

G6801371

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



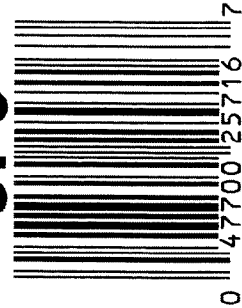
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801371

UPC



GUN SERIAL # G 6801371

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE		2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RJL
480	MAGNAFLUX BBL ACTION	(H)	3/5/09	(H)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	moj
540	APPLY COATINGS (BARREL ACTION)		3/9	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-11-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

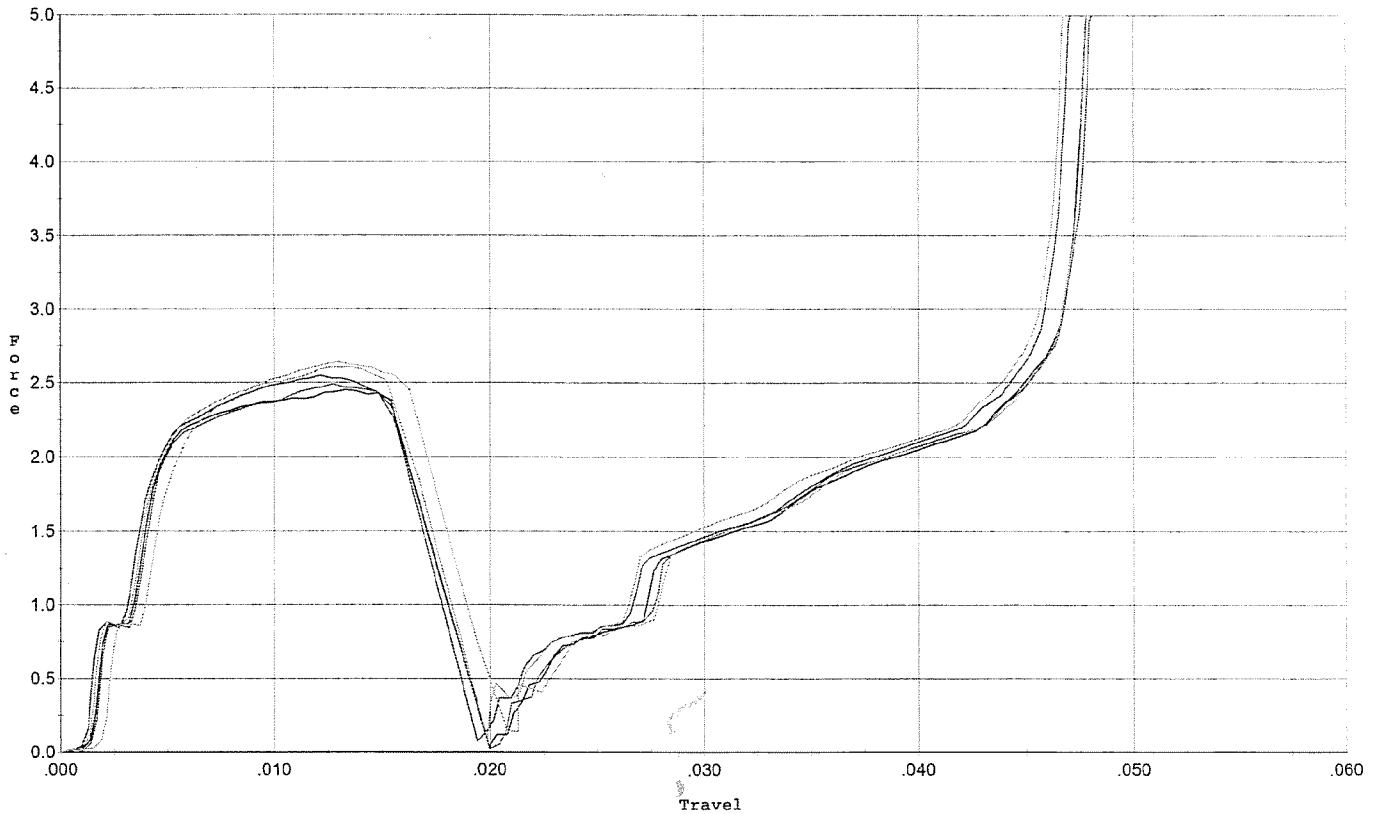
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6</u>	3-18-09	N/N
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-18-09	N/N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-18-09	N/N
	J) ASSEMBLE STOCK		3-11-09	SPAD
	K) ASSEMBLE SWIVEL STUDS		3-19-09	N/N
	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	3-16-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	N/N
670	FINAL INSPECTION A) HEADSPACE		3-18-09	N/N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.39</u> <u>2.44</u> <u>2.46</u> <u>2.50</u>	3-18-09	TK
	C) FUNCTION		3-18-09	N/N
690	PACK		3/19/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



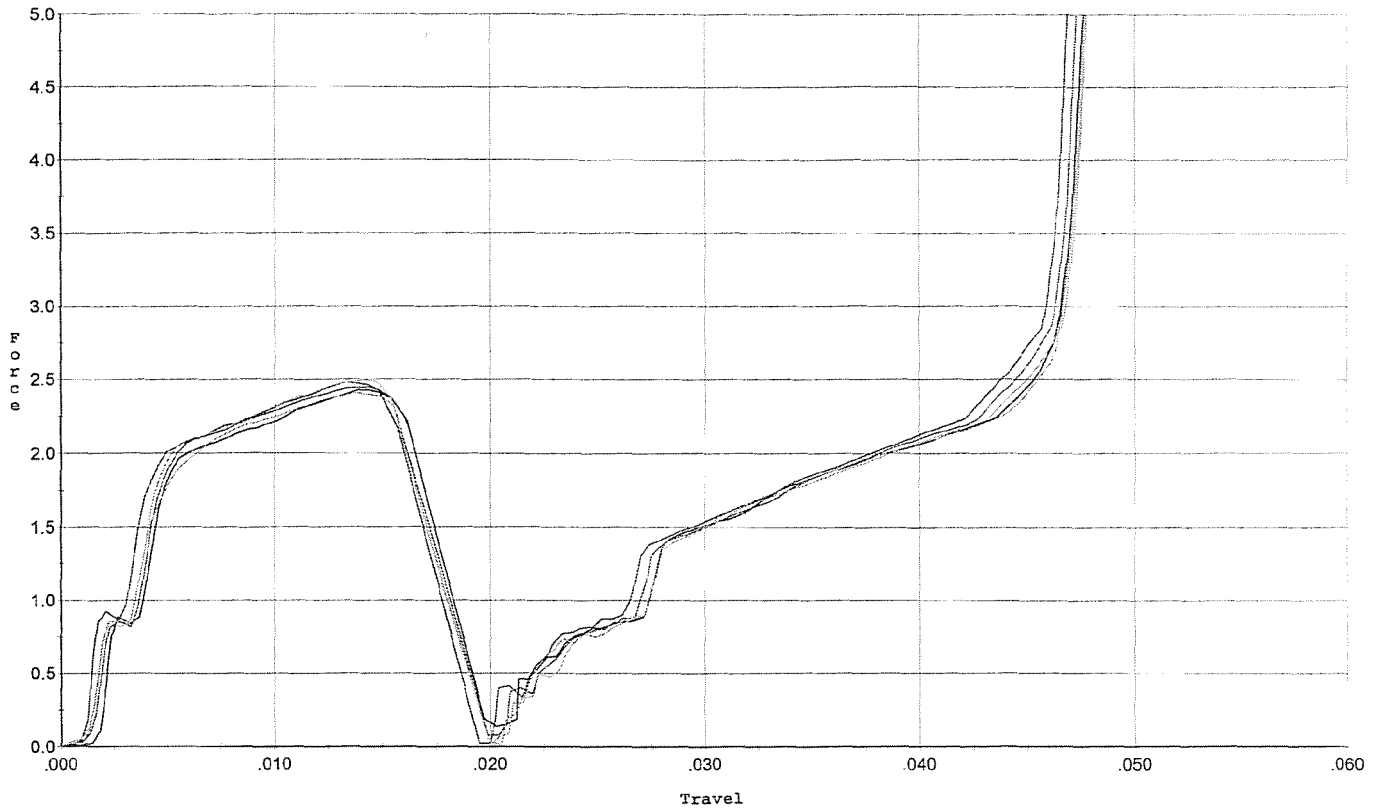
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.016	0.00	0.035	0.028		Set Trigger
2	2.450	0.015	0.003	0.036	0.027		Set Trigger
3	2.488	0.015	0.00	0.036	0.027		Set Trigger
4	2.639	0.016	0.00	0.035	0.029		Set Trigger
5	2.606	0.017	0.00	0.034	0.031		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



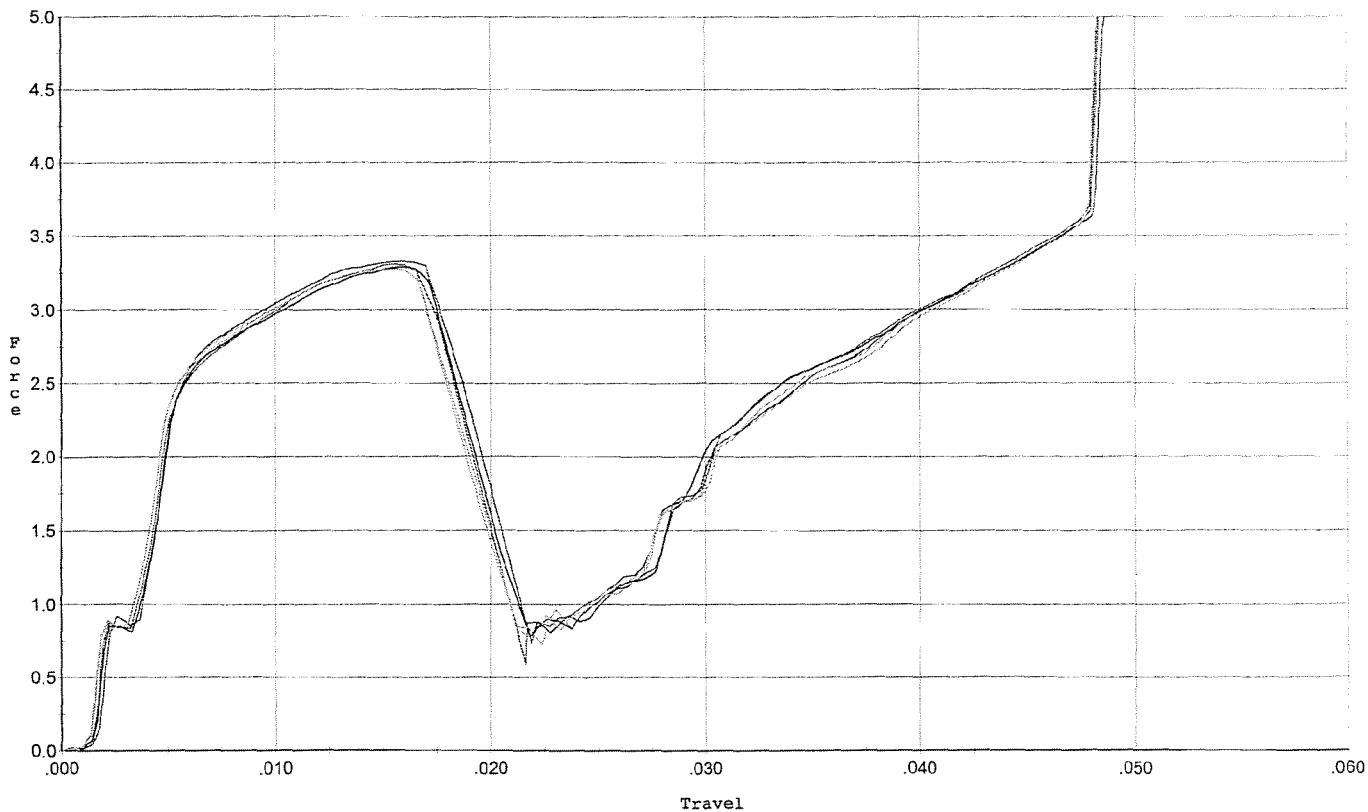
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.016	0.00	0.035	0.028		Set Trigger
2	2.429	0.016	0.00	0.035	0.027		Set Trigger
3	2.446	0.017	0.00	0.035	0.029		Set Trigger
4	2.404	0.015	0.00	0.036	0.026		Set Trigger
5	2.492	0.015	0.00	0.036	0.027		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



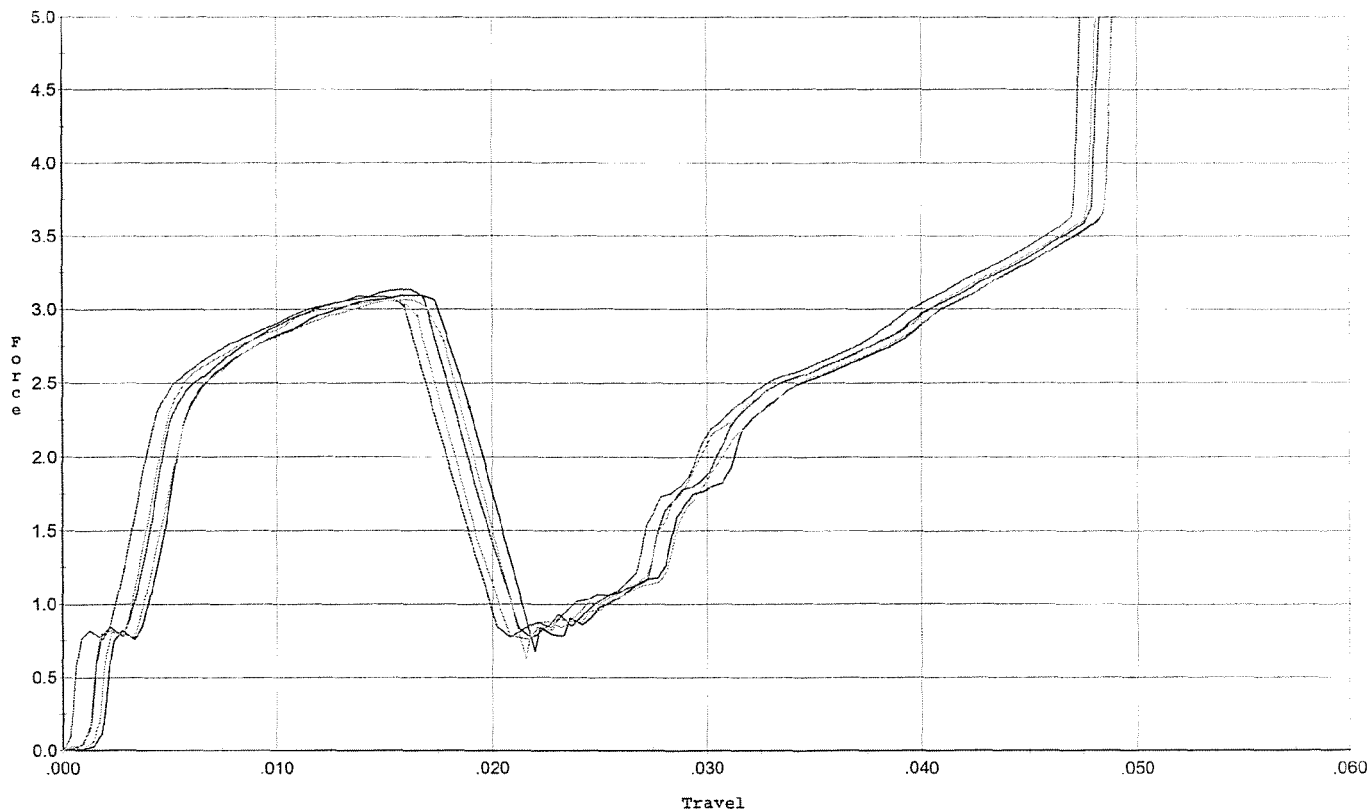
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.328	0.019	0.00	0.032	0.042		Set Trigger
2	3.288	0.017	0.004	0.032	0.038		Set Trigger
3	3.309	0.018	0.004	0.032	0.039		Set Trigger
4	3.274	0.017	0.00	0.033	0.037		Set Trigger
5	3.296	0.019	0.00	0.033	0.042		Set Trigger

3.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



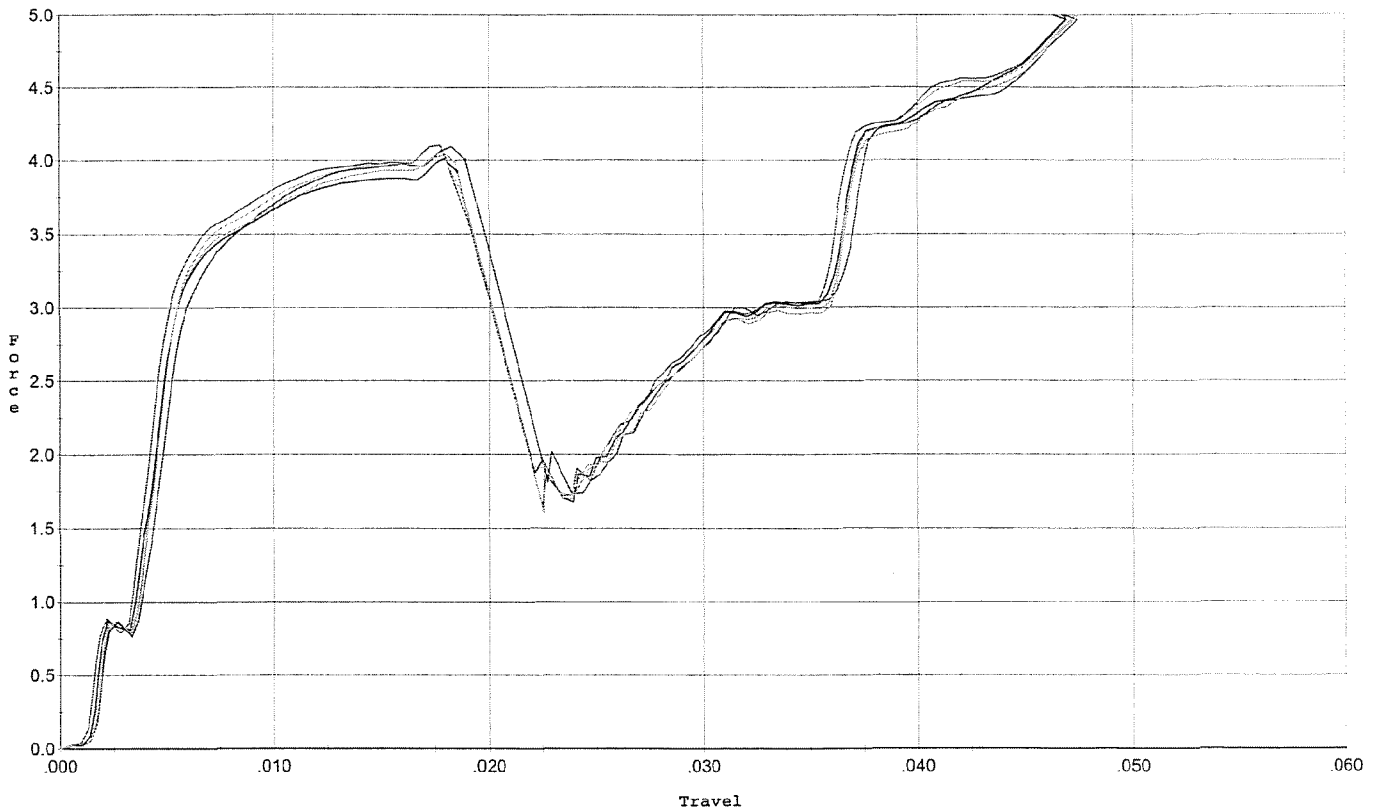
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.017	0.00	0.033	0.036		Set Trigger
2	3.094	0.019	0.00	0.032	0.039		Set Trigger
3	3.088	0.016	0.00	0.033	0.035		Set Trigger
4	3.069	0.018	0.004	0.033	0.037		Set Trigger
5	3.070	0.017	0.00	0.033	0.035		Set Trigger

A. 3.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



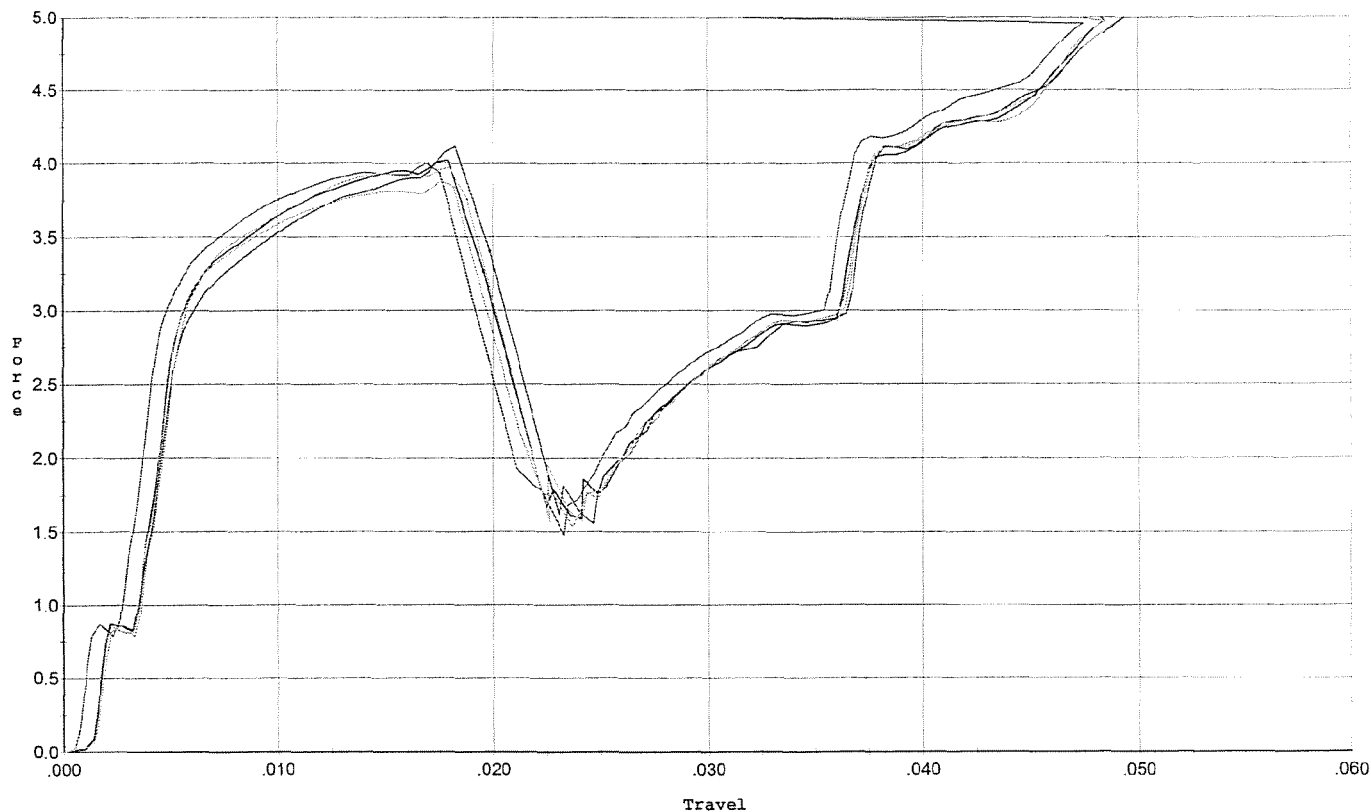
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.095	0.019	0.00	0.030	0.052		Set Trigger
2	4.010	0.019	0.003	0.030	0.050		Set Trigger
3	4.104	0.019	0.00	0.029	0.054		Set Trigger
4	4.055	0.018	0.00	0.030	0.051		Set Trigger
5	4.031	0.019	0.00	0.030	0.051		Set Trigger

A. 4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



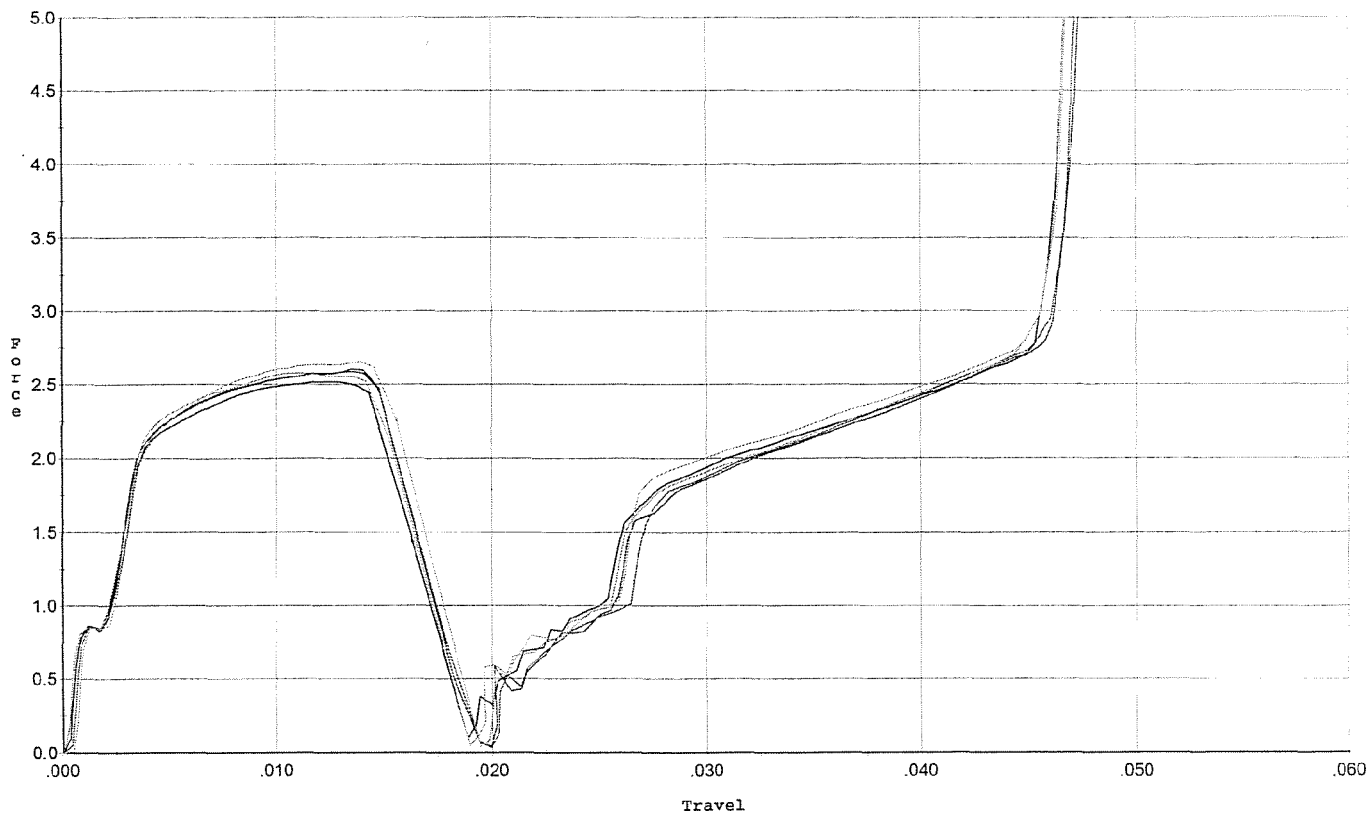
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.114	0.020	0.004	0.030	0.053		Set Trigger
2	4.018	0.020	0.003	0.030	0.053		Set Trigger
3	3.999	0.018	0.00	0.030	0.049		Set Trigger
4	3.969	0.019	0.00	0.030	0.051		Set Trigger
5	3.878	0.018	0.003	0.030	0.048		Set Trigger

14.3.99

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



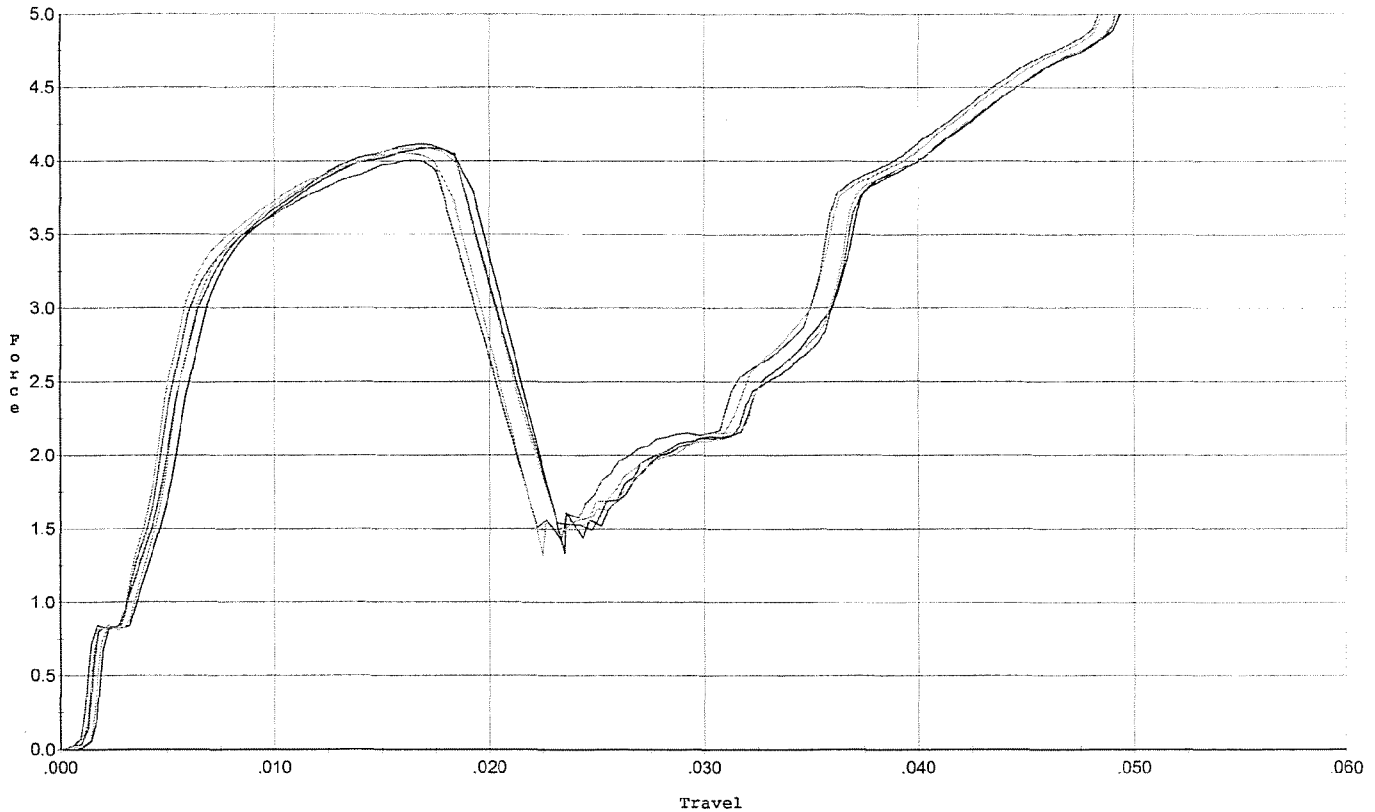
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.015	0.00	0.035	0.029		Set Trigger
2	2.518	0.016	0.00	0.035	0.031		Set Trigger
3	2.588	0.015	0.00	0.035	0.029		Set Trigger
4	2.656	0.016	0.00	0.034	0.031		Set Trigger
5	2.577	0.015	0.00	0.035	0.030		Set Trigger

A.2.58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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	4.117	0.018	0.00	0.031	0.050		Set Trigger
2	4.091	0.019	0.00	0.031	0.052		Set Trigger
3	4.006	0.018	0.00	0.031	0.047		Set Trigger
4	4.098	0.018	0.00	0.031	0.050		Set Trigger
5	4.054	0.018	0.003	0.031	0.050		Set Trigger

A-4.07