

G 6845267

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



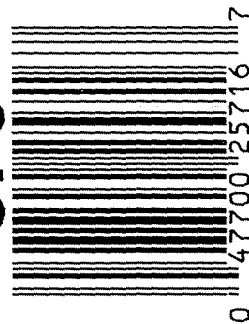
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6845267

UPC



GUN SERIAL # 66845267

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	RT
475	DRILL AND TAP SIGHT HOLES		3-19-09	SP
480	MAGNAFLUX BBL ACTION	HEAD OF 	3-20-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-28-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-28-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-28-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-1-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

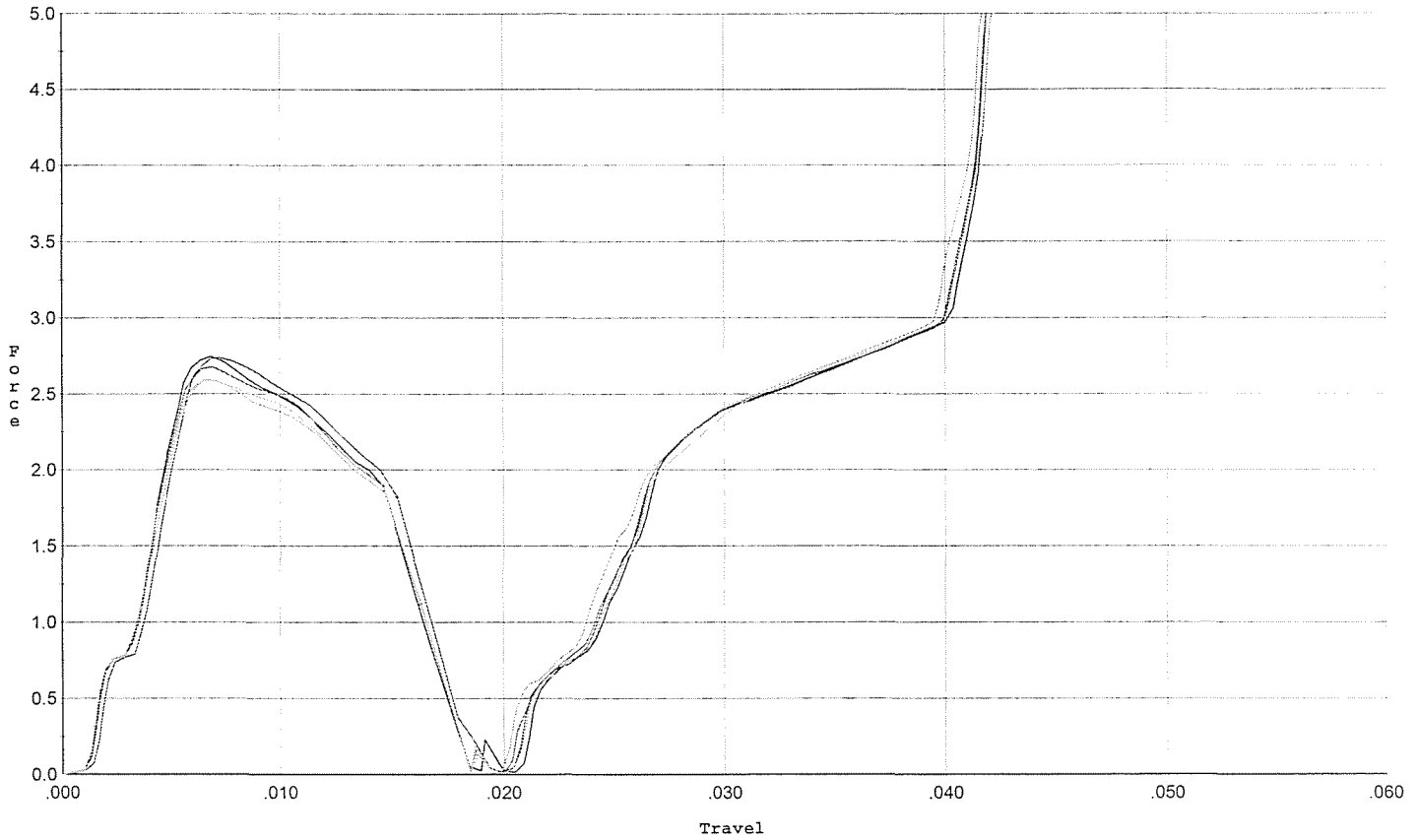
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	4-13-09	WV
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-13-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-13-09	WV
	J) ASSEMBLE STOCK			4-1-09	RPD
	K) ASSEMBLE SWIVEL STUDS			4-13-09	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	4-2-09	TC
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			4-2-09	WV
670	FINAL INSPECTION A) HEADSPACE			4-13-09	WV
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>230</u> <u>239</u> <u>240</u> <u>233</u> <u>227</u>	4-7-09	RP
	C) FUNCTION			4-13-09	WV
690	PACK			6/4/09	FM

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/31/2009

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



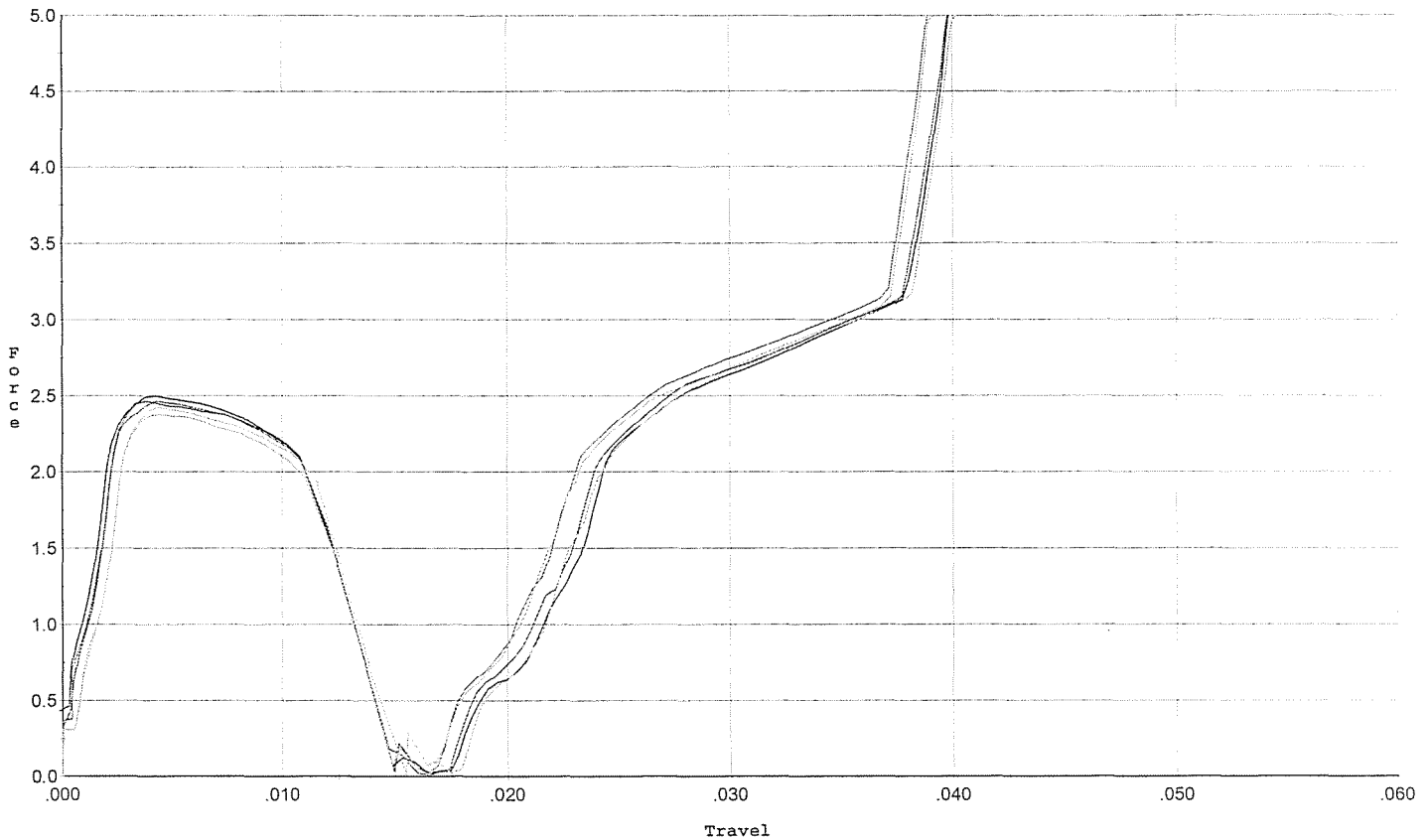
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.740	0.015	0.00	0.030	0.026		Set Trigger
2	2.747	0.015	0.00	0.031	0.025		Set Trigger
3	2.677	0.016	0.00	0.030	0.028		Set Trigger
4	2.589	0.016	0.00	0.030	0.027		Set Trigger
5	2.595	0.016	0.00	0.030	0.027		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/31/2009

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



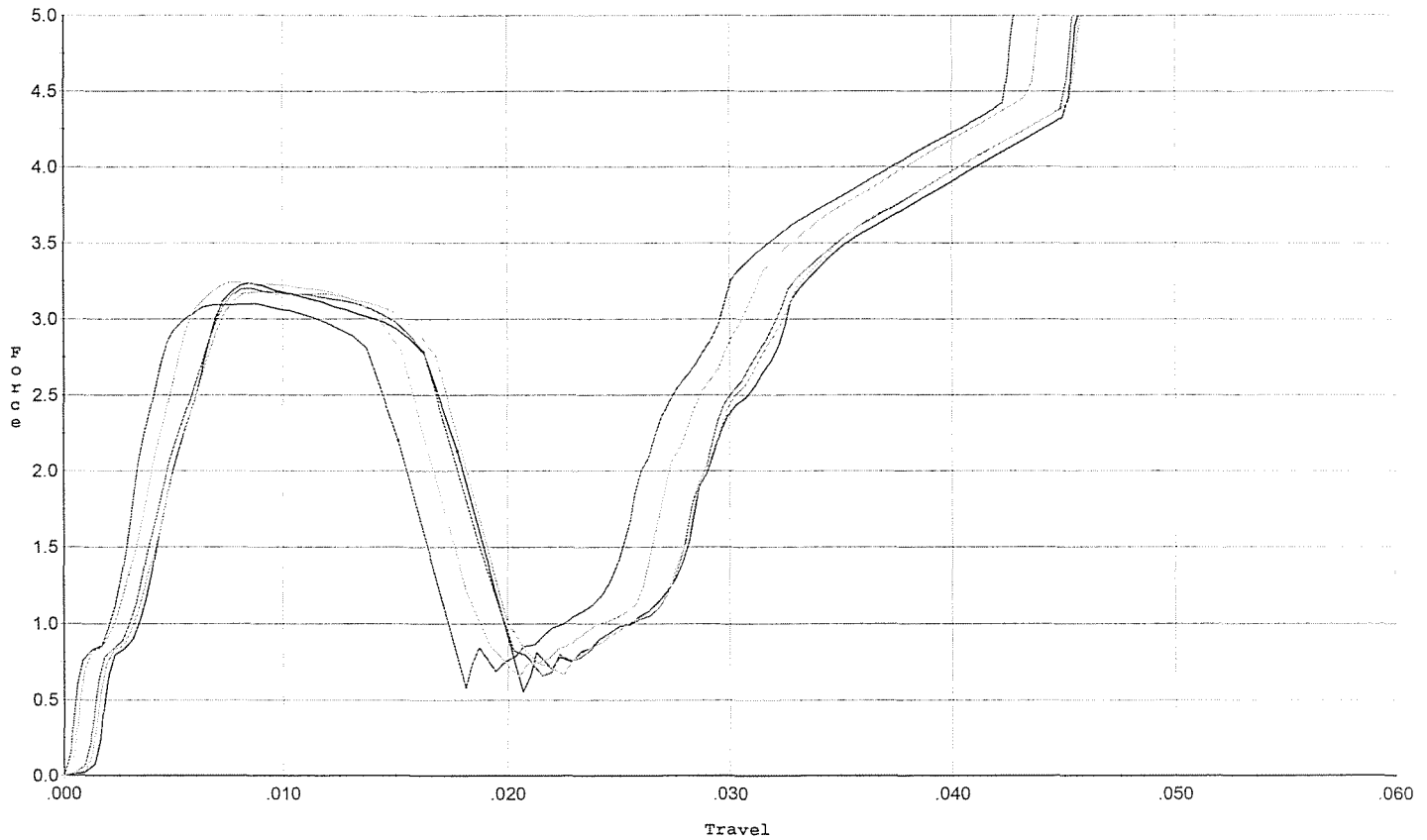
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.462	0.012	0.00	0.031	0.023		Set Trigger
2	2.498	0.012	0.00	0.031	0.023		Set Trigger
3	2.464	0.012	0.00	0.030	0.022		Set Trigger
4	2.425	0.012	0.00	0.031	0.021		Set Trigger
5	2.377	0.012	0.00	0.030	0.022		Set Trigger

A-2-44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/31/2009

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



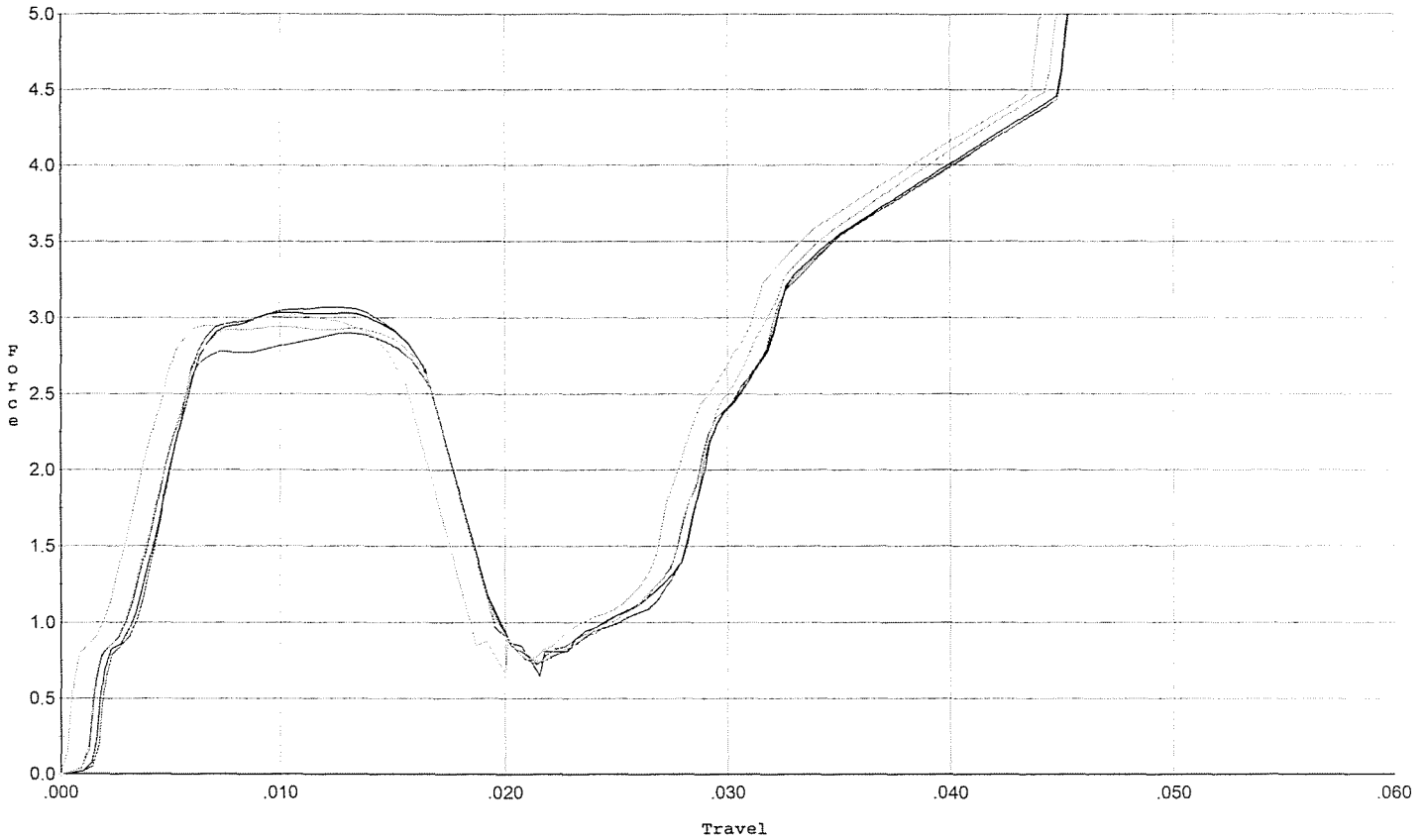
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.102	0.015	0.00	0.029	0.034		Set Trigger
2	3.238	0.018	0.00	0.031	0.038		Set Trigger
3	3.202	0.016	0.00	0.031	0.036		Set Trigger
4	3.242	0.015	0.00	0.030	0.035		Set Trigger
5	3.177	0.017	0.00	0.031	0.037		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/31/2009

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



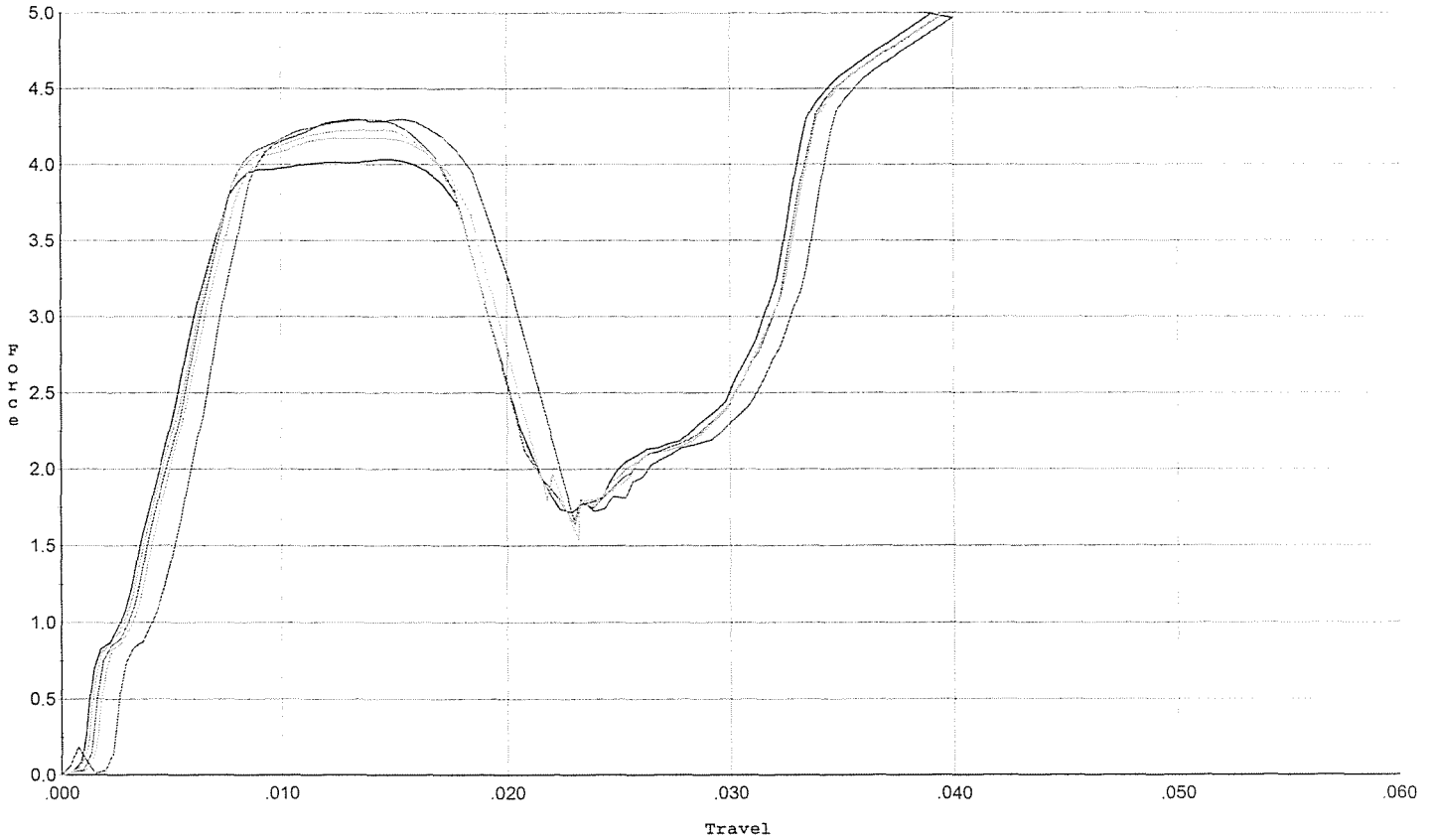
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.016	0.00	0.031	0.035		Set Trigger
2	3.032	0.016	0.00	0.031	0.035		Set Trigger
3	2.901	0.017	0.00	0.031	0.034		Set Trigger
4	3.015	0.016	0.00	0.030	0.035		Set Trigger
5	2.942	0.017	0.00	0.030	0.035		Set Trigger

A-2-99

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/31/2009

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



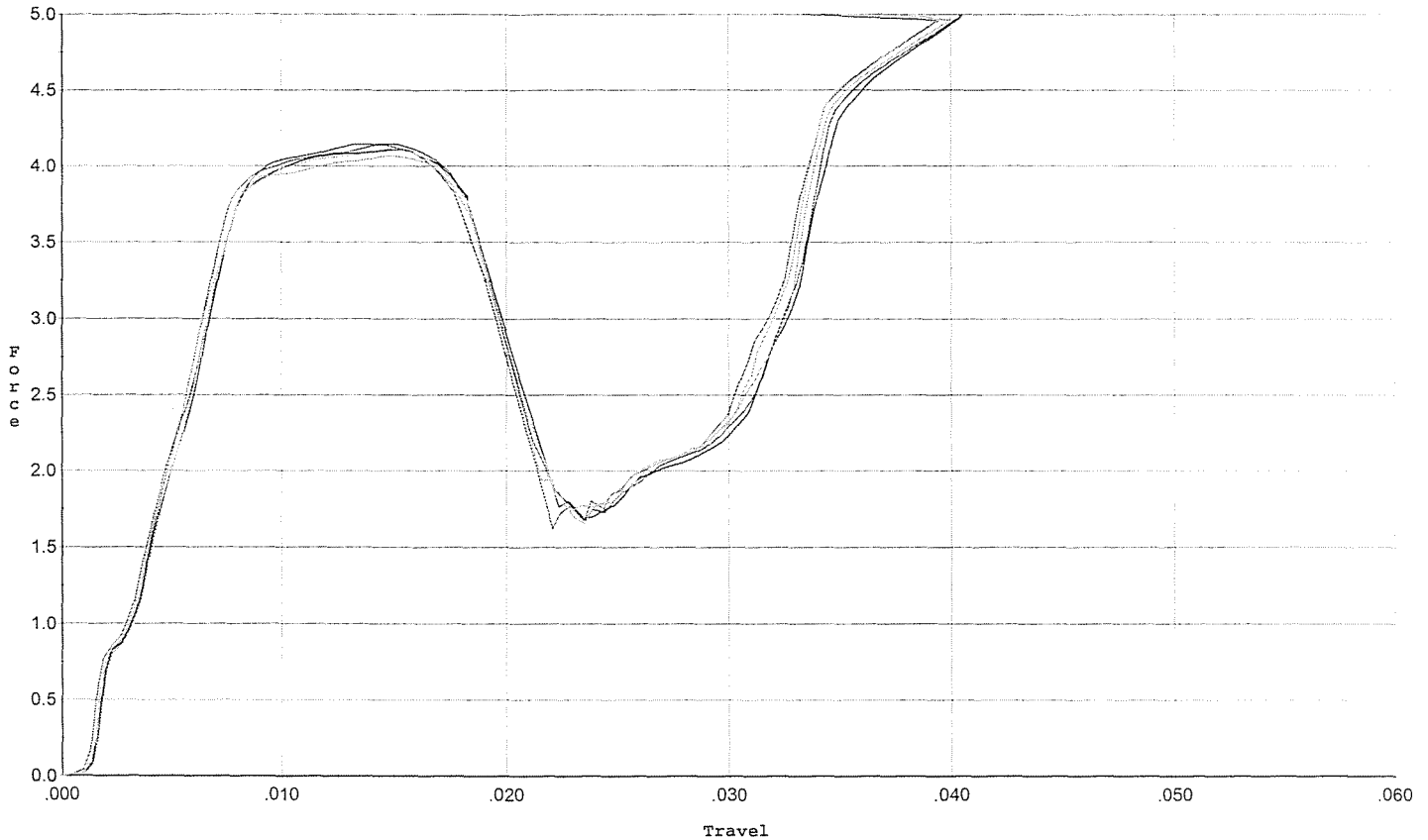
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.299	0.020	0.00	0.028	0.055		Set Trigger
2	4.034	0.018	0.00	0.028	0.050		Set Trigger
3	4.296	0.018	0.00	0.029	0.050		Set Trigger
4	4.172	0.018	0.00	0.028	0.051		Set Trigger
5	4.228	0.018	0.00	0.028	0.050		Set Trigger

A-420

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/31/2009

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



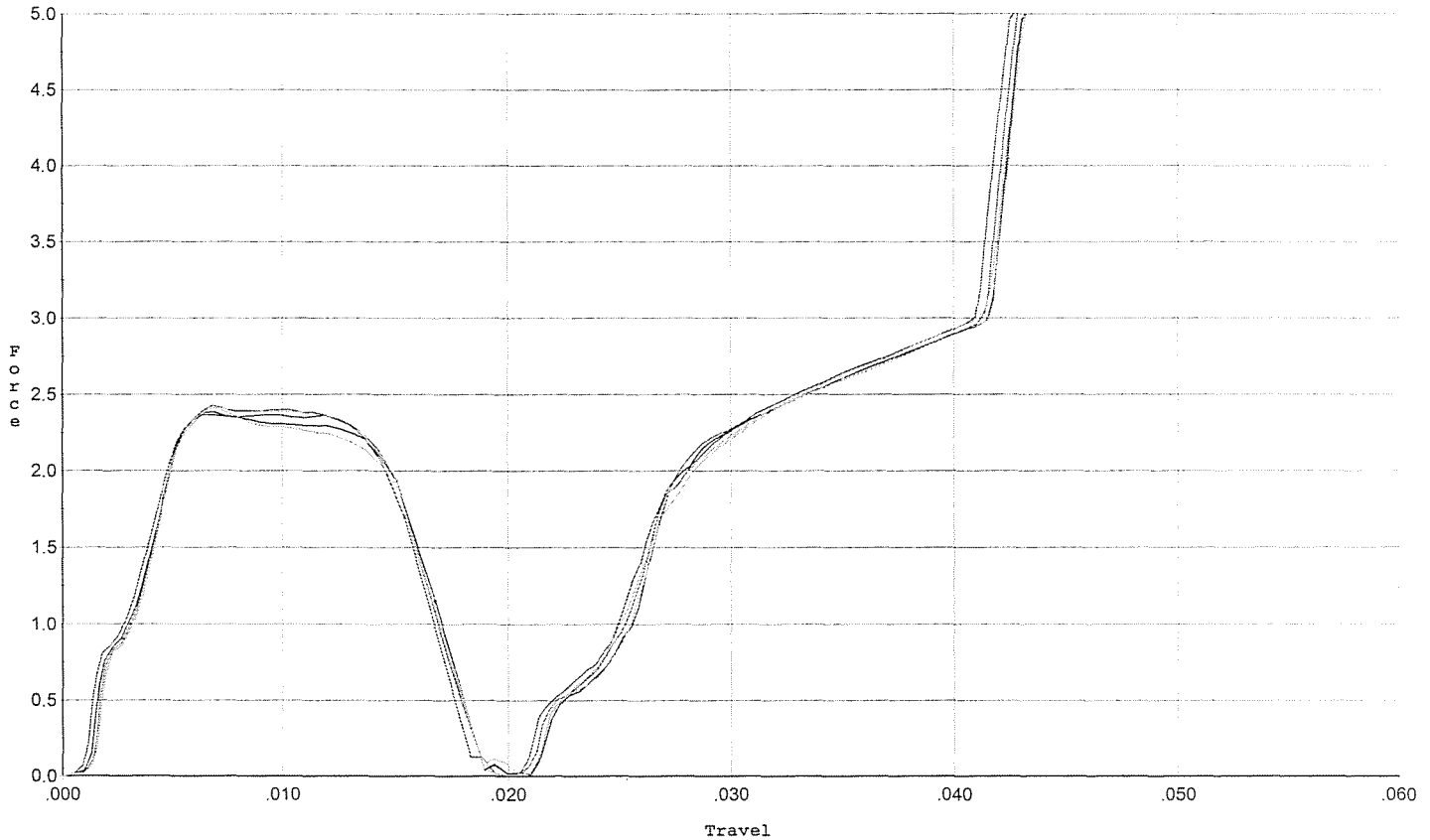
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.147	0.018	0.00	0.029	0.051		Set Trigger
2	4.109	0.018	0.00	0.029	0.050		Set Trigger
3	4.139	0.019	0.00	0.028	0.053		Set Trigger
4	4.103	0.018	0.00	0.028	0.050		Set Trigger
5	4.069	0.018	0.00	0.029	0.051		Set Trigger

A-4-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/31/2009

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



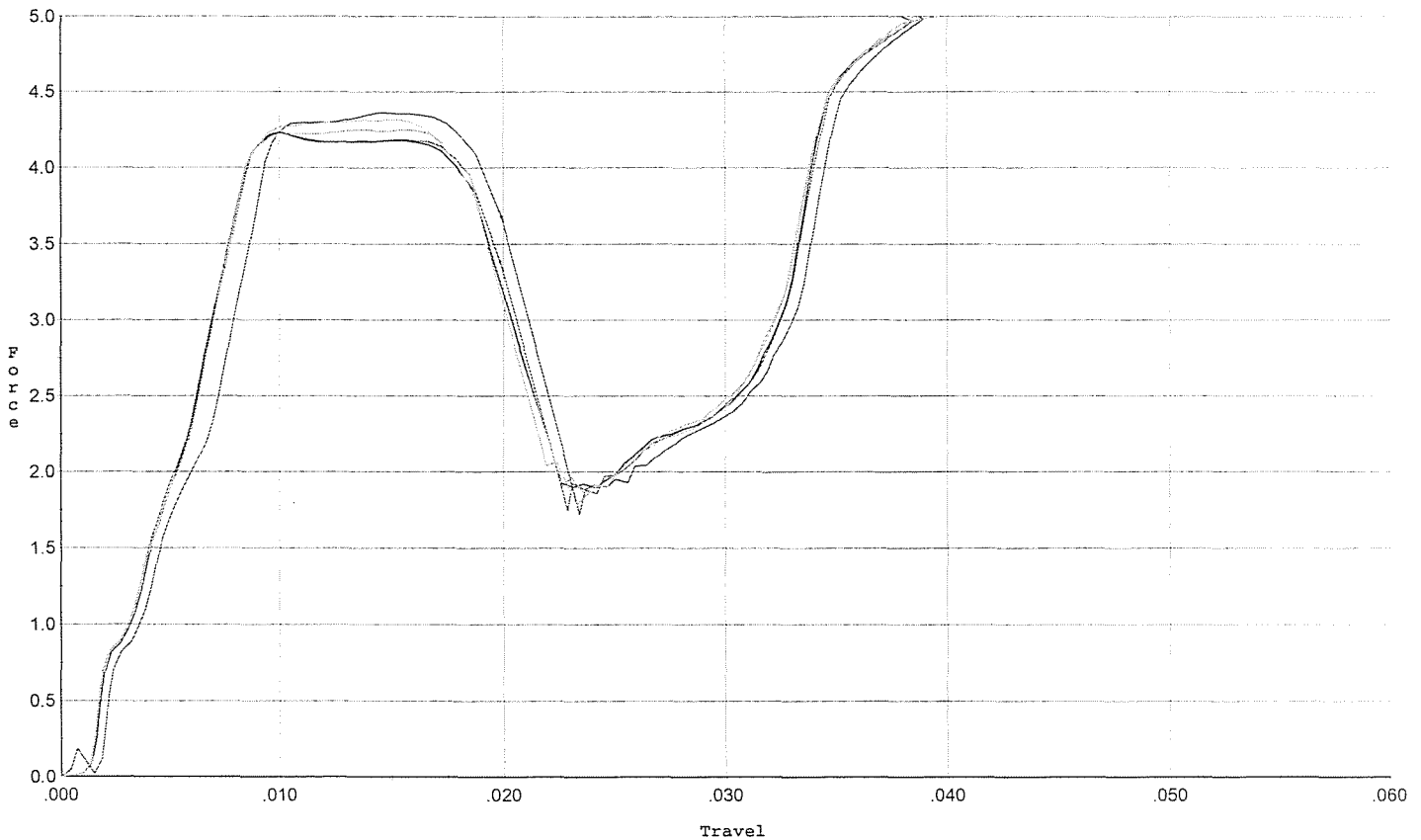
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.369	0.015	0.00	0.031	0.026		Set Trigger
2	2.385	0.017	0.00	0.031	0.028		Set Trigger
3	2.428	0.015	0.00	0.031	0.026		Set Trigger
4	2.414	0.017	0.00	0.031	0.028		Set Trigger
5	2.418	0.015	0.00	0.031	0.026		Set Trigger

A-7.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/31/2009

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	4.361	0.020	0.00	0.028	0.055		Set Trigger
2	4.231	0.019	0.00	0.028	0.052		Set Trigger
3	4.225	0.020	0.00	0.028	0.056		Set Trigger
4	4.317	0.019	0.00	0.028	0.053		Set Trigger
5	4.249	0.018	0.00	0.028	0.052		Set Trigger

A-4.27