

G680 7774

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



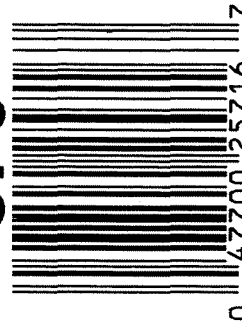
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807774

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807773

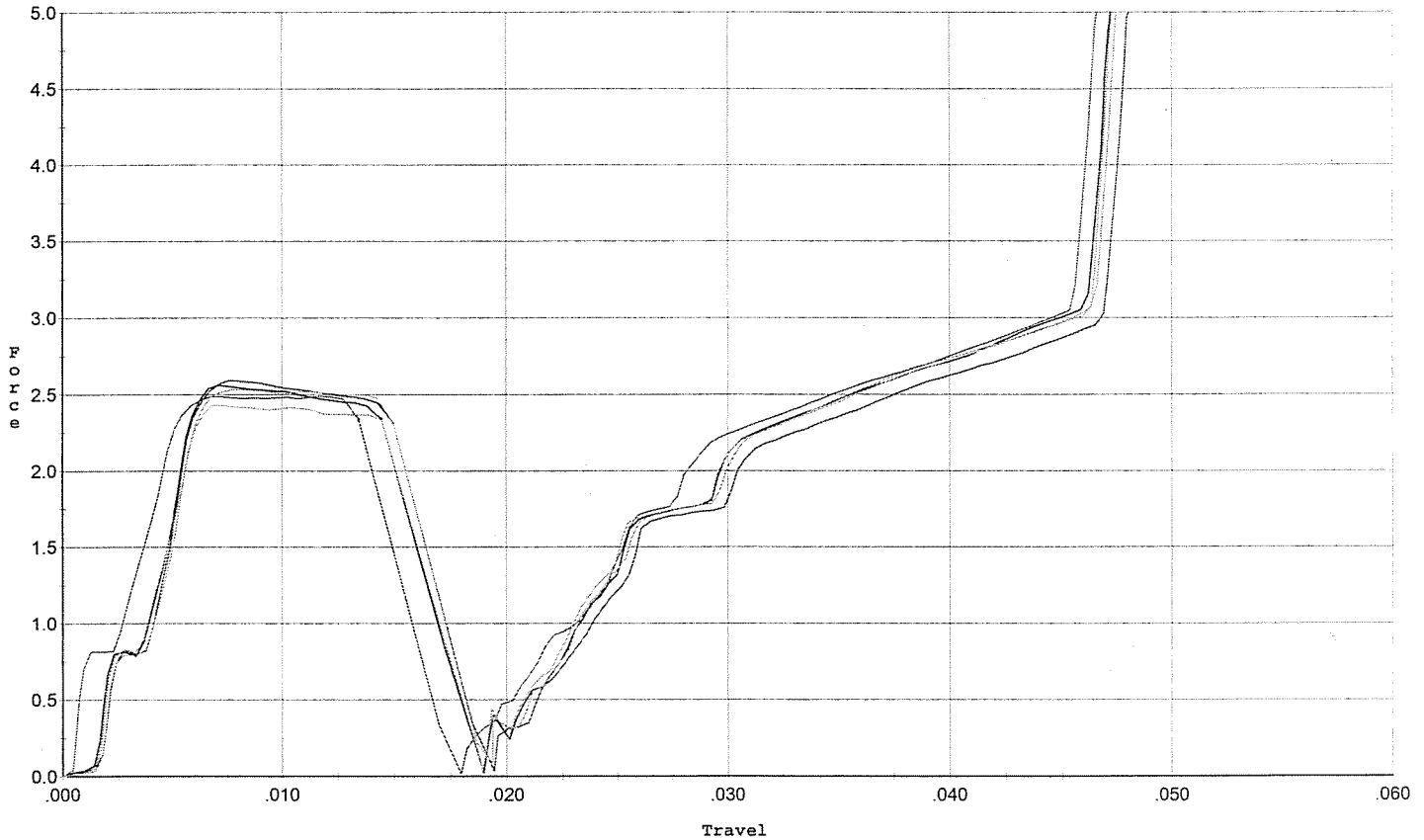
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-8-09	SP
520	GOFF BLAST BBL / REC		3/6	man
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			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-18-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-18-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-18-09	NW
	J) ASSEMBLE STOCK		3-11-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-18-09	NW
	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 FAIL PASS FAIL	3-16-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-18-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.33</u> <u>2.29</u> <u>2.31</u> <u>2.35</u>	3-18-09	NW
	C) FUNCTION		3-18-09	NW
690	PACK		3/19/09	FM

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



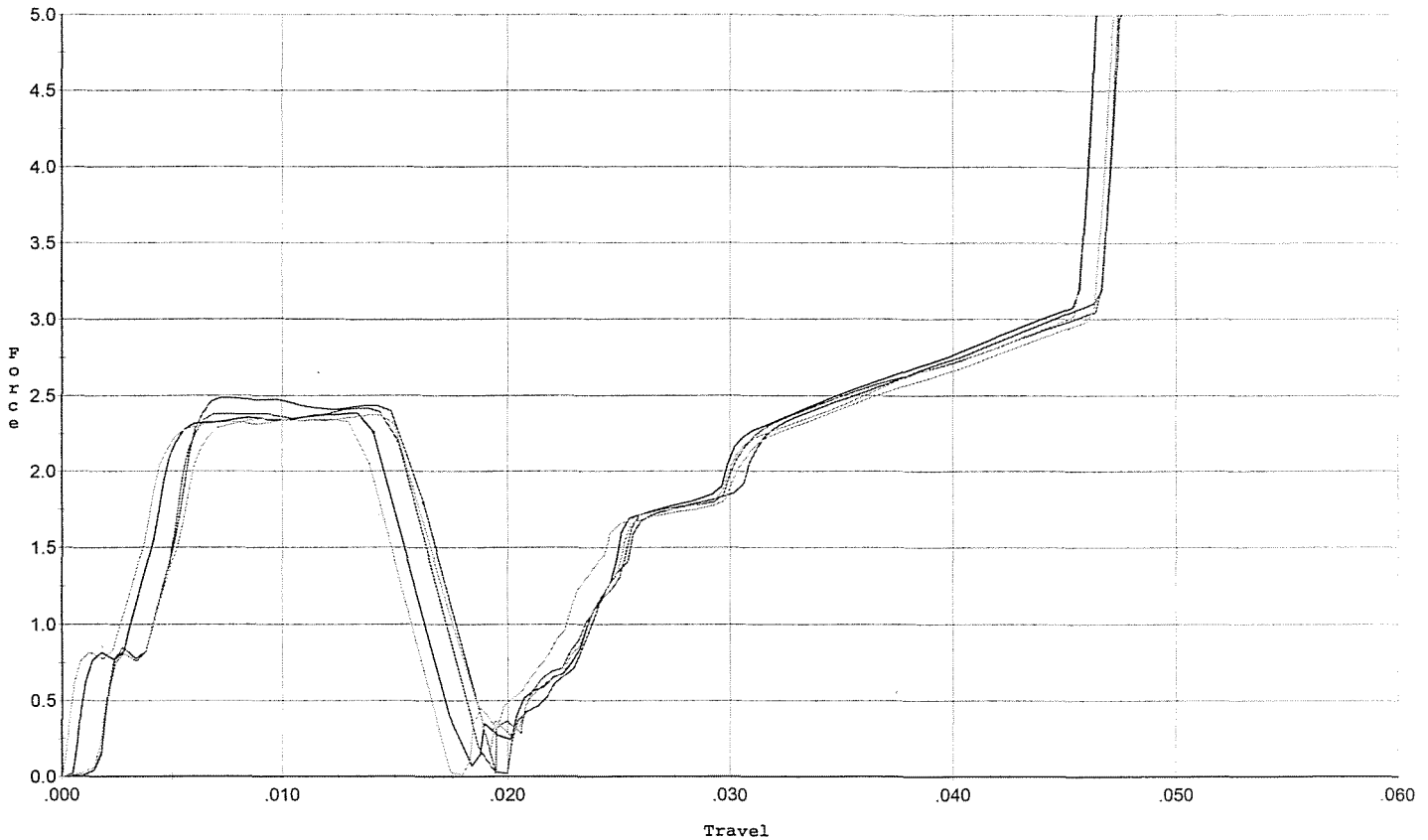
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.015	0.00	0.035	0.026		Set Trigger
2	2.560	0.014	0.00	0.035	0.025		Set Trigger
3	2.489	0.013	0.003	0.036	0.024		Set Trigger
4	2.429	0.014	0.00	0.035	0.024		Set Trigger
5	2.533	0.015	0.00	0.035	0.026		Set Trigger

A.2.52

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



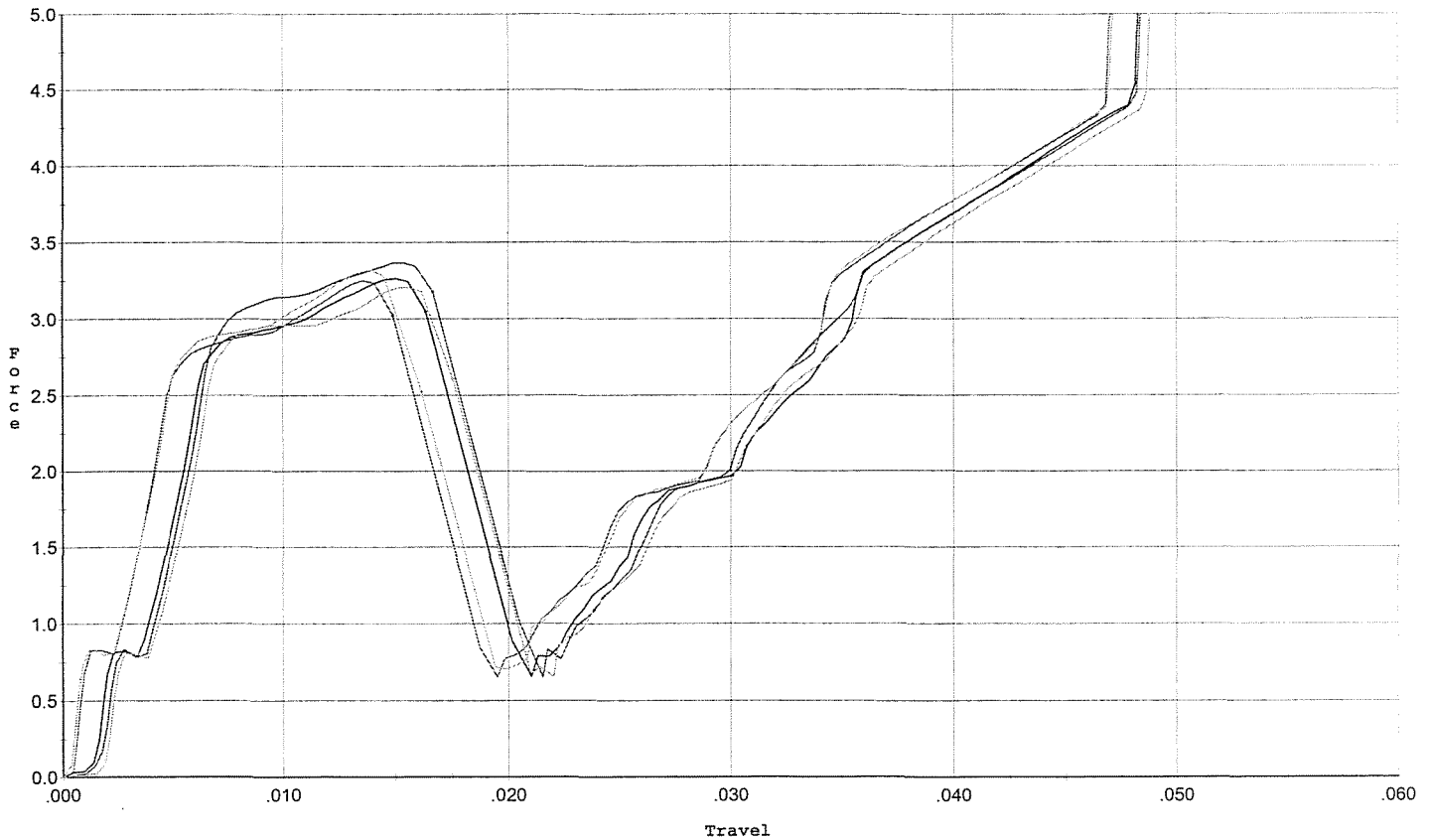
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.016	0.00	0.034	0.028		Set Trigger
2	2.382	0.014	0.00	0.035	0.024		Set Trigger
3	2.417	0.015	0.00	0.035	0.025		Set Trigger
4	2.372	0.015	0.00	0.035	0.024		Set Trigger
5	2.339	0.014	0.00	0.035	0.024		Set Trigger

A-2.40

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



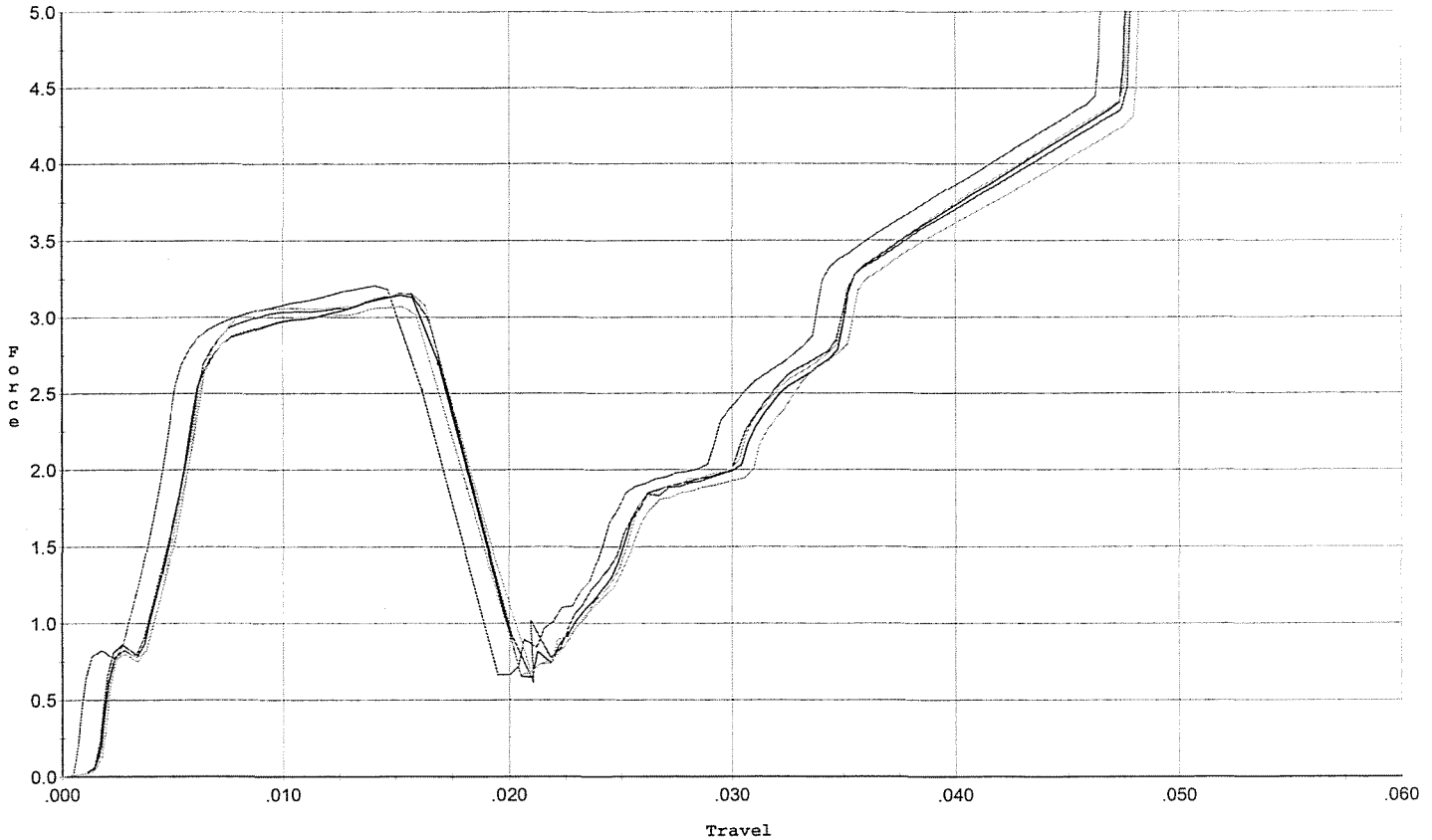
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.367	0.017	0.00	0.032	0.036		Set Trigger
2	3.265	0.016	0.00	0.033	0.035		Set Trigger
3	3.251	0.015	0.003	0.033	0.033		Set Trigger
4	3.320	0.016	0.00	0.033	0.036		Set Trigger
5	3.204	0.018	0.004	0.033	0.036		Set Trigger

A-3.28

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



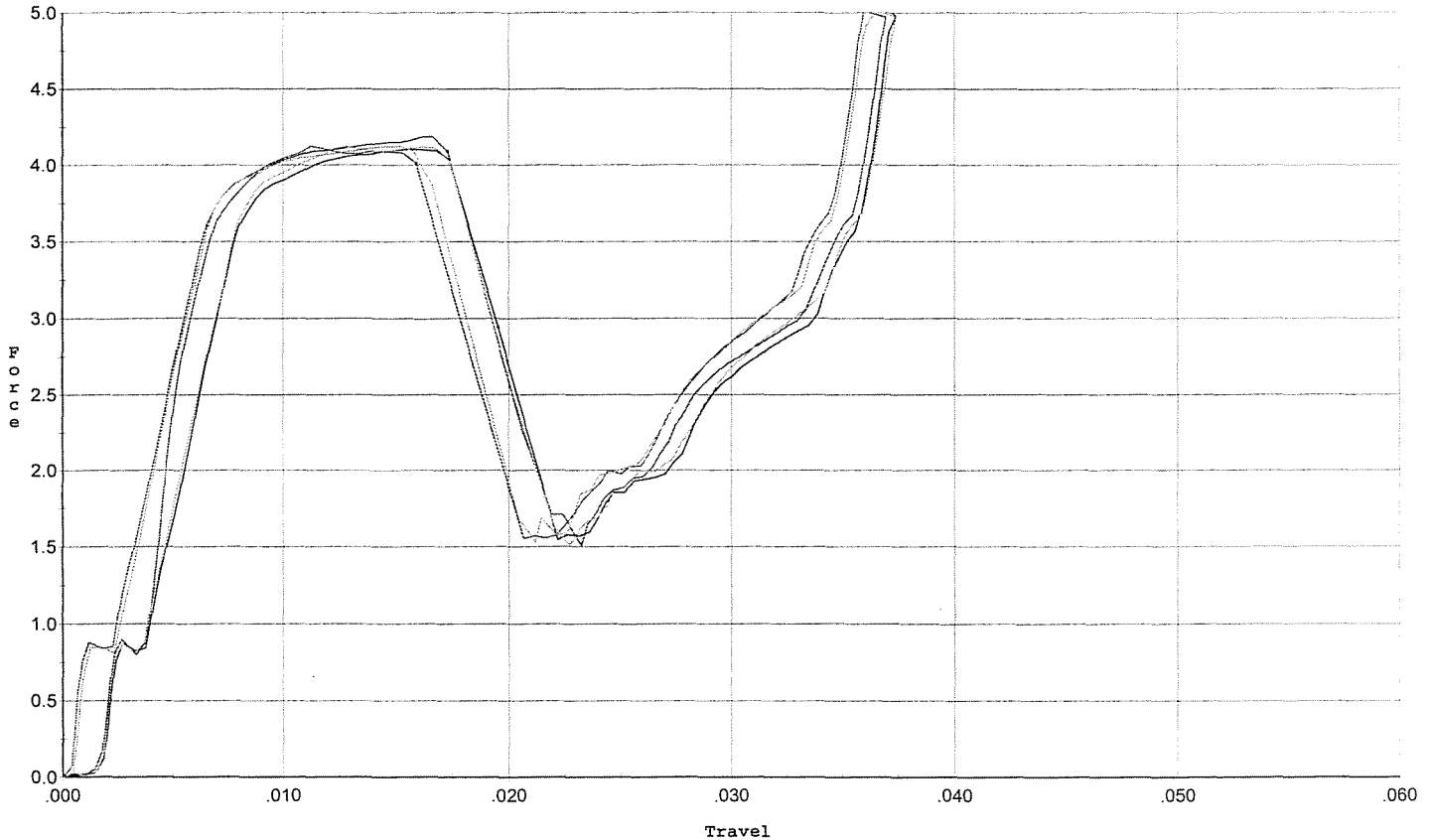
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.016	0.00	0.033	0.035		Set Trigger
2	3.147	0.017	0.00	0.033	0.035		Set Trigger
3	3.209	0.016	0.00	0.032	0.036		Set Trigger
4	3.160	0.016	0.00	0.033	0.034		Set Trigger
5	3.072	0.018	0.00	0.033	0.037		Set Trigger

A-3-14

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



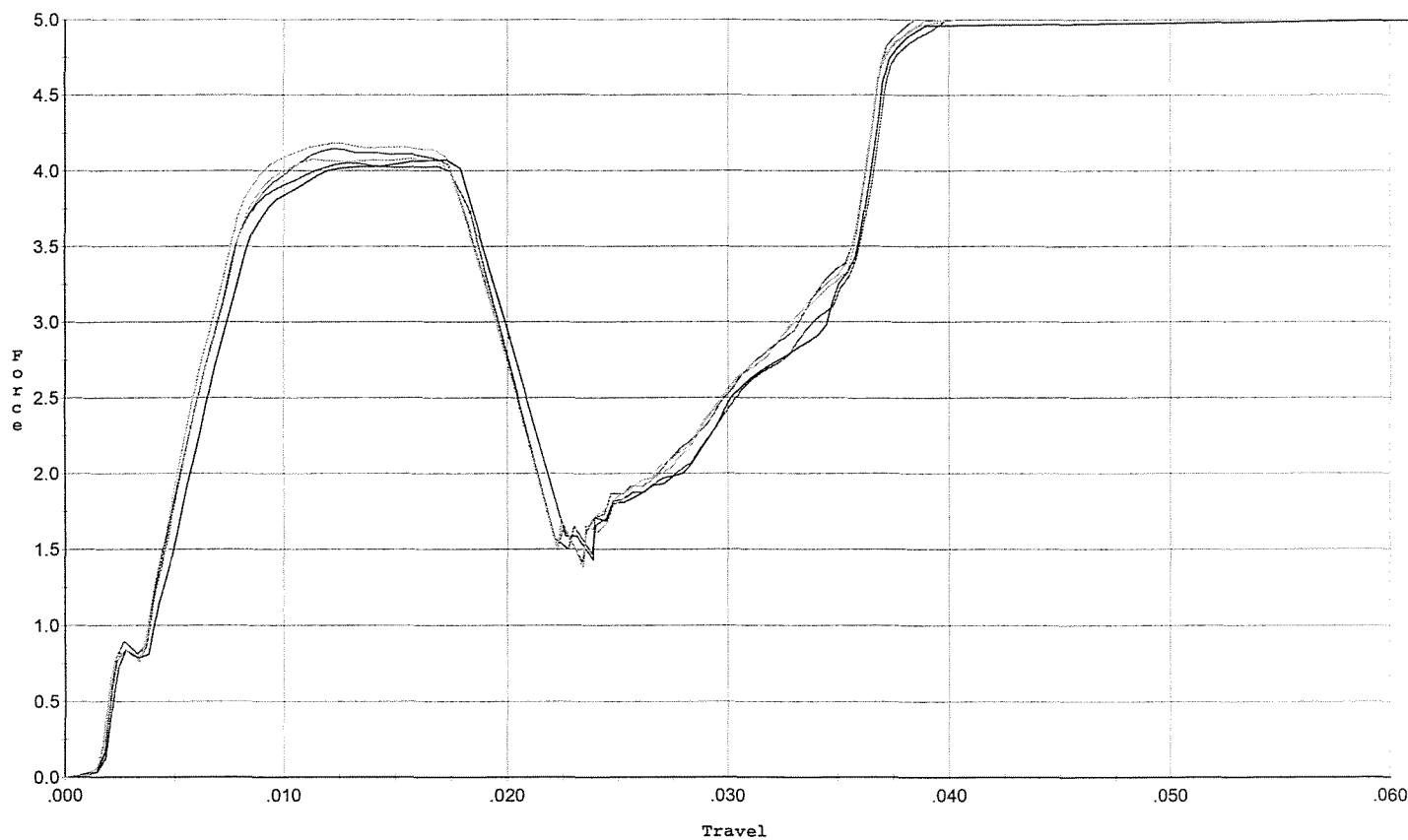
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.017	0.00	0.030	0.048		Set Trigger
2	4.105	0.020	0.00	0.030	0.052		Set Trigger
3	4.124	0.016	0.00	0.031	0.045		Set Trigger
4	4.123	0.017	0.00	0.031	0.046		Set Trigger
5	4.123	0.017	0.003	0.030	0.047		Set Trigger

A-4.13

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



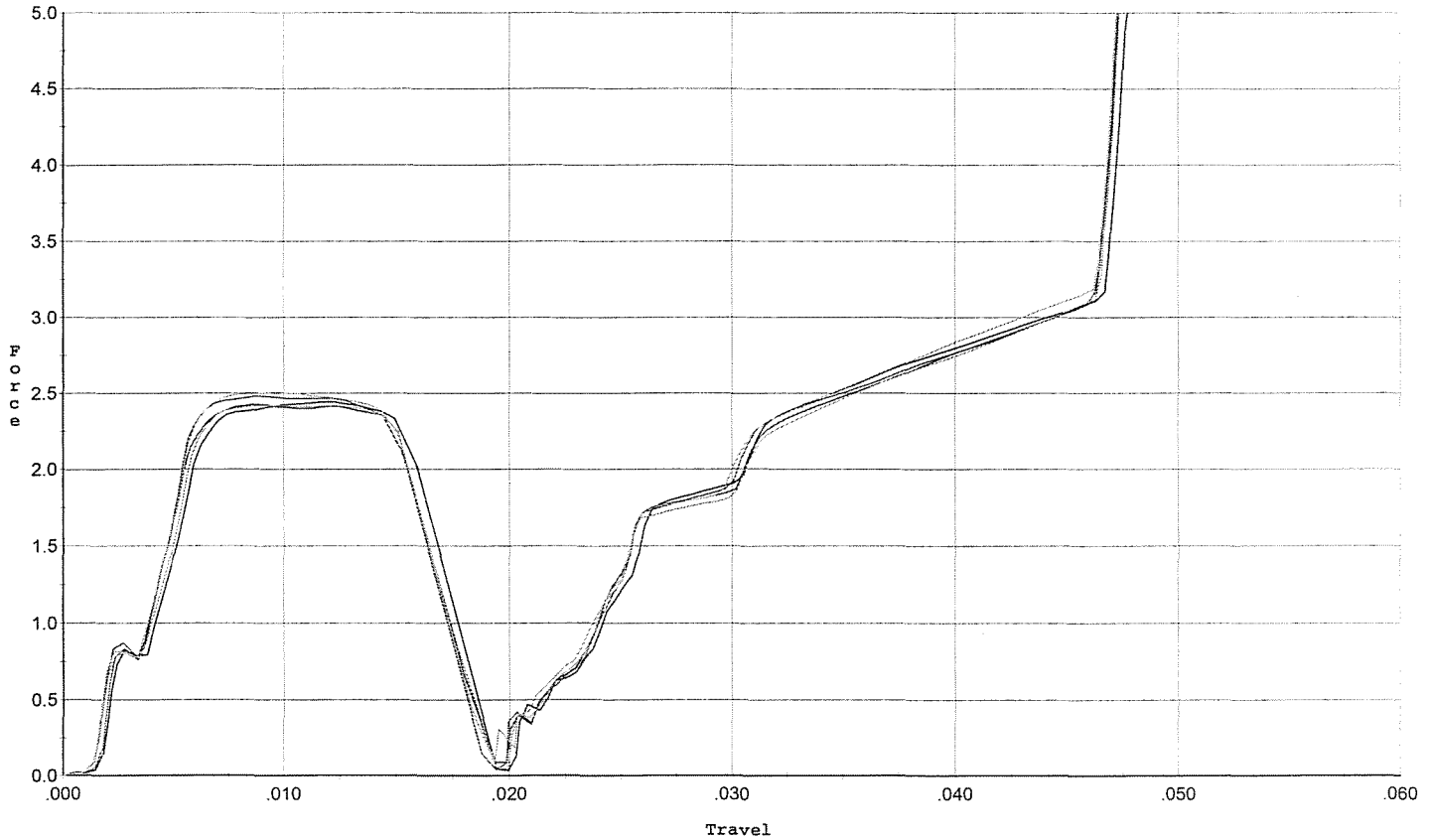
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.052	0.018	0.00	0.031	0.049		Set Trigger
2	4.070	0.020	0.00	0.030	0.052		Set Trigger
3	4.145	0.019	0.00	0.030	0.051		Set Trigger
4	4.081	0.019	0.00	0.030	0.051		Set Trigger
5	4.180	0.019	0.00	0.030	0.052		Set Trigger

A 4.10

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 ini +/- .50 lb for final test



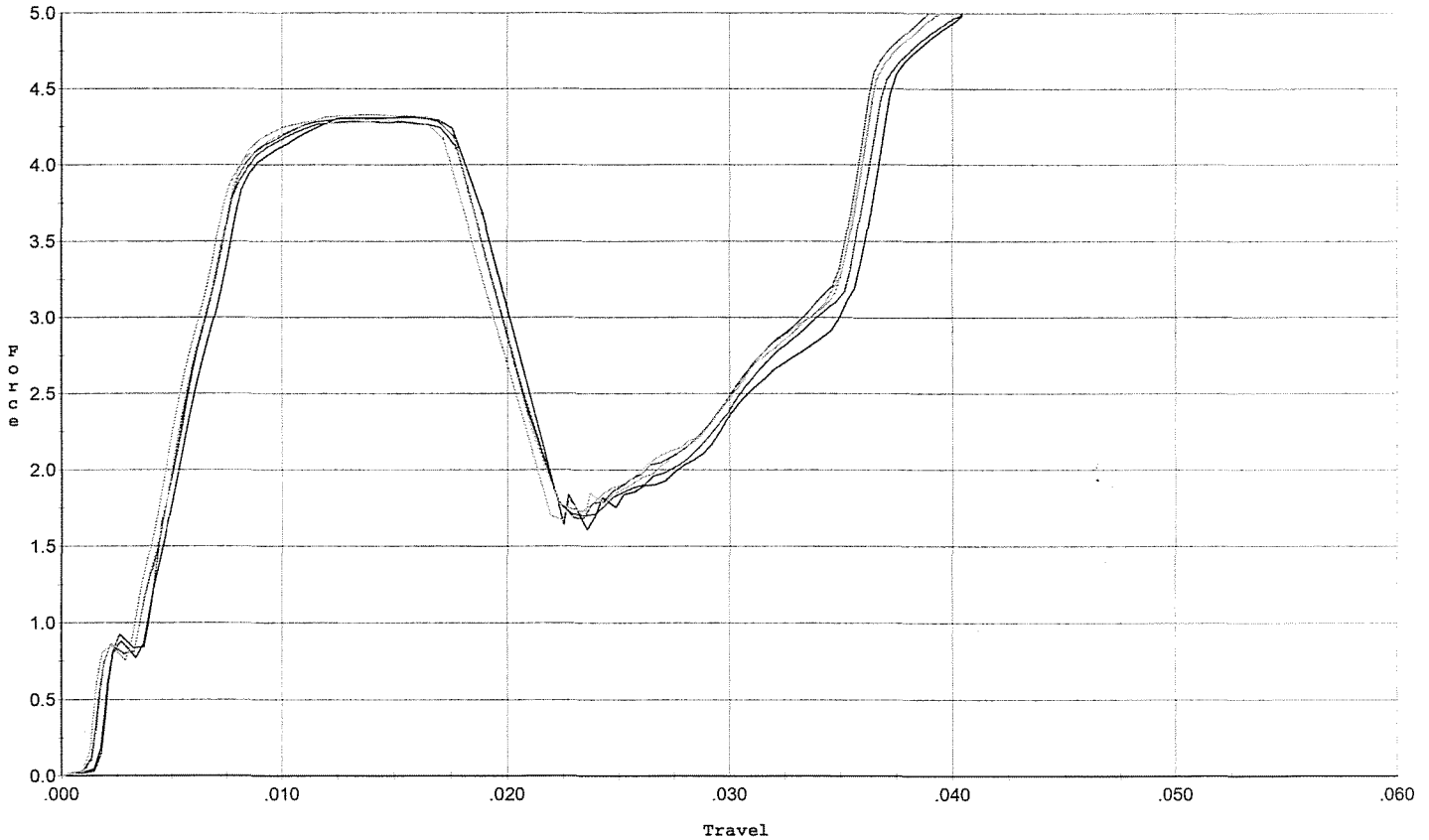
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.429	0.015	0.00	0.035	0.026		Set Trigger
2	2.442	0.016	0.00	0.035	0.027		Set Trigger
3	2.483	0.015	0.00	0.035	0.026		Set Trigger
4	2.507	0.015	0.004	0.035	0.026		Set Trigger
5	2.420	0.015	0.00	0.035	0.025		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: 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	4.287	0.018	0.00	0.030	0.050		Set Trigger
2	4.313	0.019	0.00	0.030	0.053		Set Trigger
3	4.320	0.018	0.00	0.030	0.050		Set Trigger
4	4.294	0.017	0.00	0.030	0.049		Set Trigger
5	4.334	0.018	0.00	0.030	0.050		Set Trigger

A-4.35