

G6845287

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



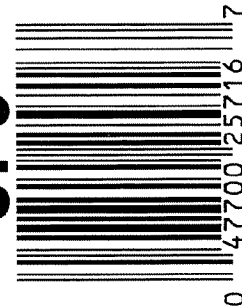
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6845287

UPC



GUN SERIAL # 66845287

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RF
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	RT
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	(N)	3/20/09	(N)
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				

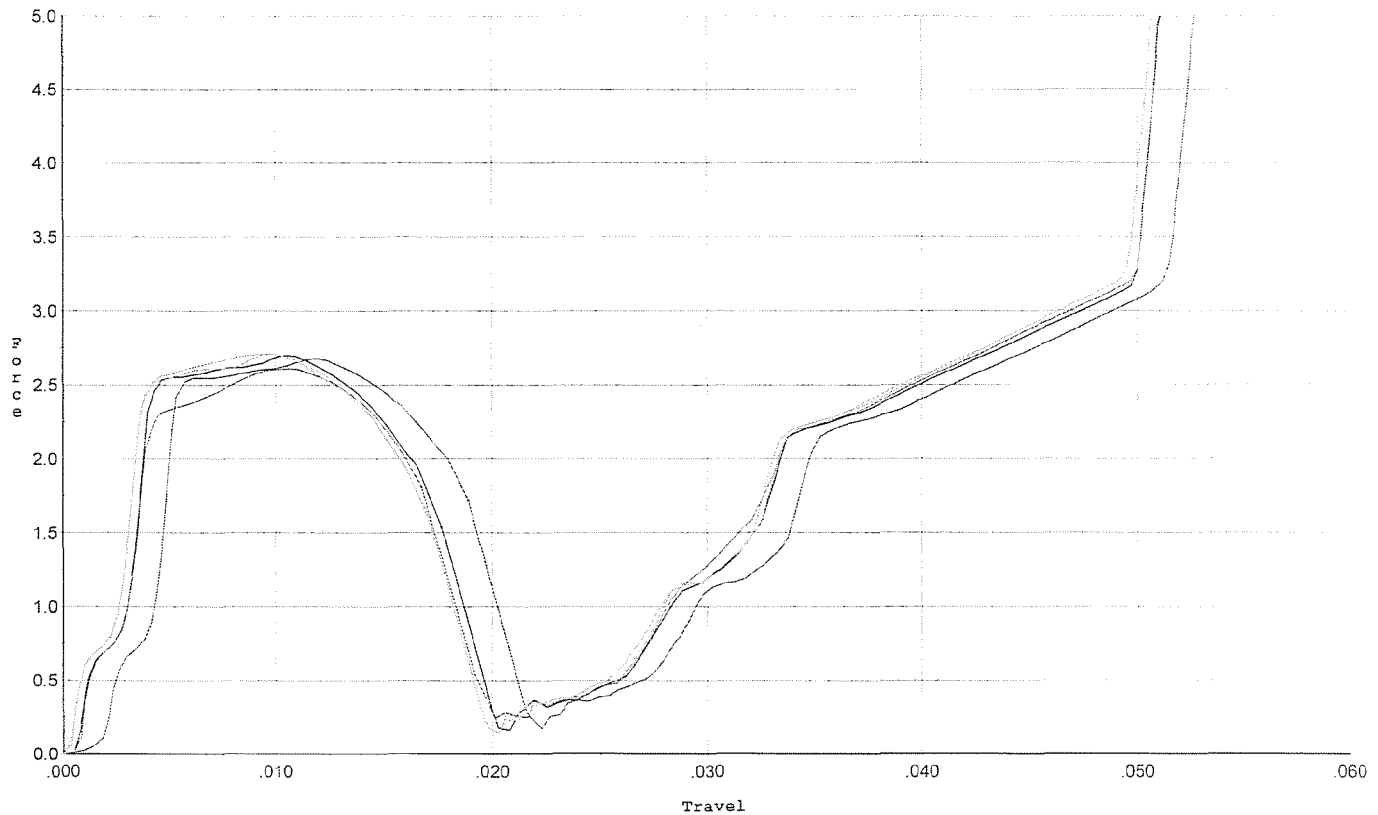
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.1</u> <u>2.1</u> <u>2.1</u>	4/20/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.3</u> <u>3.3</u> <u>3.2</u>	4/20/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4/20/09	RP
	J) ASSEMBLE STOCK		4-20-09	RP
	K) ASSEMBLE SWIVEL STUDS		4/28/09	RP
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/28/09	
	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	4-21-09	W/W
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-21-09	TCR
670	FINAL INSPECTION A) HEADSPACE		4/28/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.50</u> <u>2.38</u> <u>2.43</u> <u>2.52</u>	4-22-09	W/W
	C) FUNCTION		4/28/09	RP
690	PACK		5/20/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



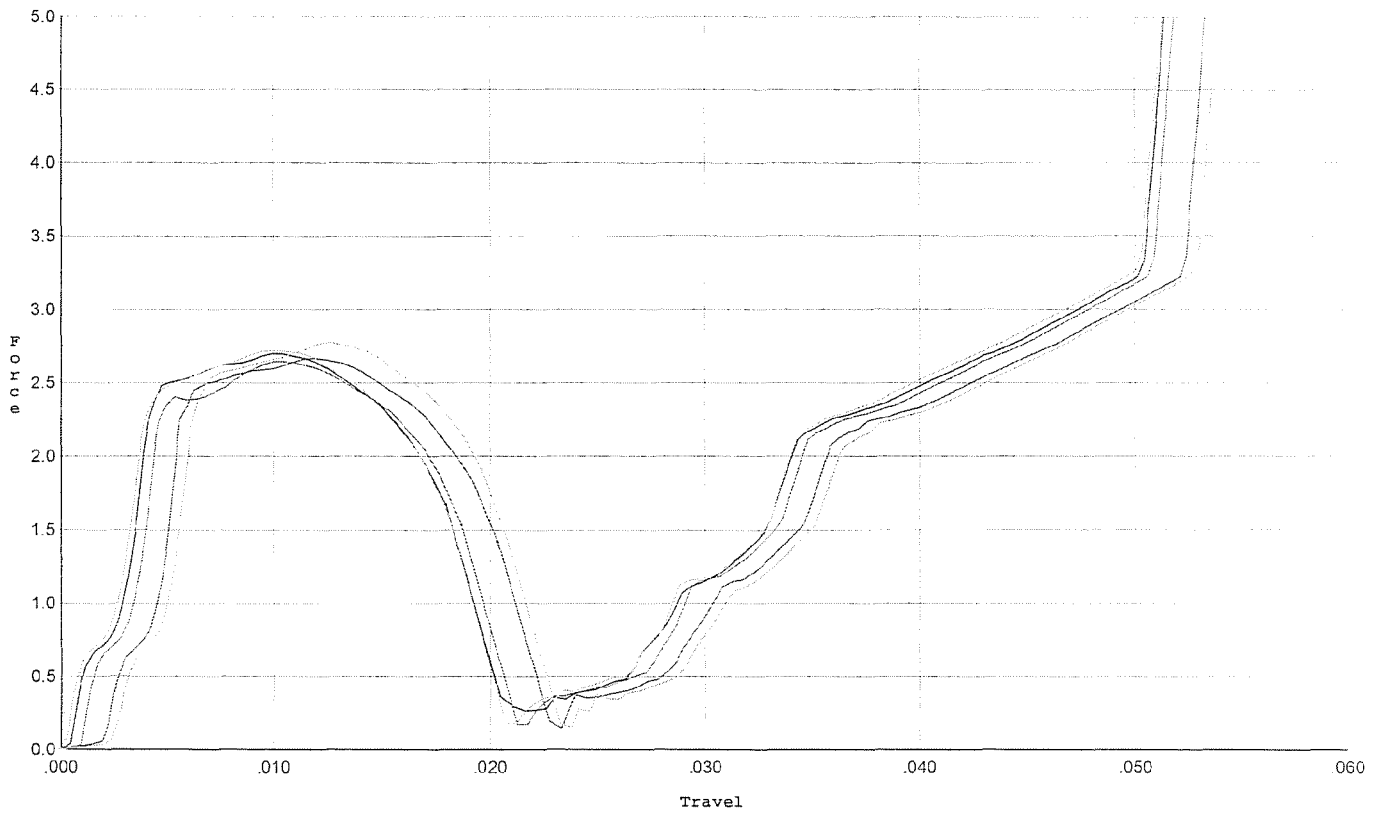
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.679	0.019	0.00	0.038	0.035		Set Trigger
2	2.699	0.018	0.00	0.037	0.034		Set Trigger
3	2.608	0.017	0.00	0.038	0.031		Set Trigger
4	2.708	0.017	0.00	0.037	0.034		Set Trigger
5	2.708	0.017	0.00	0.037	0.034		Set Trigger

A. 2.68

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



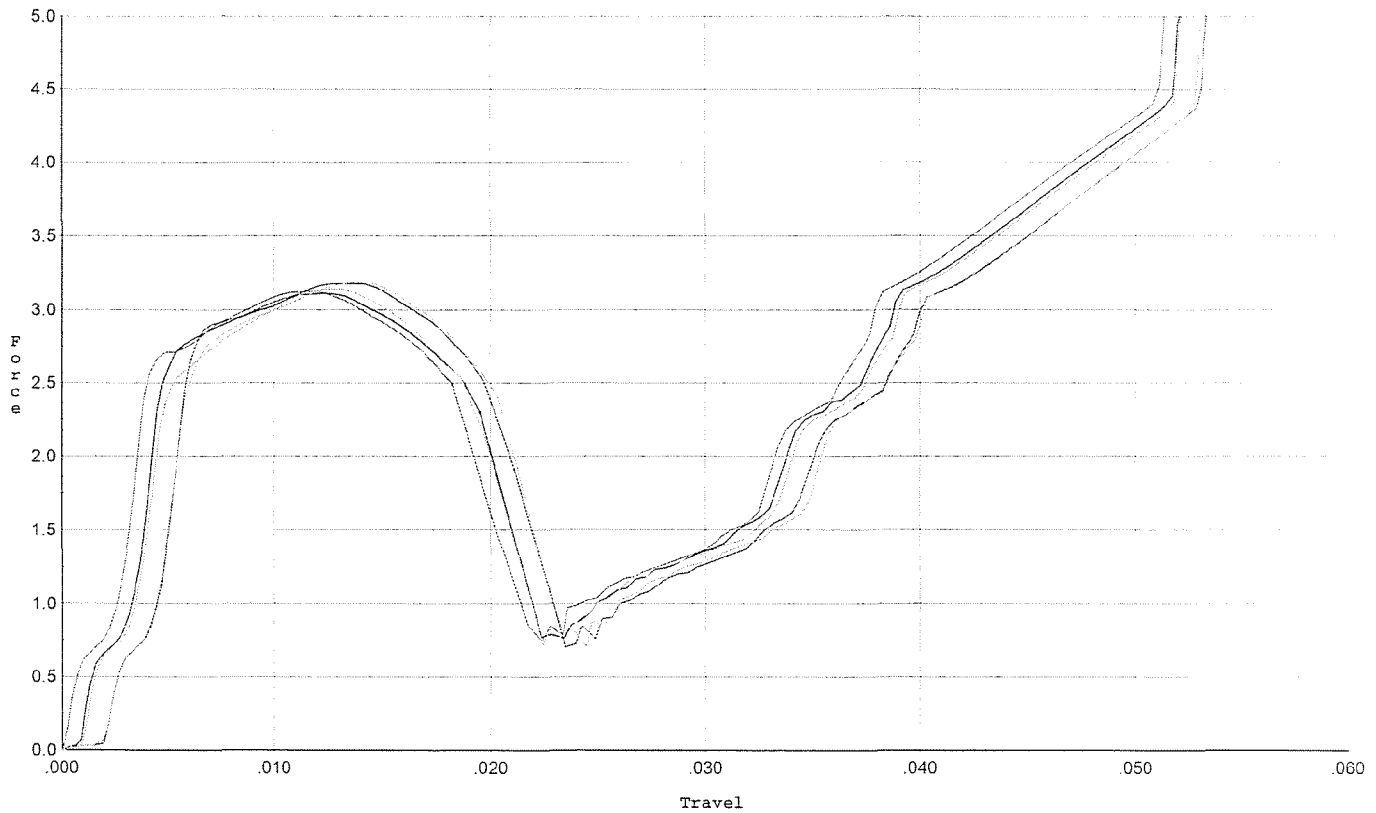
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.668	0.020	0.00	0.037	0.037		Set Trigger
2	2.698	0.018	0.00	0.037	0.035		Set Trigger
3	2.644	0.019	0.00	0.037	0.035		Set Trigger
4	2.724	0.018	0.00	0.037	0.036		Set Trigger
5	2.771	0.021	0.00	0.037	0.038		Set Trigger

A.2.70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



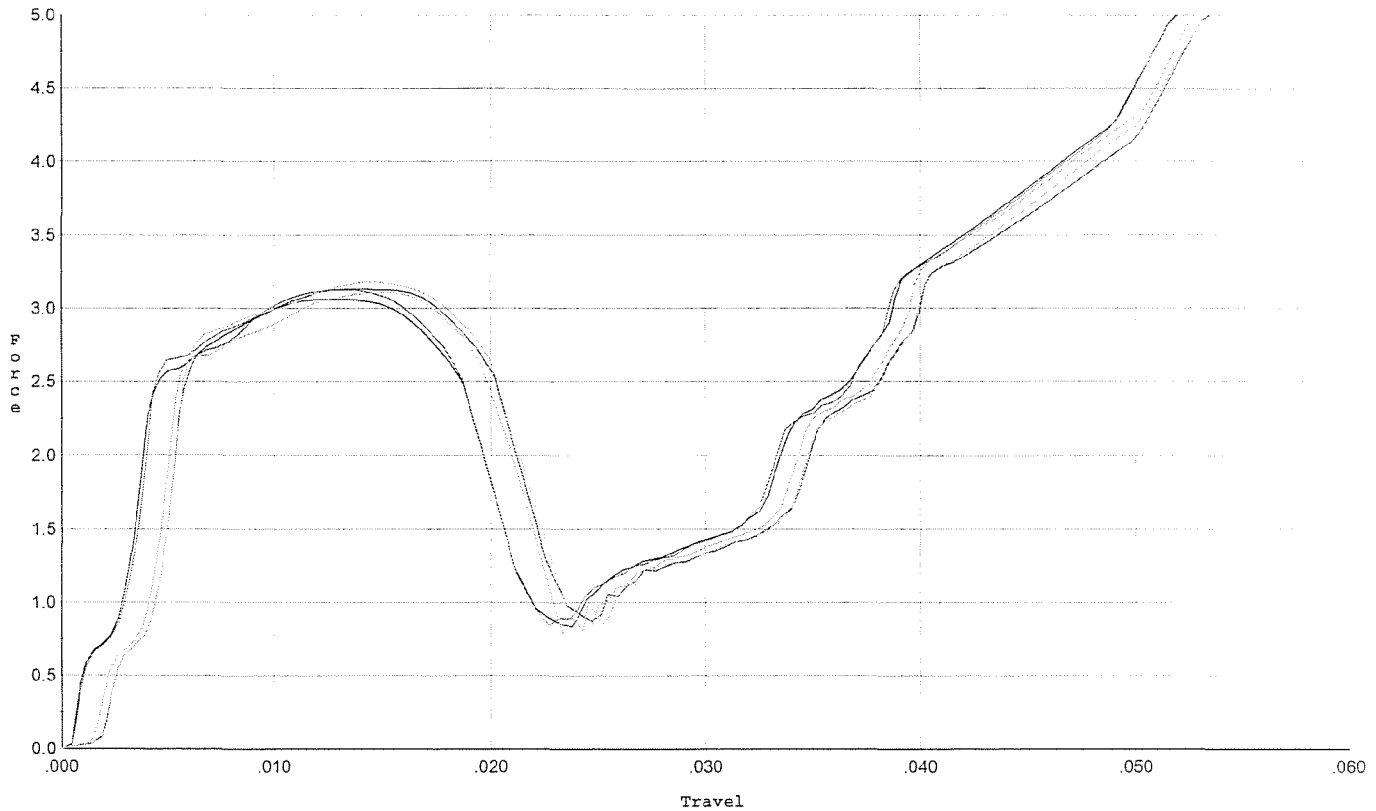
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.178	0.021	0.002	0.036	0.045		Set Trigger
2	3.111	0.020	0.00	0.036	0.043		Set Trigger
3	3.124	0.018	0.00	0.035	0.042		Set Trigger
4	3.188	0.020	0.00	0.036	0.044		Set Trigger
5	3.142	0.020	0.00	0.036	0.043		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



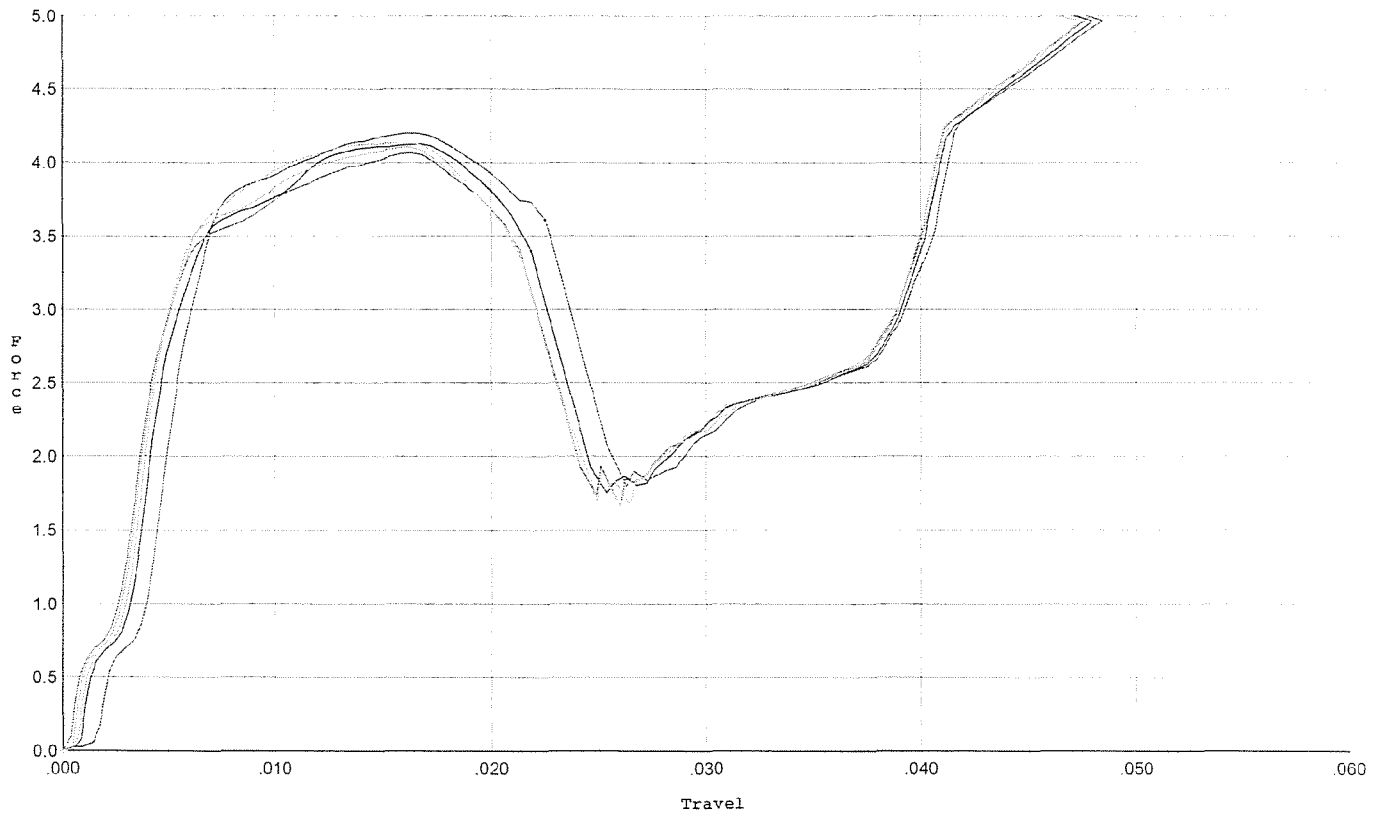
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.131	0.020	0.00	0.036	0.044		Set Trigger
2	3.064	0.019	0.00	0.035	0.042		Set Trigger
3	3.126	0.019	0.00	0.035	0.042		Set Trigger
4	3.183	0.020	0.00	0.036	0.044		Set Trigger
5	3.107	0.021	0.00	0.035	0.045		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



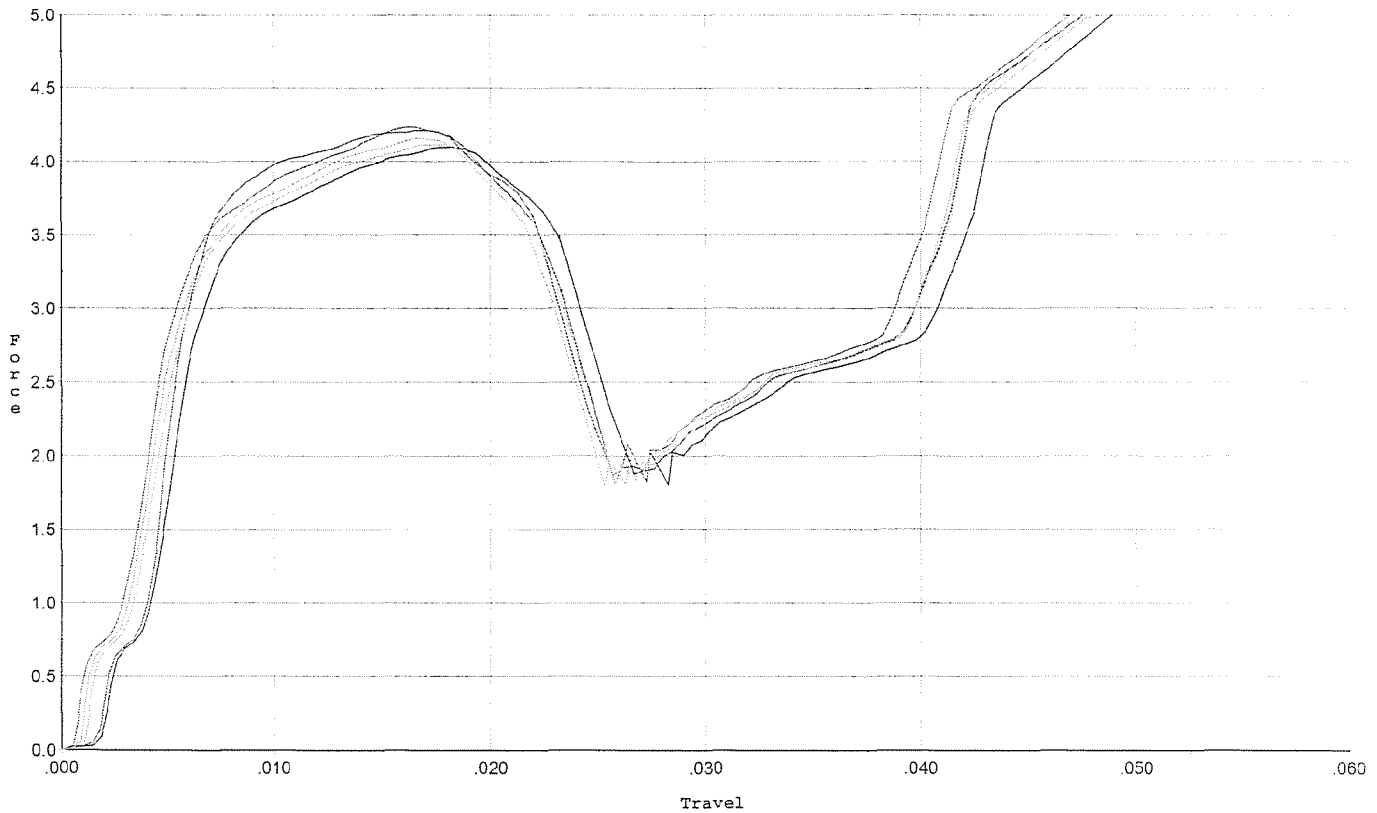
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.203	0.023	0.00	0.032	0.066		Set Trigger
2	4.129	0.022	0.00	0.032	0.064		Set Trigger
3	4.067	0.021	0.00	0.032	0.062		Set Trigger
4	4.107	0.021	0.00	0.033	0.063		Set Trigger
5	4.136	0.021	0.00	0.033	0.063		Set Trigger

A-4-12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



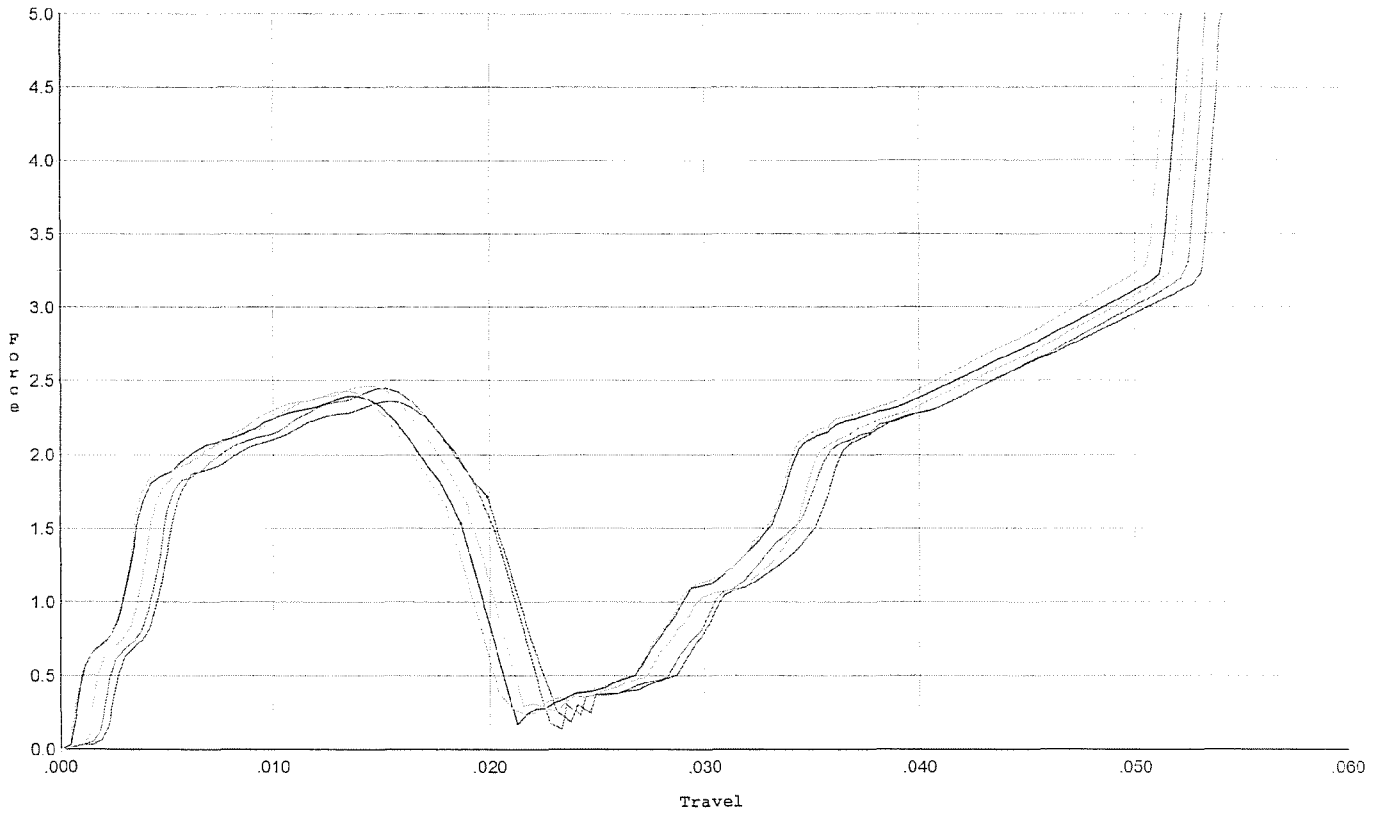
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.212	0.023	0.00	0.032	0.068		Set Trigger
2	4.099	0.023	0.002	0.032	0.065		Set Trigger
3	4.236	0.022	0.00	0.032	0.066		Set Trigger
4	4.112	0.024	0.00	0.032	0.068		Set Trigger
5	4.161	0.023	0.00	0.032	0.067		Set Trigger

A. 4.16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



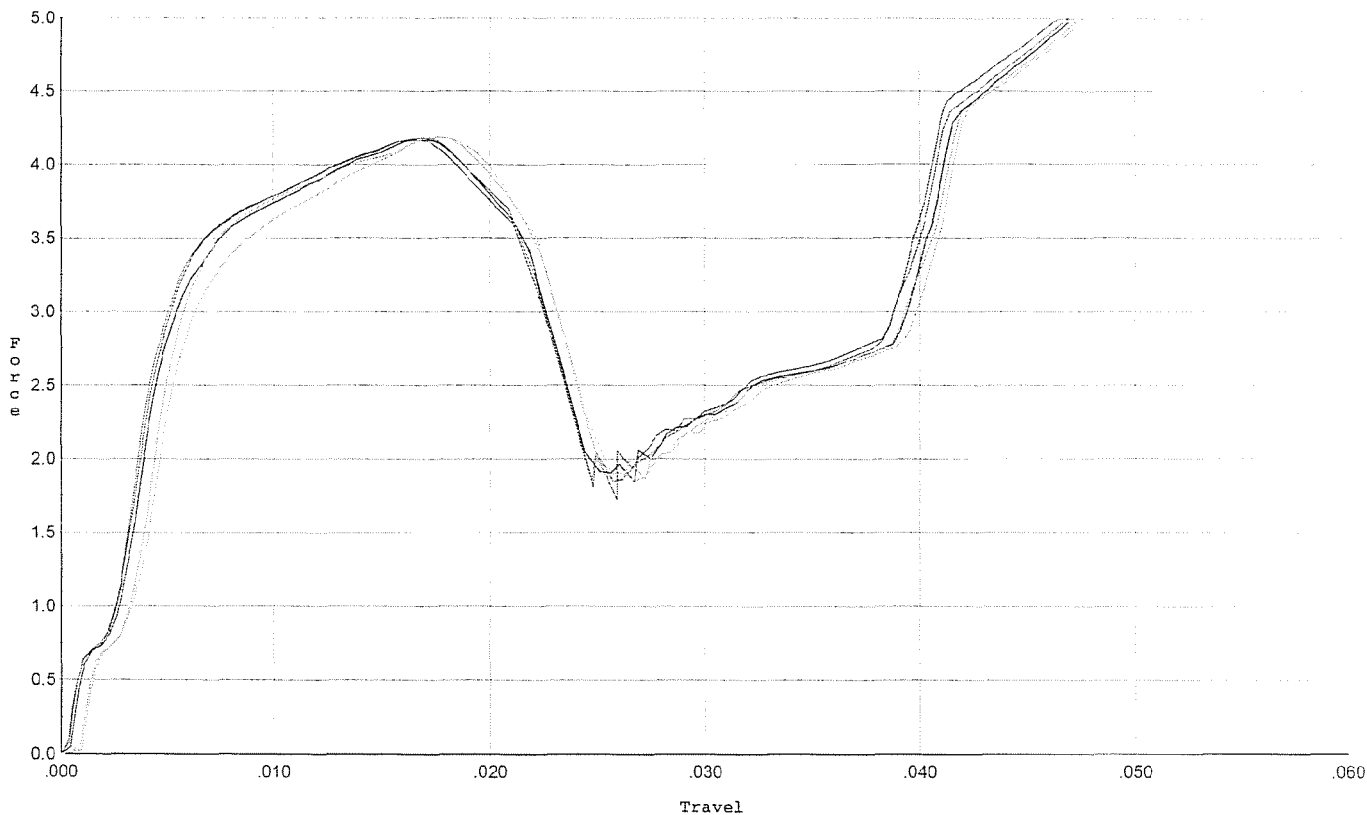
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.358	0.020	0.00	0.038	0.032		Set Trigger
2	2.393	0.019	0.00	0.038	0.032		Set Trigger
3	2.443	0.020	0.00	0.037	0.033		Set Trigger
4	2.466	0.019	0.00	0.038	0.032		Set Trigger
5	2.428	0.018	0.00	0.038	0.031		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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	4.164	0.022	0.00	0.031	0.066		Set Trigger
2	4.172	0.022	0.00	0.032	0.064		Set Trigger
3	4.185	0.022	0.00	0.032	0.066		Set Trigger
4	4.192	0.022	0.00	0.032	0.063		Set Trigger
5	4.188	0.022	0.00	0.031	0.065		Set Trigger

A-4.18