

G6801370

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



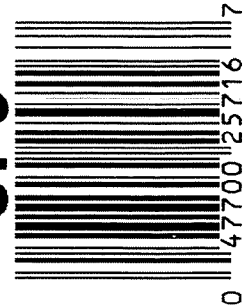
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801370

UPC



GUN SERIAL #

G 6801370

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	JPL
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	JPL
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-23-09	JF
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/25/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-26	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	JPL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

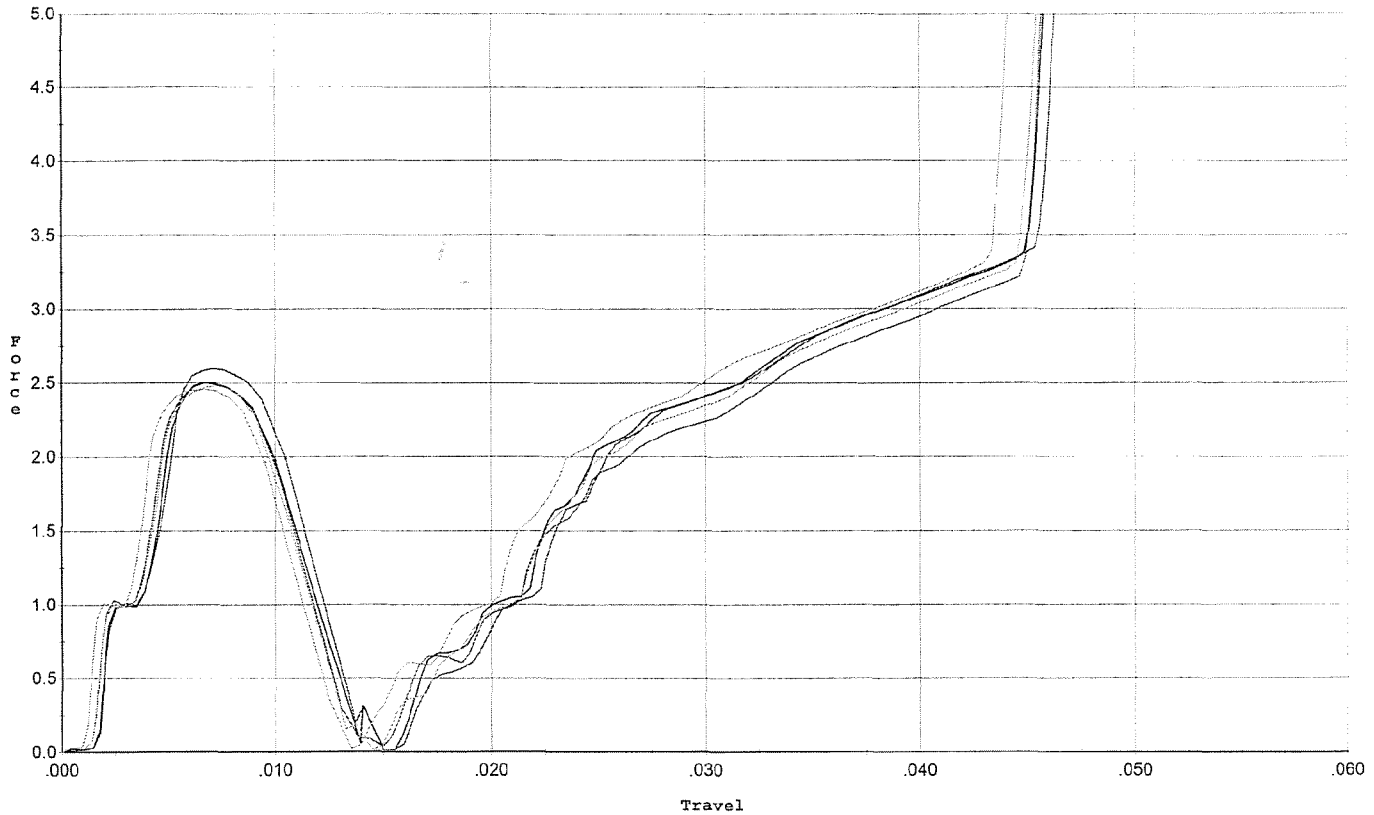
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	4-13-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-13-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	4-13-09	WV
	J) ASSEMBLE STOCK		4-2-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-13-09	WV
	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	4-4-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-4-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-13-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>237</u> <u>232</u> <u>236</u> <u>247</u> <u>239</u>	4-7-09	RP
	C) FUNCTION		4-13-09	WV
690	PACK		6/4/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



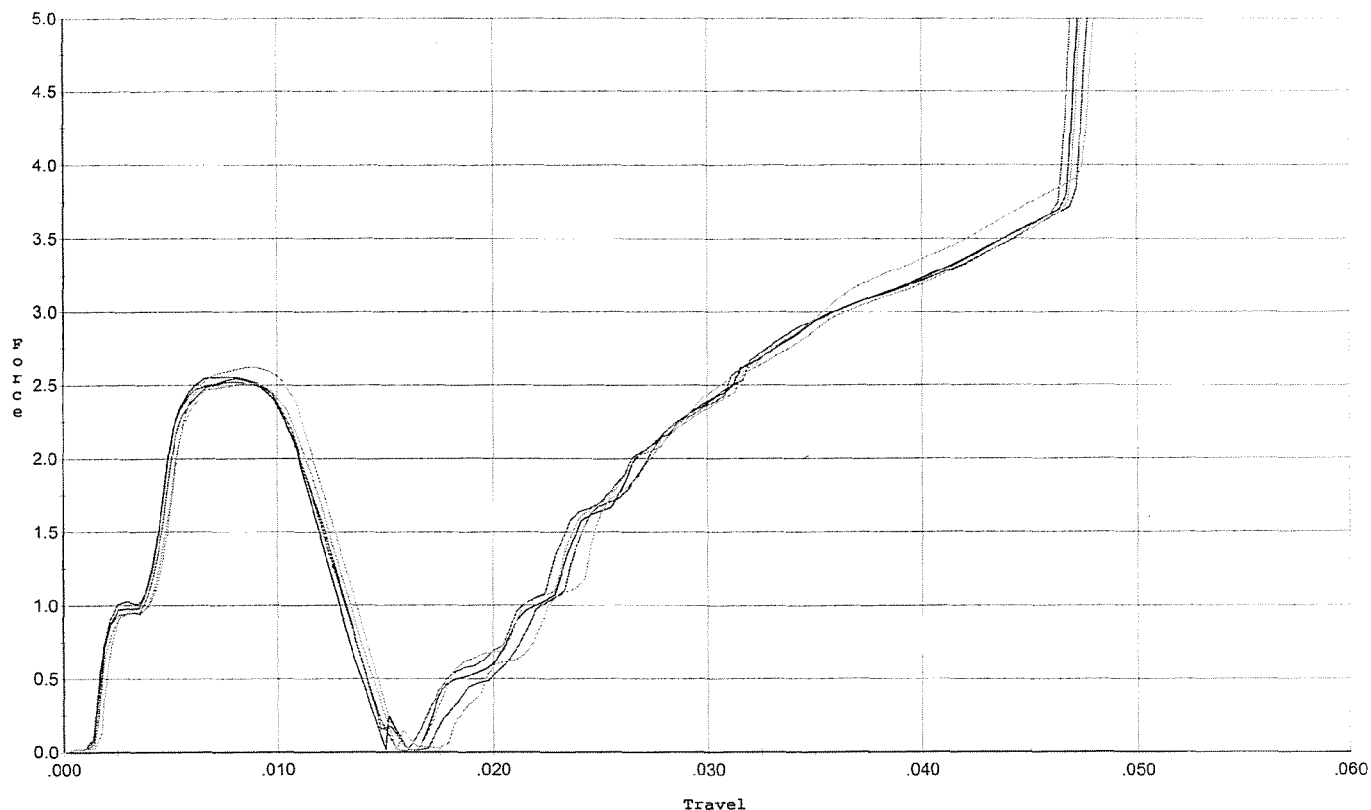
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.010	0.00	0.038	0.016		Set Trigger
2	2.499	0.010	0.00	0.038	0.015		Set Trigger
3	2.497	0.010	0.00	0.038	0.015		Set Trigger
4	2.478	0.011	0.00	0.038	0.016		Set Trigger
5	2.454	0.010	0.00	0.037	0.015		Set Trigger

A-2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



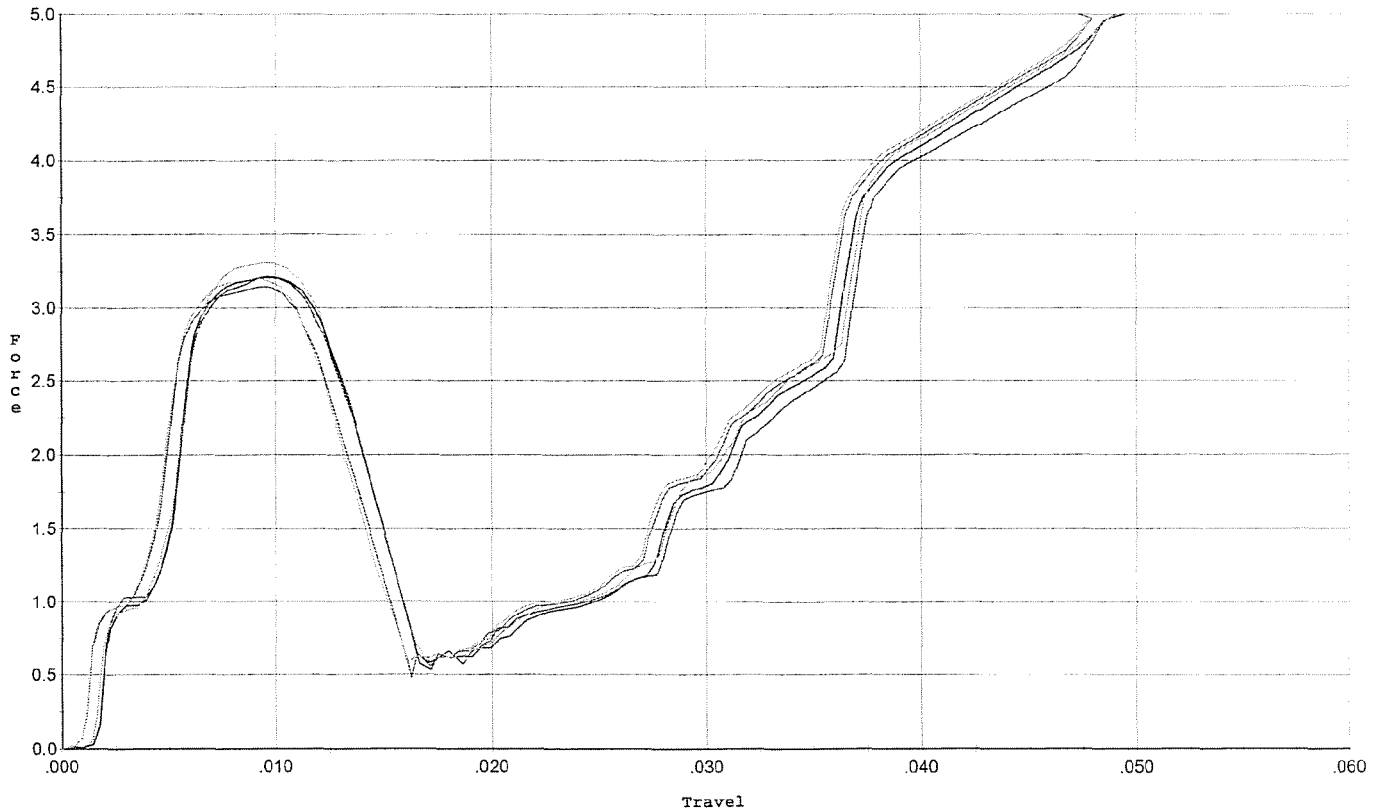
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.544	0.012	0.00	0.038	0.019		Set Trigger
2	2.556	0.011	0.004	0.038	0.017		Set Trigger
3	2.519	0.013	0.004	0.037	0.019		Set Trigger
4	2.512	0.012	0.00	0.039	0.018		Set Trigger
5	2.618	0.013	0.00	0.037	0.020		Set Trigger

A-2-SS

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



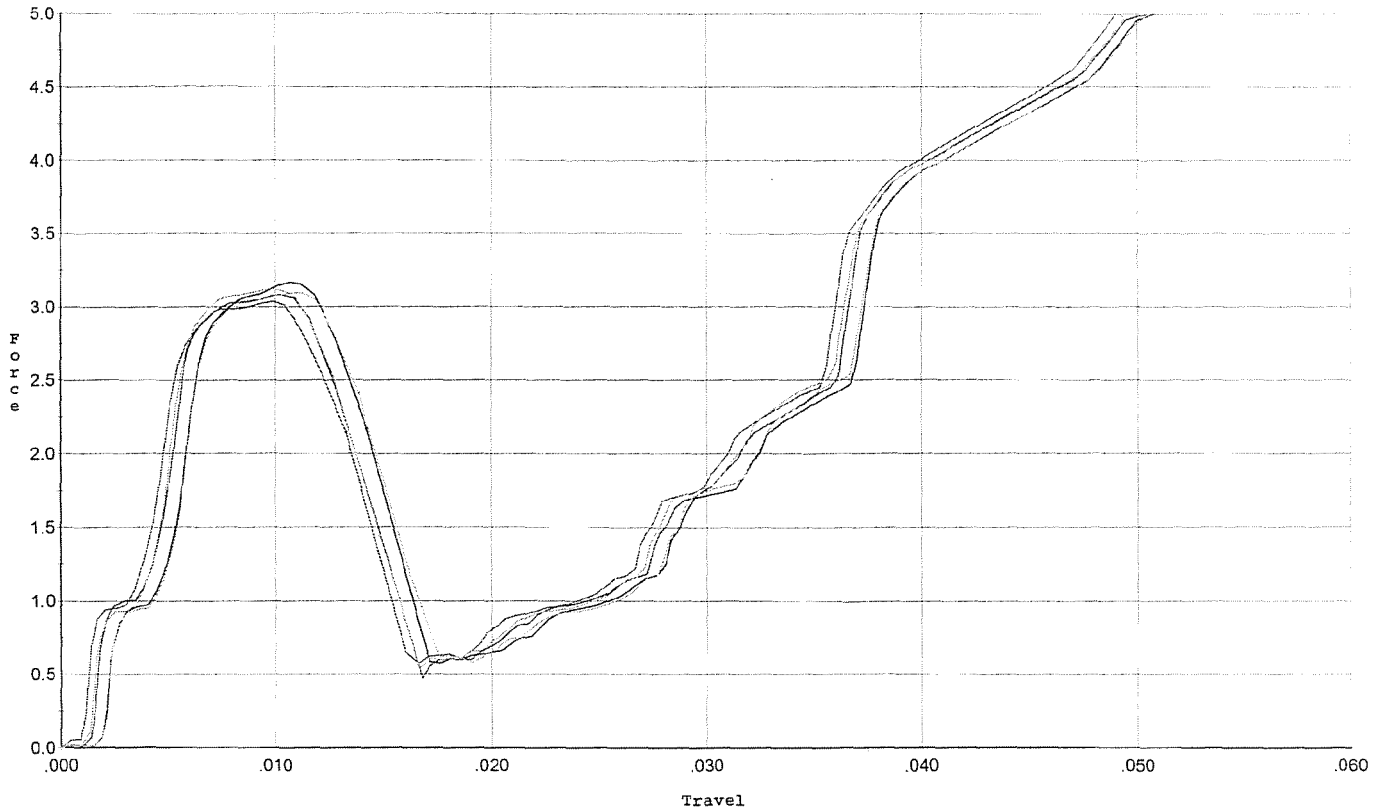
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.205	0.014	0.004	0.039	0.026		Set Trigger
2	3.212	0.013	0.00	0.039	0.026		Set Trigger
3	3.142	0.014	0.00	0.038	0.027		Set Trigger
4	3.204	0.012	0.00	0.039	0.024		Set Trigger
5	3.308	0.013	0.00	0.038	0.026		Set Trigger

A-3.21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



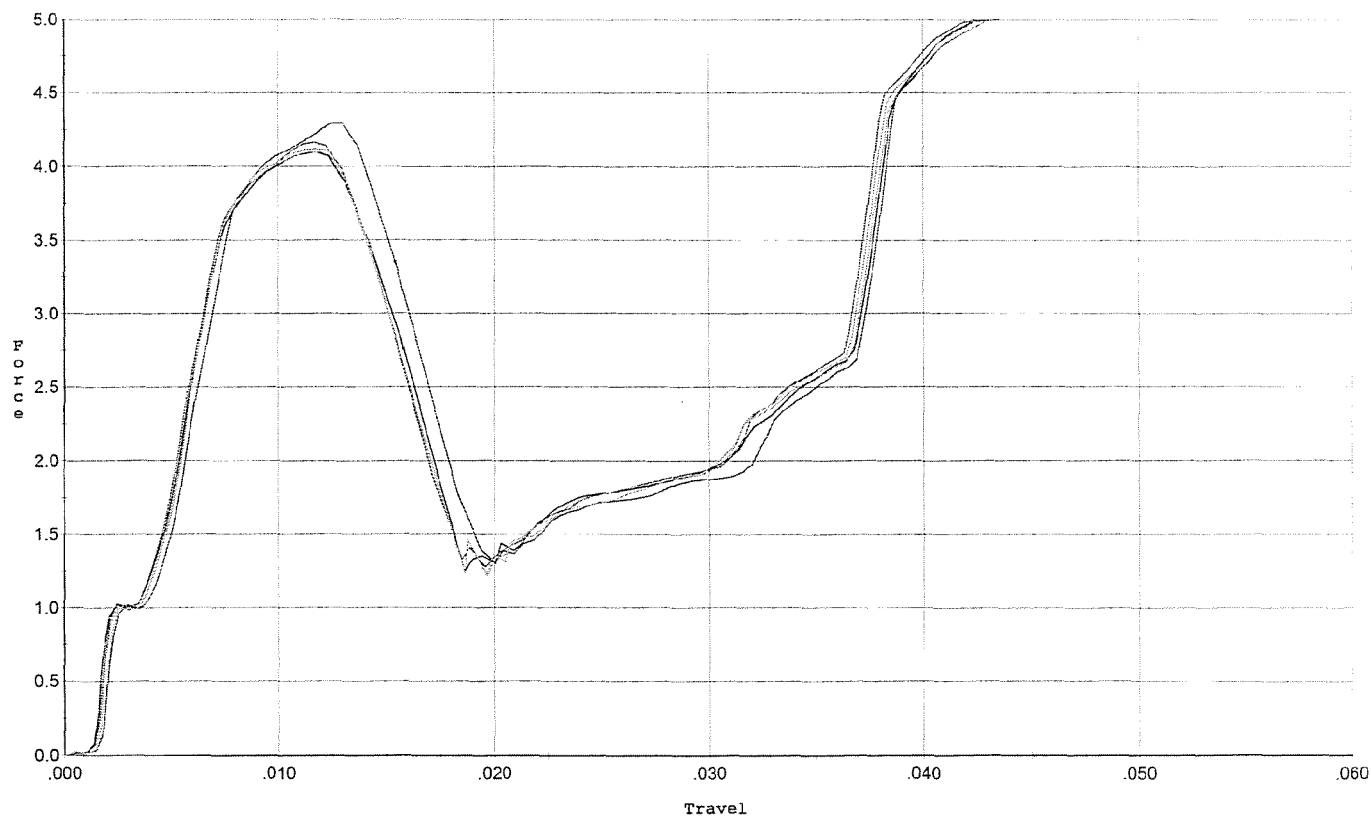
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.083	0.015	0.00	0.039	0.027		Set Trigger
2	3.166	0.014	0.00	0.039	0.026		Set Trigger
3	3.034	0.013	0.00	0.039	0.025		Set Trigger
4	3.095	0.014	0.002	0.039	0.025		Set Trigger
5	3.123	0.013	0.00	0.039	0.024		Set Trigger

A-3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



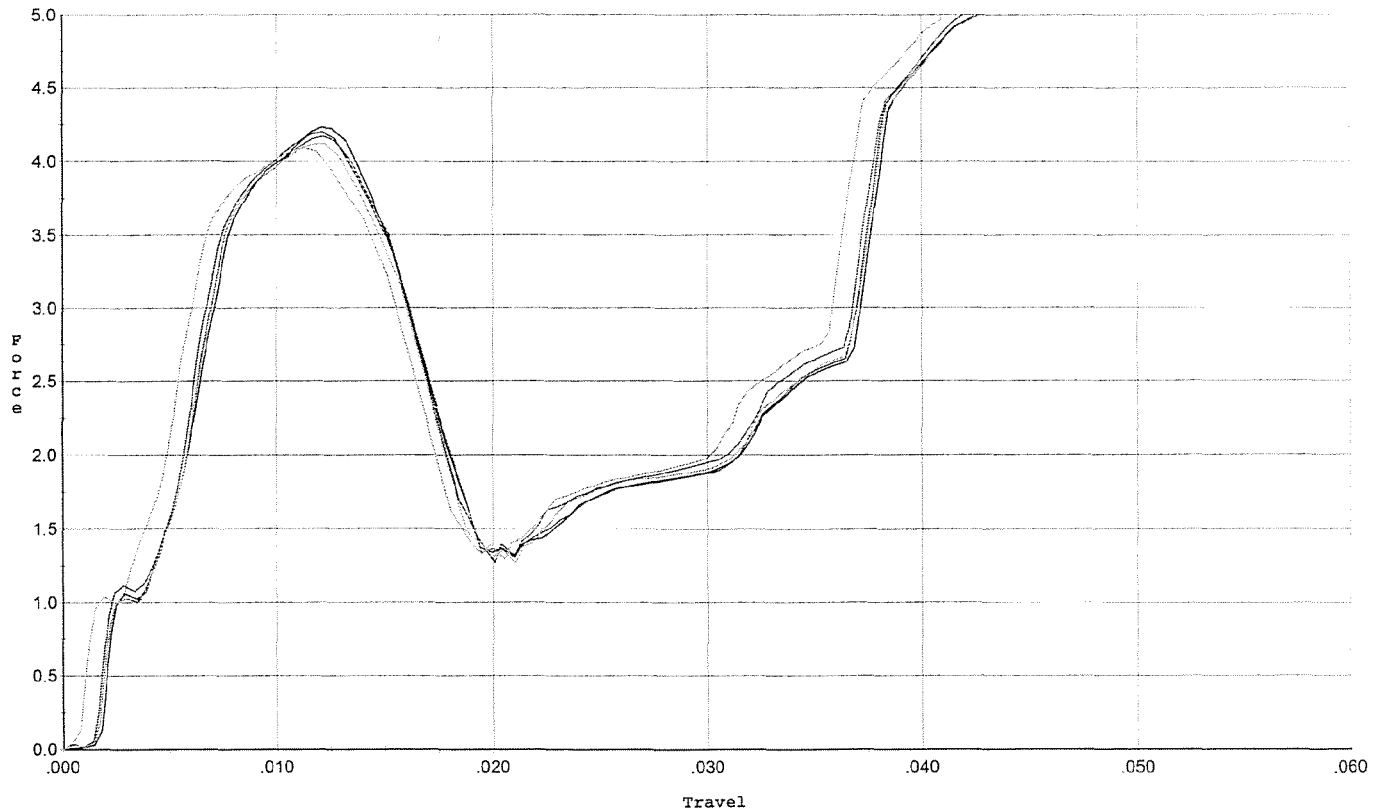
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.015	0.00	0.038	0.038		Set Trigger
2	4.098	0.016	0.00	0.037	0.038		Set Trigger
3	4.164	0.014	0.00	0.037	0.035		Set Trigger
4	4.099	0.014	0.004	0.037	0.034		Set Trigger
5	4.119	0.014	0.00	0.038	0.035		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



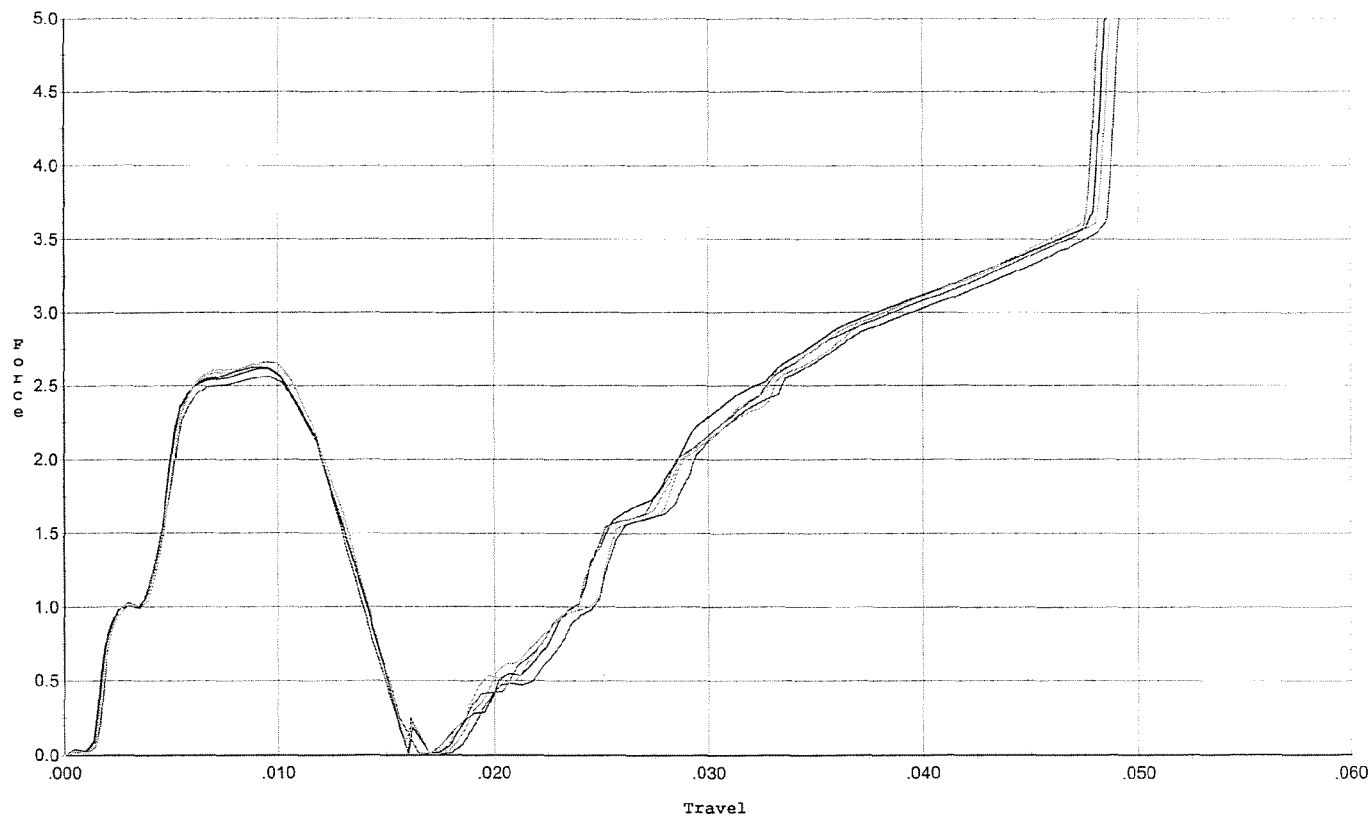
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.197	0.015	0.00	0.037	0.038		Set Trigger
2	4.231	0.015	0.00	0.037	0.037		Set Trigger
3	4.169	0.015	0.00	0.037	0.037		Set Trigger
4	4.118	0.016	0.00	0.037	0.038		Set Trigger
5	4.091	0.015	0.00	0.036	0.038		Set Trigger

A-4.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



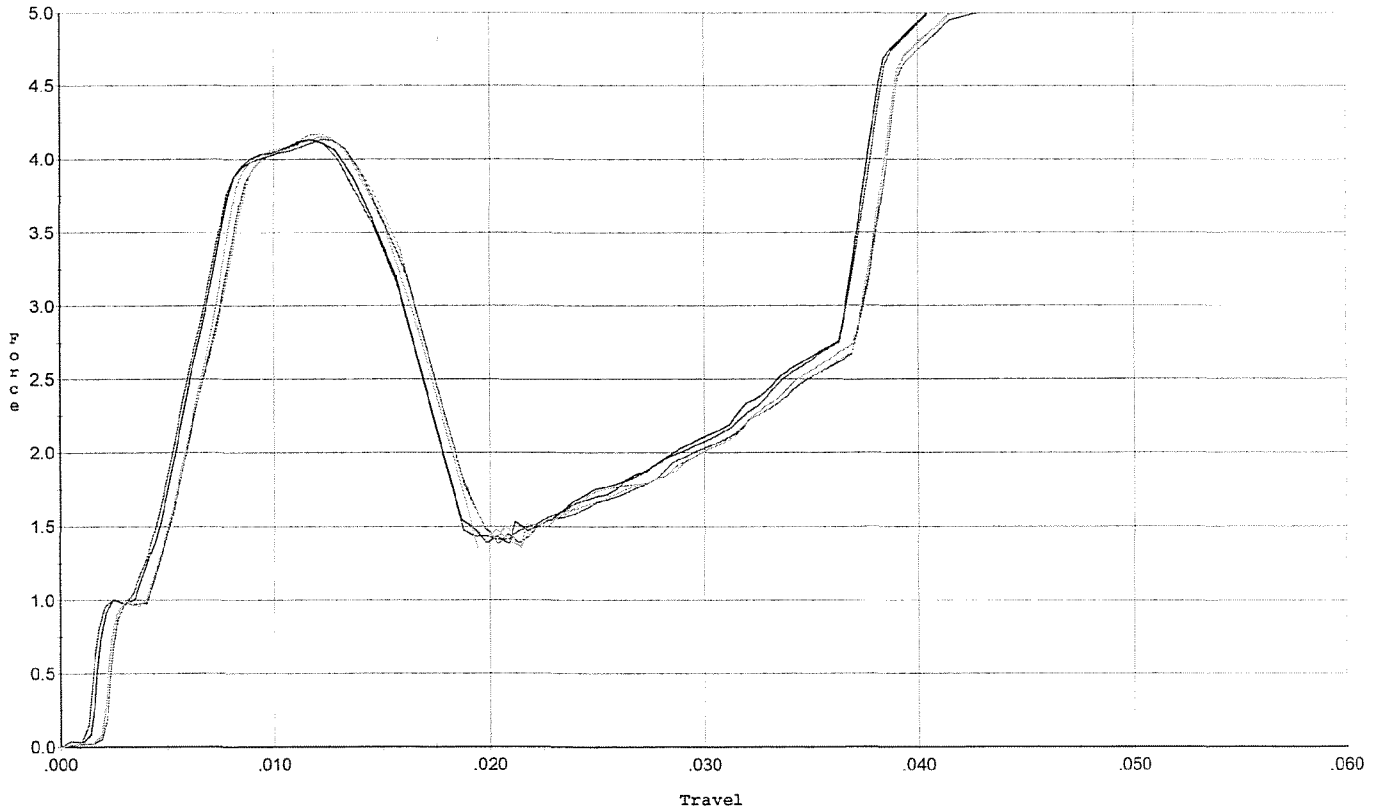
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.627	0.012	0.00	0.039	0.019		Set Trigger
2	2.617	0.014	0.00	0.038	0.022		Set Trigger
3	2.562	0.014	0.00	0.038	0.022		Set Trigger
4	2.660	0.013	0.00	0.038	0.021		Set Trigger
5	2.669	0.013	0.00	0.038	0.021		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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	4.129	0.016	0.00	0.037	0.039		Set Trigger
2	4.133	0.016	0.00	0.037	0.039		Set Trigger
3	4.134	0.016	0.004	0.037	0.038		Set Trigger
4	4.174	0.017	0.002	0.037	0.040		Set Trigger
5	4.152	0.016	0.00	0.037	0.038		Set Trigger

A-4.14