

G6845295

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



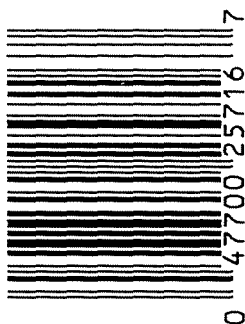
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845295

UPC



GUN SERIAL # G 6845295

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	—PFL— 	3/20/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BZ
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		

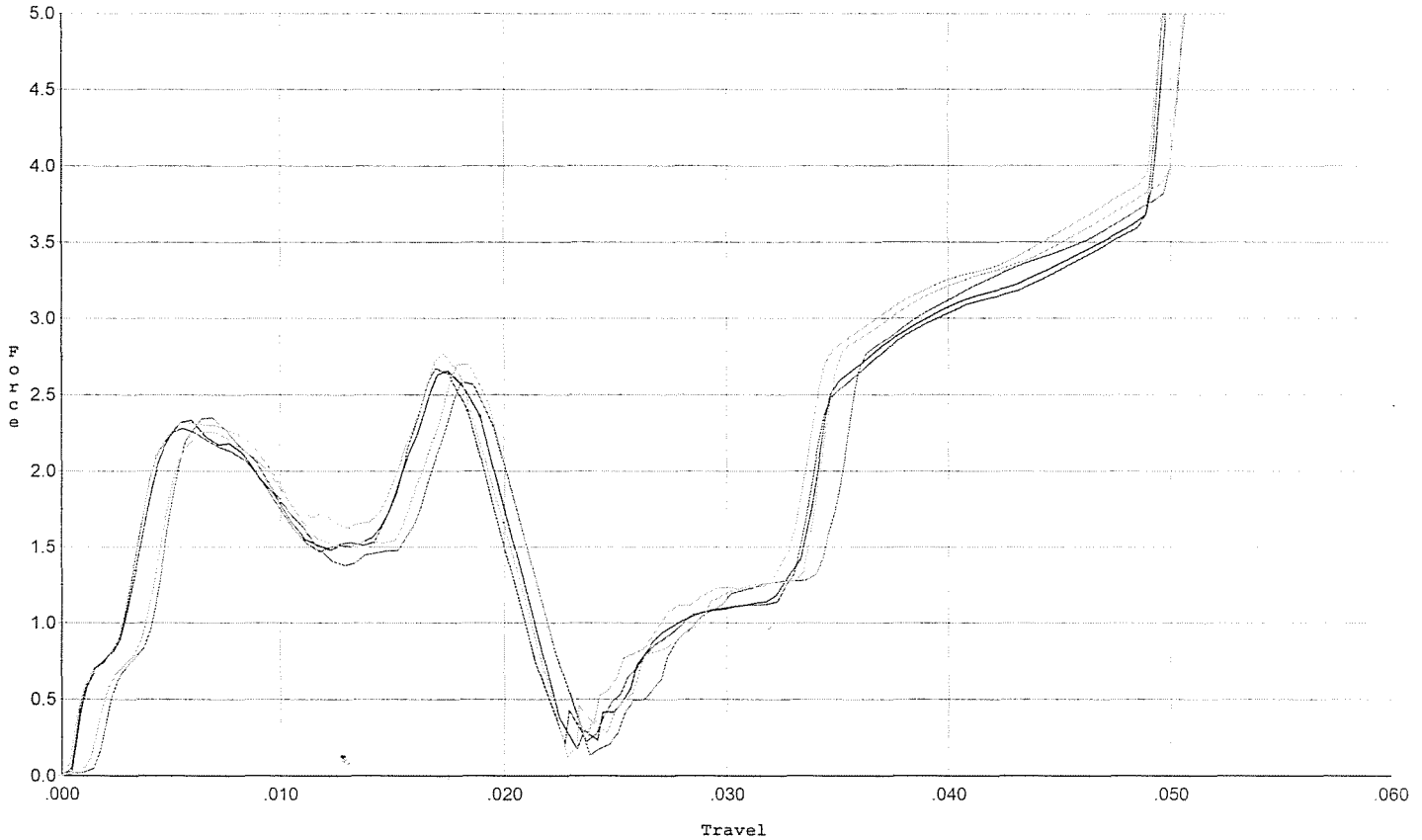
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	5-7-09	LJL		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>50</u>	<u>50</u>	<u>50</u>	5-7-09	LJL		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.024</u>	5-7-09	LJL		
	J) ASSEMBLE STOCK					4-20-09	LJL		
	K) ASSEMBLE SWIVEL STUDS					5-7-09	LJL		
	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		PASS	FAIL		4-21-09	WZ		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION			4-21-09	TCR		
660	INSPECT FOR LIVE AMMO								
670	FINAL INSPECTION A) HEADSPACE					5-7-09	LJL		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u>	<u>2.52</u>	<u>2.52</u>	<u>2.66</u>	<u>2.46</u>	4-22-09	WZ
	C) FUNCTION					5-7-09	LJL		
690	PACK					5/27/07	Fm		

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



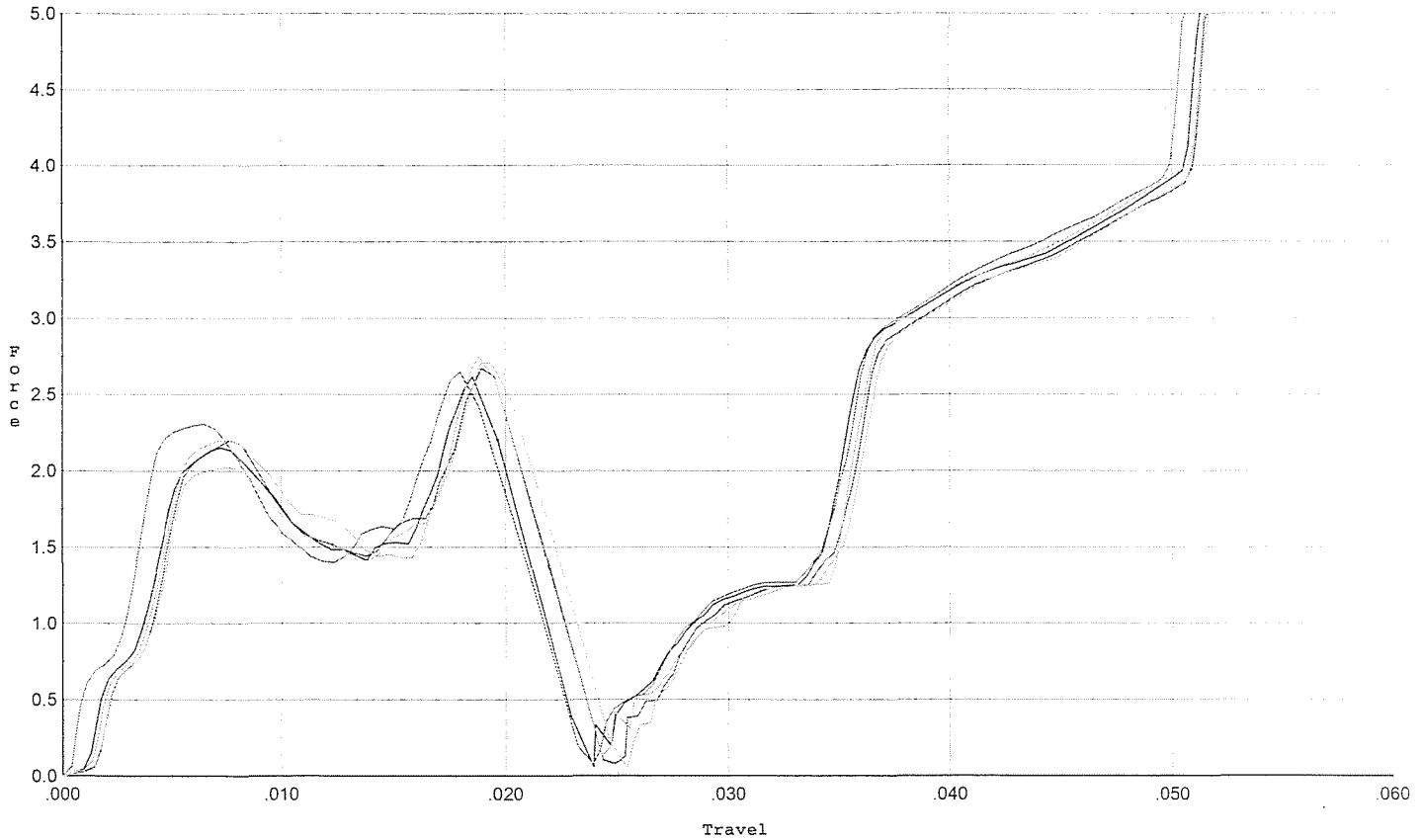
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.672	0.018	0.015	0.034	0.031		Set Trigger
2	2.657	0.019	0.015	0.034	0.032		Set Trigger
3	2.582	0.020	0.016	0.035	0.030		Set Trigger
4	2.699	0.019	0.015	0.034	0.031		Set Trigger
5	2.770	0.020	0.015	0.034	0.035		Set Trigger

A-2-67

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



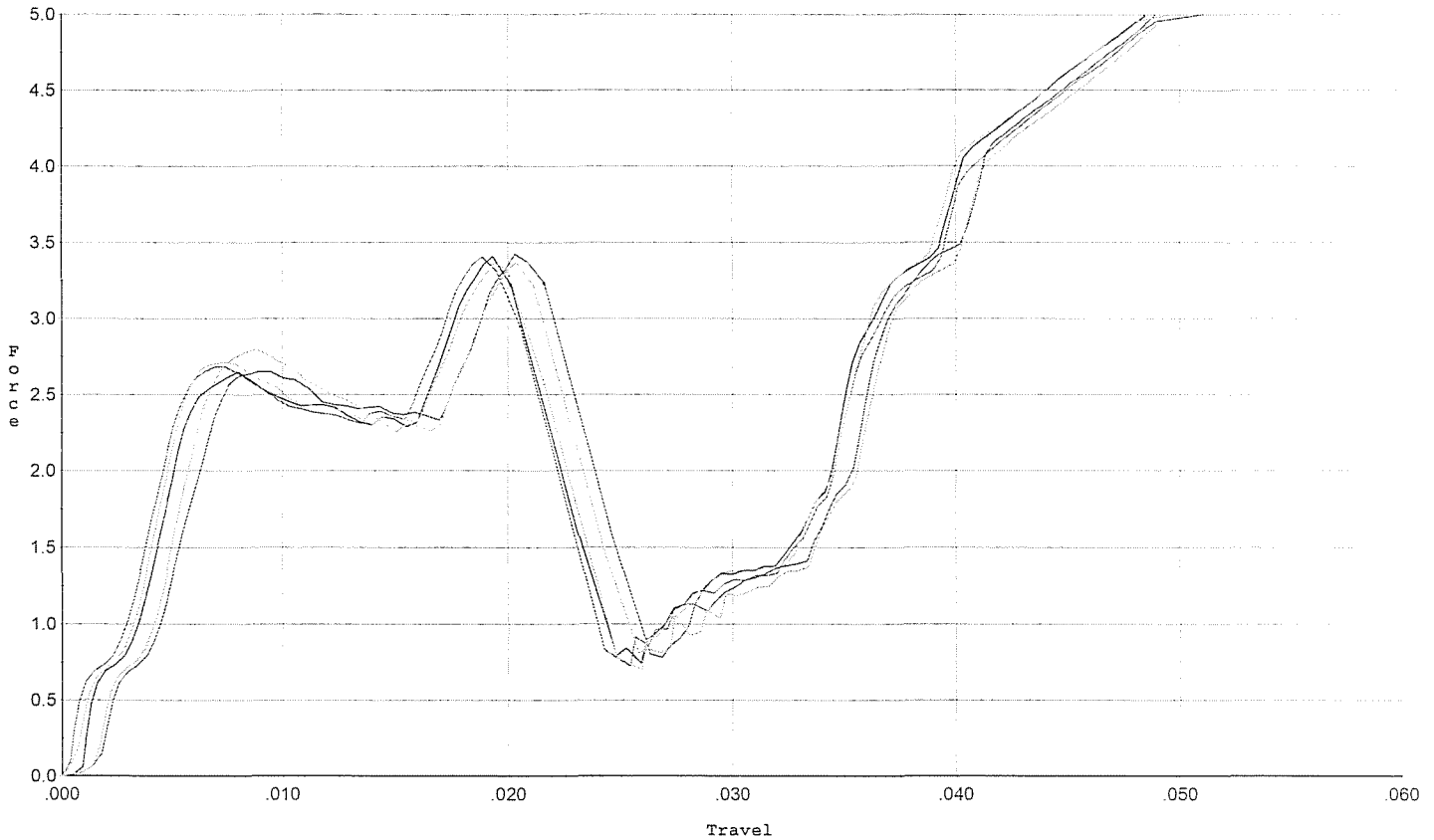
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.671	0.022	0.015	0.035	0.033		Set Trigger
2	2.616	0.020	0.014	0.035	0.030		Set Trigger
3	2.648	0.021	0.013	0.035	0.034		Set Trigger
4	2.703	0.022	0.015	0.035	0.034		Set Trigger
5	2.752	0.022	0.016	0.035	0.034		Set Trigger

A-2.67

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



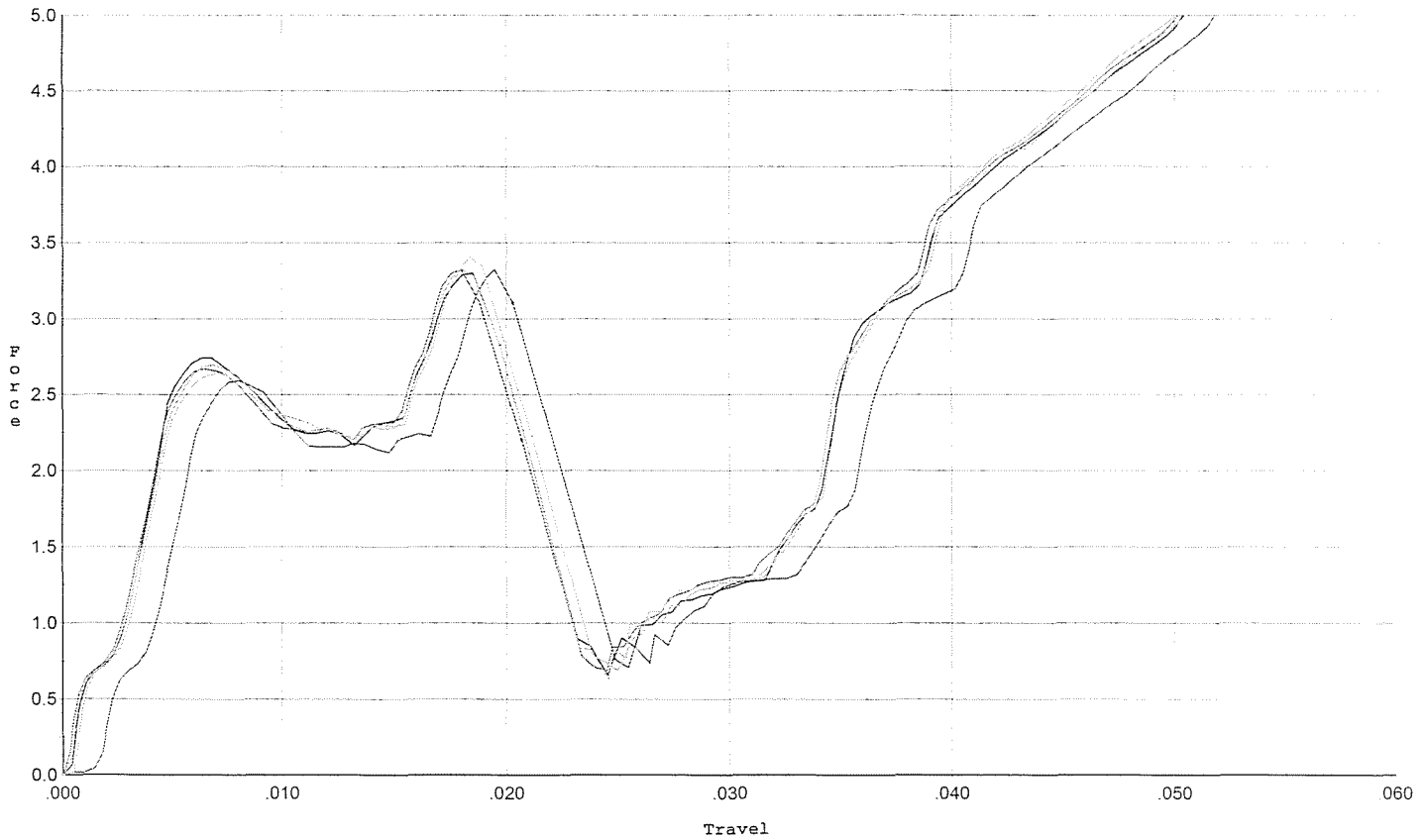
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.426	0.022	0.00	0.033	0.044		Set Trigger
2	3.410	0.020	0.00	0.033	0.042		Set Trigger
3	3.407	0.021	0.00	0.033	0.044		Set Trigger
4	3.367	0.022	0.00	0.033	0.046		Set Trigger
5	3.371	0.021	0.00	0.033	0.043		Set Trigger

A-3.39

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



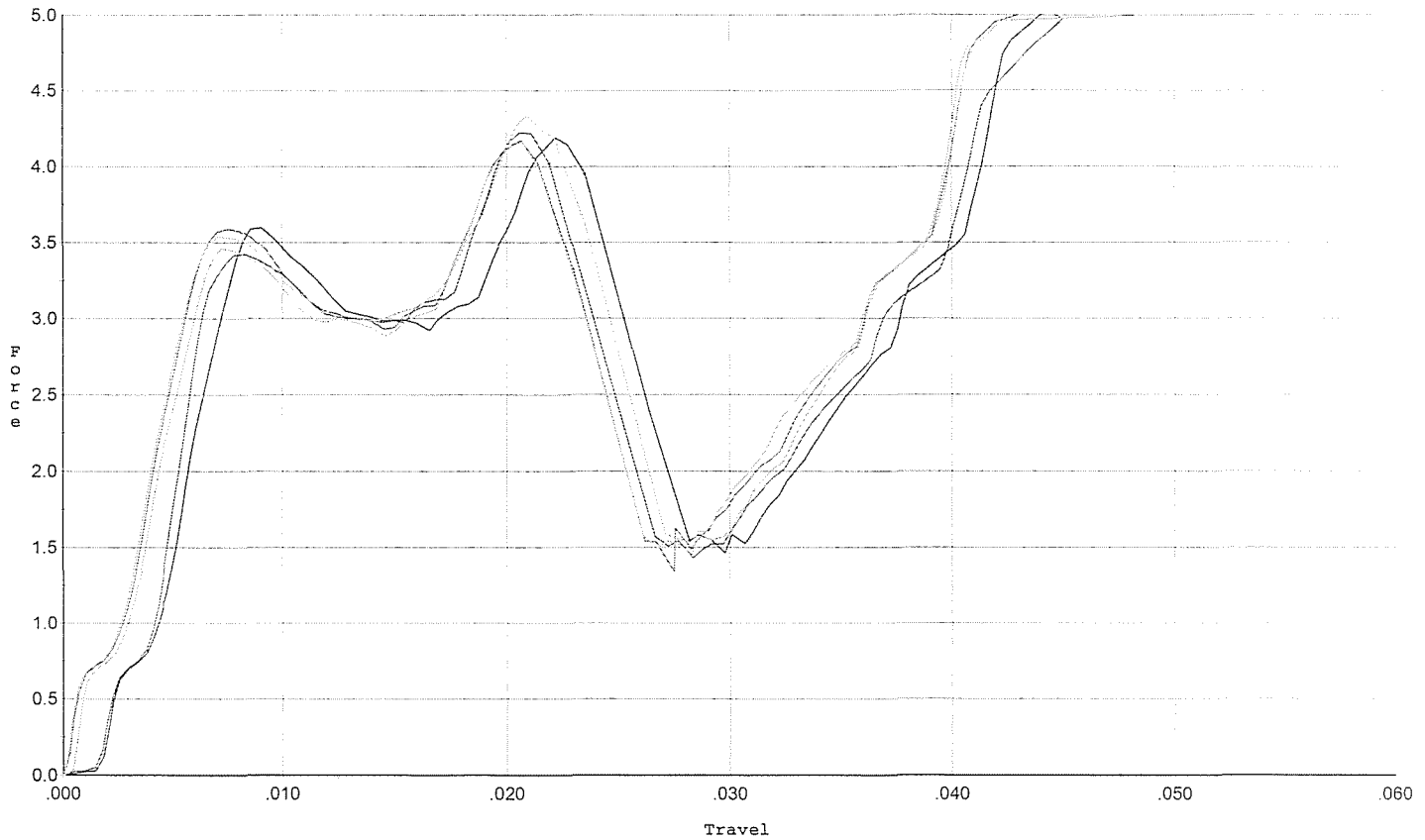
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.326	0.020	0.015	0.034	0.039		Set Trigger
2	3.299	0.020	0.00	0.033	0.041		Set Trigger
3	3.326	0.021	0.00	0.033	0.043		Set Trigger
4	3.331	0.020	0.00	0.034	0.041		Set Trigger
5	3.405	0.021	0.014	0.033	0.044		Set Trigger

A-3.33

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



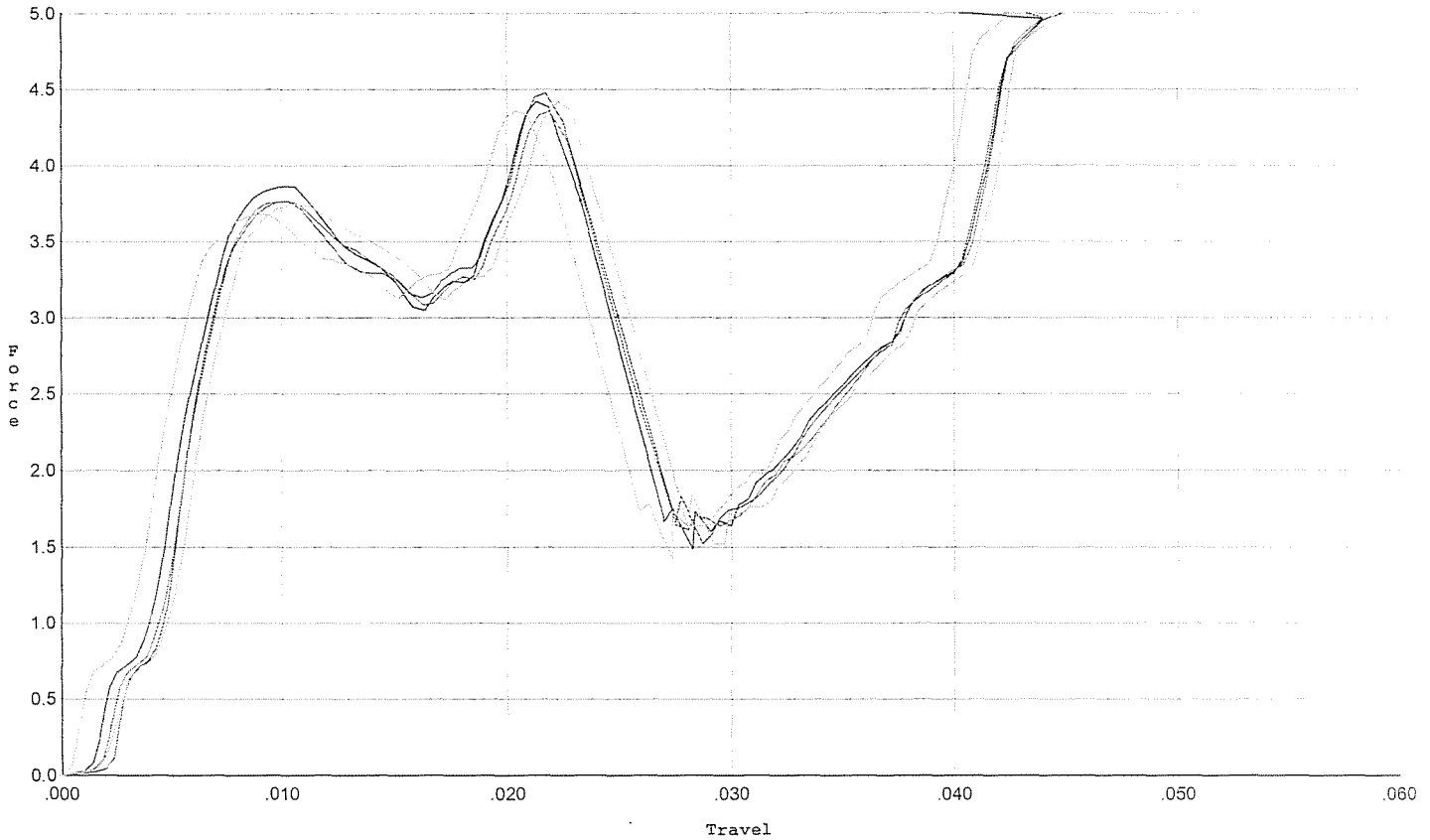
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.224	0.022	0.00	0.031	0.056		Set Trigger
2	4.191	0.023	0.00	0.030	0.060		Set Trigger
3	4.174	0.023	0.00	0.030	0.062		Set Trigger
4	4.164	0.023	0.00	0.030	0.062		Set Trigger
5	4.336	0.023	0.00	0.029	0.064		Set Trigger

A-4.21

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



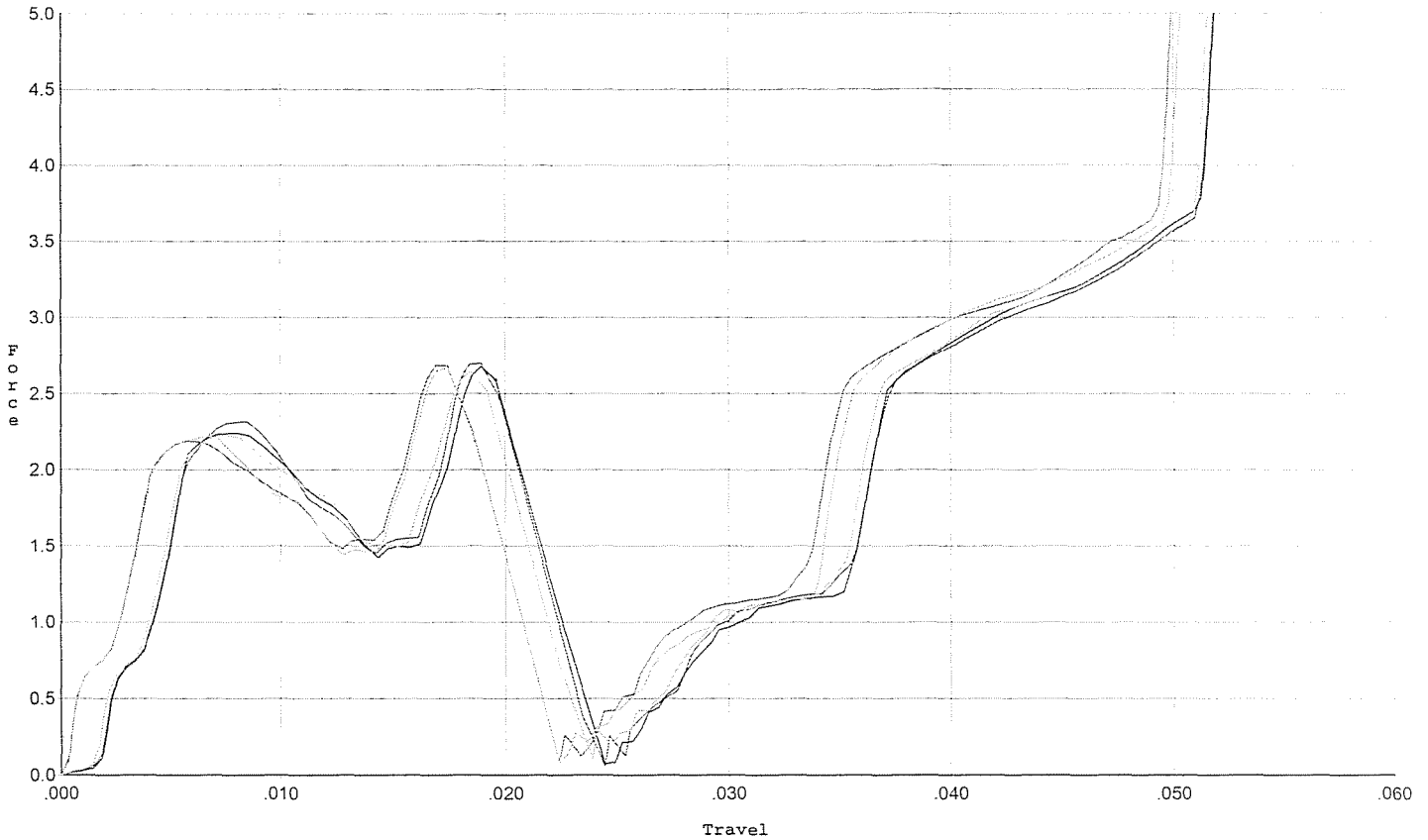
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.474	0.025	0.00	0.030	0.066		Set Trigger
2	4.420	0.023	0.00	0.030	0.063		Set Trigger
3	4.355	0.023	0.00	0.030	0.060		Set Trigger
4	4.421	0.025	0.00	0.030	0.067		Set Trigger
5	4.361	0.022	0.00	0.030	0.061		Set Trigger

A-4.40

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



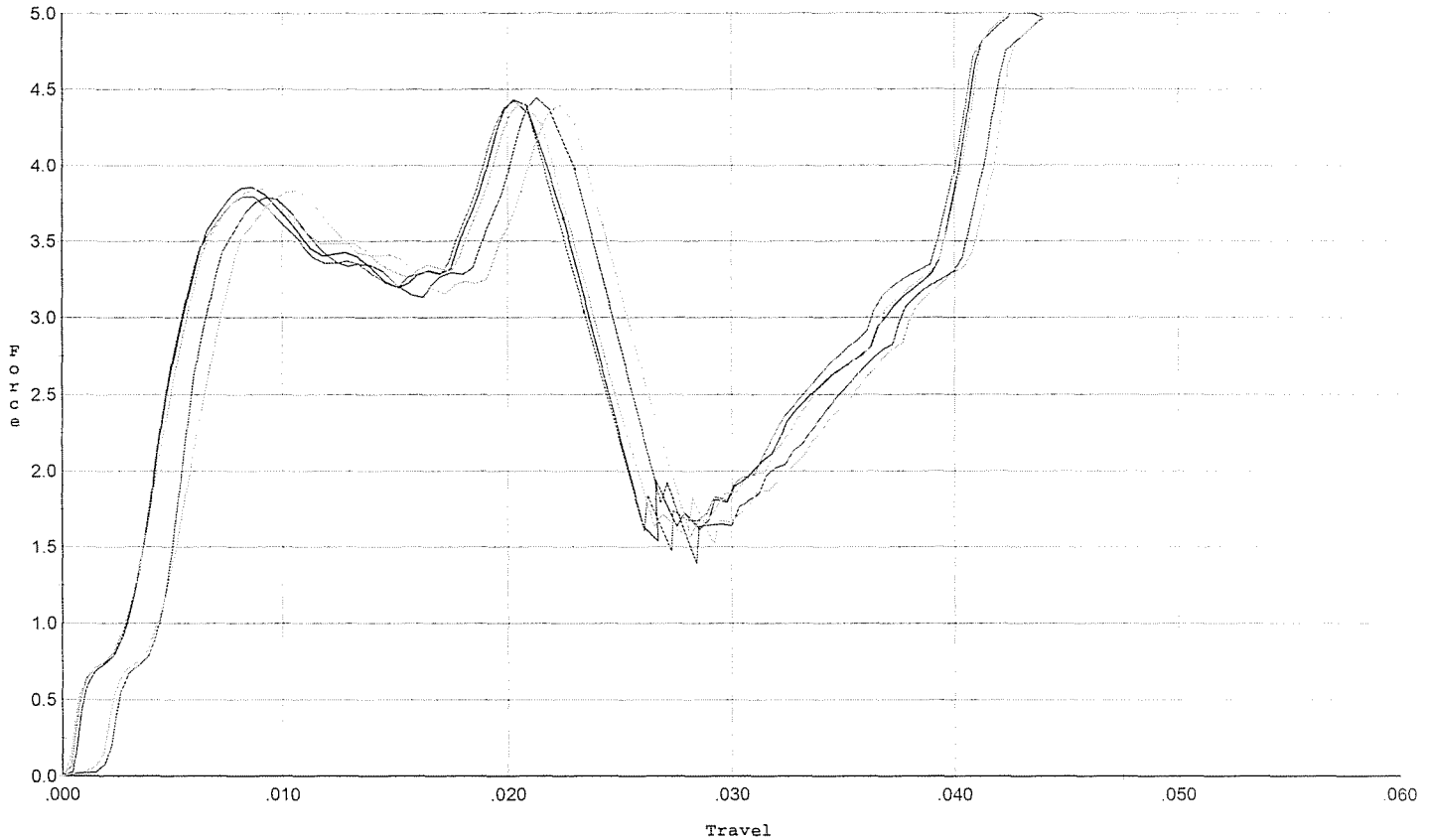
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.699	0.020	0.015	0.036	0.031		Set Trigger
2	2.675	0.020	0.015	0.036	0.031		Set Trigger
3	2.688	0.019	0.013	0.034	0.031		Set Trigger
4	2.643	0.019	0.016	0.036	0.030		Set Trigger
5	2.669	0.019	0.015	0.035	0.031		Set Trigger

A-2-67

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	4.444	0.023	0.002	0.030	0.062		Set Trigger
2	4.431	0.022	0.00	0.030	0.064		Set Trigger
3	4.420	0.023	0.00	0.030	0.066		Set Trigger
4	4.395	0.023	0.00	0.030	0.062		Set Trigger
5	4.409	0.022	0.00	0.030	0.061		Set Trigger

A. 4.42