

G6794519

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



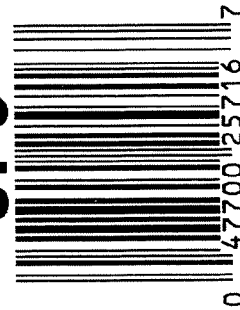
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794519

UPC



GUN SERIAL #

G 6794519

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX 10-28-08	10-28-08	SPD
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (BA)	10/24/08	(BA)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-30	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-5-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

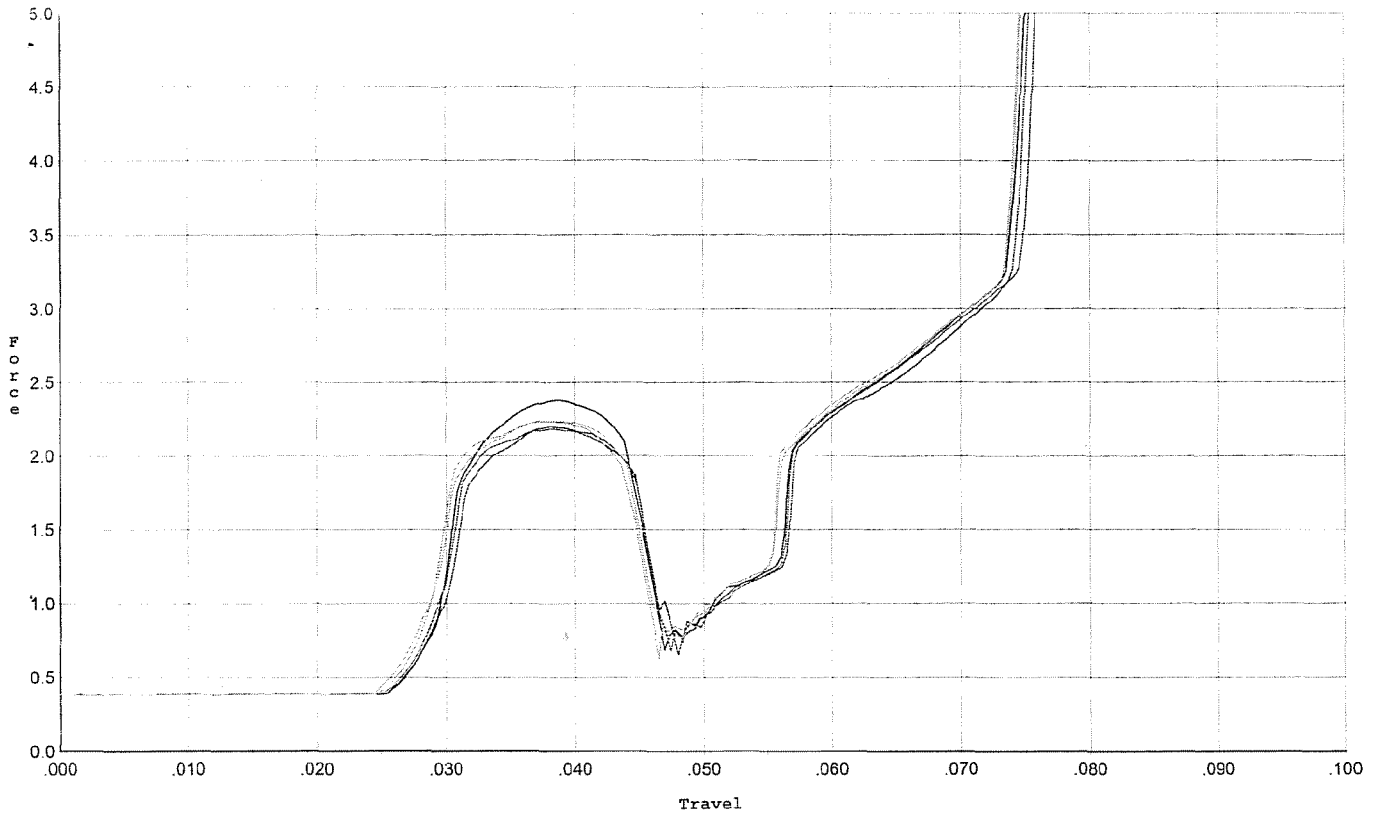
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	12-2-08	L. N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	12-2-08	L. N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-2-08	L. N
	J) ASSEMBLE STOCK		11-18-08	RSN
	K) ASSEMBLE SWIVEL STUDS		12-2-08	L. N
	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	11-19-08	L. N
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	TL
670	FINAL INSPECTION A) HEADSPACE		12-2-08	L. N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.50</u> <u>2.44</u> <u>2.49</u> <u>2.43</u>	11-26-08	TL
	C) FUNCTION		12-2-08	L. N
690	PACK		12/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



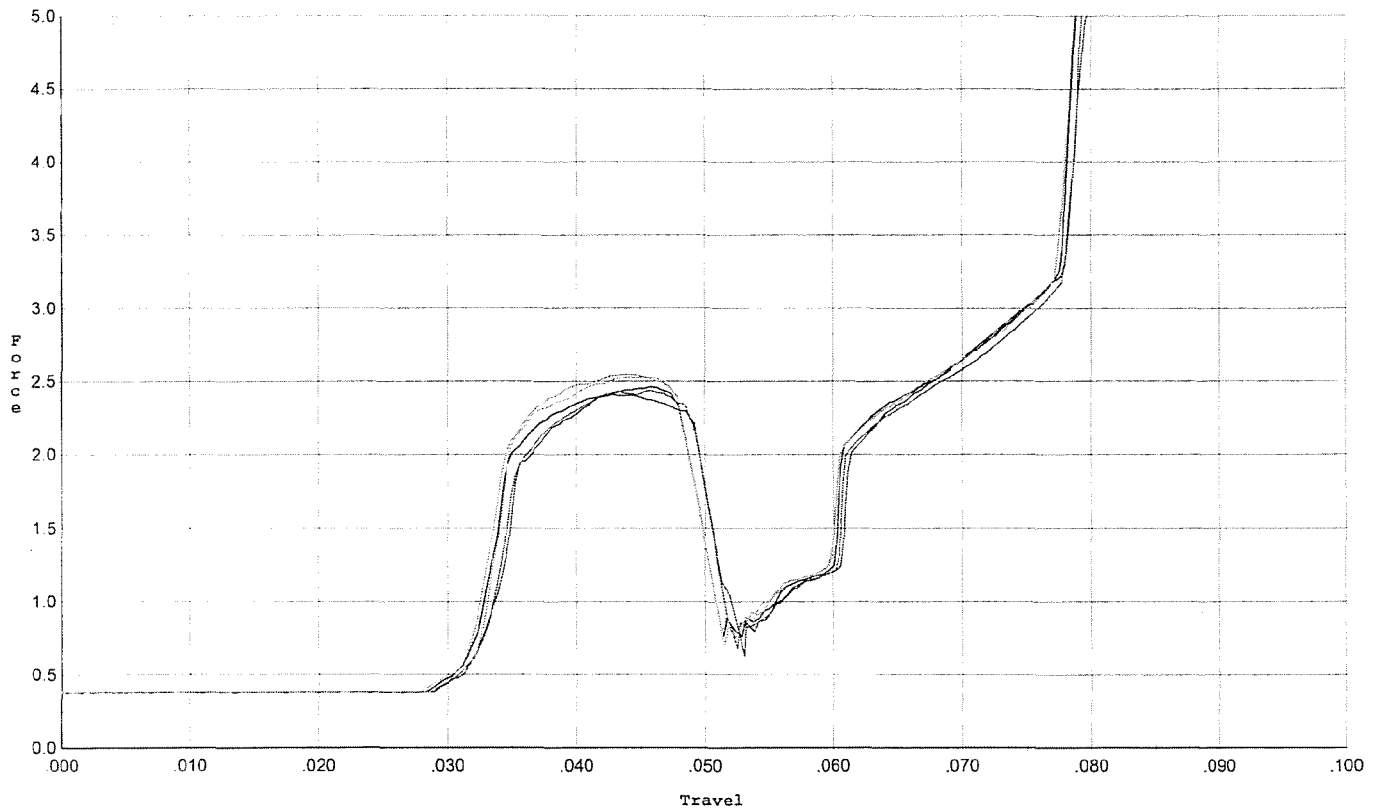
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.197	0.045	0.028	0.035	0.042		Set Trigger
2	2.375	0.045	0.028	0.034	0.045		Set Trigger
3	2.183	0.045	0.028	0.034	0.043		Set Trigger
4	2.234	0.044	0.027	0.034	0.044		Set Trigger
5	2.234	0.045	0.027	0.034	0.044		Set Trigger

A2.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



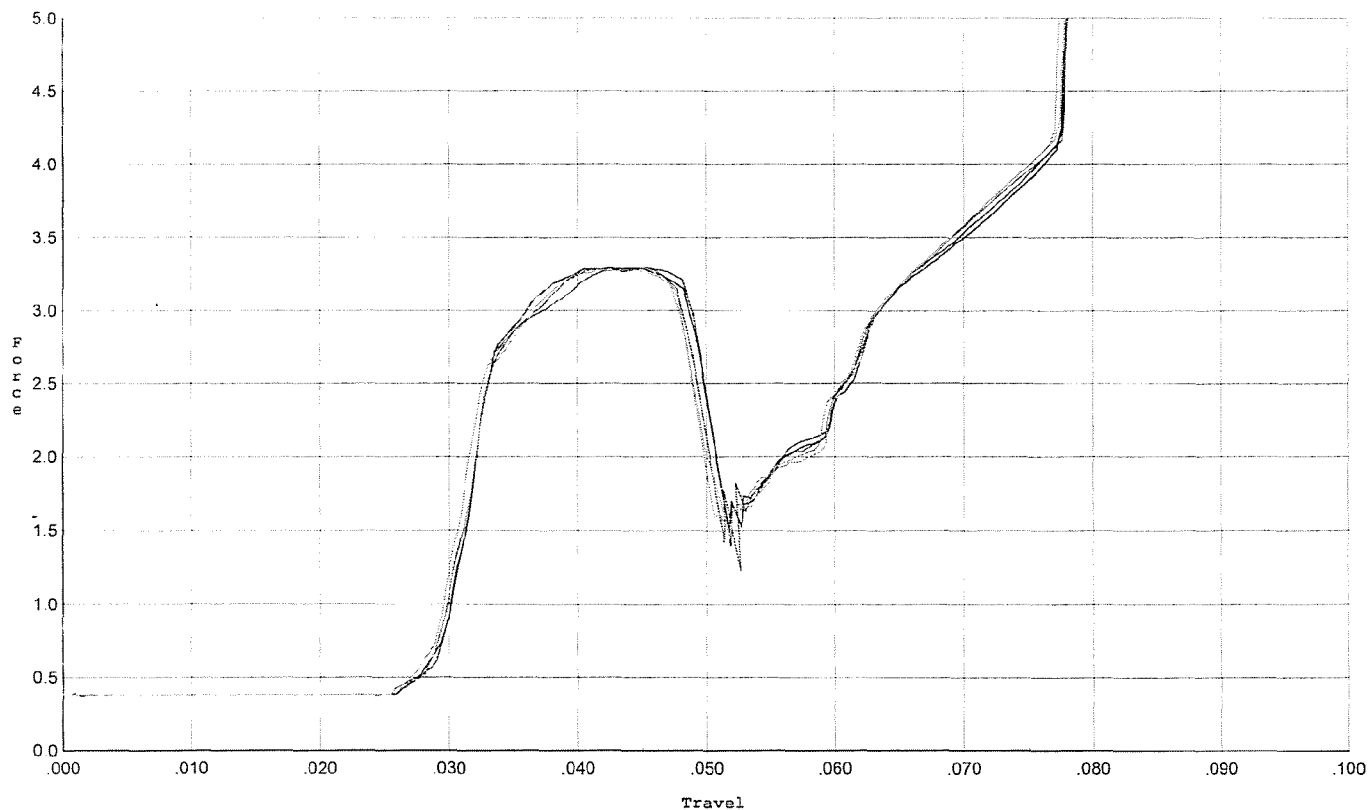
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.411	0.049	0.032	0.035	0.048		Set Trigger
2	2.465	0.050	0.032	0.034	0.050		Set Trigger
3	2.439	0.049	0.032	0.034	0.049		Set Trigger
4	2.531	0.049	0.032	0.034	0.051		Set Trigger
5	2.547	0.048	0.032	0.034	0.050		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



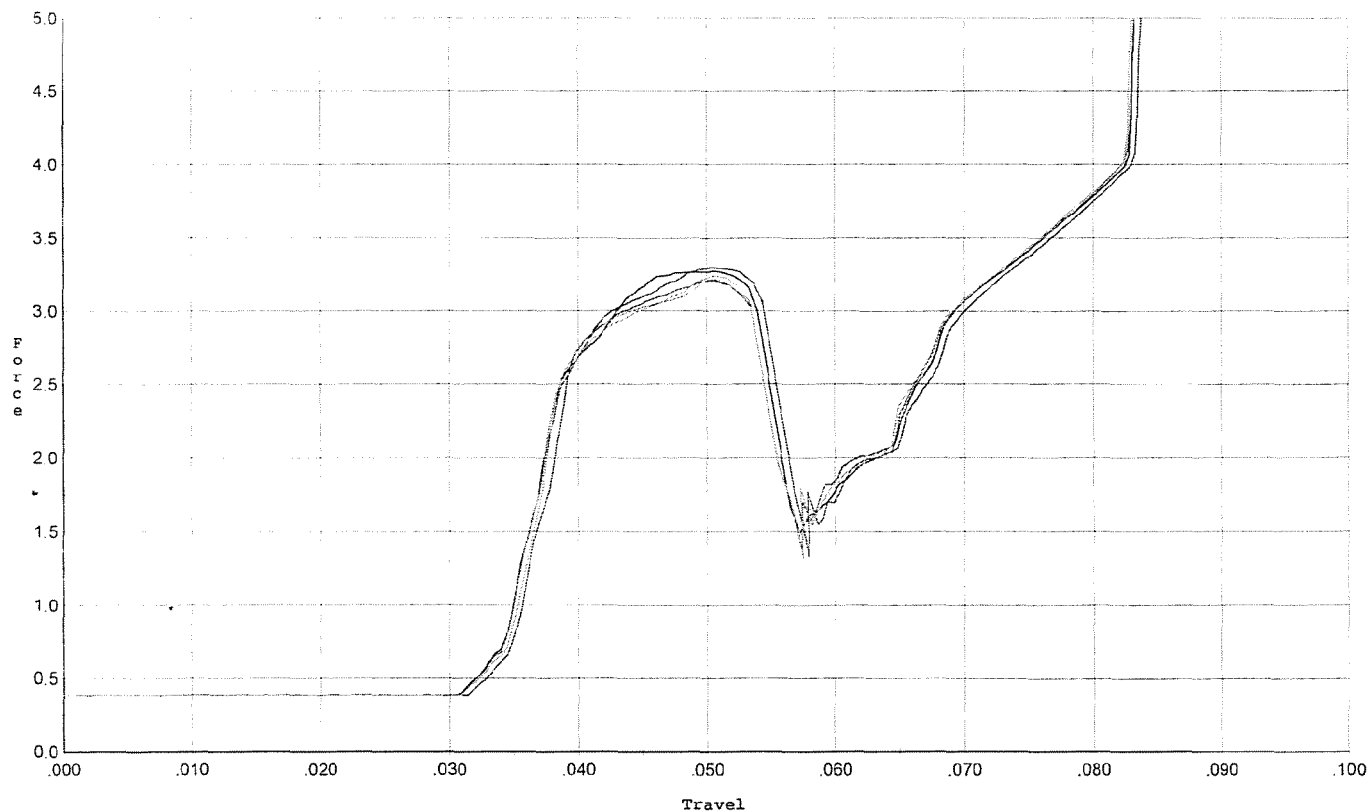
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.298	0.049	0.029	0.032	0.068		Set Trigger
2	3.291	0.049	0.029	0.032	0.069		Set Trigger
3	3.291	0.049	0.029	0.032	0.067		Set Trigger
4	3.280	0.048	0.029	0.032	0.065		Set Trigger
5	3.299	0.048	0.028	0.032	0.067		Set Trigger

A3-29

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



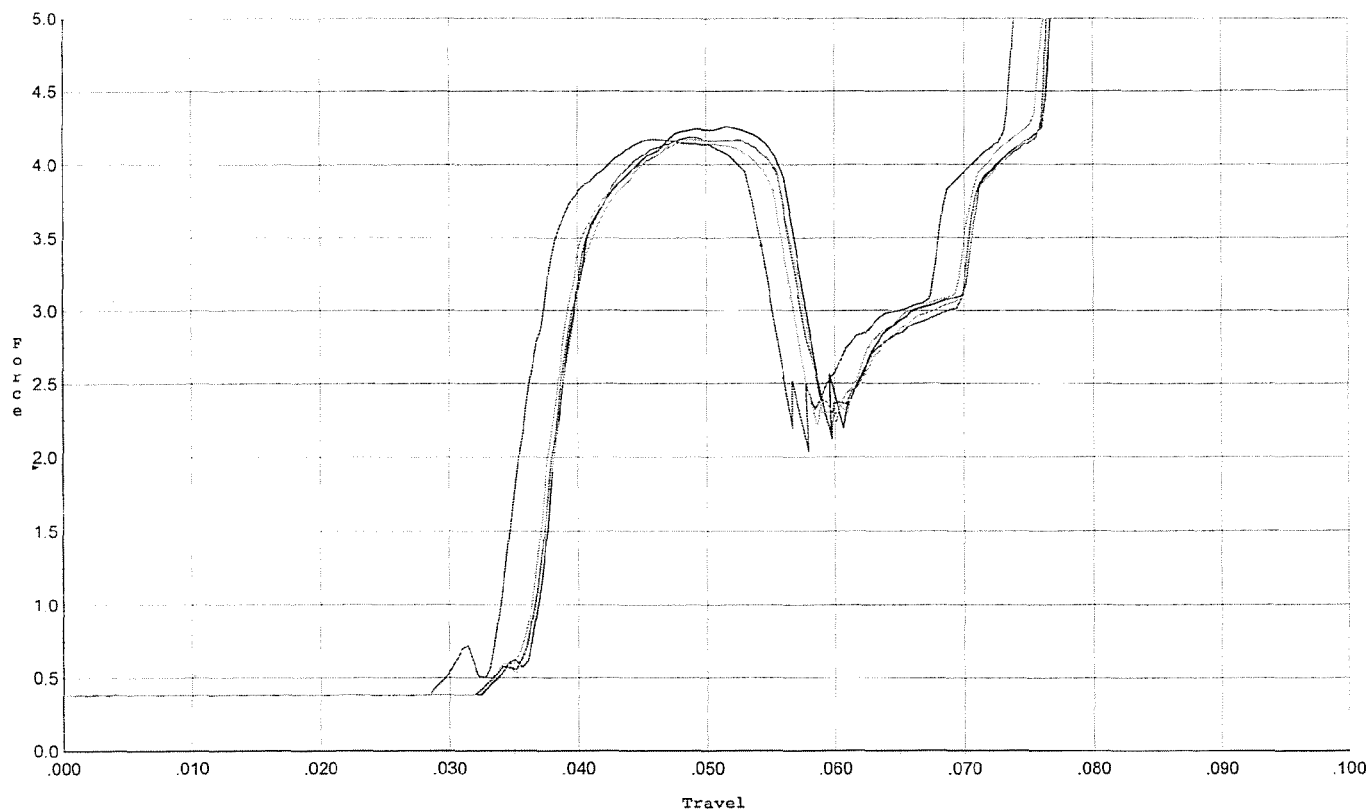
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.299	0.054	0.035	0.034	0.070		Set Trigger
2	3.274	0.054	0.033	0.033	0.070		Set Trigger
3	3.209	0.053	0.033	0.034	0.067		Set Trigger
4	3.242	0.053	0.033	0.034	0.067		Set Trigger
5	3.218	0.053	0.035	0.034	0.067		Set Trigger

A 3.24

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



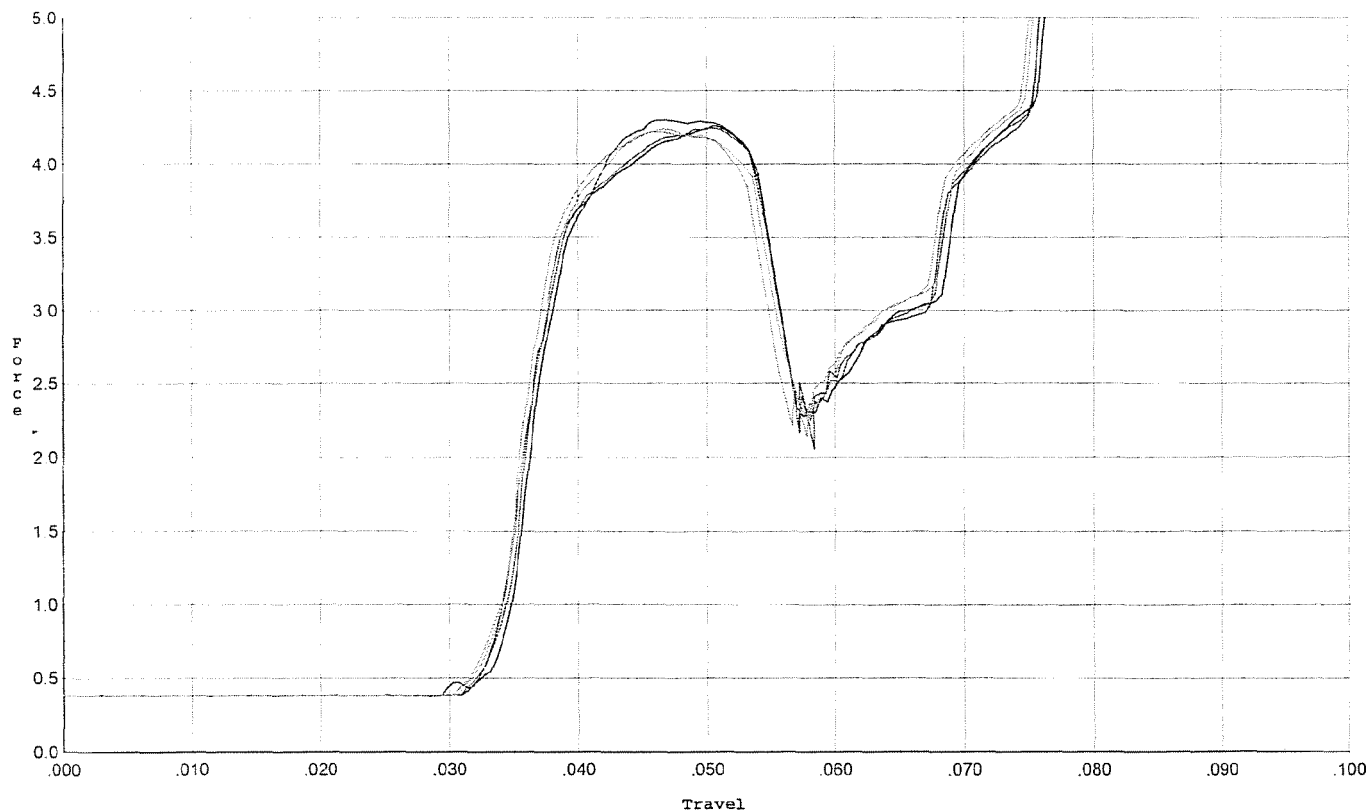
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.054	0.031	0.024	0.090		Set Trigger
2	4.259	0.056	0.035	0.024	0.090		Set Trigger
3	4.188	0.056	0.036	0.024	0.088		Set Trigger
4	4.170	0.057	0.036	0.024	0.090		Set Trigger
5	4.172	0.055	0.035	0.024	0.087		Set Trigger

14.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



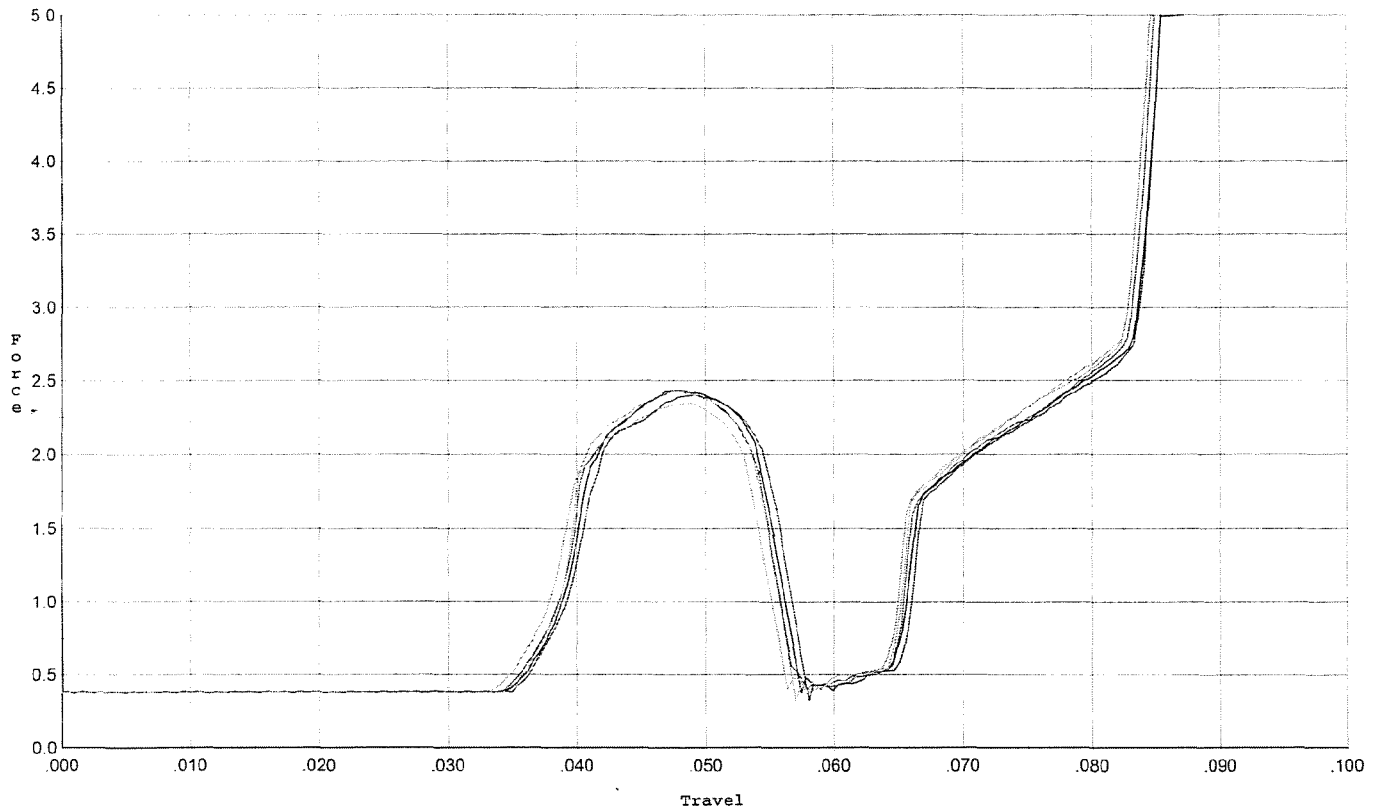
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.300	0.054	0.033	0.025	0.091		Set Trigger
2	4.261	0.054	0.034	0.026	0.088		Set Trigger
3	4.244	0.054	0.031	0.025	0.089		Set Trigger
4	4.237	0.054	0.033	0.025	0.088		Set Trigger
5	4.220	0.053	0.032	0.026	0.087		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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

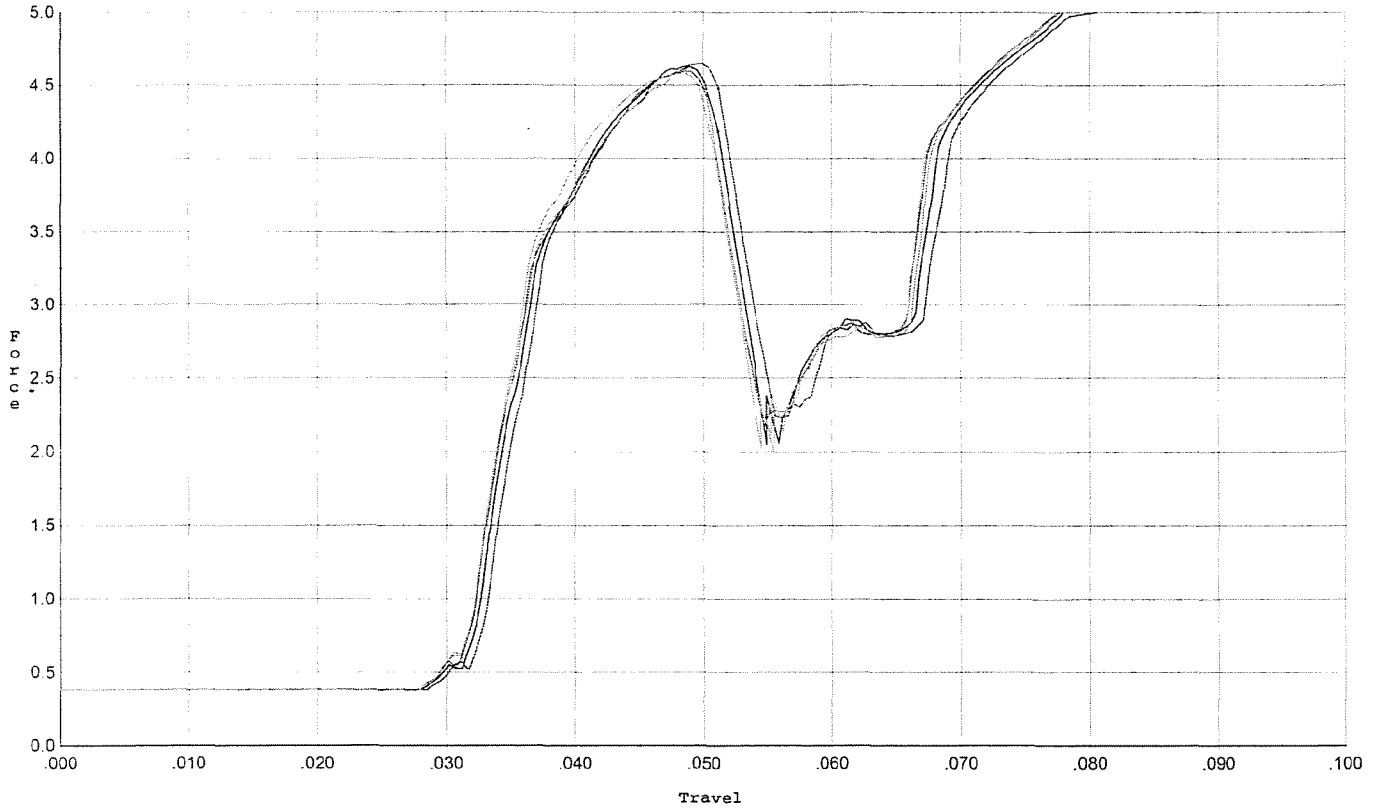


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.403	0.056	0.037	0.037	0.051		Set Trigger
2	2.434	0.055	0.037	0.037	0.051		Set Trigger
3	2.428	0.054	0.036	0.037	0.050		Set Trigger
4	2.347	0.055	0.037	0.037	0.049		Set Trigger
5	2.428	0.054	0.036	0.036	0.051		Set Trigger

A-2.40

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	set to 4.0 lbs +/- 1.0 lb for target & accuracy
Note:	C schults 10/31/2008		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.647	0.051	0.032	0.032	0.086		Set Trigger
2	4.627	0.051	0.032	0.032	0.086		Set Trigger
3	4.598	0.050	0.030	0.032	0.084		Set Trigger
4	4.613	0.050	0.030	0.032	0.084		Set Trigger
5	4.585	0.051	0.030	0.032	0.086		Set Trigger

A-4.61