

G6801468

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



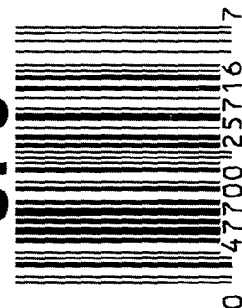
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801468

UPC



GUN SERIAL #

G 6801468

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	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	CJC
480	MAGNAFLUX BBL ACTION	(P)	3/9/09	(H)
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	TZ
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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

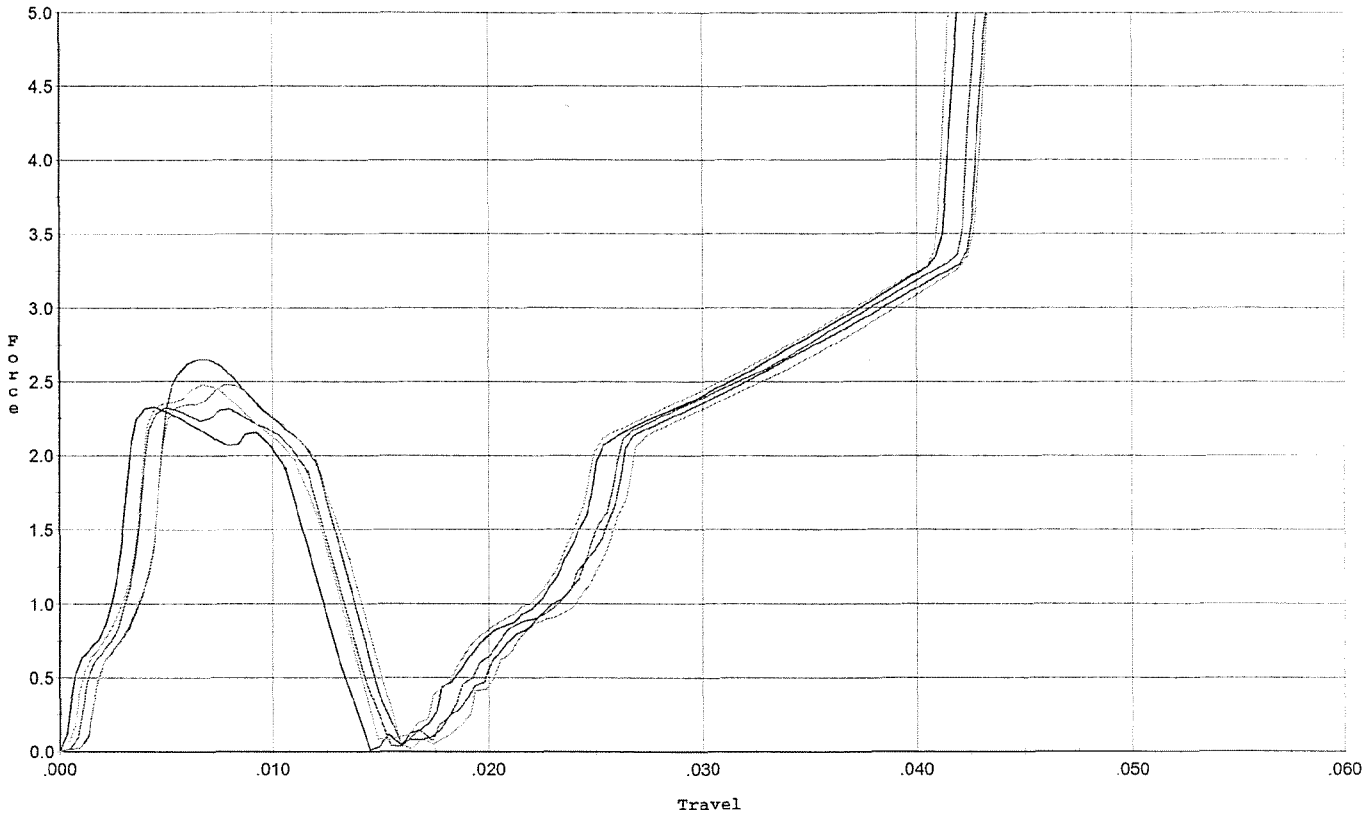
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>0</u> <u>5.5</u> <u>5.5</u>	3-31-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-31-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-31-09	WV
	J) ASSEMBLE STOCK		3-27-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-2-09	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	3-30-09	RP
	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	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.45</u> <u>2.46</u> <u>2.31</u> <u>2.34</u>	3-31-09	WV
	C) FUNCTION		3-31-09	WV
690	PACK		4/5/09	Fry

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



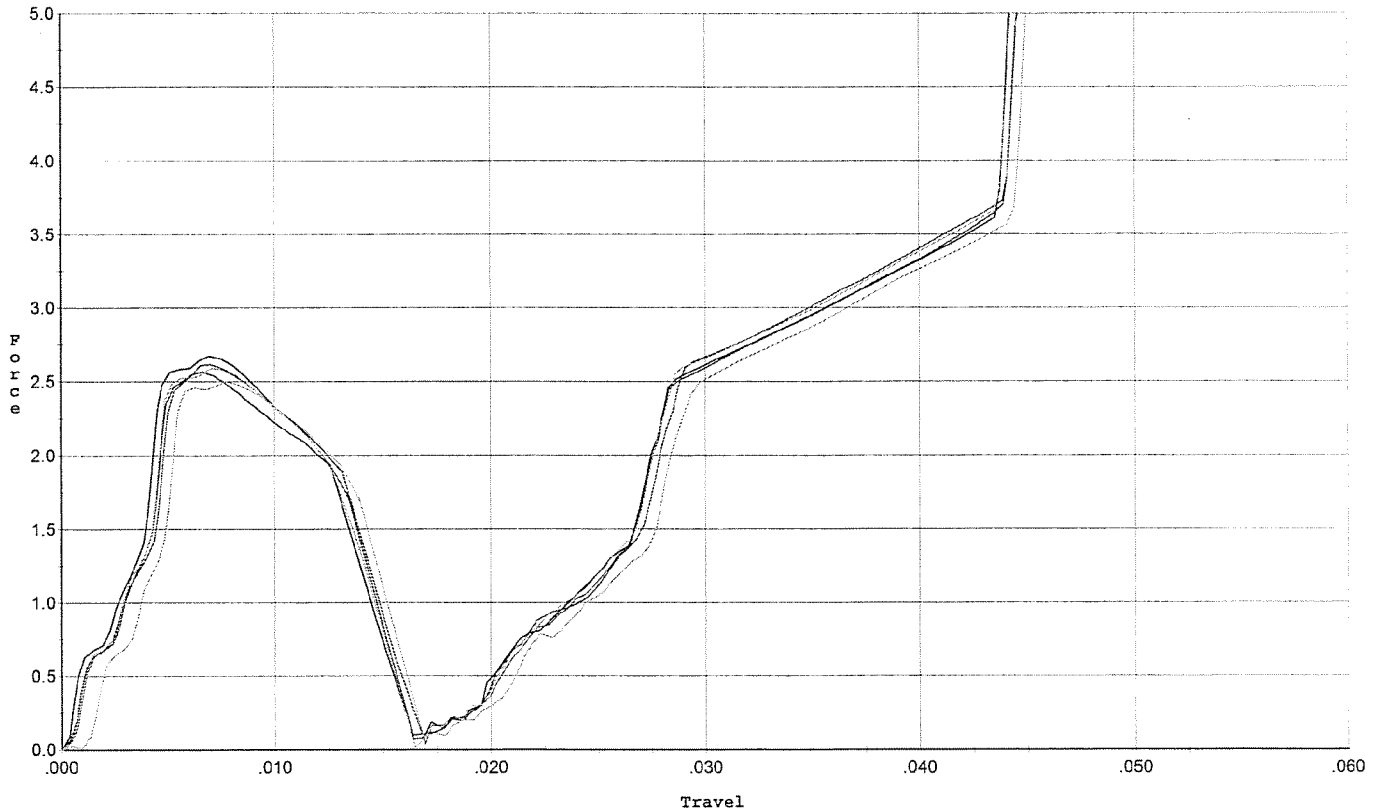
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.647	0.012	0.00	0.034	0.019		Set Trigger
2	2.328	0.011	0.00	0.034	0.017		Set Trigger
3	2.323	0.012	0.00	0.034	0.018		Set Trigger
4	2.482	0.012	0.00	0.033	0.019		Set Trigger
5	2.481	0.014	0.00	0.034	0.021		Set Trigger

A-2-45

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



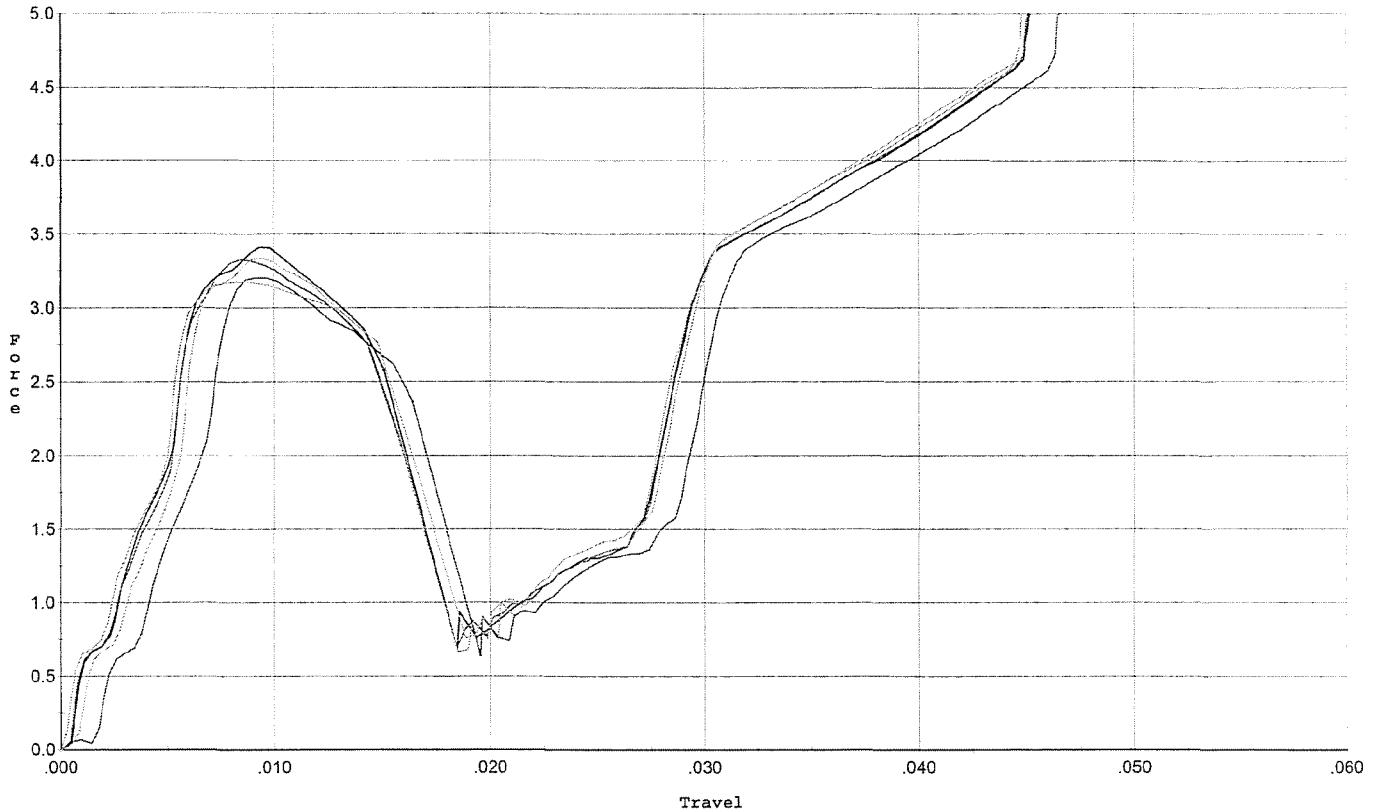
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.013	0.00	0.034	0.022		Set Trigger
2	2.672	0.013	0.00	0.034	0.022		Set Trigger
3	2.615	0.013	0.00	0.034	0.022		Set Trigger
4	2.591	0.014	0.00	0.034	0.023		Set Trigger
5	2.499	0.014	0.00	0.034	0.022		Set Trigger

A-258

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



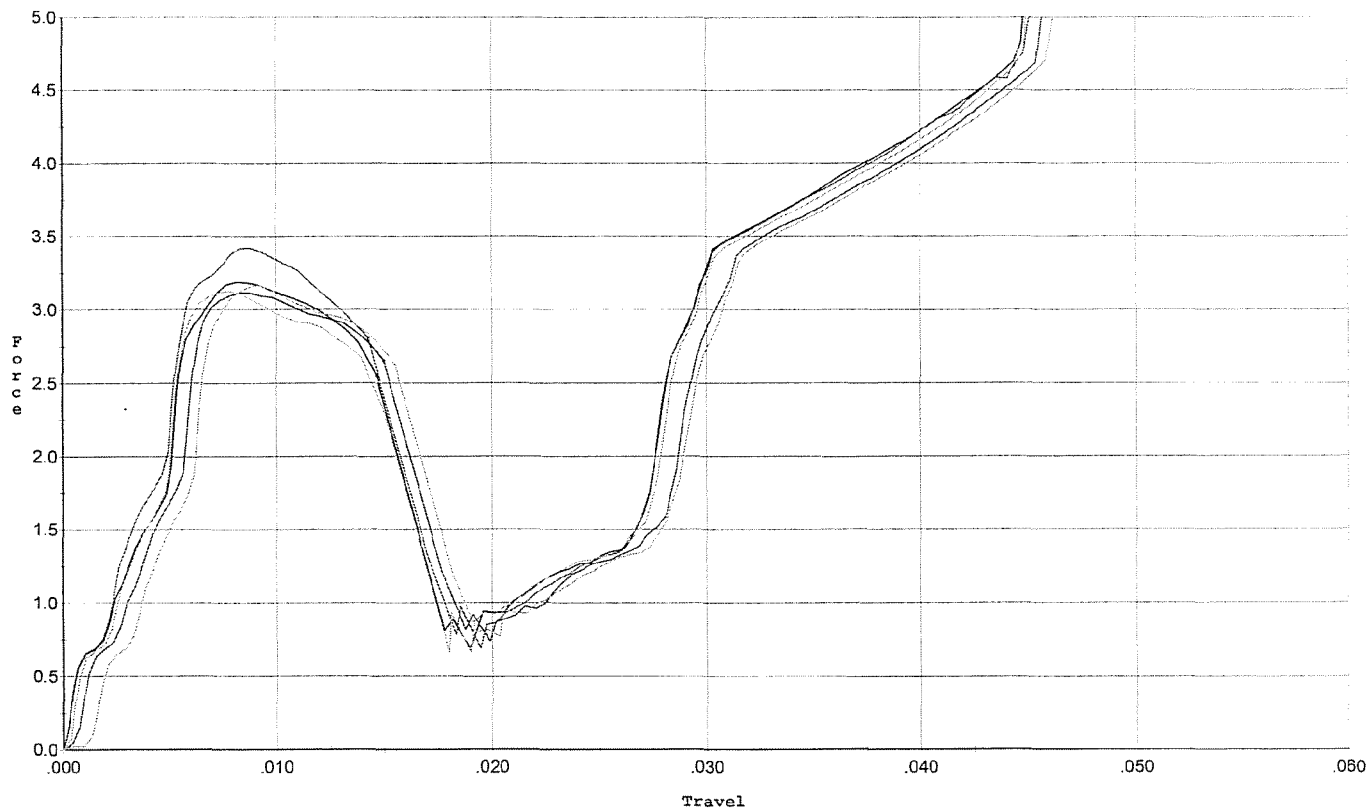
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.201	0.016	0.00	0.031	0.031		Set Trigger
2	3.410	0.015	0.00	0.031	0.033		Set Trigger
3	3.325	0.016	0.00	0.031	0.034		Set Trigger
4	3.174	0.017	0.00	0.030	0.034		Set Trigger
5	3.336	0.016	0.00	0.030	0.034		Set Trigger

A-3-28

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



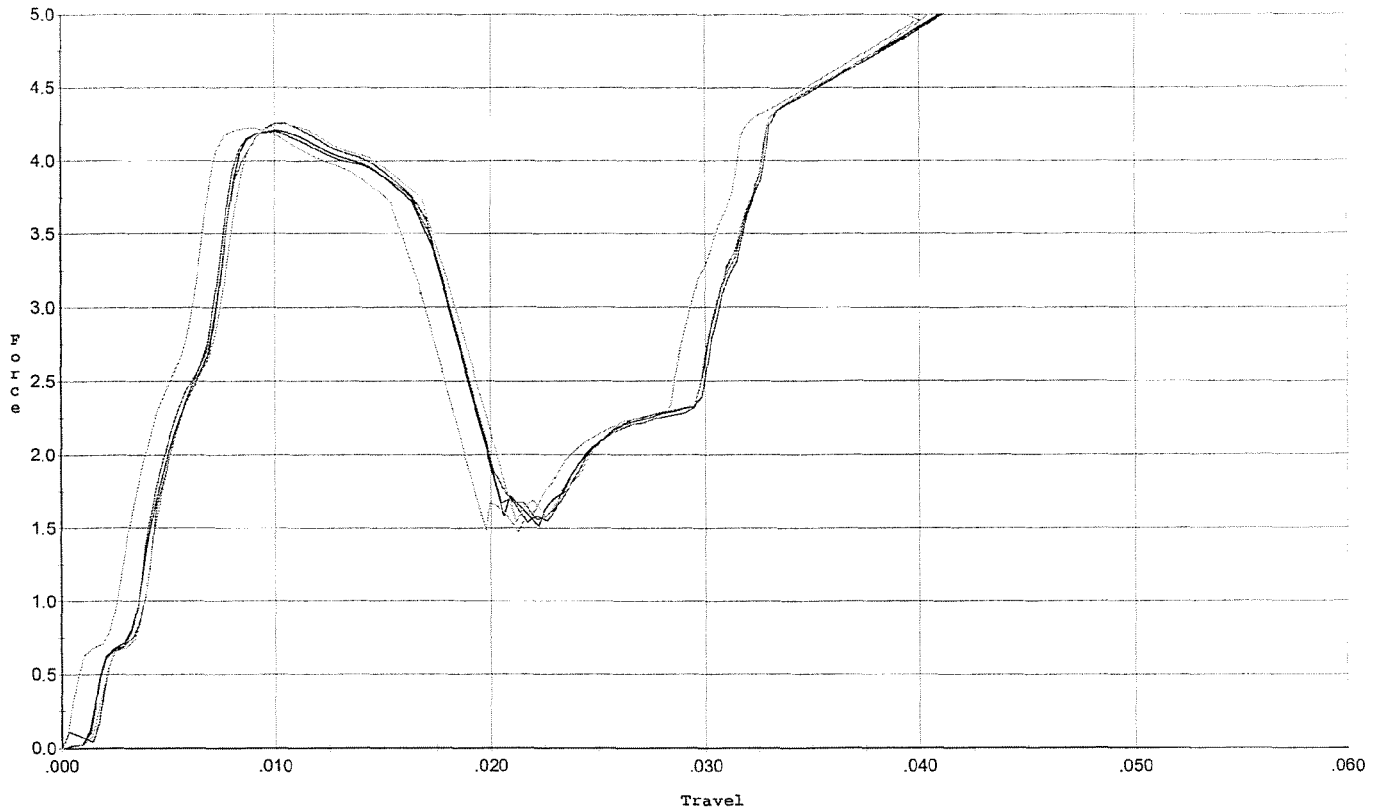
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.112	0.015	0.00	0.031	0.031		Set Trigger
2	3.185	0.015	0.00	0.031	0.031		Set Trigger
3	3.420	0.014	0.00	0.032	0.032		Set Trigger
4	3.125	0.015	0.00	0.031	0.031		Set Trigger
5	3.166	0.016	0.00	0.031	0.031		Set Trigger

A-3.20

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 ini +/- 1.0 lb



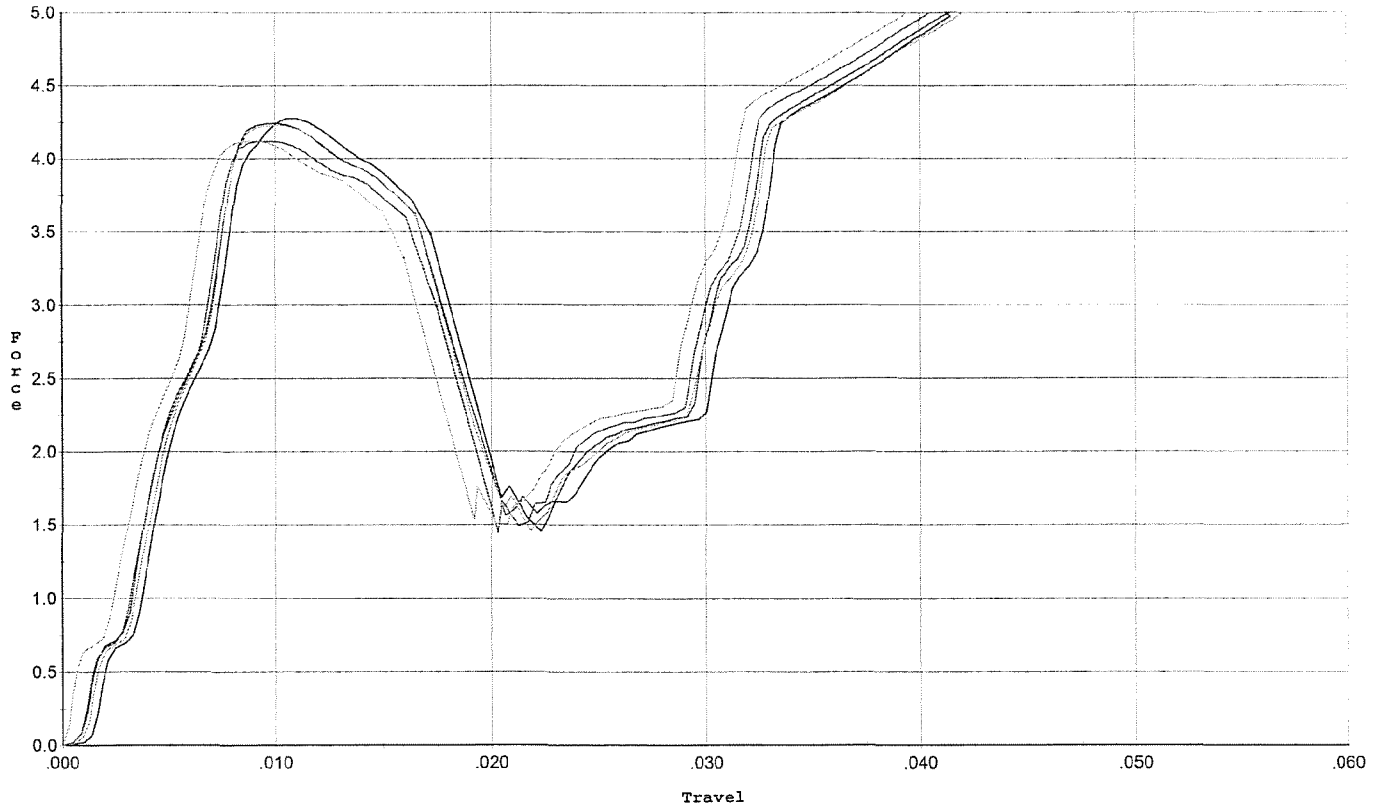
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.197	0.017	0.002	0.030	0.045		Set Trigger
2	4.207	0.017	0.00	0.030	0.045		Set Trigger
3	4.255	0.017	0.00	0.030	0.045		Set Trigger
4	4.250	0.019	0.00	0.030	0.048		Set Trigger
5	4.224	0.017	0.00	0.029	0.046		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

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

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



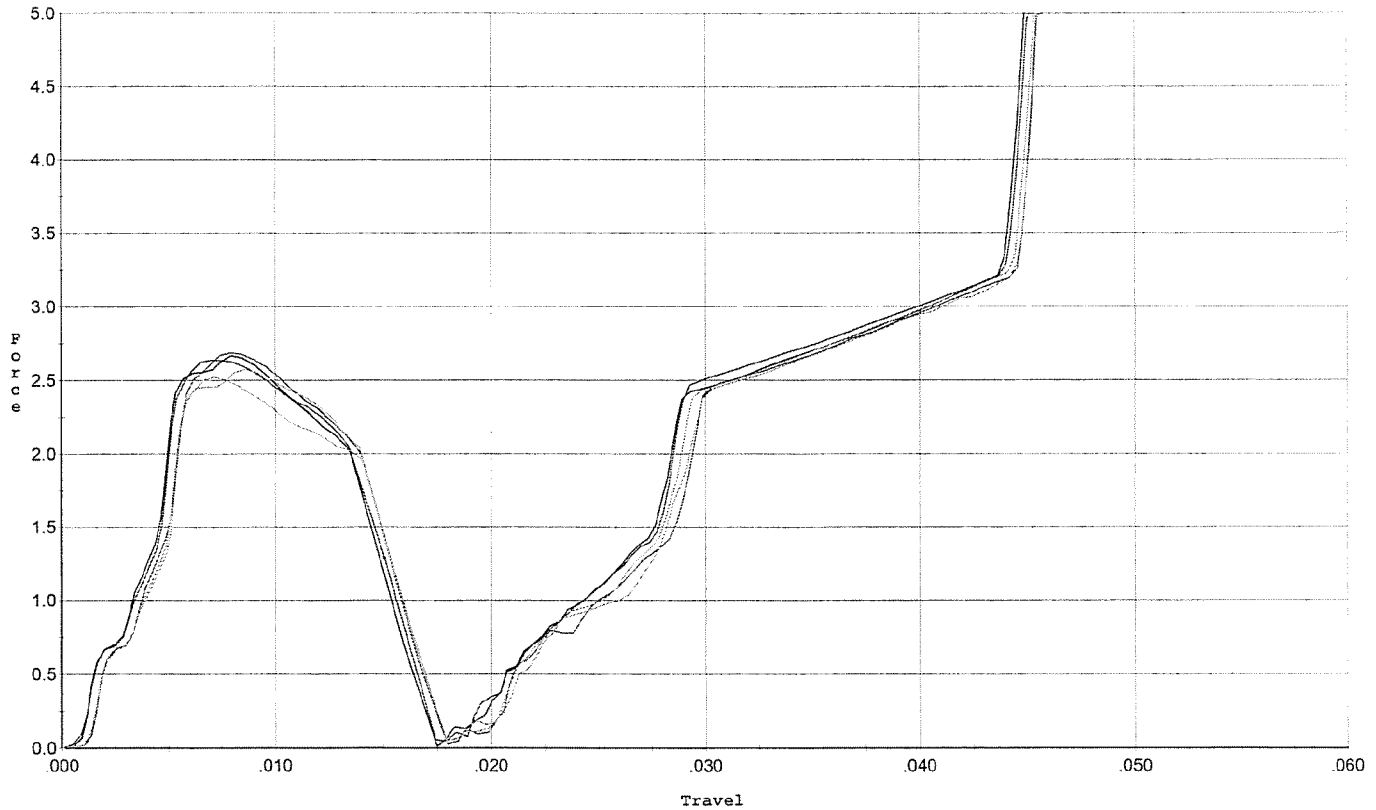
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.243	0.016	0.00	0.030	0.044		Set Trigger
2	4.277	0.017	0.00	0.030	0.045		Set Trigger
3	4.121	0.017	0.00	0.030	0.045		Set Trigger
4	4.123	0.016	0.00	0.029	0.043		Set Trigger
5	4.231	0.017	0.00	0.030	0.043		Set Trigger

A-4.19

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



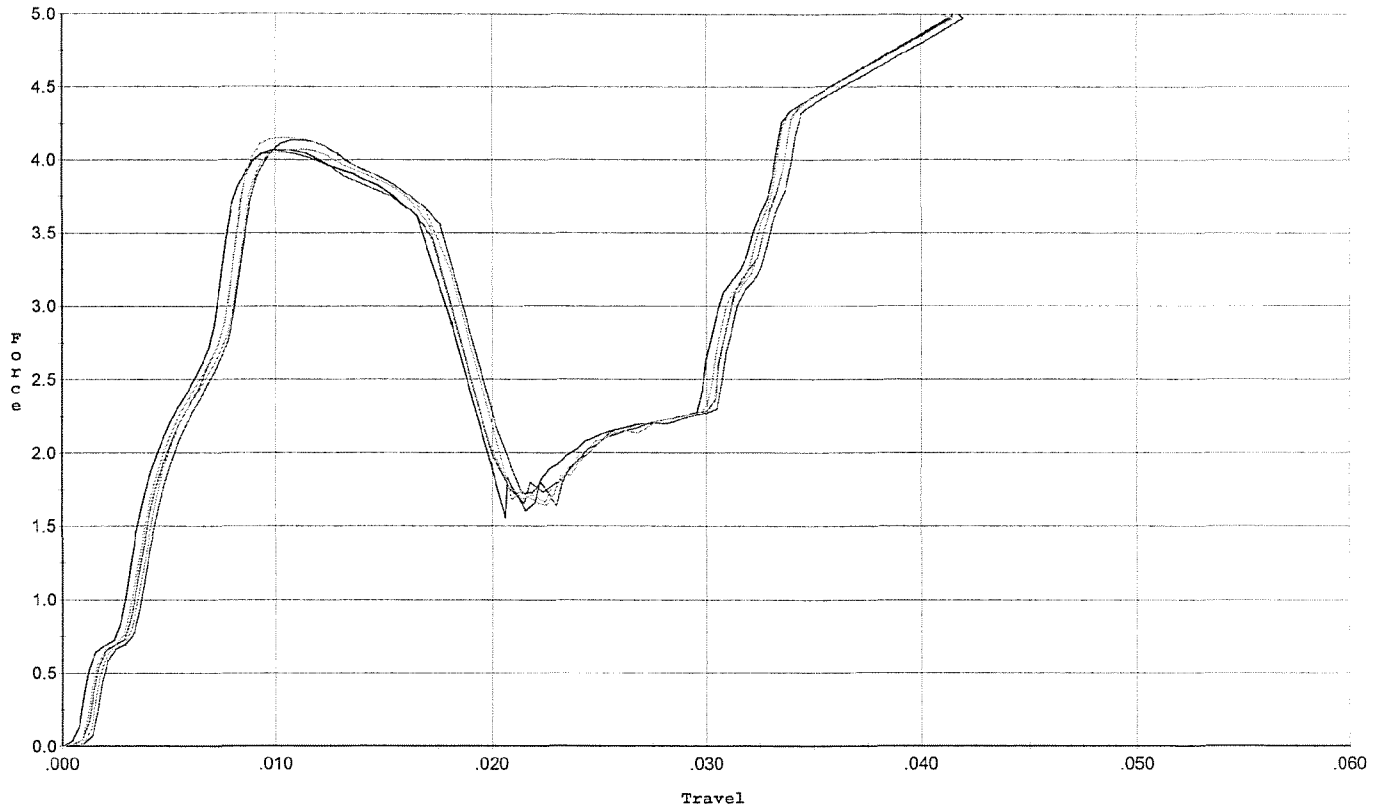
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.634	0.015	0.00	0.034	0.025		Set Trigger
2	2.667	0.013	0.00	0.034	0.023		Set Trigger
3	2.686	0.014	0.00	0.034	0.023		Set Trigger
4	2.520	0.014	0.00	0.034	0.022		Set Trigger
5	2.574	0.014	0.00	0.034	0.023		Set Trigger

A2.61

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	4.135	0.018	0.00	0.031	0.045		Set Trigger
2	4.067	0.018	0.00	0.030	0.047		Set Trigger
3	4.055	0.017	0.00	0.031	0.044		Set Trigger
4	4.152	0.017	0.00	0.030	0.044		Set Trigger
5	4.075	0.018	0.00	0.030	0.046		Set Trigger

A-4.09