

G6801360

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



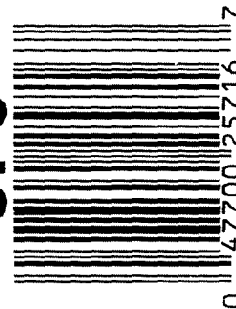
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801360

UPC



GUN SERIAL #

66801360

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	(D)	3/9/09	(D)
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		3-27-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

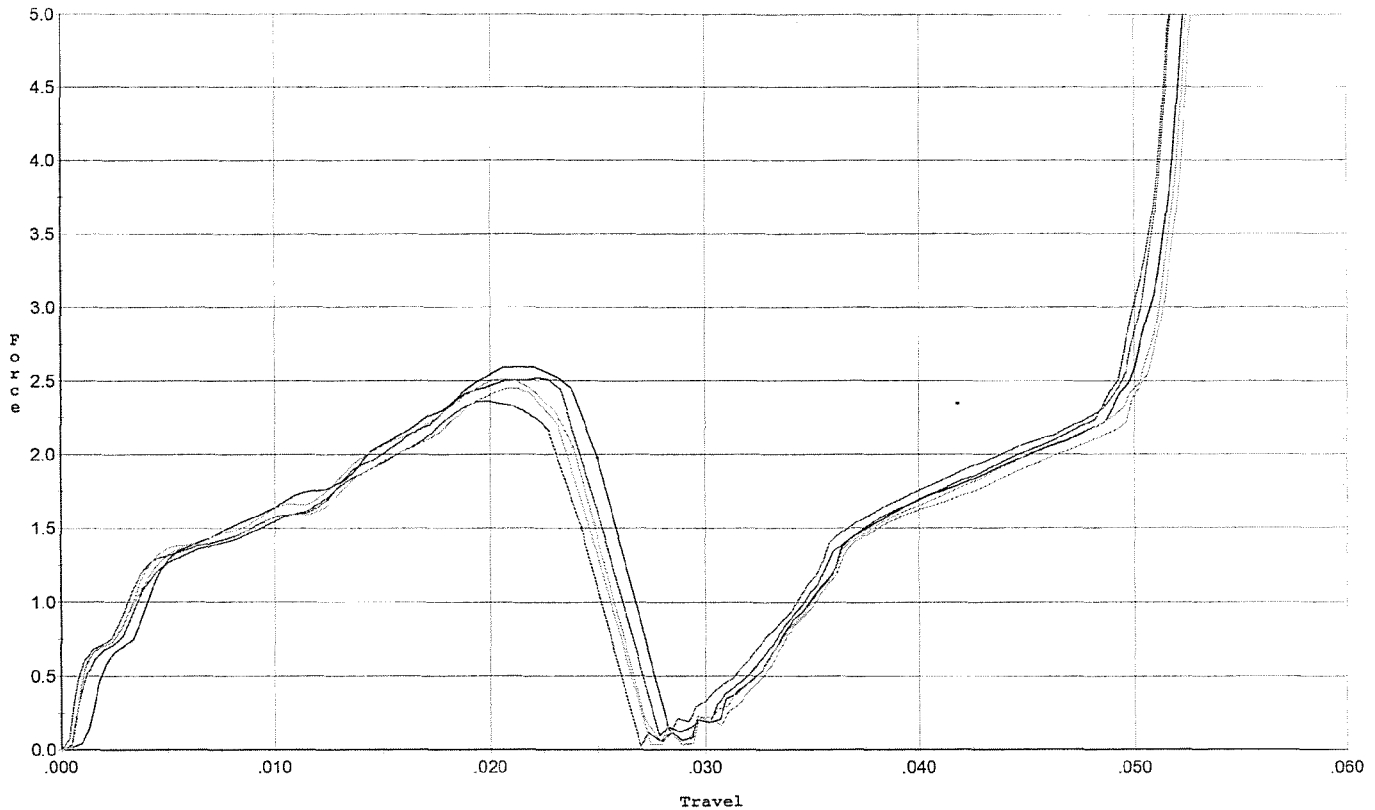
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	3-31-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-31-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	3-31-09	WN
	J) ASSEMBLE STOCK		3-27-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		3-31-09	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 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-30-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.44</u> <u>2.35</u> <u>2.29</u> <u>2.29</u>	3-31-09	WN
	C) FUNCTION		3-31-09	WN
690	PACK		5-28-09	WN

F004 REV 5/2006

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



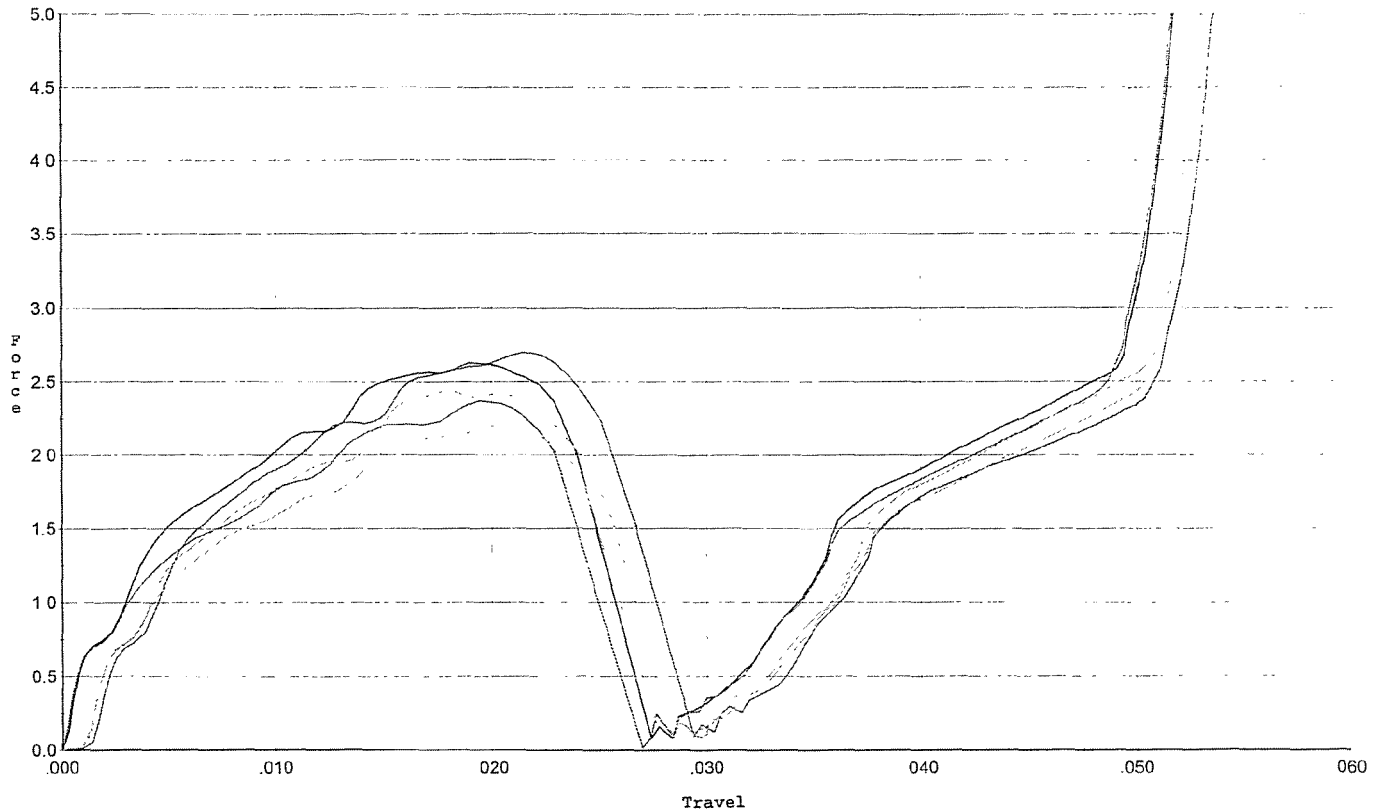
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.025	0.00	0.033	0.041		Set Trigger
2	2.591	0.025	0.00	0.033	0.042		Set Trigger
3	2.360	0.024	0.00	0.034	0.038		Set Trigger
4	2.448	0.025	0.00	0.034	0.040		Set Trigger
5	2.509	0.024	0.00	0.034	0.039		Set Trigger

A-2.48

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



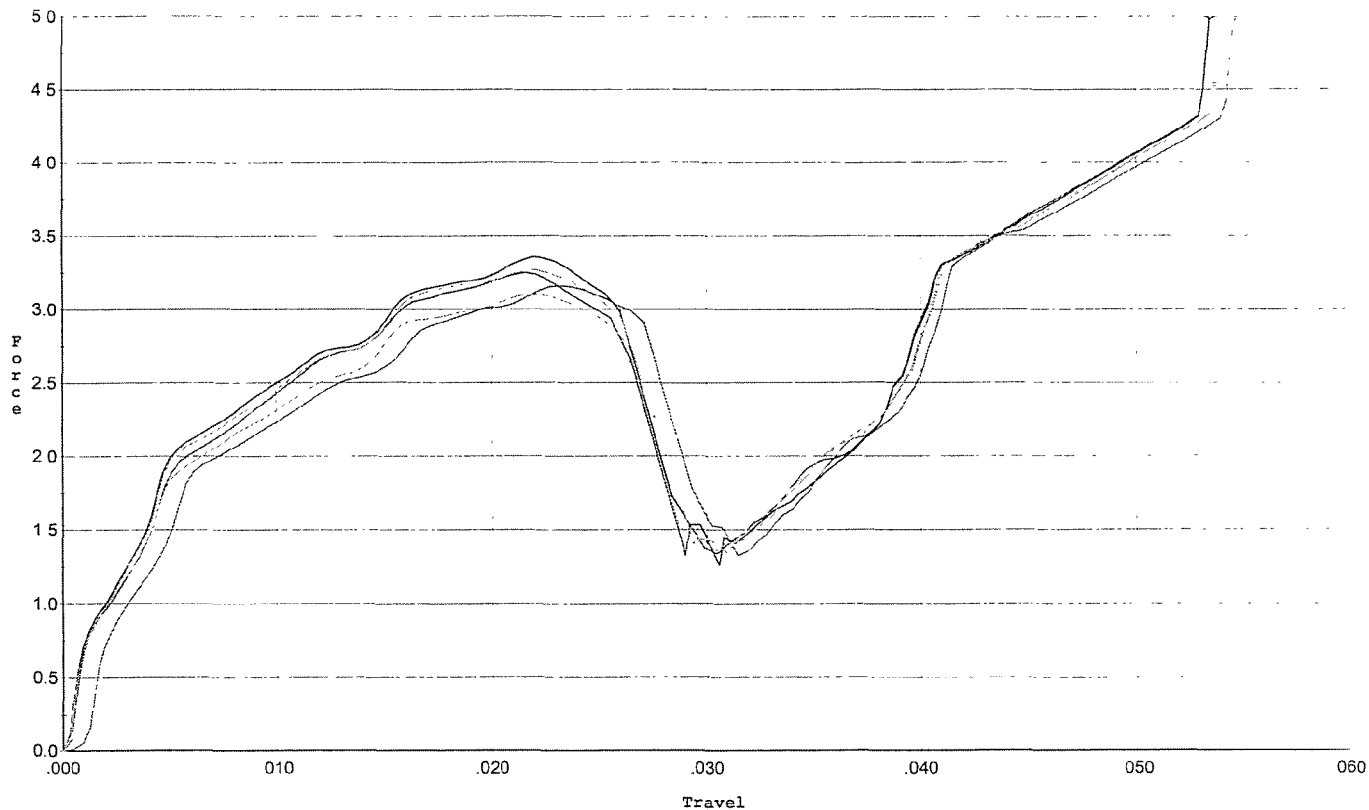
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.696	0.027	0.00	0.034	0.048		Set Trigger
2	2.629	0.024	0.00	0.033	0.045		Set Trigger
3	2.369	0.023	0.00	0.034	0.038		Set Trigger
4	2.201	0.026	0.00	0.034	0.039		Set Trigger
5	2.434	0.026	0.00	0.034	0.043		Set Trigger

A-2.46

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



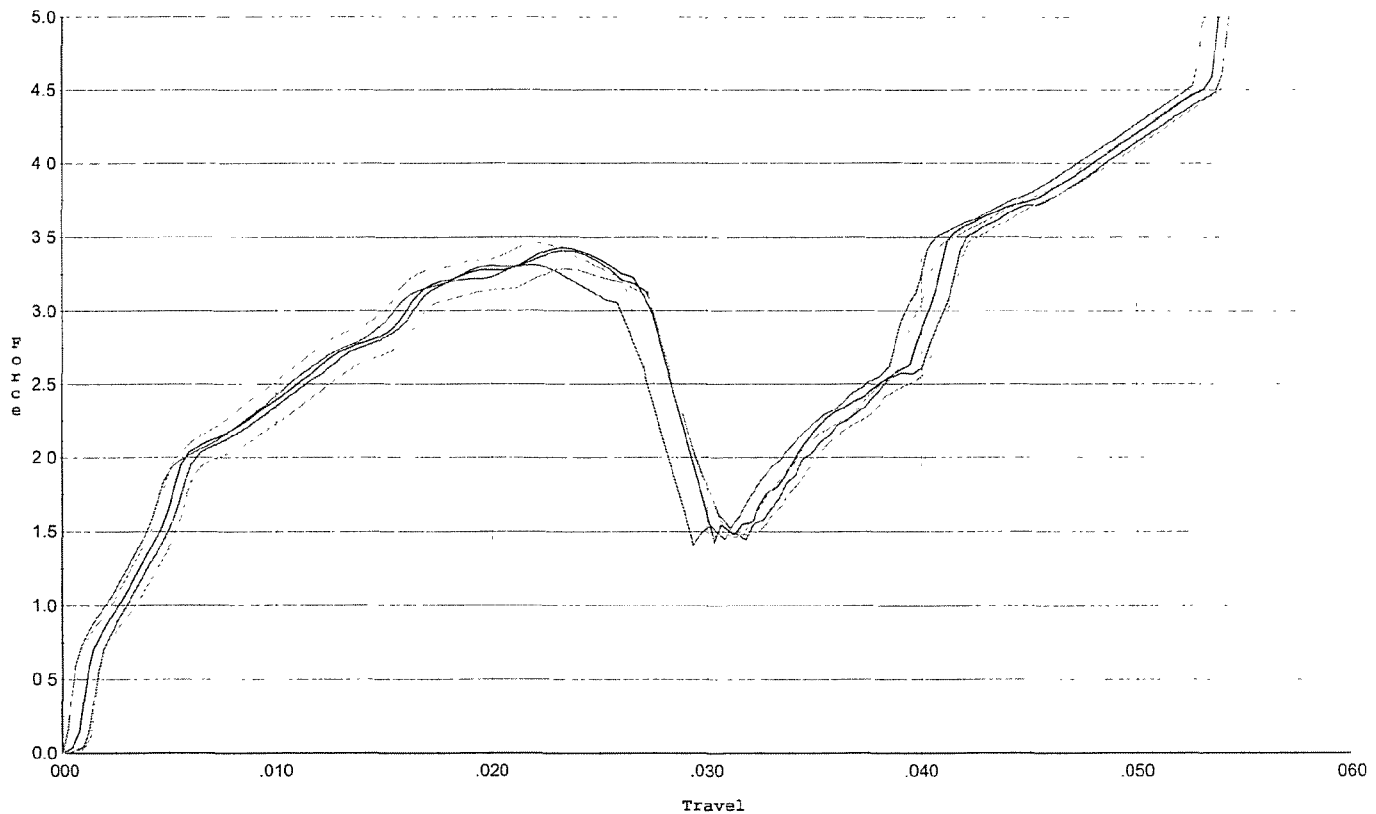
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.252	0.026	0.00	0.031	0.061		Set Trigger
2	3.355	0.026	0.00	0.031	0.062		Set Trigger
3	3.158	0.027	0.00	0.031	0.059		Set Trigger
4	3.268	0.028	0.00	0.031	0.065		Set Trigger
5	3.103	0.026	0.00	0.031	0.059		Set Trigger

A-3-22

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



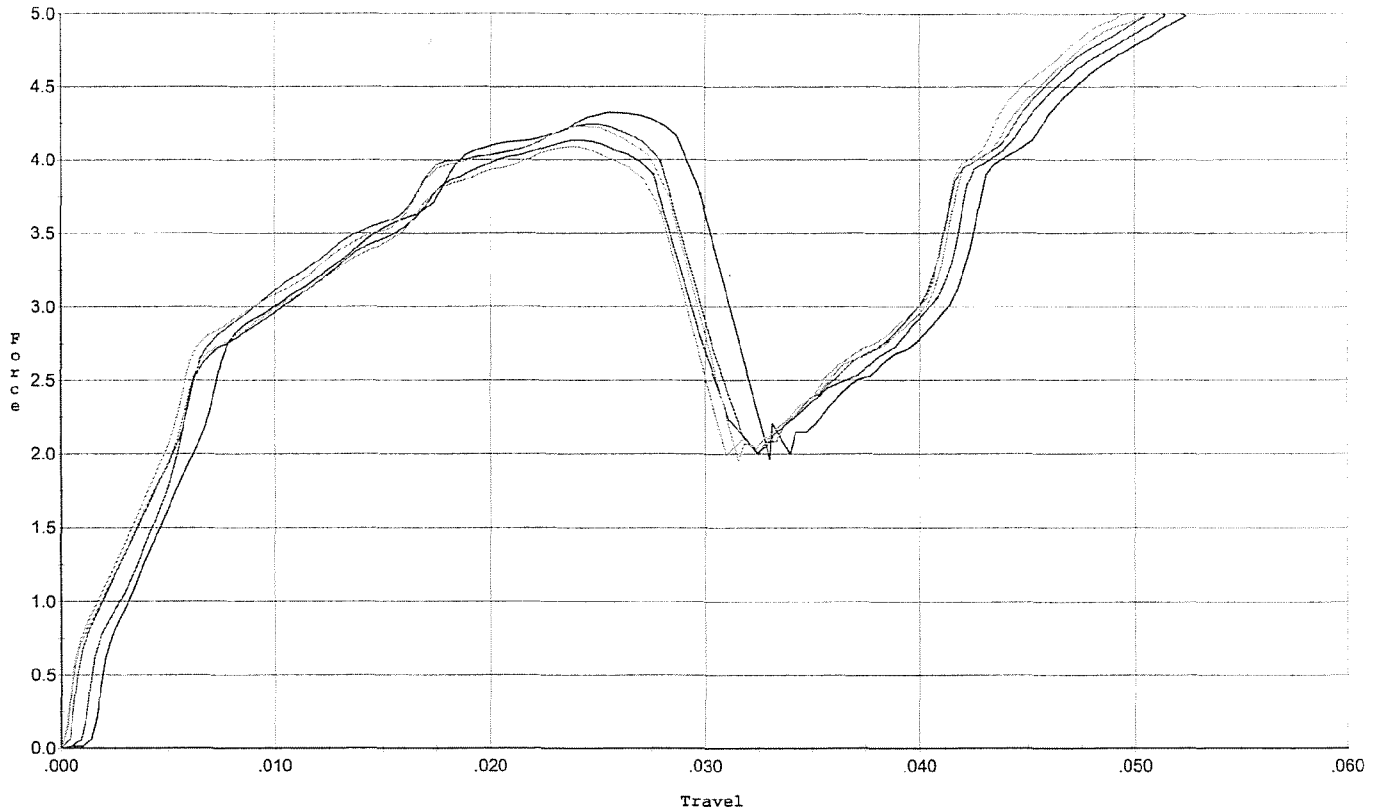
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.410	0.027	0.00	0.029	0.064		Set Trigger
2	3.431	0.027	0.00	0.027	0.066		Set Trigger
3	3.313	0.027	0.00	0.030	0.064		Set Trigger
4	3.461	0.026	0.00	0.030	0.064		Set Trigger
5	3.285	0.027	0.00	0.029	0.061		Set Trigger

A-3-38

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



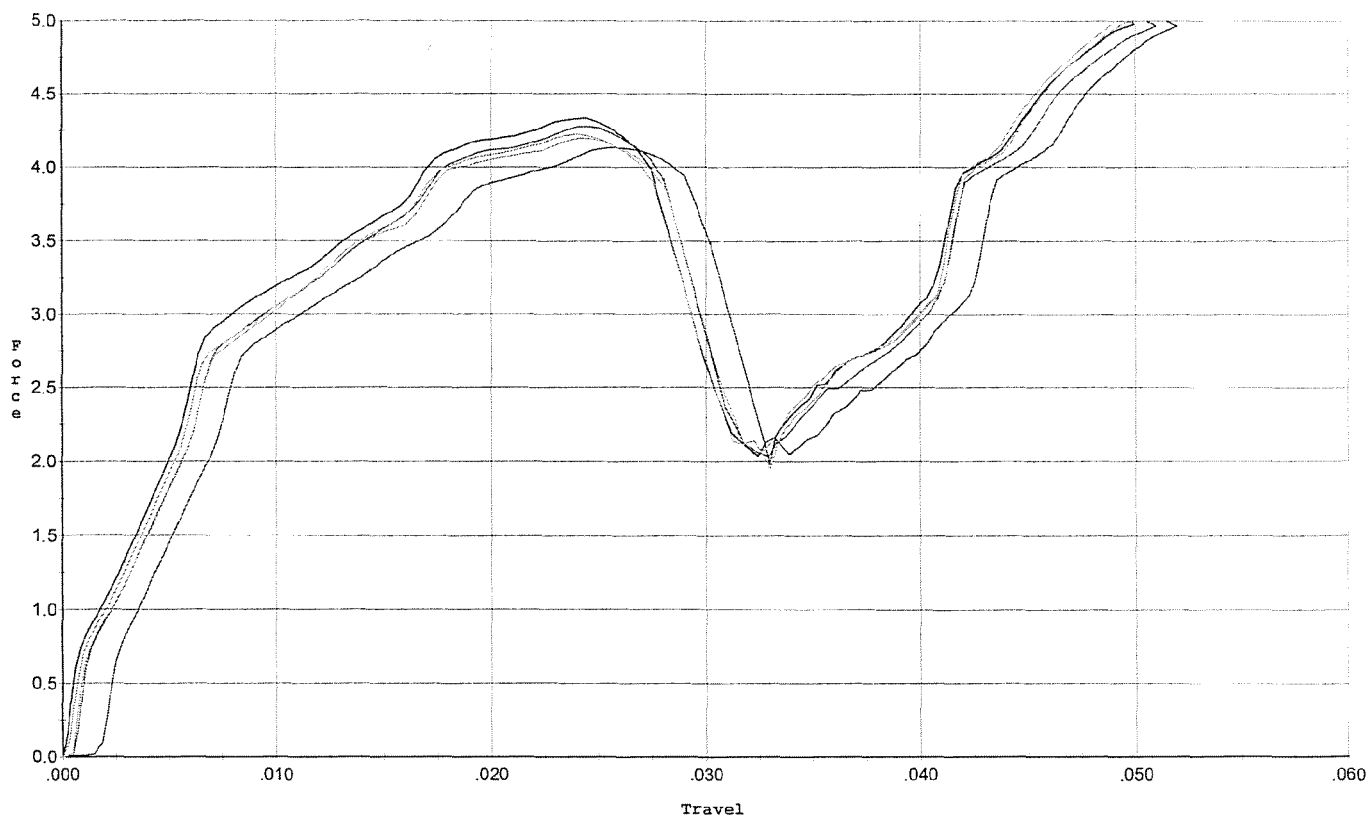
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.134	0.028	0.00	0.025	0.079		Set Trigger
2	4.324	0.030	0.00	0.024	0.087		Set Trigger
3	4.244	0.028	0.00	0.024	0.083		Set Trigger
4	4.227	0.028	0.00	0.023	0.085		Set Trigger
5	4.092	0.028	0.00	0.024	0.081		Set Trigger

A-4.20

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



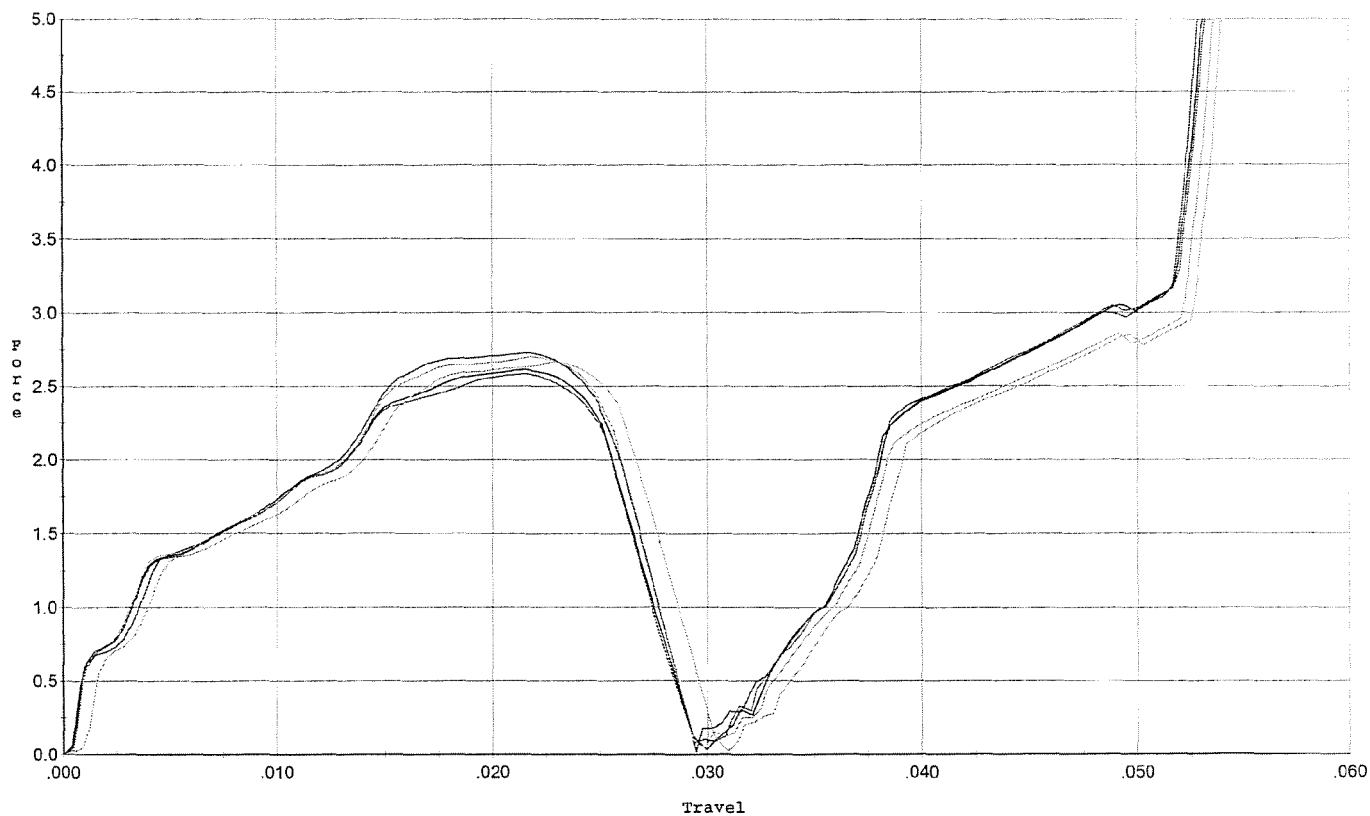
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.134	0.030	0.002	0.024	0.084		Set Trigger
2	4.332	0.027	0.00	0.023	0.083		Set Trigger
3	4.274	0.028	0.00	0.024	0.083		Set Trigger
4	4.226	0.028	0.00	0.024	0.081		Set Trigger
5	4.195	0.028	0.00	0.024	0.082		Set Trigger

A-4.23

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



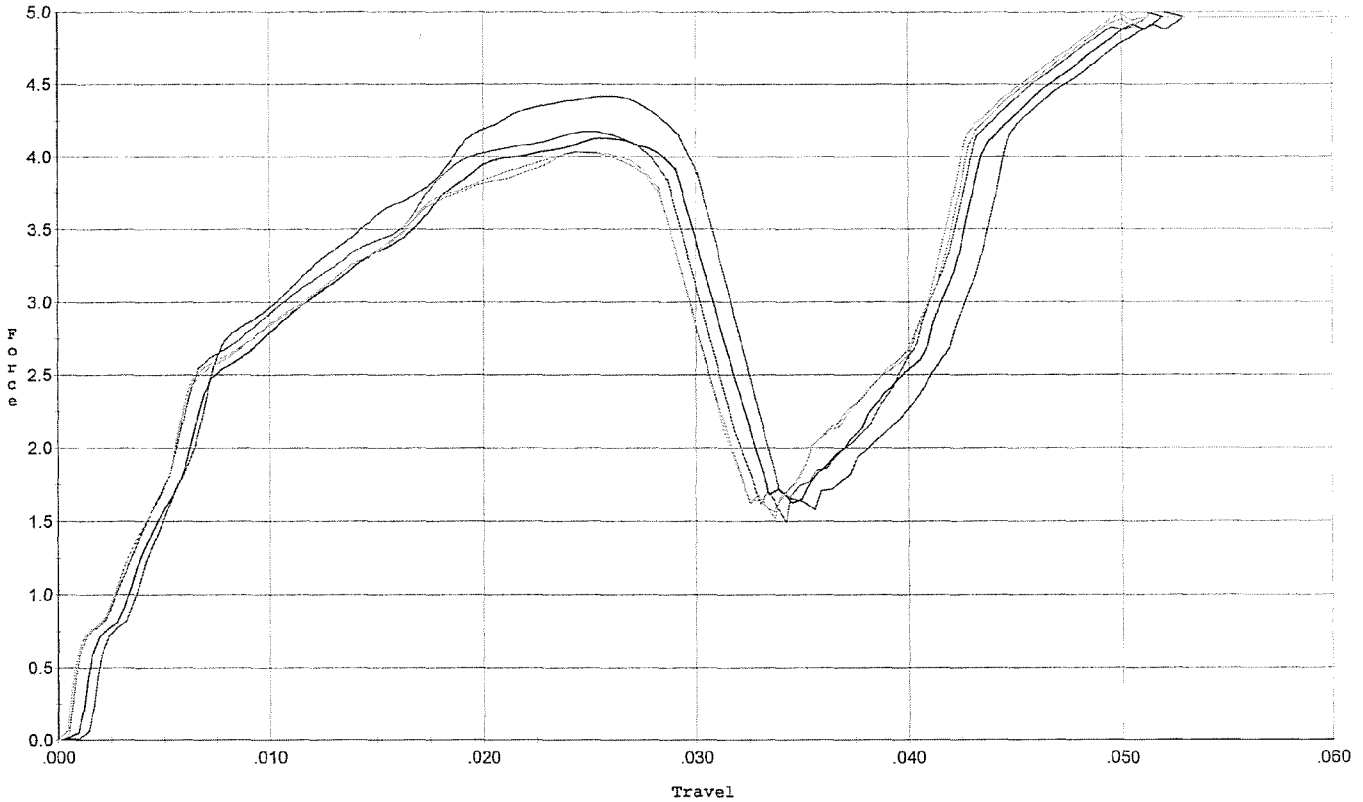
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.728	0.026	0.00	0.033	0.048		Set Trigger
2	2.614	0.025	0.00	0.033	0.045		Set Trigger
3	2.583	0.025	0.00	0.033	0.045		Set Trigger
4	2.667	0.028	0.00	0.033	0.049		Set Trigger
5	2.701	0.026	0.00	0.034	0.047		Set Trigger

A-2-65

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	4.416	0.030	0.00	0.023	0.089		Set Trigger
2	4.128	0.029	0.00	0.024	0.082		Set Trigger
3	4.172	0.029	0.00	0.024	0.083		Set Trigger
4	4.032	0.028	0.00	0.024	0.079		Set Trigger
5	4.036	0.028	0.00	0.024	0.079		Set Trigger

A-4.15