

G6845309

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

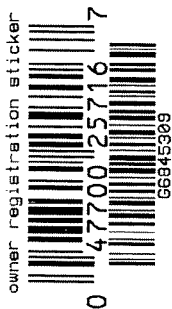
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



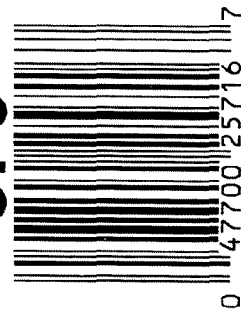
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845309

UPC



GUN SERIAL # G 6845309

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	RPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	RPD
460	CHECK HEADSPACE		3-17-09	RPD
470	DIS-ASSEMBLE ACTION		3-17-09	RPD
472	SERIALIZE BOLT HANDLE		3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3-22-09	
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	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	RTZ
	D) OIL FIRING PIN ASSEMBLY		3-30-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

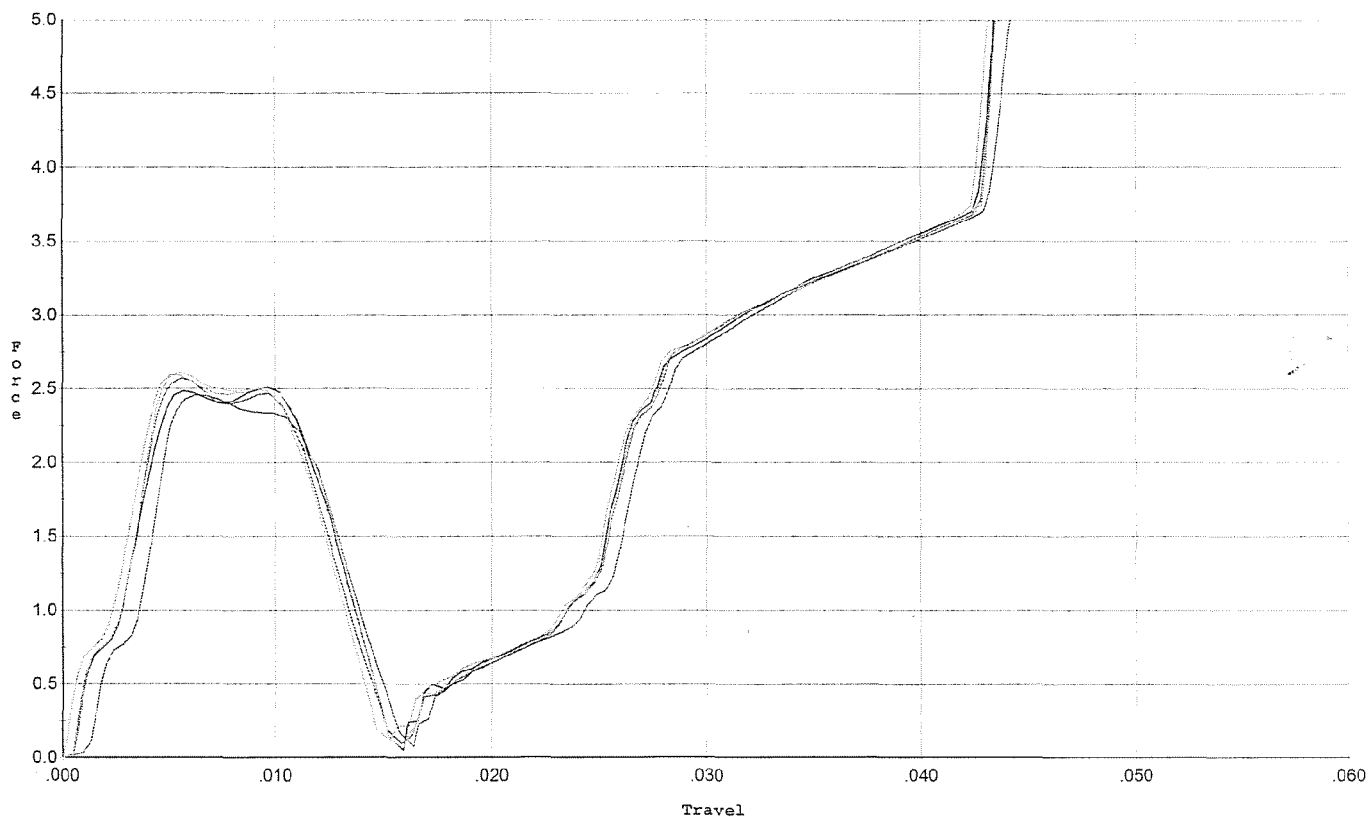
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>5.5</u> <u>5.5</u>	4-1-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-1-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	4-1-09	NW
	J) ASSEMBLE STOCK		3-31-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-2-09	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>2.33</u> <u>2.39</u> <u>2.31</u> <u>2.36</u> <u>2.40</u>	4-1-09	NW
	C) FUNCTION		4-1-09	NW
690	PACK		4/5/09	FM

F004 REV 5/2006

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



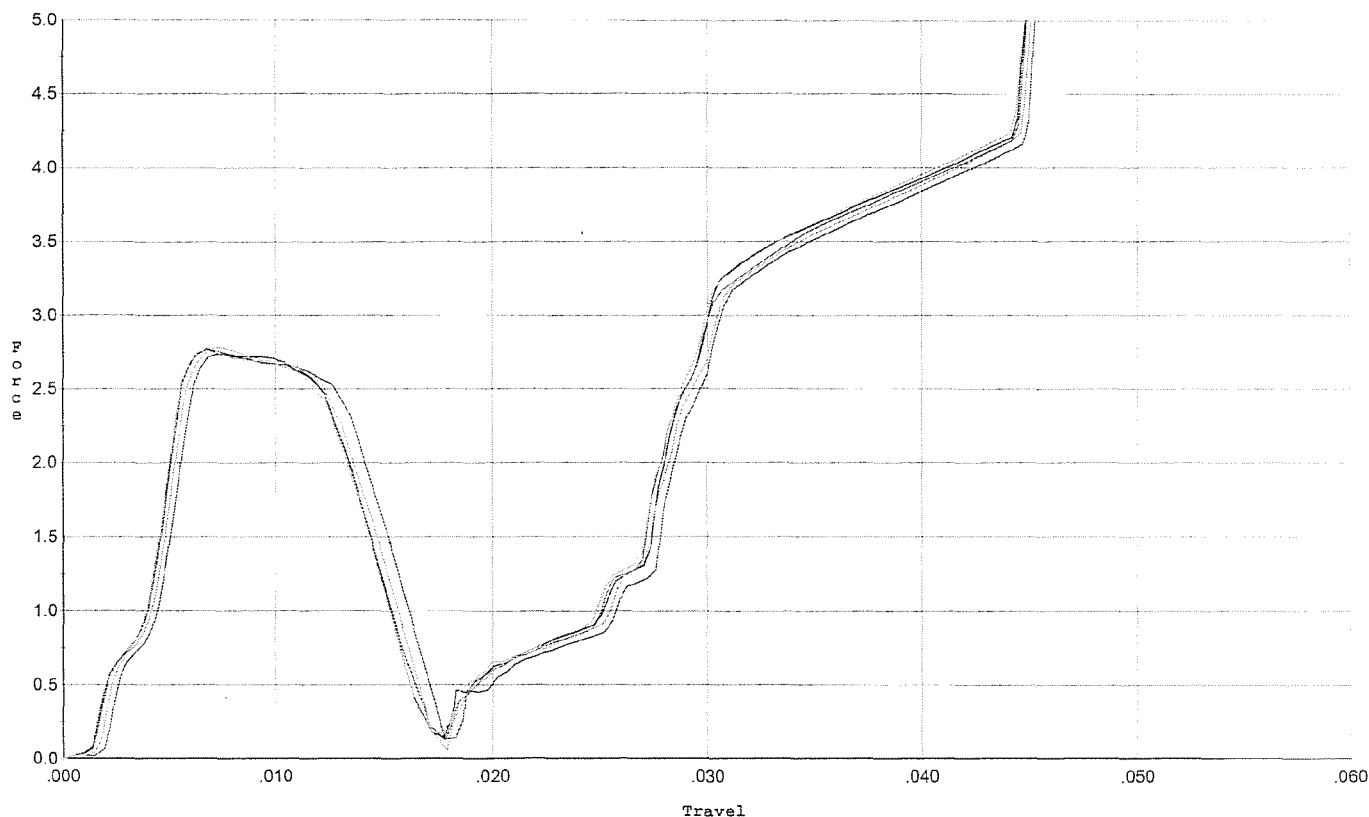
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.463	0.012	0.00	0.034	0.019		Set Trigger
2	2.516	0.012	0.00	0.033	0.021		Set Trigger
3	2.572	0.011	0.00	0.034	0.019		Set Trigger
4	2.612	0.012	0.00	0.034	0.021		Set Trigger
5	2.596	0.012	0.00	0.034	0.021		Set Trigger

A-2:55

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



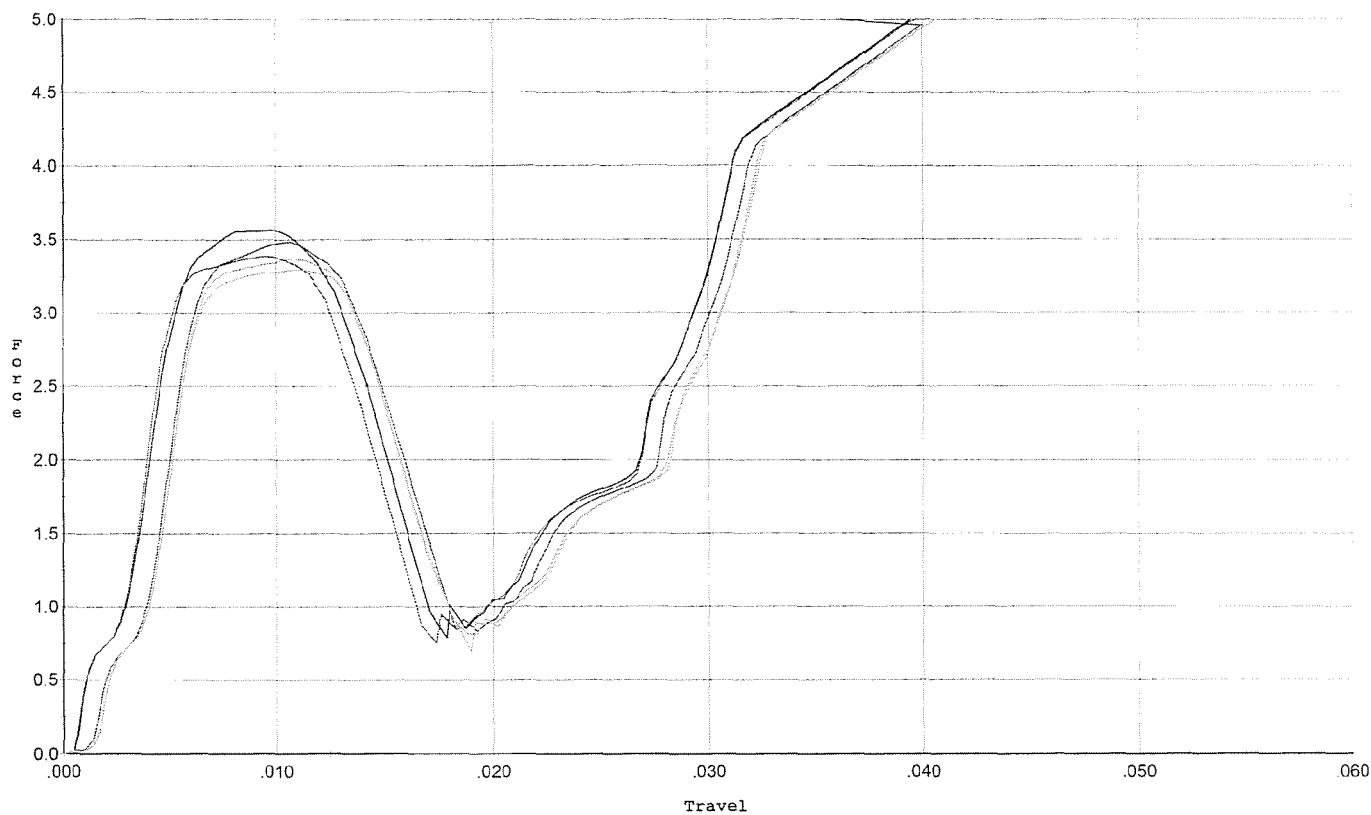
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.739	0.015	0.002	0.032	0.026		Set Trigger
2	2.770	0.014	0.00	0.033	0.023		Set Trigger
3	2.769	0.014	0.00	0.033	0.024		Set Trigger
4	2.780	0.014	0.00	0.033	0.024		Set Trigger
5	2.785	0.015	0.00	0.033	0.025		Set Trigger

A-2-76

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



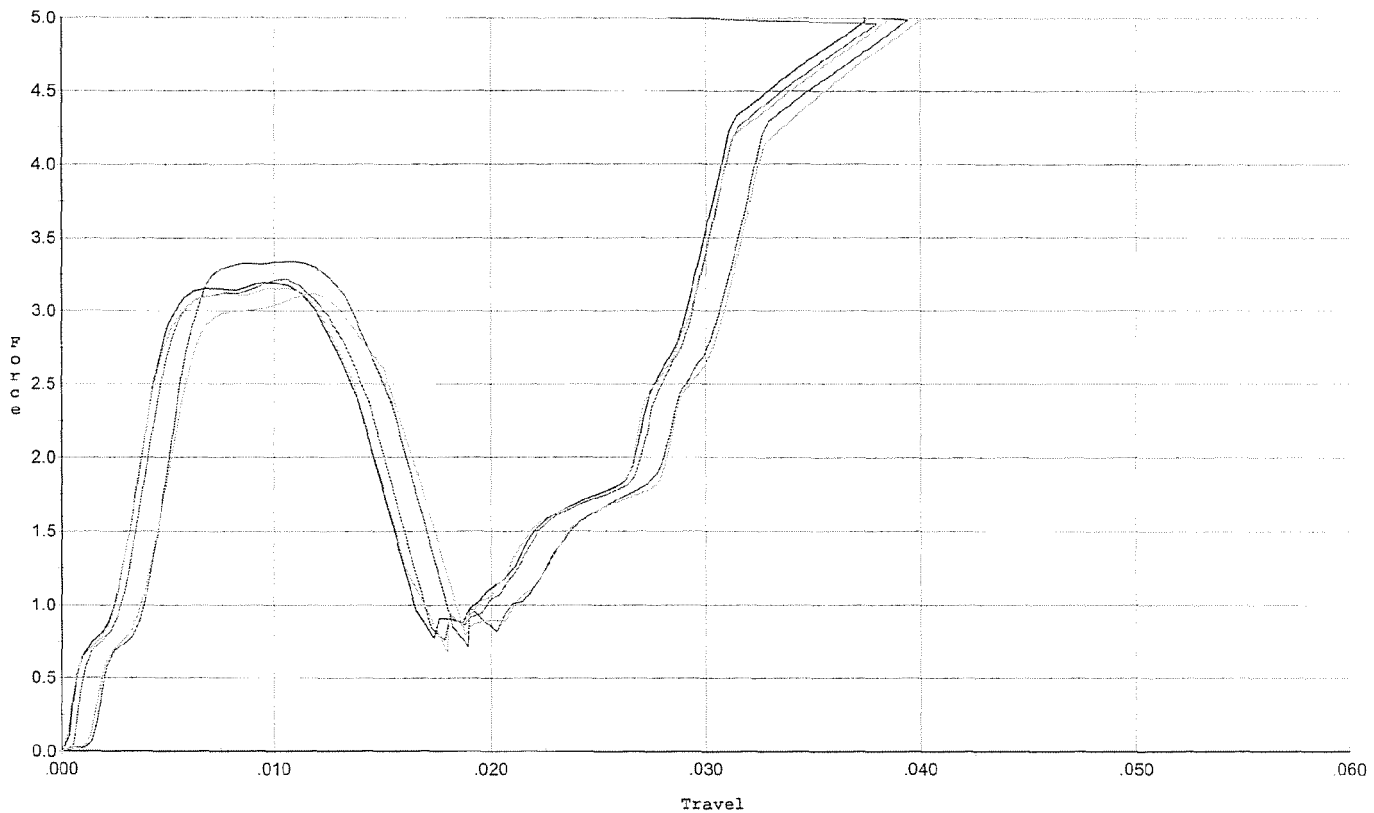
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.485	0.016	0.00	0.031	0.034		Set Trigger
2	3.564	0.014	0.00	0.030	0.033		Set Trigger
3	3.388	0.014	0.00	0.031	0.031		Set Trigger
4	3.297	0.014	0.00	0.031	0.030		Set Trigger
5	3.371	0.014	0.00	0.031	0.030		Set Trigger

A-3-42

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



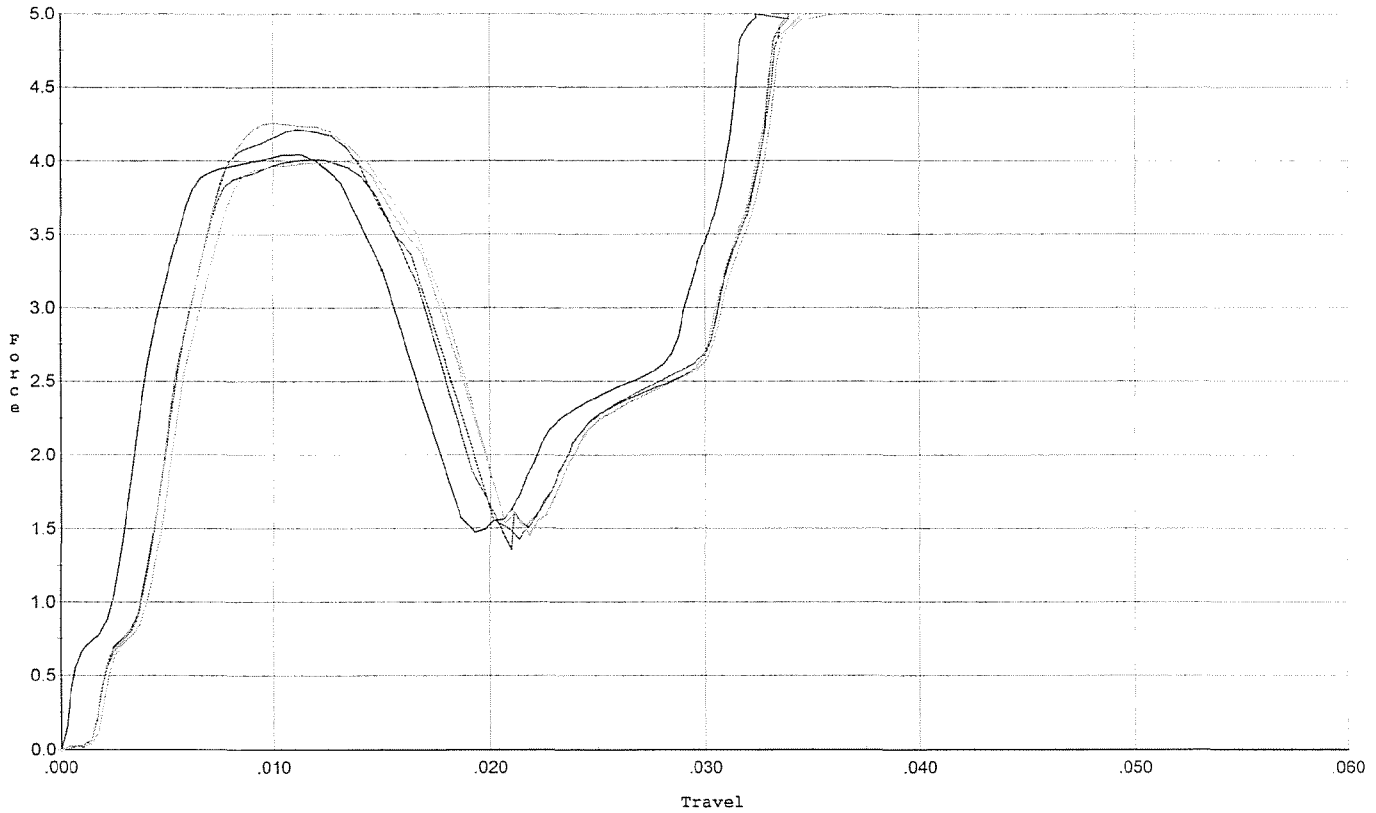
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.338	0.015	0.00	0.031	0.032		Set Trigger
2	3.194	0.014	0.00	0.030	0.030		Set Trigger
3	3.216	0.014	0.00	0.030	0.031		Set Trigger
4	3.154	0.014	0.00	0.030	0.030		Set Trigger
5	3.118	0.017	0.00	0.031	0.033		Set Trigger

A-3-20

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



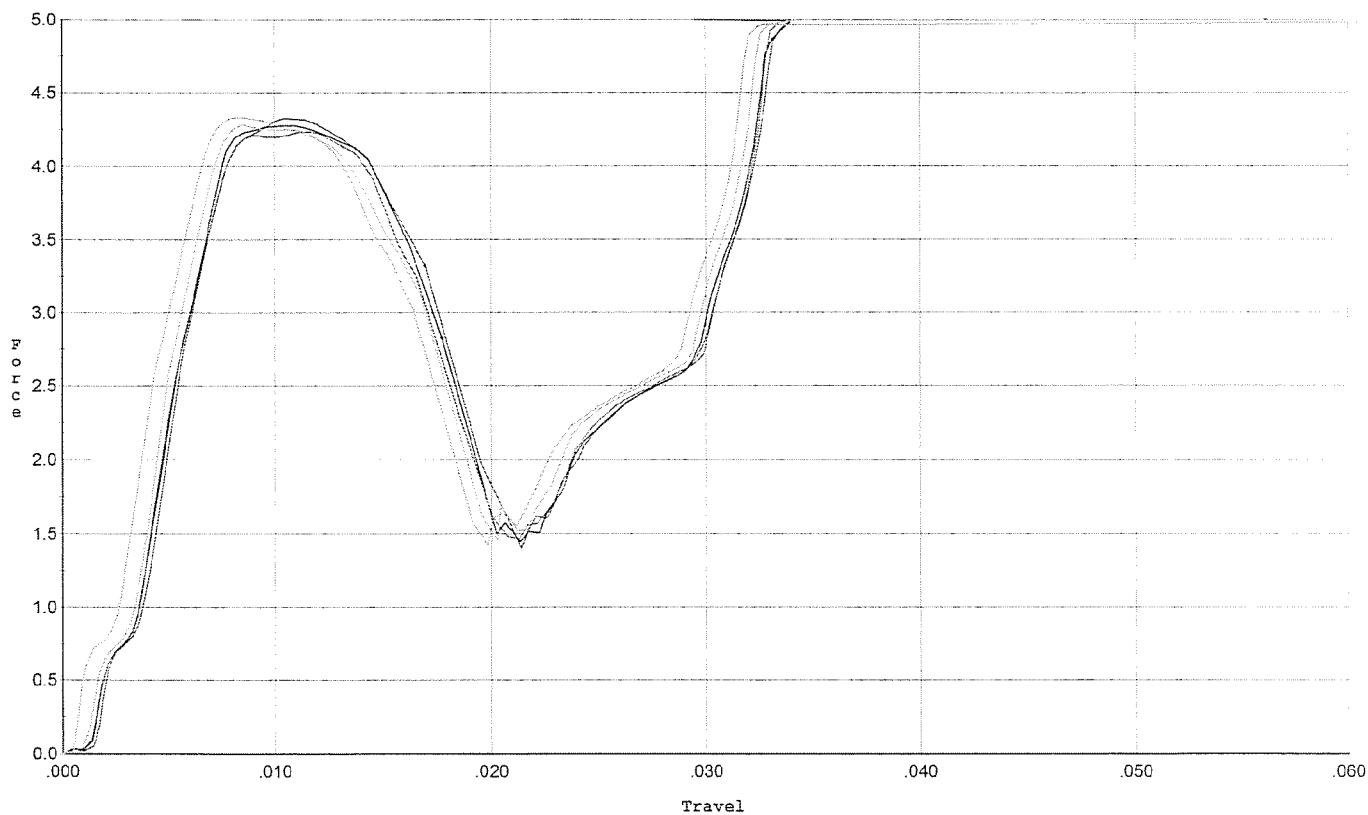
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.009	0.017	0.00	0.028	0.043		Set Trigger
2	4.042	0.015	0.00	0.028	0.041		Set Trigger
3	4.211	0.018	0.00	0.028	0.047		Set Trigger
4	3.996	0.019	0.00	0.027	0.047		Set Trigger
5	4.254	0.018	0.00	0.027	0.048		Set Trigger

A-4.10

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



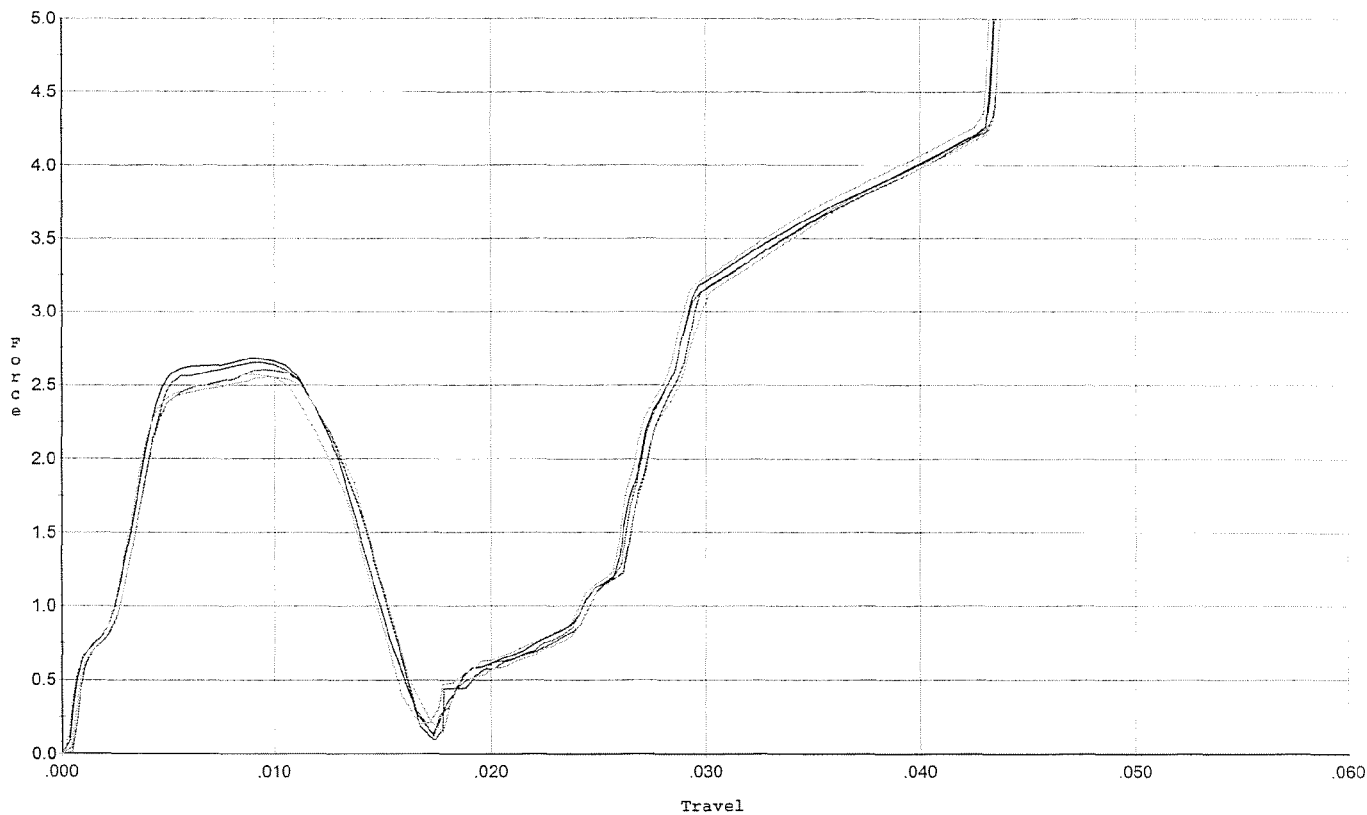
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.326	0.017	0.00	0.027	0.045		Set Trigger
2	4.277	0.018	0.00	0.027	0.047		Set Trigger
3	4.236	0.017	0.00	0.027	0.044		Set Trigger
4	4.287	0.017	0.00	0.027	0.045		Set Trigger
5	4.335	0.016	0.00	0.027	0.046		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

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

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



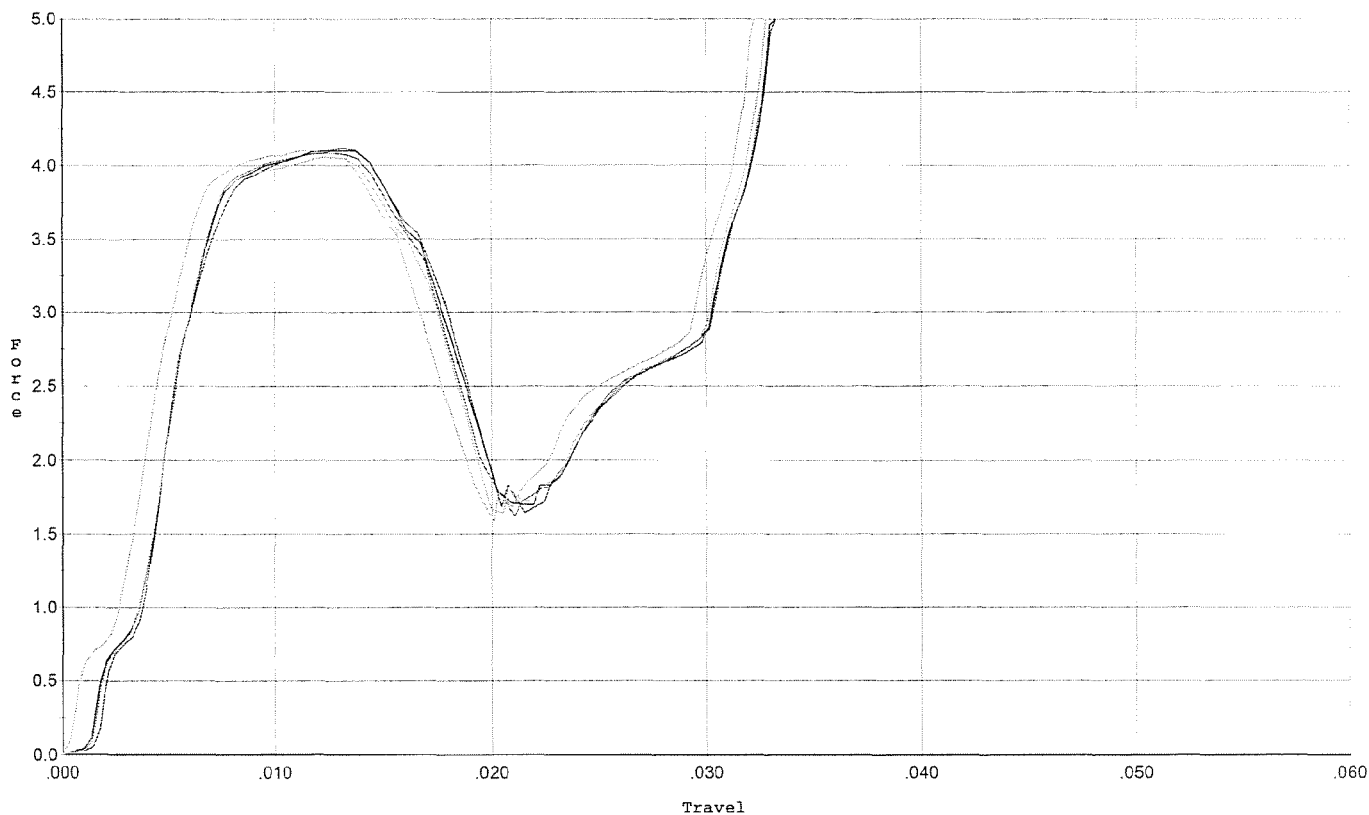
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.652	0.014	0.00	0.032	0.026		Set Trigger
2	2.684	0.013	0.00	0.032	0.024		Set Trigger
3	2.603	0.014	0.00	0.031	0.025		Set Trigger
4	2.553	0.014	0.00	0.032	0.025		Set Trigger
5	2.572	0.013	0.00	0.032	0.024		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

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

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	4.117	0.018	0.00	0.025	0.047		Set Trigger
2	4.102	0.018	0.00	0.025	0.049		Set Trigger
3	4.085	0.017	0.00	0.025	0.044		Set Trigger
4	4.059	0.017	0.00	0.024	0.045		Set Trigger
5	4.101	0.016	0.00	0.025	0.043		Set Trigger

A-4.09