

G6845260

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



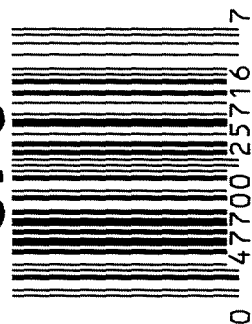
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845260

UPC



GUN SERIAL # 66845260

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SP
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SP
460	CHECK HEADSPACE		3-17-09	SP
470	DIS-ASSEMBLE ACTION		3-17-09	SP
472	SERIALIZE BOLT HANDLE		3-18-09	KIC
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	(H)	3/20/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

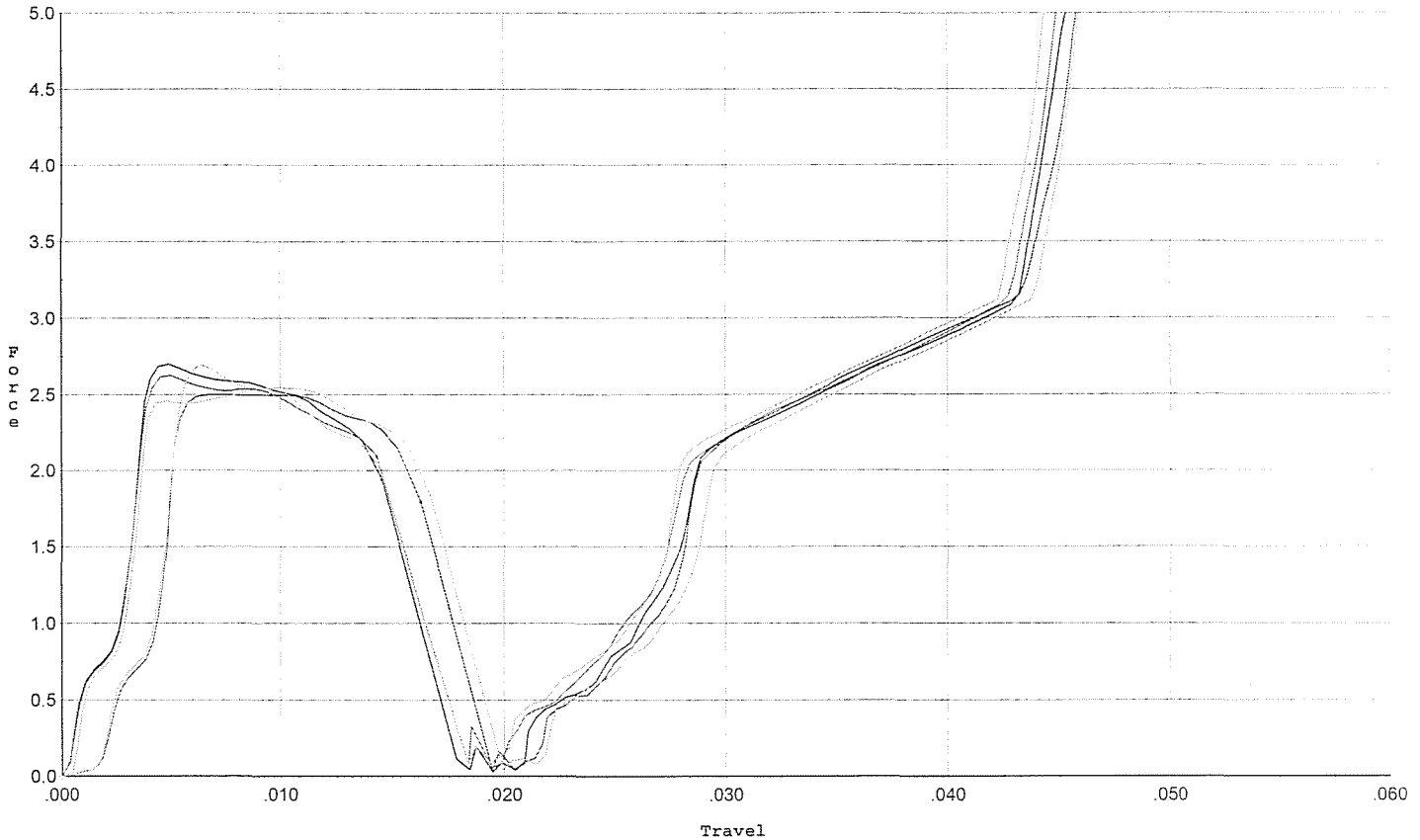
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	24	24	24	4/28/09	RP
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	40	42	42	4/28/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	.024	.024	.024	4/28/09	RP
	J) ASSEMBLE STOCK					4-20-09	WJ
	K) ASSEMBLE SWIVEL STUDS					4/28/09	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	FAIL			
			PASS	FAIL		4-21-09	WJ
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION	N/A			
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION			4-21-09	TQR
660	INSPECT FOR LIVE AMMO						
670	FINAL INSPECTION A) HEADSPACE					4/28/09	RP
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	238	230	248	240	231
	C) FUNCTION					4-22-09	WJ
						4/28/09	RP
690	PACK					5/30/09	FM

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



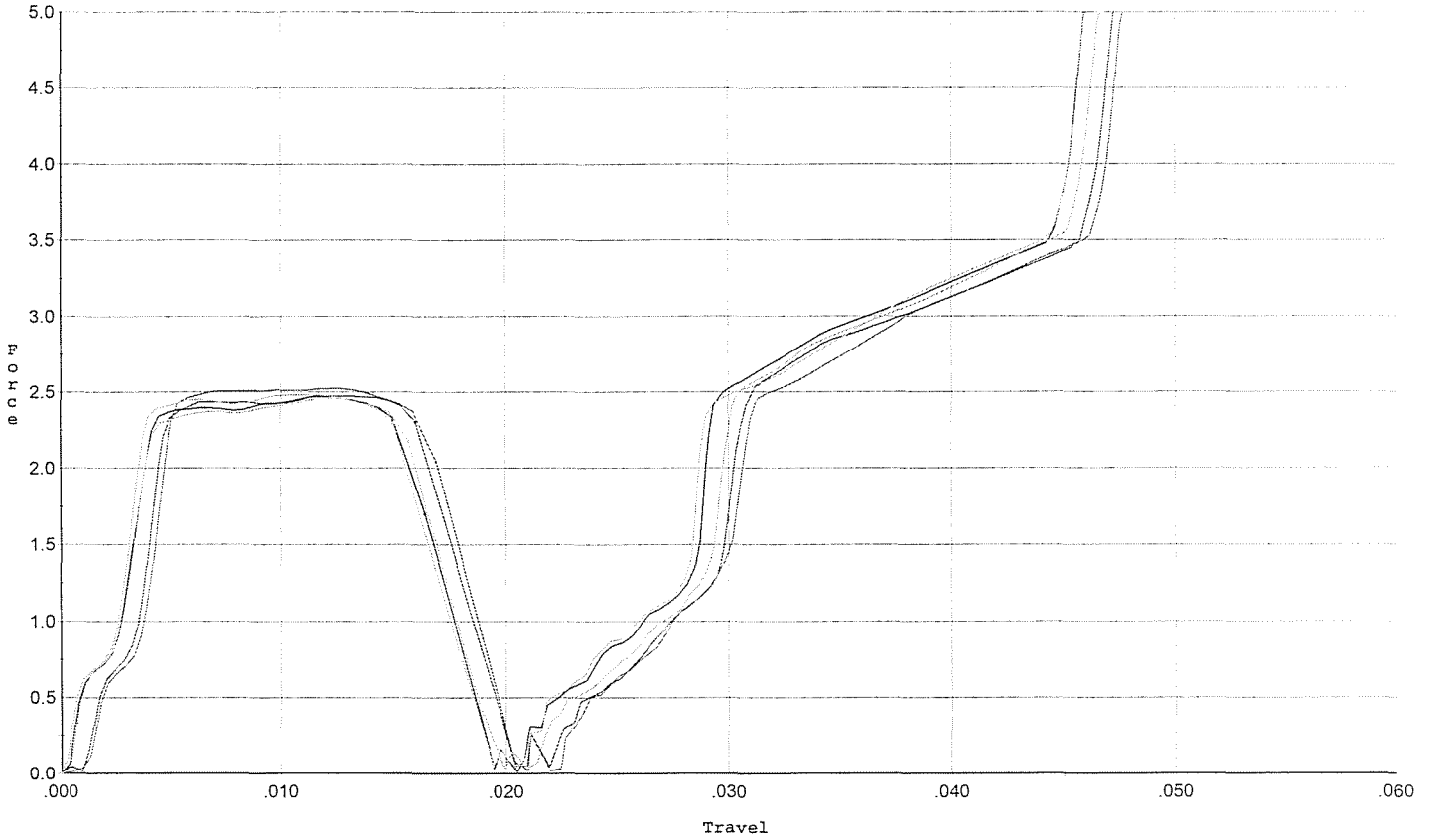
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.501	0.016	0.00	0.033	0.028		Set Trigger
2	2.700	0.015	0.00	0.034	0.028		Set Trigger
3	2.624	0.014	0.00	0.034	0.027		Set Trigger
4	2.696	0.017	0.00	0.033	0.029		Set Trigger
5	2.535	0.014	0.00	0.033	0.026		Set Trigger

A.2.61

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



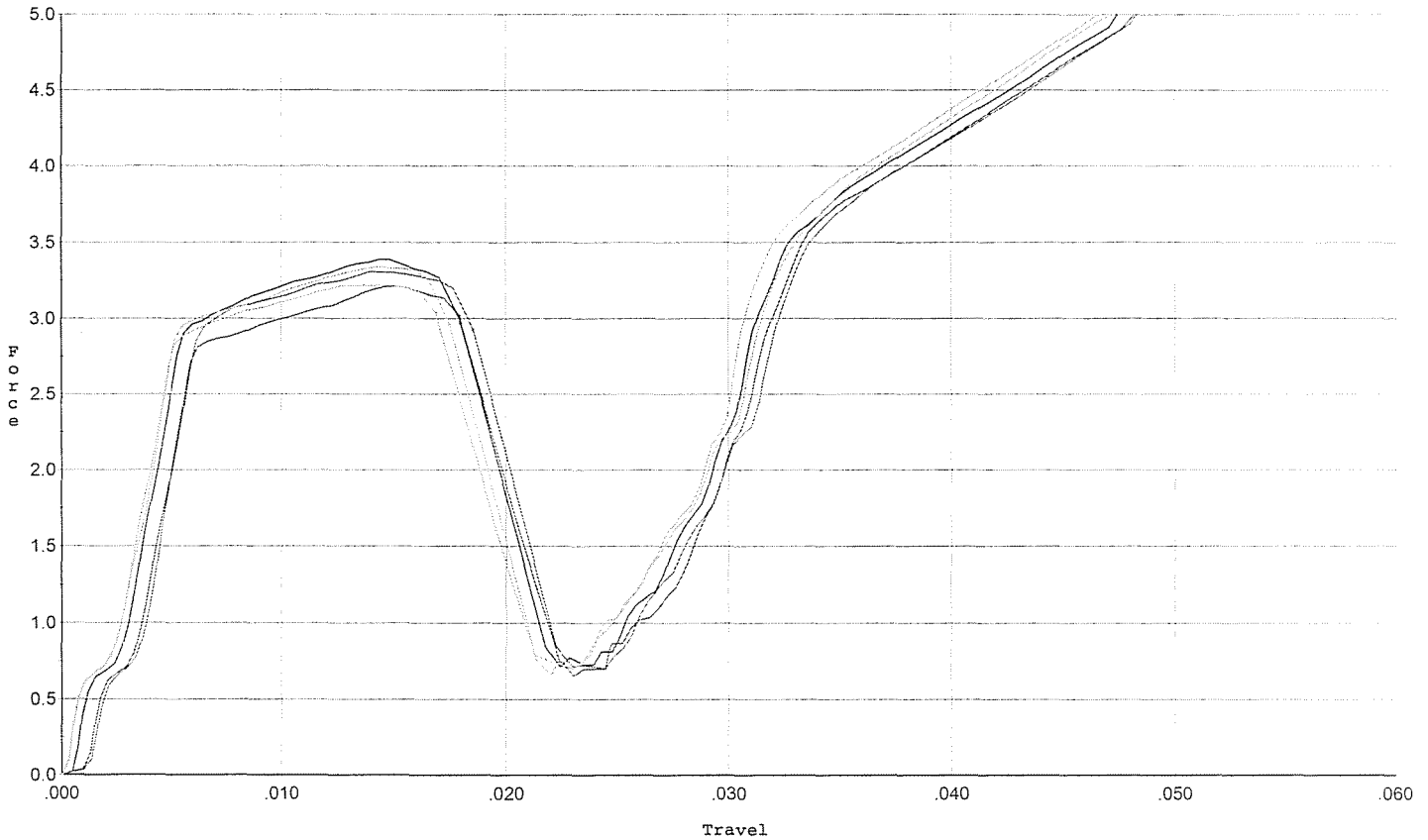
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.473	0.016	0.00	0.033	0.029		Set Trigger
2	2.477	0.016	0.00	0.033	0.031		Set Trigger
3	2.523	0.017	0.00	0.034	0.031		Set Trigger
4	2.484	0.015	0.00	0.033	0.029		Set Trigger
5	2.459	0.016	0.00	0.033	0.029		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



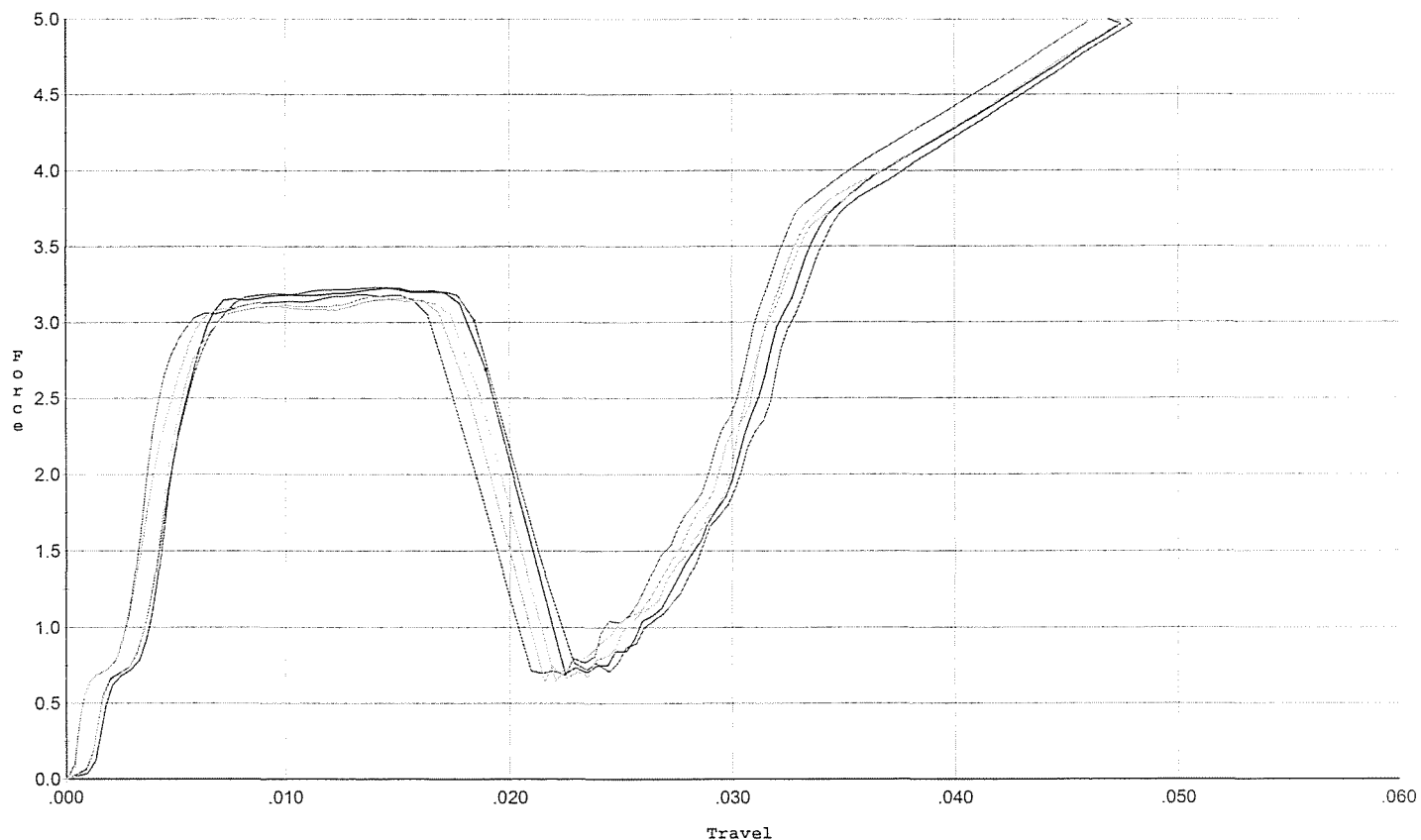
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.213	0.018	0.00	0.031	0.040		Set Trigger
2	3.387	0.018	0.00	0.031	0.043		Set Trigger
3	3.308	0.019	0.00	0.031	0.043		Set Trigger
4	3.219	0.017	0.00	0.031	0.040		Set Trigger
5	3.340	0.017	0.00	0.030	0.042		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



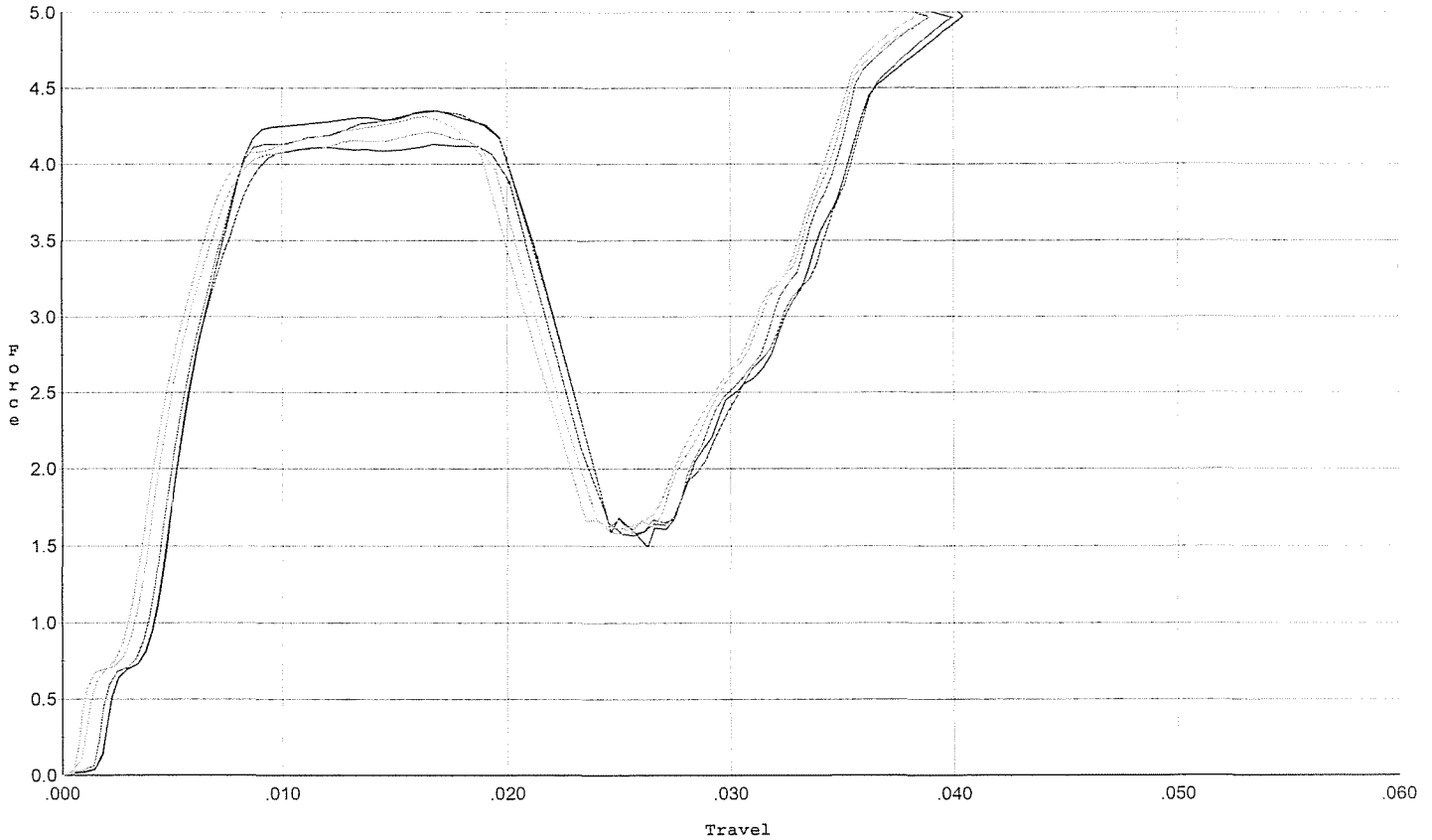
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.232	0.018	0.00	0.032	0.043		Set Trigger
2	3.228	0.019	0.00	0.031	0.043		Set Trigger
3	3.182	0.018	0.00	0.031	0.044		Set Trigger
4	3.151	0.019	0.00	0.031	0.042		Set Trigger
5	3.171	0.018	0.00	0.031	0.043		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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



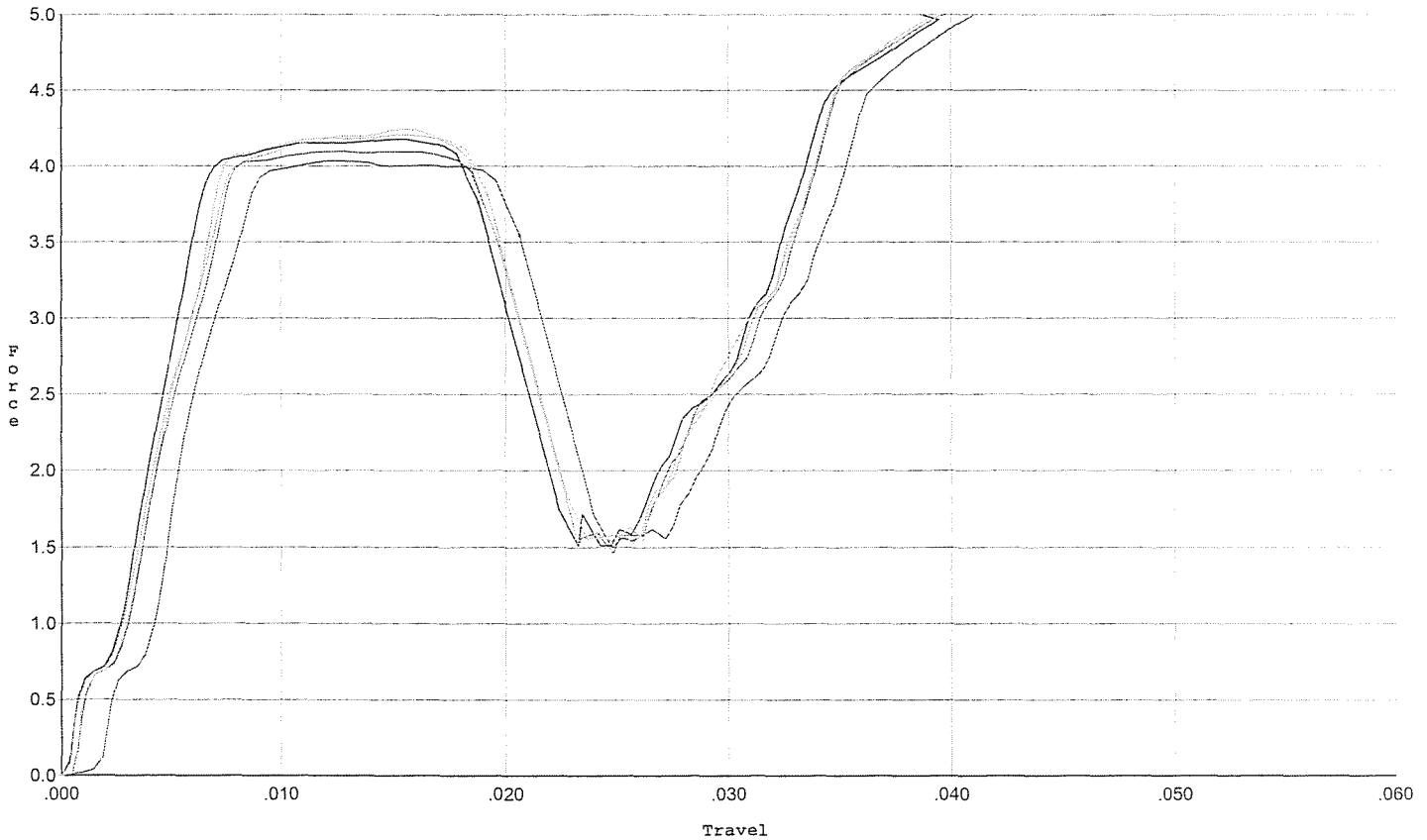
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.132	0.020	0.00	0.030	0.056		Set Trigger
2	4.352	0.021	0.00	0.029	0.062		Set Trigger
3	4.350	0.022	0.00	0.029	0.063		Set Trigger
4	4.312	0.019	0.00	0.029	0.056		Set Trigger
5	4.212	0.019	0.00	0.029	0.057		Set Trigger

A. 4.27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



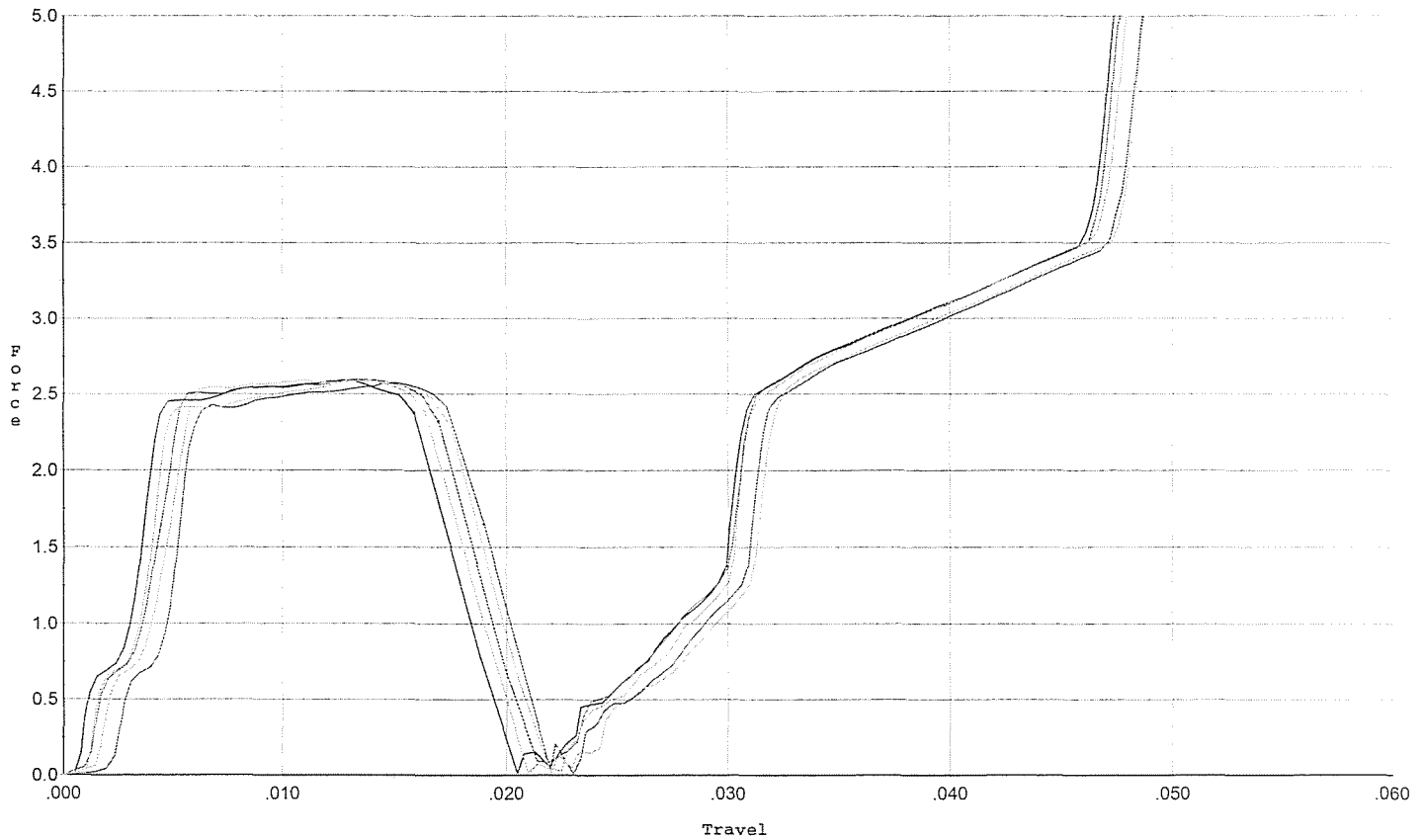
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.036	0.021	0.00	0.030	0.056		Set Trigger
2	4.177	0.019	0.00	0.029	0.056		Set Trigger
3	4.099	0.020	0.00	0.029	0.057		Set Trigger
4	4.206	0.020	0.00	0.029	0.059		Set Trigger
5	4.244	0.019	0.00	0.029	0.056		Set Trigger

A. 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/14/2009

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



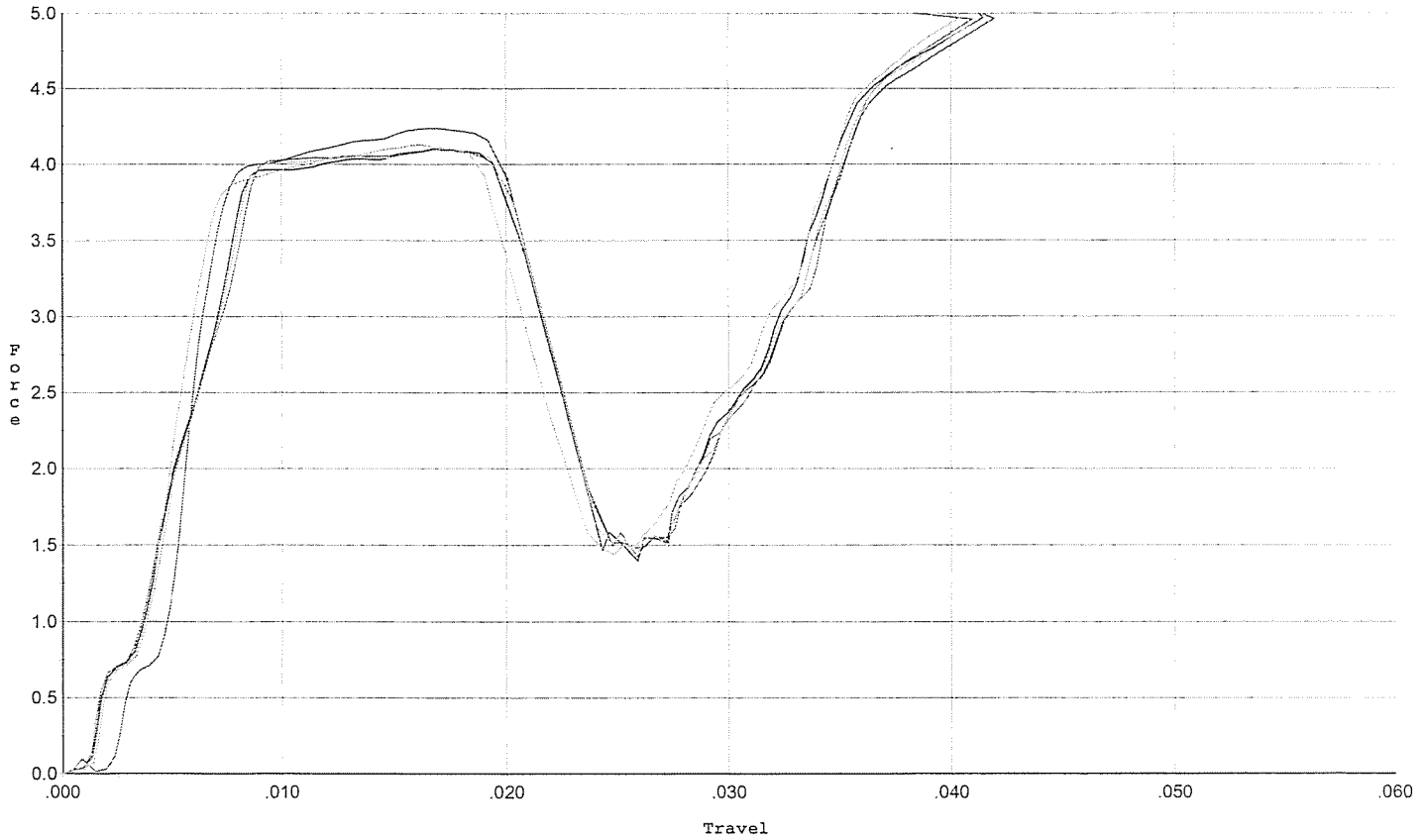
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.580	0.019	0.00	0.033	0.033		Set Trigger
2	2.591	0.016	0.00	0.033	0.031		Set Trigger
3	2.594	0.017	0.00	0.033	0.032		Set Trigger
4	2.593	0.018	0.00	0.034	0.033		Set Trigger
5	2.607	0.016	0.00	0.033	0.031		Set Trigger

A-2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/14/2009

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	4.238	0.020	0.00	0.030	0.056		Set Trigger
2	4.100	0.021	0.00	0.029	0.058		Set Trigger
3	4.103	0.020	0.00	0.030	0.057		Set Trigger
4	4.103	0.020	0.00	0.030	0.057		Set Trigger
5	4.130	0.019	0.00	0.030	0.054		Set Trigger

A - 4.13