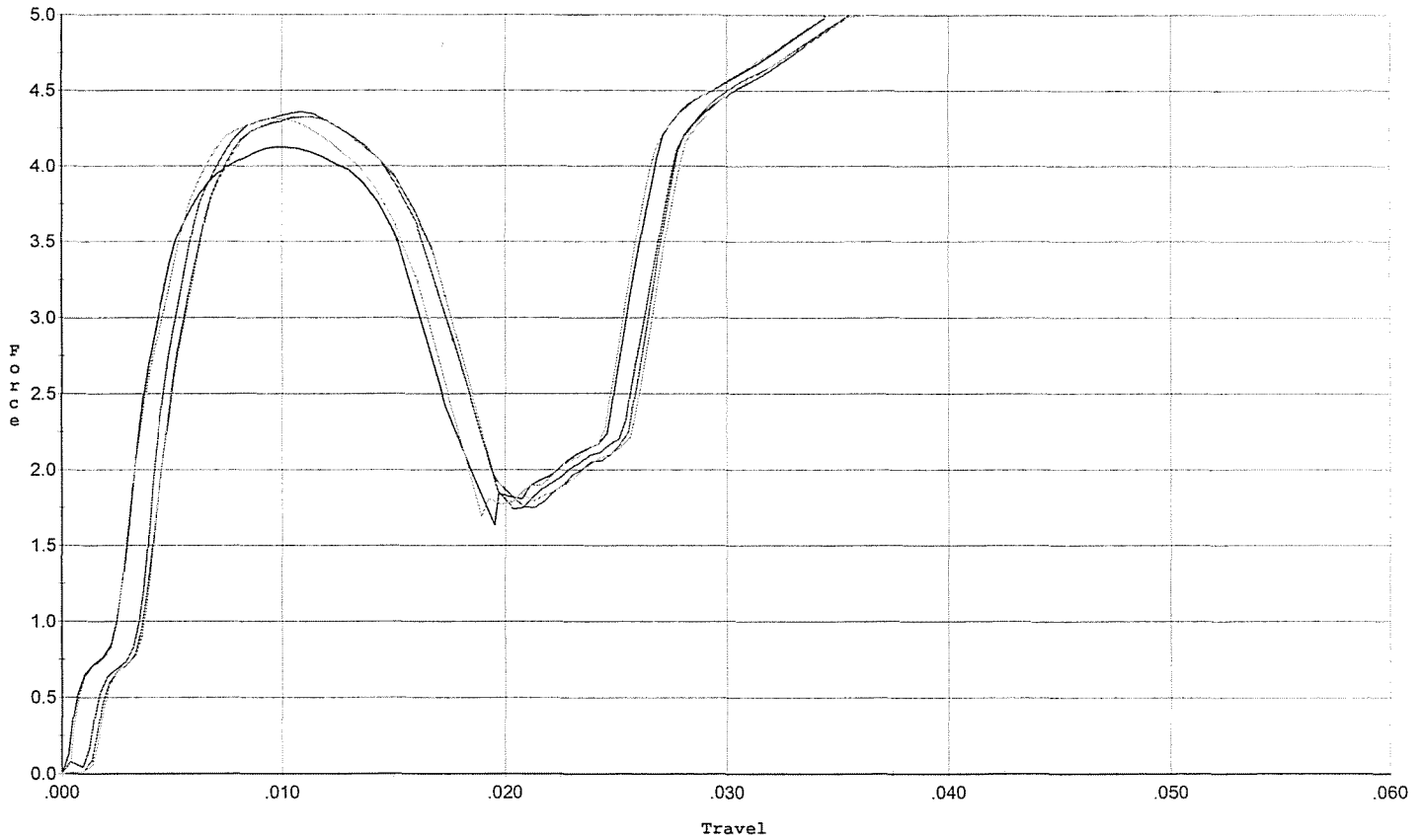
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.685	0.014	0.00	0.027	0.025		Set Trigger
2	2.669	0.014	0.00	0.026	0.026		Set Trigger
3	2.731	0.013	0.00	0.026	0.025		Set Trigger
4	2.651	0.013	0.00	0.026	0.025		Set Trigger
5	2.777	0.013	0.00	0.026	0.024		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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	4.358	0.018	0.00	0.023	0.049		Set Trigger
2	4.126	0.015	0.00	0.022	0.043		Set Trigger
3	4.324	0.017	0.00	0.023	0.046		Set Trigger
4	4.326	0.017	0.00	0.023	0.046		Set Trigger
5	4.312	0.016	0.00	0.022	0.046		Set Trigger

A-4-28