

G6801479

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



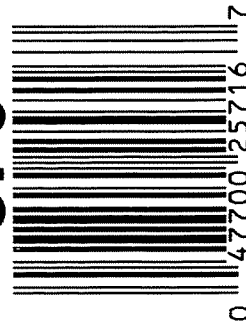
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801479

UPC



GUN SERIAL # G 6801479

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SP
460	CHECK HEADSPACE		3-20-09	SP
470	DIS-ASSEMBLE ACTION		3-20-09	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	3-23-09	RT
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION		3/25/09	AD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	B+
542	APPLY COATINGS (BARREL ACTION)		3-28	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-7-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

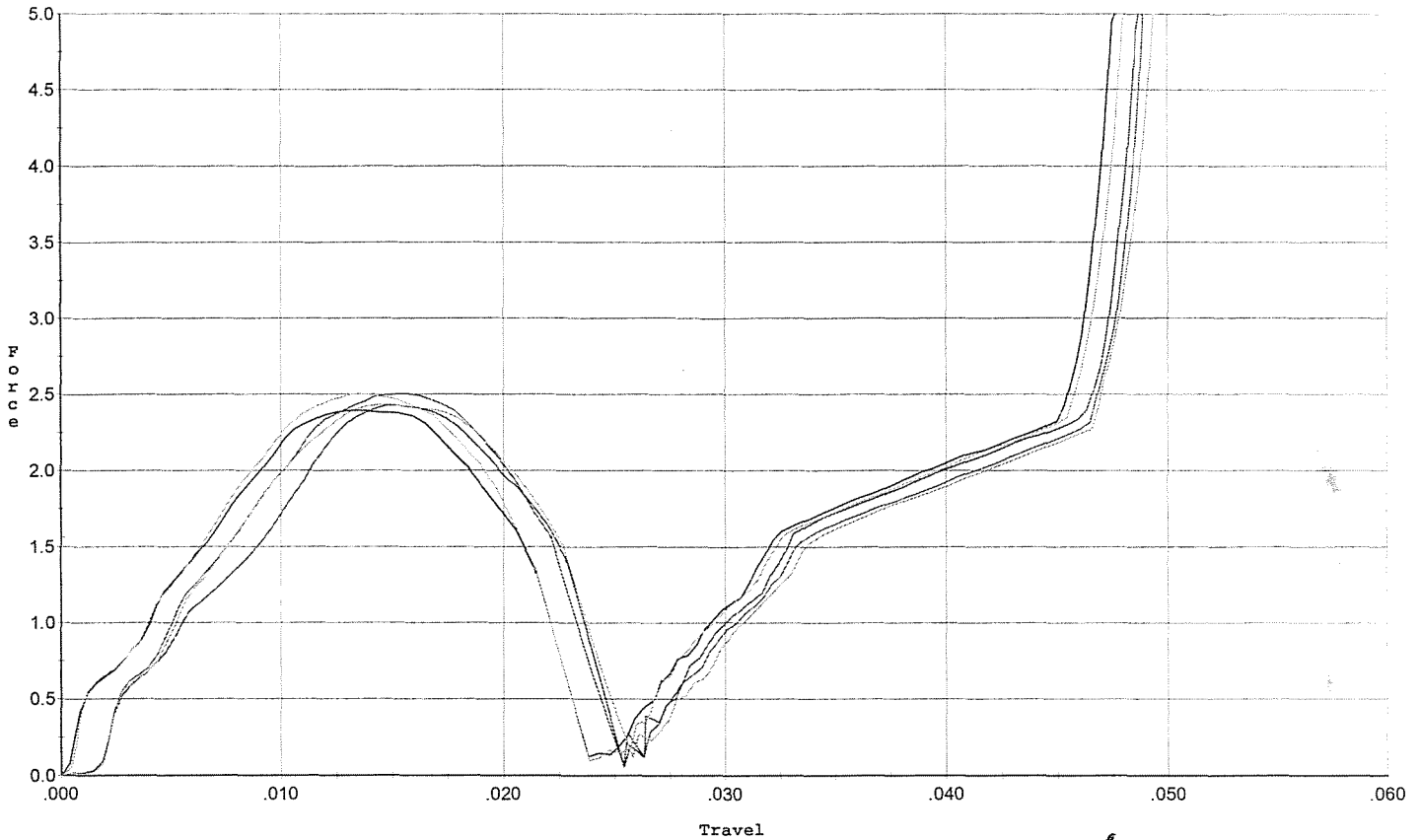
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2.8</u> <u>2.7</u> <u>2.7</u>	4/17/09	RP
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	4/17/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u> <u>.025</u> <u>.024</u>	4/12/09	RP
	J) ASSEMBLE STOCK			4-7-09	L2J
	K) ASSEMBLE SWIVEL STUDS			4/17/09	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		PASS PASS FAIL FAIL	4-9-09	WV
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION	4-9-09	TOR
660	INSPECT FOR LIVE AMMO				
670	FINAL INSPECTION A) HEADSPACE				
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.71</u> <u>2.71</u> <u>2.73</u> <u>2.76</u>	4-14-09	WV
	C) FUNCTION			4/17/09	RP
690	PACK			5/29/09	F04

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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



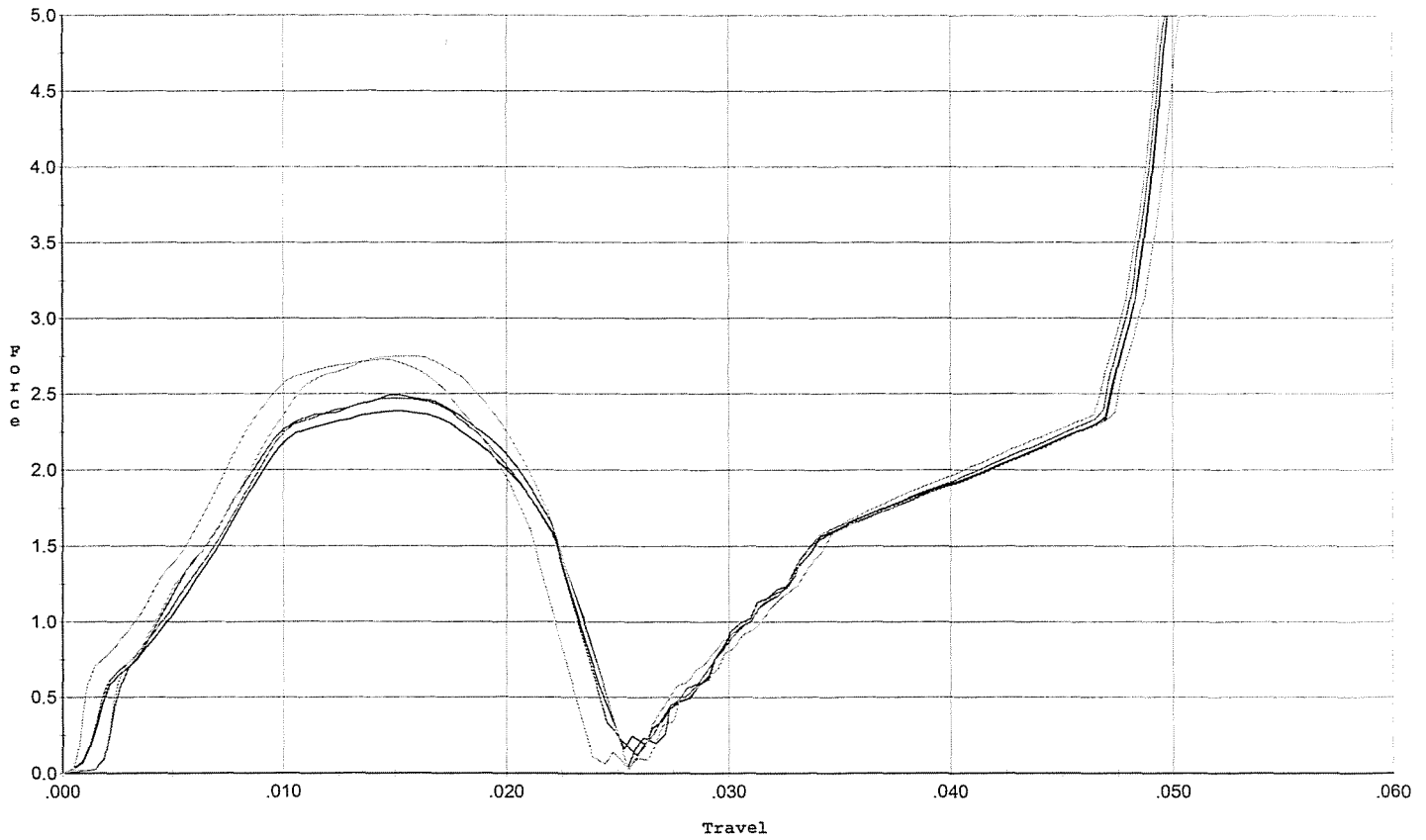
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.023	0.00	0.032	0.034		Set Trigger
2	2.393	0.021	0.00	0.032	0.035		Set Trigger
3	2.502	0.022	0.00	0.033	0.035		Set Trigger
4	2.501	0.021	0.00	0.032	0.036		Set Trigger
5	2.431	0.023	0.00	0.033	0.036		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



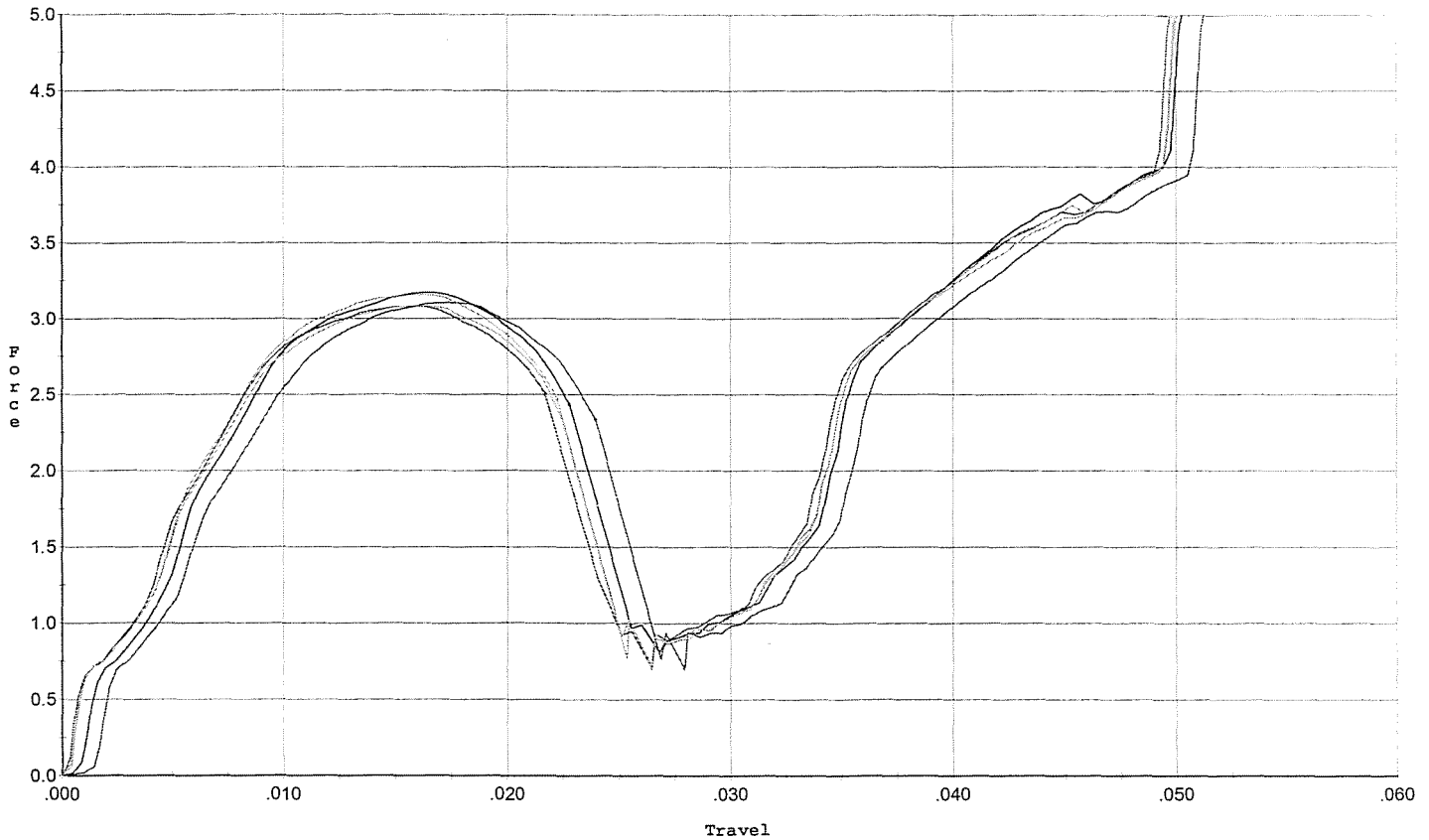
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.491	0.023	0.00	0.033	0.039		Set Trigger
2	2.385	0.022	0.00	0.033	0.036		Set Trigger
3	2.469	0.022	0.00	0.033	0.037		Set Trigger
4	2.748	0.024	0.00	0.033	0.042		Set Trigger
5	2.730	0.021	0.00	0.034	0.039		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



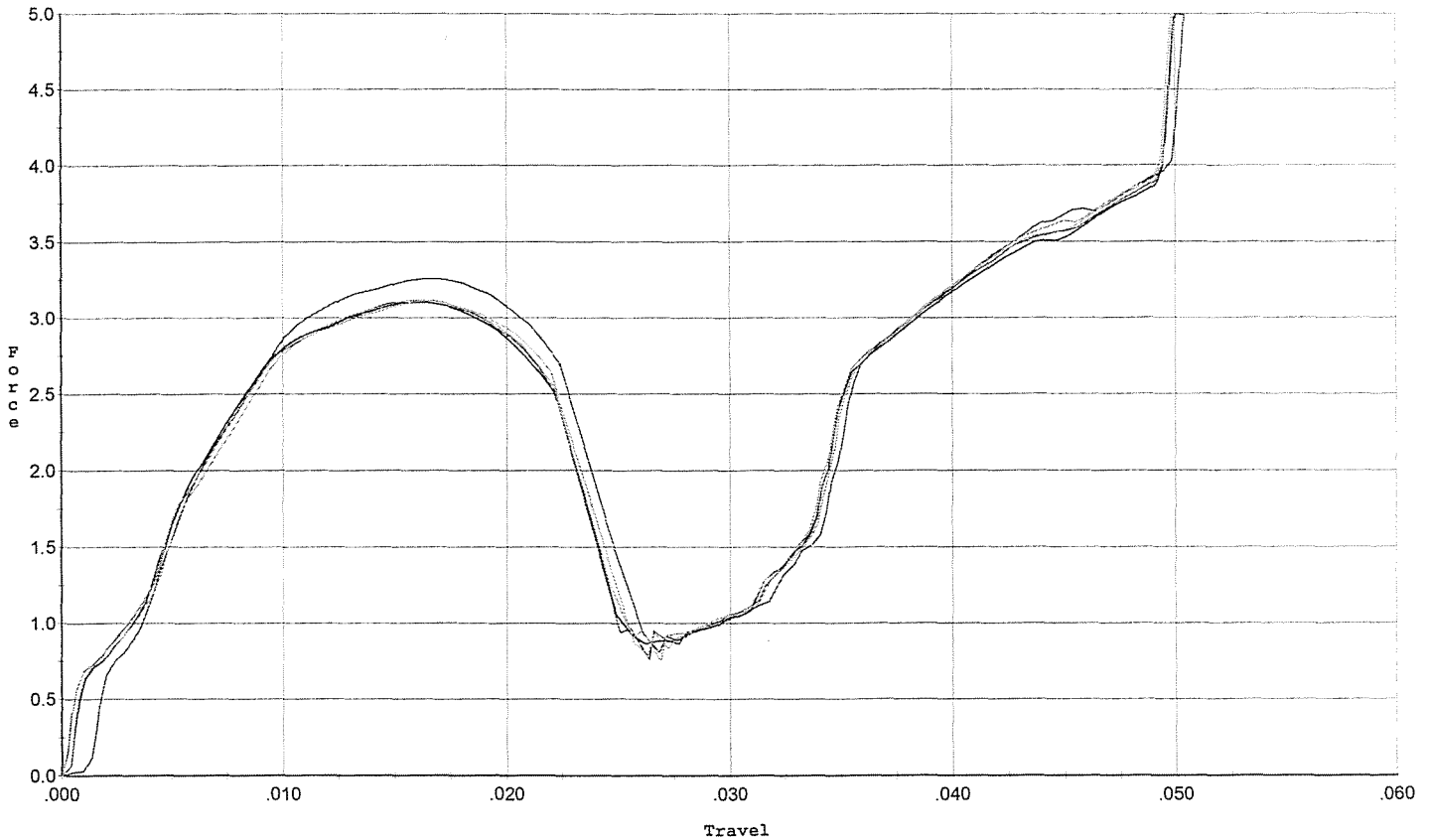
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.105	0.024	0.00	0.032	0.050		Set Trigger
2	3.174	0.023	0.00	0.032	0.050		Set Trigger
3	3.082	0.022	0.00	0.032	0.047		Set Trigger
4	3.085	0.022	0.00	0.032	0.049		Set Trigger
5	3.158	0.022	0.00	0.032	0.049		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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



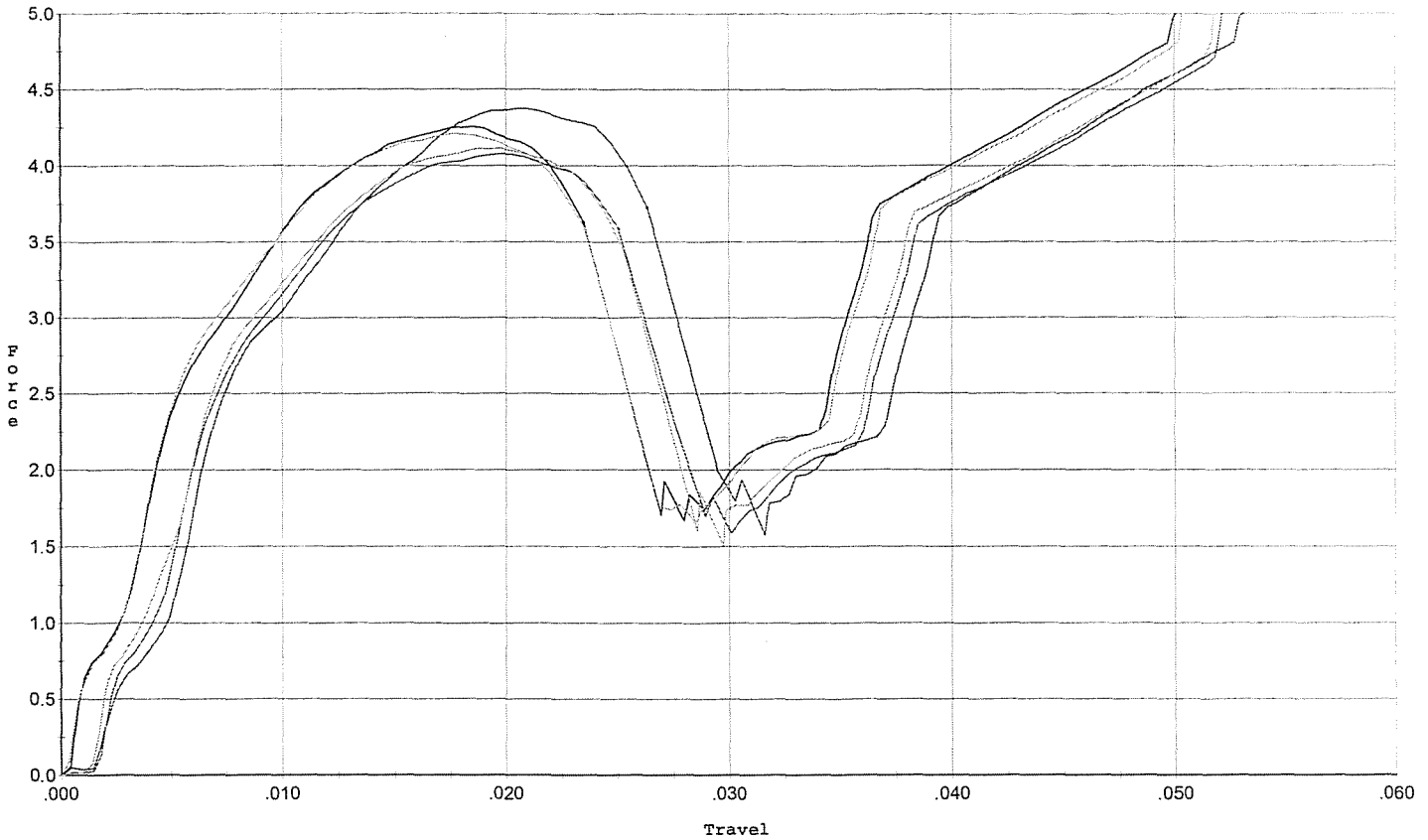
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.022	0.00	0.032	0.050		Set Trigger
2	3.104	0.022	0.00	0.032	0.049		Set Trigger
3	3.114	0.022	0.00	0.032	0.049		Set Trigger
4	3.119	0.022	0.00	0.032	0.049		Set Trigger
5	3.109	0.024	0.00	0.032	0.052		Set Trigger

A.3-14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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



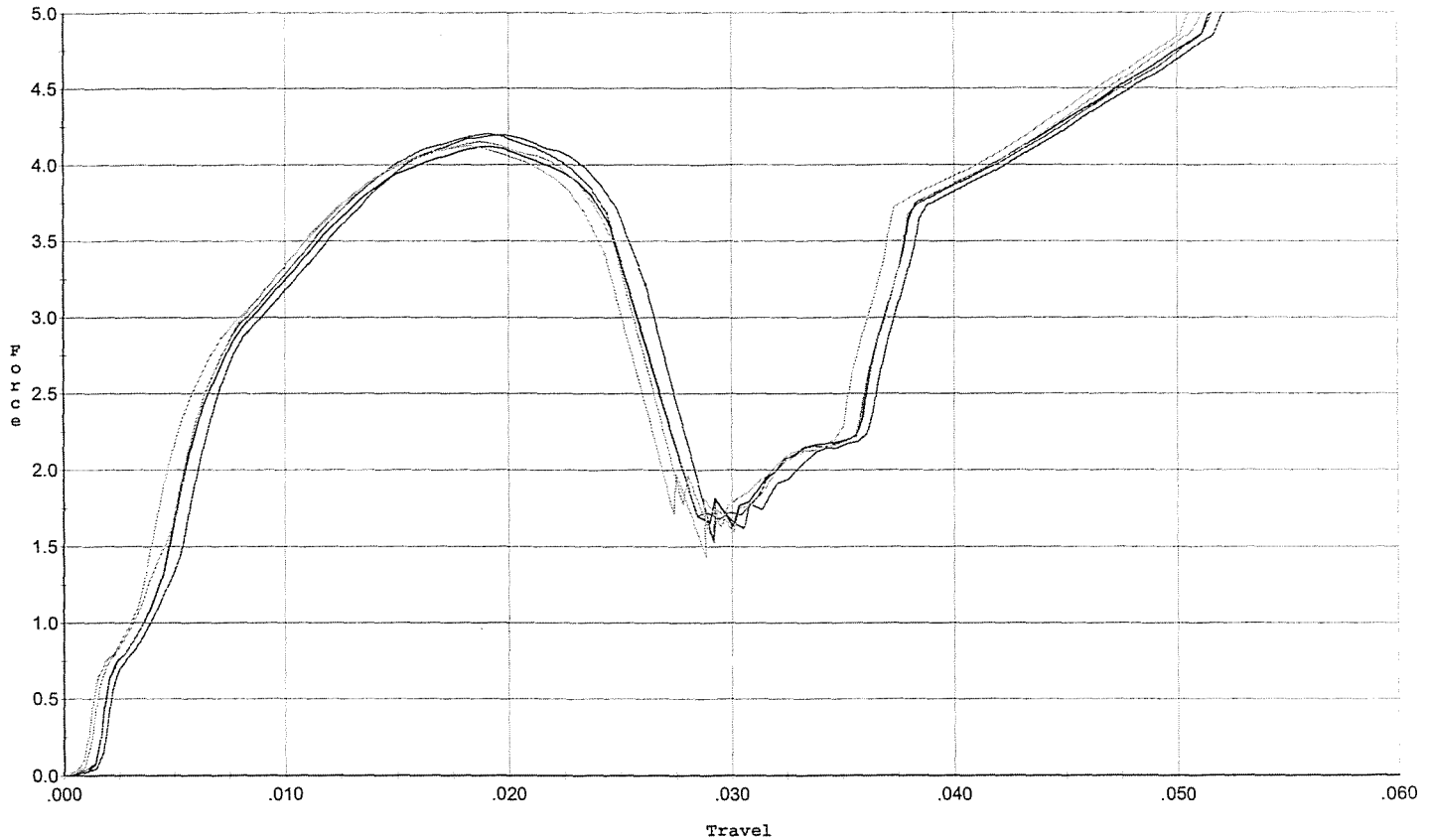
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.376	0.026	0.00	0.025	0.075		Set Trigger
2	4.256	0.023	0.00	0.028	0.070		Set Trigger
3	4.077	0.025	0.00	0.029	0.069		Set Trigger
4	4.209	0.024	0.00	0.028	0.070		Set Trigger
5	4.112	0.025	0.00	0.029	0.070		Set Trigger

A.4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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



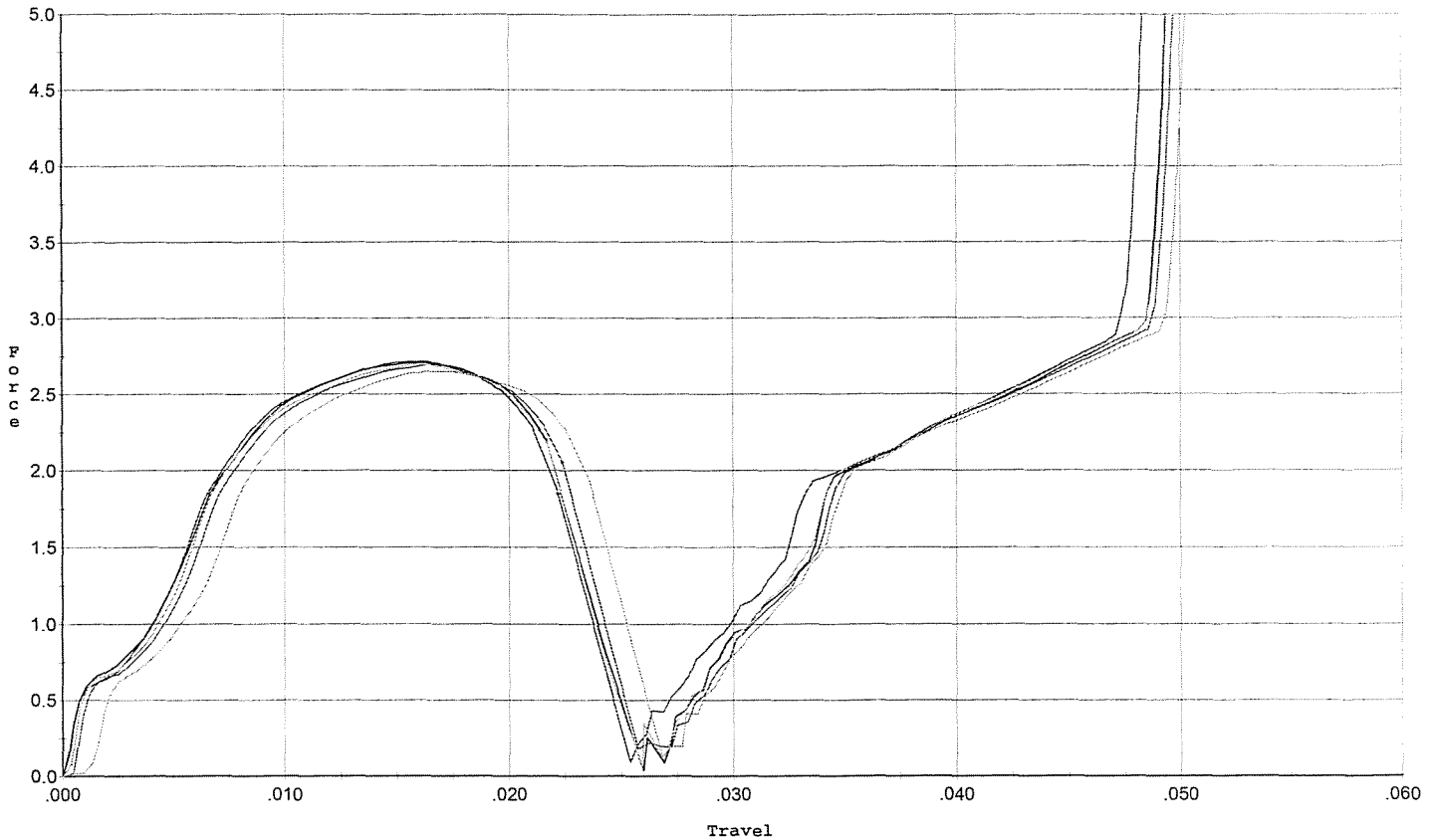
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.194	0.026	0.00	0.026	0.073		Set Trigger
2	4.119	0.025	0.00	0.029	0.068		Set Trigger
3	4.203	0.024	0.00	0.029	0.069		Set Trigger
4	4.123	0.024	0.00	0.029	0.069		Set Trigger
5	4.153	0.025	0.00	0.028	0.070		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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



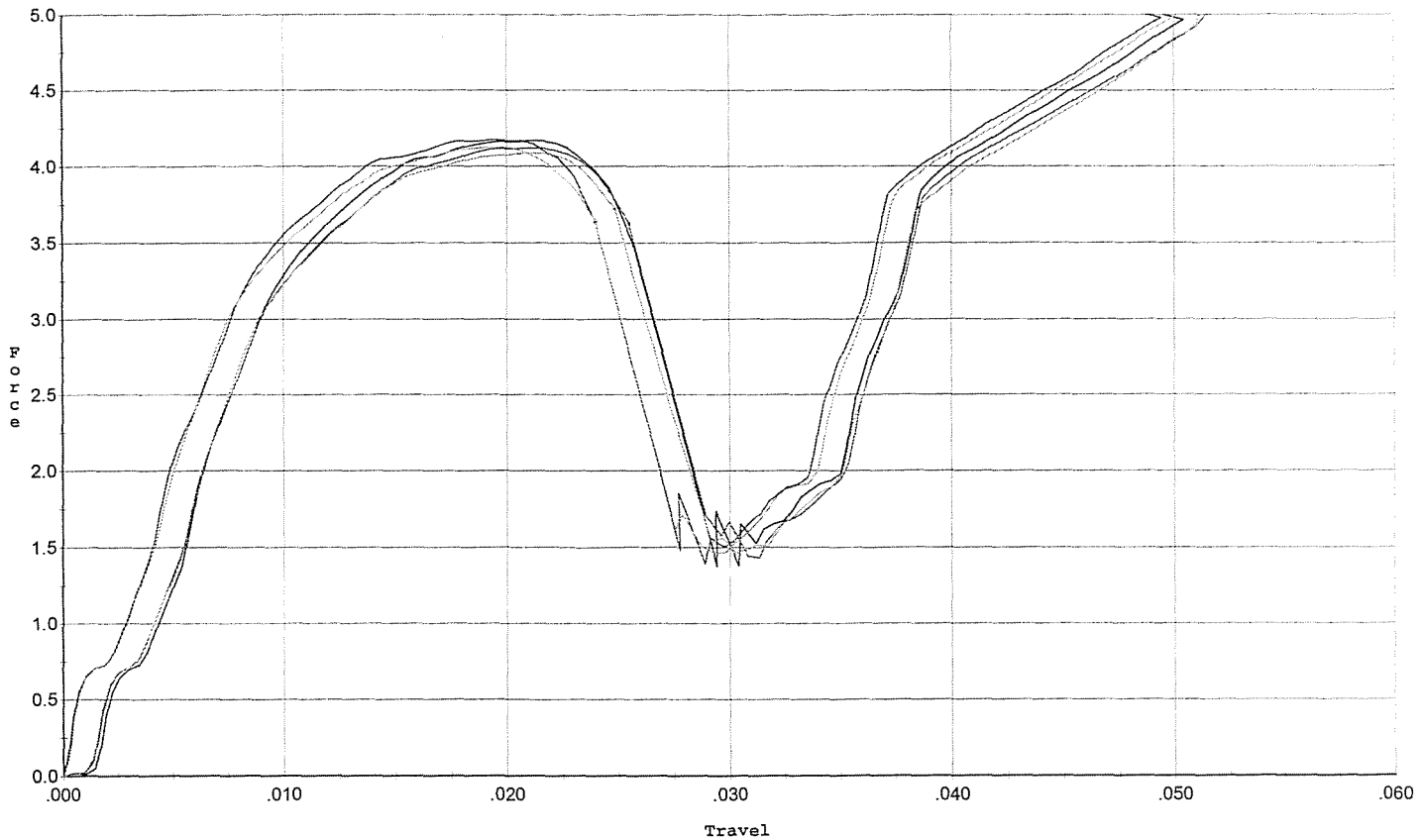
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.714	0.022	0.00	0.031	0.042		Set Trigger
2	2.704	0.022	0.00	0.032	0.042		Set Trigger
3	2.696	0.022	0.00	0.032	0.042		Set Trigger
4	2.694	0.022	0.00	0.032	0.041		Set Trigger
5	2.651	0.024	0.00	0.032	0.042		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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	4.171	0.024	0.00	0.028	0.070		Set Trigger
2	4.169	0.026	0.00	0.023	0.072		Set Trigger
3	4.120	0.025	0.00	0.024	0.071		Set Trigger
4	4.126	0.024	0.00	0.028	0.069		Set Trigger
5	4.085	0.025	0.00	0.025	0.068		Set Trigger

A-4-13