

G6801365

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



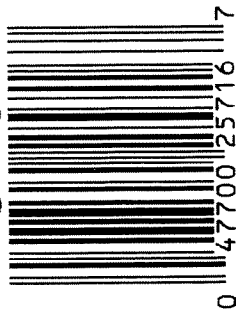
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801365

UPC



GUN SERIAL #

G 6801365

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	(AD)	3/9/09	(AD)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TR
540	APPLY COATINGS (BARREL ACTION)		5/18	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

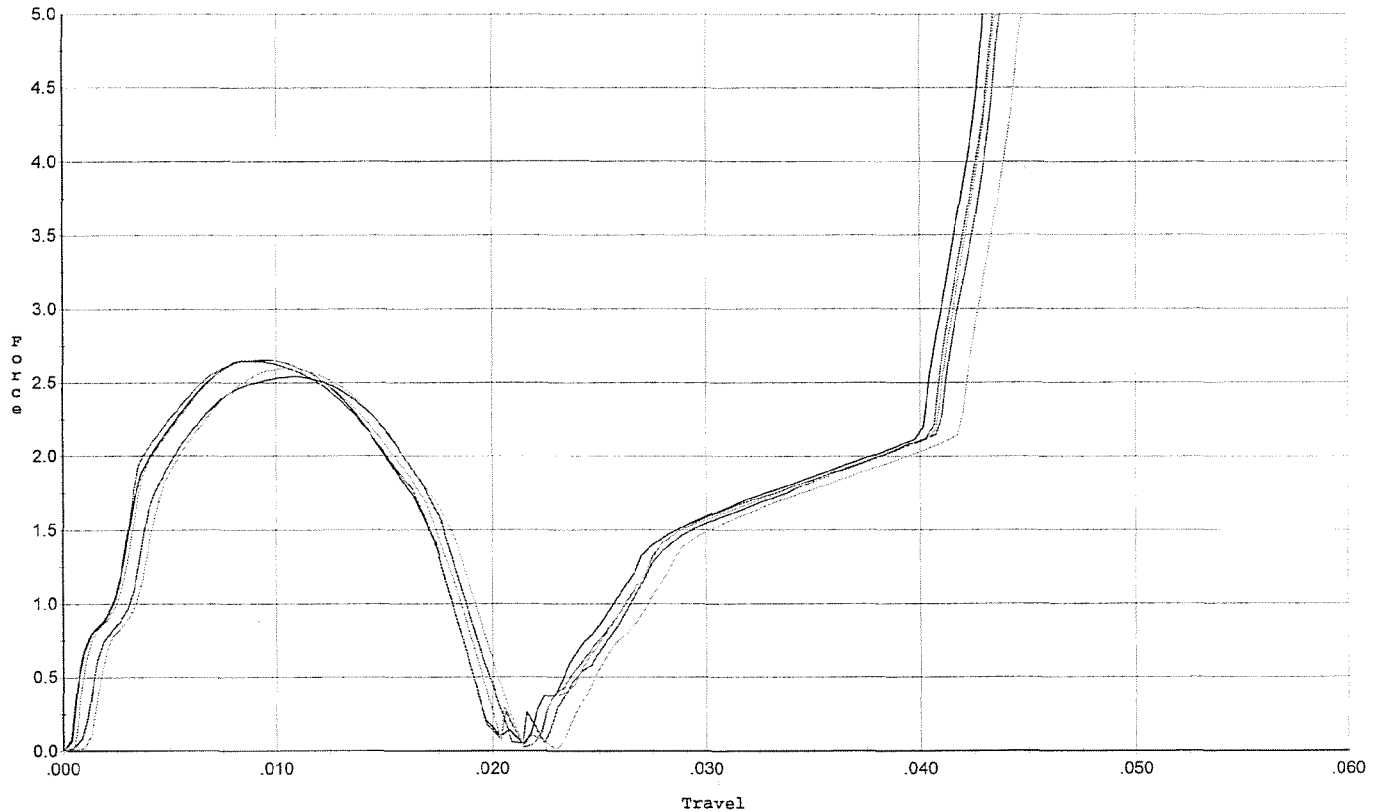
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>2.8</u> <u>2.9</u>	3/23/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.8</u> <u>4.6</u> <u>4.6</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-20-09	RP
	K) ASSEMBLE SWIVEL STUDS		3/23/09	RP
	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	3-23-09	TL
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WW
670	FINAL INSPECTION A) HEADSPACE		3/23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.60</u> <u>2.53</u> <u>2.52</u> <u>2.46</u>	3-23-09	TL
	C) FUNCTION		3/23/09	RP
690	PACK		3/24/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



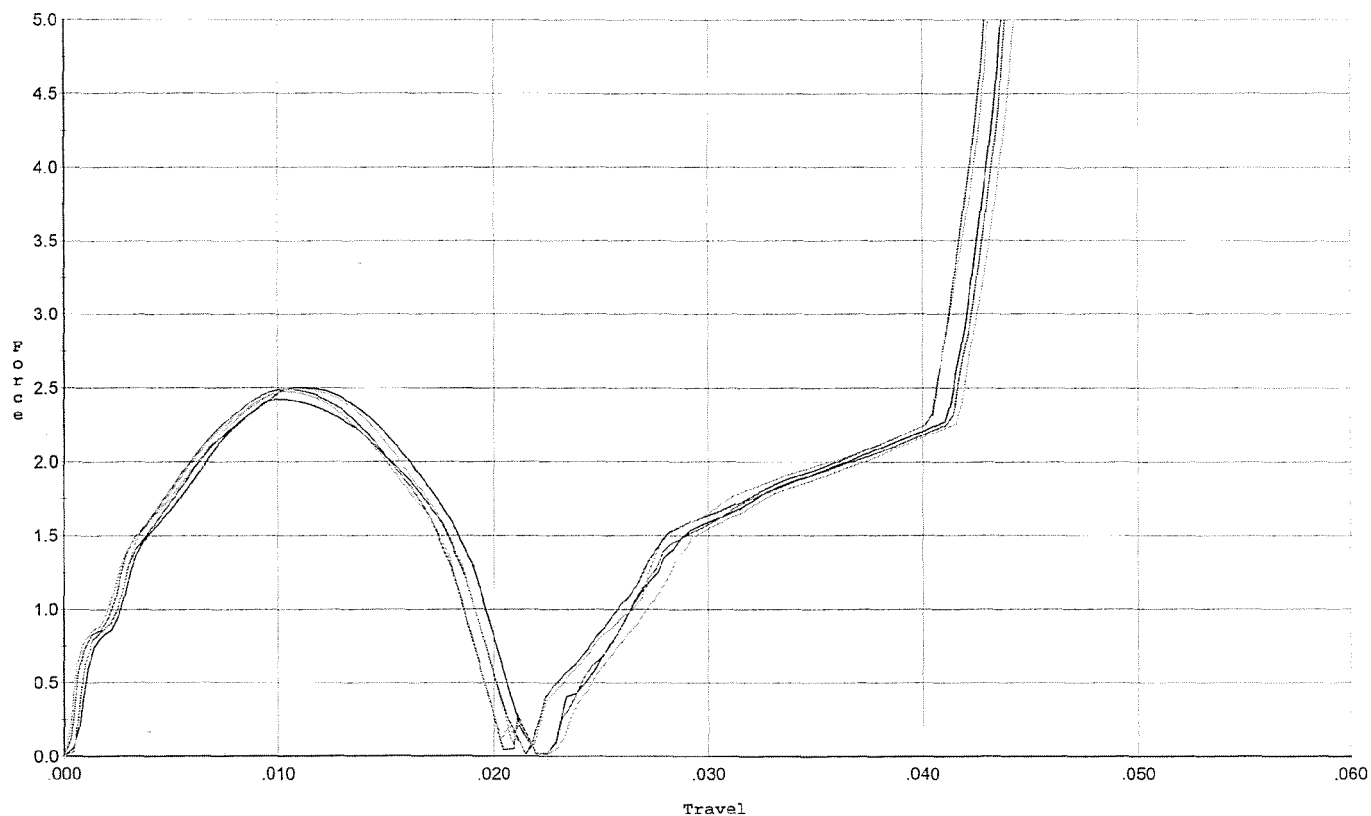
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.540	0.018	0.00	0.031	0.031		Set Trigger
2	2.652	0.017	0.00	0.031	0.033		Set Trigger
3	2.644	0.017	0.00	0.031	0.033		Set Trigger
4	2.600	0.018	0.00	0.032	0.032		Set Trigger
5	2.658	0.018	0.00	0.031	0.034		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



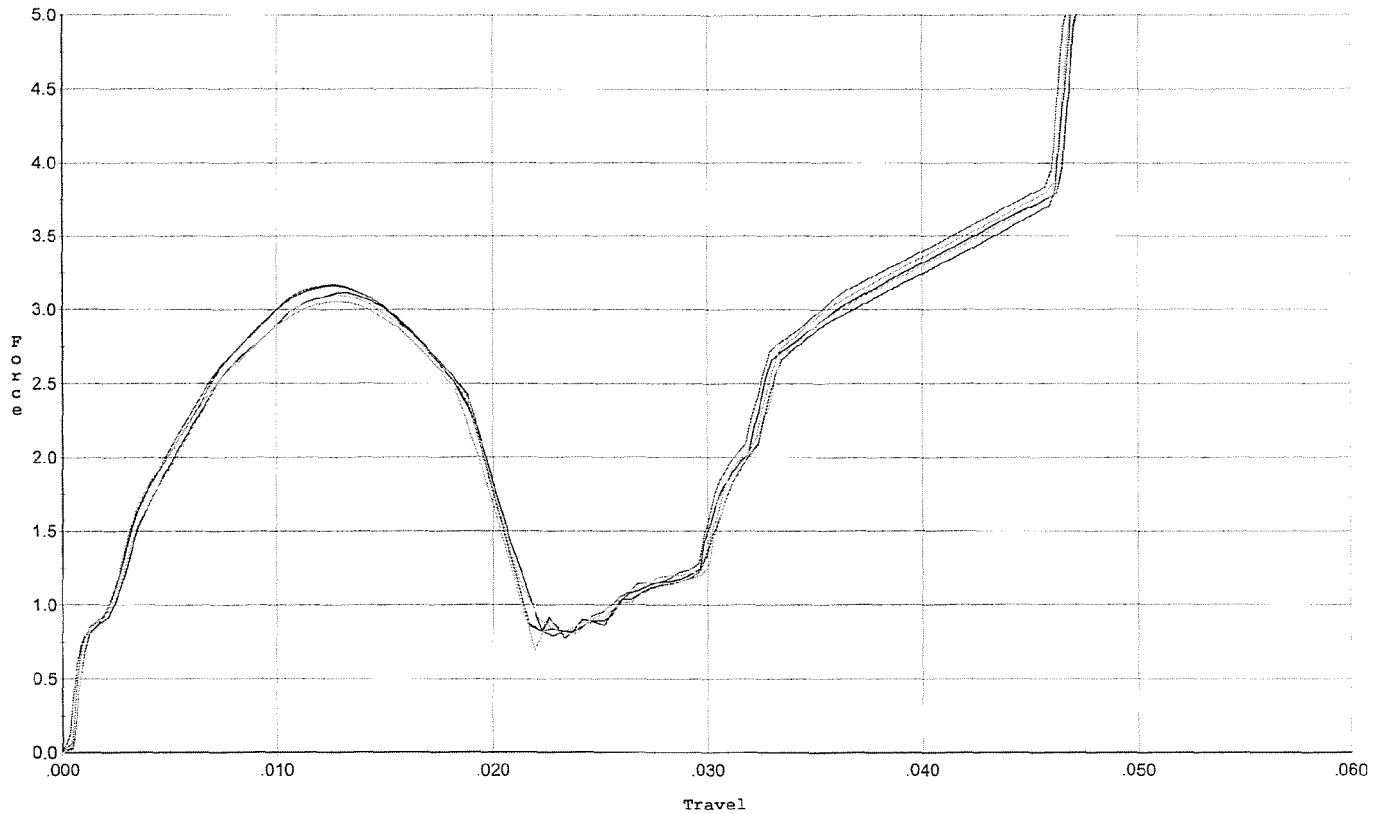
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.424	0.019	0.00	0.030	0.032		Set Trigger
2	2.501	0.019	0.00	0.030	0.033		Set Trigger
3	2.488	0.018	0.00	0.031	0.032		Set Trigger
4	2.493	0.019	0.00	0.031	0.032		Set Trigger
5	2.471	0.018	0.00	0.030	0.032		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



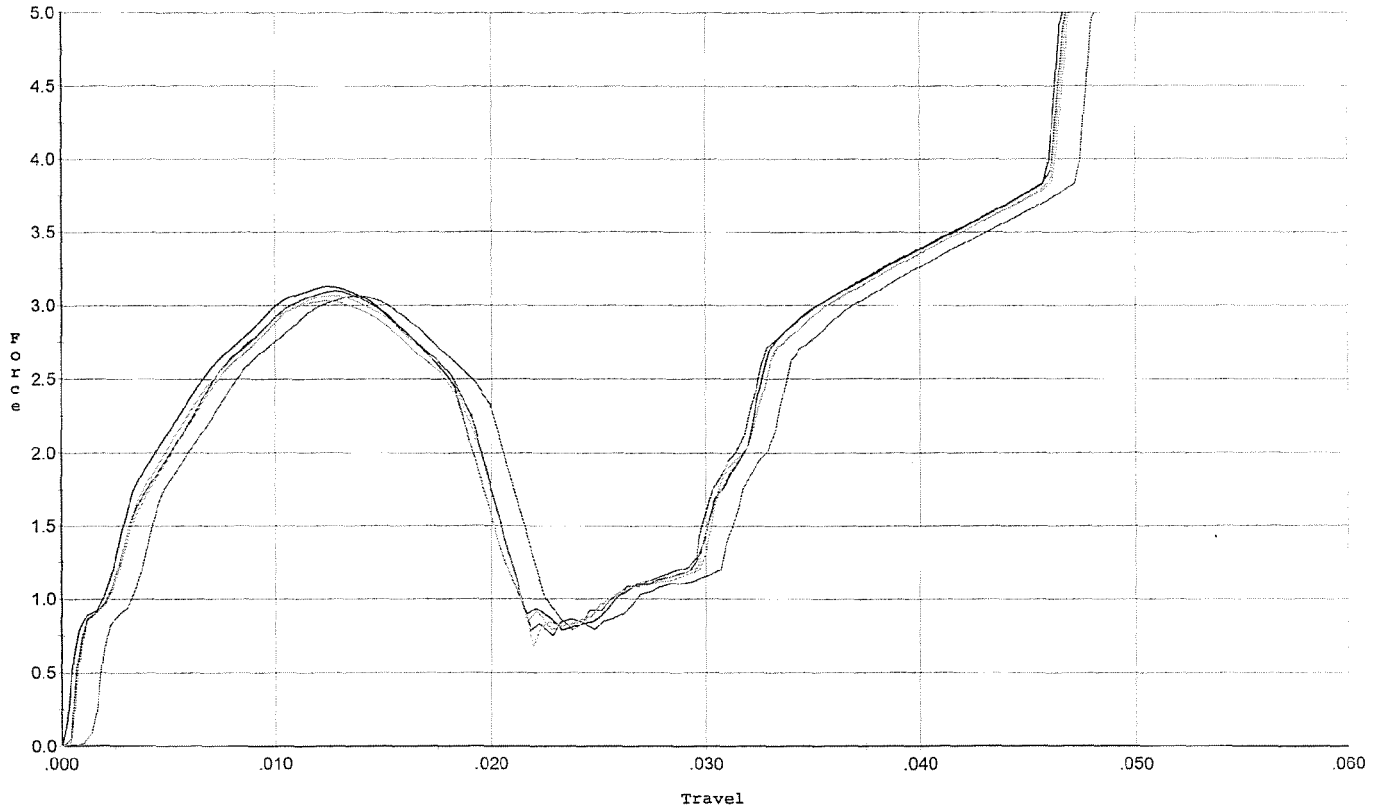
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.019	0.00	0.031	0.042		Set Trigger
2	3.114	0.019	0.00	0.032	0.041		Set Trigger
3	3.169	0.019	0.00	0.031	0.042		Set Trigger
4	3.098	0.019	0.00	0.032	0.041		Set Trigger
5	3.053	0.020	0.00	0.031	0.043		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



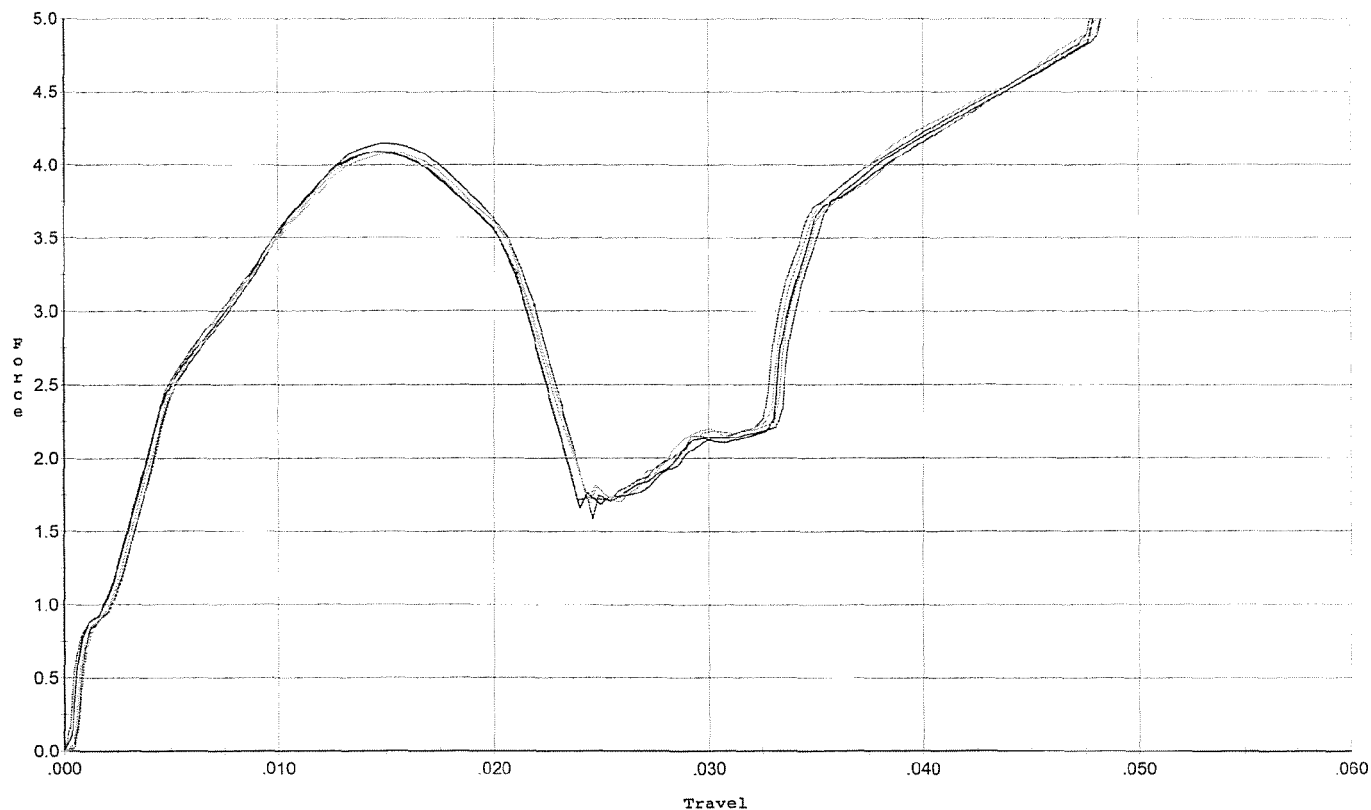
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.098	0.019	0.00	0.031	0.041		Set Trigger
2	3.127	0.018	0.00	0.032	0.041		Set Trigger
3	3.069	0.020	0.00	0.032	0.041		Set Trigger
4	3.066	0.019	0.00	0.031	0.041		Set Trigger
5	3.034	0.018	0.00	0.032	0.039		Set Trigger

A.3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



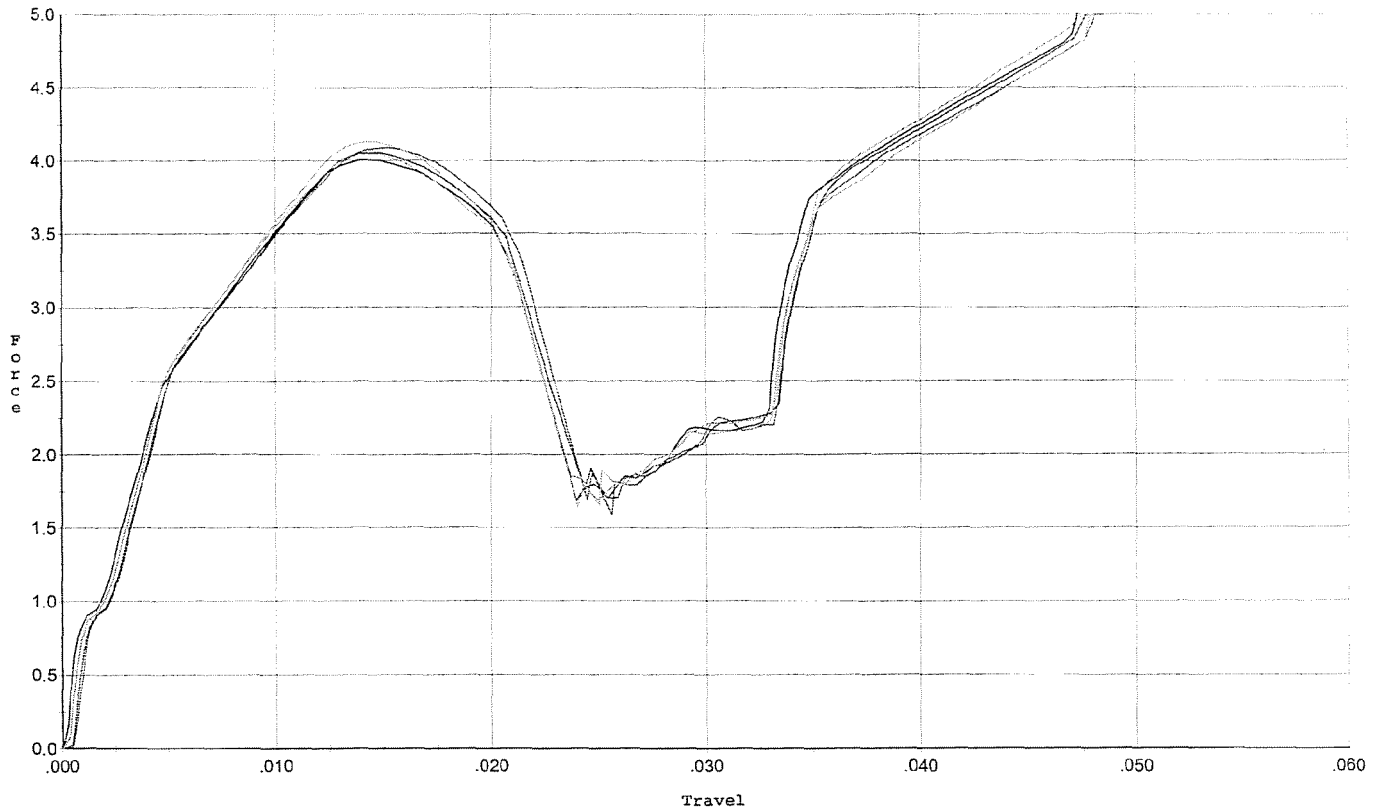
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.022	0.00	0.029	0.061		Set Trigger
2	4.088	0.021	0.00	0.028	0.059		Set Trigger
3	4.093	0.021	0.00	0.028	0.059		Set Trigger
4	4.074	0.022	0.00	0.028	0.063		Set Trigger
5	4.095	0.021	0.00	0.029	0.058		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



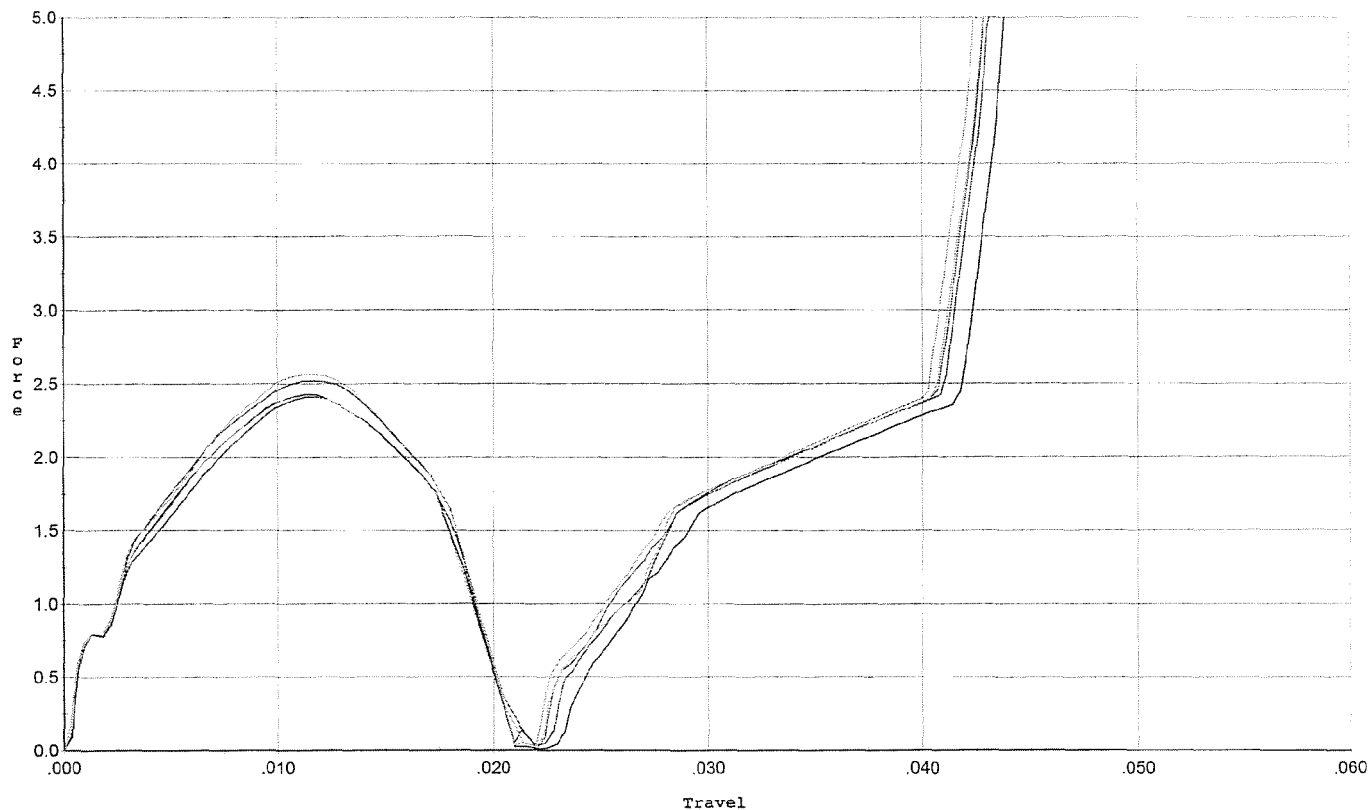
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.021	0.00	0.029	0.058		Set Trigger
2	4.008	0.021	0.00	0.028	0.059		Set Trigger
3	4.088	0.021	0.00	0.028	0.060		Set Trigger
4	4.130	0.021	0.00	0.029	0.060		Set Trigger
5	4.045	0.021	0.00	0.028	0.059		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



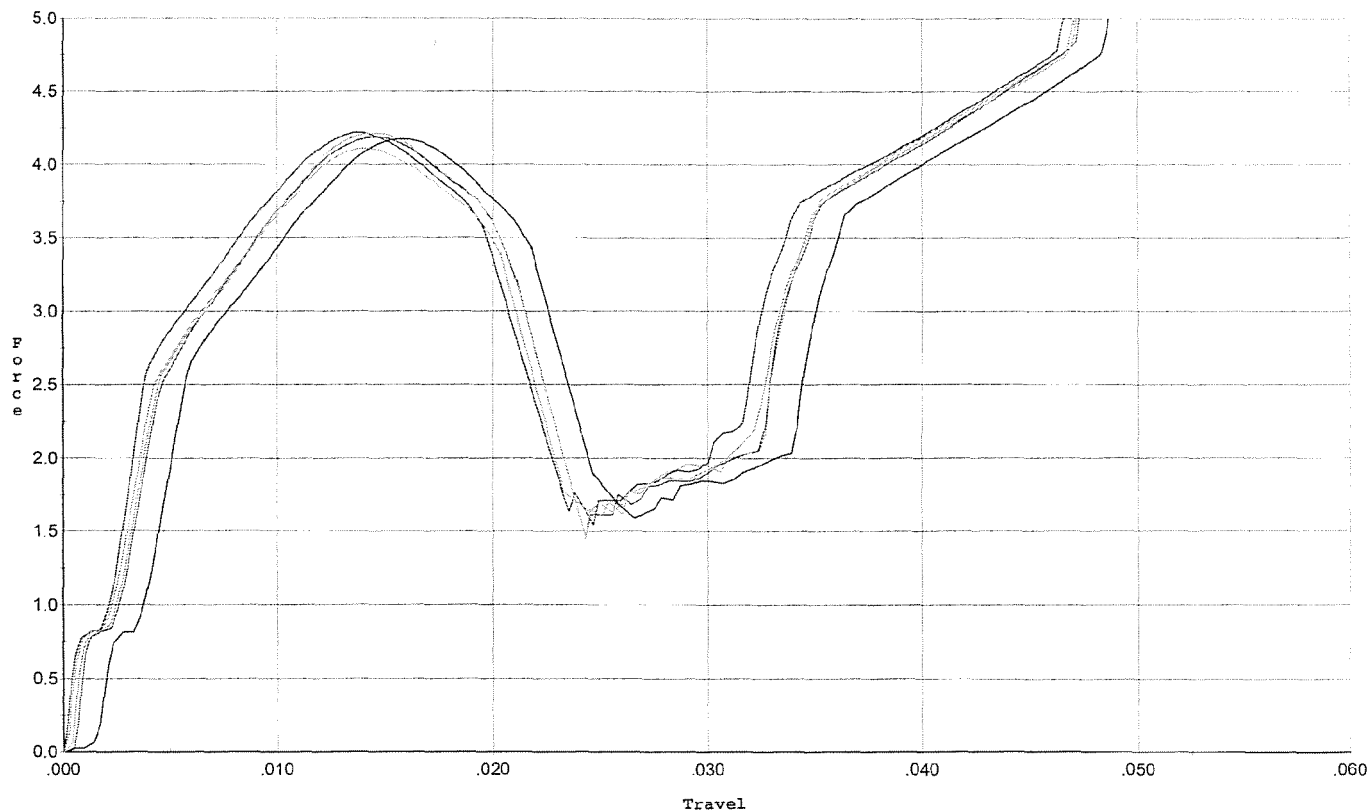
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.409	0.018	0.00	0.030	0.031		Set Trigger
2	2.429	0.019	0.00	0.030	0.032		Set Trigger
3	2.519	0.018	0.00	0.029	0.032		Set Trigger
4	2.418	0.019	0.00	0.029	0.032		Set Trigger
5	2.563	0.018	0.00	0.029	0.033		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs +/- 1.0 lb for final test



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.218	0.020	0.00	0.029	0.057		Set Trigger
2	4.173	0.022	0.00	0.029	0.059		Set Trigger
3	4.185	0.021	0.00	0.028	0.060		Set Trigger
4	4.107	0.020	0.00	0.029	0.058		Set Trigger
5	4.211	0.021	0.00	0.028	0.061		Set Trigger

A 4.17