

G6785093

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



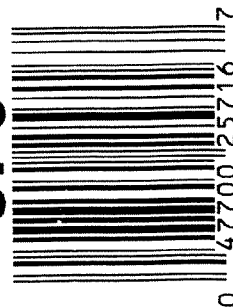
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6785093

UPC



GUN SERIAL # G6785093

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SP
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SP
460	CHECK HEADSPACE		9-19-08	SP
470	DIS-ASSEMBLE ACTION		9-19-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-7-08	RT
475	DRILL AND TAP SIGHT HOLES		10-7-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (R)	10/8/08	(R)
490	MAGNAFLUX BOLT		9/19/08	MR
500	ROLLMARK CALIBER		10/8/08	RT
520	GOFF BLAST BBL / REC		10/8/08	RG
542	APPLY COATINGS (BARREL ACTION)		10/3	
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	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

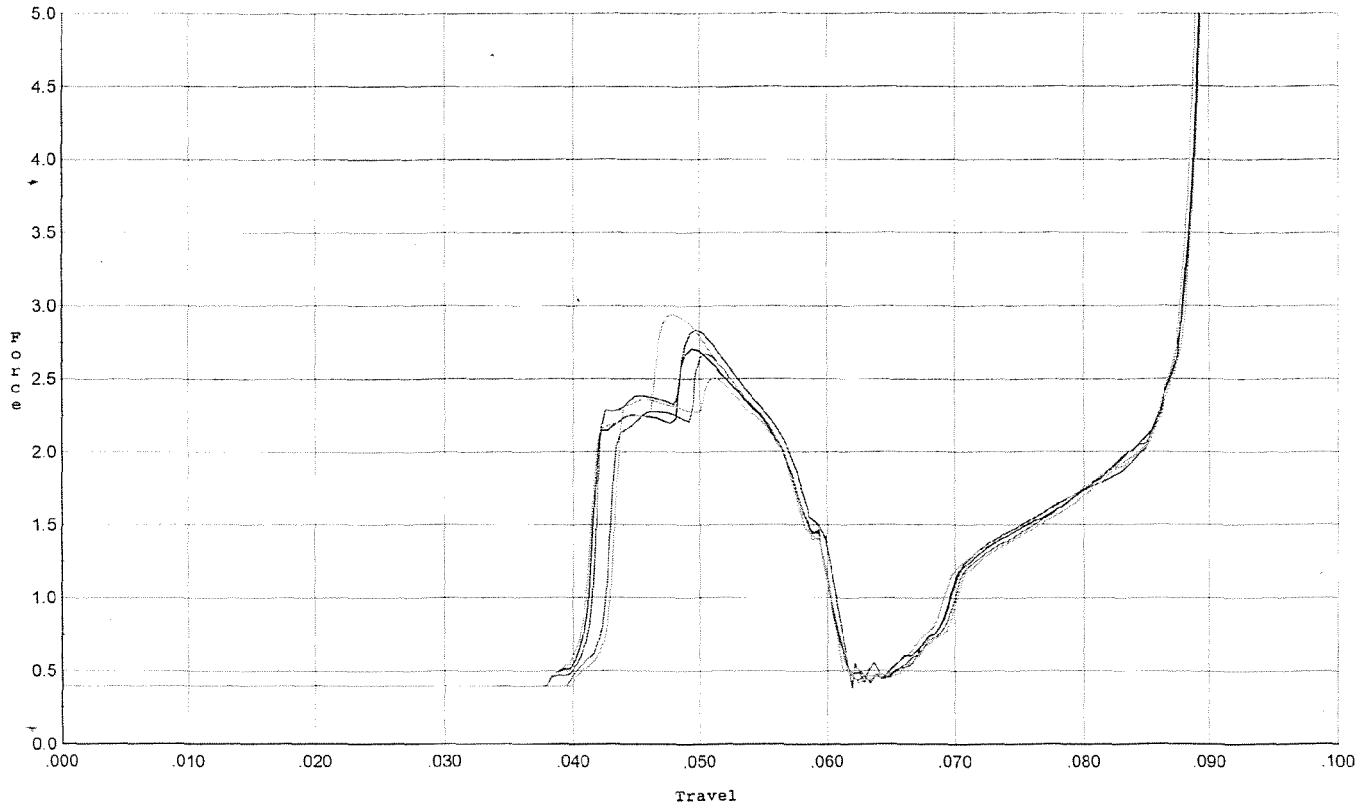
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>40</u> <u>40</u>	12-2-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>50</u>	12-2-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	12-2-08	LJ
	J) ASSEMBLE STOCK		11-12-08	TC
	K) ASSEMBLE SWIVEL STUDS		12-2-08	LJ
	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	LJ
670	FINAL INSPECTION A) HEADSPACE		12-2-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.65</u> <u>2.62</u> <u>2.58</u> <u>2.59</u>	12-2-08	LJ
	C) FUNCTION		12-2-08	LJ
690	PACK		12-3-08	TC

F004 REV 5/2006

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 ini +/- .50 lbs



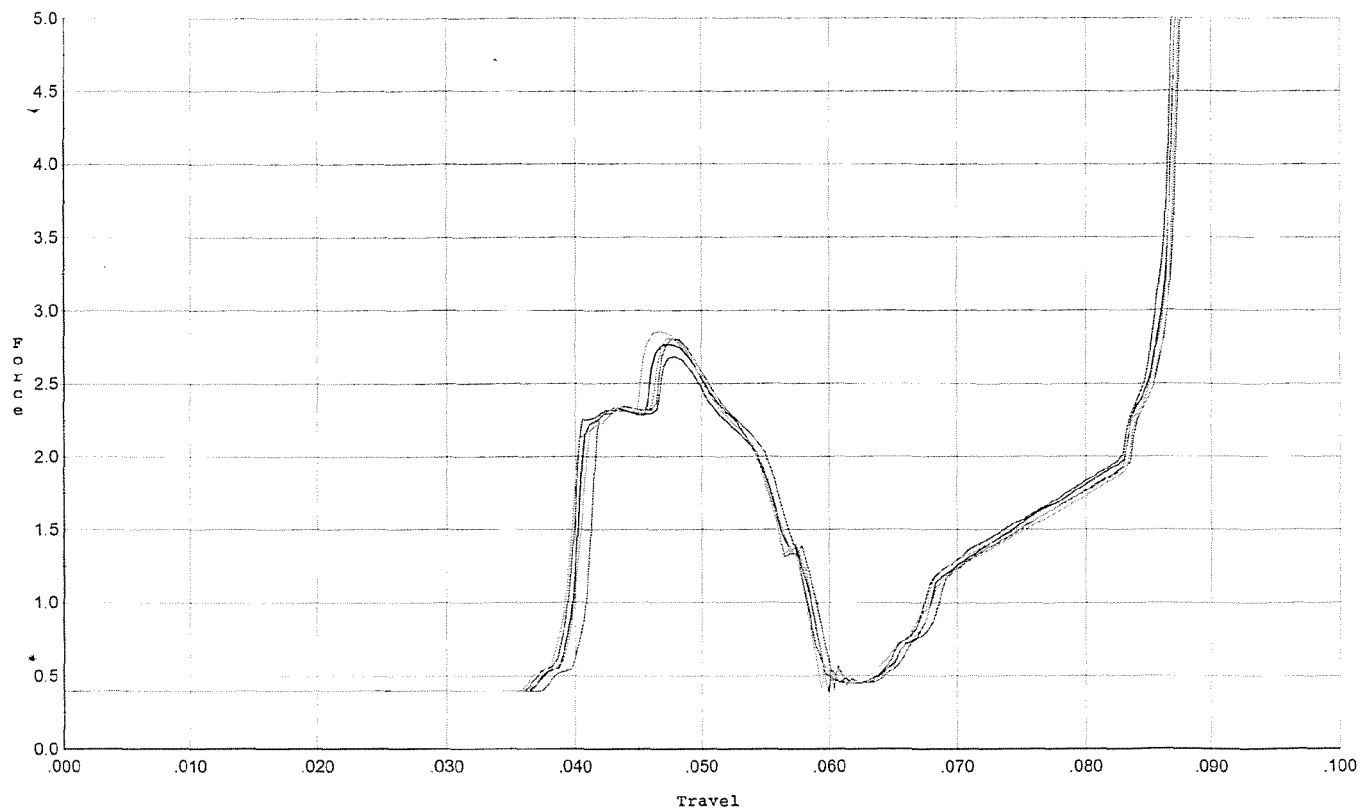
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.837	0.060	0.038	0.036	0.059		Set Trigger
2	2.709	0.059	0.038	0.037	0.057		Set Trigger
3	2.675	0.059	0.042	0.037	0.054		Set Trigger
4	2.508	0.059	0.040	0.037	0.053		Set Trigger
5	2.943	0.059	0.038	0.036	0.059		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



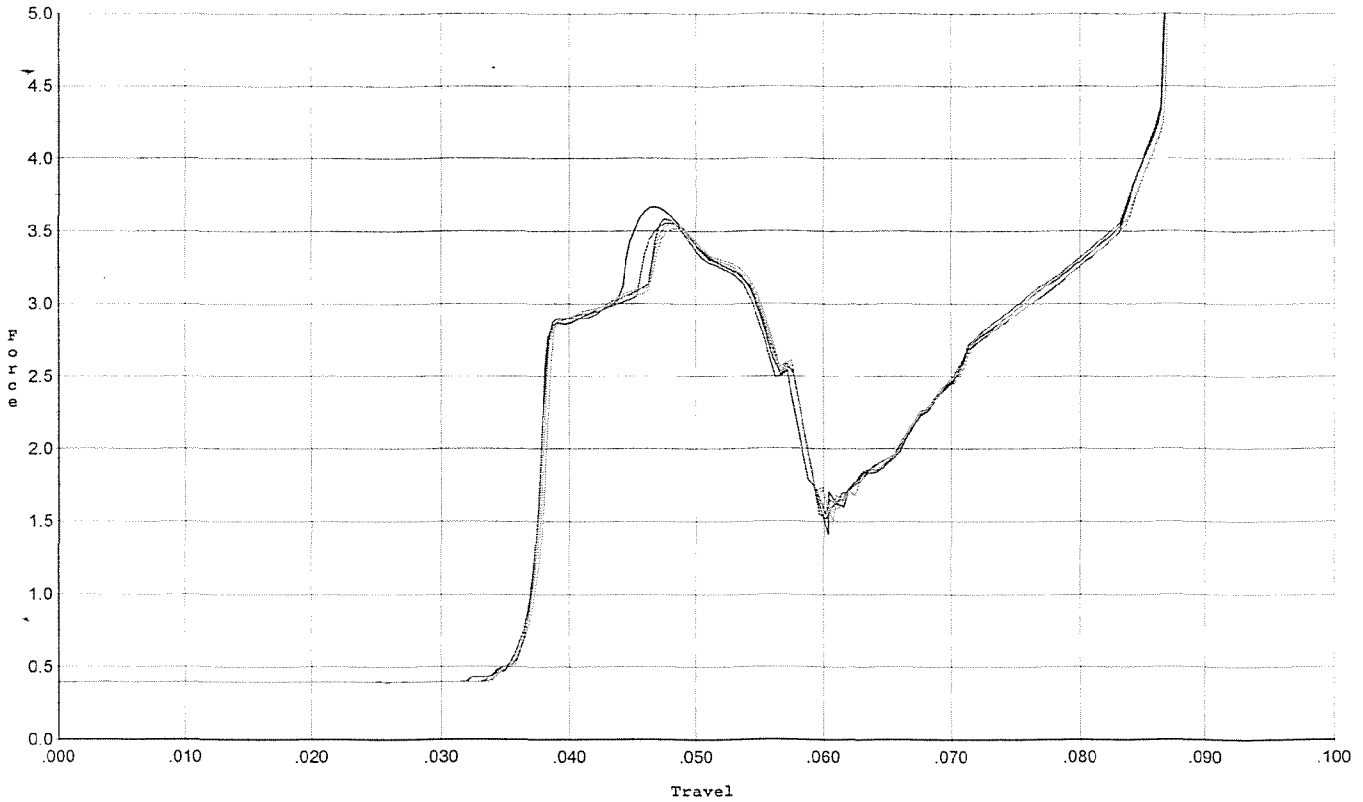
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.686	0.057	0.039	0.036	0.055		Set Trigger
2	2.769	0.058	0.039	0.036	0.056		Set Trigger
3	2.807	0.059	0.040	0.036	0.056		Set Trigger
4	2.806	0.058	0.038	0.036	0.057		Set Trigger
5	2.859	0.058	0.039	0.037	0.055		Set Trigger

A-2.78

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



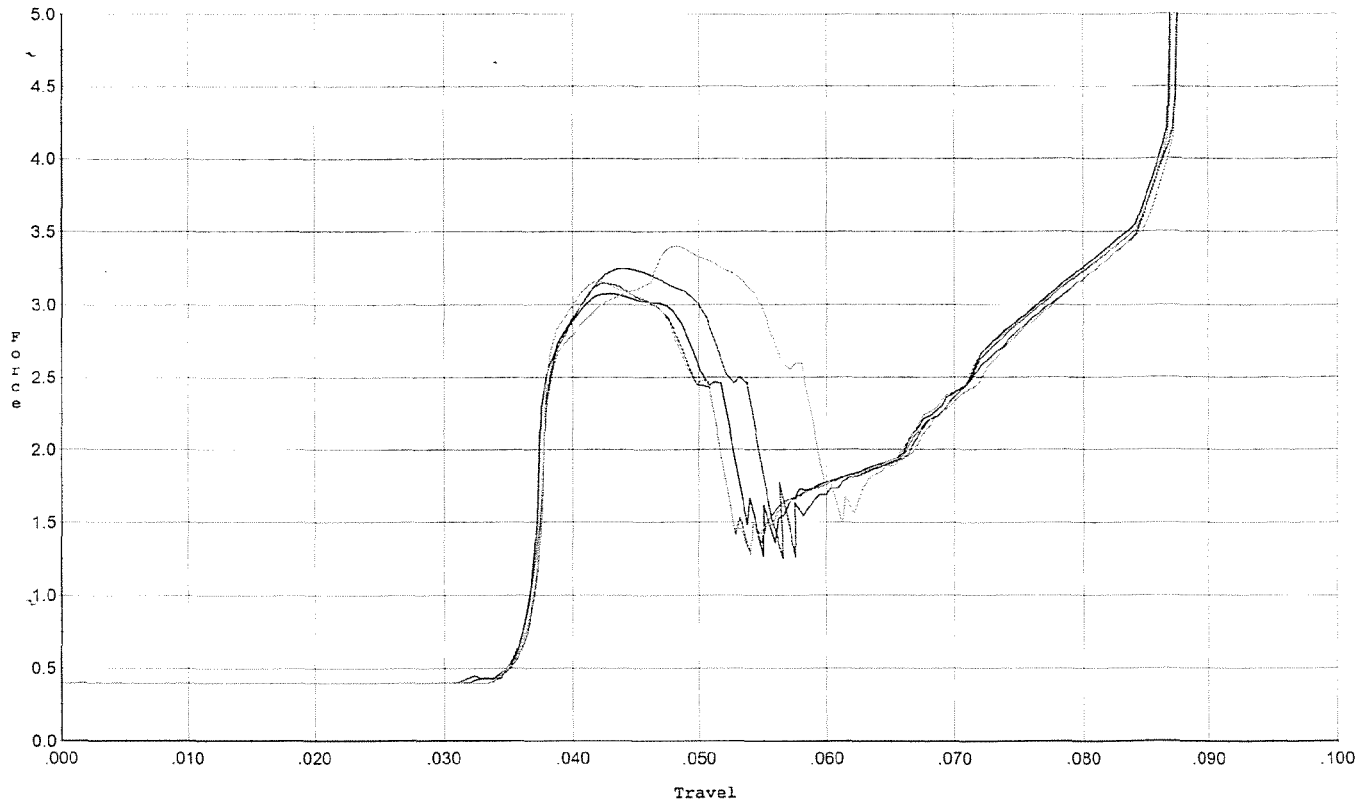
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.583	0.057	0.036	0.035	0.076		Set Trigger
2	3.665	0.058	0.036	0.034	0.079		Set Trigger
3	3.557	0.058	0.036	0.034	0.078		Set Trigger
4	3.550	0.058	0.036	0.034	0.078		Set Trigger
5	3.516	0.058	0.036	0.034	0.077		Set Trigger

A-357

Trigger Profile [lbs,inch]

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

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



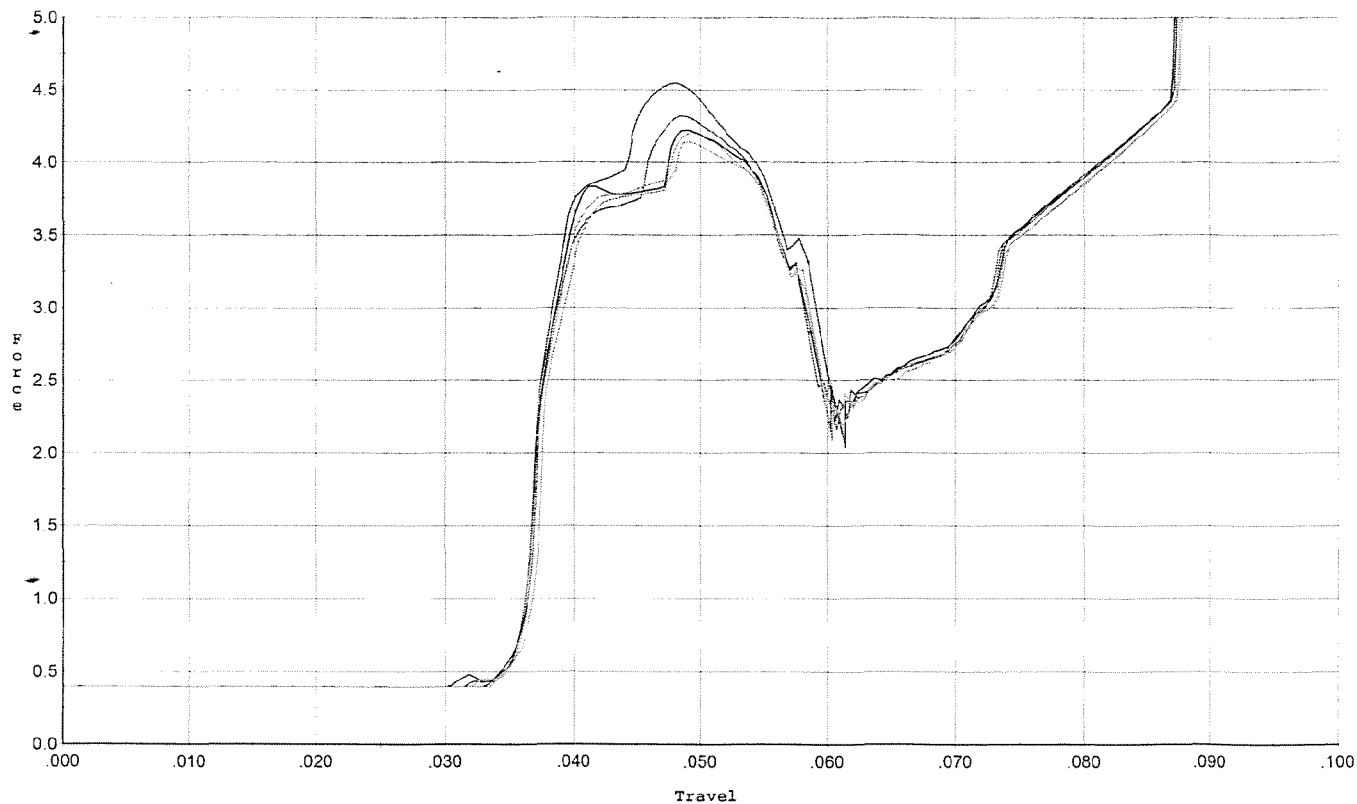
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.252	0.054	0.035	0.037	0.065		Set Trigger
2	3.073	0.052	0.036	0.038	0.058		Set Trigger
3	3.144	0.051	0.036	0.038	0.055		Set Trigger
4	3.401	0.058	0.036	0.034	0.078		Set Trigger
5	3.158	0.051	0.036	0.038	0.055		Set Trigger

A-3-20

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 lbs



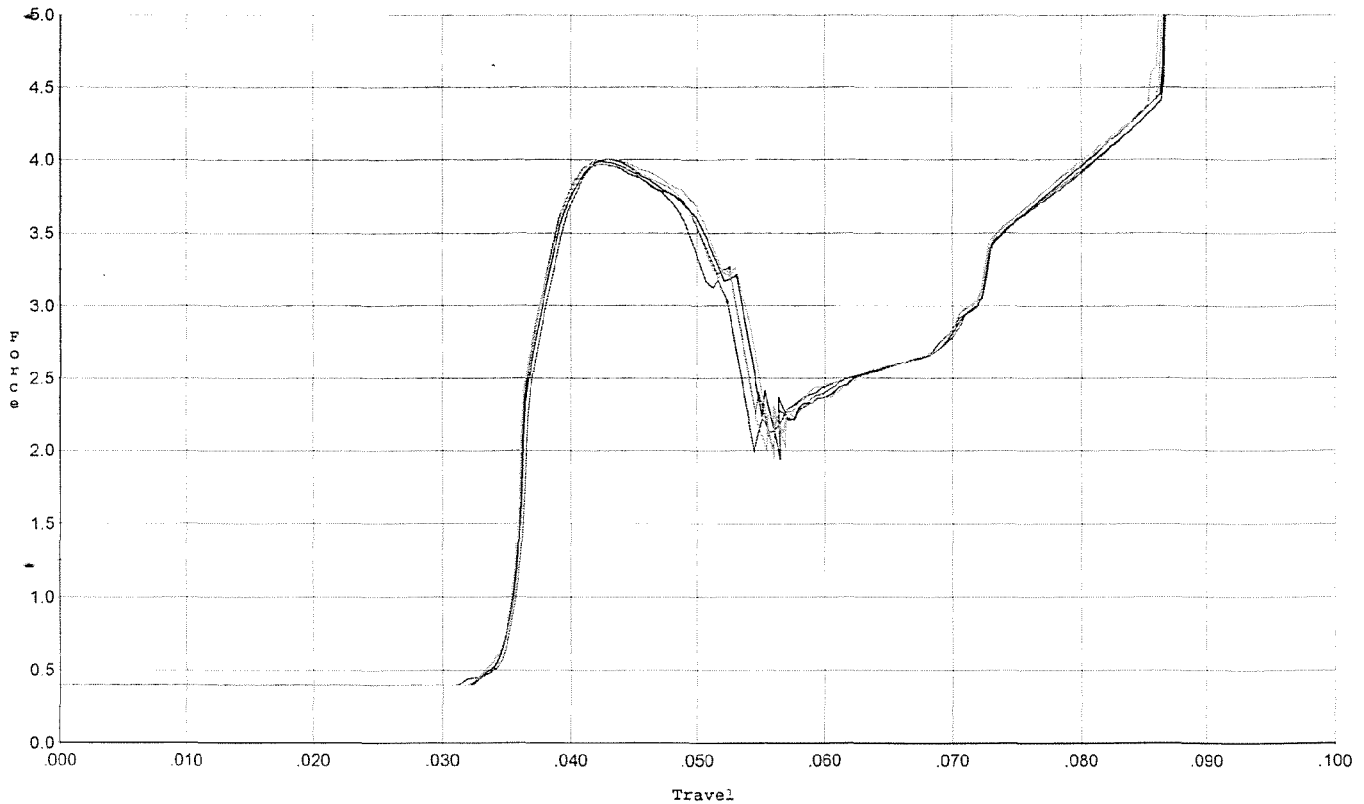
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.548	0.058	0.035	0.033	0.101		Set Trigger
2	4.222	0.059	0.035	0.033	0.096		Set Trigger
3	4.323	0.057	0.035	0.034	0.094		Set Trigger
4	4.143	0.058	0.036	0.033	0.094		Set Trigger
5	4.200	0.058	0.036	0.034	0.093		Set Trigger

A-4.28

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 lbs



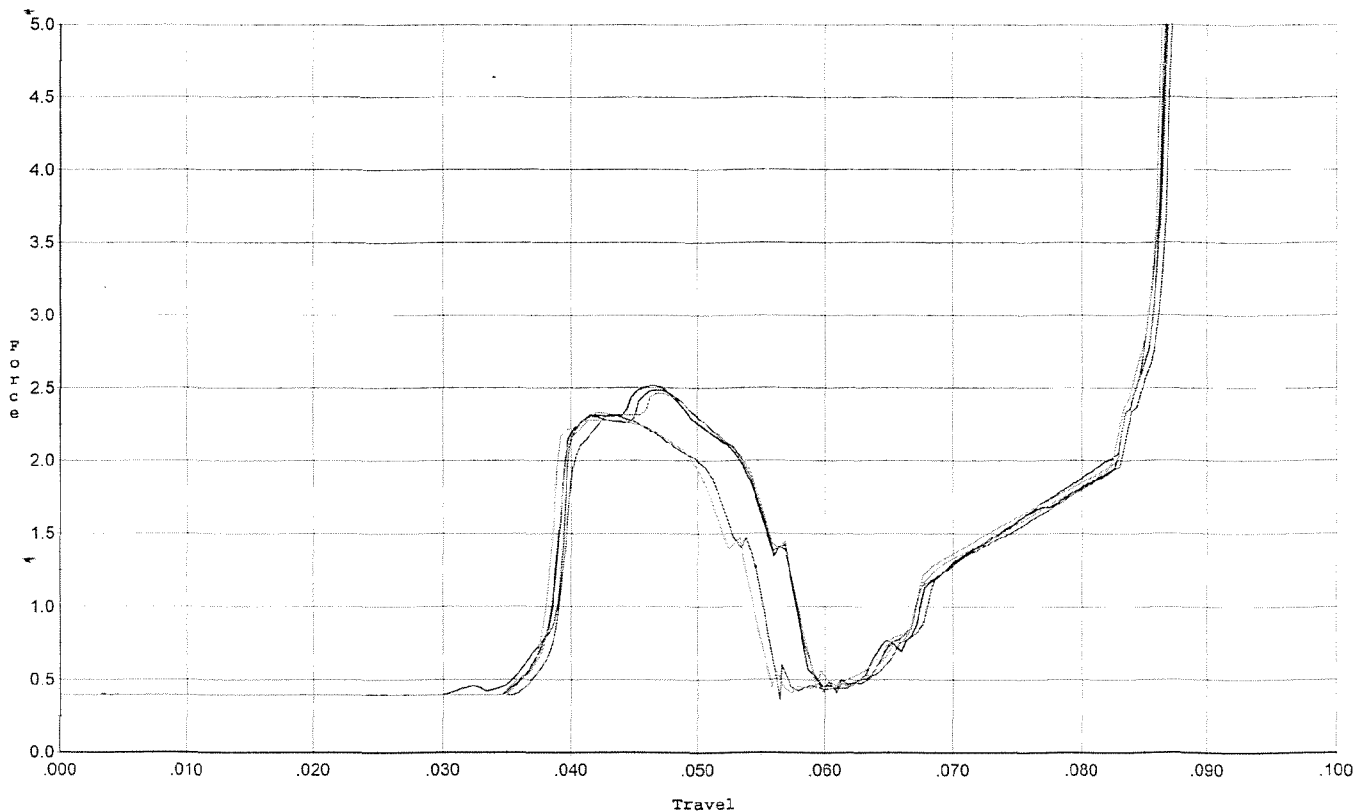
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.988	0.052	0.035	0.036	0.075		Set Trigger
2	4.004	0.053	0.035	0.036	0.078		Set Trigger
3	3.972	0.053	0.035	0.036	0.075		Set Trigger
4	4.004	0.054	0.035	0.035	0.081		Set Trigger
5	3.969	0.053	0.035	0.036	0.077		Set Trigger

A-3.98

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



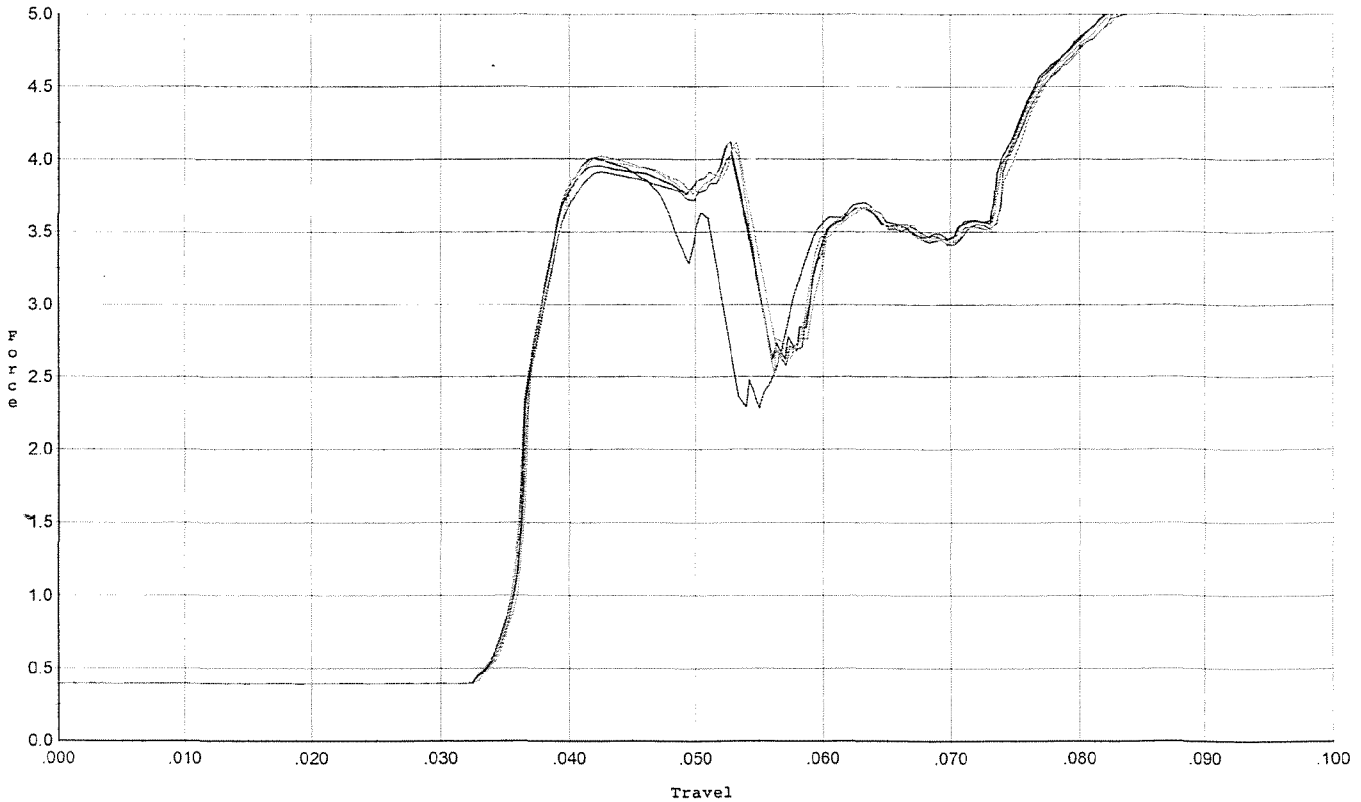
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.486	0.057	0.039	0.037	0.055		Set Trigger
2	2.515	0.057	0.037	0.037	0.055		Set Trigger
3	2.318	0.055	0.038	0.039	0.047		Set Trigger
4	2.281	0.053	0.037	0.038	0.047		Set Trigger
5	2.467	0.057	0.037	0.037	0.055		Set Trigger

A-2.41

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 lb for target 7 accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.012	0.051	0.034	0.036	0.072		Set Trigger
2	4.133	0.054	0.034	0.034	0.084		Set Trigger
3	4.039	0.054	0.034	0.035	0.083		Set Trigger
4	4.134	0.053	0.034	0.034	0.084		Set Trigger
5	4.120	0.055	0.035	0.034	0.086		Set Trigger

A-4.08