

G6778934

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**

G6778934

UPC



GUN SERIAL #

G 6778934

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	L.P.D.
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	L.P.D.
460	CHECK HEADSPACE		8-20-08	L.P.D.
470	DIS-ASSEMBLE ACTION		8-20-08	L.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX AUG 22 2008 OPERATOR <u>BH</u>	8-21-08	RTZ
475	DRILL AND TAP SIGHT HOLES		8-21-08	SP
480	MAGNAFLUX BBL ACTION		8-22-08	BH
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		9-29-08	L
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-29-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-29-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-22-08	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

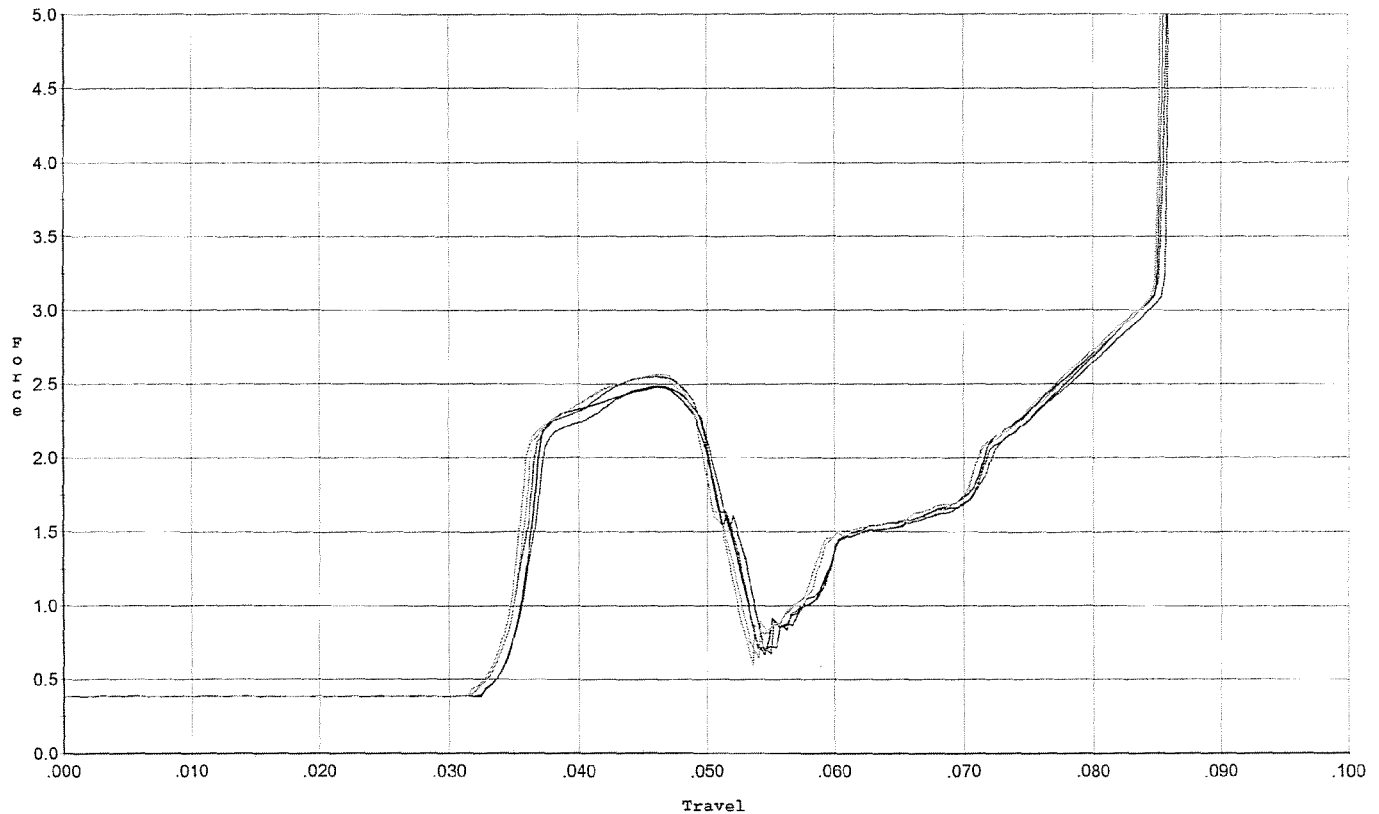
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-30-08	RJD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.5</u> <u>5.5</u> <u>5.5</u>	10-30-08	RJD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-30-08	RJD
	J) ASSEMBLE STOCK		10-30-08	RJD
	K) ASSEMBLE SWIVEL STUDS		10-30-08	RJD
	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	10-24-08	RCW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-30-08	RJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.49</u> <u>2.51</u> <u>2.48</u> <u>2.49</u>	10-28-08	TC
	C) FUNCTION		10-30-08	RJD
690	PACK		11/3/08	FM

F004 REV 5/2006

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. ini. +/- .50 lbs.



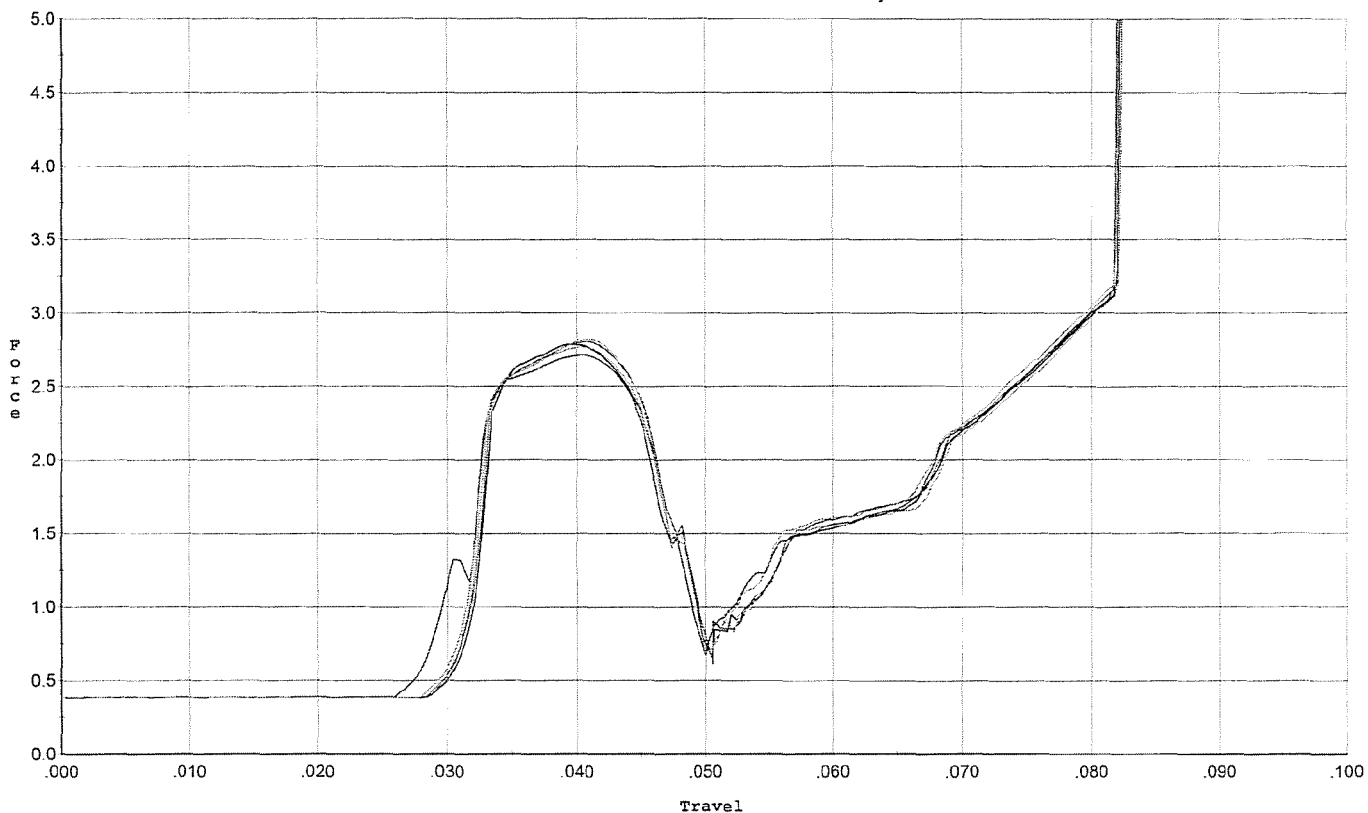
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.482	0.053	0.034	0.037	0.051		Set Trigger
2	2.477	0.050	0.034	0.039	0.048		Set Trigger
3	2.552	0.052	0.034	0.038	0.052		Set Trigger
4	2.550	0.049	0.034	0.039	0.048		Set Trigger
5	2.565	0.049	0.033	0.039	0.049		Set Trigger

A-2.52

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.



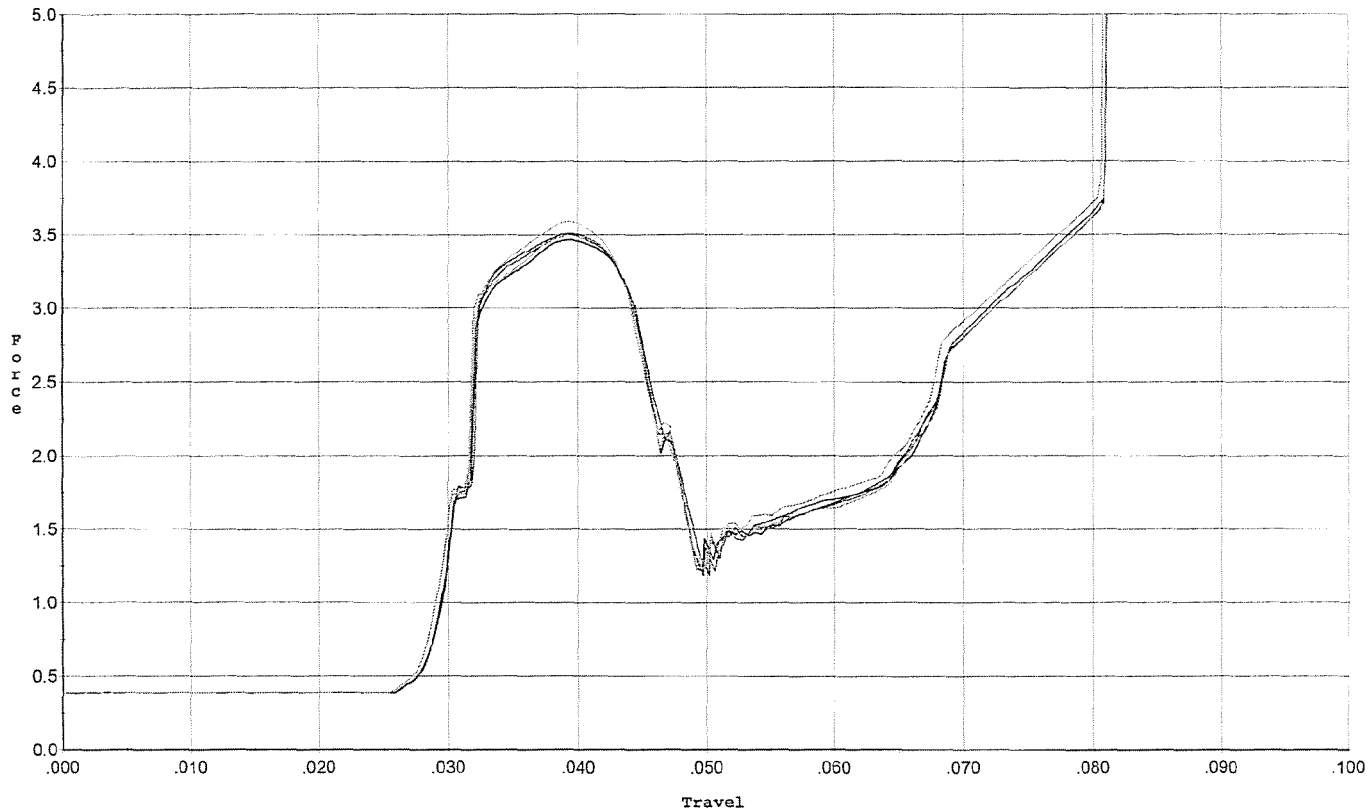
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.715	0.045	0.028	0.039	0.049		Set Trigger
2	2.788	0.048	0.031	0.037	0.051		Set Trigger
3	2.810	0.046	0.031	0.039	0.049		Set Trigger
4	2.820	0.046	0.030	0.039	0.049		Set Trigger
5	2.769	0.048	0.030	0.037	0.052		Set Trigger

A-2-78

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.



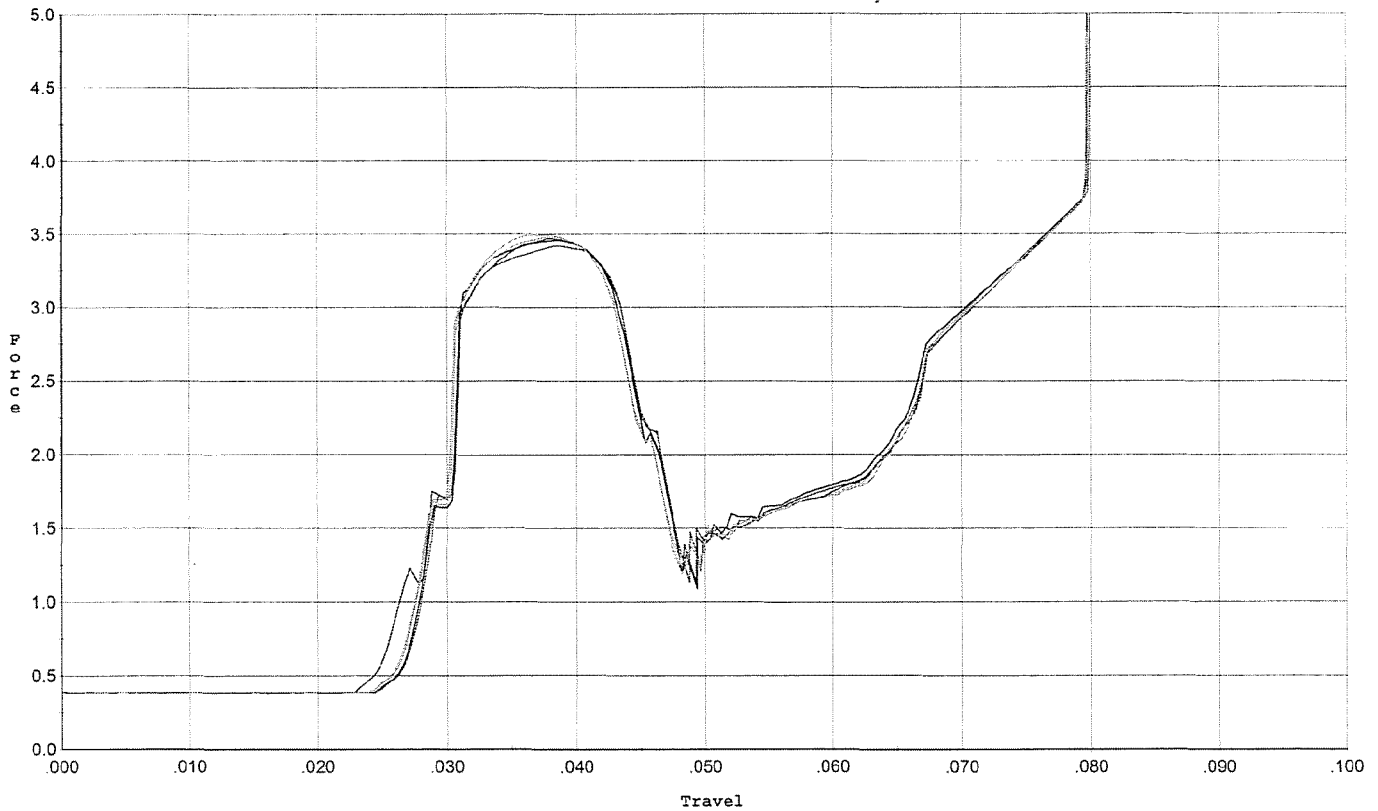
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.509	0.044	0.029	0.036	0.059		Set Trigger
2	3.465	0.047	0.028	0.035	0.064		Set Trigger
3	3.501	0.047	0.028	0.035	0.064		Set Trigger
4	3.592	0.048	0.028	0.035	0.065		Set Trigger
5	3.499	0.047	0.028	0.035	0.065		Set Trigger

A-3.51

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.



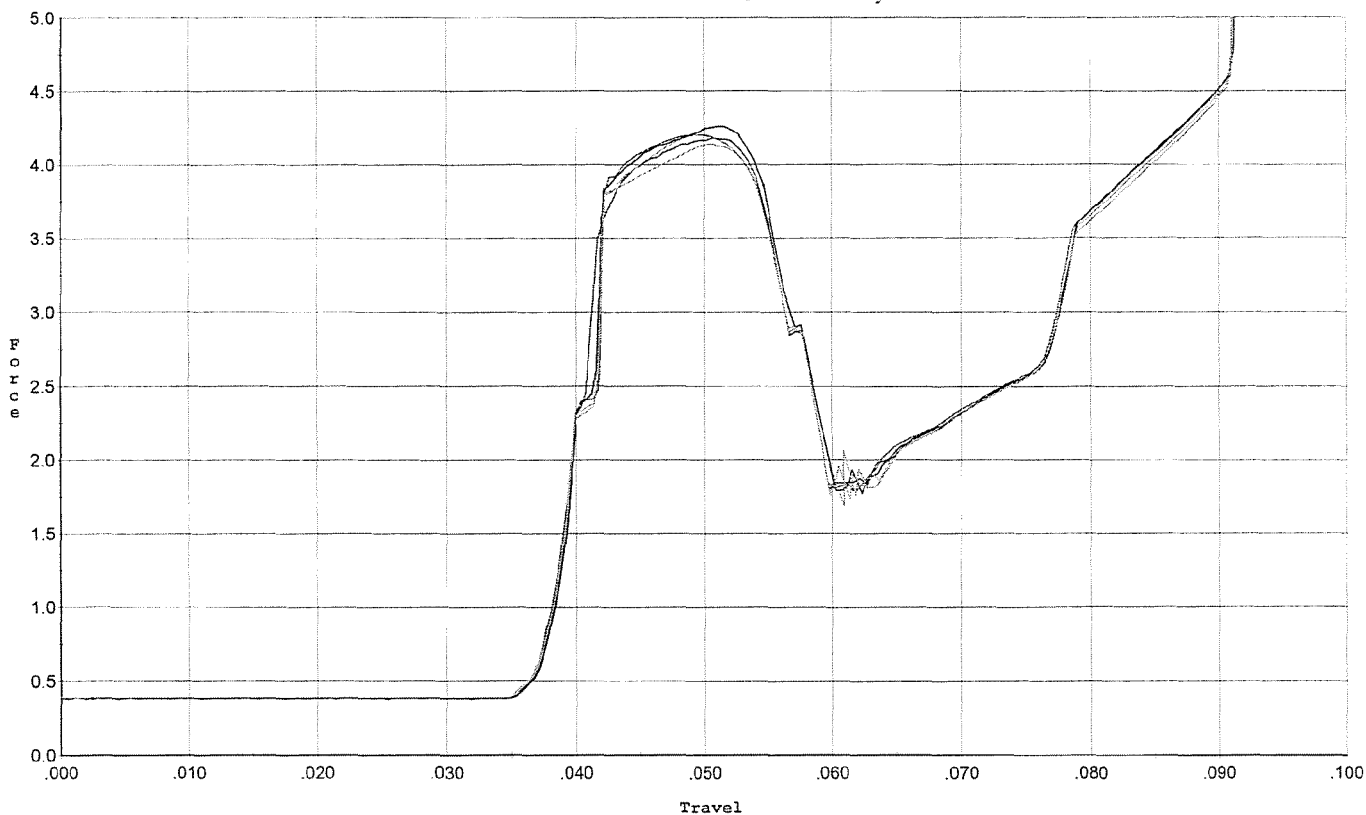
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.464	0.046	0.025	0.035	0.066		Set Trigger
2	3.453	0.046	0.027	0.035	0.064		Set Trigger
3	3.419	0.046	0.027	0.035	0.064		Set Trigger
4	3.483	0.043	0.026	0.037	0.059		Set Trigger
5	3.494	0.043	0.027	0.036	0.059		Set Trigger

A-3.46

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.



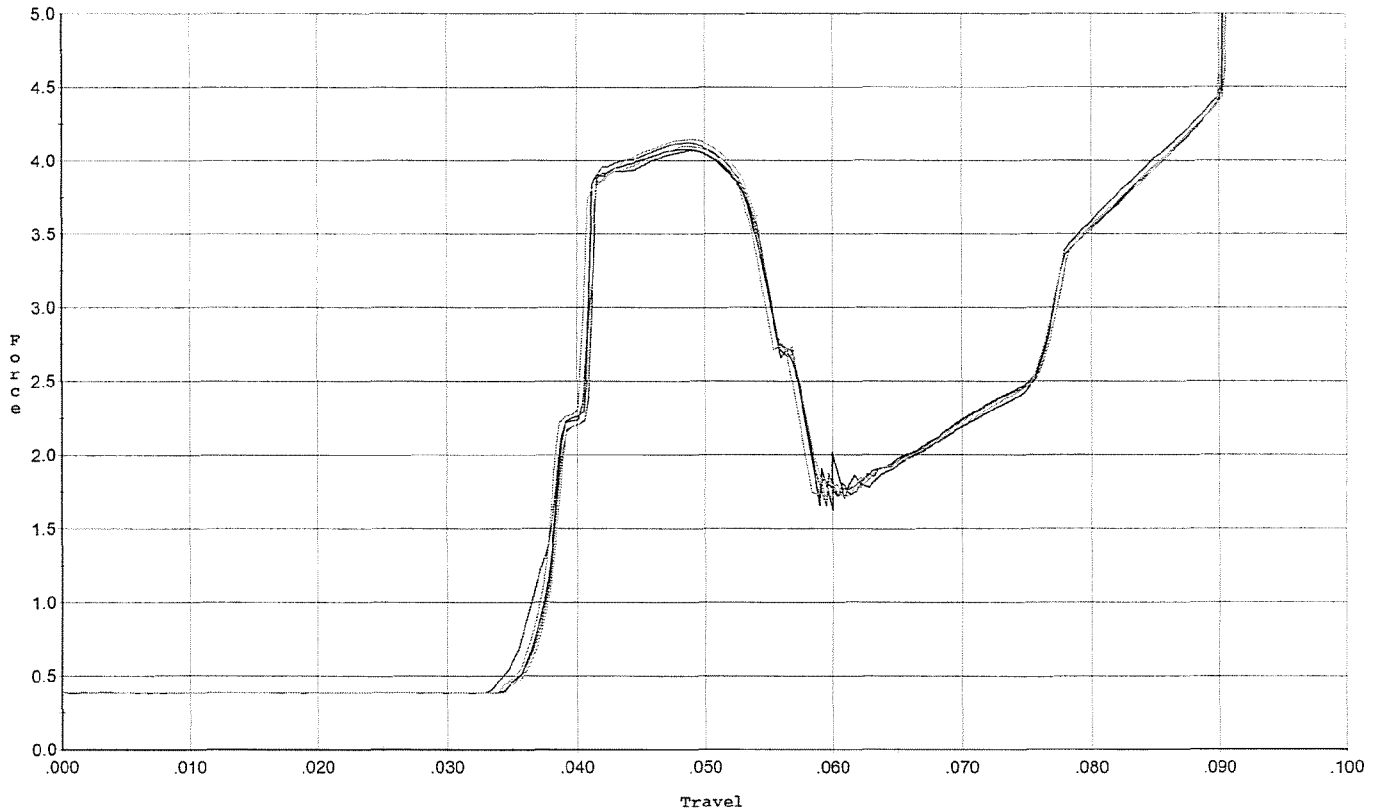
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.183	0.058	0.037	0.037	0.085		Set Trigger
2	4.261	0.055	0.037	0.039	0.079		Set Trigger
3	4.204	0.058	0.037	0.037	0.085		Set Trigger
4	4.139	0.058	0.037	0.037	0.084		Set Trigger
5	4.207	0.058	0.037	0.037	0.085		Set Trigger

A-4-19

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.



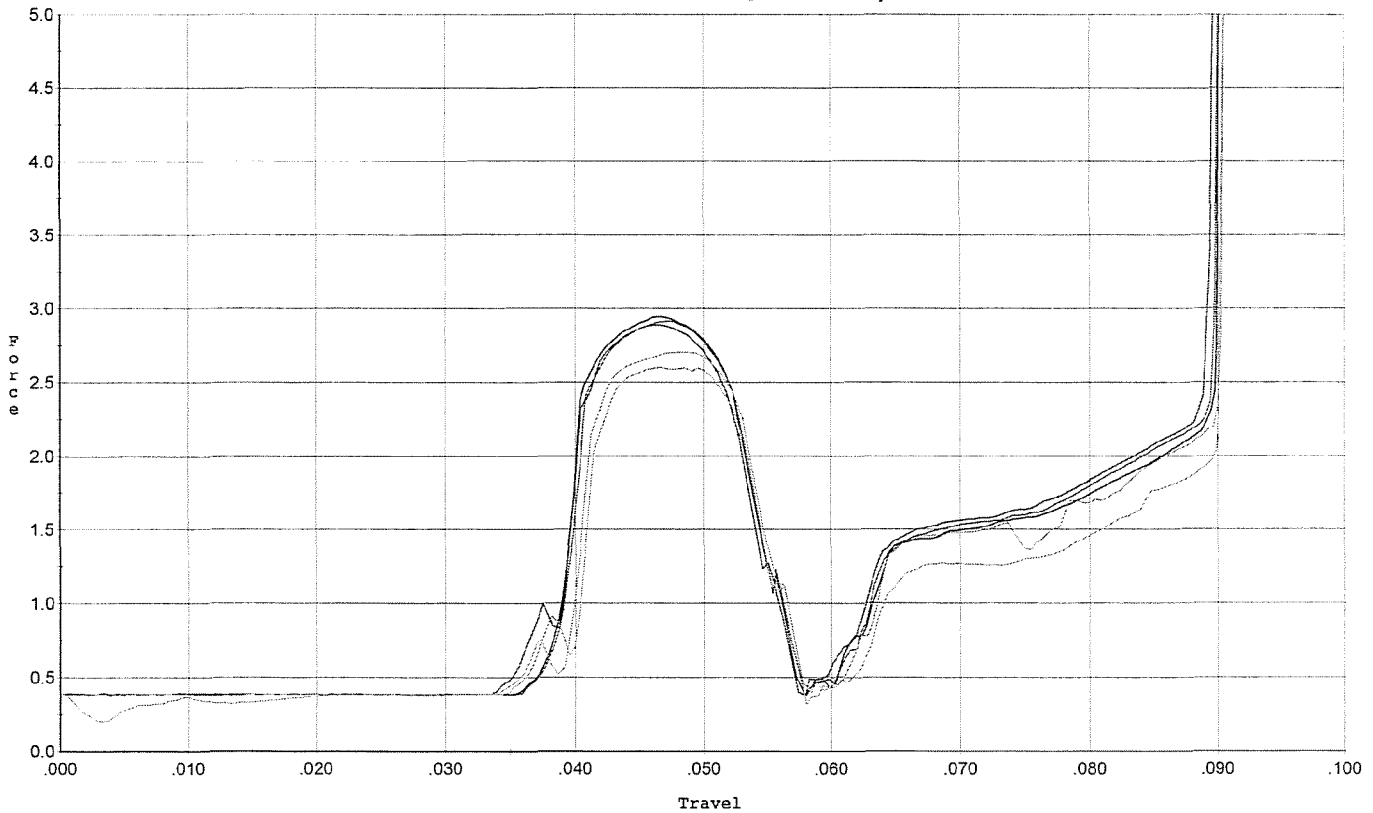
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.069	0.057	0.035	0.037	0.083		Set Trigger
2	4.077	0.057	0.036	0.037	0.083		Set Trigger
3	4.125	0.054	0.036	0.038	0.077		Set Trigger
4	4.146	0.054	0.036	0.038	0.077		Set Trigger
5	4.097	0.056	0.036	0.037	0.082		Set Trigger

A-4.10

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



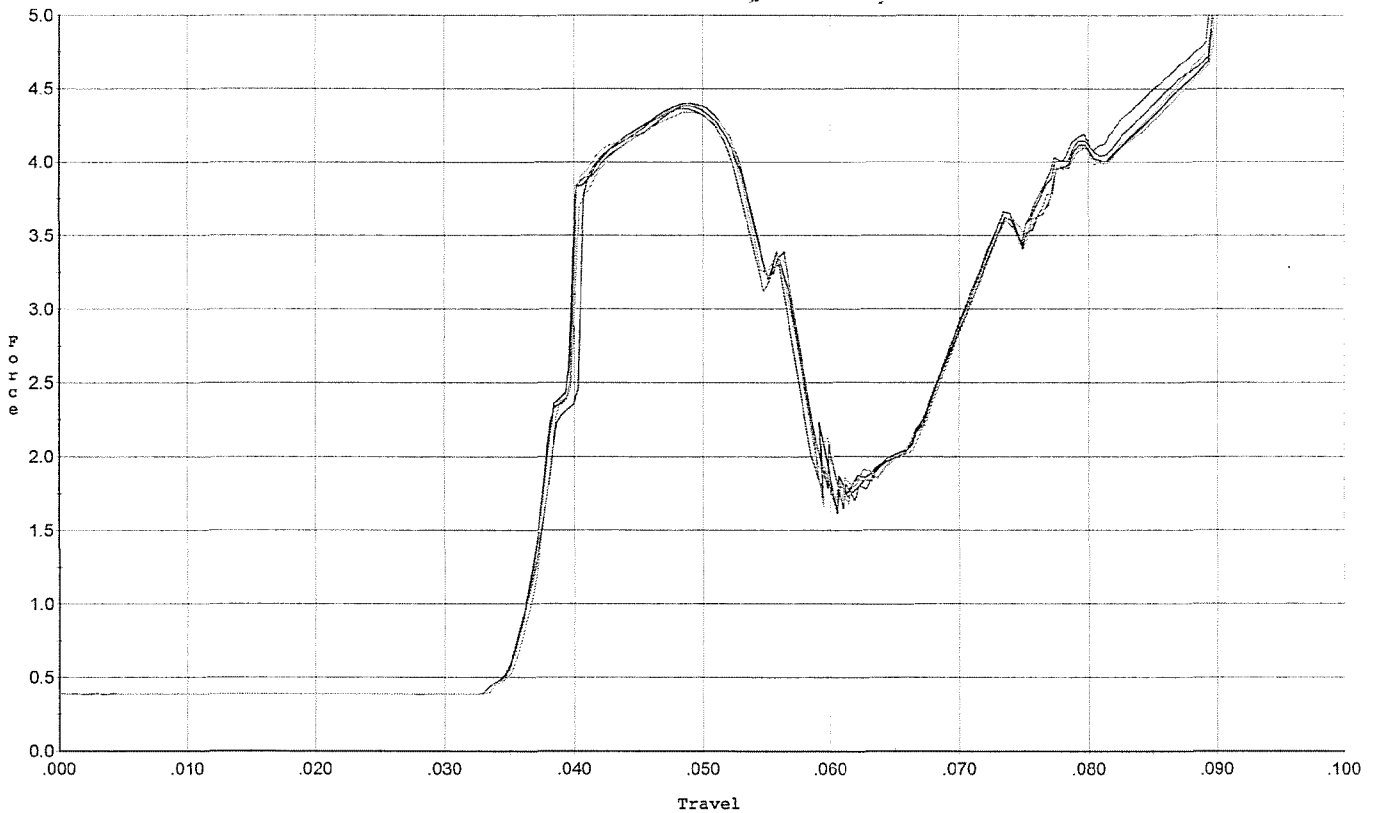
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.886	0.053	0.036	0.040	0.053		Set Trigger
2	2.943	0.056	0.038	0.040	0.057		Set Trigger
3	2.912	0.054	0.038	0.040	0.053		Set Trigger
4	2.705	0.053	0.036	0.041	0.050		Set Trigger
5	2.601	0.053	0.037	0.041	0.048		Set Trigger

14-2.80

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 for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.385	0.056	0.035	0.036	0.088		Set Trigger
2	4.402	0.057	0.035	0.036	0.090		Set Trigger
3	4.366	0.056	0.035	0.036	0.088		Set Trigger
4	4.339	0.057	0.035	0.036	0.090		Set Trigger
5	4.402	0.056	0.036	0.037	0.089		Set Trigger

A-4.37