

G6785088

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



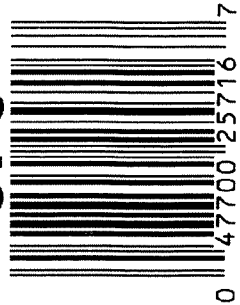
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785088

UPC



GUN SERIAL # G6785088

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-22-08	SPD
430	ASSEMBLE TO STOCK		9-22-08	SP
440	PROOF		9-22-08	SPD
460	CHECK HEADSPACE		9-22-08	SPD
470	DIS-ASSEMBLE ACTION		9-22-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	10-6-08	RTZ
475	DRILL AND TAP SIGHT HOLES	2006	10-7-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/8/08	(H)
490	MAGNAFLUX BOLT		9/22/08	MR
500	ROLLMARK CALIBER		10/8/08	RT
520	GOFF BLAST BBL / REC		10/9/08	RT
542	APPLY COATINGS (BARREL ACTION)		10/13	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/13/08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/13/08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/13/08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

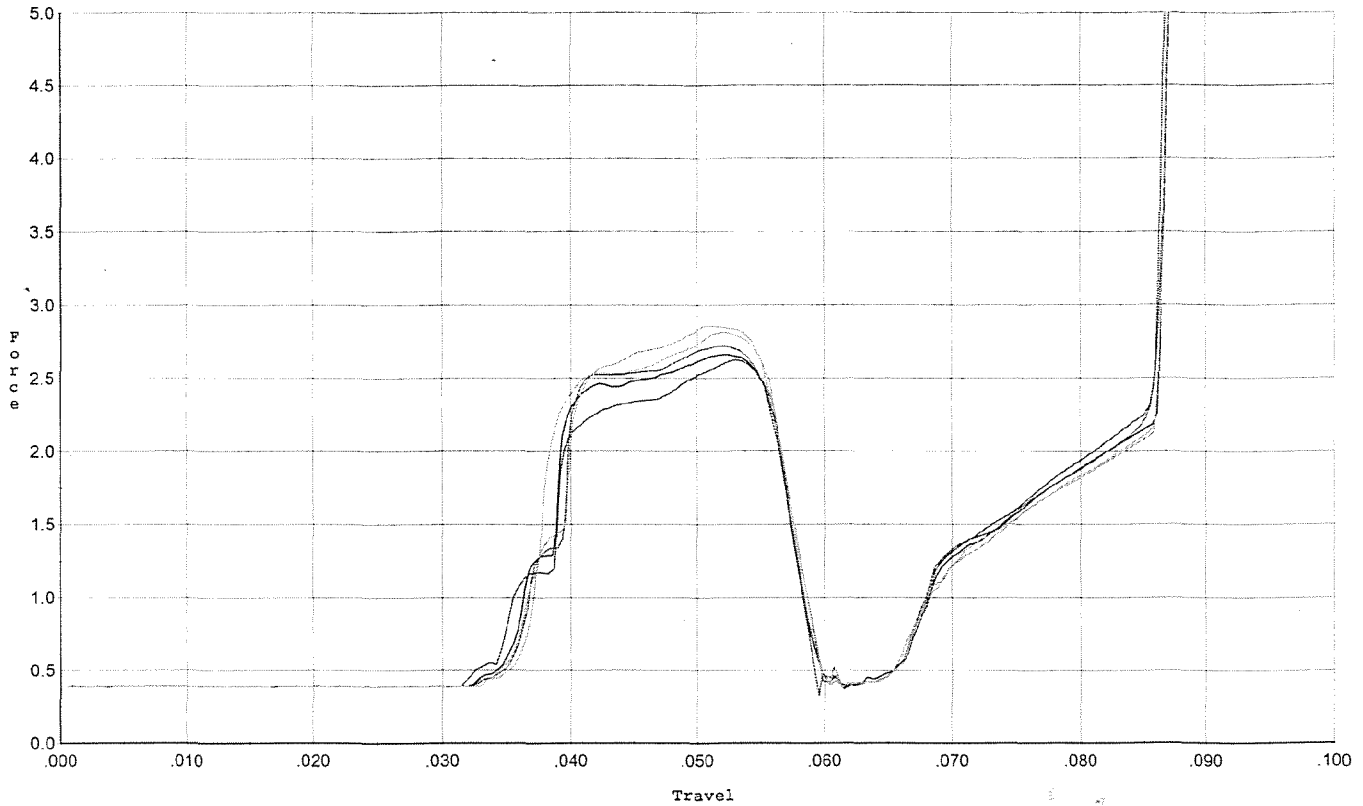
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>3.5</u>	12-2-08	L P
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>5.0</u> <u>5.0</u>	12-2-08	L P
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	12-2-08	L P
	J) ASSEMBLE STOCK		11-12-08	RT
	K) ASSEMBLE SWIVEL STUDS		12-2-08	L P
	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	11-13-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-13-08	J
670	FINAL INSPECTION A) HEADSPACE		12-2-08	L P
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.30</u> <u>2.28</u> <u>2.31</u> <u>2.35</u>	11-20-08	TC
	C) FUNCTION		12-2-08	L P
690	PACK		3/10/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schultz 11/07/2008

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



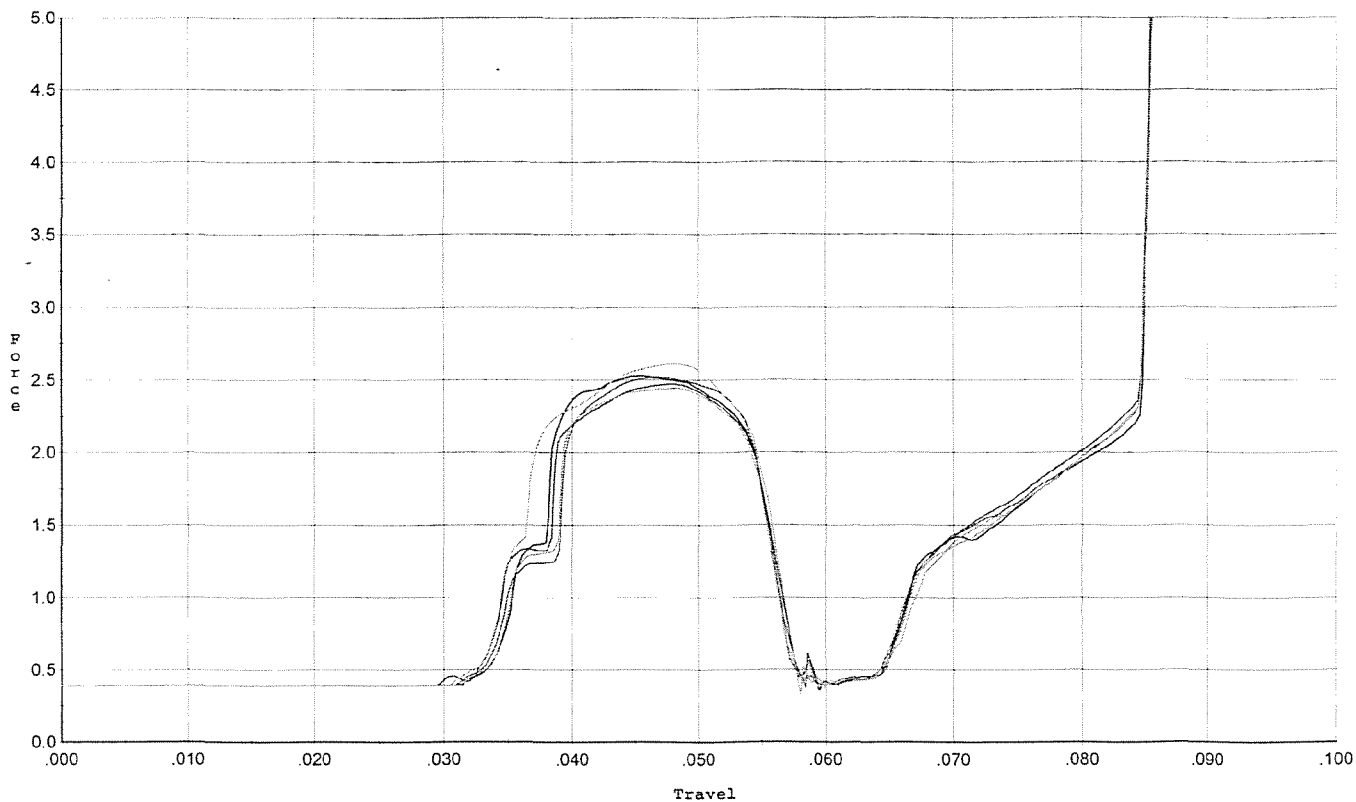
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.056	0.035	0.036	0.060		Set Trigger
2	2.661	0.056	0.035	0.036	0.062		Set Trigger
3	2.722	0.056	0.036	0.036	0.062		Set Trigger
4	2.815	0.056	0.036	0.036	0.064		Set Trigger
5	2.859	0.056	0.036	0.036	0.063		Set Trigger

A-2-73

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



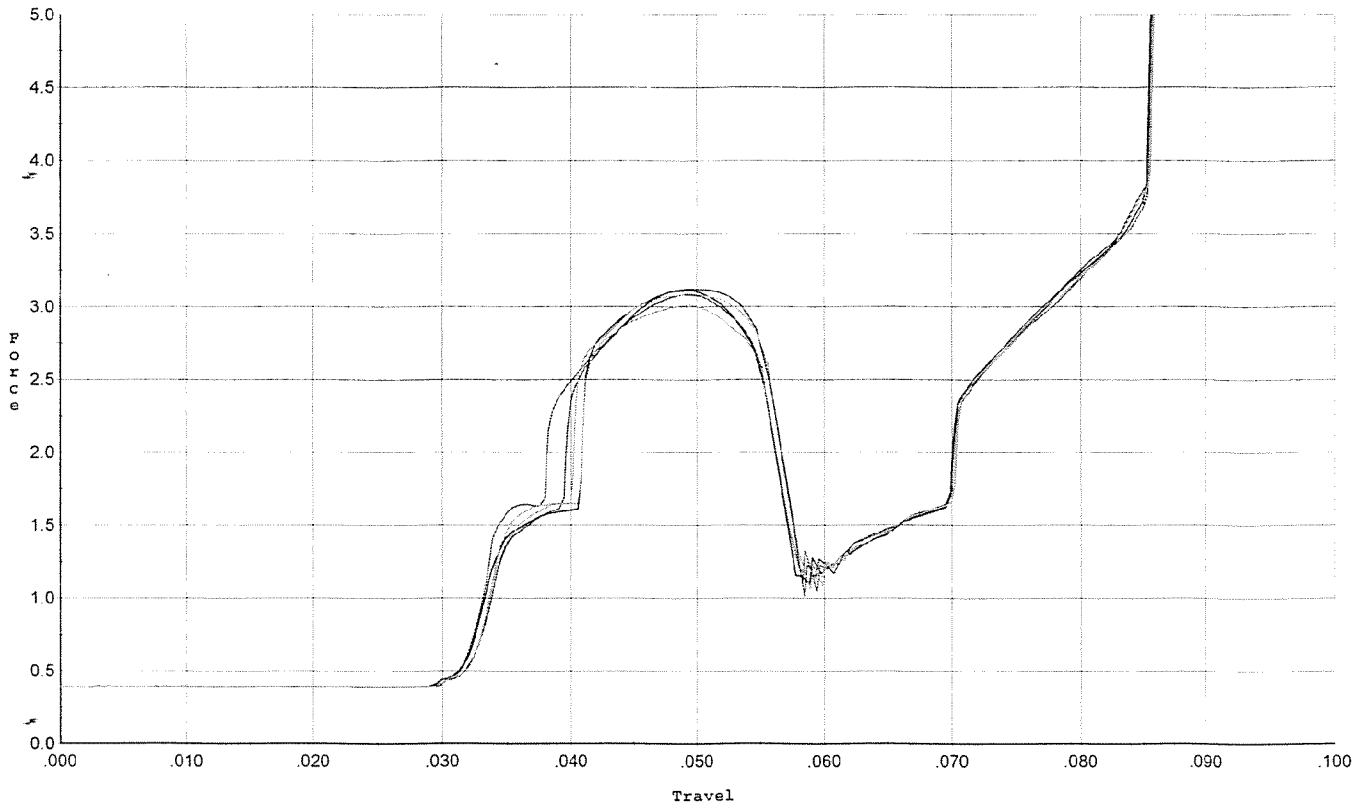
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.055	0.033	0.036	0.057		Set Trigger
2	2.528	0.056	0.034	0.036	0.059		Set Trigger
3	2.523	0.054	0.034	0.036	0.056		Set Trigger
4	2.617	0.055	0.033	0.035	0.062		Set Trigger
5	2.445	0.055	0.034	0.036	0.056		Set Trigger

A-2-SI

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



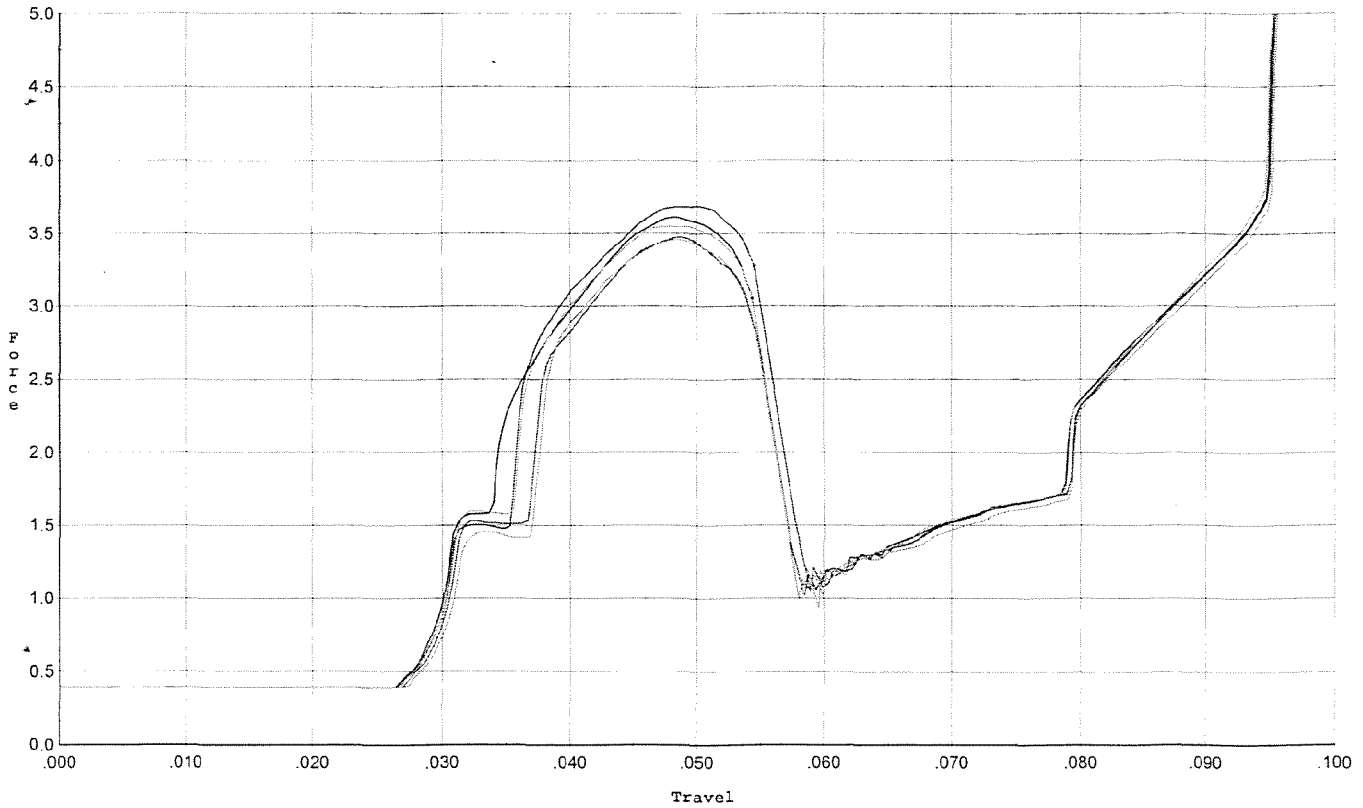
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.056	0.033	0.034	0.070		Set Trigger
2	3.115	0.055	0.032	0.034	0.068		Set Trigger
3	3.082	0.055	0.032	0.034	0.070		Set Trigger
4	3.091	0.056	0.032	0.034	0.070		Set Trigger
5	3.012	0.055	0.032	0.035	0.067		Set Trigger

A3-08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



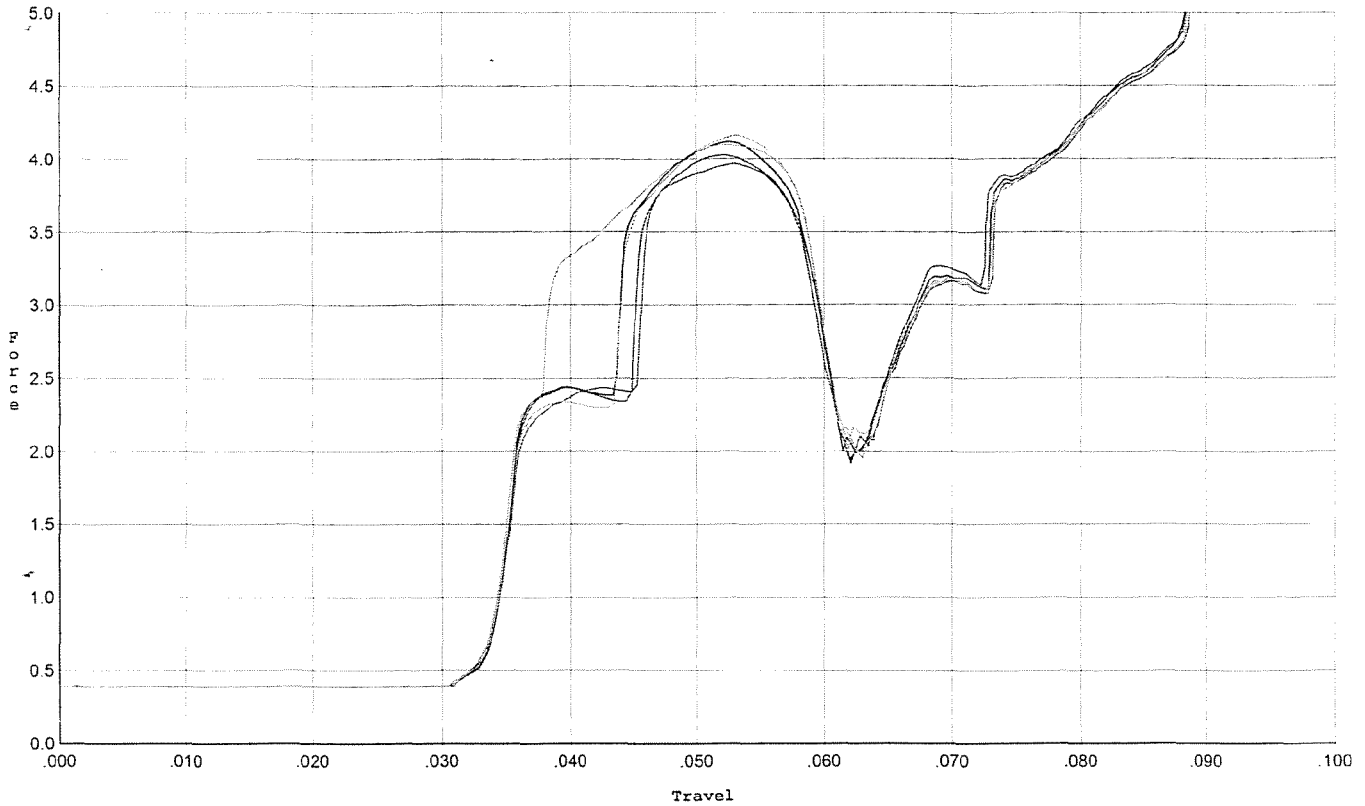
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.690	0.055	0.029	0.041	0.085		Set Trigger
2	3.612	0.054	0.029	0.041	0.084		Set Trigger
3	3.476	0.055	0.029	0.042	0.079		Set Trigger
4	3.550	0.054	0.027	0.042	0.082		Set Trigger
5	3.457	0.055	0.030	0.041	0.078		Set Trigger

A 3.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



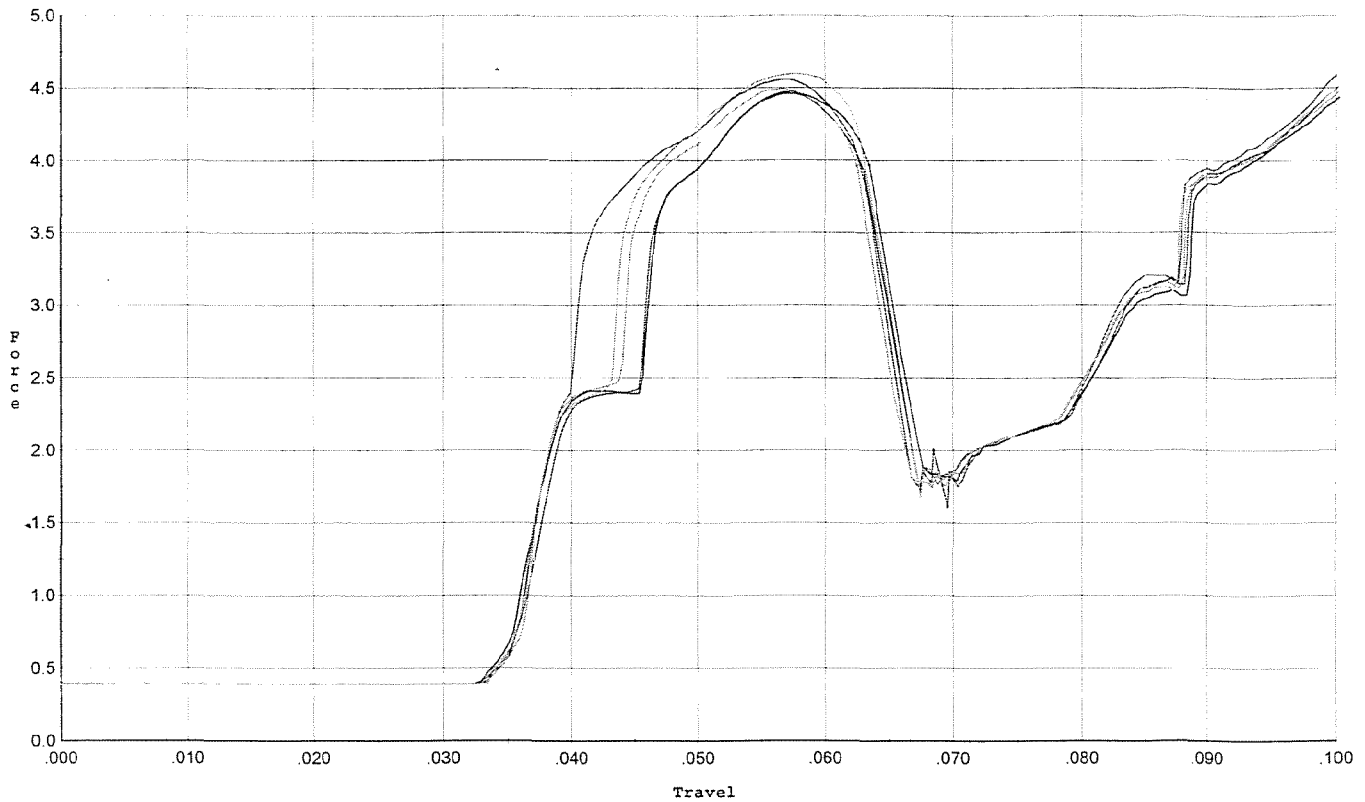
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.026	0.058	0.033	0.034	0.090		Set Trigger
2	4.115	0.059	0.033	0.033	0.095		Set Trigger
3	3.966	0.058	0.033	0.034	0.089		Set Trigger
4	4.096	0.059	0.033	0.033	0.094		Set Trigger
5	4.160	0.059	0.033	0.033	0.101		Set Trigger

A 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



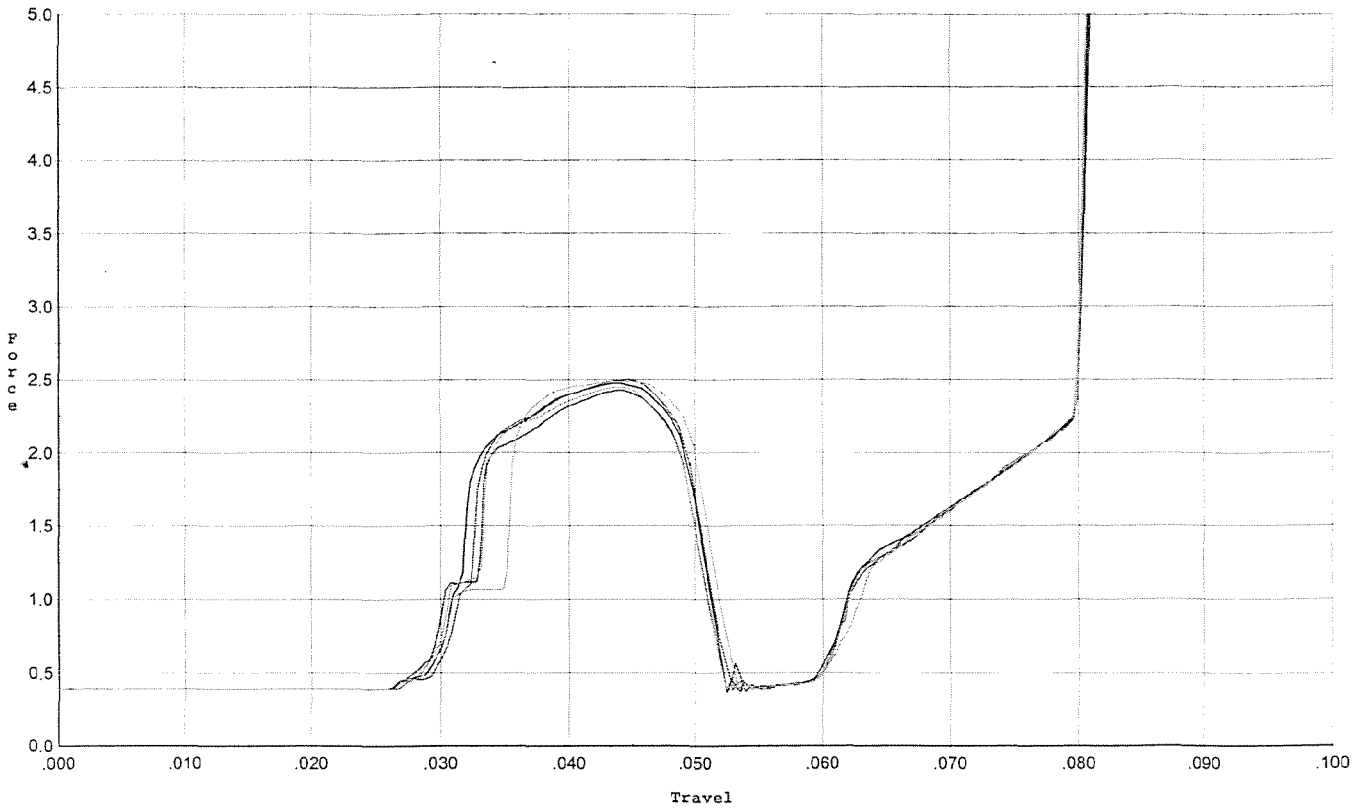
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.473	0.063	0.034	0.041	0.111		Set Trigger
2	4.461	0.065	0.035	0.041	0.114		Set Trigger
3	4.558	0.063	0.034	0.040	0.119		Set Trigger
4	4.597	0.064	0.035	0.040	0.119		Set Trigger
5	4.495	0.062	0.034	0.041	0.111		Set Trigger

A-4-S1

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



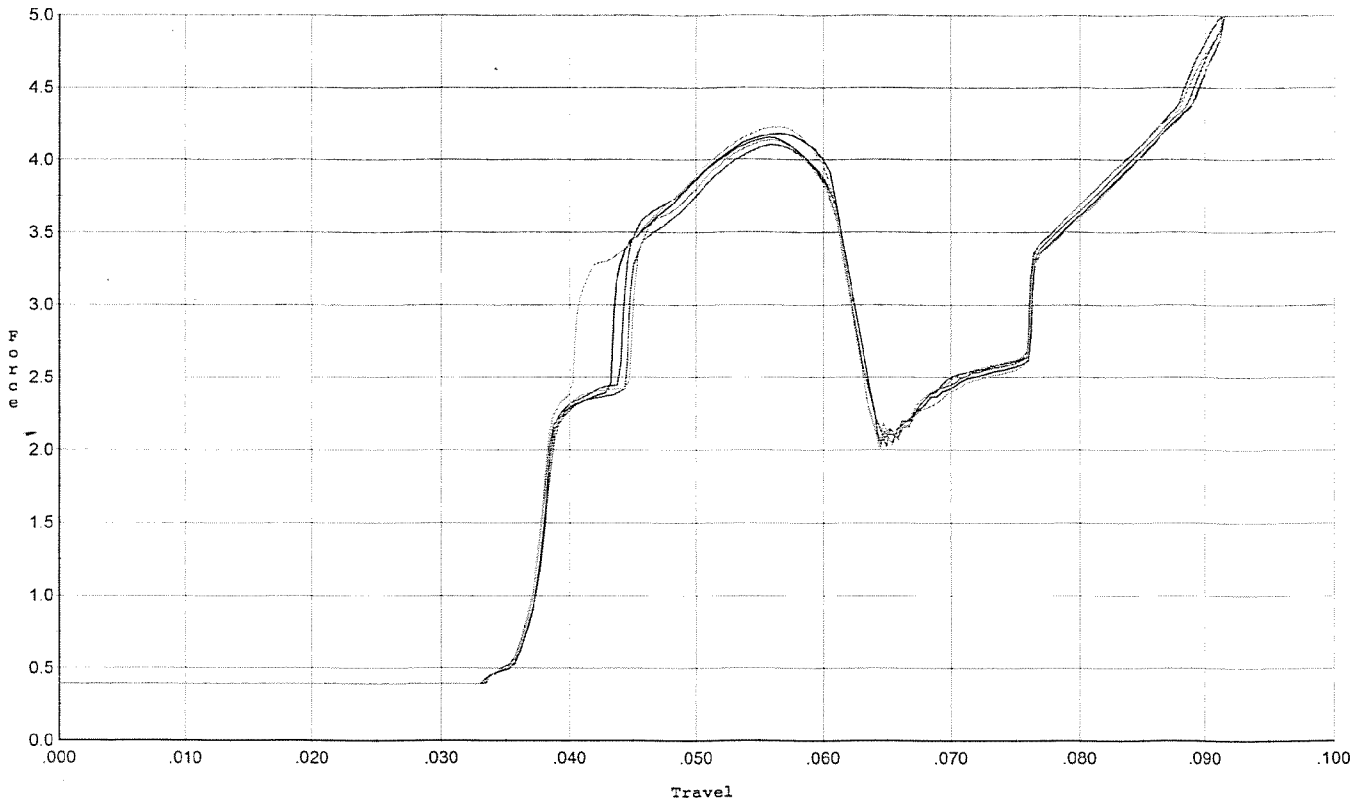
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.424	0.049	0.029	0.035	0.052		Set Trigger
2	2.474	0.050	0.030	0.035	0.055		Set Trigger
3	2.501	0.050	0.030	0.035	0.054		Set Trigger
4	2.449	0.049	0.029	0.035	0.052		Set Trigger
5	2.491	0.050	0.030	0.035	0.053		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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	4.154	0.061	0.036	0.034	0.098		Set Trigger
2	4.180	0.062	0.036	0.033	0.102		Set Trigger
3	4.103	0.061	0.036	0.034	0.096		Set Trigger
4	4.226	0.061	0.036	0.034	0.102		Set Trigger
5	4.136	0.061	0.036	0.034	0.097		Set Trigger

A 4.16