

G6845288

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

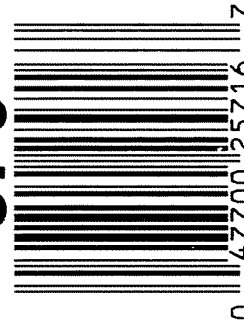
24"

CAPACITY

6

G6845288

UPC



GUN SERIAL # G6845288

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	KIC
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(#)</u>	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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

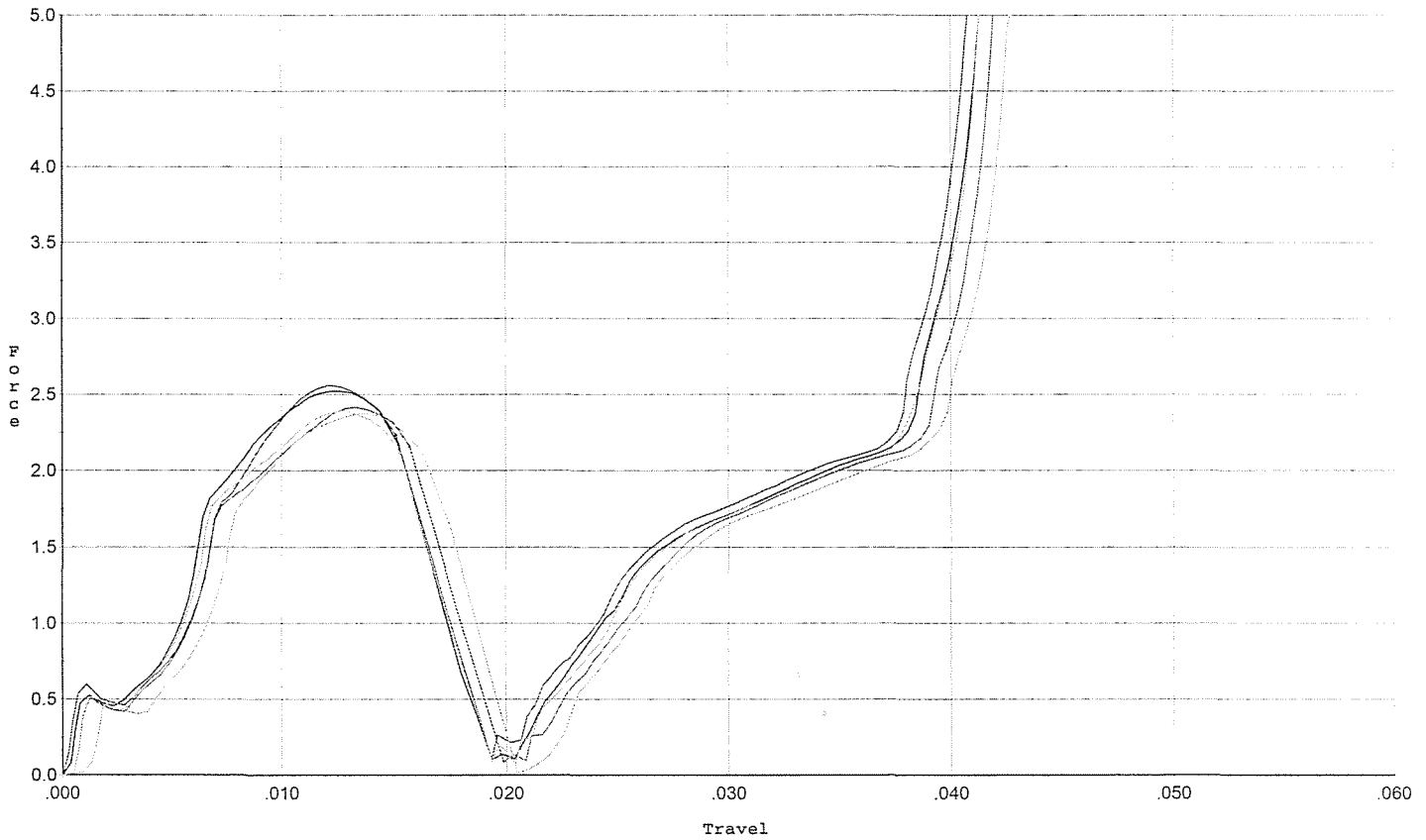
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5</u>	<u>5.5</u>	<u>5.5</u>	4-13-09	NW		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.5</u>	<u>3.5</u>	<u>3.5</u>	4-13-09	NW		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.024</u>	4-13-09	NW		
	J) ASSEMBLE STOCK					4-1-09	L.P.N.		
	K) ASSEMBLE SWIVEL STUDS					4-13-09	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	4-4-09	RP		
			<u>PASS</u>		FAIL				
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					4-4-09	RP		
670	FINAL INSPECTION A) HEADSPACE					4-13-09	NW		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u>	<u>2.29</u>	<u>2.42</u>	<u>2.40</u>	<u>2.44</u>	4-7-09	RP
	C) FUNCTION					4-13-09	NW		
690	PACK					6/5/09	Fey		

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



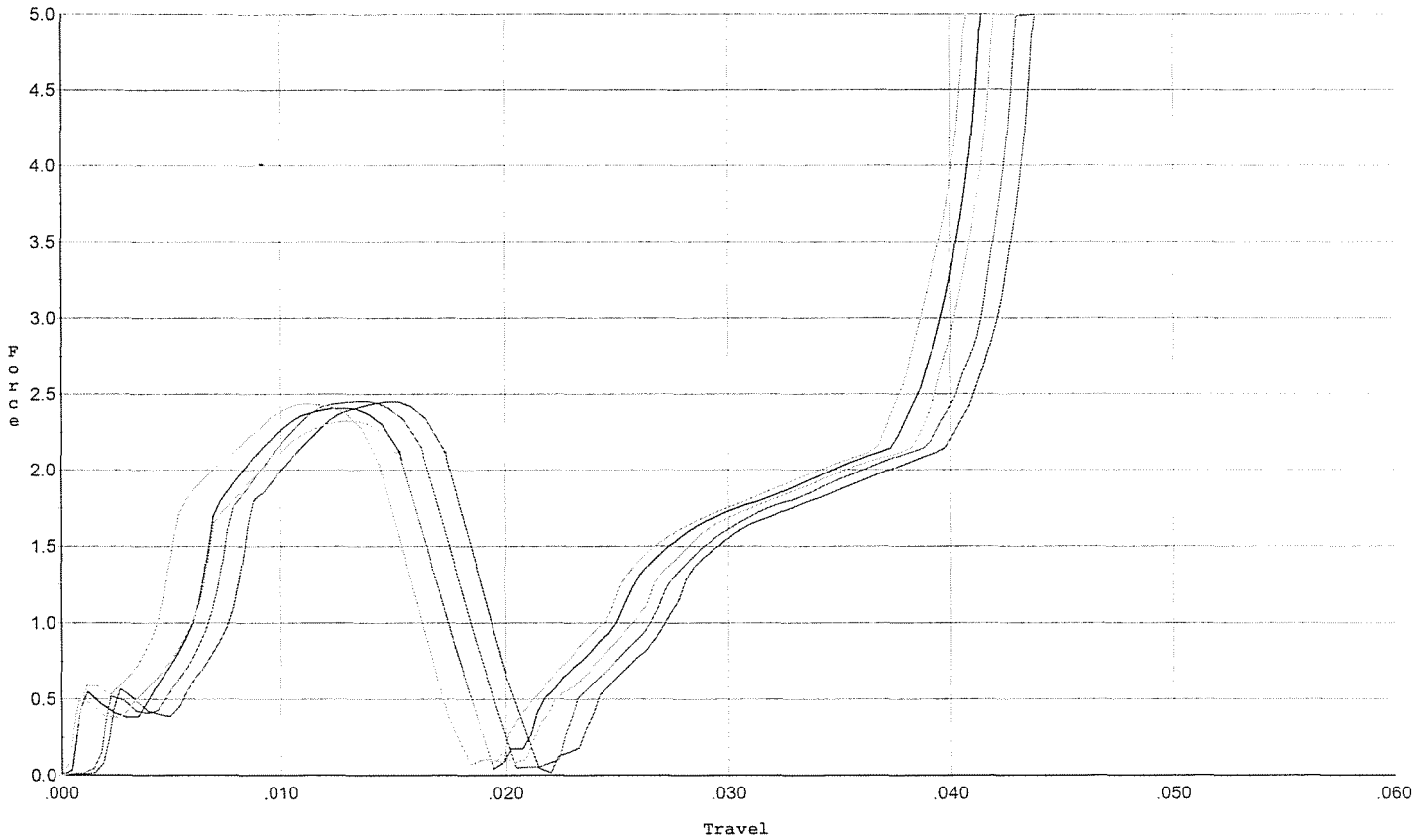
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.015	0.003	0.029	0.023		Set Trigger
2	2.521	0.015	0.003	0.030	0.023		Set Trigger
3	2.418	0.016	0.003	0.030	0.023		Set Trigger
4	2.395	0.015	0.003	0.030	0.022		Set Trigger
5	2.376	0.018	0.004	0.030	0.024		Set Trigger

A-2.45

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



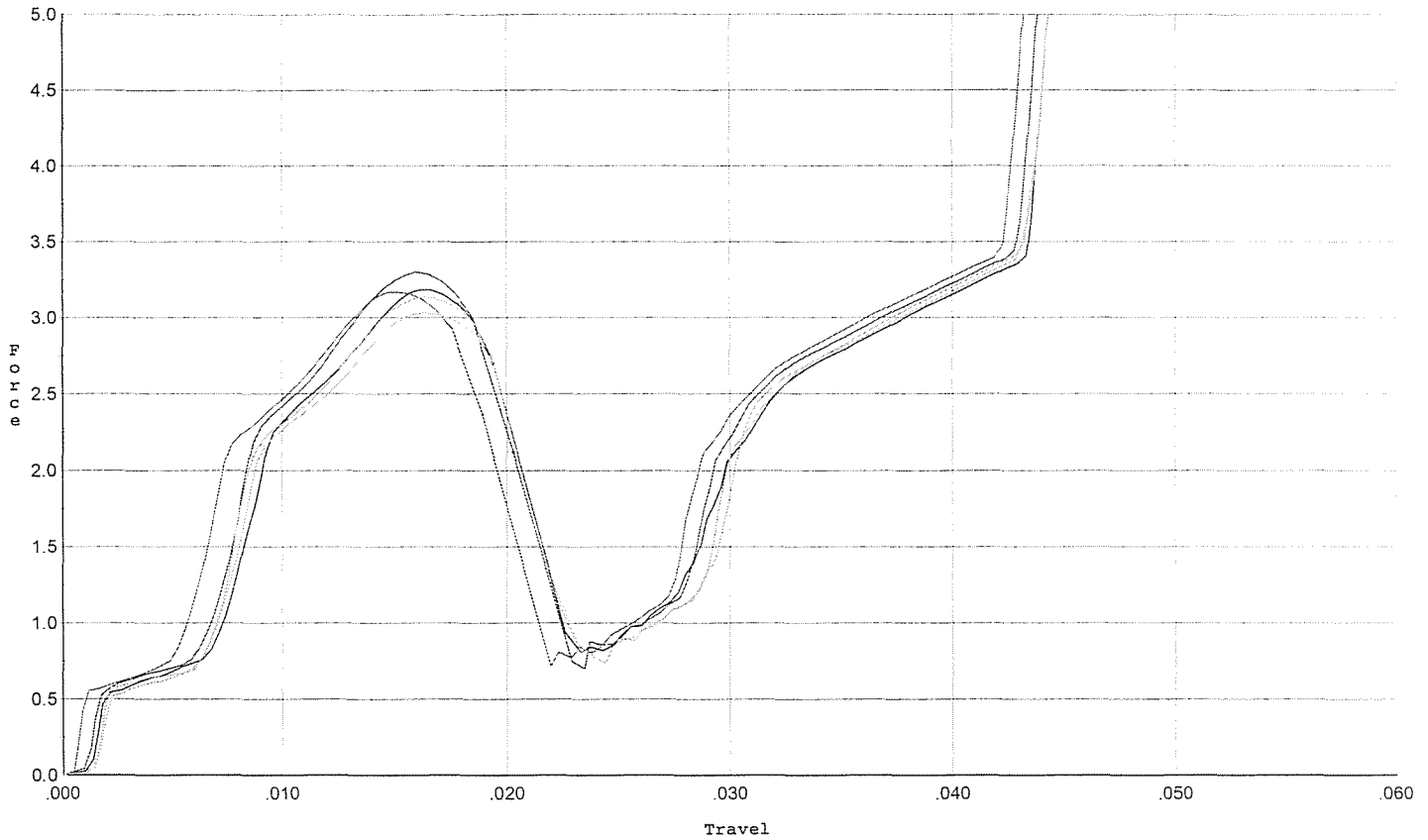
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.450	0.017	0.002	0.031	0.023		Set Trigger
2	2.411	0.015	0.004	0.030	0.022		Set Trigger
3	2.455	0.016	0.005	0.031	0.023		Set Trigger
4	2.323	0.015	0.003	0.031	0.022		Set Trigger
5	2.439	0.014	0.003	0.030	0.023		Set Trigger

A-2-41.

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 lbs ini +/- .75 lb



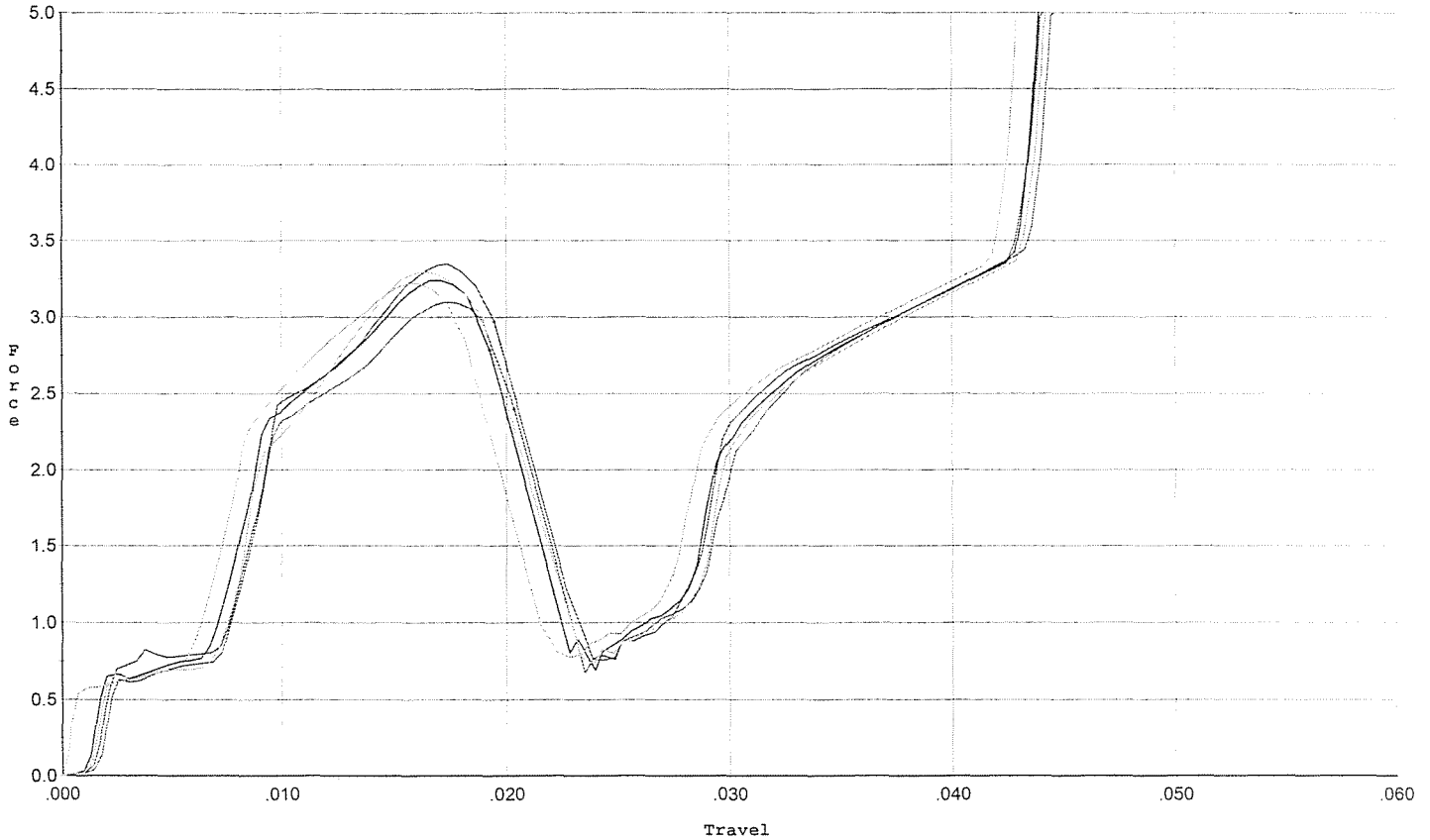
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.303	0.020	0.00	0.028	0.038		Set Trigger
2	3.184	0.019	0.00	0.028	0.034		Set Trigger
3	3.166	0.019	0.00	0.028	0.036		Set Trigger
4	3.032	0.019	0.00	0.029	0.034		Set Trigger
5	3.140	0.019	0.00	0.029	0.035		Set Trigger

A-3.16

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 lbs after 20 cycles+/- .75 lb



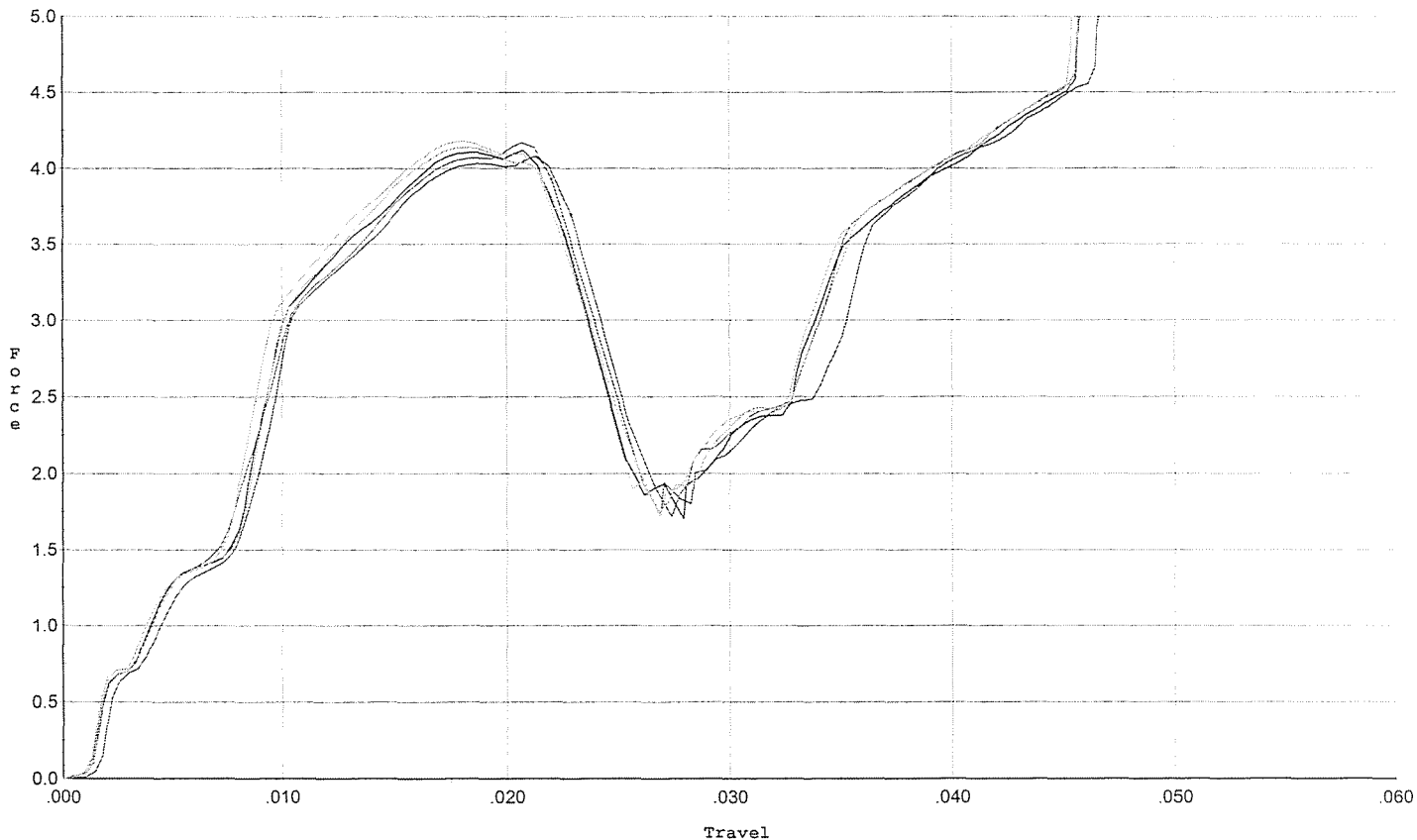
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.347	0.019	0.008	0.028	0.036		Set Trigger
2	3.241	0.019	0.00	0.028	0.035		Set Trigger
3	3.099	0.020	0.00	0.029	0.035		Set Trigger
4	3.296	0.019	0.007	0.029	0.034		Set Trigger
5	3.219	0.018	0.00	0.028	0.034		Set Trigger

A.3.24

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



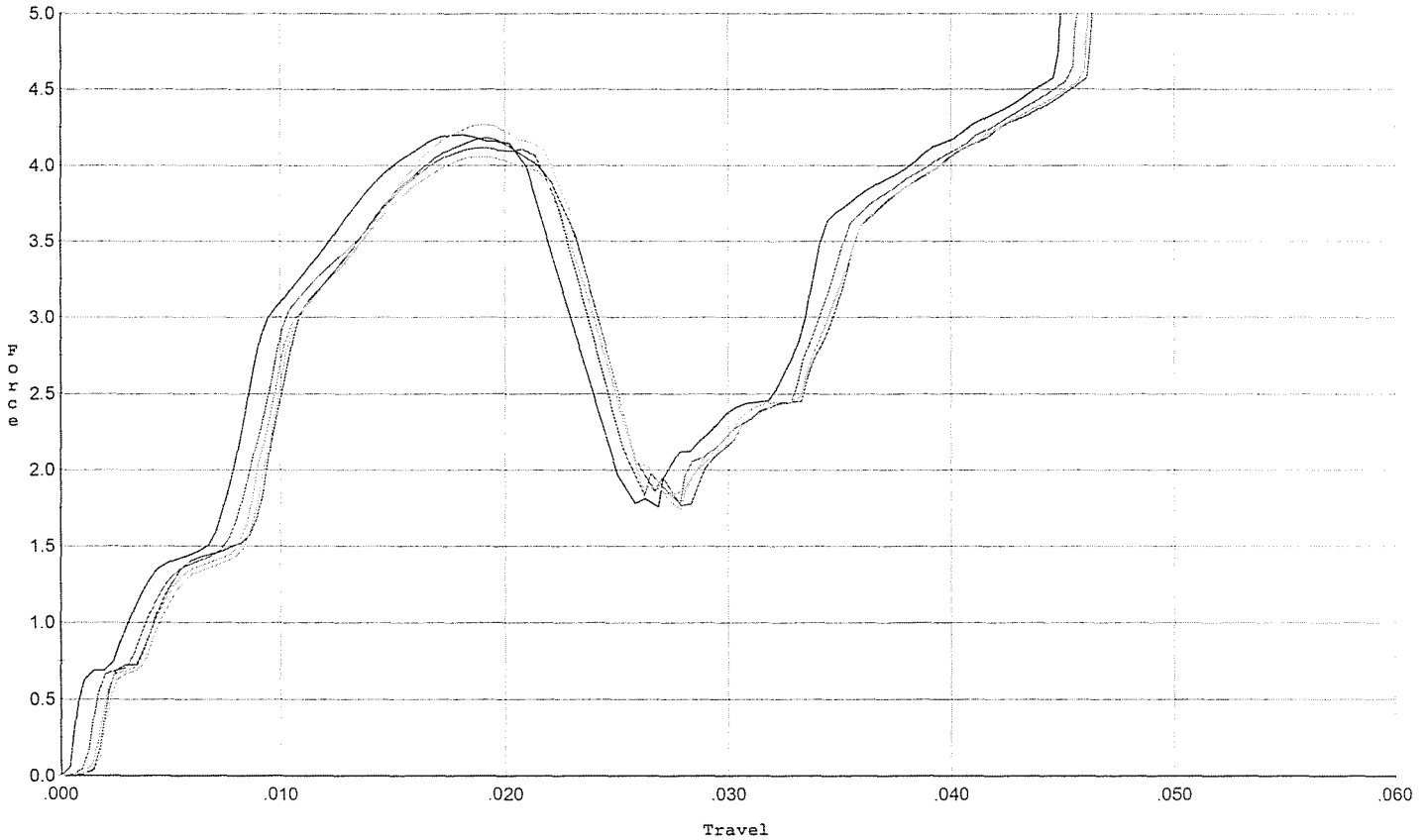
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.080	0.023	0.00	0.022	0.056		Set Trigger
2	4.122	0.023	0.00	0.021	0.056		Set Trigger
3	4.172	0.022	0.00	0.021	0.055		Set Trigger
4	4.182	0.023	0.00	0.021	0.059		Set Trigger
5	4.138	0.022	0.00	0.021	0.056		Set Trigger

A-4.13

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



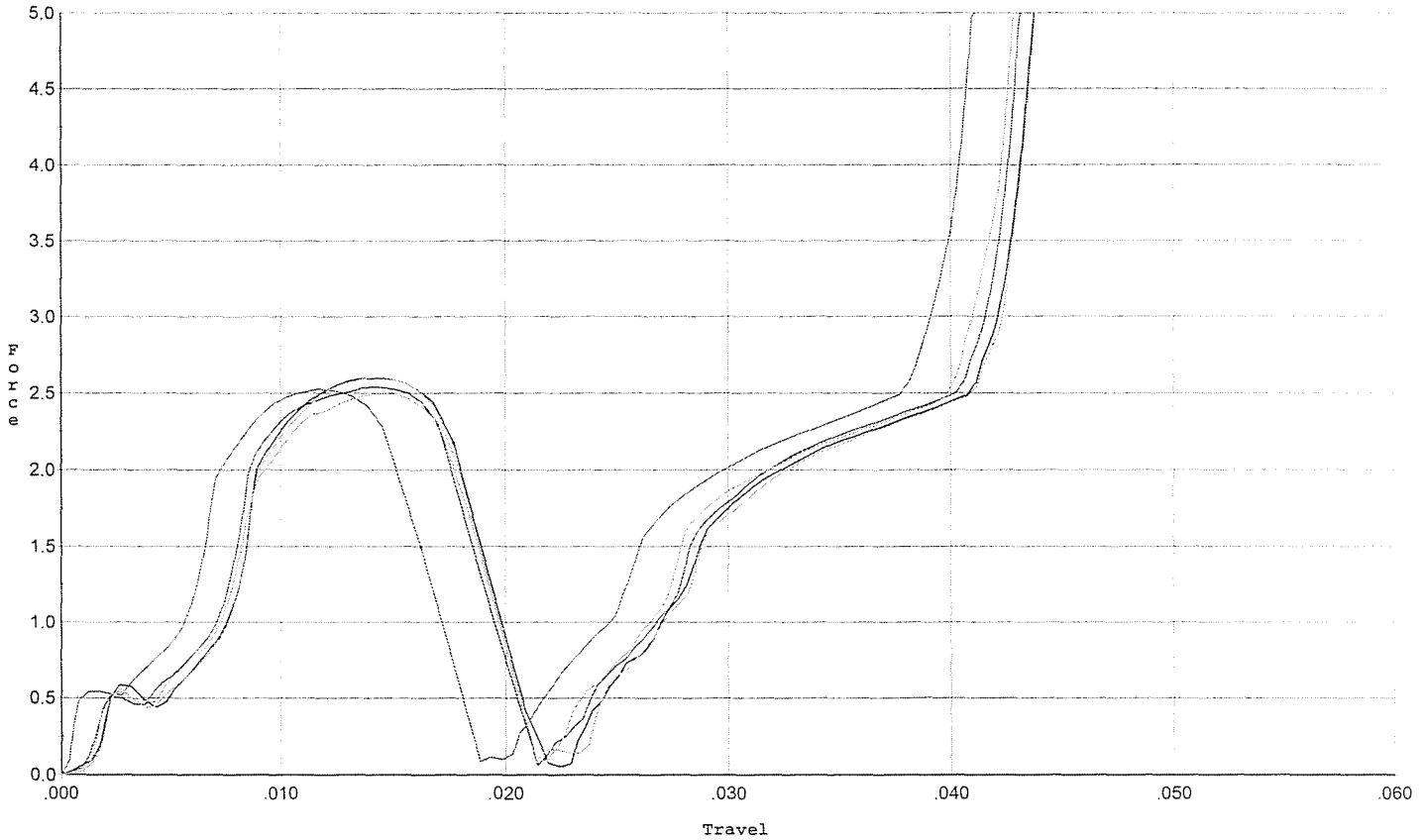
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.182	0.023	0.00	0.021	0.057		Set Trigger
2	4.202	0.021	0.00	0.023	0.054		Set Trigger
3	4.114	0.022	0.00	0.021	0.056		Set Trigger
4	4.269	0.023	0.00	0.021	0.056		Set Trigger
5	4.058	0.024	0.00	0.021	0.058		Set Trigger

A-4.16

Trigger Profile [lbs,inch]

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

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



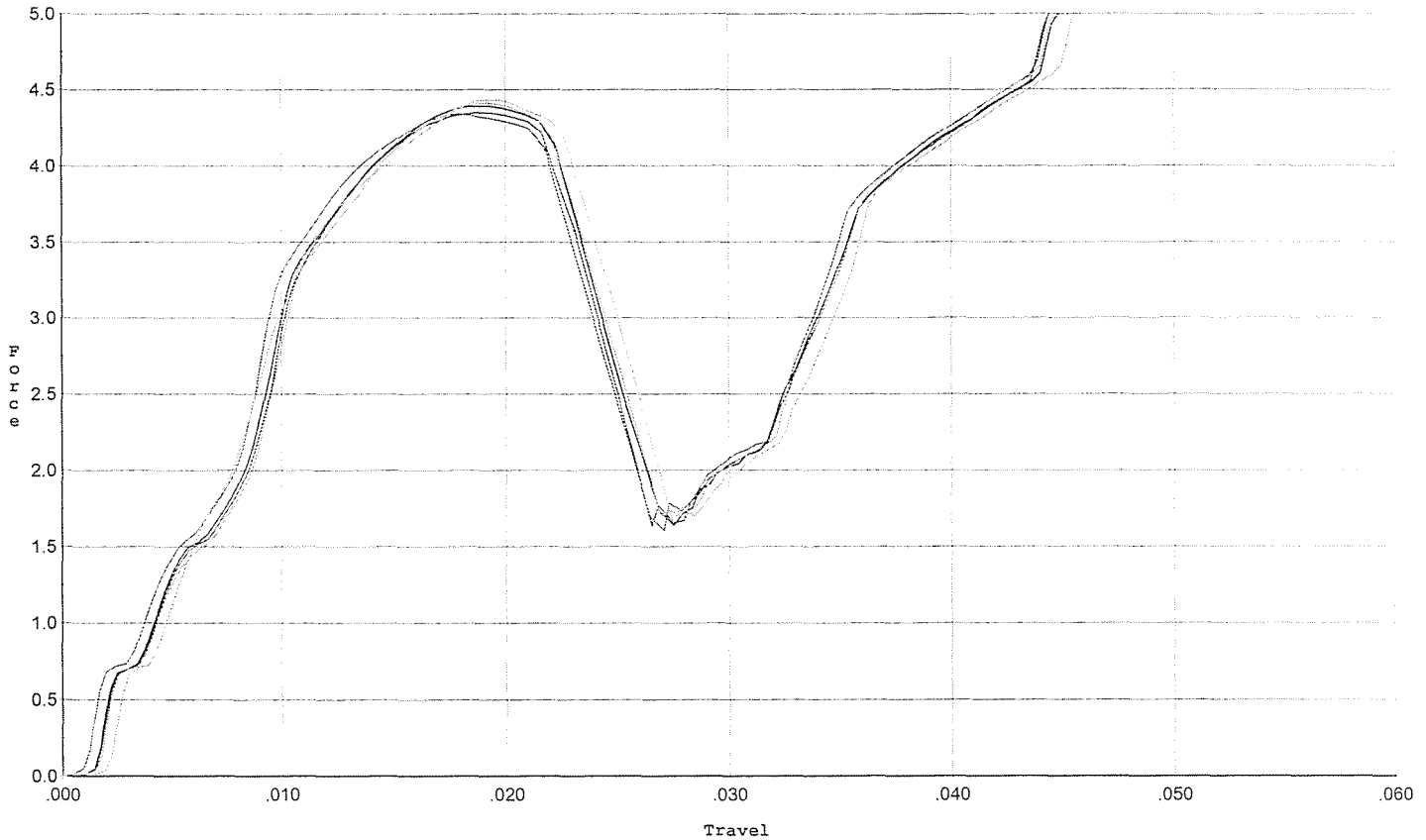
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.017	0.004	0.030	0.025		Set Trigger
2	2.597	0.018	0.005	0.030	0.026		Set Trigger
3	2.525	0.016	0.003	0.029	0.025		Set Trigger
4	2.602	0.018	0.005	0.030	0.026		Set Trigger
5	2.499	0.018	0.005	0.029	0.027		Set Trigger

A. 2.55

Trigger Profile [lbs,inch]

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

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.351	0.023	0.00	0.021	0.061		Set Trigger
2	4.395	0.022	0.00	0.021	0.059		Set Trigger
3	4.341	0.022	0.00	0.021	0.059		Set Trigger
4	4.436	0.025	0.002	0.020	0.066		Set Trigger
5	4.412	0.024	0.00	0.020	0.064		Set Trigger

A-4-38