

G680 7738

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**

G6807738

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 7738

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	KJZ
430	ASSEMBLE TO STOCK		3-6-09	KJZ
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	KR
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-6-09	KR
475	DRILL AND TAP SIGHT HOLES	MAR 0 2009	3-6-09	JP
480	MAGNAFLUX BBL ACTION	OPERATOR. (A)	3/9/09	(A)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	MR
542	APPLY COATINGS (BARREL ACTION)		3-20	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-20-09	KJZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

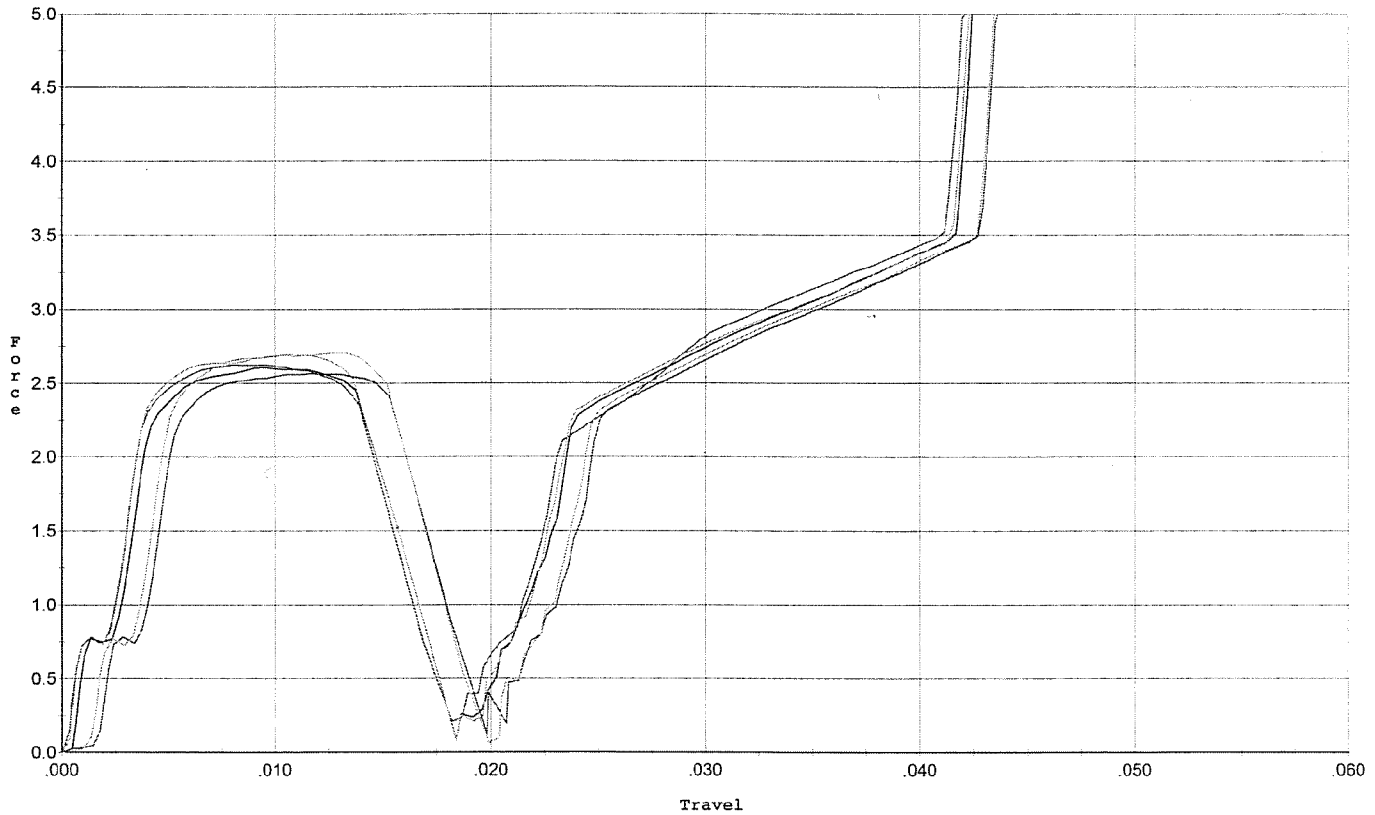
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>5.5</u>	3-24-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-24-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-24-09	WV
	J) ASSEMBLE STOCK		3-23-09	RT
	K) ASSEMBLE SWIVEL STUDS		3-24-09	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	3-24-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-24-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.57</u> <u>2.51</u> <u>2.67</u> <u>2.52</u>	3-24-09	TC
	C) FUNCTION		3-24-09	WV
690	PACK		3/25/09	FM

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



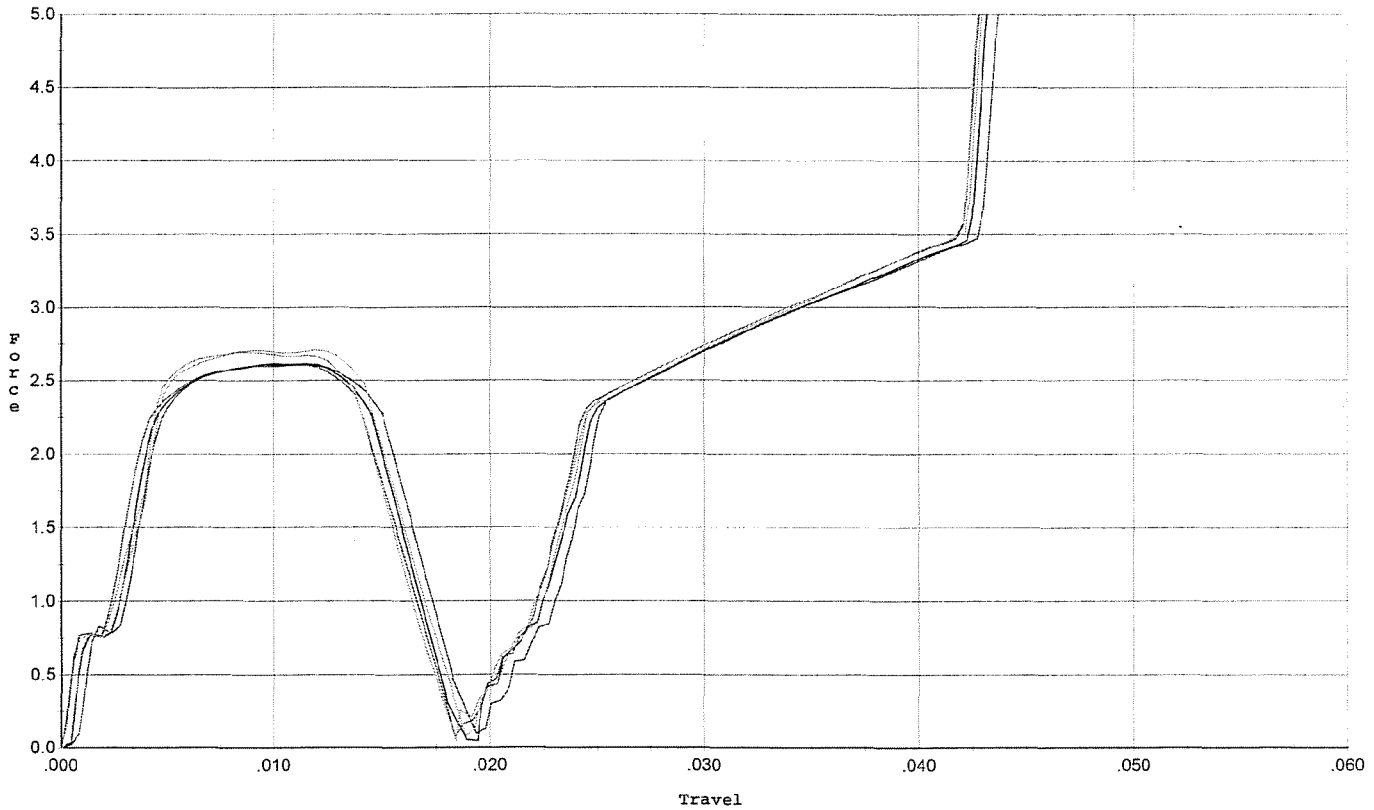
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.015	0.00	0.030	0.027		Set Trigger
2	2.609	0.016	0.00	0.030	0.030		Set Trigger
3	2.625	0.014	0.00	0.030	0.027		Set Trigger
4	2.708	0.015	0.00	0.030	0.029		Set Trigger
5	2.693	0.016	0.00	0.030	0.031		Set Trigger

A-2-64

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



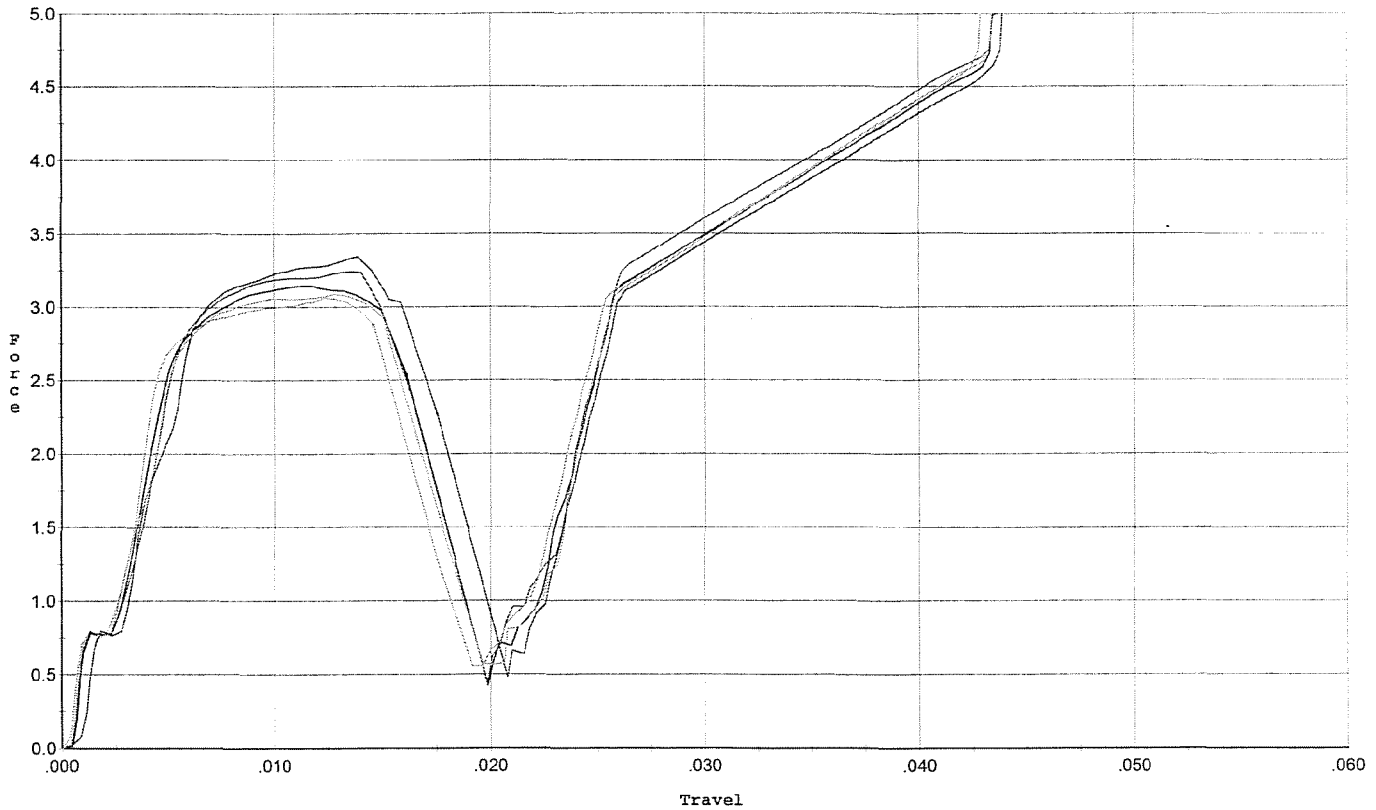
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.015	0.00	0.031	0.028		Set Trigger
2	2.610	0.015	0.00	0.031	0.028		Set Trigger
3	2.604	0.016	0.00	0.030	0.031		Set Trigger
4	2.709	0.014	0.00	0.031	0.028		Set Trigger
5	2.693	0.014	0.00	0.031	0.027		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



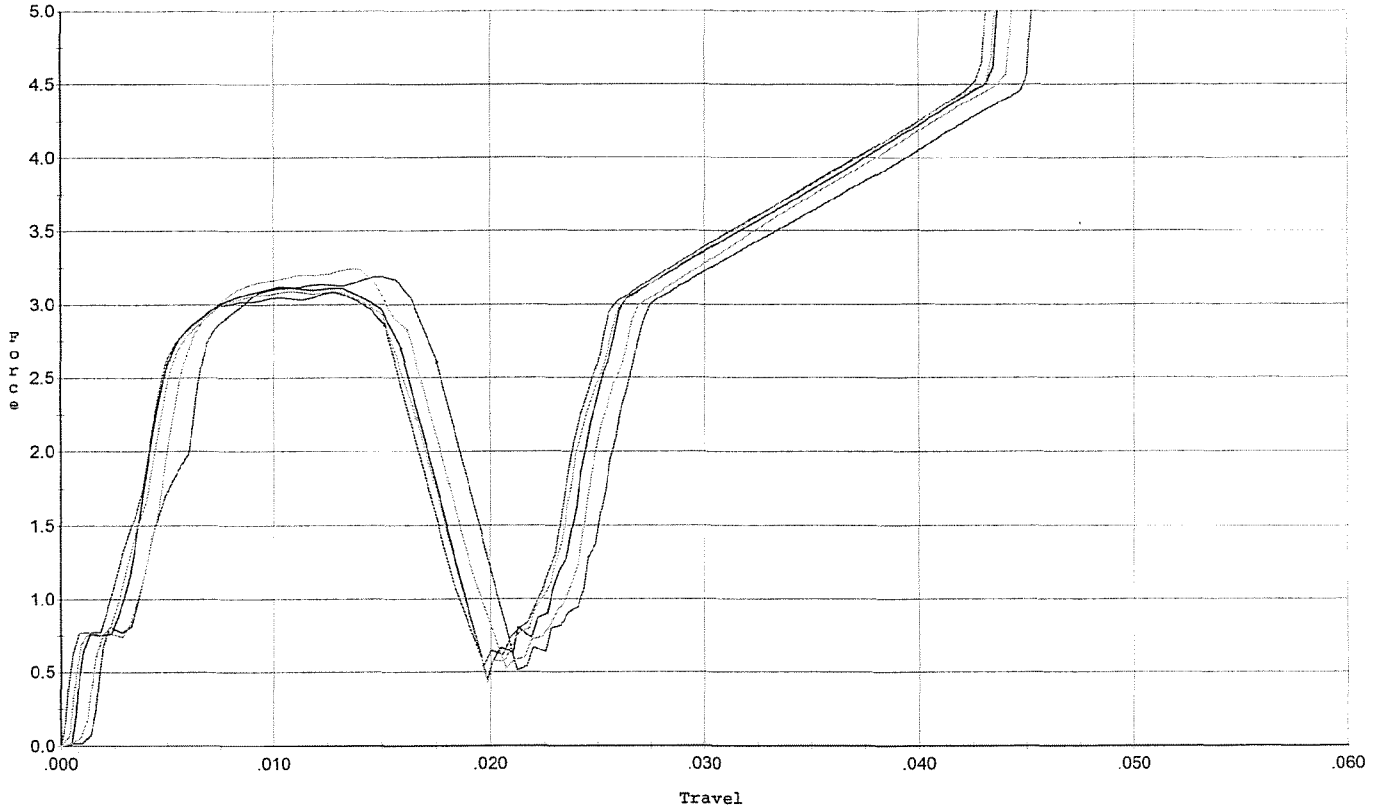
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.347	0.018	0.00	0.028	0.040		Set Trigger
2	3.147	0.016	0.00	0.028	0.036		Set Trigger
3	3.242	0.016	0.00	0.028	0.036		Set Trigger
4	3.088	0.015	0.00	0.029	0.033		Set Trigger
5	3.061	0.015	0.00	0.028	0.032		Set Trigger

A.3.17

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



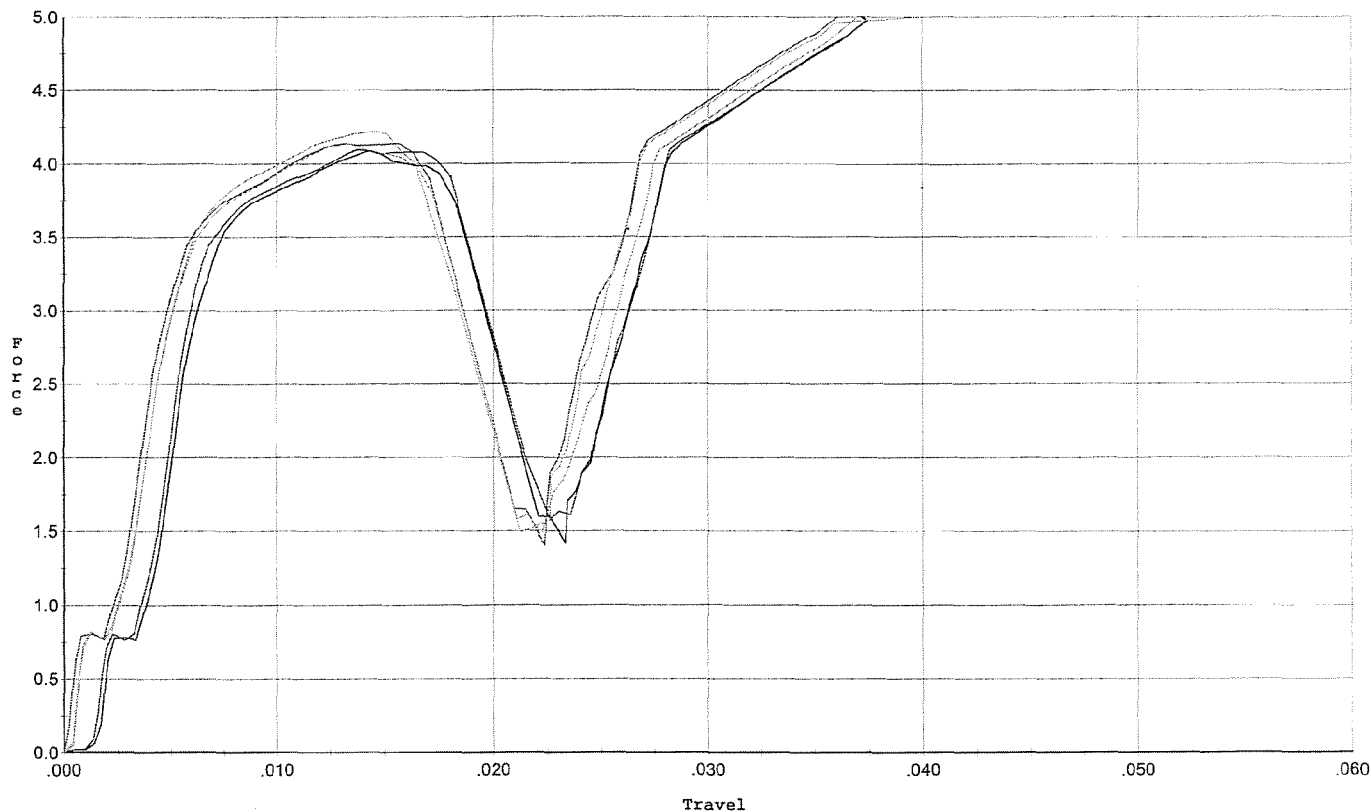
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.188	0.018	0.00	0.029	0.037		Set Trigger
2	3.122	0.016	0.00	0.029	0.035		Set Trigger
3	3.082	0.015	0.002	0.029	0.034		Set Trigger
4	3.091	0.017	0.00	0.029	0.036		Set Trigger
5	3.240	0.016	0.00	0.029	0.035		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



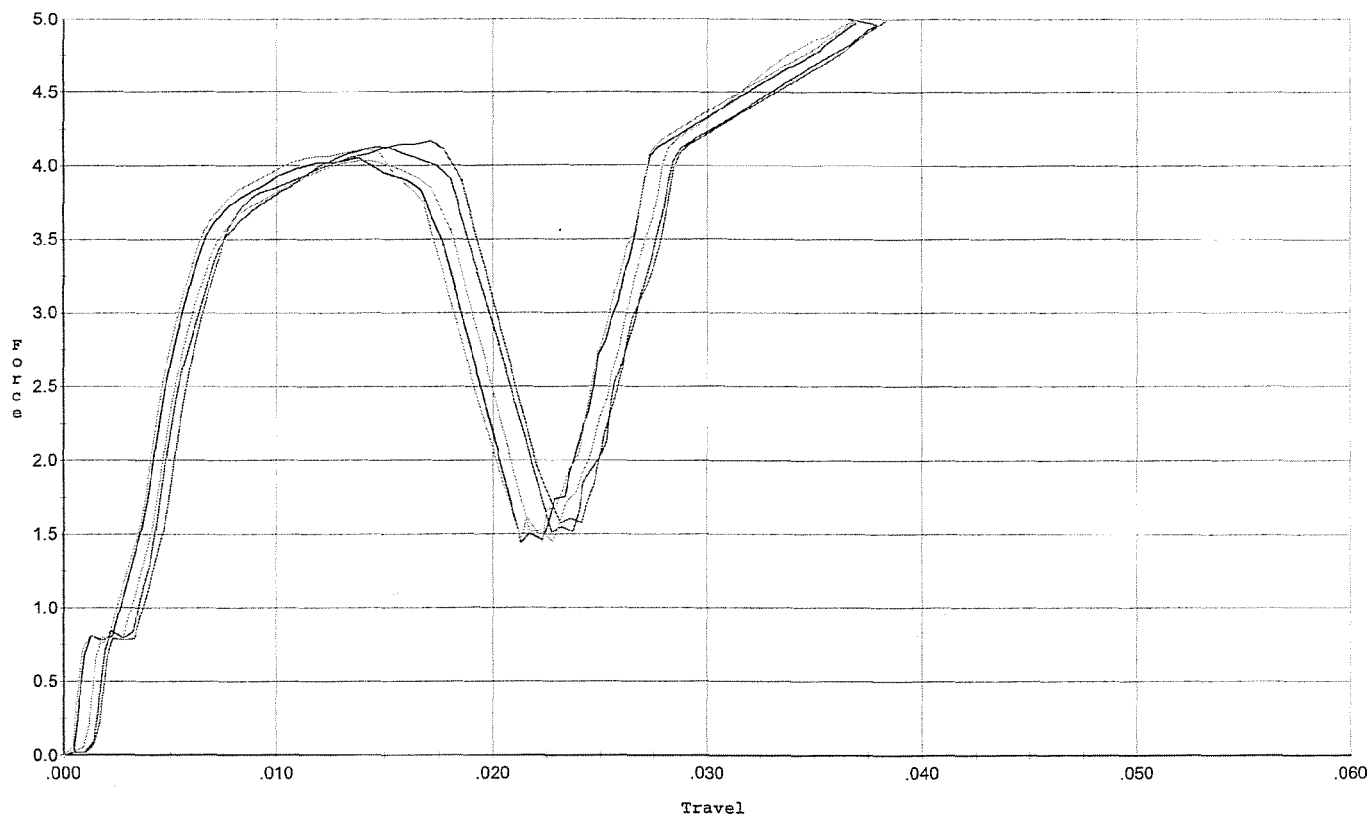
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.096	0.018	0.00	0.026	0.049		Set Trigger
2	4.088	0.018	0.00	0.026	0.049		Set Trigger
3	4.136	0.017	0.00	0.026	0.050		Set Trigger
4	4.139	0.018	0.00	0.026	0.052		Set Trigger
5	4.215	0.017	0.00	0.026	0.050		Set Trigger

A. 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



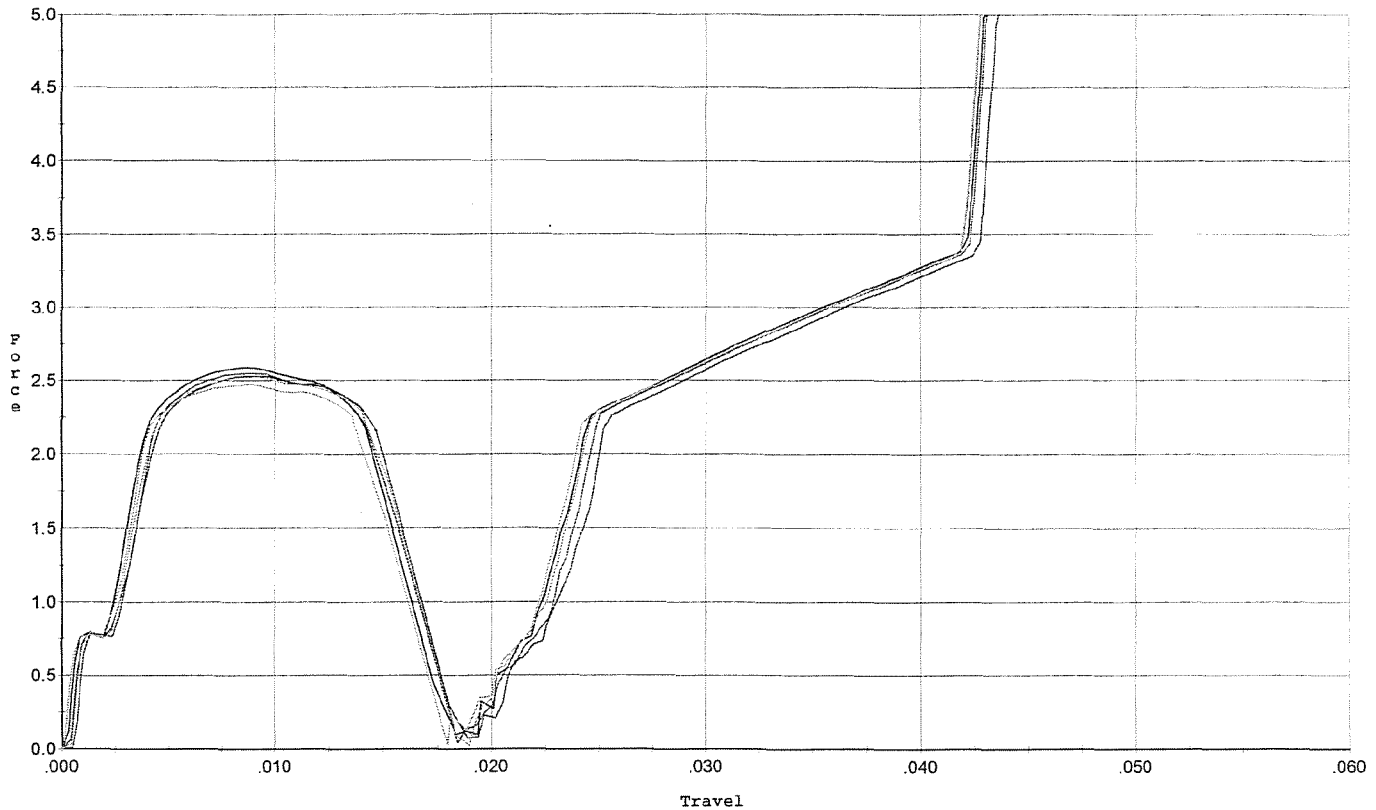
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.127	0.020	0.00	0.026	0.055		Set Trigger
2	4.054	0.018	0.00	0.026	0.049		Set Trigger
3	4.166	0.019	0.00	0.026	0.051		Set Trigger
4	4.034	0.018	0.00	0.026	0.049		Set Trigger
5	4.109	0.017	0.00	0.026	0.047		Set Trigger

A. 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



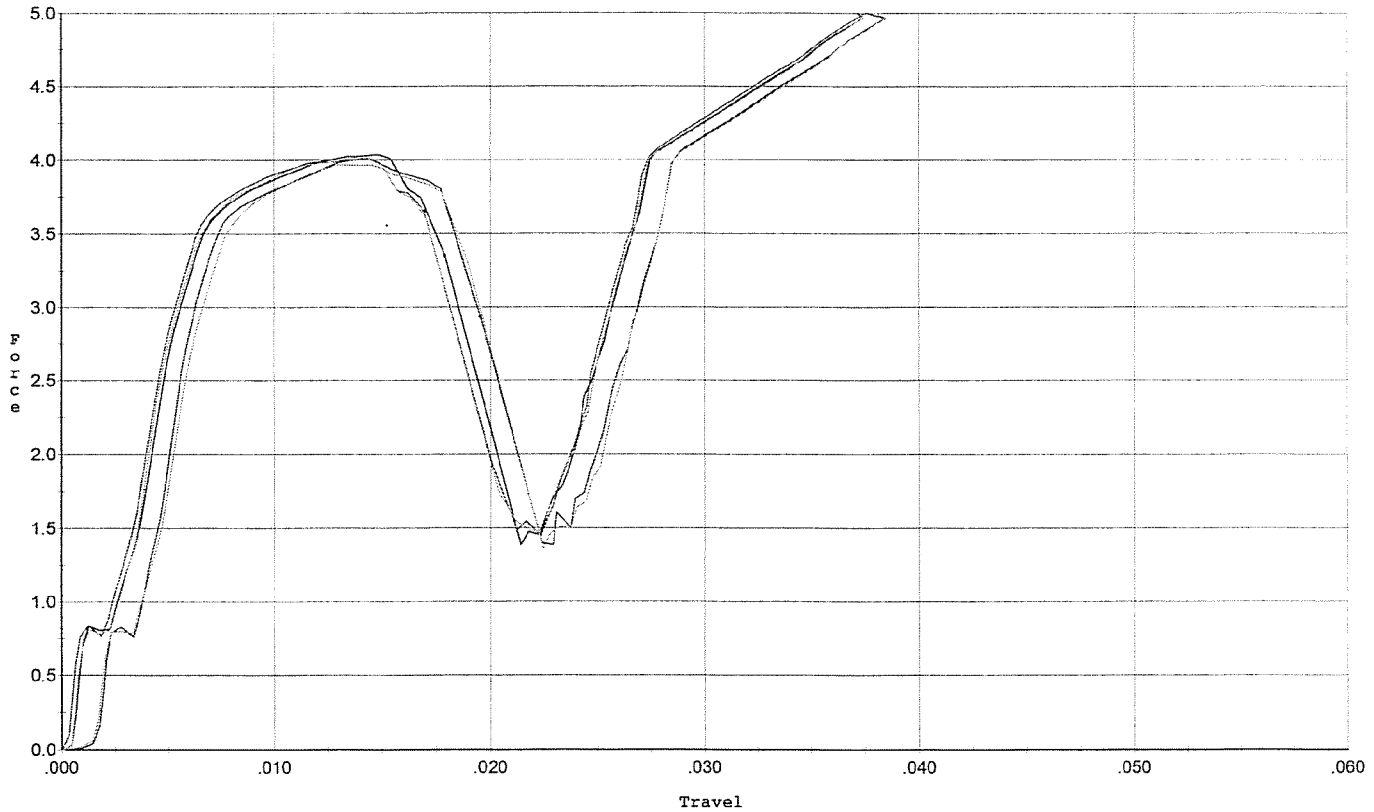
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.015	0.003	0.031	0.027		Set Trigger
2	2.589	0.014	0.00	0.031	0.027		Set Trigger
3	2.545	0.016	0.00	0.031	0.029		Set Trigger
4	2.473	0.015	0.00	0.031	0.028		Set Trigger
5	2.525	0.015	0.00	0.030	0.028		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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	4.013	0.020	0.00	0.027	0.052		Set Trigger
2	4.038	0.018	0.00	0.026	0.049		Set Trigger
3	4.012	0.017	0.00	0.026	0.047		Set Trigger
4	3.966	0.019	0.004	0.027	0.050		Set Trigger
5	4.018	0.017	0.00	0.026	0.047		Set Trigger

A - 4.00