

G6778825

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



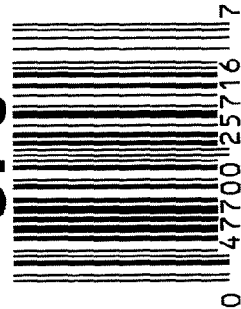
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6778825

UPC



BM FORM

GUN SERIAL #

G 677 8825

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	SP
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	SP
460	CHECK HEADSPACE		8-20-08	SP
470	DIS-ASSEMBLE ACTION		8-20-08	SP
472	SERIALIZE BOLT HANDLE		8-21-08	RT
475	DRILL AND TAP SIGHT HOLES		8-21-08	SP
480	MAGNAFLUX BBL ACTION		8-22-08	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-22-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			

F004 REV 5/2006

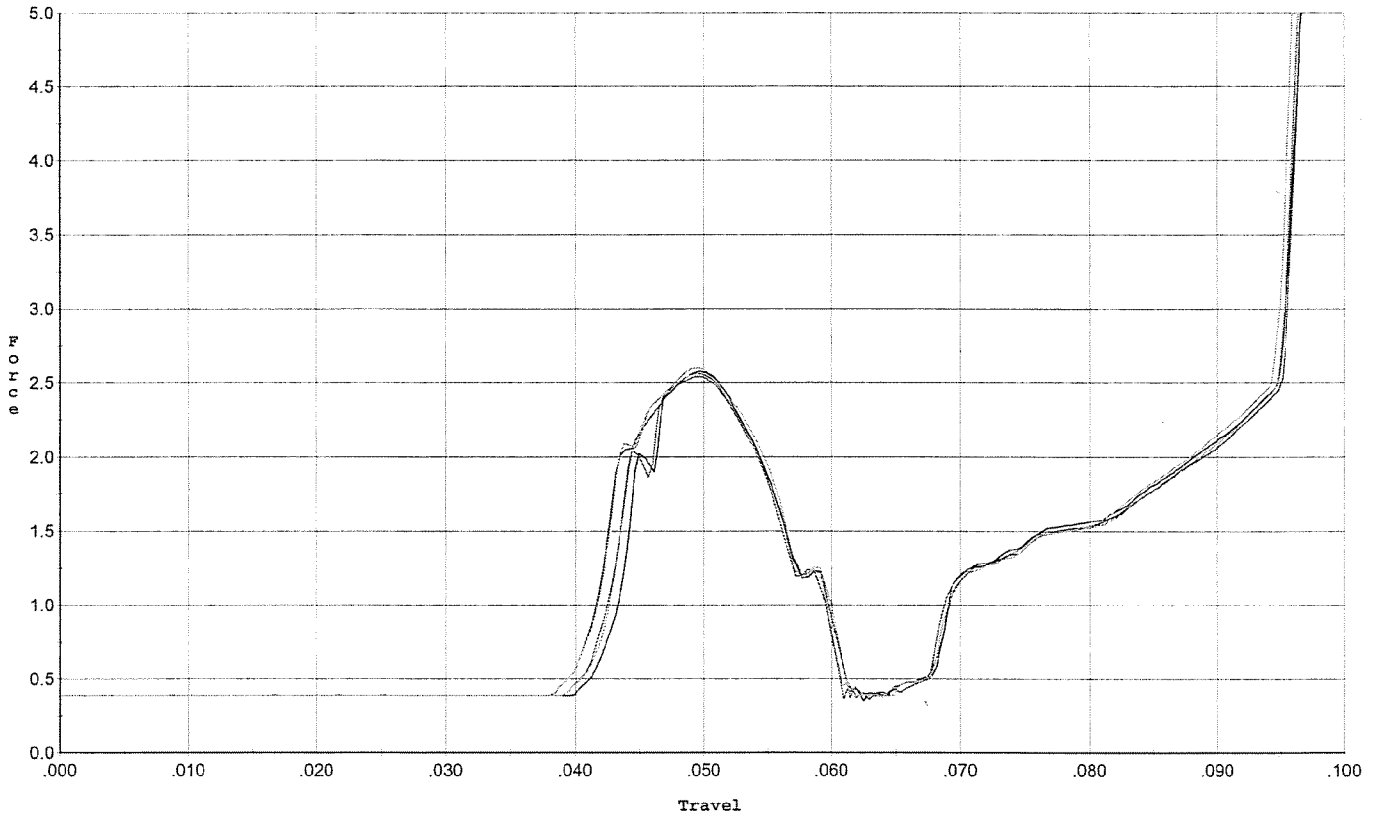
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>4.5</u>	10/24/08	Fm
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5</u> <u>5</u> <u>5</u>	10/28/08	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10/28/08	Fm
	J) ASSEMBLE STOCK		10-22-08	SPD
	K) ASSEMBLE SWIVEL STUDS		10/24/08	Fm
	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	10-27-08	Rgw
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-27-08	TC
670	FINAL INSPECTION A) HEADSPACE		10/28/08	Fm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.48</u> <u>2.35</u> <u>2.42</u> <u>2.42</u>	10-28-08	L. N.
	C) FUNCTION		11/24/08	Fm
690	PACK		11/3/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schultz 10/14/2008

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



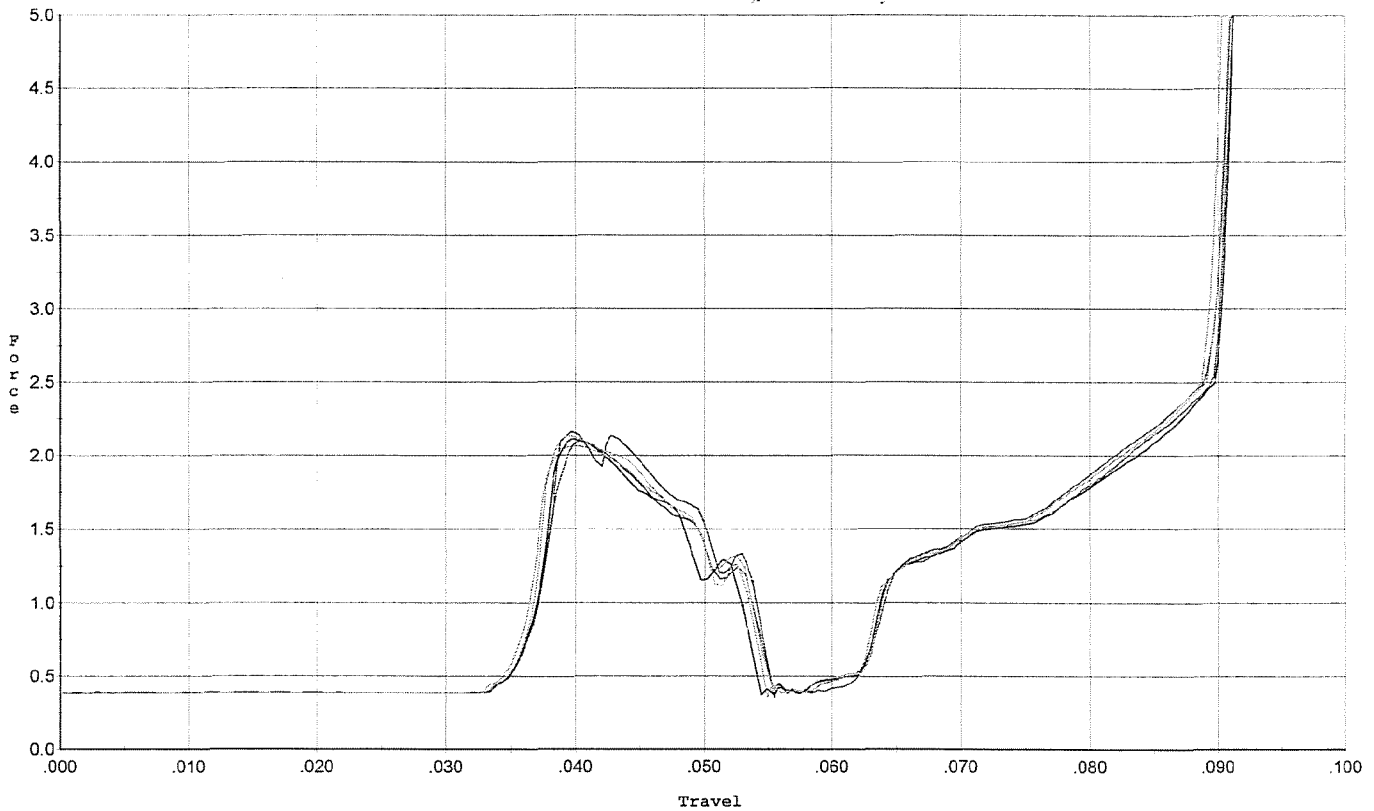
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.060	0.040	0.043	0.053		Set Trigger
2	2.577	0.060	0.042	0.043	0.050		Set Trigger
3	2.543	0.059	0.041	0.043	0.050		Set Trigger
4	2.601	0.060	0.040	0.042	0.053		Set Trigger
5	2.564	0.059	0.041	0.043	0.050		Set Trigger

A-2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



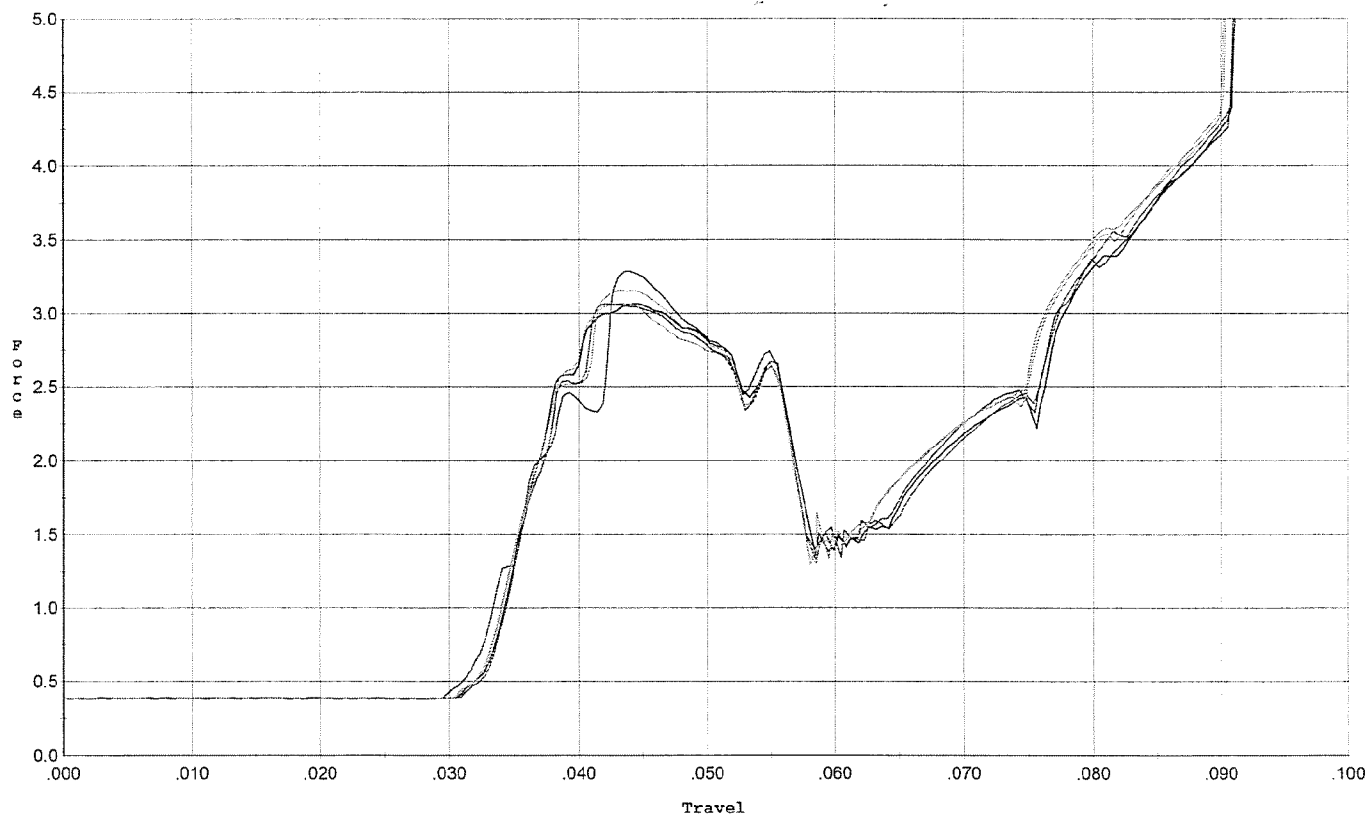
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.161	0.054	0.036	0.042	0.044		Set Trigger
2	2.113	0.053	0.035	0.044	0.041		Set Trigger
3	2.098	0.054	0.036	0.042	0.043		Set Trigger
4	2.132	0.053	0.036	0.042	0.043		Set Trigger
5	2.061	0.053	0.035	0.042	0.043		Set Trigger

A-2-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



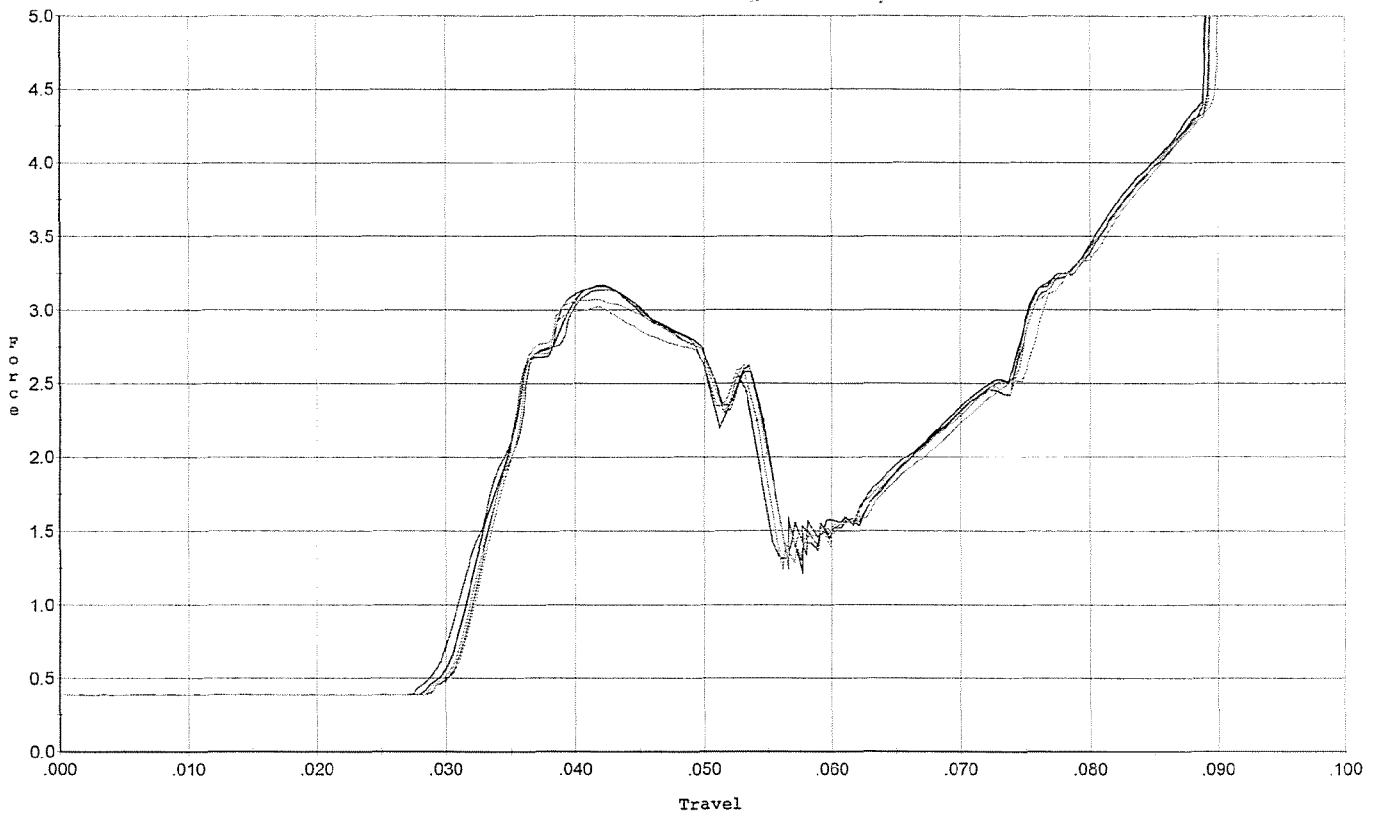
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.288	0.056	0.032	0.038	0.071		Set Trigger
2	3.066	0.055	0.033	0.038	0.071		Set Trigger
3	3.065	0.056	0.033	0.038	0.070		Set Trigger
4	3.069	0.056	0.033	0.037	0.070		Set Trigger
5	3.159	0.056	0.033	0.037	0.071		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



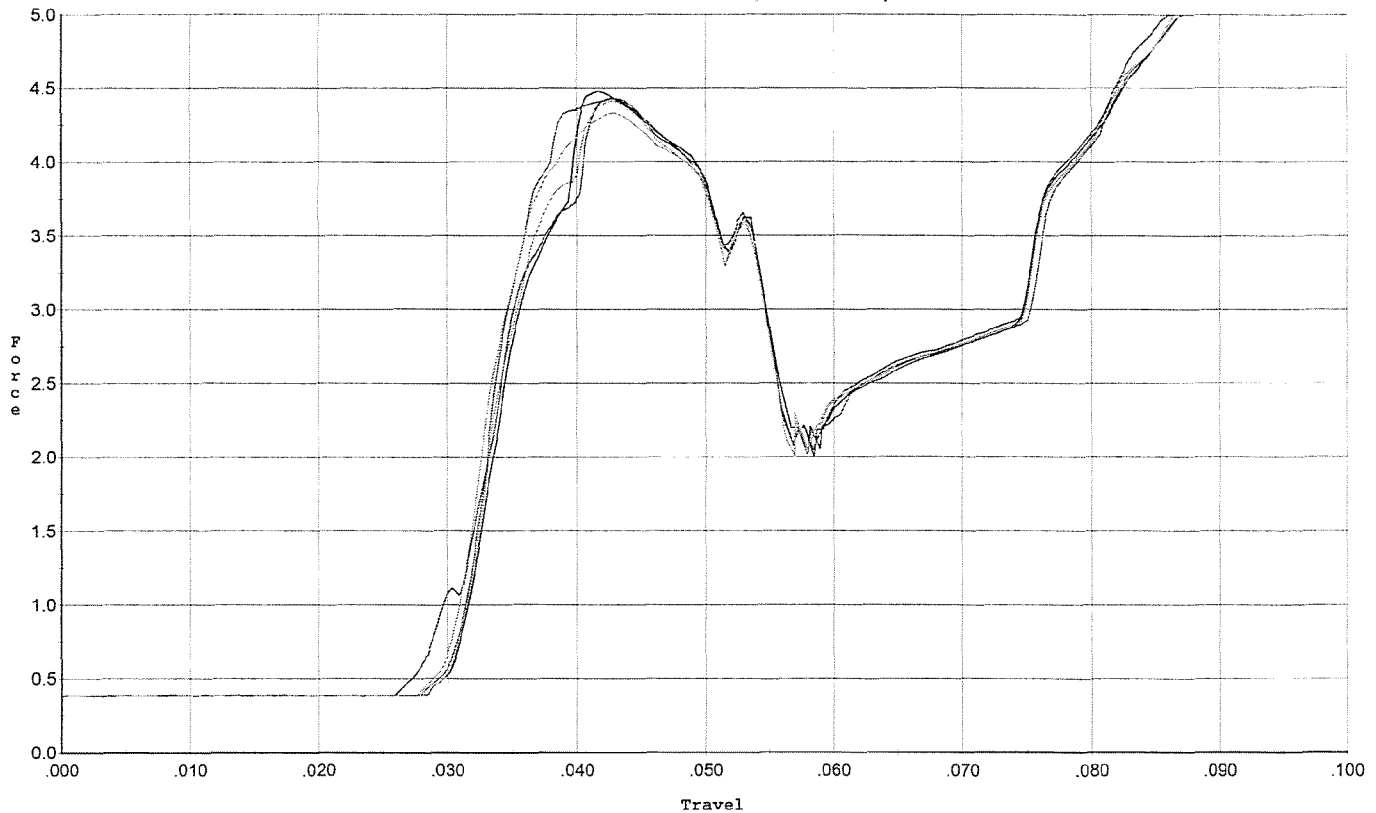
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.170	0.053	0.030	0.038	0.071		Set Trigger
2	3.162	0.055	0.030	0.036	0.073		Set Trigger
3	3.136	0.055	0.031	0.037	0.072		Set Trigger
4	3.072	0.055	0.031	0.037	0.072		Set Trigger
5	3.020	0.054	0.031	0.038	0.070		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



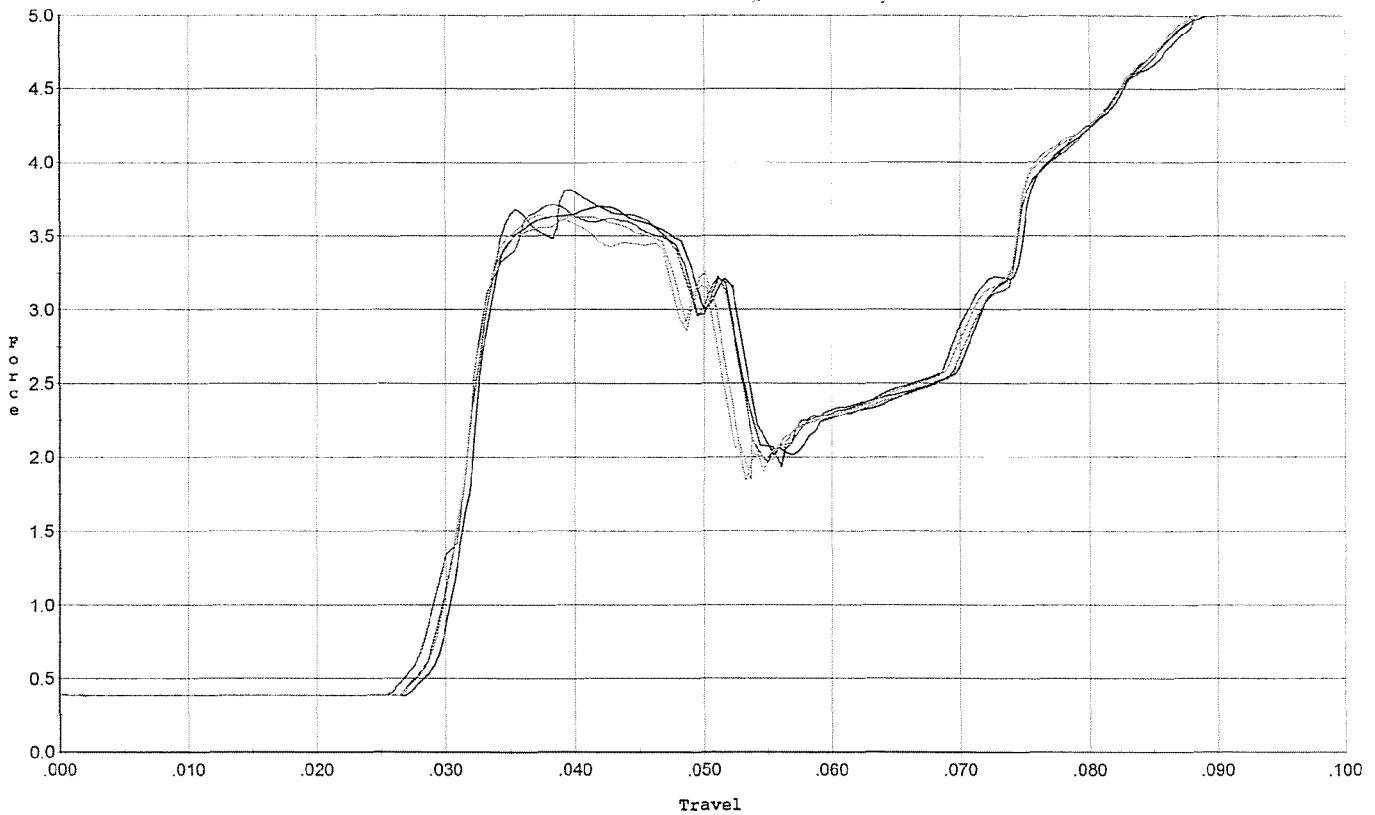
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.436	0.054	0.028	0.035	0.095		Set Trigger
2	4.479	0.054	0.031	0.035	0.093		Set Trigger
3	4.426	0.054	0.030	0.035	0.096		Set Trigger
4	4.331	0.054	0.028	0.035	0.096		Set Trigger
5	4.412	0.054	0.030	0.035	0.094		Set Trigger

A-4.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



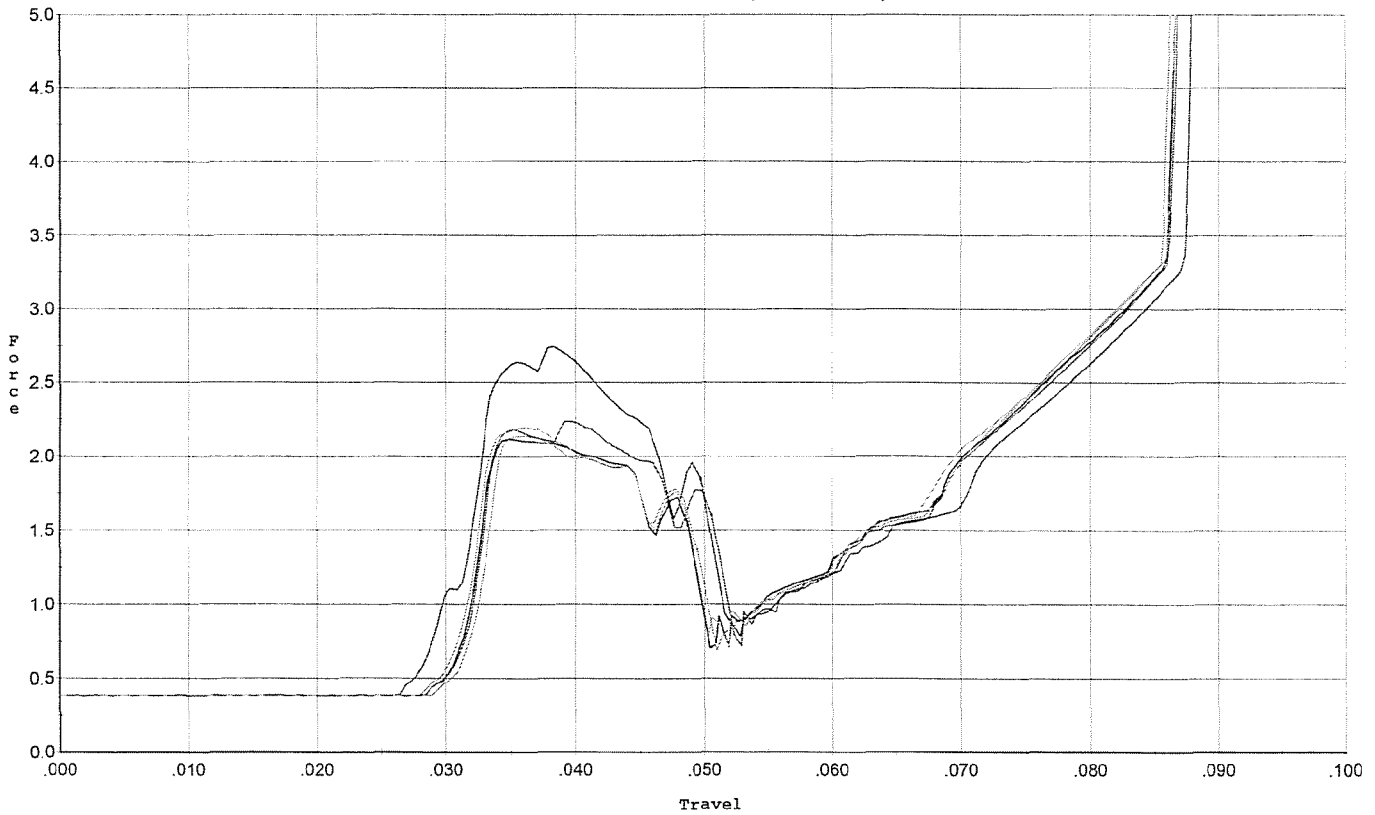
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.812	0.052	0.026	0.036	0.085		Set Trigger
2	3.702	0.052	0.029	0.036	0.085		Set Trigger
3	3.712	0.052	0.029	0.036	0.084		Set Trigger
4	3.639	0.050	0.027	0.037	0.078		Set Trigger
5	3.634	0.051	0.029	0.037	0.080		Set Trigger

A-3-70

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



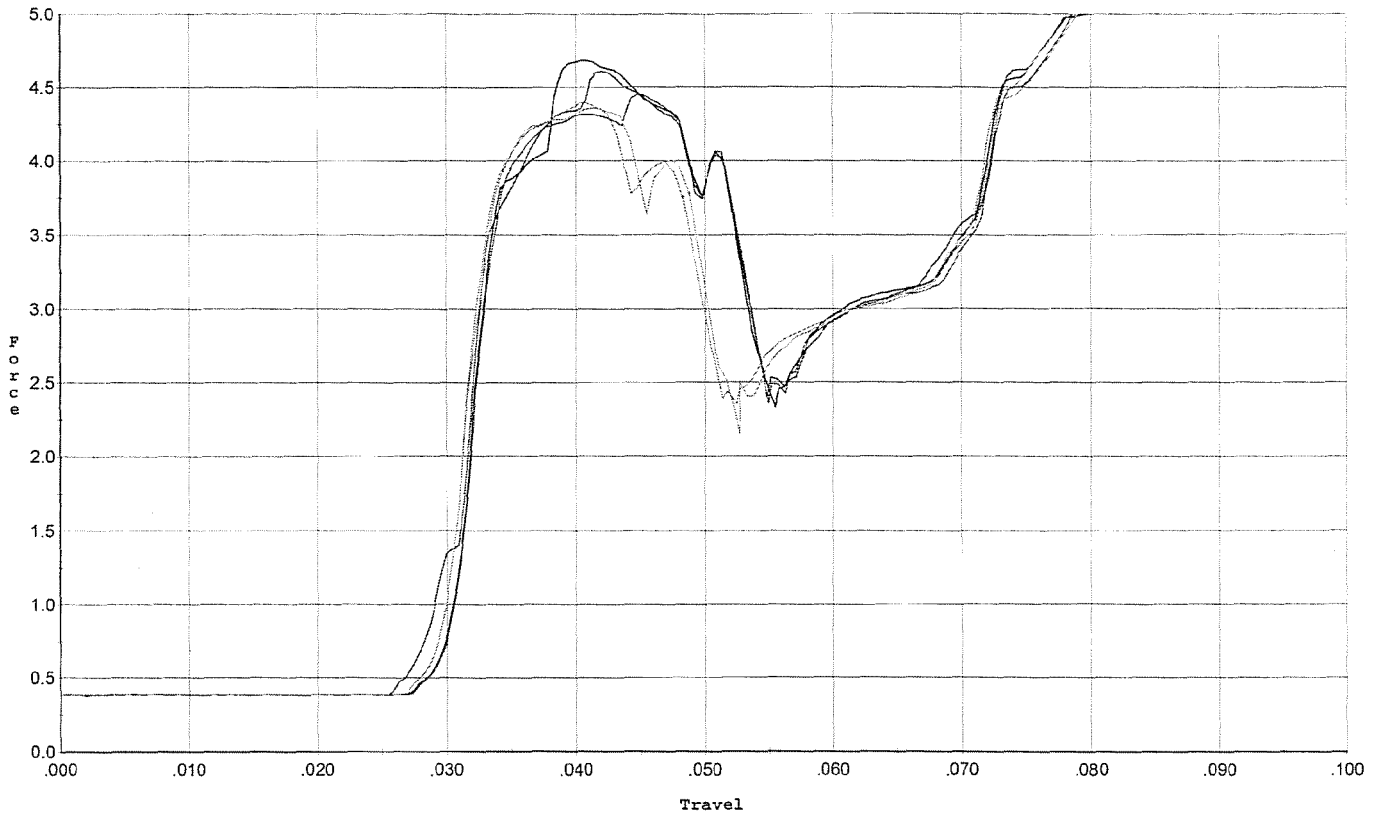
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.742	0.050	0.027	0.041	0.056		Set Trigger
2	2.118	0.049	0.031	0.043	0.045		Set Trigger
3	2.236	0.051	0.031	0.040	0.049		Set Trigger
4	2.196	0.049	0.030	0.042	0.045		Set Trigger
5	2.135	0.049	0.031	0.042	0.045		Set Trigger

A-228

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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	4.607	0.053	0.028	0.033	0.102		Set Trigger
2	4.682	0.051	0.030	0.033	0.097		Set Trigger
3	4.455	0.053	0.030	0.033	0.099		Set Trigger
4	4.361	0.049	0.027	0.034	0.086		Set Trigger
5	4.393	0.048	0.027	0.035	0.083		Set Trigger

A- 4.50