

G6845278

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



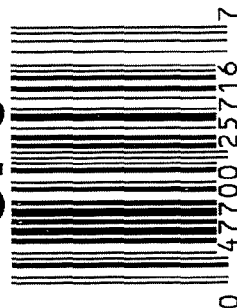
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845278

UPC



BM FORM

GUN SERIAL # G6845278

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
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	B4
542	APPLY COATINGS (BARREL ACTION)		3-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TK
	D) OIL FIRING PIN ASSEMBLY		3-31-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

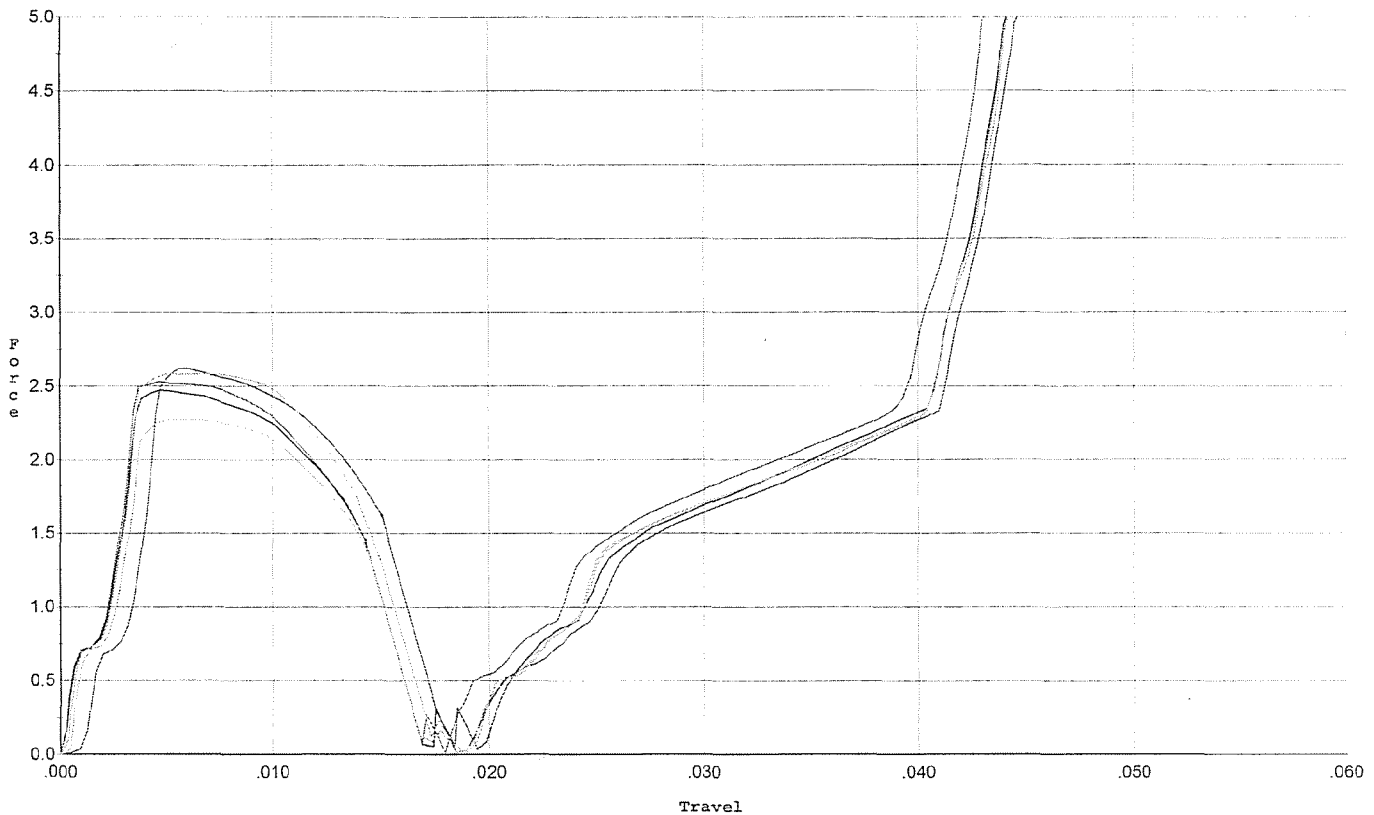
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6.5</u> <u>6.5</u>	4-1-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4</u> <u>4</u>	4-1-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	4-1-09	NW
	J) ASSEMBLE STOCK		3-31-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		4-1-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-31-09	RP
	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	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.41</u> <u>2.43</u> <u>2.46</u> <u>2.45</u>	4-1-09	NW
	C) FUNCTION		4-1-09	NW
690	PACK		6/9/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



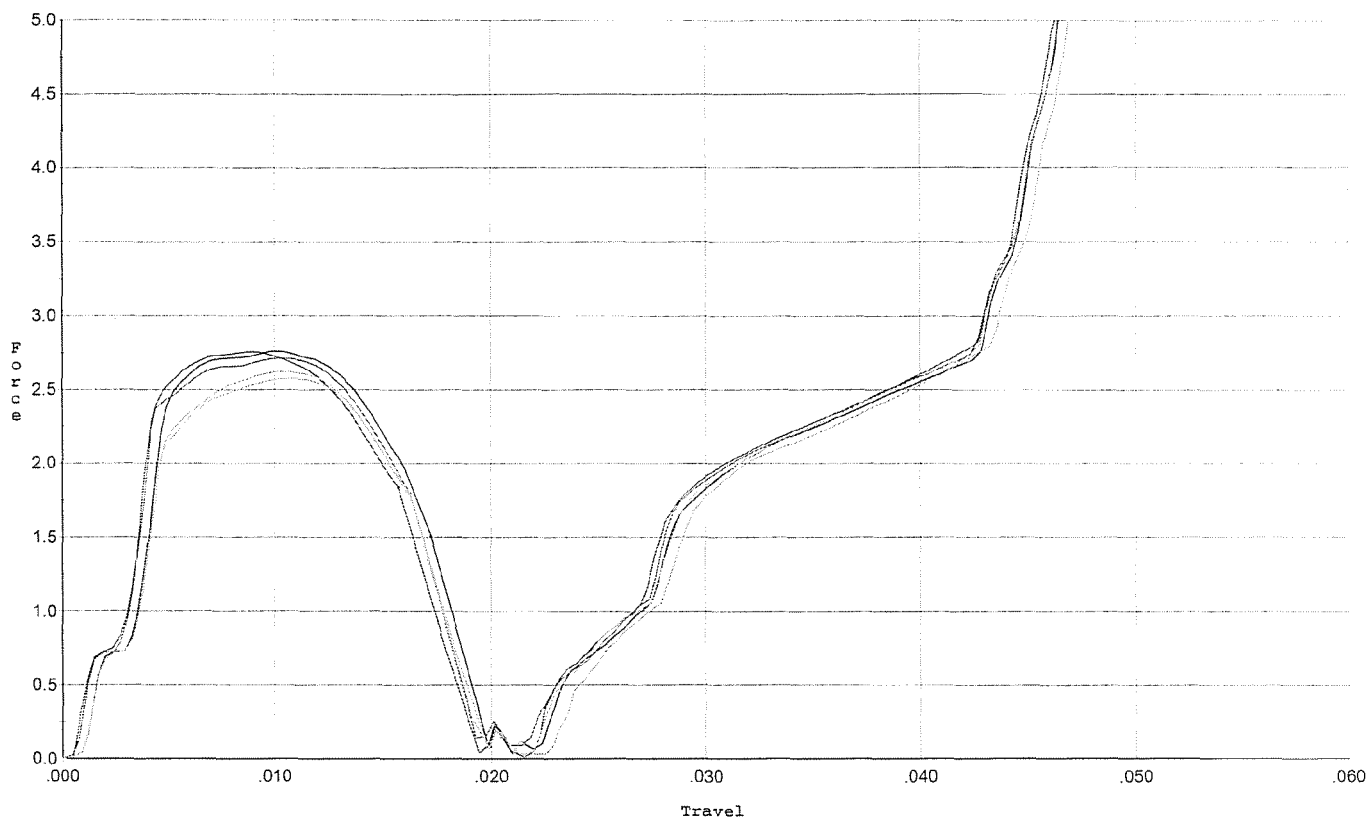
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.619	0.015	0.00	0.034	0.026		Set Trigger
2	2.472	0.014	0.00	0.035	0.025		Set Trigger
3	2.529	0.014	0.00	0.033	0.026		Set Trigger
4	2.271	0.014	0.00	0.035	0.023		Set Trigger
5	2.585	0.015	0.00	0.034	0.028		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



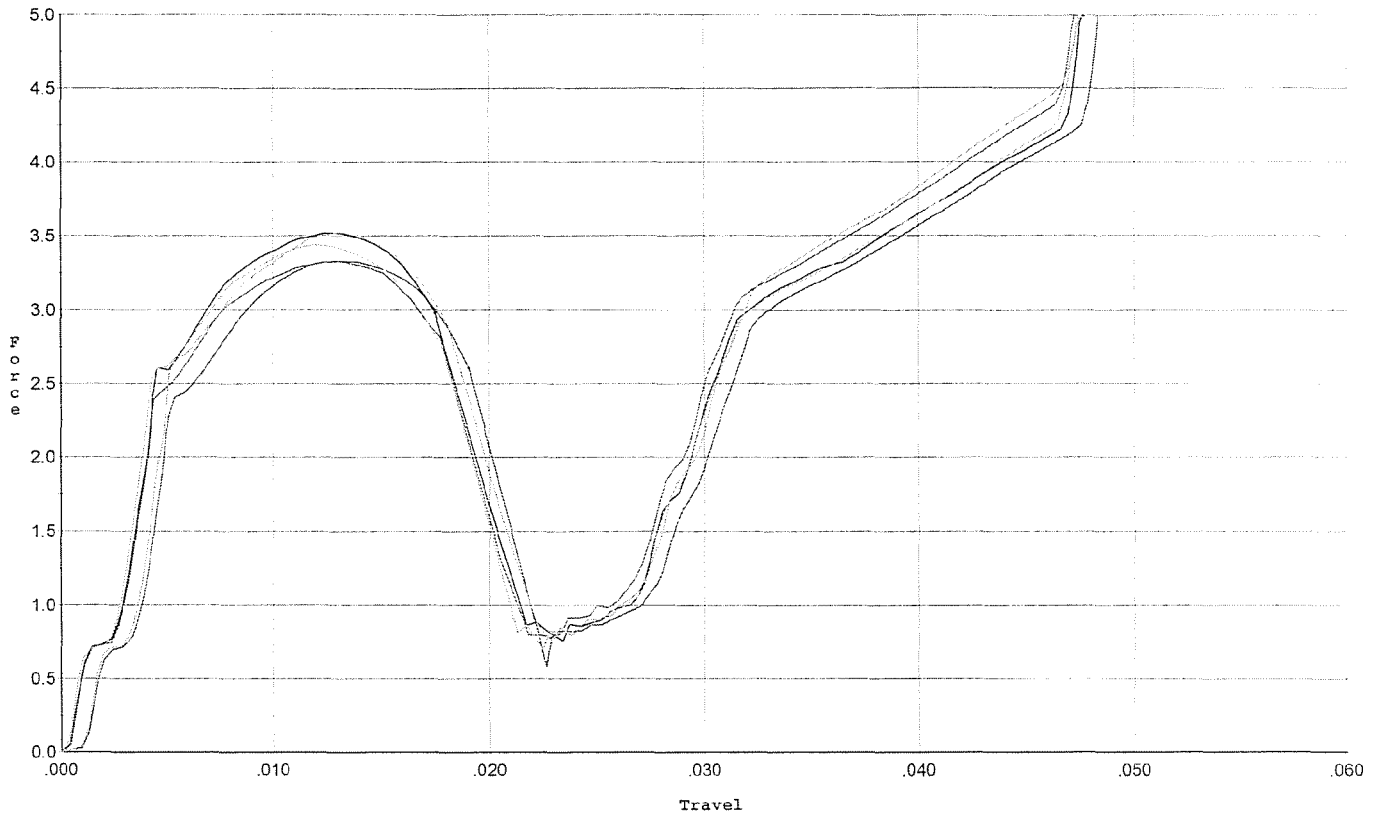
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.758	0.016	0.00	0.034	0.030		Set Trigger
2	2.762	0.017	0.00	0.034	0.033		Set Trigger
3	2.715	0.016	0.00	0.034	0.031		Set Trigger
4	2.577	0.016	0.00	0.034	0.029		Set Trigger
5	2.624	0.016	0.00	0.035	0.029		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



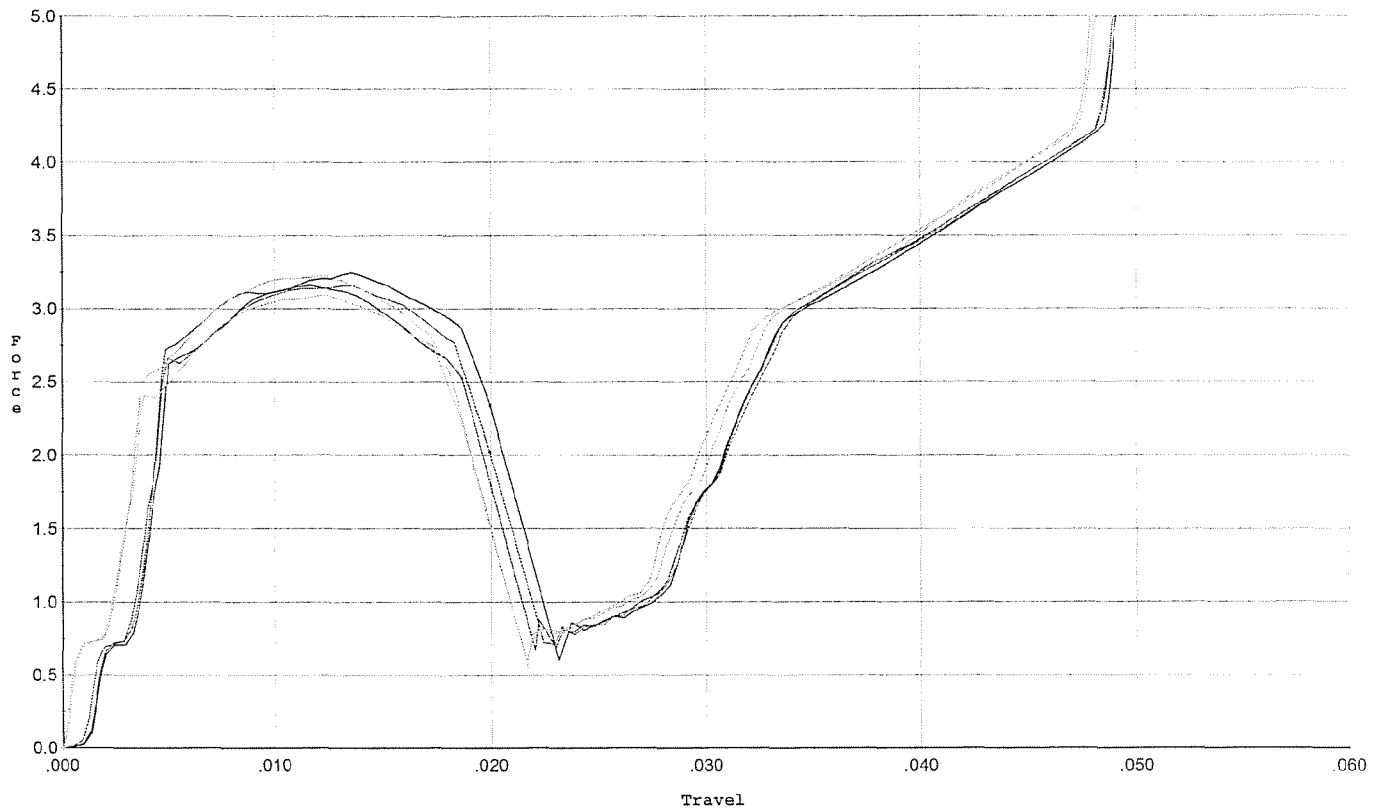
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.328	0.019	0.00	0.032	0.043		Set Trigger
2	3.522	0.017	0.00	0.031	0.043		Set Trigger
3	3.331	0.018	0.00	0.031	0.042		Set Trigger
4	3.436	0.018	0.00	0.031	0.043		Set Trigger
5	3.520	0.018	0.00	0.031	0.043		Set Trigger

A-3-42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



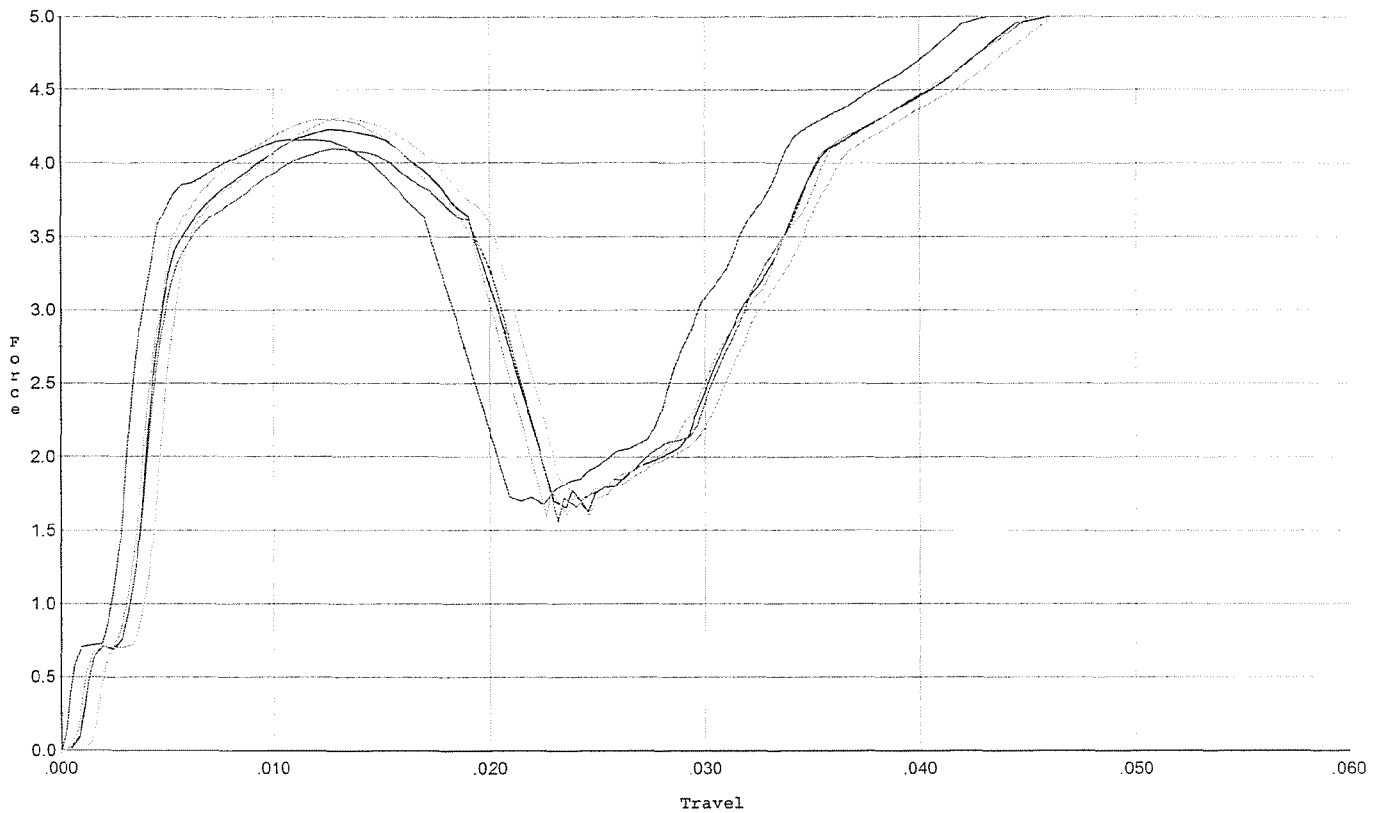
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.019	0.00	0.033	0.042		Set Trigger
2	3.248	0.020	0.00	0.032	0.045		Set Trigger
3	3.161	0.020	0.00	0.032	0.045		Set Trigger
4	3.092	0.019	0.00	0.032	0.042		Set Trigger
5	3.226	0.018	0.00	0.032	0.043		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



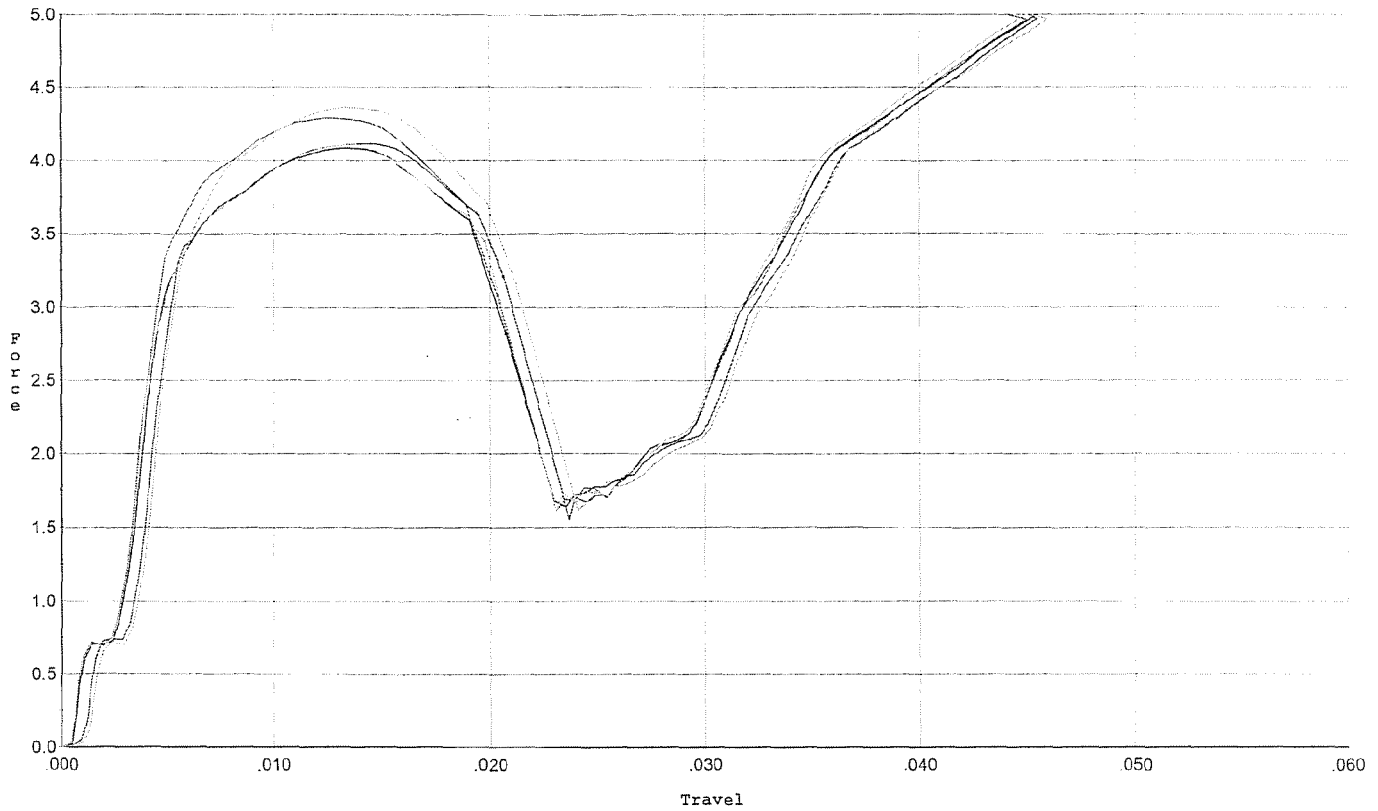
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.164	0.019	0.00	0.029	0.056		Set Trigger
2	4.231	0.021	0.00	0.030	0.060		Set Trigger
3	4.099	0.020	0.00	0.030	0.057		Set Trigger
4	4.309	0.020	0.00	0.030	0.058		Set Trigger
5	4.294	0.019	0.00	0.030	0.057		Set Trigger

A.4.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



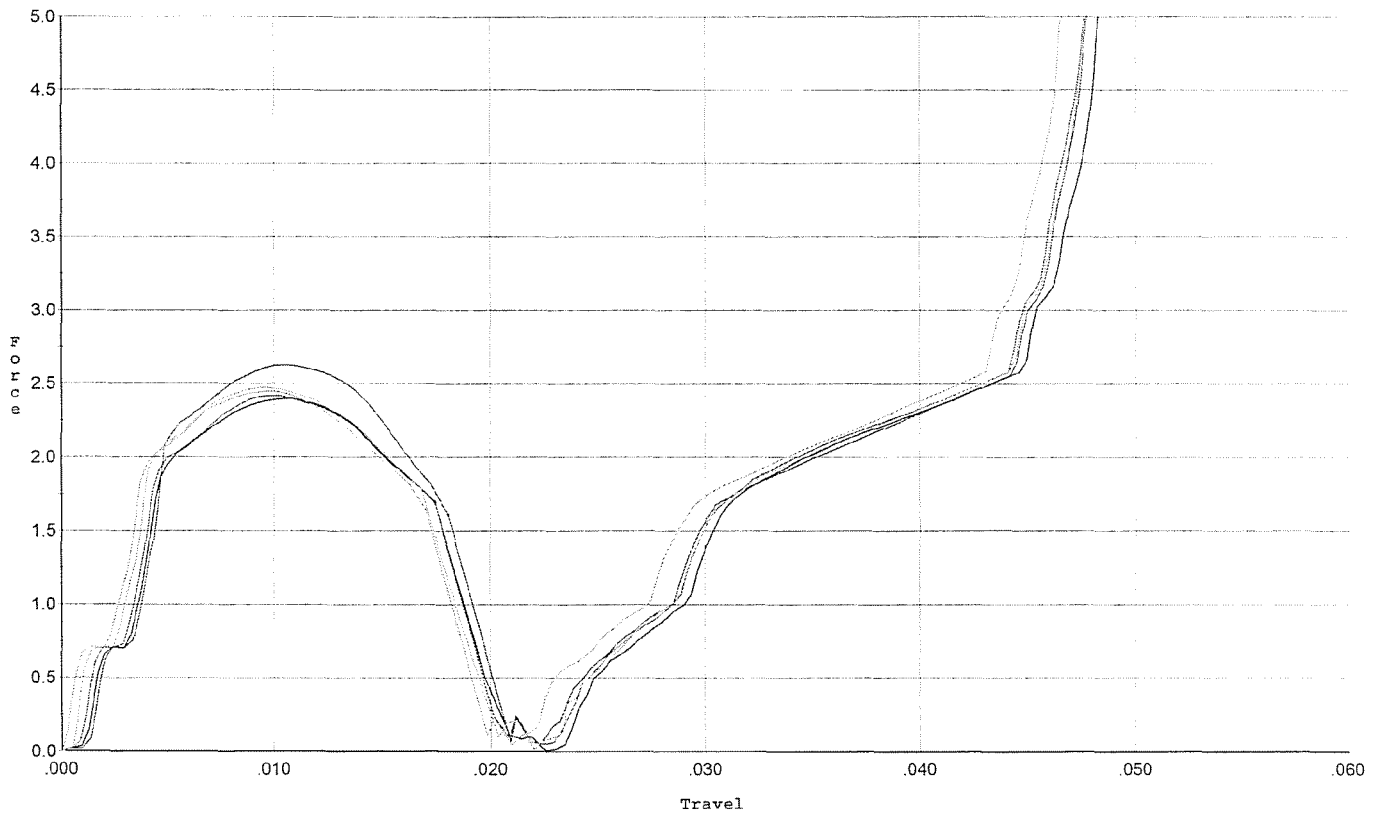
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.115	0.021	0.00	0.030	0.059		Set Trigger
2	4.084	0.021	0.00	0.030	0.060		Set Trigger
3	4.292	0.020	0.00	0.030	0.061		Set Trigger
4	4.116	0.020	0.00	0.030	0.057		Set Trigger
5	4.364	0.021	0.00	0.030	0.063		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



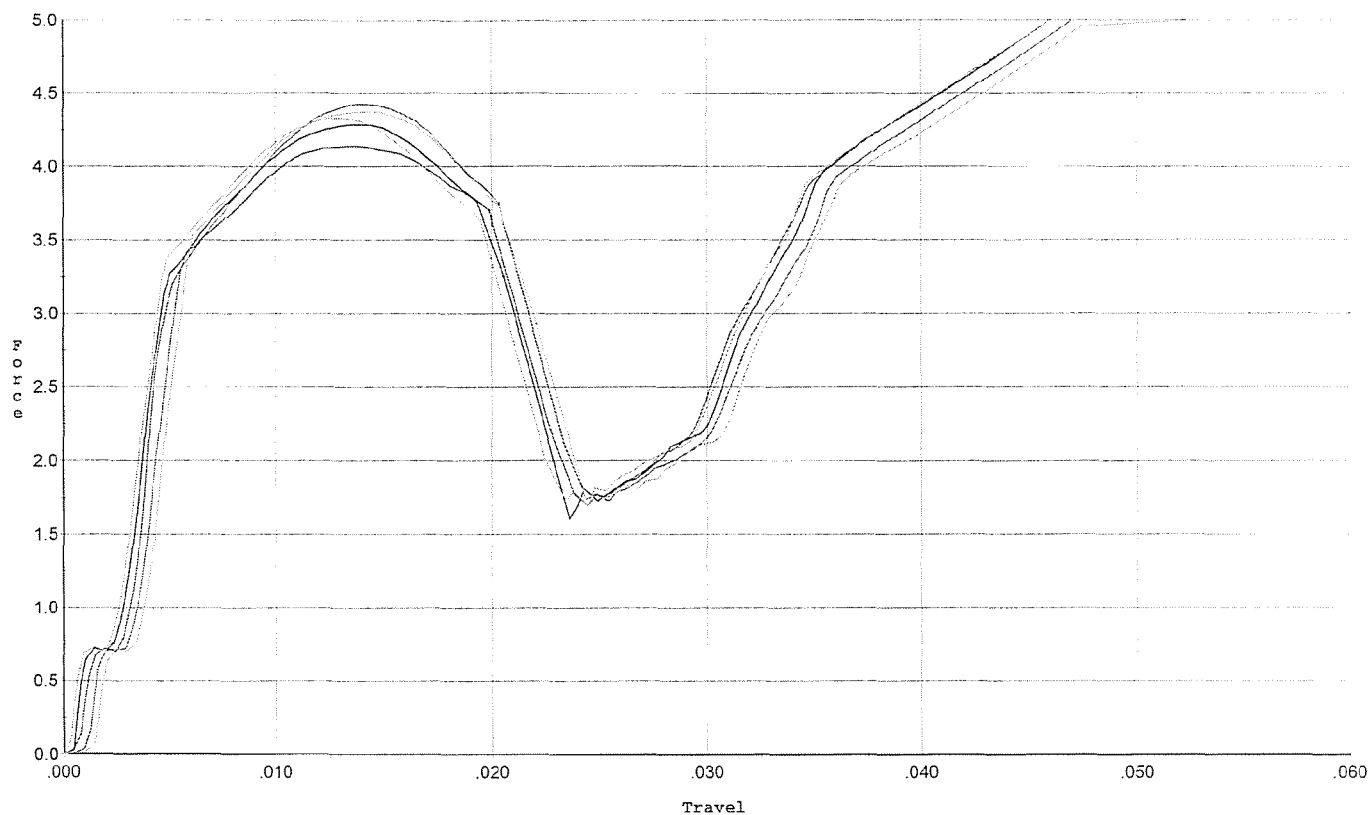
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.627	0.018	0.00	0.034	0.032		Set Trigger
2	2.399	0.017	0.00	0.035	0.029		Set Trigger
3	2.416	0.017	0.00	0.034	0.030		Set Trigger
4	2.472	0.017	0.00	0.035	0.030		Set Trigger
5	2.447	0.017	0.00	0.034	0.030		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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	4.139	0.020	0.00	0.029	0.058		Set Trigger
2	4.288	0.021	0.00	0.029	0.062		Set Trigger
3	4.427	0.020	0.00	0.030	0.061		Set Trigger
4	4.374	0.022	0.00	0.030	0.065		Set Trigger
5	4.333	0.019	0.00	0.030	0.059		Set Trigger

A4.31