

G6845268

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



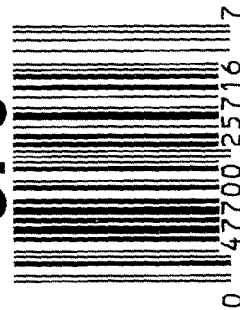
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845268

UPC



GUN SERIAL # G 6845268

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPN
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPN
460	CHECK HEADSPACE		3-17-09	SPN
470	DIS-ASSEMBLE ACTION		3-17-09	SPN
472	SERIALIZE BOLT HANDLE		3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	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		3-30-09	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	RTZ
	D) OIL FIRING PIN ASSEMBLY		3-30-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

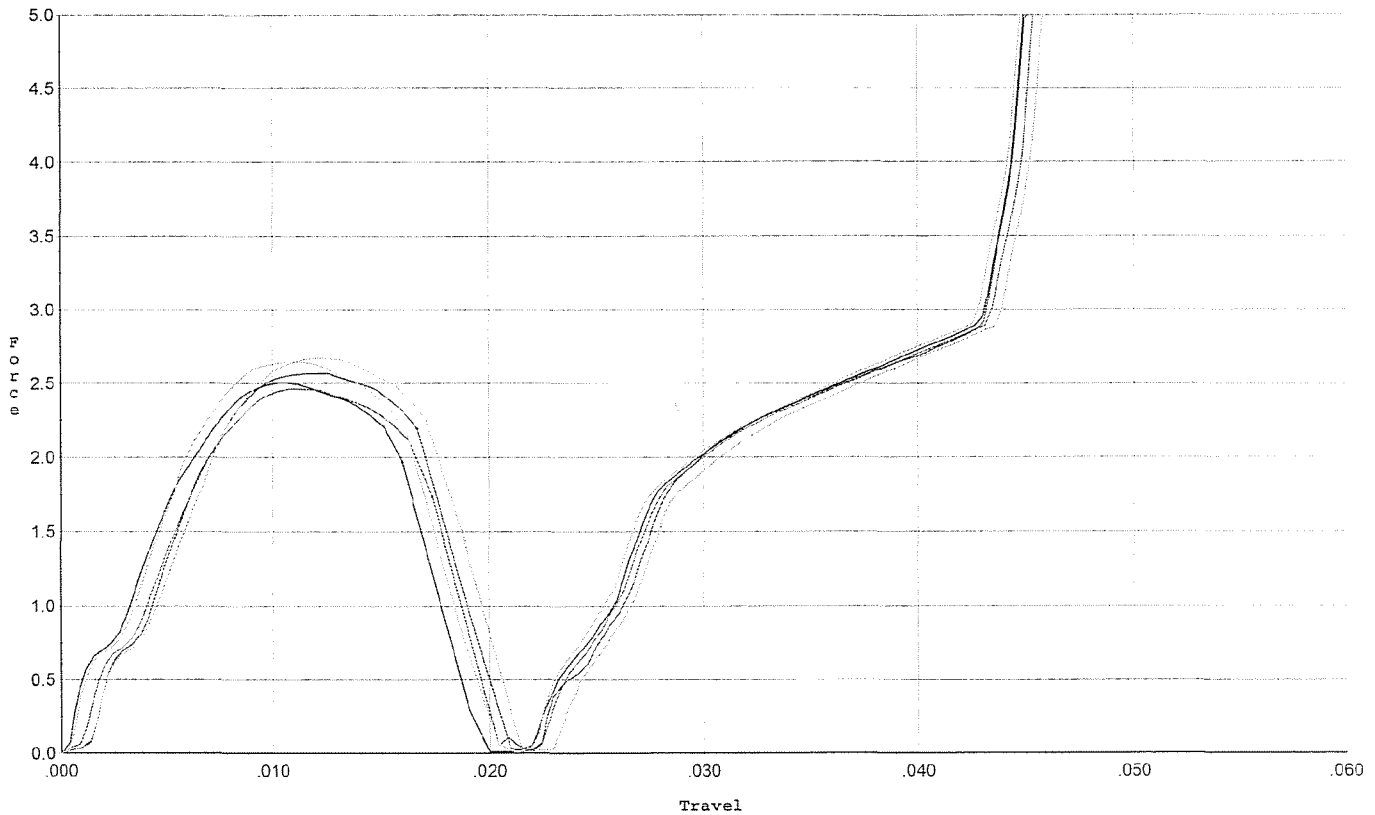
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>5.5</u> <u>5.5</u>	4-1-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-1-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-1-09	WW
	J) ASSEMBLE STOCK		3-31-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		4-1-09	WW
	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	3-31-09	L.P.P.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.66</u> <u>2.63</u> <u>2.46</u> <u>2.78</u>	4-1-09	WW
	C) FUNCTION		4-1-09	WW
690	PACK		4/9/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



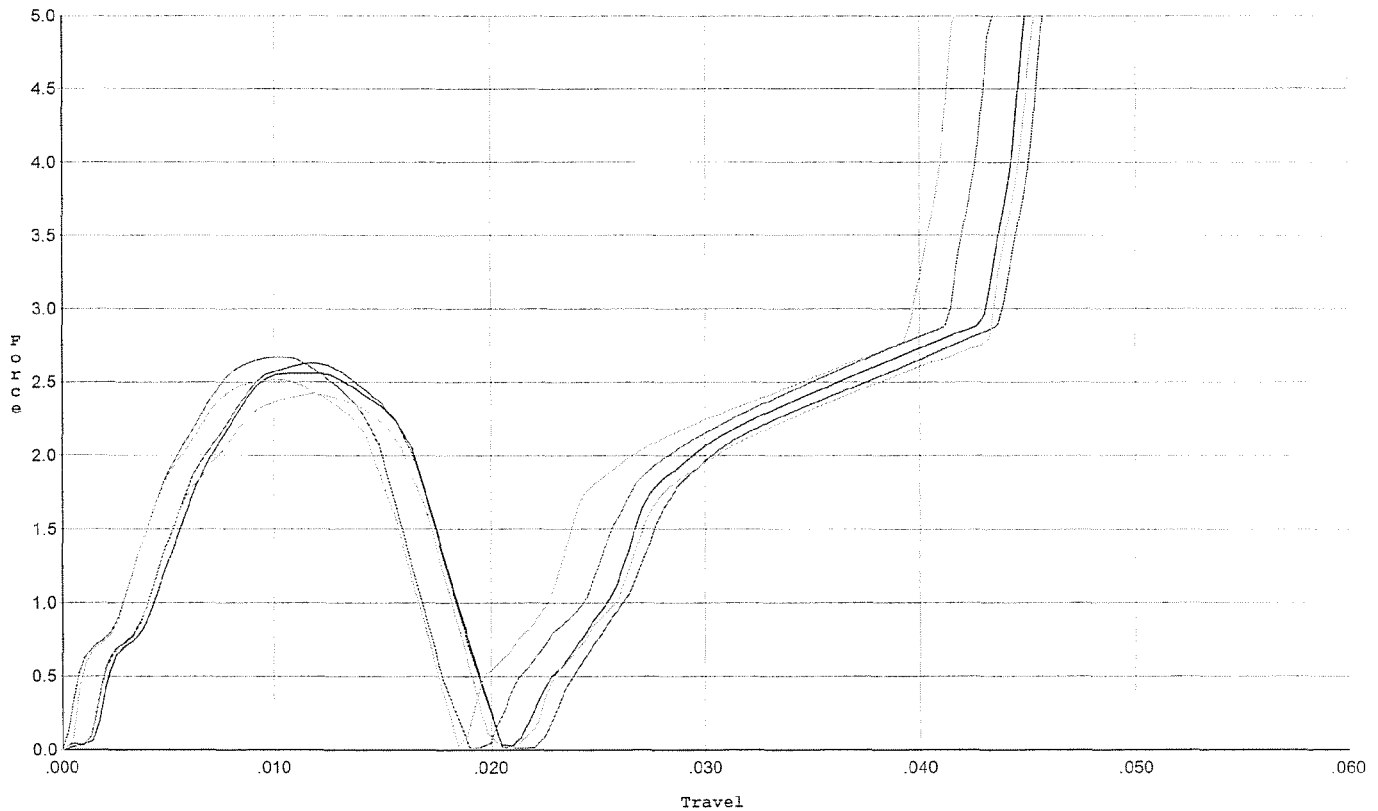
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.568	0.017	0.00	0.032	0.028		Set Trigger
2	2.502	0.016	0.00	0.033	0.028		Set Trigger
3	2.460	0.017	0.00	0.032	0.029		Set Trigger
4	2.646	0.016	0.00	0.032	0.029		Set Trigger
5	2.671	0.019	0.00	0.032	0.032		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



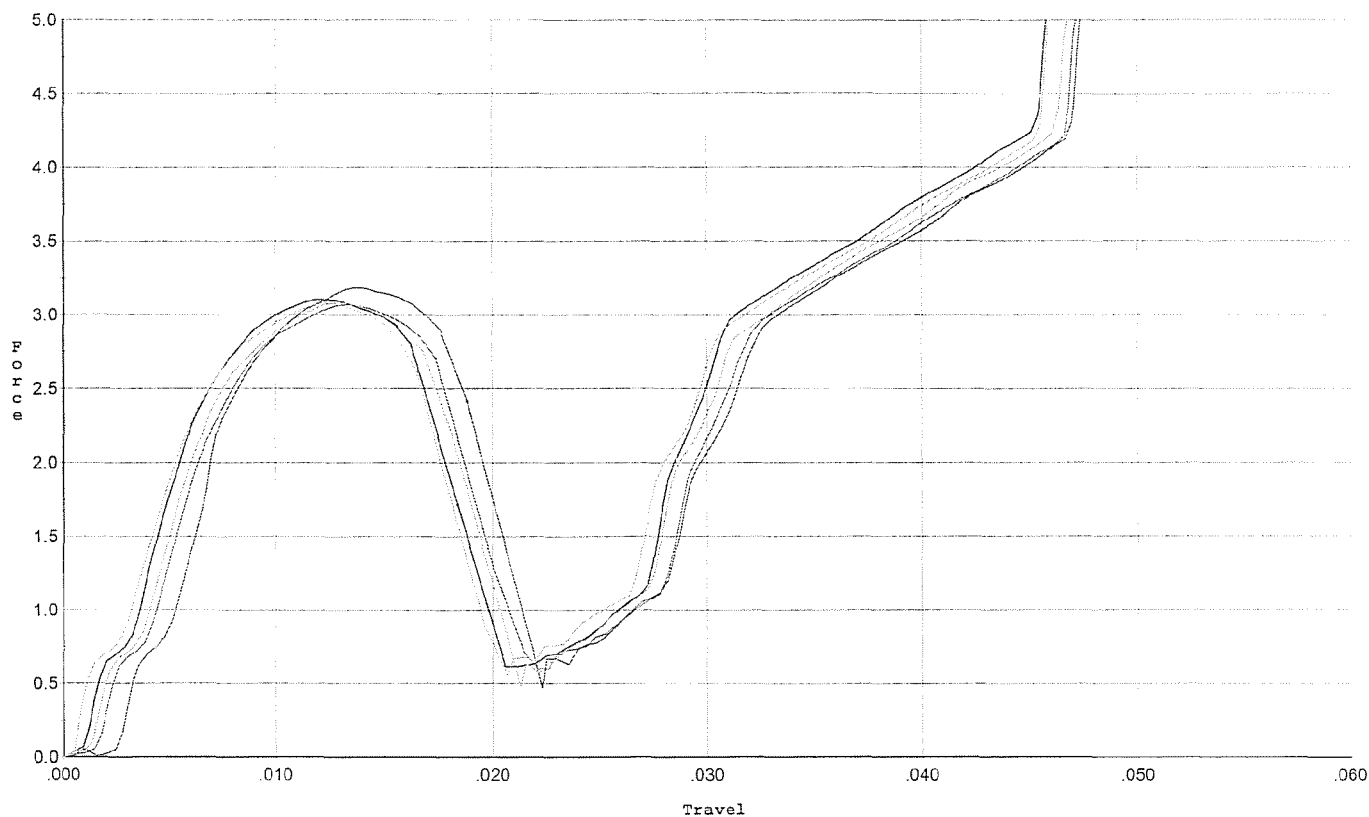
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.627	0.016	0.00	0.033	0.028		Set Trigger
2	2.558	0.016	0.00	0.032	0.027		Set Trigger
3	2.670	0.015	0.00	0.032	0.027		Set Trigger
4	2.423	0.017	0.00	0.032	0.027		Set Trigger
5	2.518	0.016	0.00	0.030	0.027		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



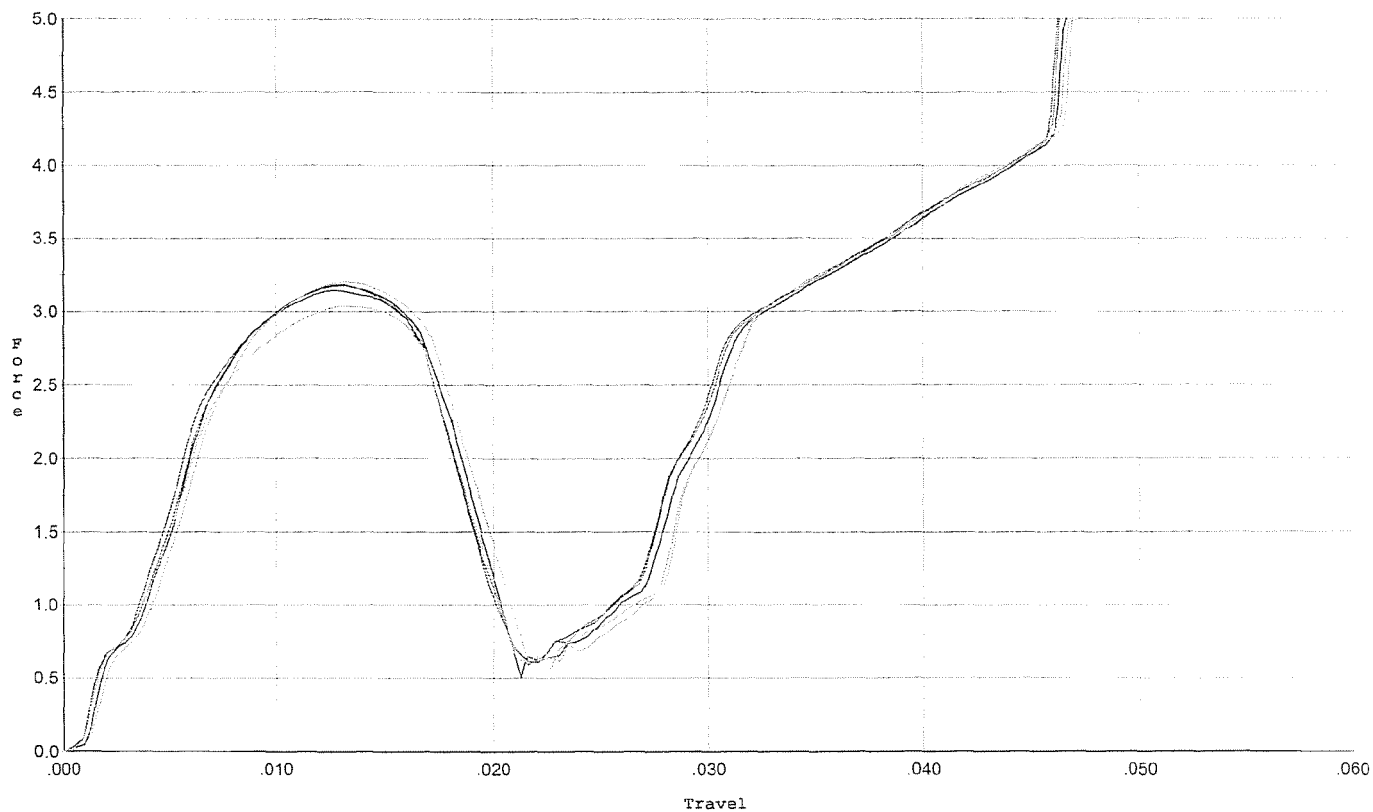
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.185	0.019	0.00	0.031	0.036		Set Trigger
2	3.104	0.018	0.00	0.030	0.038		Set Trigger
3	3.069	0.017	0.00	0.031	0.034		Set Trigger
4	3.079	0.017	0.00	0.031	0.034		Set Trigger
5	3.082	0.018	0.00	0.031	0.036		Set Trigger

A-3-10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



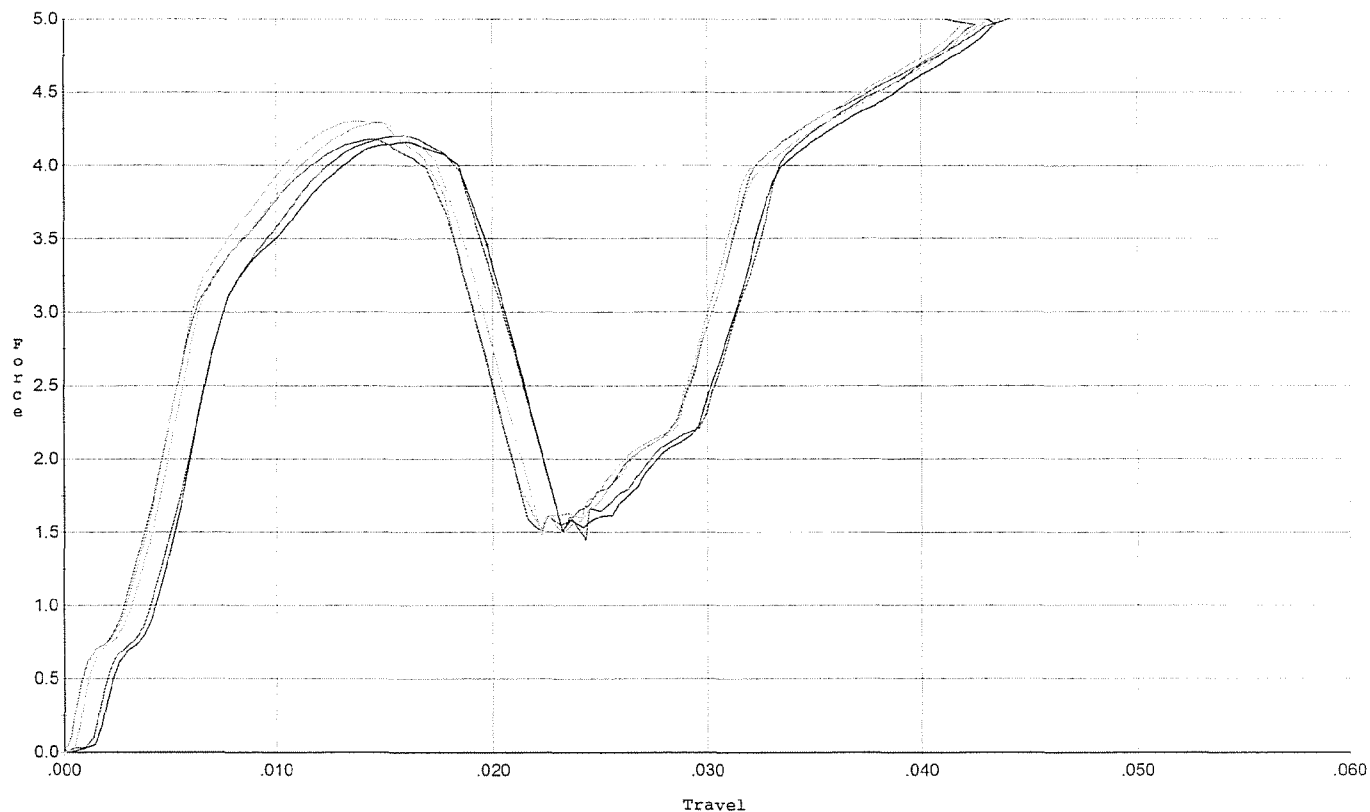
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.147	0.017	0.00	0.031	0.035		Set Trigger
2	3.180	0.018	0.00	0.031	0.037		Set Trigger
3	3.187	0.017	0.00	0.031	0.035		Set Trigger
4	3.036	0.017	0.00	0.031	0.034		Set Trigger
5	3.205	0.019	0.00	0.031	0.039		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



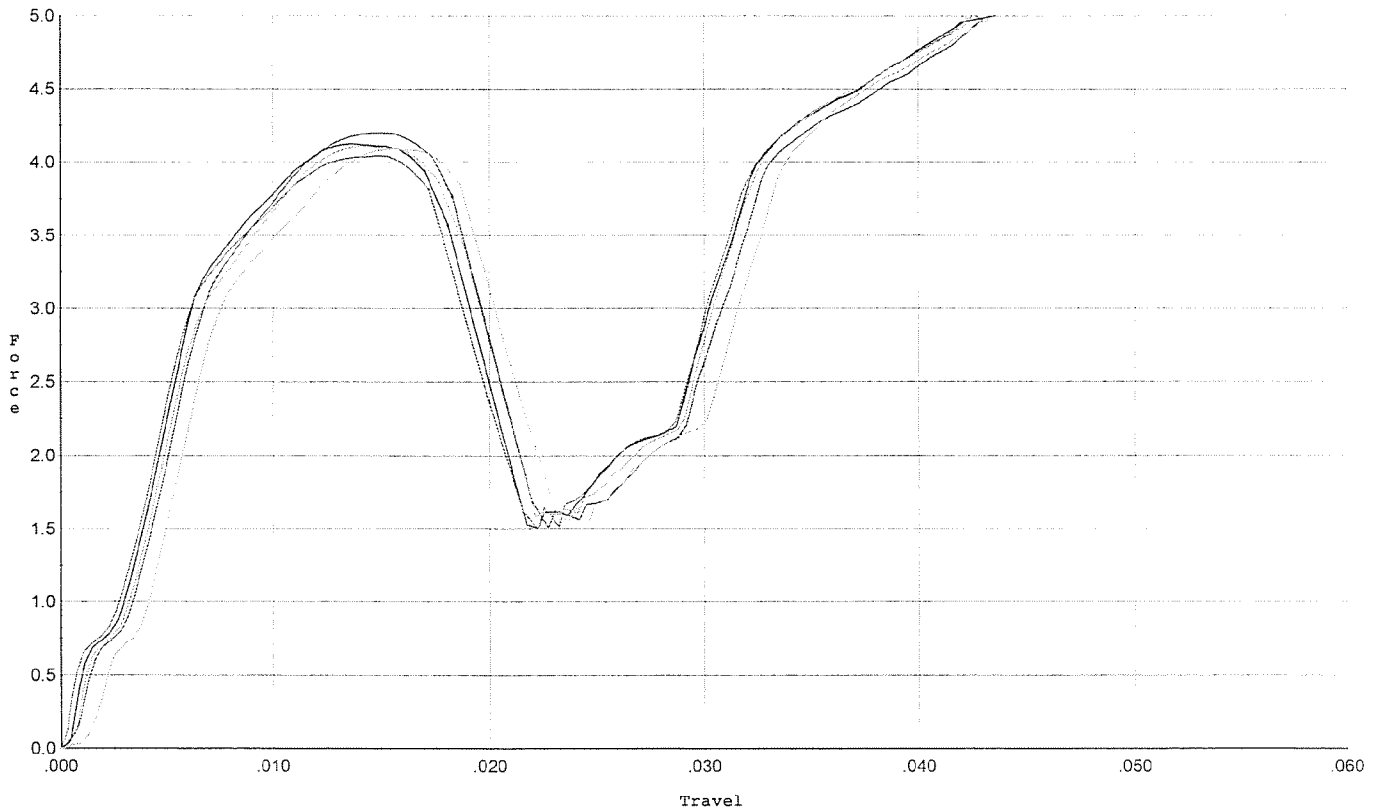
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.204	0.020	0.00	0.029	0.053		Set Trigger
2	4.163	0.020	0.00	0.029	0.051		Set Trigger
3	4.182	0.018	0.00	0.029	0.049		Set Trigger
4	4.293	0.019	0.00	0.029	0.052		Set Trigger
5	4.303	0.018	0.00	0.029	0.050		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



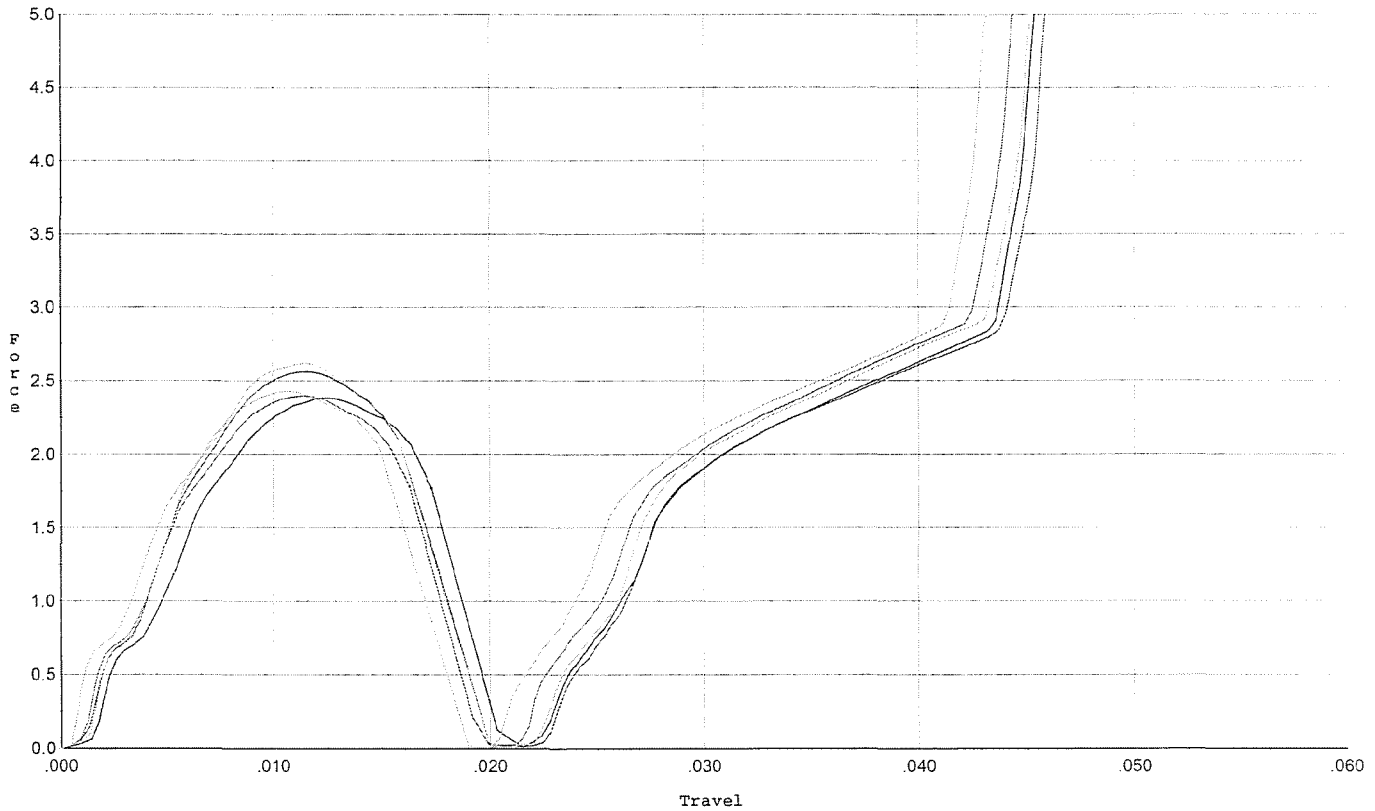
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.200	0.018	0.00	0.029	0.049		Set Trigger
2	4.125	0.018	0.00	0.029	0.049		Set Trigger
3	4.045	0.017	0.00	0.029	0.046		Set Trigger
4	4.088	0.019	0.00	0.029	0.048		Set Trigger
5	4.111	0.019	0.00	0.029	0.050		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



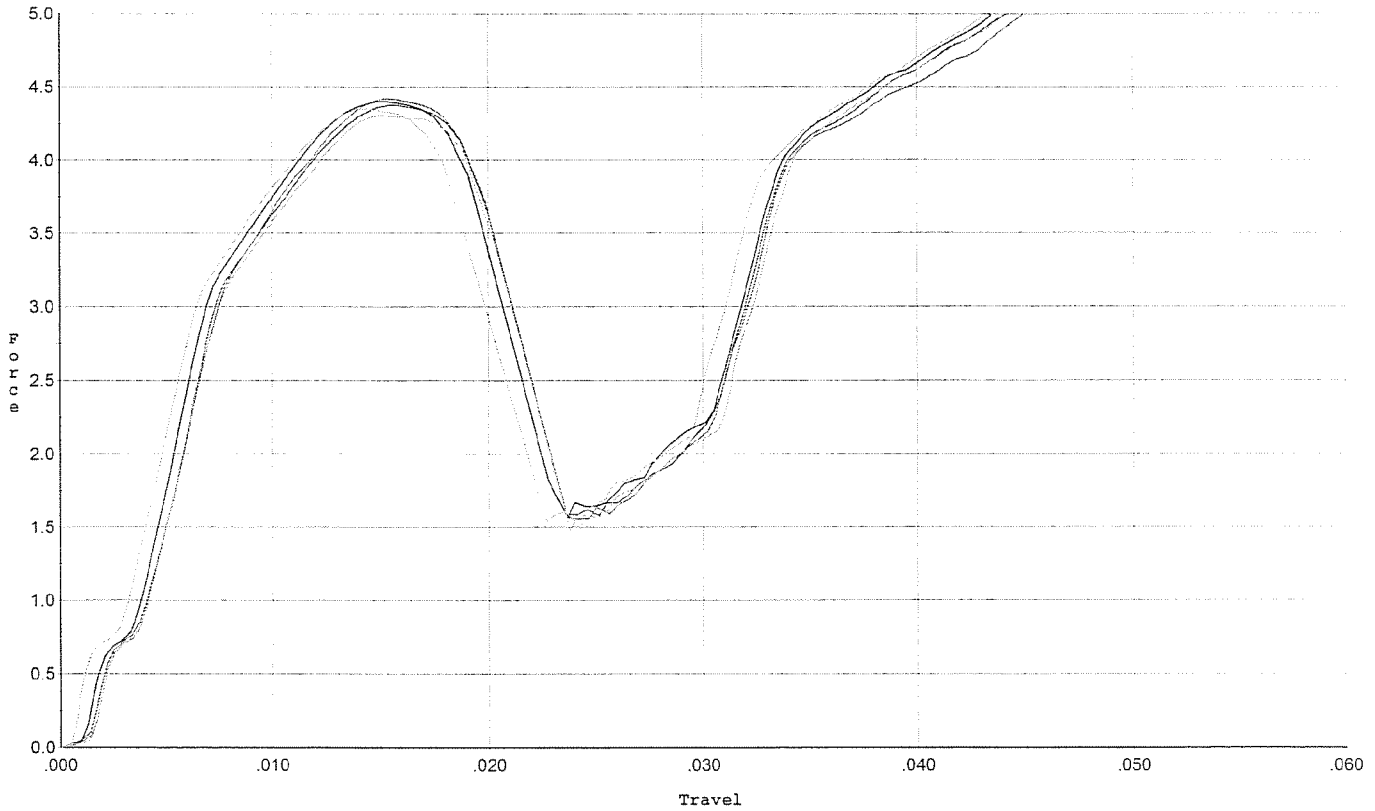
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.562	0.018	0.00	0.033	0.029		Set Trigger
2	2.383	0.017	0.00	0.032	0.026		Set Trigger
3	2.399	0.016	0.00	0.032	0.026		Set Trigger
4	2.620	0.016	0.00	0.033	0.027		Set Trigger
5	2.429	0.017	0.00	0.031	0.028		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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	4.374	0.020	0.00	0.029	0.054		Set Trigger
2	4.402	0.019	0.00	0.028	0.053		Set Trigger
3	4.422	0.020	0.00	0.029	0.054		Set Trigger
4	4.352	0.020	0.00	0.029	0.056		Set Trigger
5	4.304	0.020	0.00	0.029	0.054		Set Trigger

A-4.37