

G6845324

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



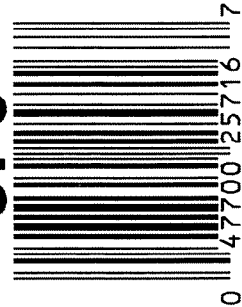
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845324

UPC



GUN SERIAL # G6845324

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	OPERATOR (H)	3/20/09	(H)
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		4-8-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

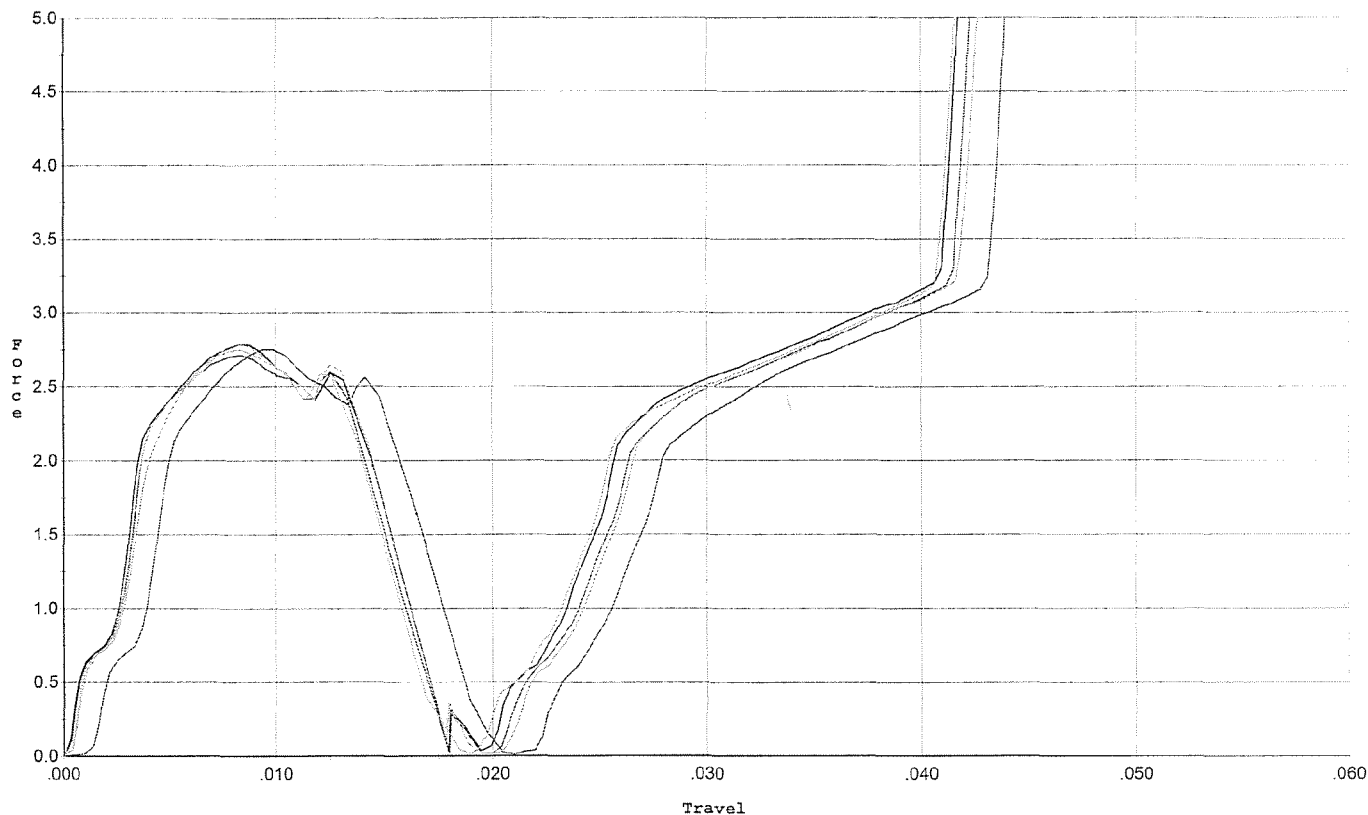
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	4-17-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-17-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	4-17-09	WN
	J) ASSEMBLE STOCK		4-8-09	LN
	K) ASSEMBLE SWIVEL STUDS		4-17-09	WN
	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	LP
	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	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>263</u> <u>236</u> <u>253</u> <u>270</u> <u>279</u>	4-16-09	RP
	C) FUNCTION		4-17-09	WN
690	PACK		5/19/09	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



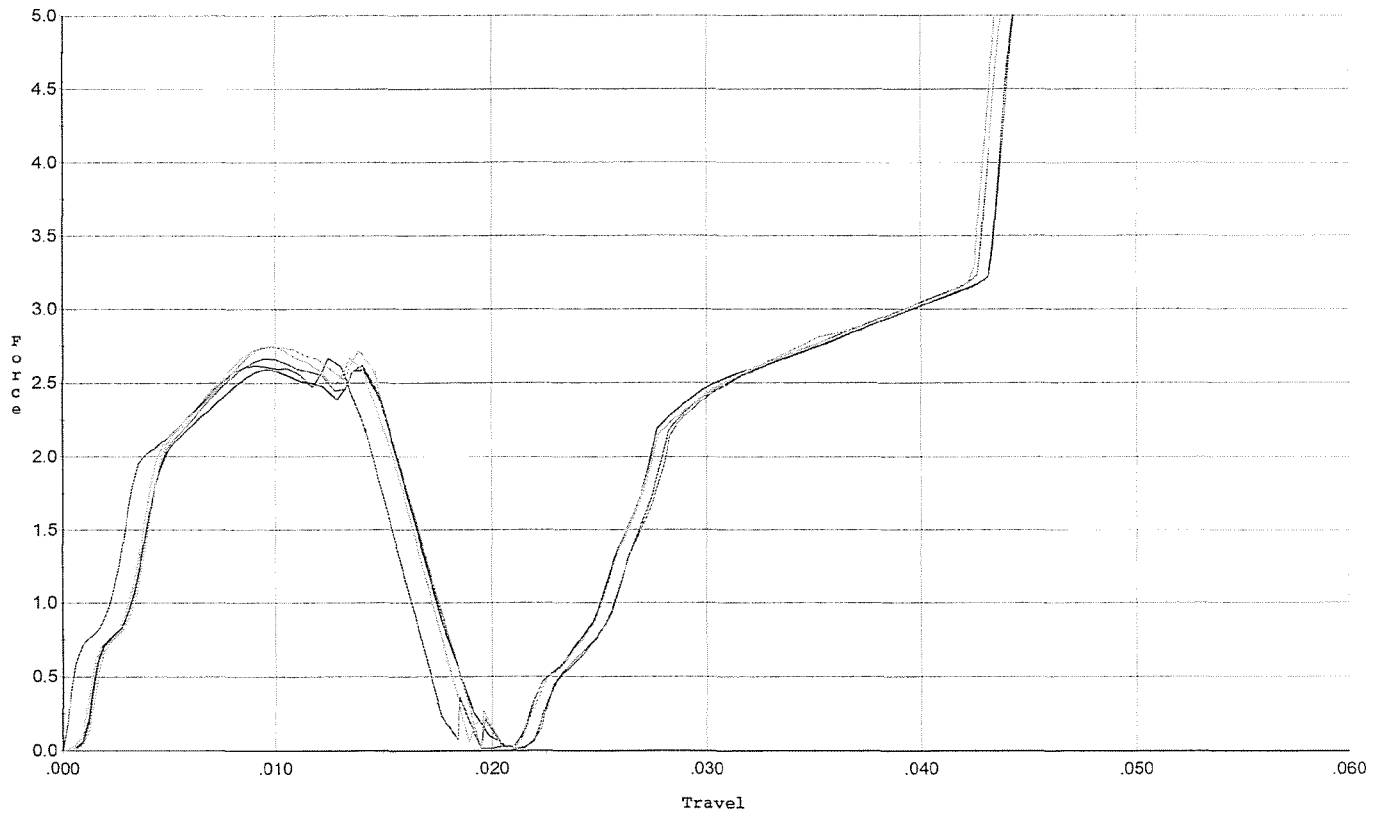
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.752	0.017	0.00	0.031	0.029		Set Trigger
2	2.785	0.015	0.00	0.030	0.028		Set Trigger
3	2.714	0.013	0.00	0.031	0.025		Set Trigger
4	2.747	0.014	0.00	0.031	0.026		Set Trigger
5	2.788	0.014	0.00	0.031	0.027		Set Trigger

A. 2.75

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



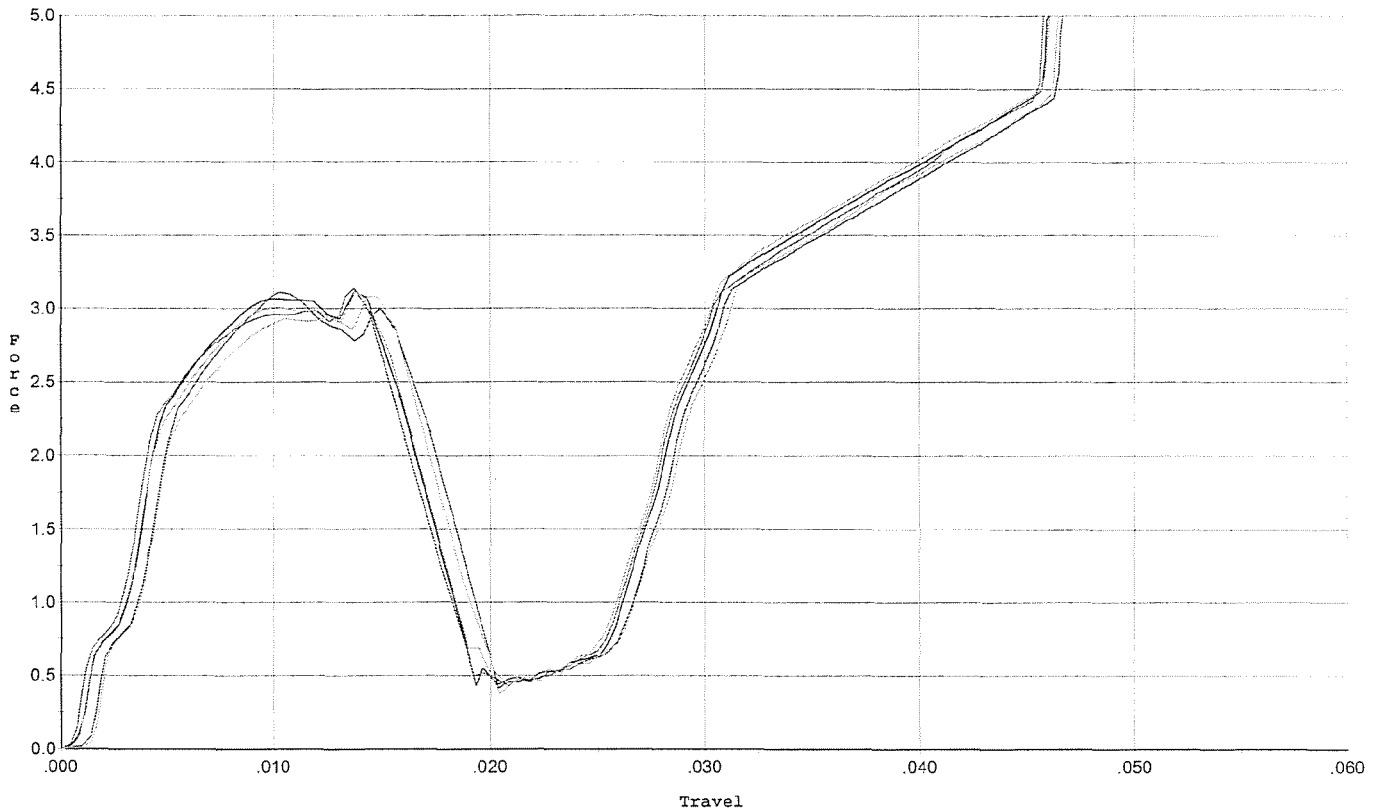
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.664	0.014	0.00	0.033	0.027		Set Trigger
2	2.587	0.015	0.00	0.031	0.027		Set Trigger
3	2.662	0.015	0.00	0.032	0.027		Set Trigger
4	2.748	0.015	0.00	0.031	0.029		Set Trigger
5	2.742	0.015	0.00	0.031	0.027		Set Trigger

A-2.68

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



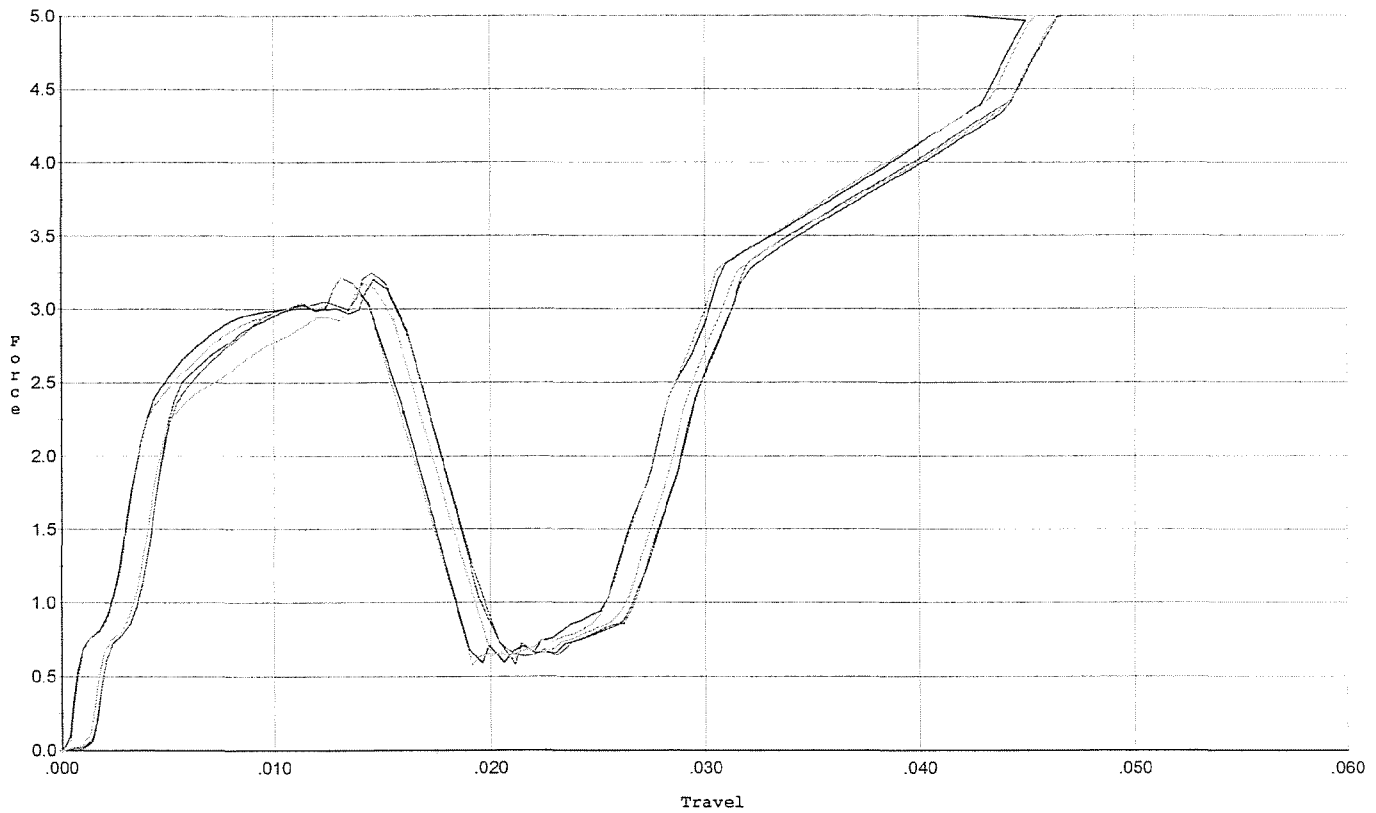
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.110	0.017	0.00	0.031	0.035		Set Trigger
2	3.122	0.016	0.00	0.032	0.033		Set Trigger
3	3.137	0.014	0.00	0.032	0.030		Set Trigger
4	3.082	0.016	0.00	0.032	0.031		Set Trigger
5	3.115	0.015	0.00	0.032	0.032		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: 3.0 lbs after 20 cycles+/- .75 lb



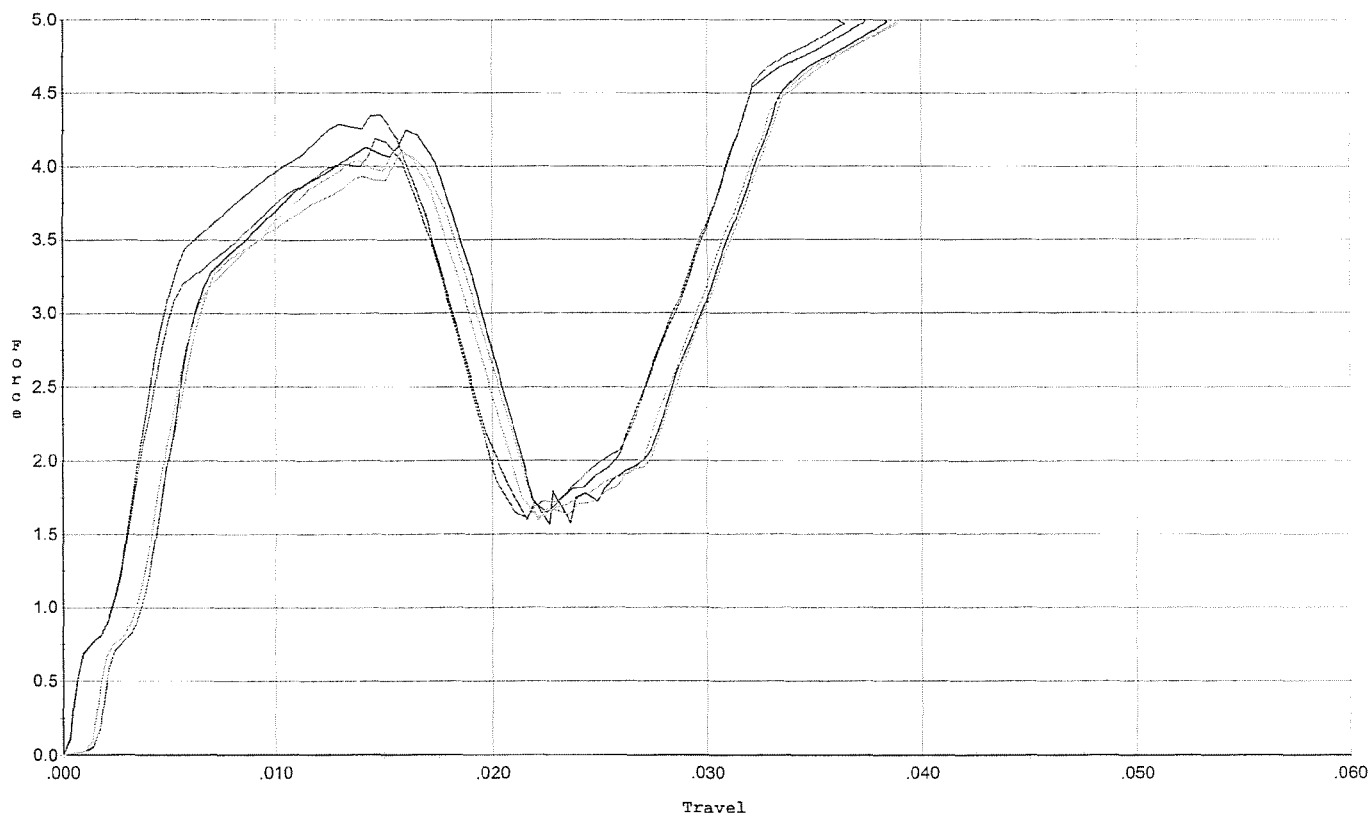
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.202	0.016	0.00	0.032	0.034		Set Trigger
2	3.215	0.016	0.00	0.031	0.035		Set Trigger
3	3.247	0.016	0.00	0.031	0.034		Set Trigger
4	3.178	0.016	0.00	0.032	0.031		Set Trigger
5	3.215	0.017	0.00	0.031	0.036		Set Trigger

A-3.21

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



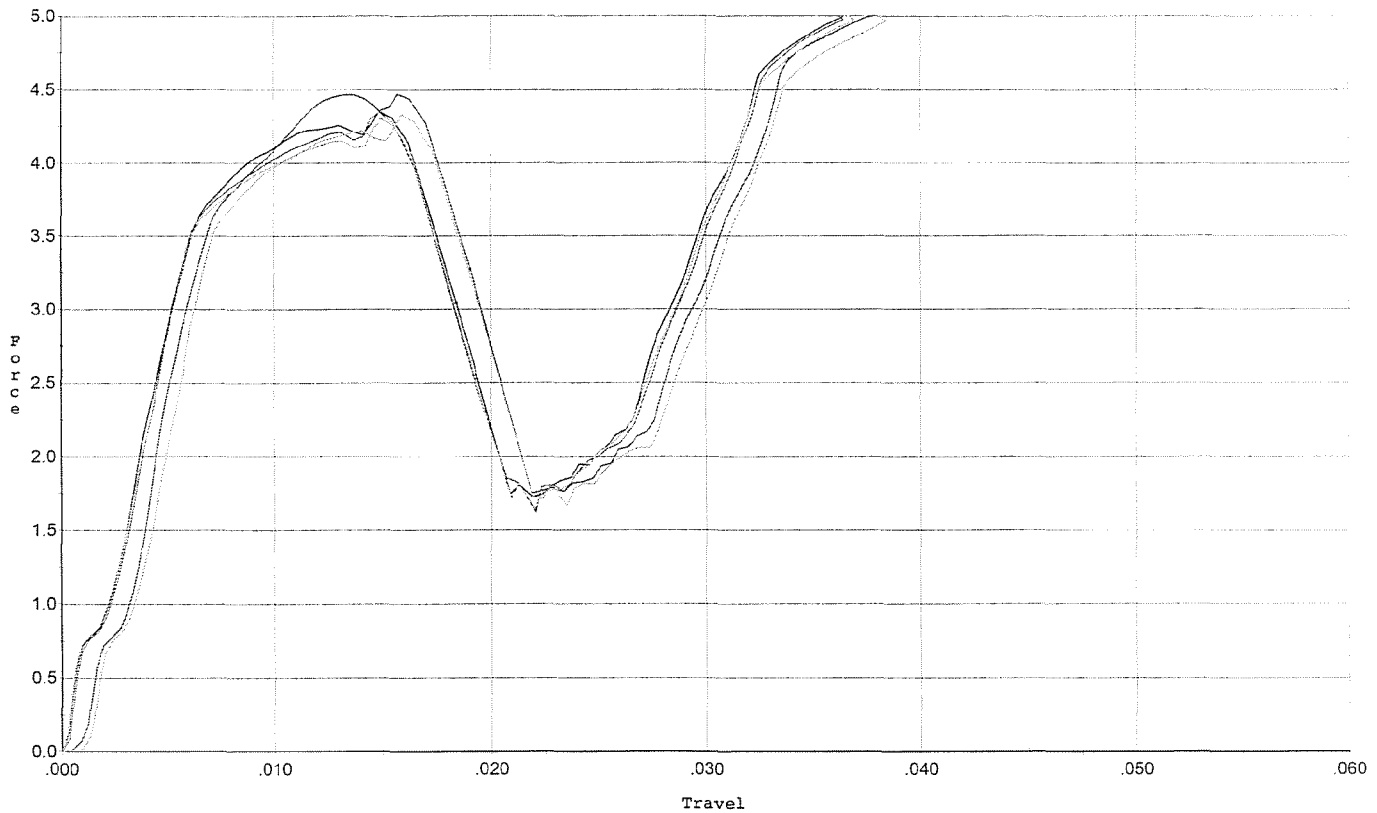
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.350	0.017	0.00	0.028	0.049		Set Trigger
2	4.252	0.019	0.00	0.029	0.051		Set Trigger
3	4.188	0.017	0.00	0.028	0.048		Set Trigger
4	4.135	0.019	0.00	0.029	0.050		Set Trigger
5	4.093	0.020	0.00	0.029	0.051		Set Trigger

A. 4.20

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



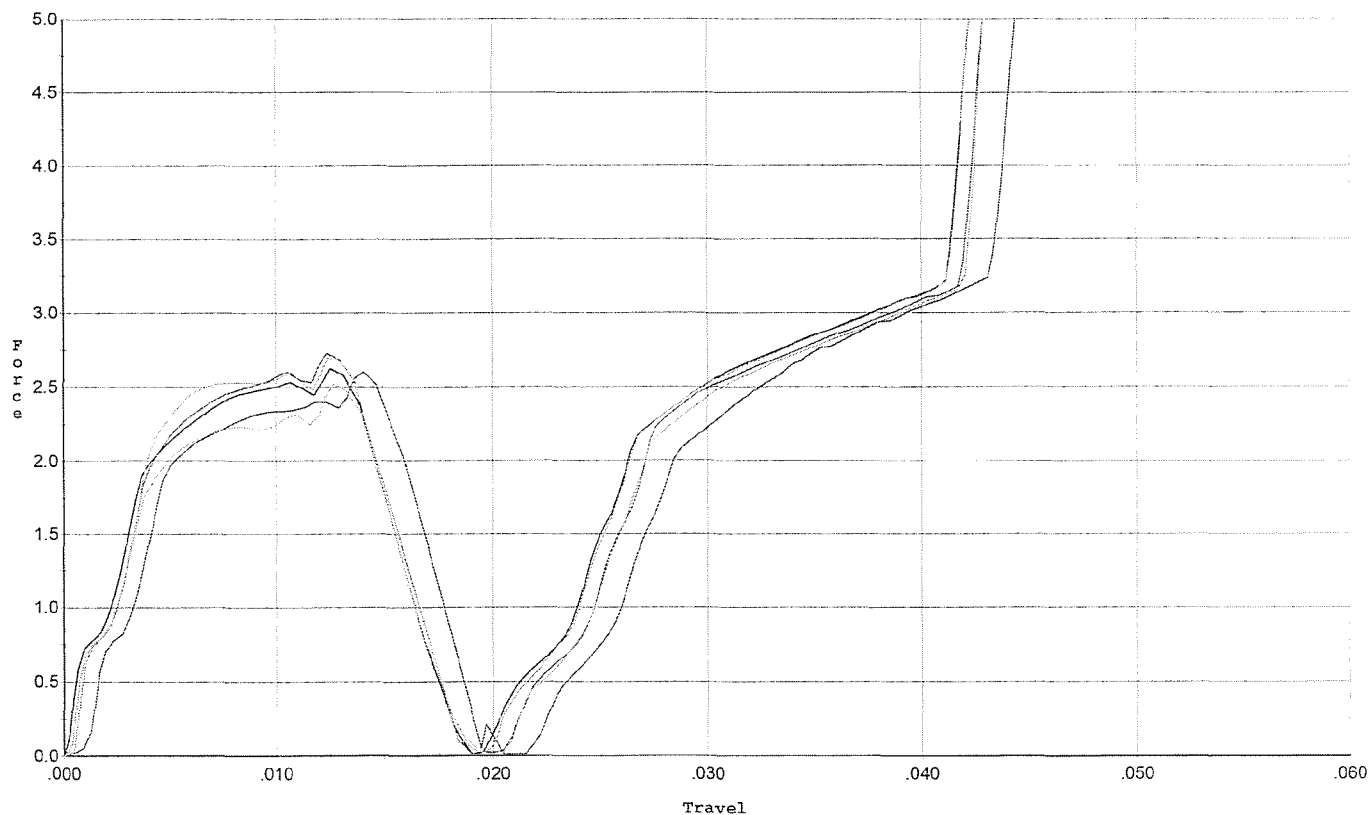
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.466	0.019	0.00	0.028	0.055		Set Trigger
2	4.355	0.018	0.00	0.028	0.054		Set Trigger
3	4.351	0.016	0.00	0.029	0.047		Set Trigger
4	4.331	0.019	0.00	0.029	0.053		Set Trigger
5	4.301	0.016	0.00	0.028	0.047		Set Trigger

A-4.36

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



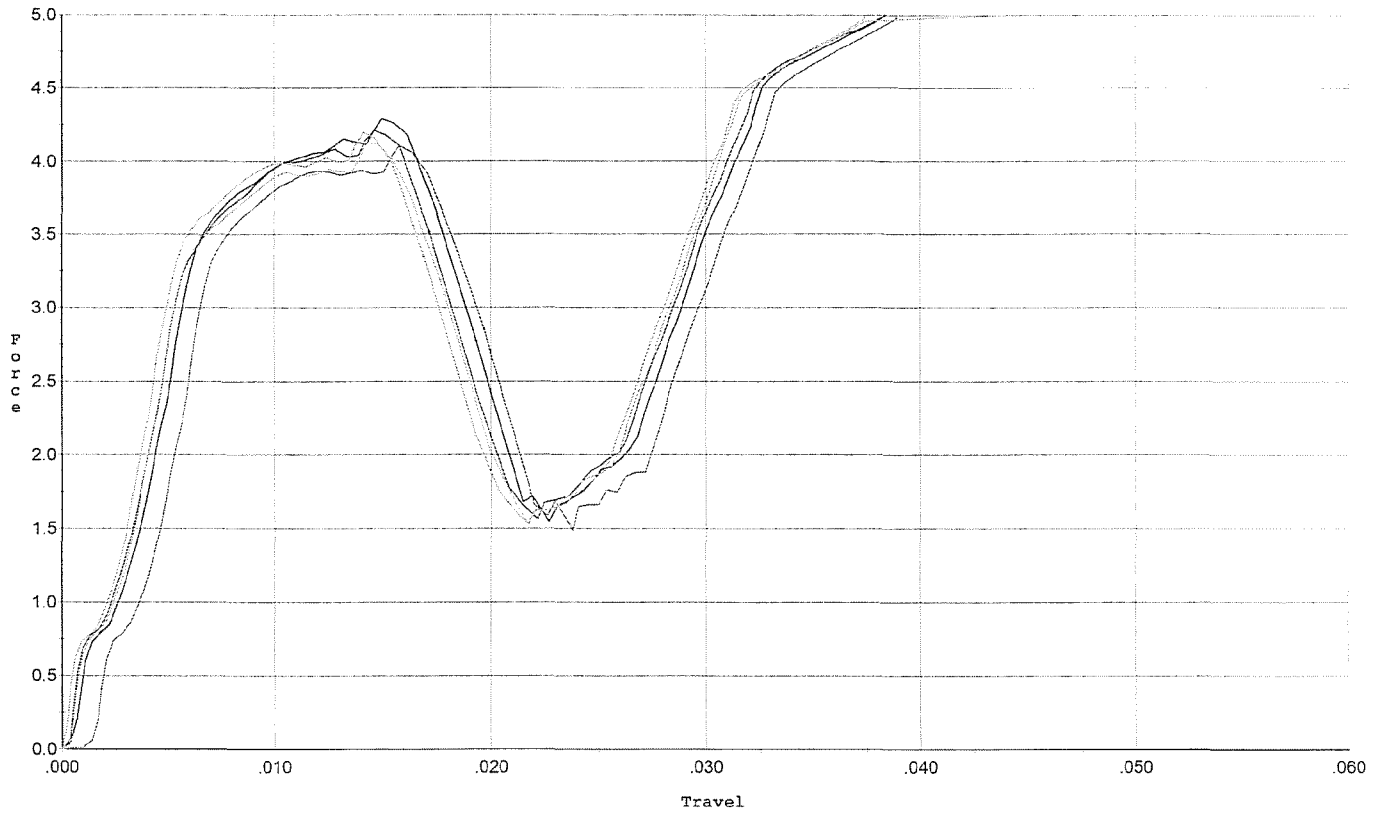
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.016	0.00	0.031	0.028		Set Trigger
2	2.625	0.014	0.00	0.031	0.026		Set Trigger
3	2.728	0.014	0.00	0.031	0.026		Set Trigger
4	2.699	0.016	0.00	0.031	0.030		Set Trigger
5	2.521	0.014	0.00	0.031	0.024		Set Trigger

A.2.63

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	4.210	0.017	0.00	0.029	0.048		Set Trigger
2	4.289	0.019	0.00	0.029	0.054		Set Trigger
3	4.107	0.020	0.00	0.029	0.051		Set Trigger
4	4.121	0.018	0.00	0.028	0.049		Set Trigger
5	4.198	0.017	0.00	0.028	0.048		Set Trigger

A. 4.18