

G6845269

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



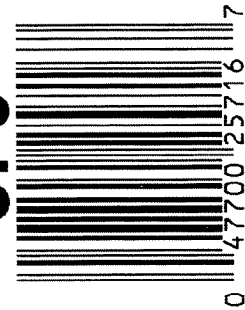
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845269

UPC



GUN SERIAL # 66845269

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	RC
475	DRILL AND TAP SIGHT HOLES		3-17-09	SP
480	MAGNAFLUX BBL ACTION		3-20-09	AD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-25	
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		4-9-09	RAL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

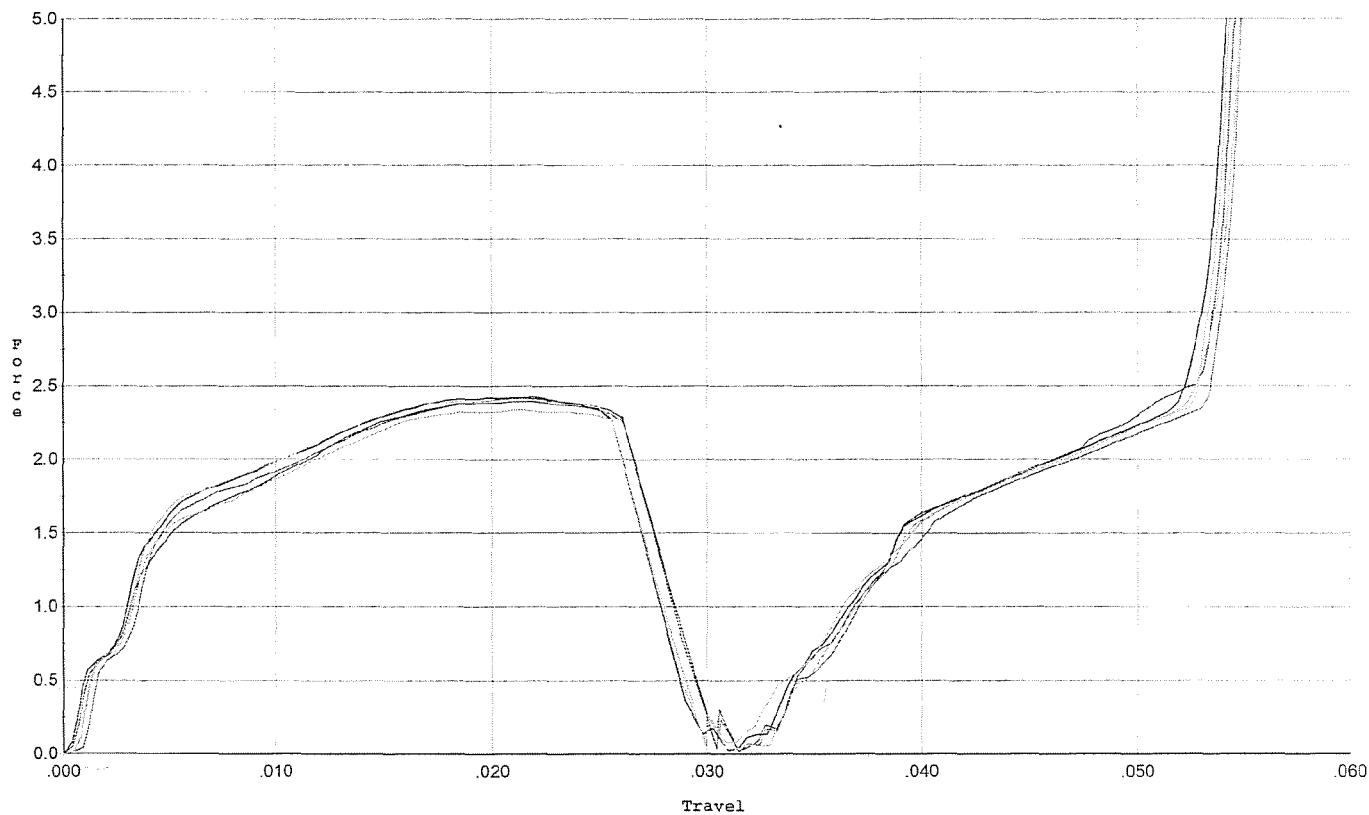
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>6.5</u> <u>7</u>	4-17-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-17-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-17-09	WW
	J) ASSEMBLE STOCK		4-9-09	RJ
	K) ASSEMBLE SWIVEL STUDS		4-17-09	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	4-14-09	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-14-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-17-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>277</u> <u>278</u> <u>278</u> <u>289</u> <u>292</u>	4-16-09	RP
	C) FUNCTION		4-17-09	WW
690	PACK		4/1/09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



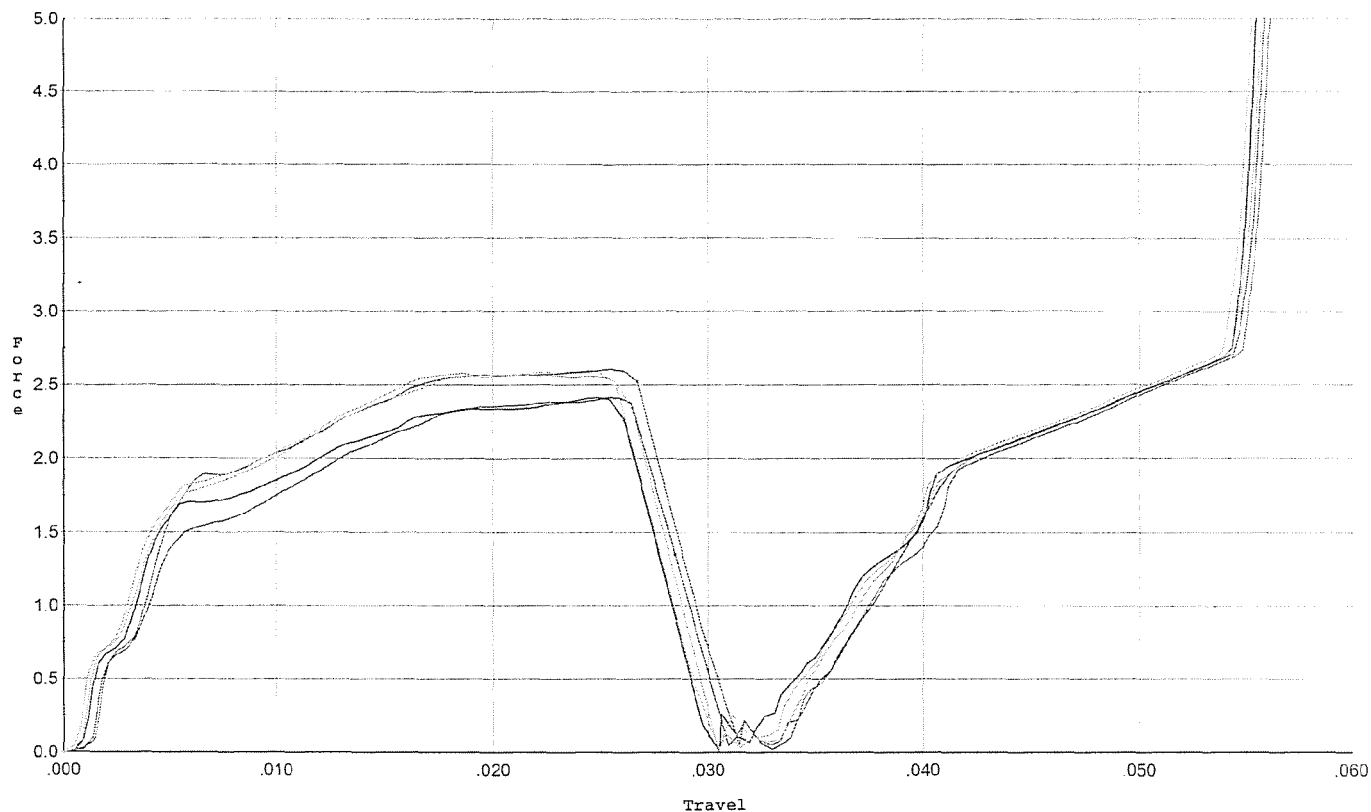
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.026	0.00	0.034	0.047		Set Trigger
2	2.423	0.026	0.00	0.034	0.047		Set Trigger
3	2.395	0.026	0.00	0.034	0.047		Set Trigger
4	2.339	0.026	0.00	0.034	0.045		Set Trigger
5	2.408	0.026	0.00	0.035	0.047		Set Trigger

A-2.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



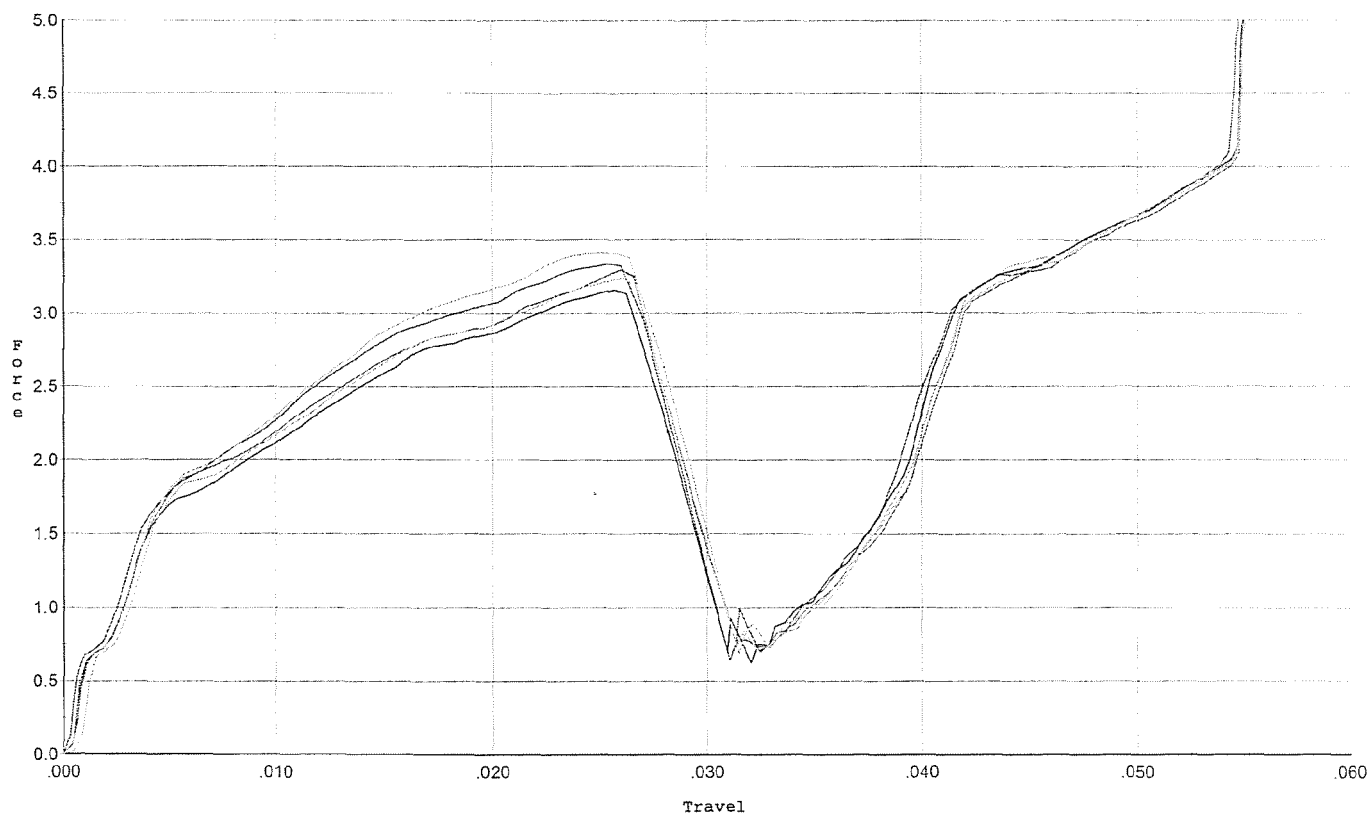
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.412	0.028	0.00	0.035	0.049		Set Trigger
2	2.413	0.026	0.00	0.035	0.047		Set Trigger
3	2.604	0.027	0.00	0.035	0.051		Set Trigger
4	2.599	0.026	0.00	0.035	0.050		Set Trigger
5	2.565	0.026	0.00	0.035	0.051		Set Trigger

A-2.51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



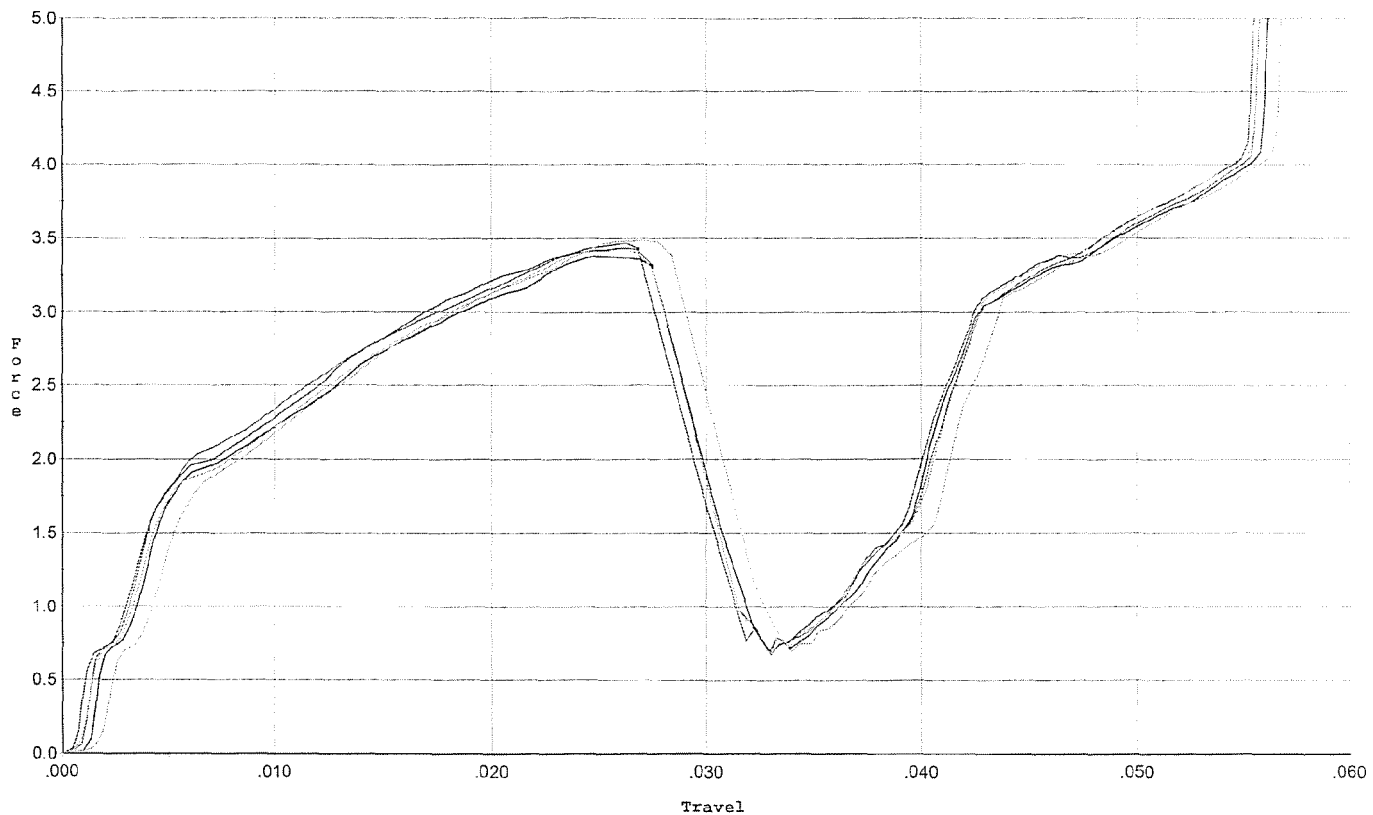
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.336	0.027	0.00	0.031	0.062		Set Trigger
2	3.159	0.028	0.00	0.032	0.061		Set Trigger
3	3.296	0.027	0.00	0.032	0.059		Set Trigger
4	3.238	0.027	0.00	0.032	0.059		Set Trigger
5	3.411	0.028	0.00	0.032	0.066		Set Trigger

A 3.28

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



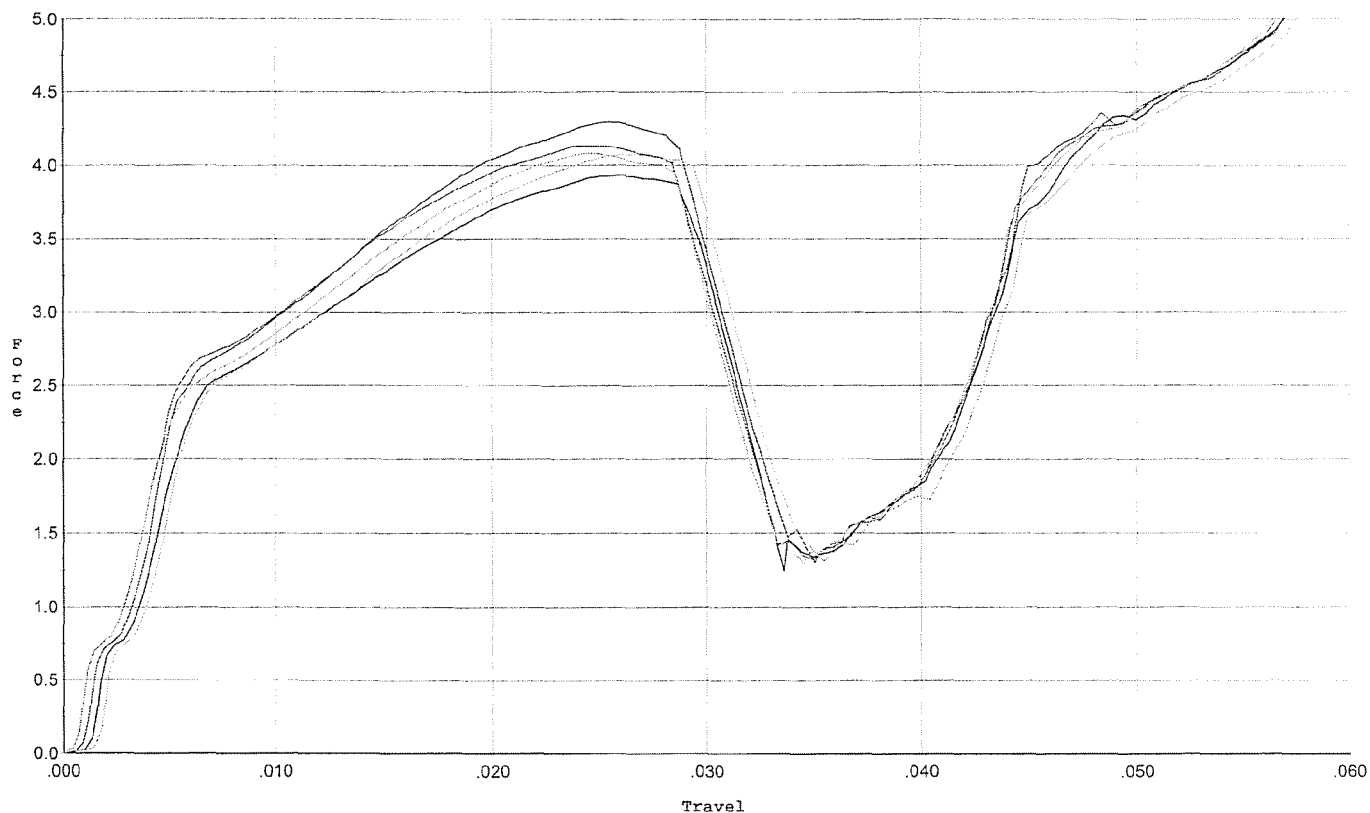
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.468	0.027	0.00	0.032	0.063		Set Trigger
2	3.382	0.027	0.00	0.032	0.063		Set Trigger
3	3.433	0.027	0.00	0.032	0.065		Set Trigger
4	3.421	0.028	0.00	0.032	0.064		Set Trigger
5	3.485	0.028	0.00	0.028	0.065		Set Trigger

A-3.43

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



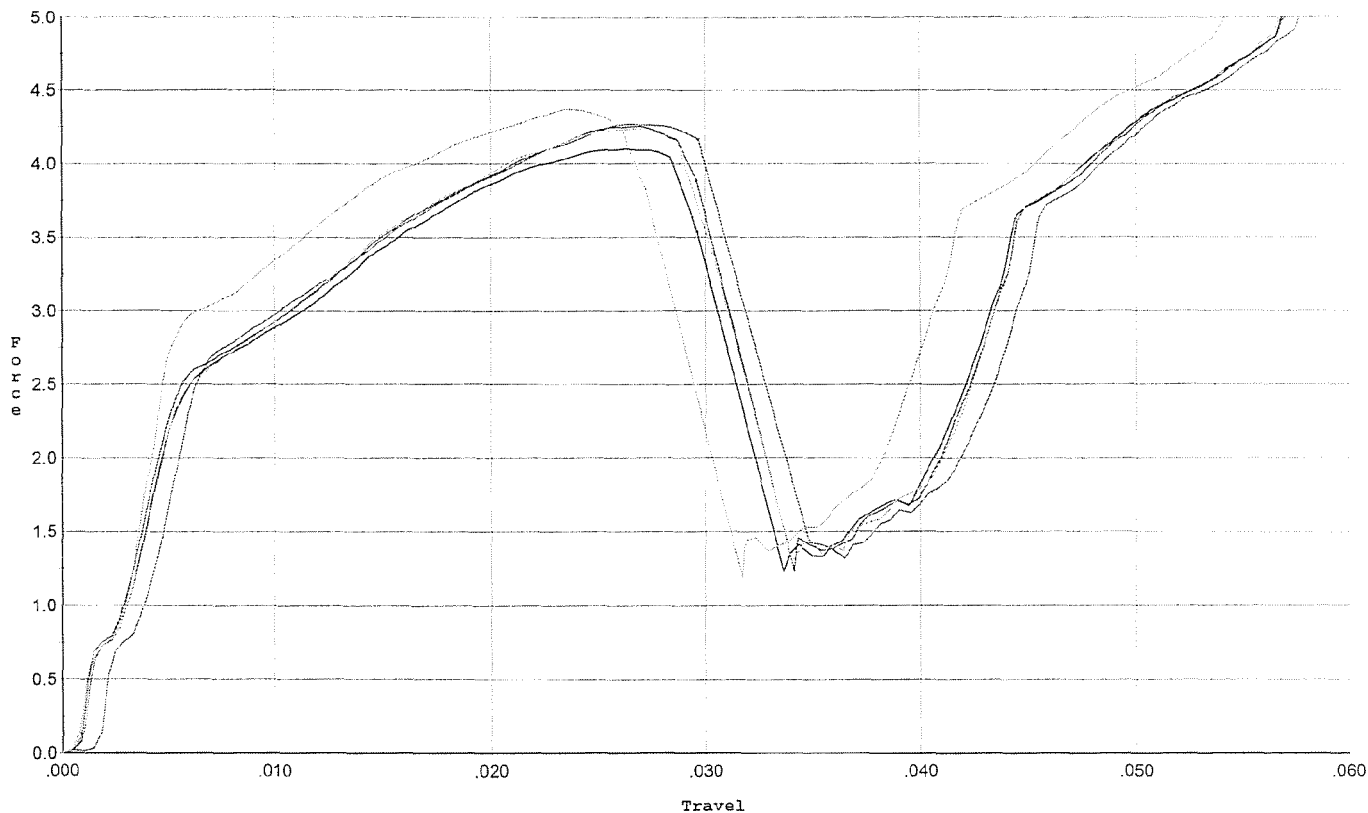
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.296	0.029	0.00	0.025	0.085		Set Trigger
2	3.933	0.030	0.00	0.026	0.081		Set Trigger
3	4.133	0.028	0.00	0.025	0.083		Set Trigger
4	4.074	0.029	0.00	0.025	0.082		Set Trigger
5	4.082	0.028	0.00	0.025	0.082		Set Trigger

A-4-10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



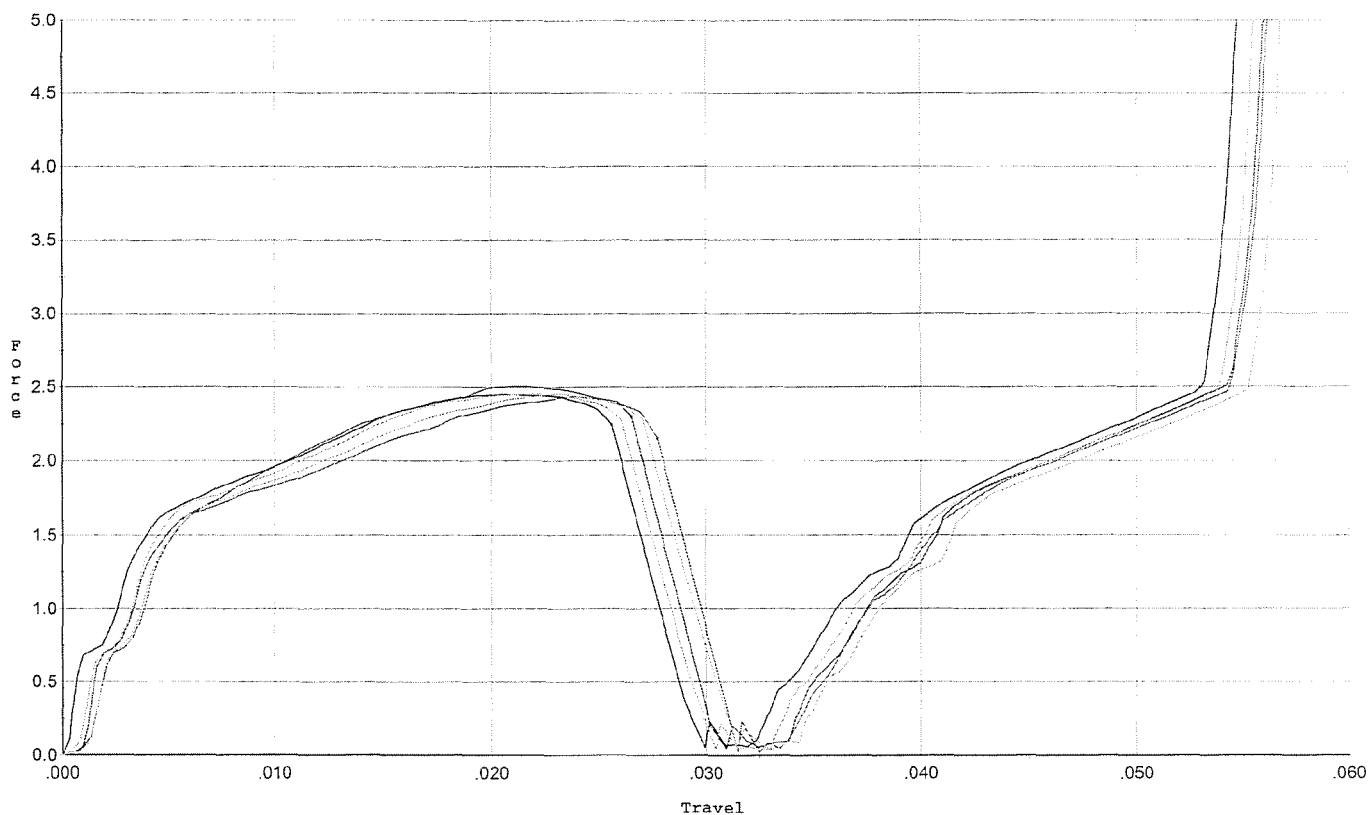
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.253	0.030	0.00	0.025	0.088		Set Trigger
2	4.100	0.030	0.00	0.025	0.085		Set Trigger
3	4.269	0.030	0.00	0.025	0.087		Set Trigger
4	4.237	0.030	0.00	0.025	0.089		Set Trigger
5	4.372	0.027	0.00	0.024	0.084		Set Trigger

A. 4.24

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



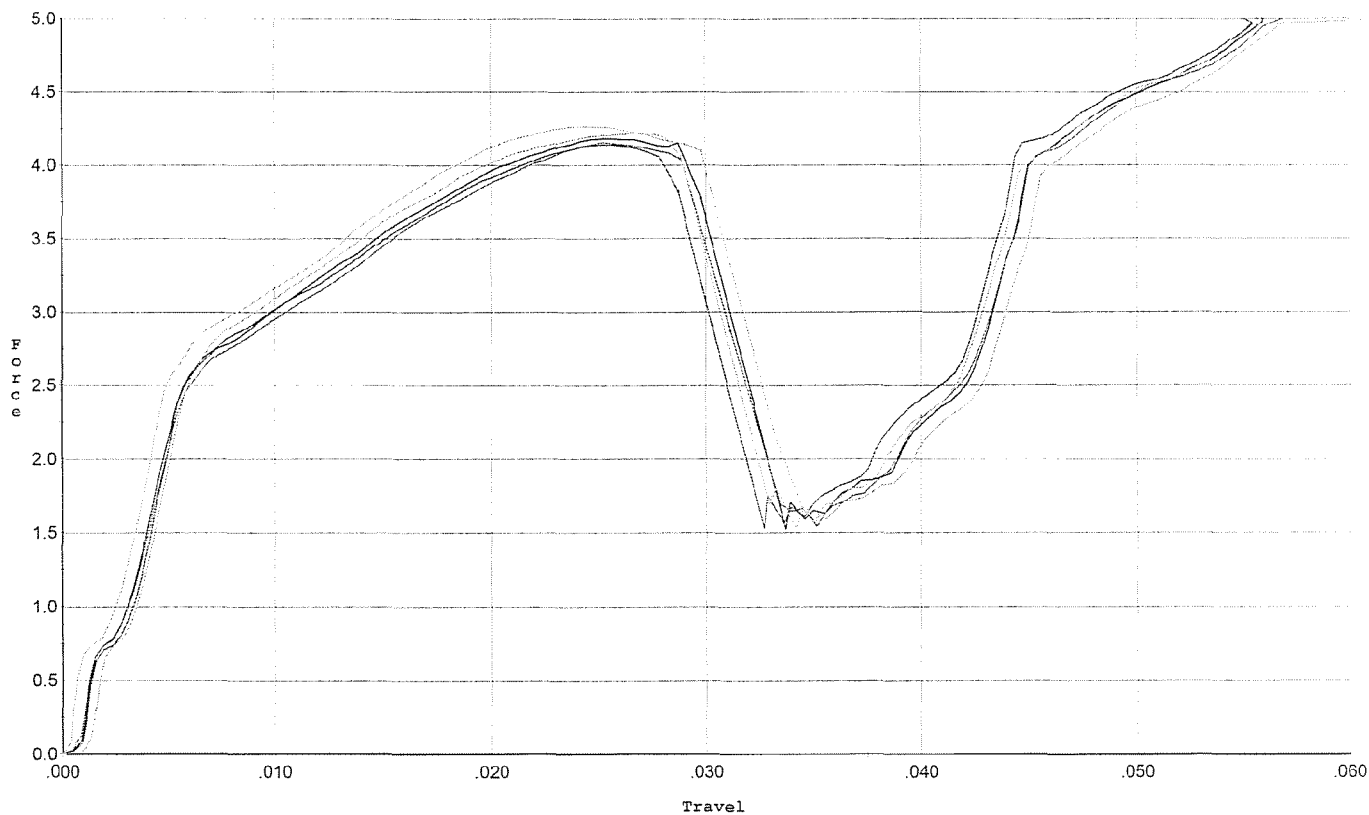
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.026	0.00	0.035	0.049		Set Trigger
2	2.446	0.026	0.00	0.035	0.048		Set Trigger
3	2.434	0.028	0.00	0.035	0.049		Set Trigger
4	2.453	0.027	0.00	0.035	0.049		Set Trigger
5	2.455	0.026	0.00	0.035	0.048		Set Trigger

17-2-45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs ini +/- 1.0 for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.139	0.029	0.00	0.025	0.083		Set Trigger
2	4.181	0.030	0.00	0.025	0.088		Set Trigger
3	4.156	0.031	0.00	0.025	0.090		Set Trigger
4	4.269	0.029	0.00	0.025	0.089		Set Trigger
5	4.221	0.030	0.00	0.025	0.089		Set Trigger

A-4.19