

G6445305

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



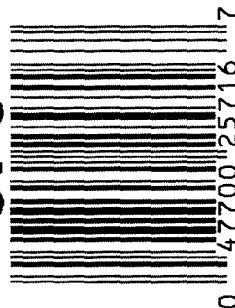
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845305

UPC



GUN SERIAL # 66845305

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	JP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>ND</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		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	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

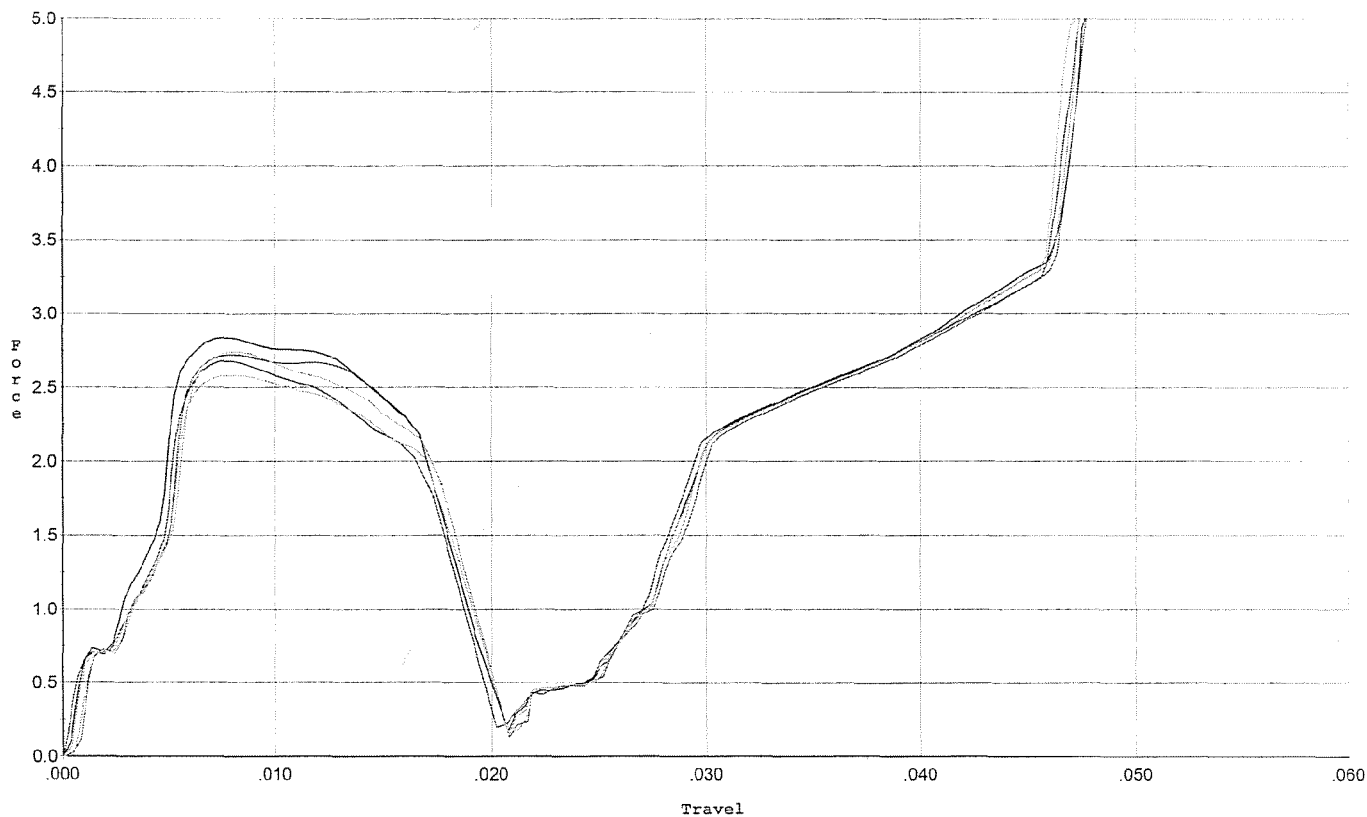
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6</u>	4-1-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-1-09	WV
	J) ASSEMBLE STOCK		3-31-09	RTZ
	K) ASSEMBLE SWIVEL STUDS		4-1-09	WV
	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	RPD
	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	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.70</u> <u>2.65</u> <u>2.65</u> <u>2.55</u> <u>2.46</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		4/9/09	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



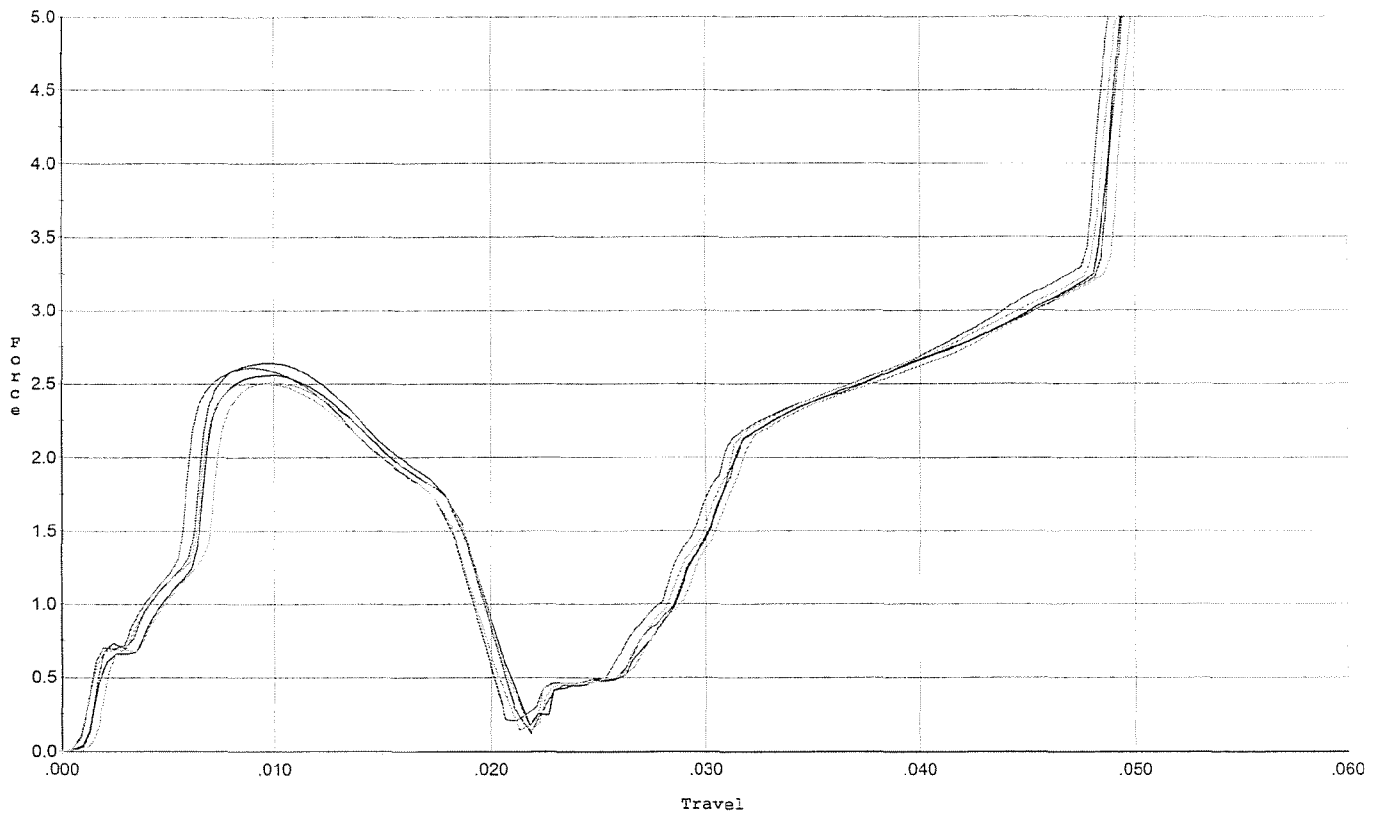
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.679	0.017	0.00	0.034	0.032		Set Trigger
2	2.836	0.017	0.00	0.034	0.033		Set Trigger
3	2.720	0.018	0.00	0.034	0.033		Set Trigger
4	2.583	0.018	0.00	0.033	0.033		Set Trigger
5	2.741	0.018	0.00	0.033	0.033		Set Trigger

A-2-71

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



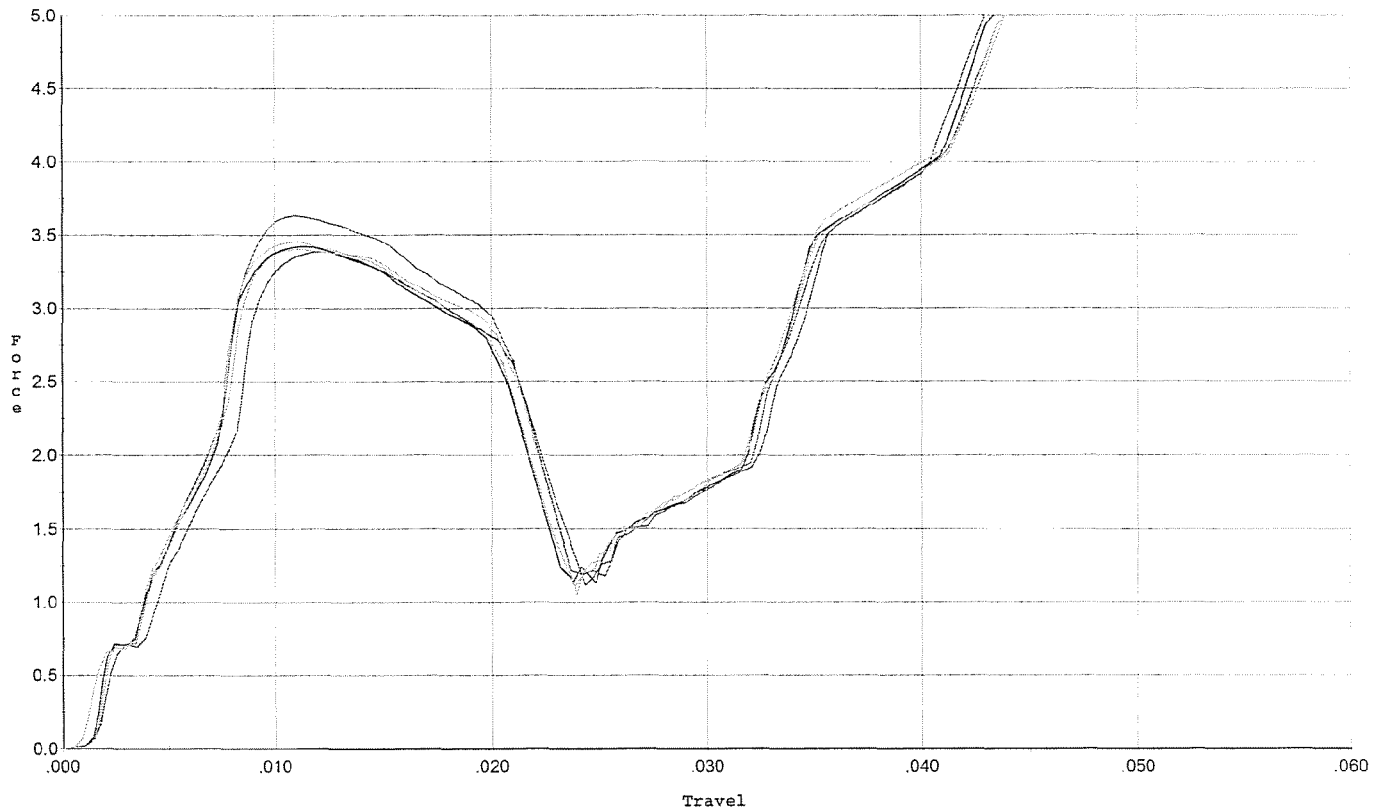
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.641	0.019	0.00	0.035	0.031		Set Trigger
2	2.561	0.019	0.00	0.035	0.030		Set Trigger
3	2.611	0.018	0.00	0.034	0.031		Set Trigger
4	2.509	0.018	0.00	0.035	0.029		Set Trigger
5	2.510	0.019	0.00	0.035	0.029		Set Trigger

A-2-56

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



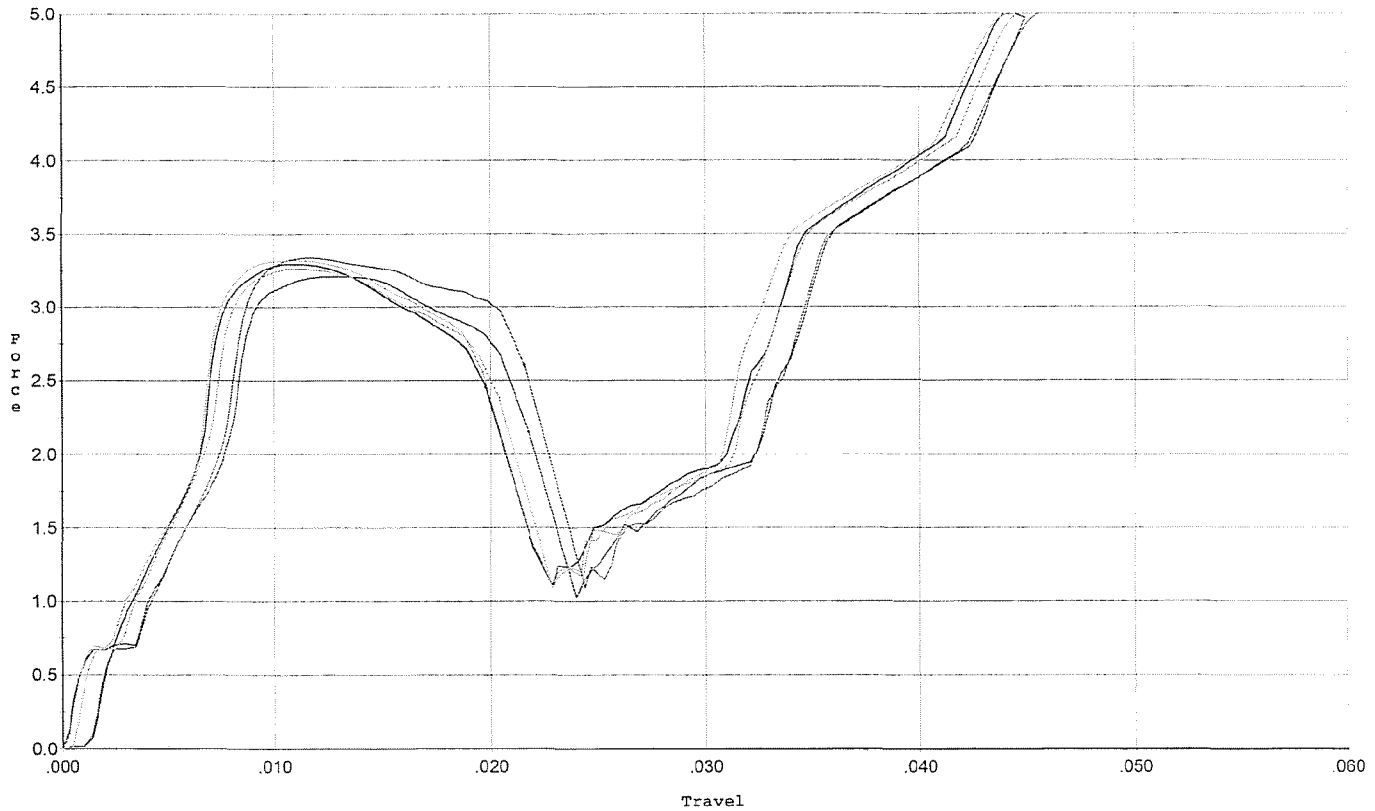
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.387	0.021	0.00	0.028	0.045		Set Trigger
2	3.424	0.021	0.00	0.028	0.046		Set Trigger
3	3.634	0.021	0.00	0.028	0.049		Set Trigger
4	3.452	0.021	0.00	0.028	0.046		Set Trigger
5	3.405	0.021	0.00	0.028	0.047		Set Trigger

A-3-46

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



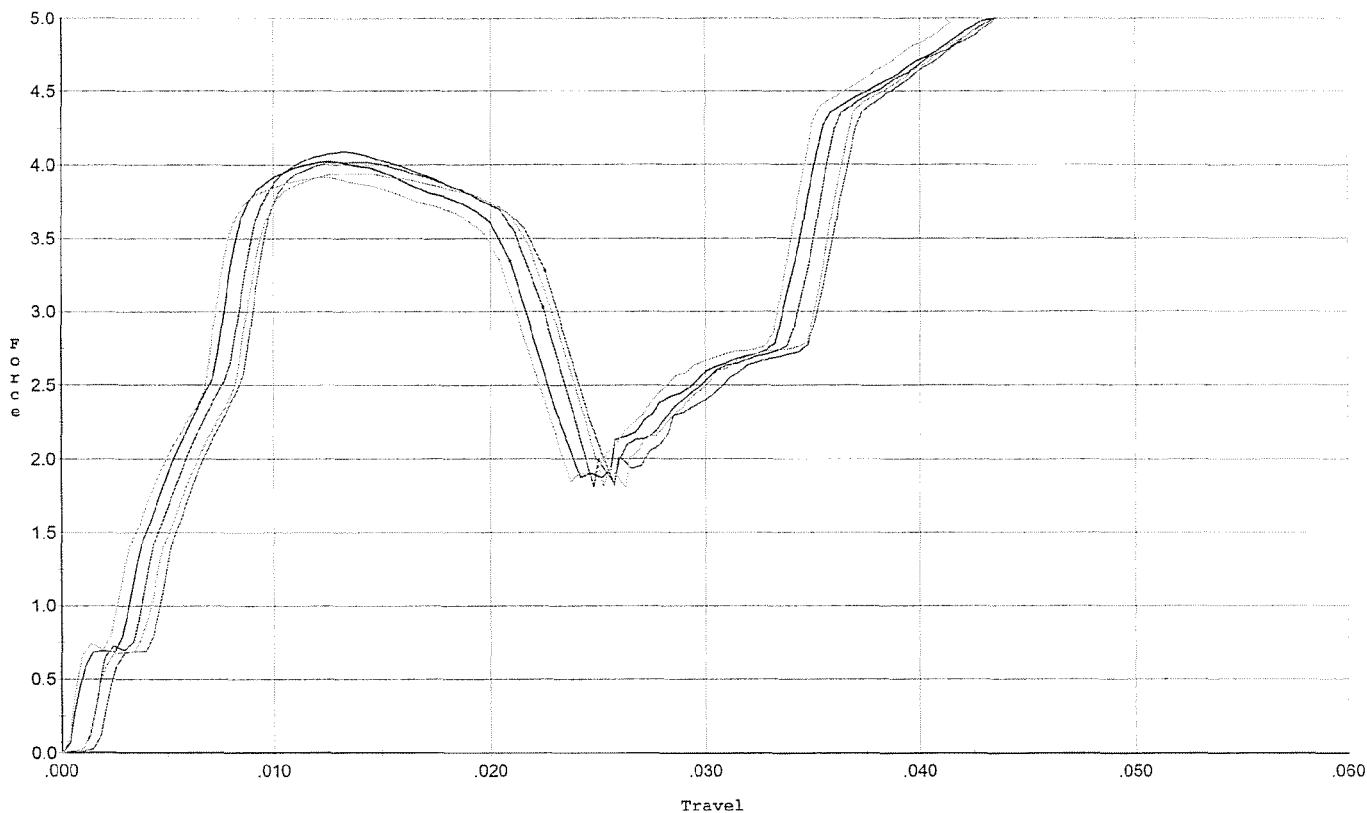
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.209	0.022	0.00	0.032	0.046		Set Trigger
2	3.296	0.020	0.00	0.032	0.044		Set Trigger
3	3.339	0.022	0.00	0.032	0.048		Set Trigger
4	3.320	0.020	0.00	0.031	0.044		Set Trigger
5	3.262	0.020	0.00	0.032	0.045		Set Trigger

A.3.28

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



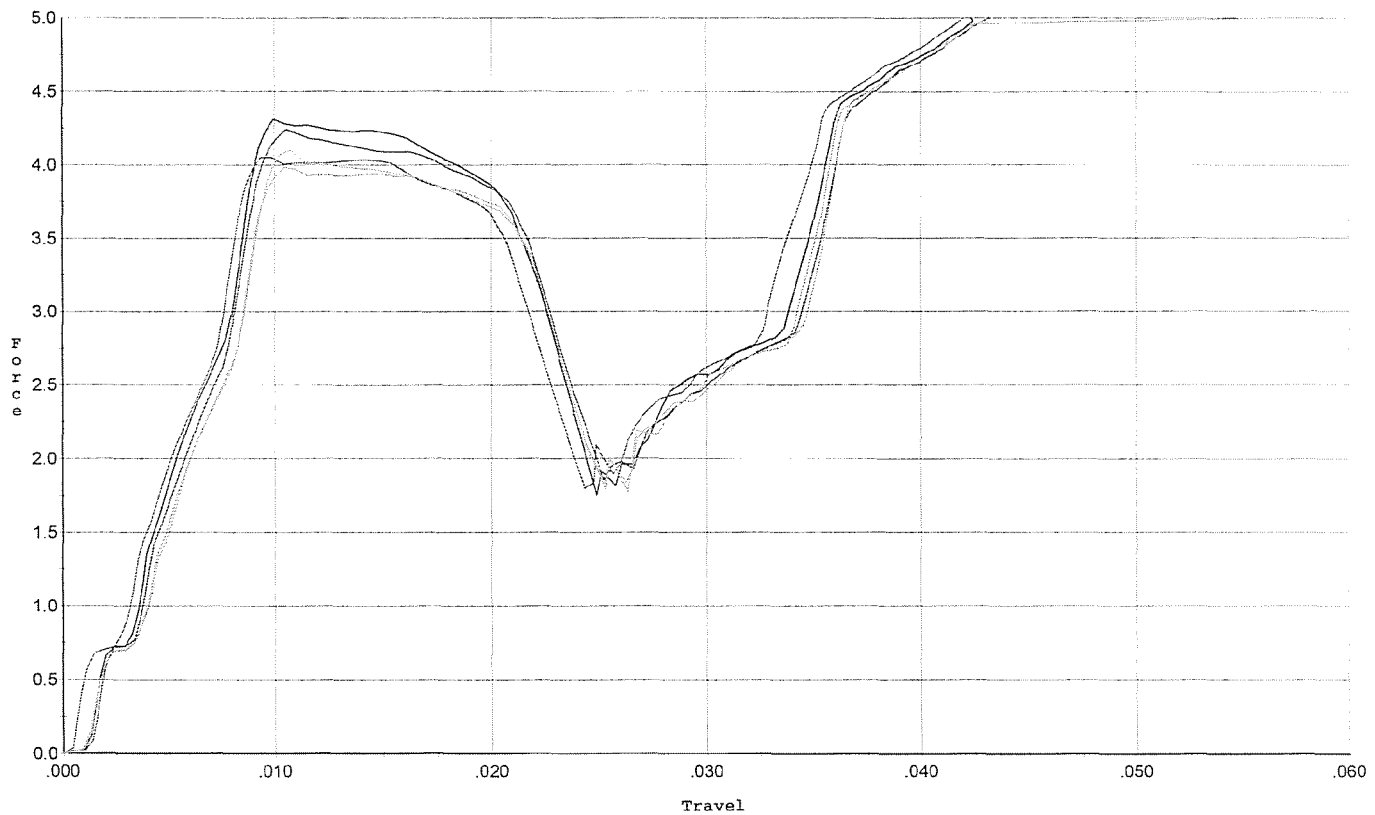
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.022	0.00	0.030	0.060		Set Trigger
2	4.021	0.021	0.00	0.030	0.057		Set Trigger
3	4.019	0.023	0.004	0.030	0.058		Set Trigger
4	3.916	0.020	0.00	0.030	0.055		Set Trigger
5	3.941	0.023	0.00	0.030	0.060		Set Trigger

A-3.99

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



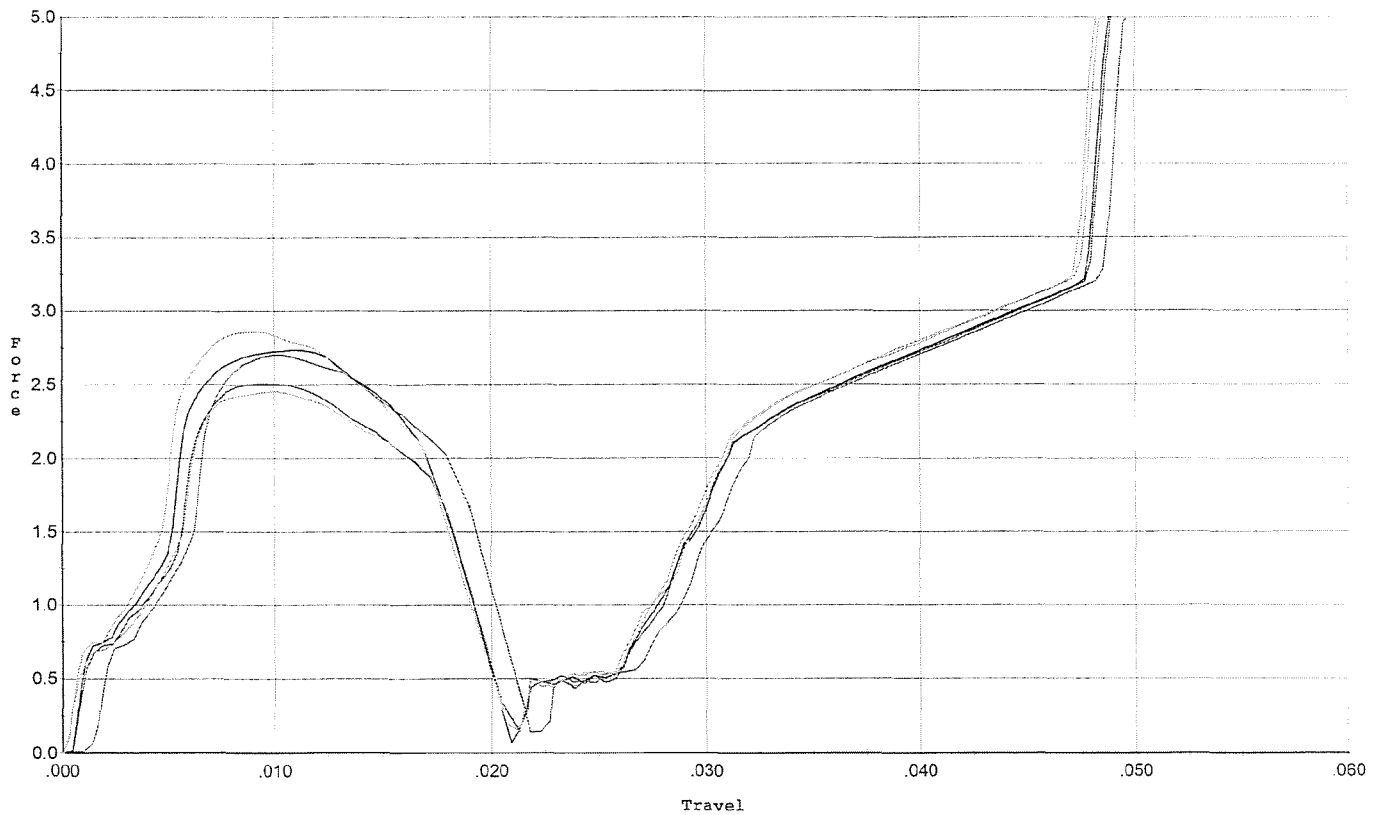
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.243	0.022	0.00	0.030	0.060		Set Trigger
2	4.315	0.022	0.00	0.029	0.063		Set Trigger
3	4.052	0.021	0.00	0.030	0.057		Set Trigger
4	4.104	0.022	0.00	0.030	0.058		Set Trigger
5	3.985	0.022	0.00	0.029	0.058		Set Trigger

A-4.14

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



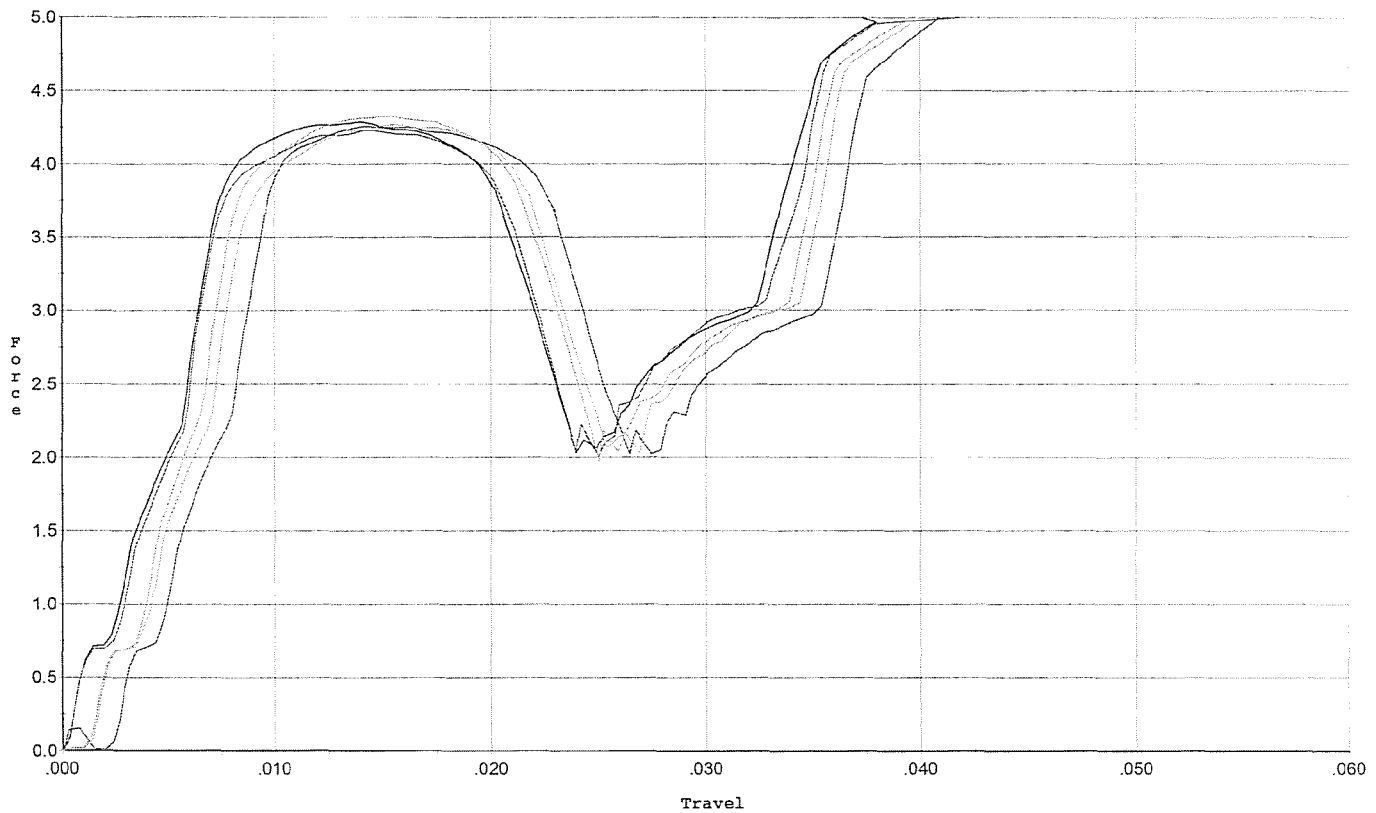
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.505	0.018	0.00	0.035	0.031		Set Trigger
2	2.735	0.018	0.00	0.035	0.034		Set Trigger
3	2.703	0.019	0.00	0.034	0.033		Set Trigger
4	2.861	0.017	0.00	0.034	0.033		Set Trigger
5	2.453	0.018	0.00	0.034	0.030		Set Trigger

A-2-65

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	4.254	0.023	0.003	0.026	0.063		Set Trigger
2	4.288	0.022	0.00	0.025	0.065		Set Trigger
3	4.229	0.021	0.00	0.026	0.062		Set Trigger
4	4.269	0.022	0.00	0.026	0.061		Set Trigger
5	4.327	0.022	0.00	0.025	0.065		Set Trigger

A = 4.27