

G6794552

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

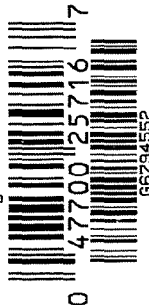
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



ORDER NO.

25716

BARREL LENGTH

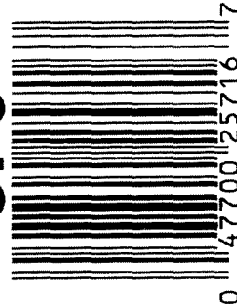
24"

CAPACITY

6

G6794552

UPC



GUN SERIAL # G 6794552

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD
460	CHECK HEADSPACE		9-30-08	SPD
470	DIS-ASSEMBLE ACTION		9-30-08	SPD
472	SERIALIZE BOLT HANDLE		10-1-08	KSM
475	DRILL AND TAP SIGHT HOLES	MAGNA FLUX 2008	10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (B)	10/2/08	(B)
490	MAGNAFLUX BOLT		9-30-08	ma
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10 8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-11-08	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-11-08	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-11-08	SPD
	D) OIL FIRING PIN ASSEMBLY		11-13-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

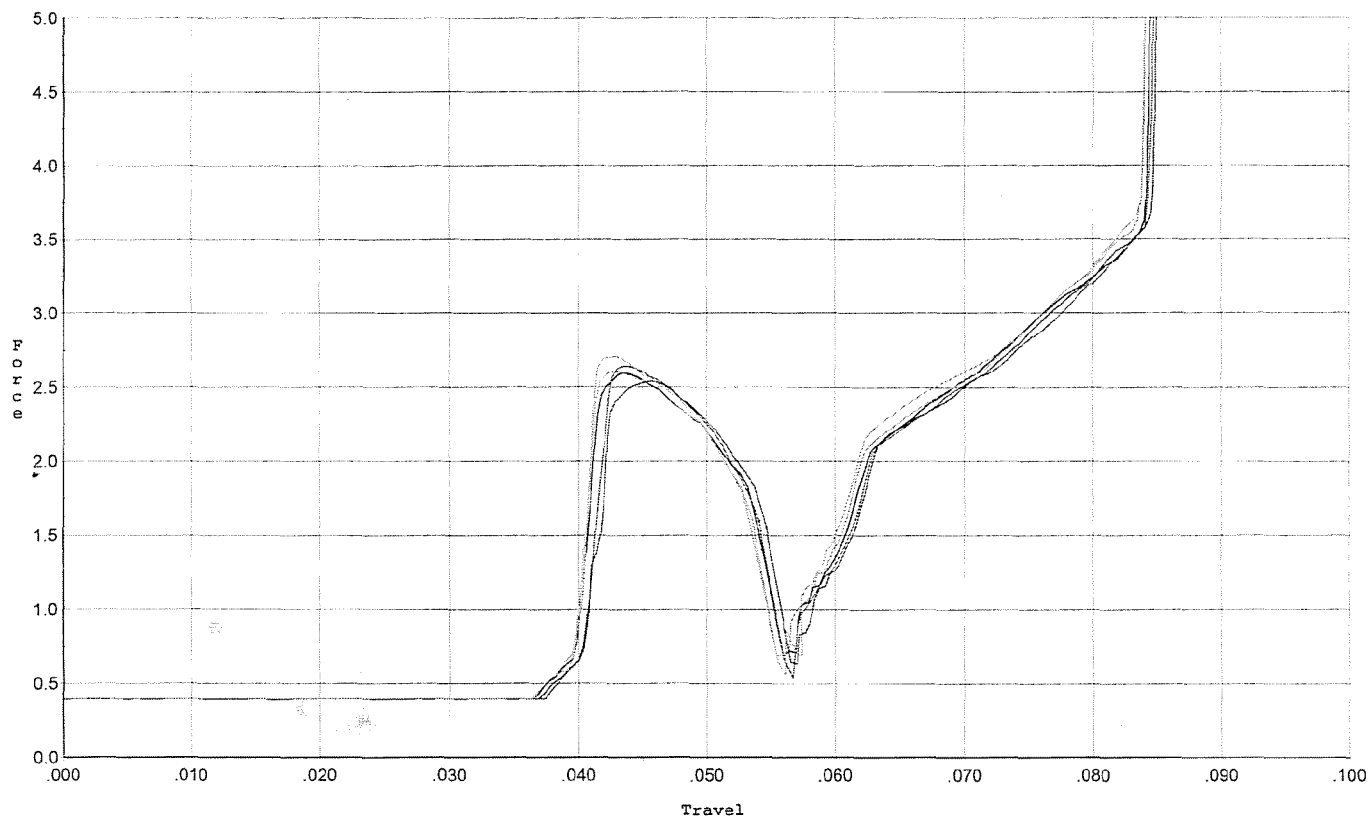
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>3.5</u>	11-8-08	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>4.0</u>	12-2-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	12-2-08	L.N.
	J) ASSEMBLE STOCK		11-13-08	L.N.
	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	11-14-08	L.N.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-14-08	TC
670	FINAL INSPECTION A) HEADSPACE		12-2-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.39</u> <u>2.42</u> <u>2.36</u> <u>2.38</u>	11-20-08	TC
	C) FUNCTION		12-2-08	L.N.
690	PACK		12-2-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



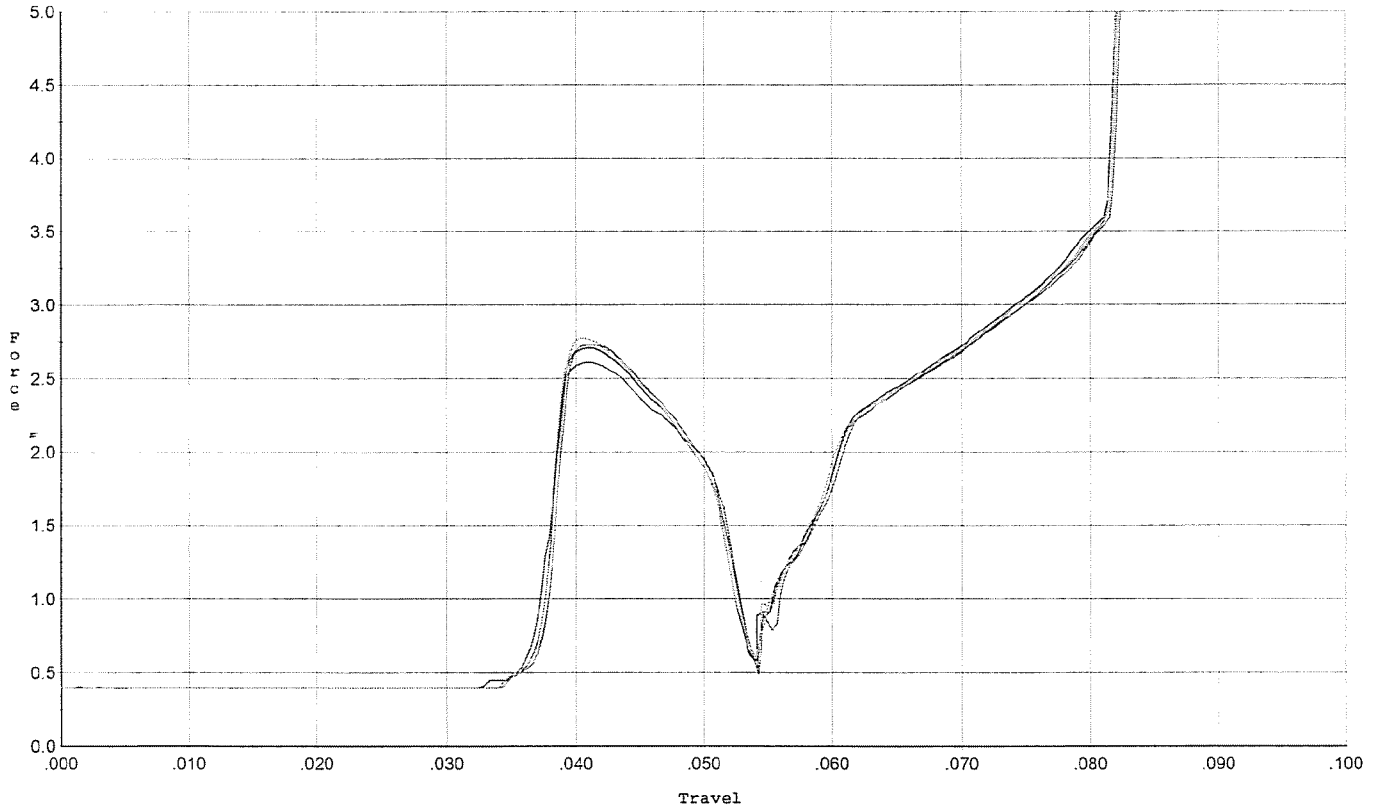
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.541	0.055	0.040	0.037	0.047		Set Trigger
2	2.597	0.054	0.040	0.037	0.048		Set Trigger
3	2.640	0.054	0.038	0.037	0.047		Set Trigger
4	2.607	0.054	0.040	0.037	0.047		Set Trigger
5	2.710	0.054	0.040	0.037	0.048		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/062008

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



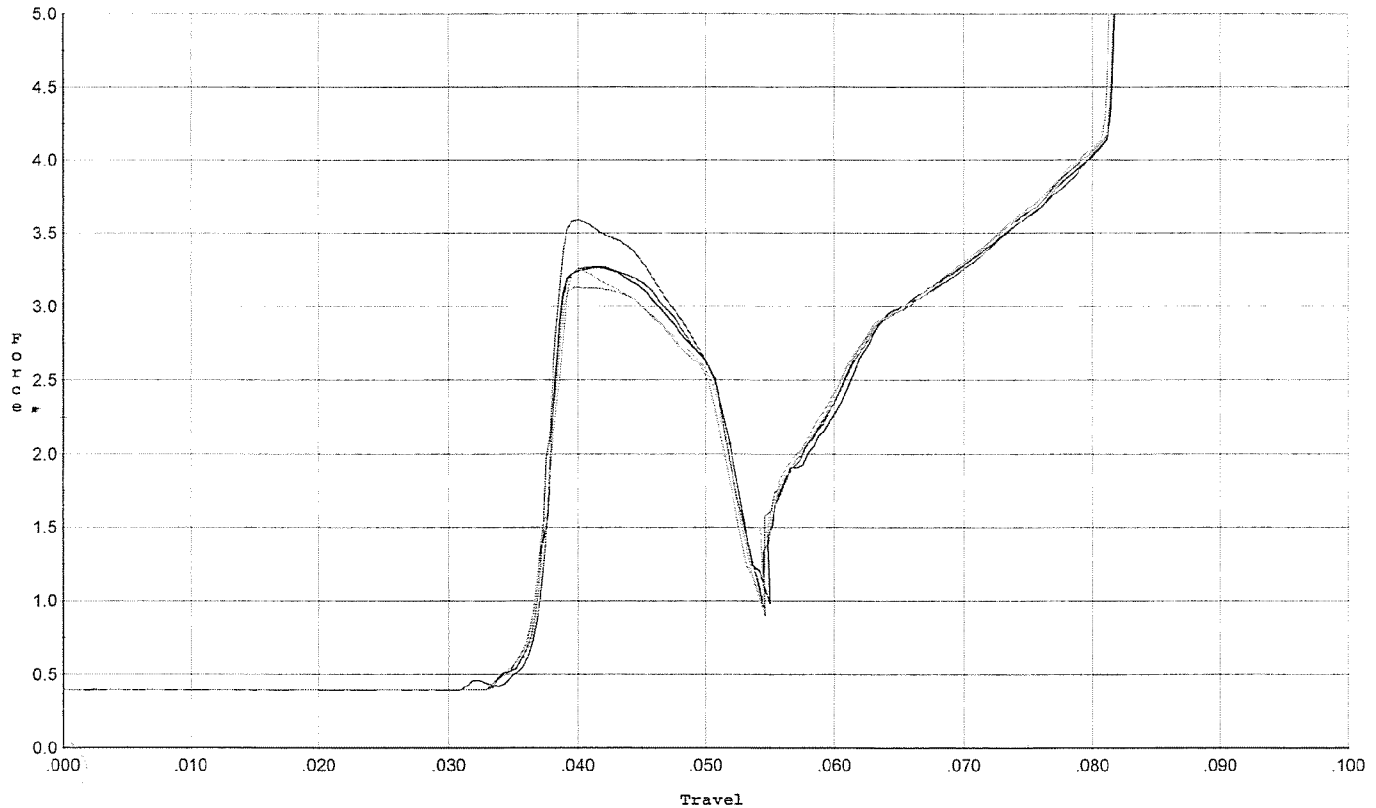
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.611	0.052	0.036	0.037	0.048		Set Trigger
2	2.708	0.051	0.037	0.037	0.047		Set Trigger
3	2.728	0.052	0.037	0.037	0.047		Set Trigger
4	2.772	0.052	0.037	0.037	0.048		Set Trigger
5	2.728	0.051	0.037	0.037	0.047		Set Trigger

A-2.70

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



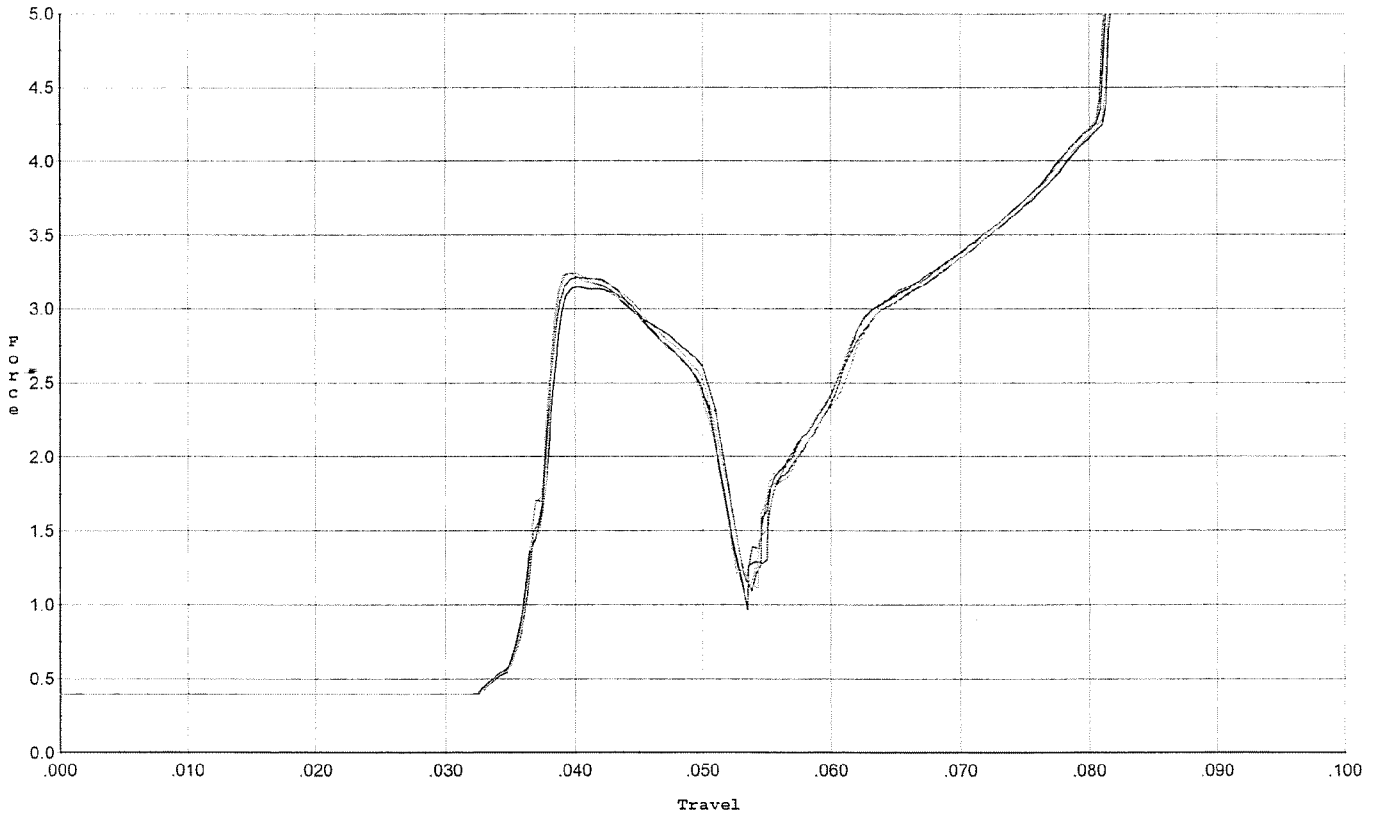
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.270	0.051	0.036	0.036	0.057		Set Trigger
2	3.265	0.052	0.035	0.036	0.058		Set Trigger
3	3.591	0.051	0.036	0.036	0.059		Set Trigger
4	3.252	0.051	0.036	0.036	0.055		Set Trigger
5	3.131	0.051	0.036	0.036	0.056		Set Trigger

A-330

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



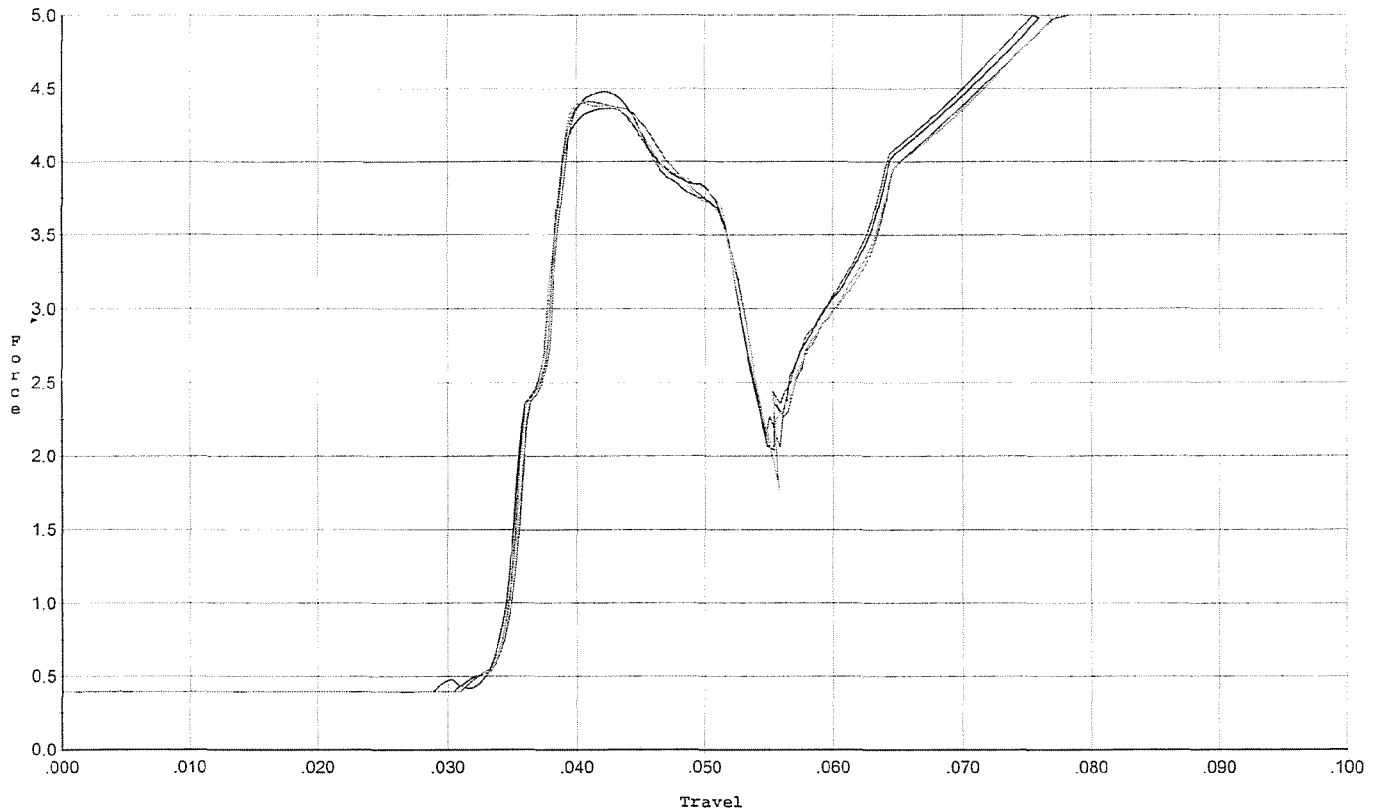
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.210	0.051	0.035	0.036	0.057		Set Trigger
2	3.149	0.050	0.035	0.036	0.055		Set Trigger
3	3.242	0.051	0.035	0.036	0.056		Set Trigger
4	3.237	0.051	0.035	0.036	0.056		Set Trigger
5	3.242	0.051	0.035	0.036	0.057		Set Trigger

A-3.21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



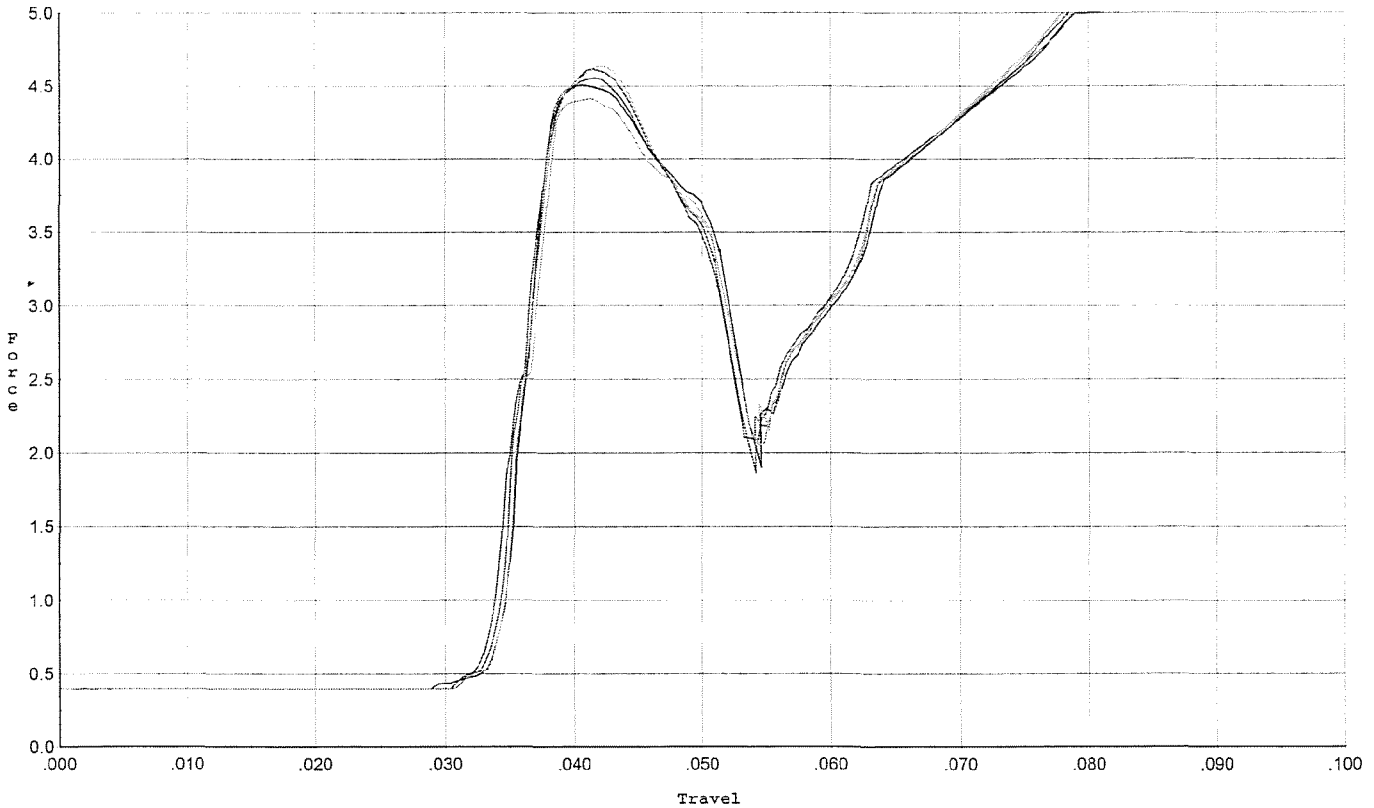
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.481	0.052	0.034	0.033	0.079		Set Trigger
2	4.366	0.052	0.034	0.033	0.080		Set Trigger
3	4.411	0.053	0.034	0.032	0.081		Set Trigger
4	4.415	0.052	0.034	0.033	0.079		Set Trigger
5	4.403	0.053	0.034	0.032	0.082		Set Trigger

A-4.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



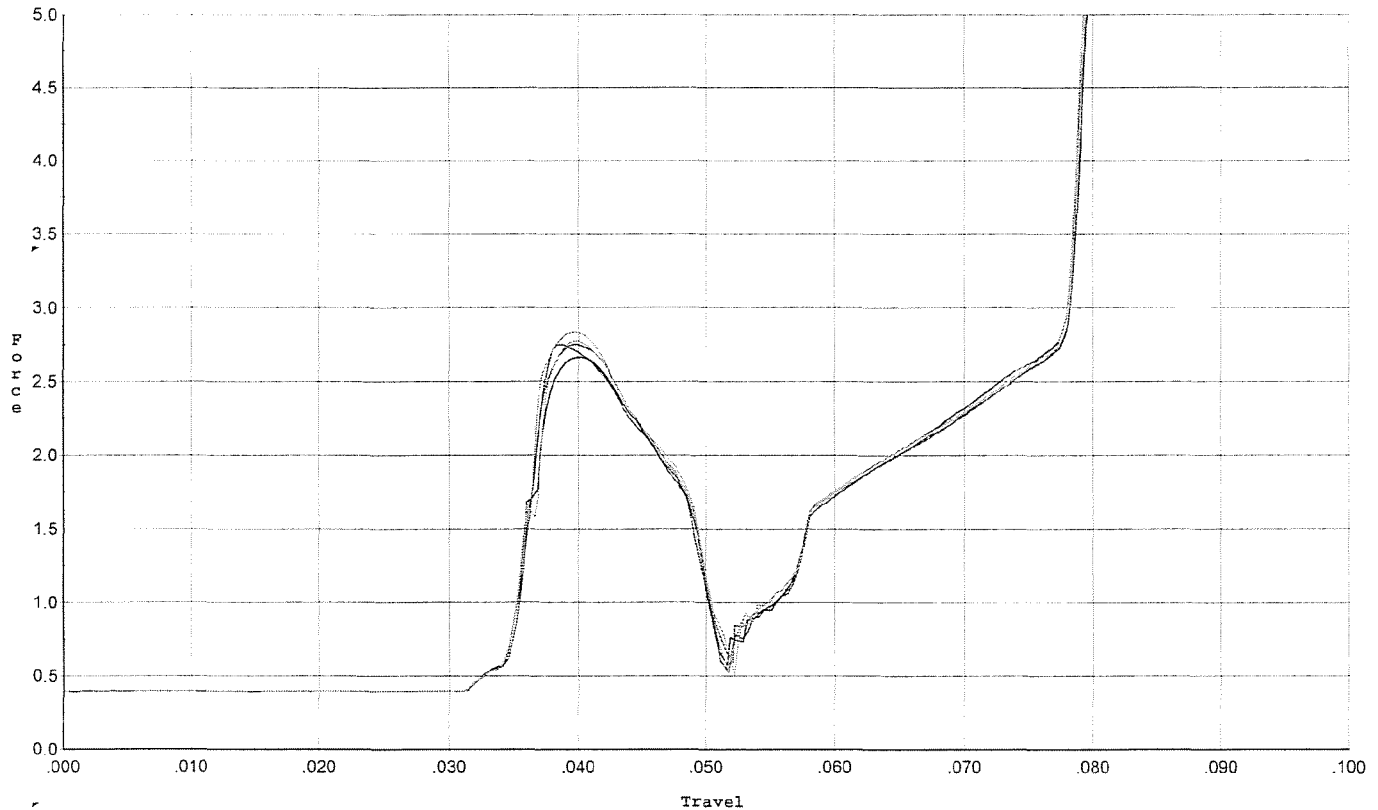
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.558	0.051	0.033	0.033	0.080		Set Trigger
2	4.508	0.051	0.034	0.033	0.080		Set Trigger
3	4.617	0.051	0.033	0.033	0.079		Set Trigger
4	4.638	0.052	0.034	0.033	0.081		Set Trigger
5	4.416	0.052	0.034	0.032	0.080		Set Trigger

A-4.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



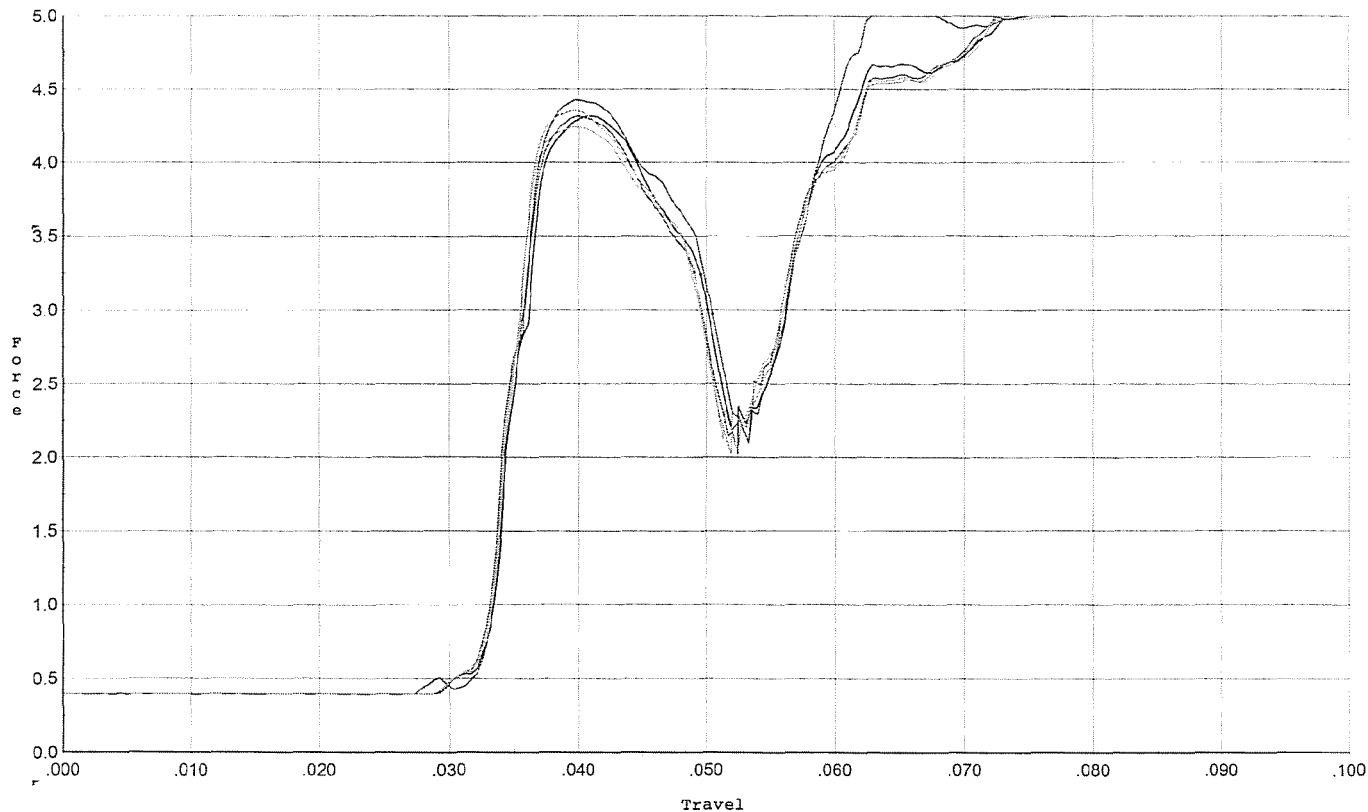
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.750	0.050	0.034	0.036	0.046		Set Trigger
2	2.664	0.049	0.034	0.036	0.045		Set Trigger
3	2.754	0.049	0.035	0.036	0.046		Set Trigger
4	2.775	0.049	0.034	0.036	0.046		Set Trigger
5	2.836	0.049	0.034	0.036	0.047		Set Trigger

A-2-75

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs ini +/- 1.0 for target&accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.428	0.050	0.033	0.033	0.078		Set Trigger
2	4.317	0.050	0.032	0.033	0.074		Set Trigger
3	4.316	0.049	0.032	0.033	0.073		Set Trigger
4	4.242	0.049	0.032	0.033	0.074		Set Trigger
5	4.353	0.049	0.032	0.033	0.074		Set Trigger

A. 4.33