

G6801484

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

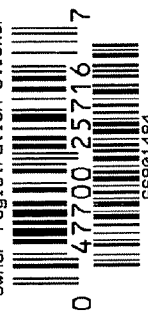
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



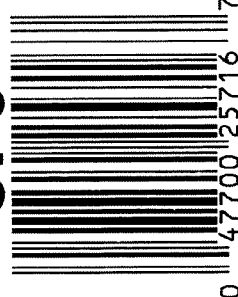
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801484

UPC



GUN SERIAL #

G6801484

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	(P)	3/9/09	(D)
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	RT
540	APPLY COATINGS (BARREL ACTION)		3/18	—
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		3-21-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

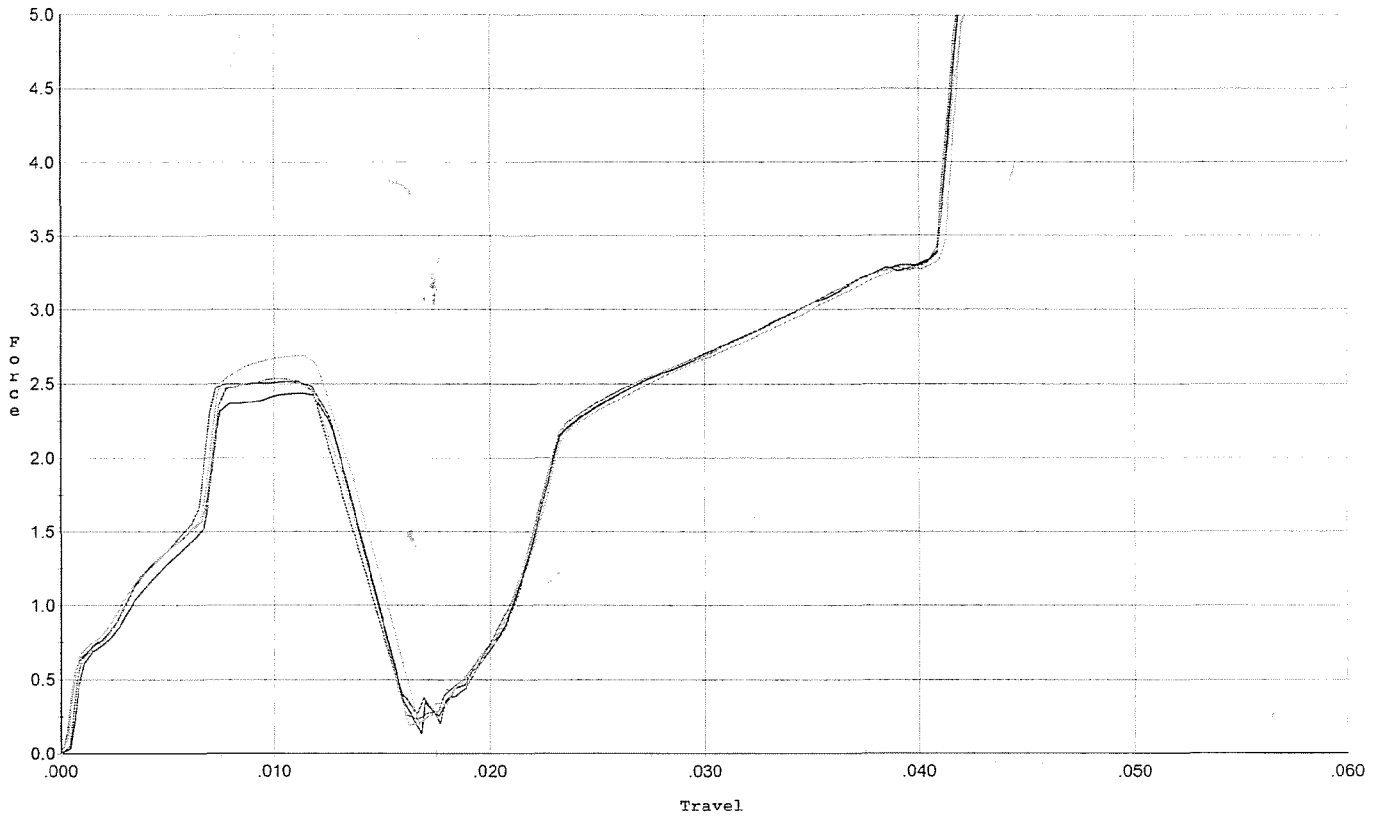
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.2</u> <u>3.0</u> <u>3.0</u>	3/23/09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.8</u> <u>5.0</u> <u>5.0</u>	3/23/09	R.P
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-21-09	S. W.
	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		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	W W
670	FINAL INSPECTION A) HEADSPACE		3-23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.53</u> <u>2.55</u> <u>2.45</u> <u>2.51</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 3/20/2009

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



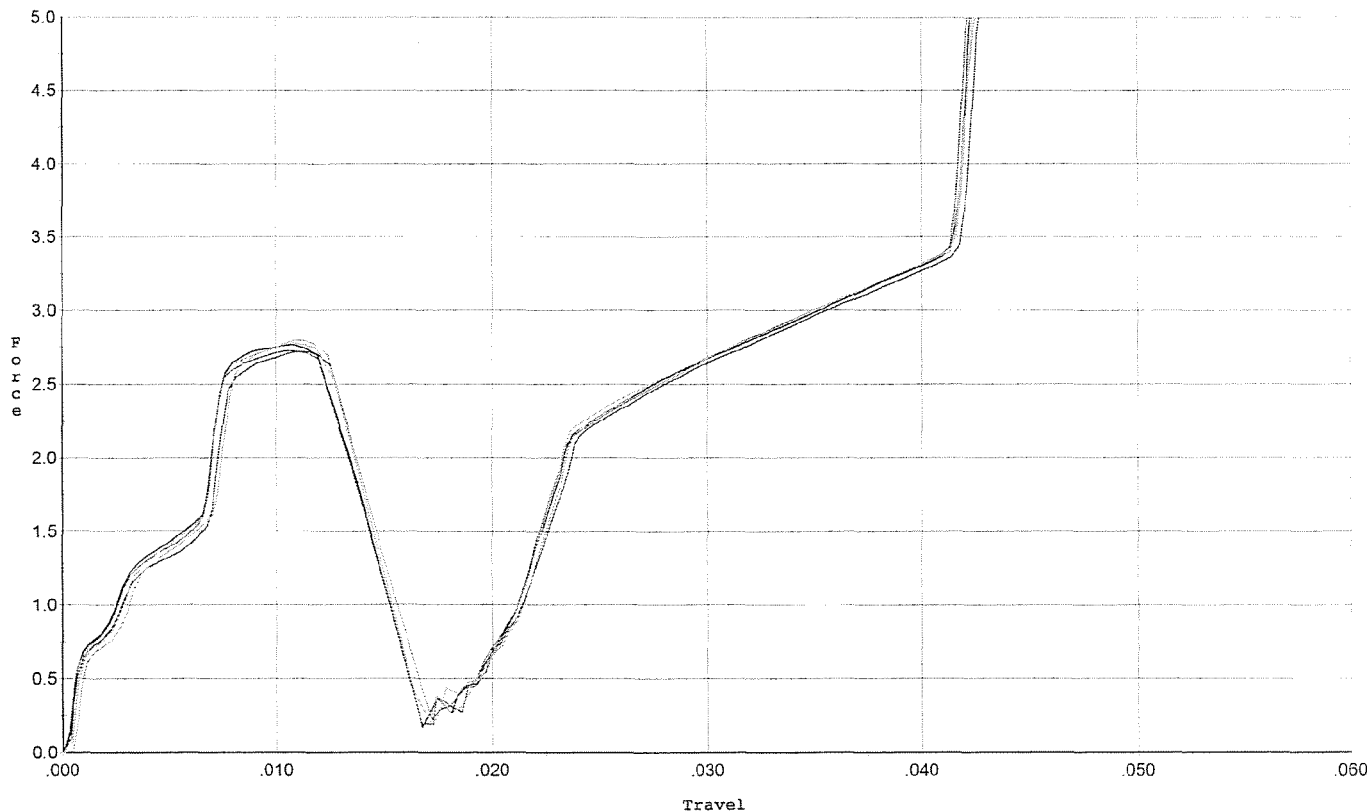
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.013	0.00	0.031	0.020		Set Trigger
2	2.438	0.013	0.00	0.032	0.019		Set Trigger
3	2.536	0.012	0.00	0.032	0.019		Set Trigger
4	2.688	0.014	0.00	0.031	0.023		Set Trigger
5	2.536	0.013	0.00	0.032	0.021		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



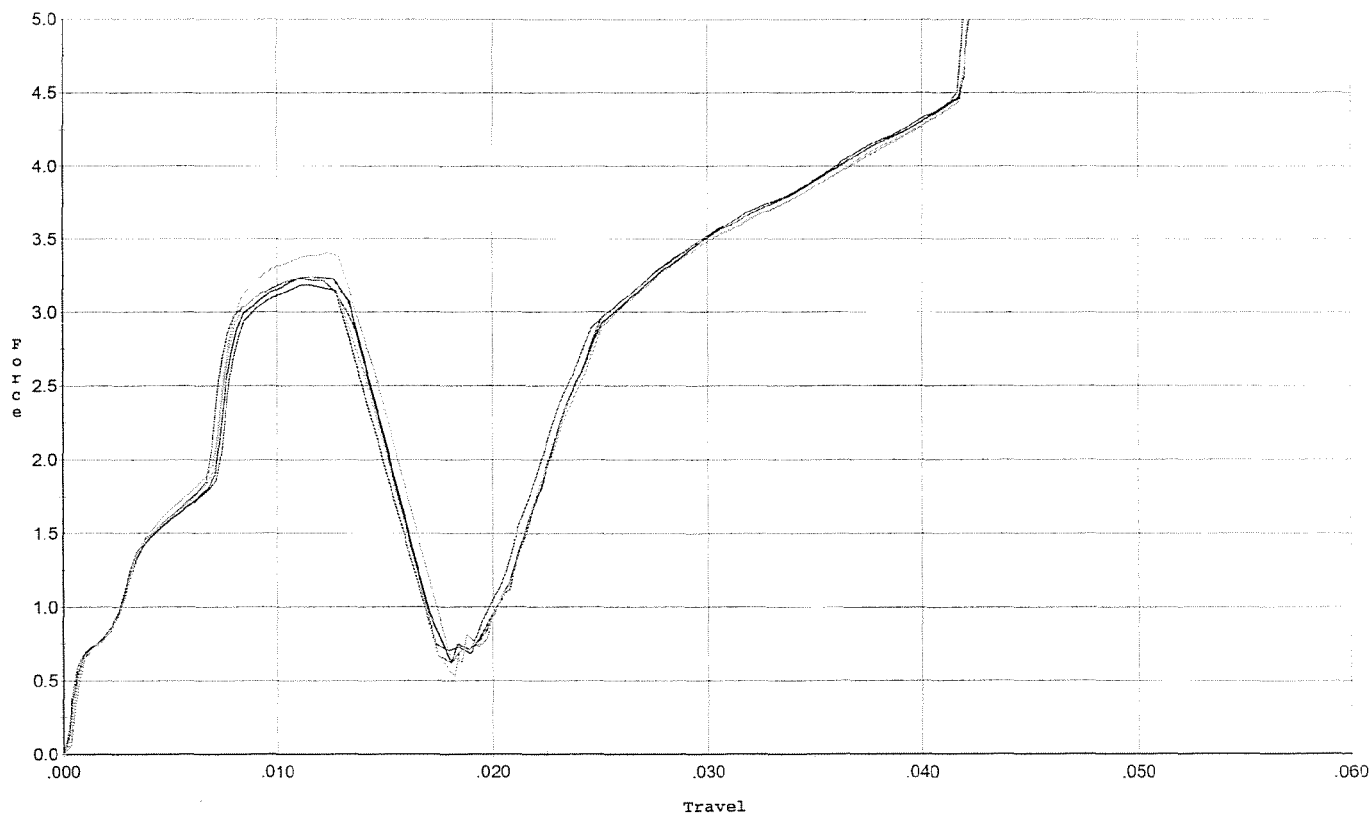
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.720	0.012	0.00	0.032	0.021		Set Trigger
2	2.766	0.014	0.00	0.031	0.023		Set Trigger
3	2.726	0.014	0.00	0.031	0.023		Set Trigger
4	2.780	0.013	0.00	0.032	0.021		Set Trigger
5	2.796	0.012	0.00	0.031	0.020		Set Trigger

A-2-75

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



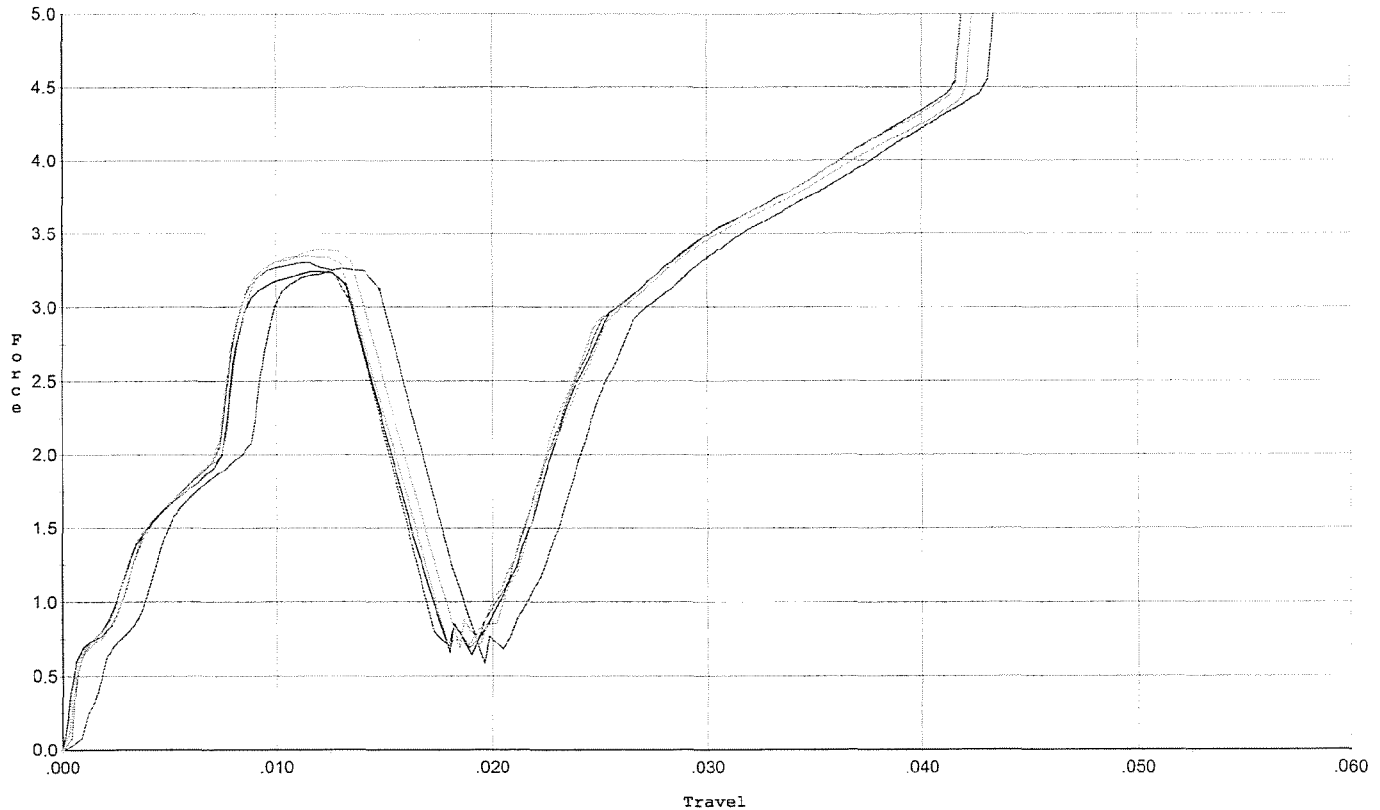
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.183	0.014	0.00	0.029	0.026		Set Trigger
2	3.239	0.013	0.00	0.029	0.026		Set Trigger
3	3.227	0.013	0.00	0.029	0.025		Set Trigger
4	3.240	0.014	0.00	0.029	0.028		Set Trigger
5	3.404	0.015	0.00	0.028	0.030		Set Trigger

A-3-25

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



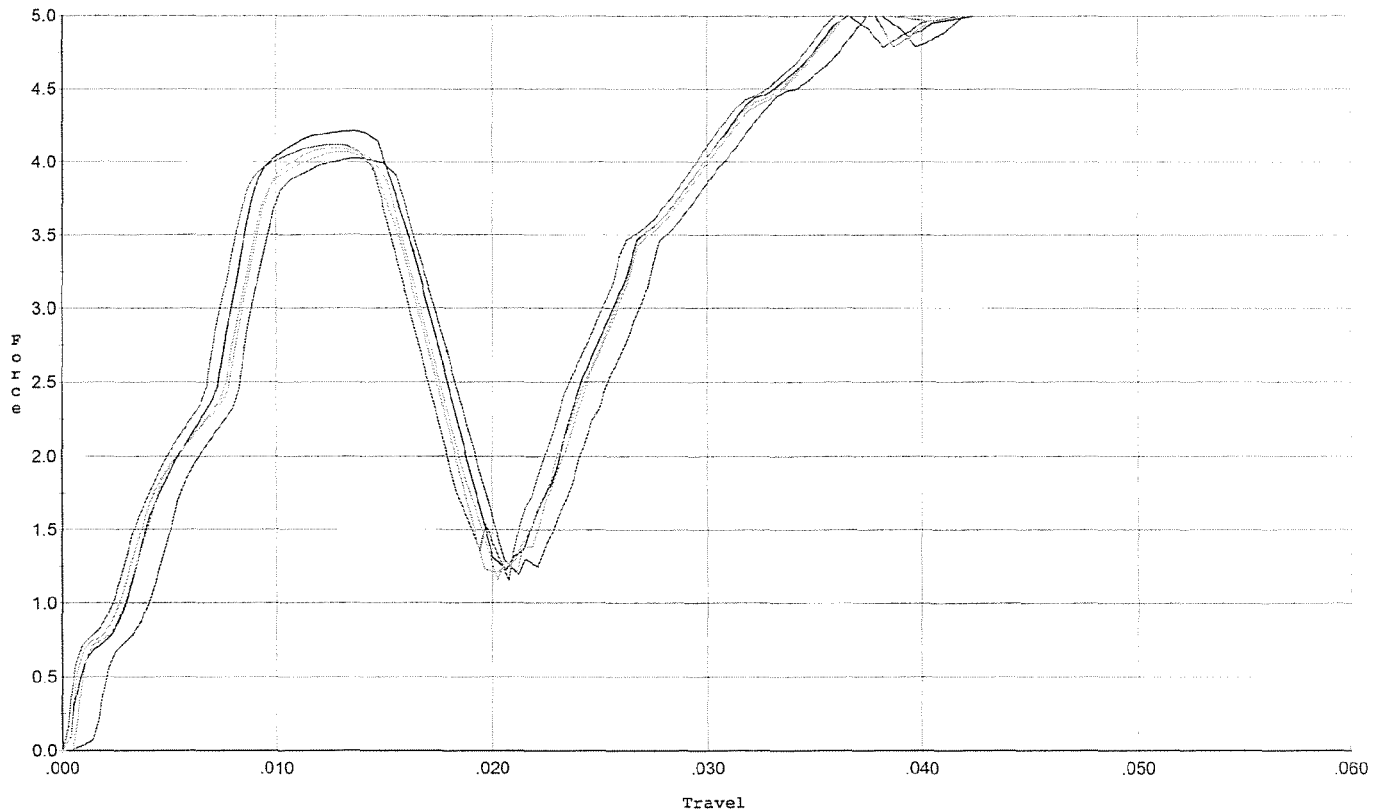
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.262	0.015	0.00	0.029	0.028		Set Trigger
2	3.242	0.013	0.00	0.028	0.026		Set Trigger
3	3.301	0.013	0.00	0.028	0.027		Set Trigger
4	3.348	0.015	0.00	0.028	0.031		Set Trigger
5	3.390	0.013	0.00	0.028	0.027		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



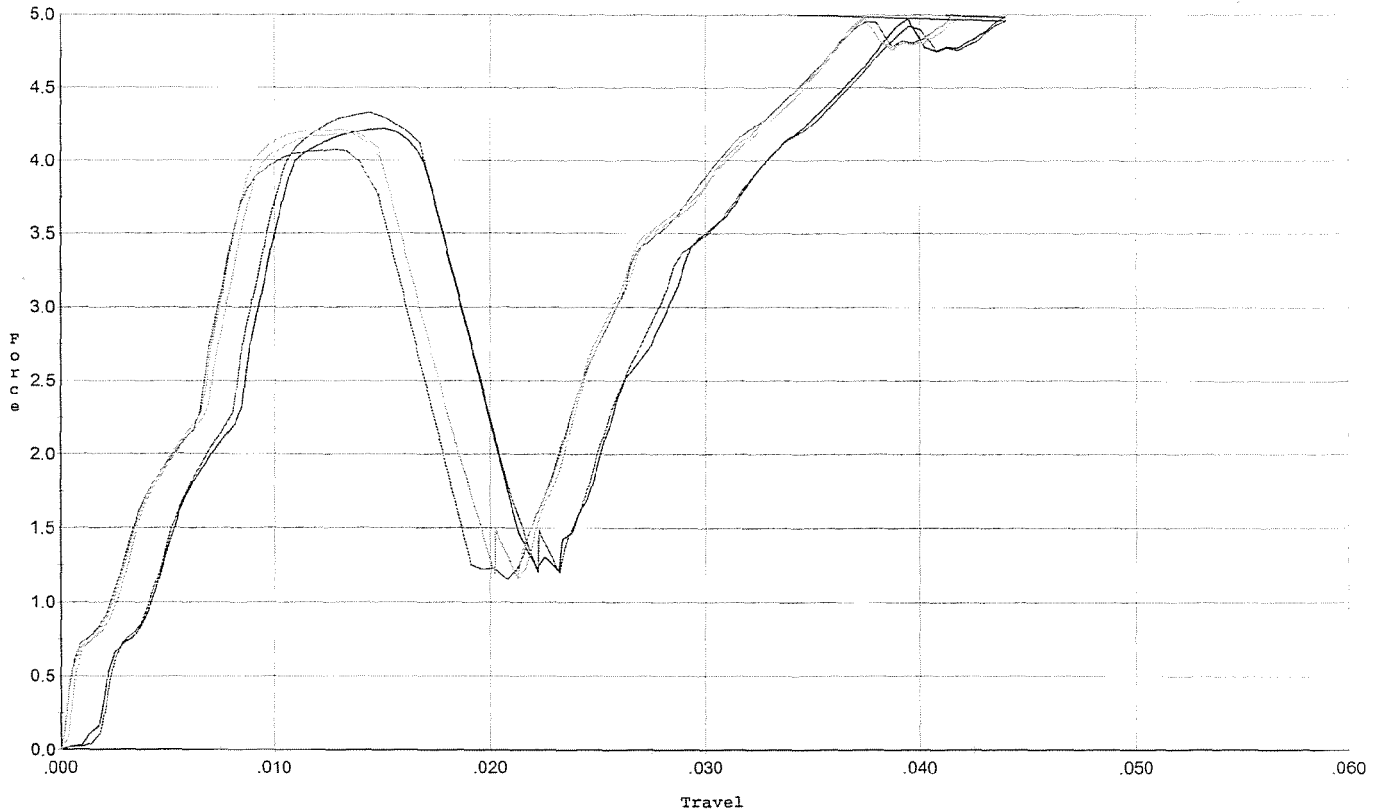
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.021	0.018	0.00	0.027	0.041		Set Trigger
2	4.213	0.016	0.00	0.026	0.041		Set Trigger
3	4.117	0.014	0.00	0.026	0.037		Set Trigger
4	4.066	0.016	0.00	0.026	0.038		Set Trigger
5	4.094	0.015	0.00	0.027	0.037		Set Trigger

A. 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



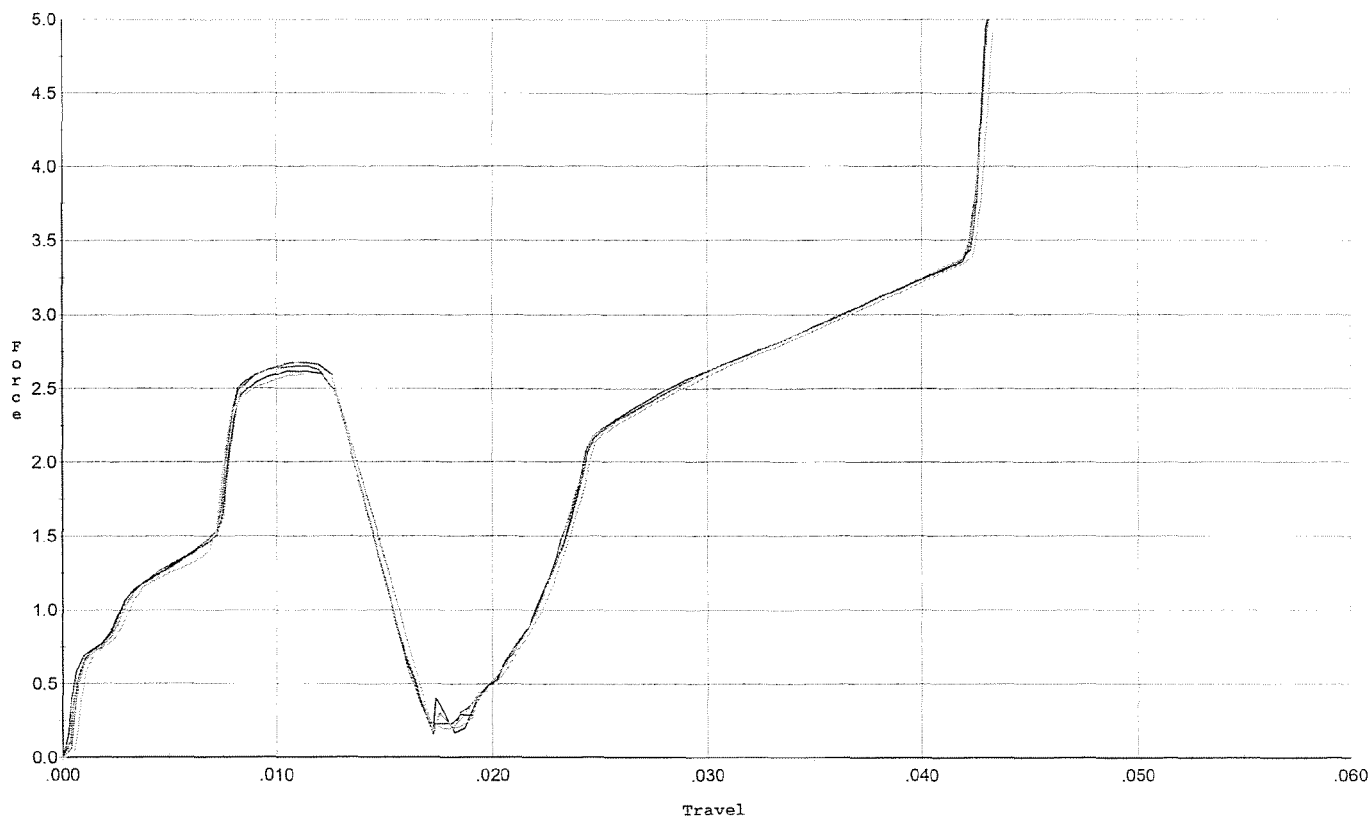
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.327	0.017	0.00	0.027	0.041		Set Trigger
2	4.220	0.017	0.00	0.027	0.041		Set Trigger
3	4.076	0.015	0.00	0.027	0.037		Set Trigger
4	4.182	0.015	0.00	0.027	0.038		Set Trigger
5	4.212	0.015	0.00	0.026	0.038		Set Trigger

A-420

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



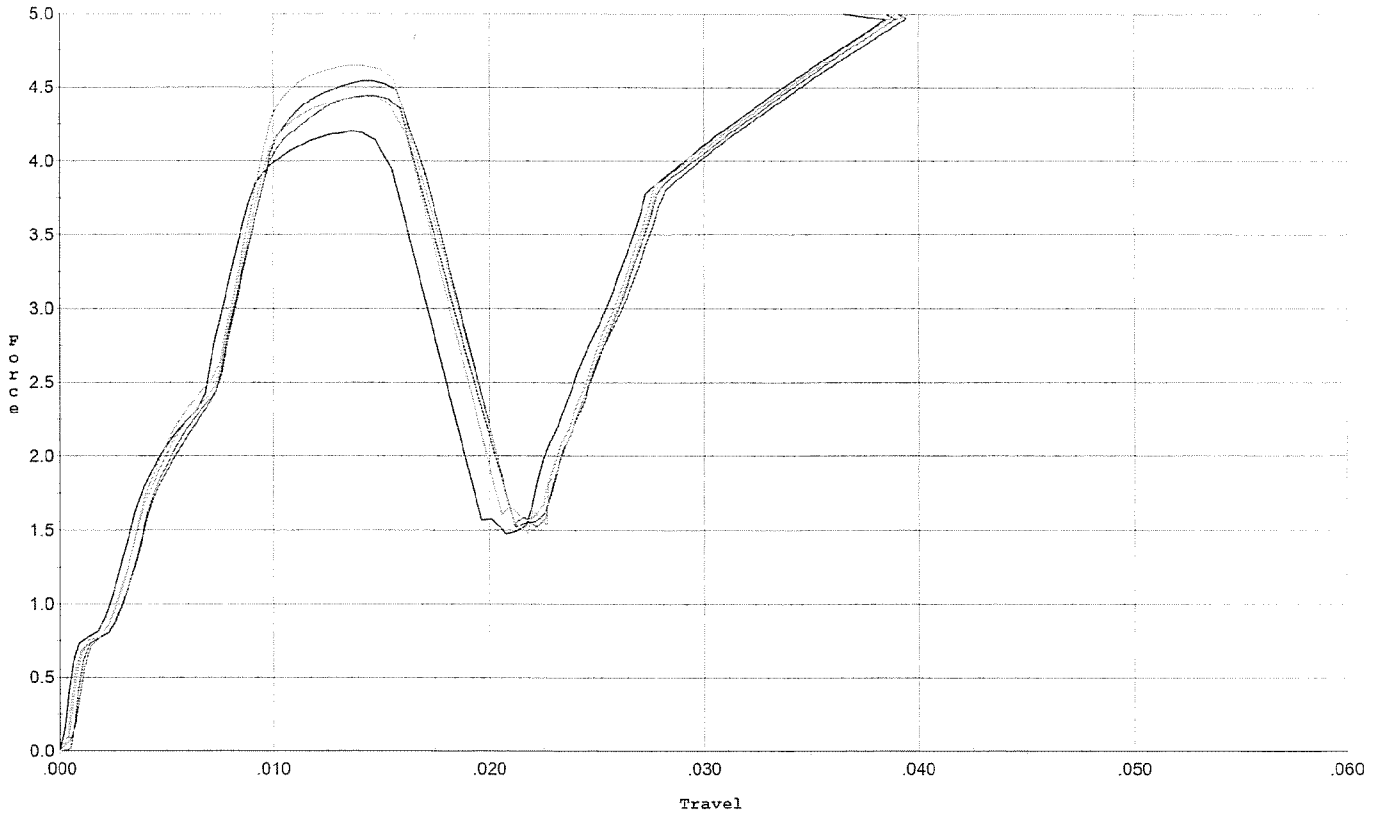
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.676	0.015	0.00	0.032	0.024		Set Trigger
2	2.620	0.013	0.00	0.032	0.020		Set Trigger
3	2.652	0.013	0.00	0.032	0.020		Set Trigger
4	2.677	0.015	0.00	0.032	0.023		Set Trigger
5	2.601	0.013	0.00	0.032	0.020		Set Trigger

A-2-64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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	4.542	0.017	0.00	0.026	0.046		Set Trigger
2	4.204	0.016	0.00	0.026	0.041		Set Trigger
3	4.442	0.016	0.00	0.026	0.042		Set Trigger
4	4.434	0.016	0.00	0.026	0.043		Set Trigger
5	4.647	0.018	0.00	0.026	0.050		Set Trigger

A-2'

4.45

cms