

G-6845315

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



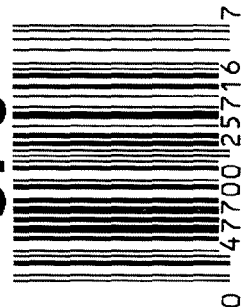
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845315

UPC



GUN SERIAL # 66845315

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SP
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SP
460	CHECK HEADSPACE		3-17-09	SP
470	DIS-ASSEMBLE ACTION		3-17-09	SP
472	SERIALIZE BOLT HANDLE		3-18-09	RIC
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION		3/20/09	(D)
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		4-9-09	R.N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

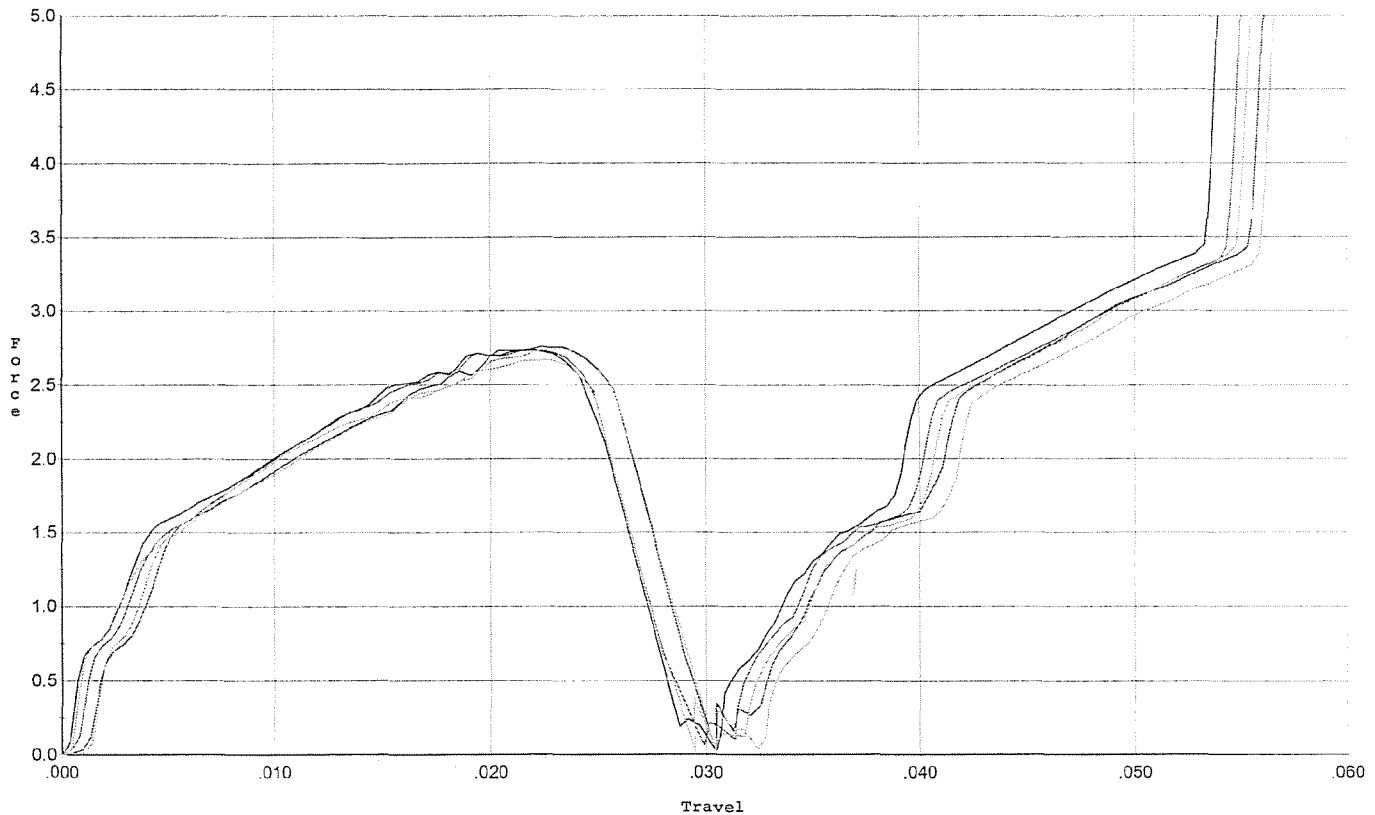
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8</u> <u>8</u> <u>8</u>	4-17-09	NW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-17-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	4-17-09	NW
	J) ASSEMBLE STOCK		4-9-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-17-09	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	4-14-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-14-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-17-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.47</u> <u>2.50</u> <u>2.48</u> <u>2.54</u>	4-16-09	RP
	C) FUNCTION		4-17-09	NW
690	PACK		6/1/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



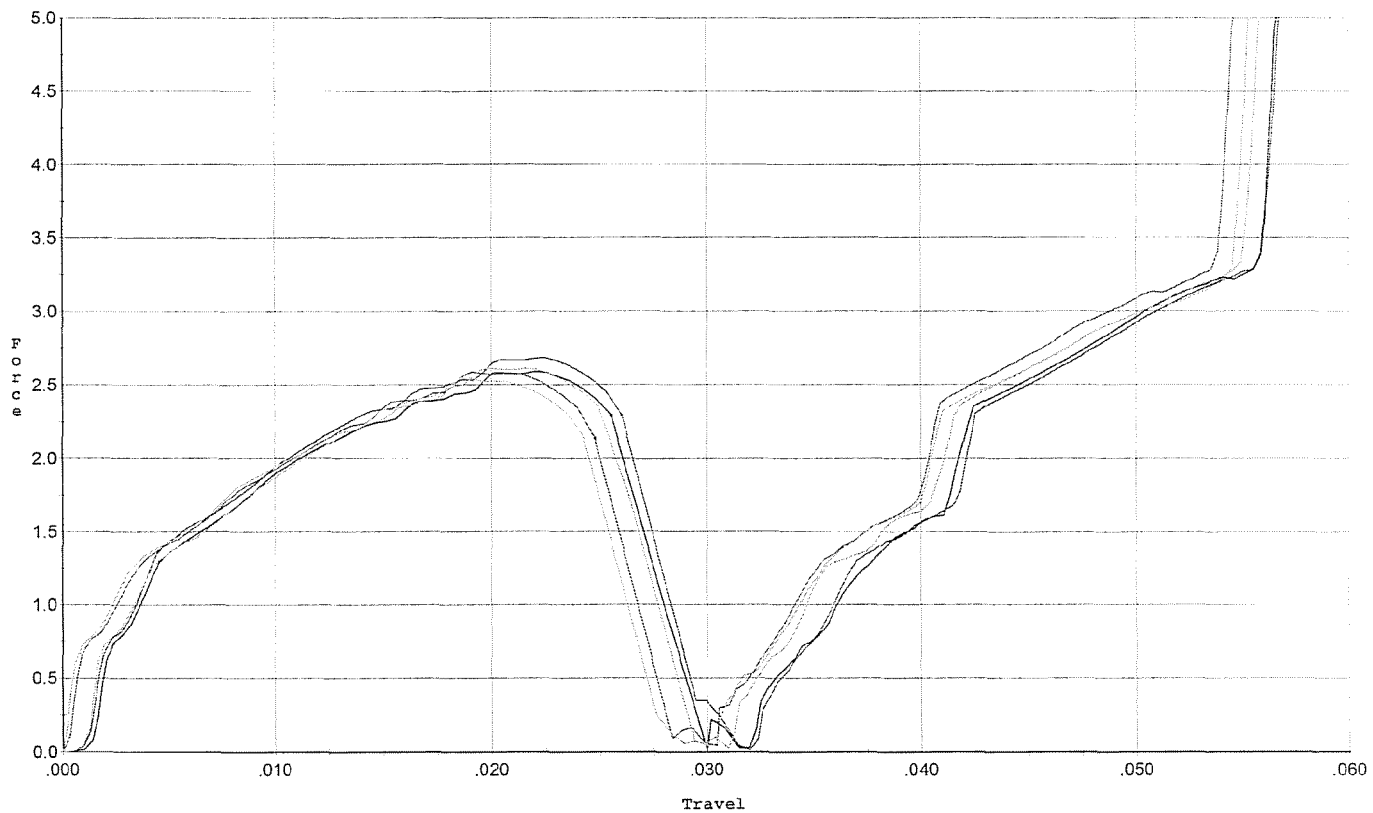
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.758	0.026	0.00	0.035	0.048		Set Trigger
2	2.734	0.025	0.00	0.034	0.049		Set Trigger
3	2.739	0.025	0.00	0.034	0.048		Set Trigger
4	2.670	0.025	0.00	0.035	0.047		Set Trigger
5	2.742	0.026	0.00	0.036	0.048		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



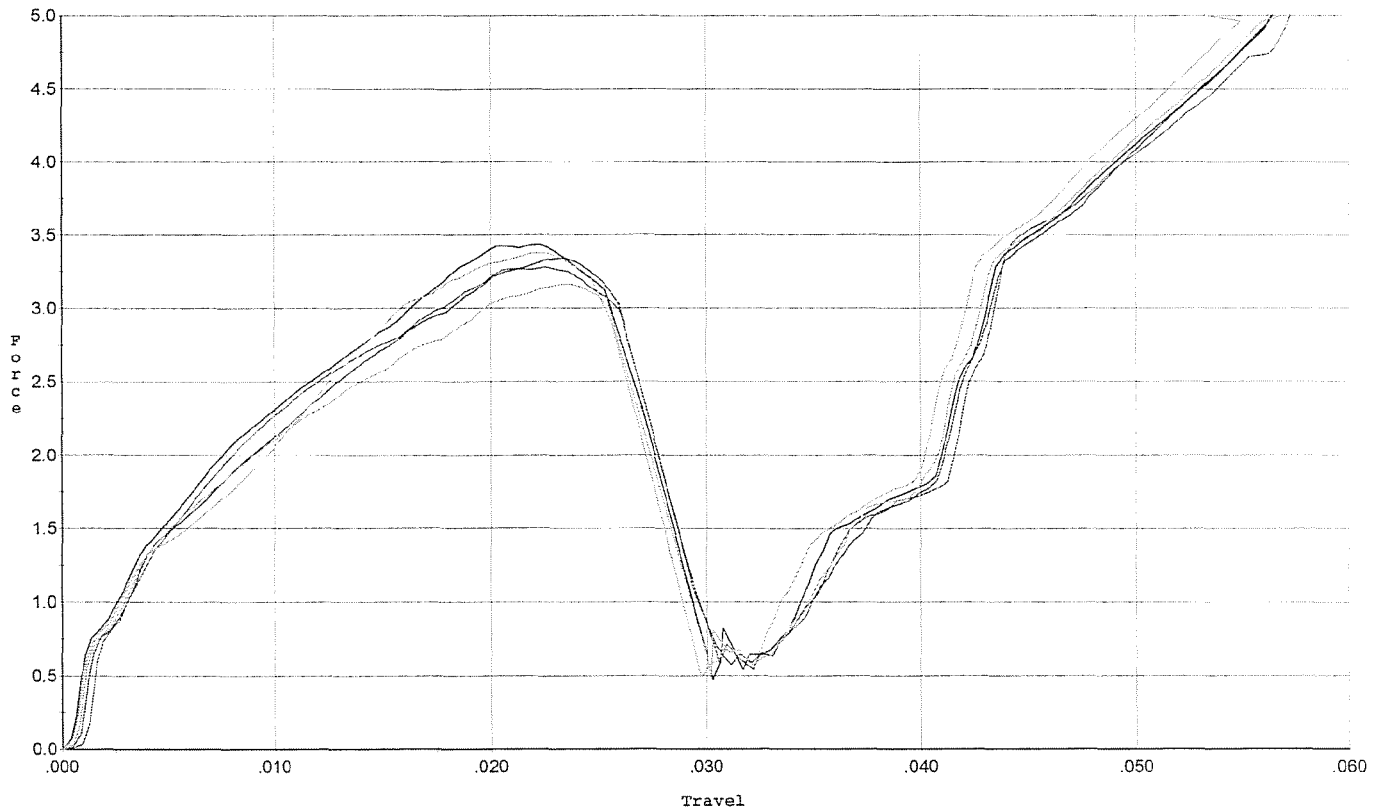
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.683	0.026	0.00	0.036	0.049		Set Trigger
2	2.590	0.026	0.00	0.036	0.046		Set Trigger
3	2.588	0.025	0.00	0.035	0.046		Set Trigger
4	2.550	0.024	0.00	0.036	0.045		Set Trigger
5	2.612	0.026	0.00	0.035	0.048		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



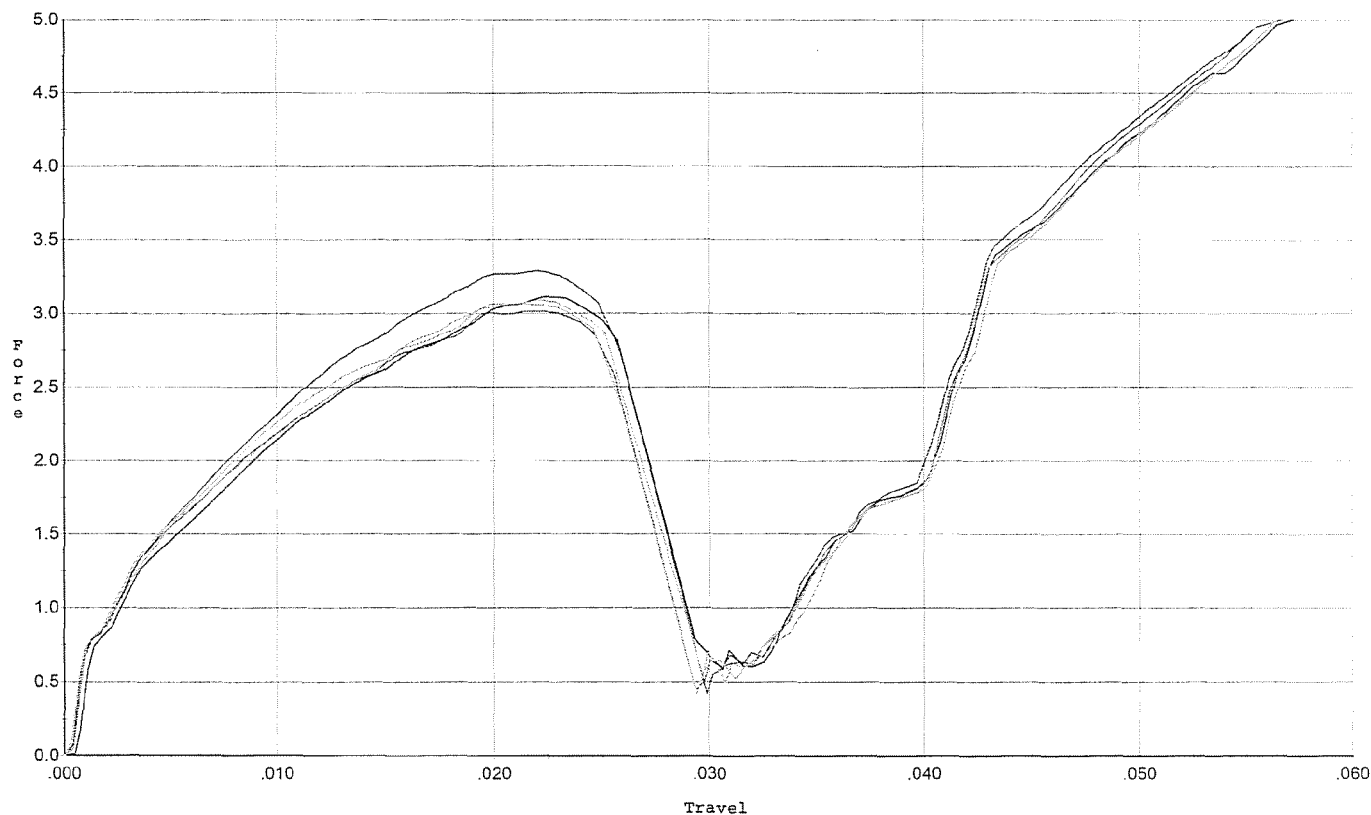
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.342	0.026	0.00	0.035	0.057		Set Trigger
2	3.436	0.027	0.00	0.034	0.062		Set Trigger
3	3.284	0.026	0.00	0.035	0.057		Set Trigger
4	3.377	0.026	0.00	0.034	0.057		Set Trigger
5	3.162	0.028	0.00	0.034	0.059		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



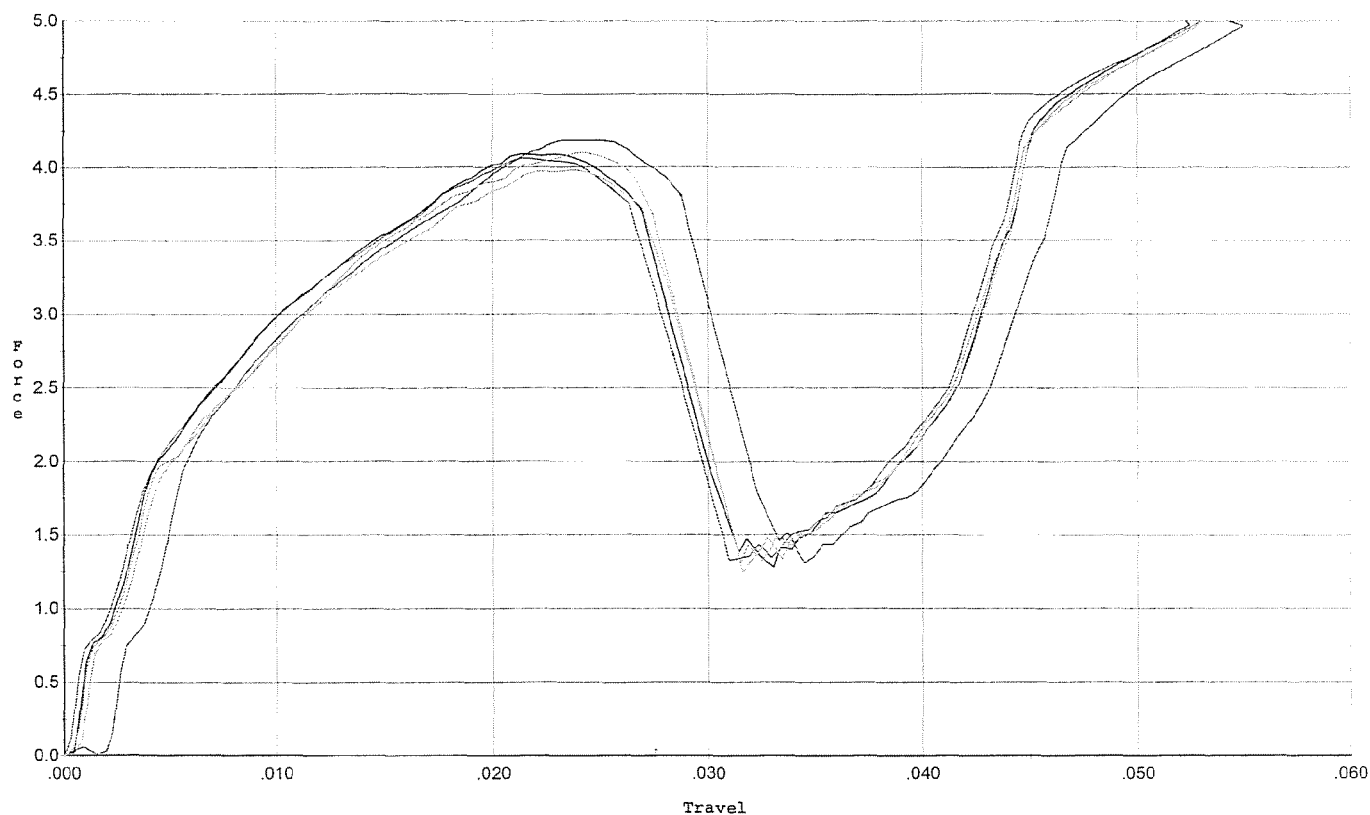
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.290	0.026	0.00	0.034	0.059		Set Trigger
2	3.111	0.026	0.00	0.035	0.055		Set Trigger
3	3.014	0.026	0.00	0.035	0.054		Set Trigger
4	3.062	0.026	0.00	0.035	0.055		Set Trigger
5	3.086	0.025	0.00	0.035	0.054		Set Trigger

A-3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



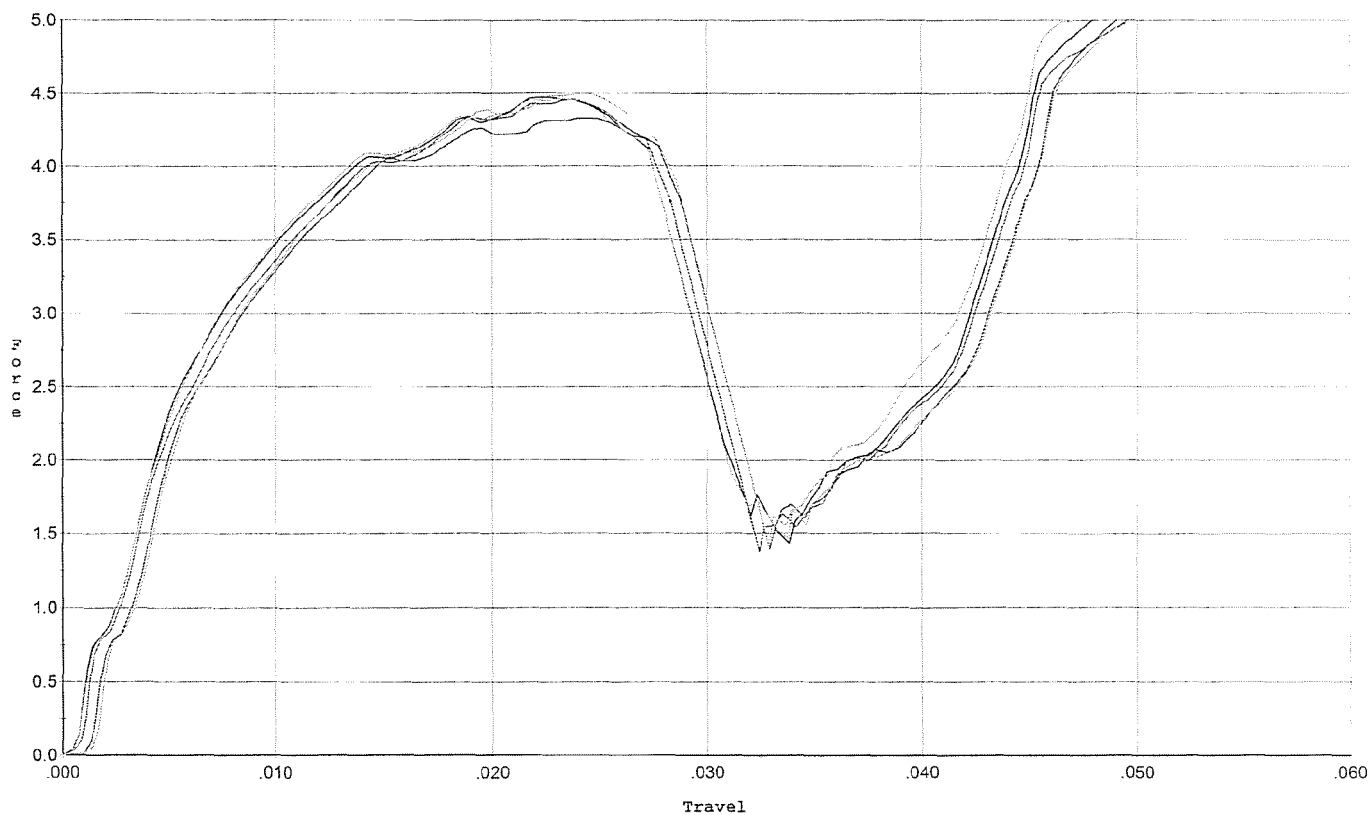
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.184	0.029	0.00	0.029	0.080		Set Trigger
2	4.090	0.027	0.00	0.032	0.076		Set Trigger
3	4.061	0.028	0.00	0.032	0.080		Set Trigger
4	3.977	0.028	0.00	0.032	0.077		Set Trigger
5	4.100	0.027	0.00	0.032	0.077		Set Trigger

A. 4.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



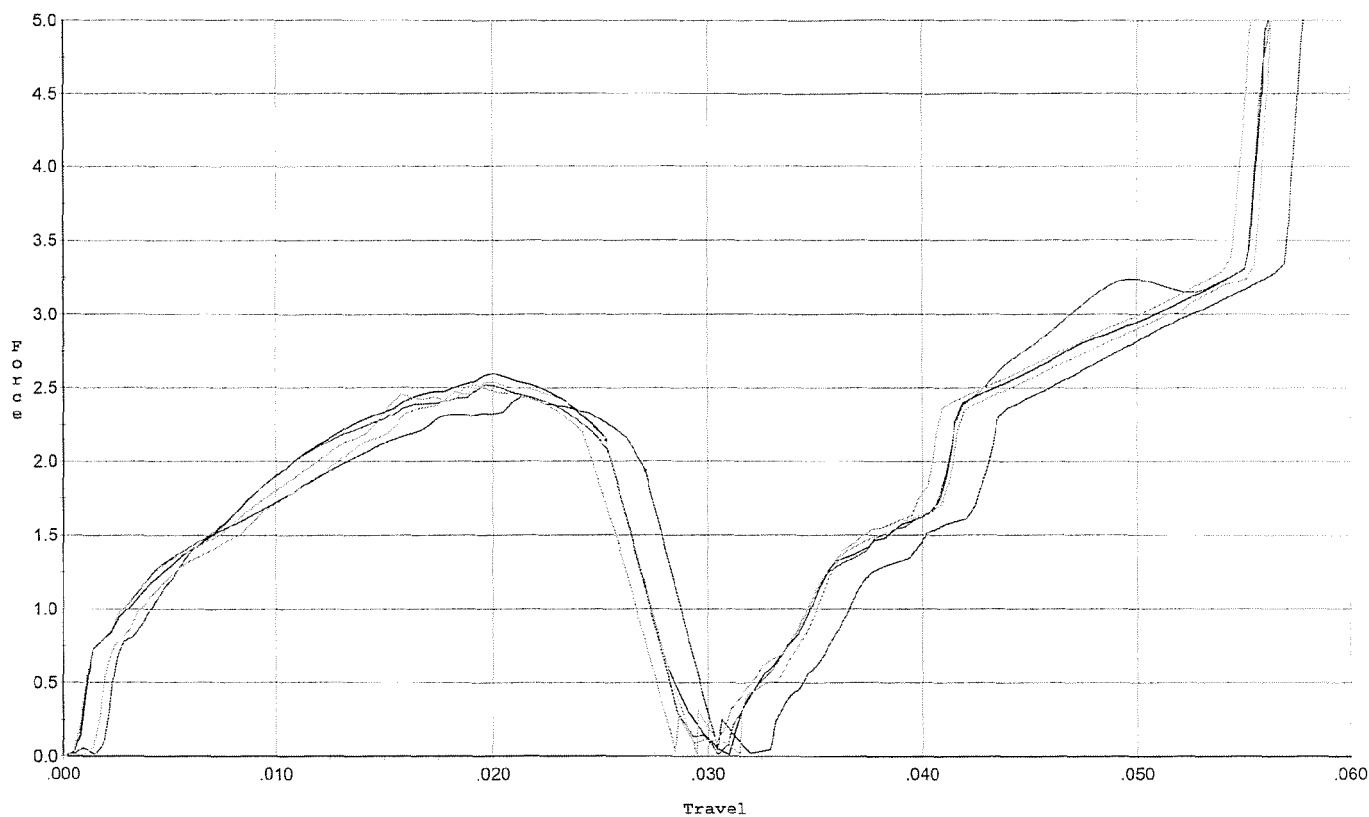
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.329	0.029	0.00	0.025	0.088		Set Trigger
2	4.471	0.027	0.00	0.026	0.086		Set Trigger
3	4.461	0.028	0.00	0.026	0.088		Set Trigger
4	4.463	0.027	0.00	0.026	0.086		Set Trigger
5	4.500	0.029	0.00	0.026	0.089		Set Trigger

A-4.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



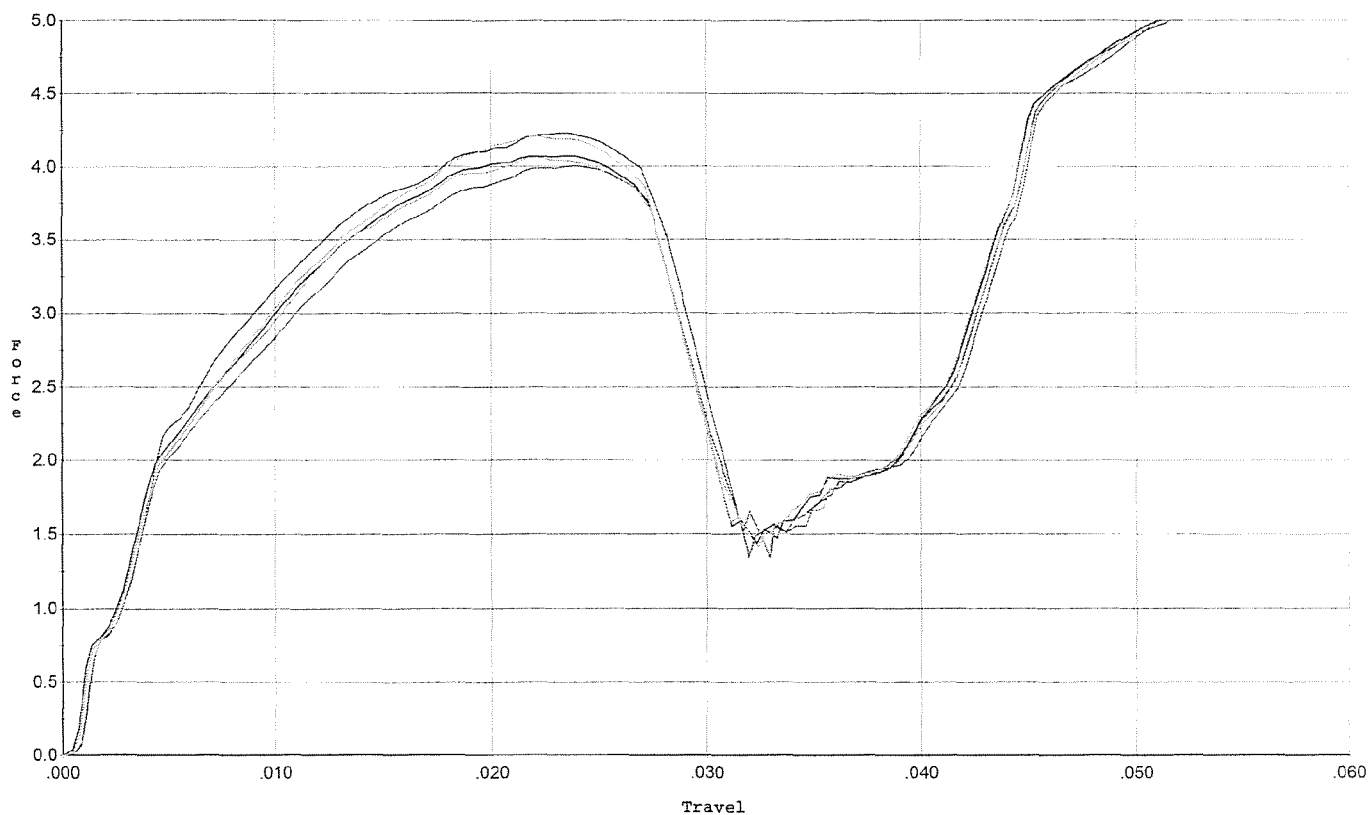
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.442	0.027	0.00	0.036	0.046		Set Trigger
2	2.599	0.025	0.00	0.036	0.046		Set Trigger
3	2.520	0.025	0.00	0.036	0.046		Set Trigger
4	2.537	0.025	0.00	0.036	0.043		Set Trigger
5	2.523	0.026	0.00	0.035	0.045		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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	4.228	0.028	0.00	0.032	0.084		Set Trigger
2	4.072	0.027	0.00	0.032	0.079		Set Trigger
3	4.005	0.027	0.00	0.032	0.076		Set Trigger
4	4.207	0.027	0.00	0.032	0.079		Set Trigger
5	4.060	0.027	0.00	0.032	0.078		Set Trigger

A-4.11