

G6794585

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



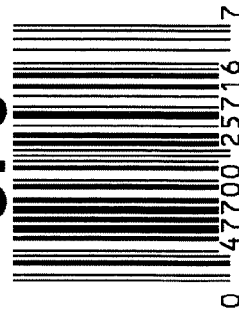
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794585

UPC



GUN SERIAL #

G 6794585

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		10-28-08	PSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/29/08	PS
490	MAGNAFLUX BOLT		10/29/08	PS
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC		10/29/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/3	
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		11-11-08	PSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

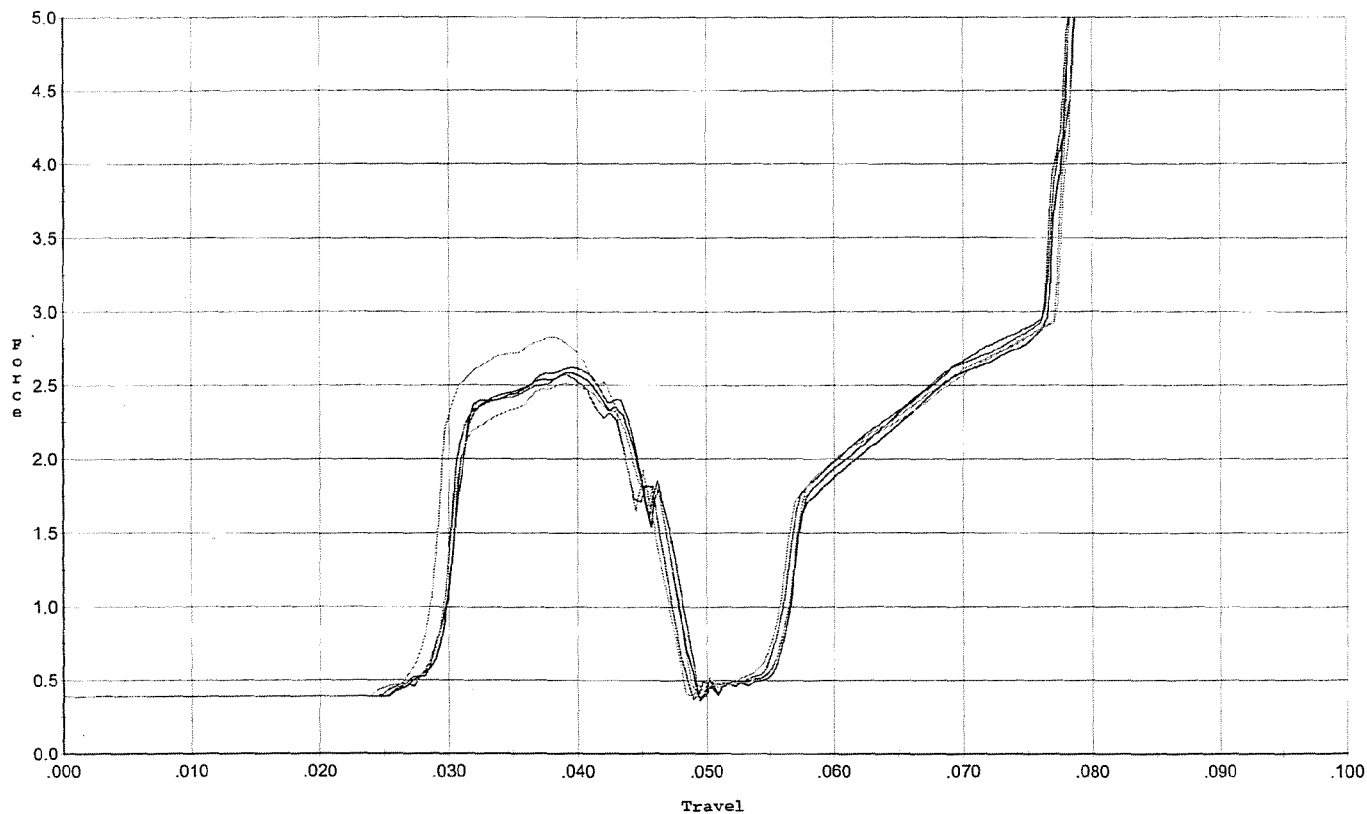
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-18-08	LA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-18-08	LA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-18-08	LA
	J) ASSEMBLE STOCK		11-11-08	RSW
	K) ASSEMBLE SWIVEL STUDS		11-18-08	LA
	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	11-12-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-12-08	LA
670	FINAL INSPECTION A) HEADSPACE		11-18-08	LA
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.59</u> <u>2.54</u> <u>2.59</u> <u>2.56</u>	11-14-08	TL
	C) FUNCTION		11-18-08	LA
690	PACK		12-1-08	TL

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



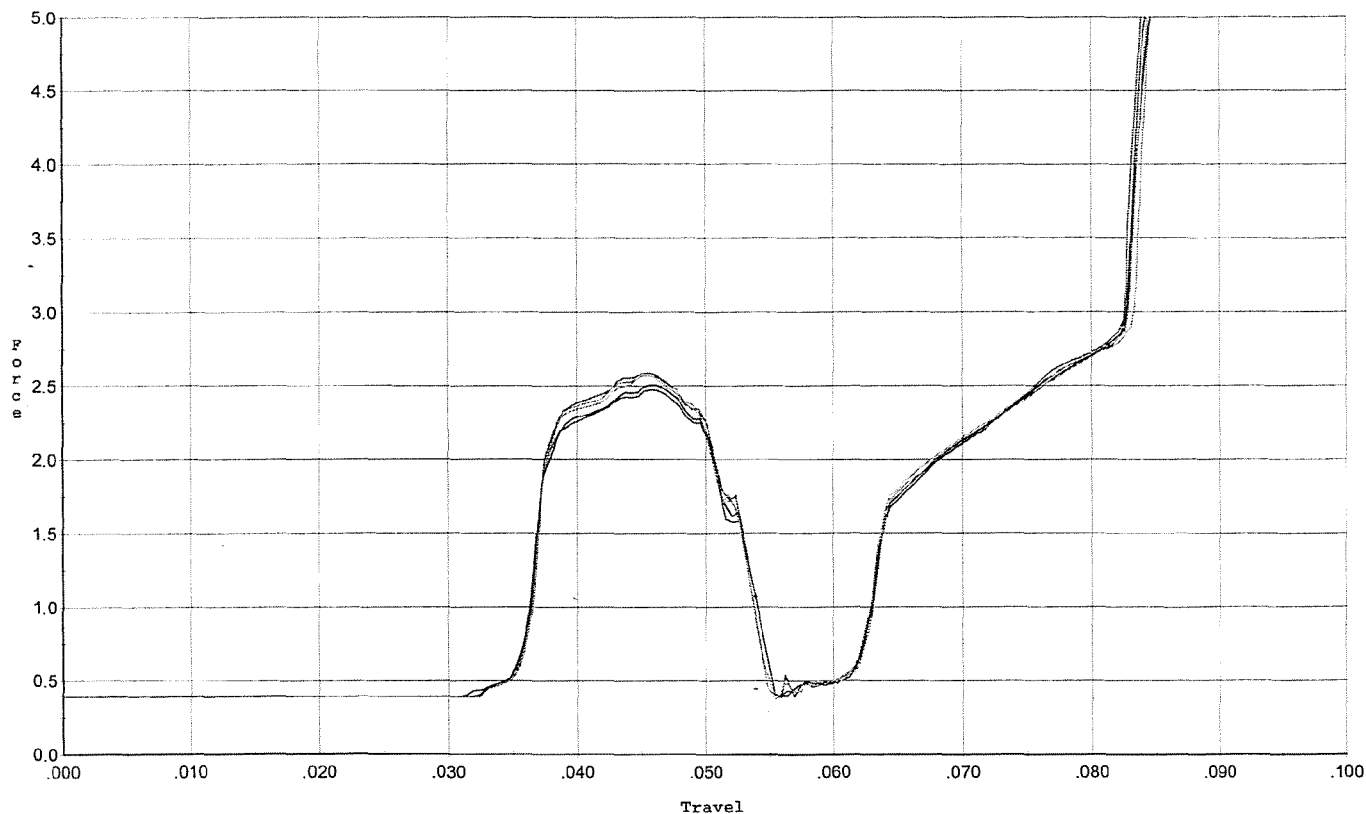
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.624	0.047	0.029	0.035	0.052		Set Trigger
2	2.586	0.046	0.029	0.035	0.050		Set Trigger
3	2.572	0.046	0.028	0.036	0.049		Set Trigger
4	2.516	0.046	0.028	0.036	0.049		Set Trigger
5	2.834	0.045	0.028	0.036	0.053		Set Trigger

A-2-62

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



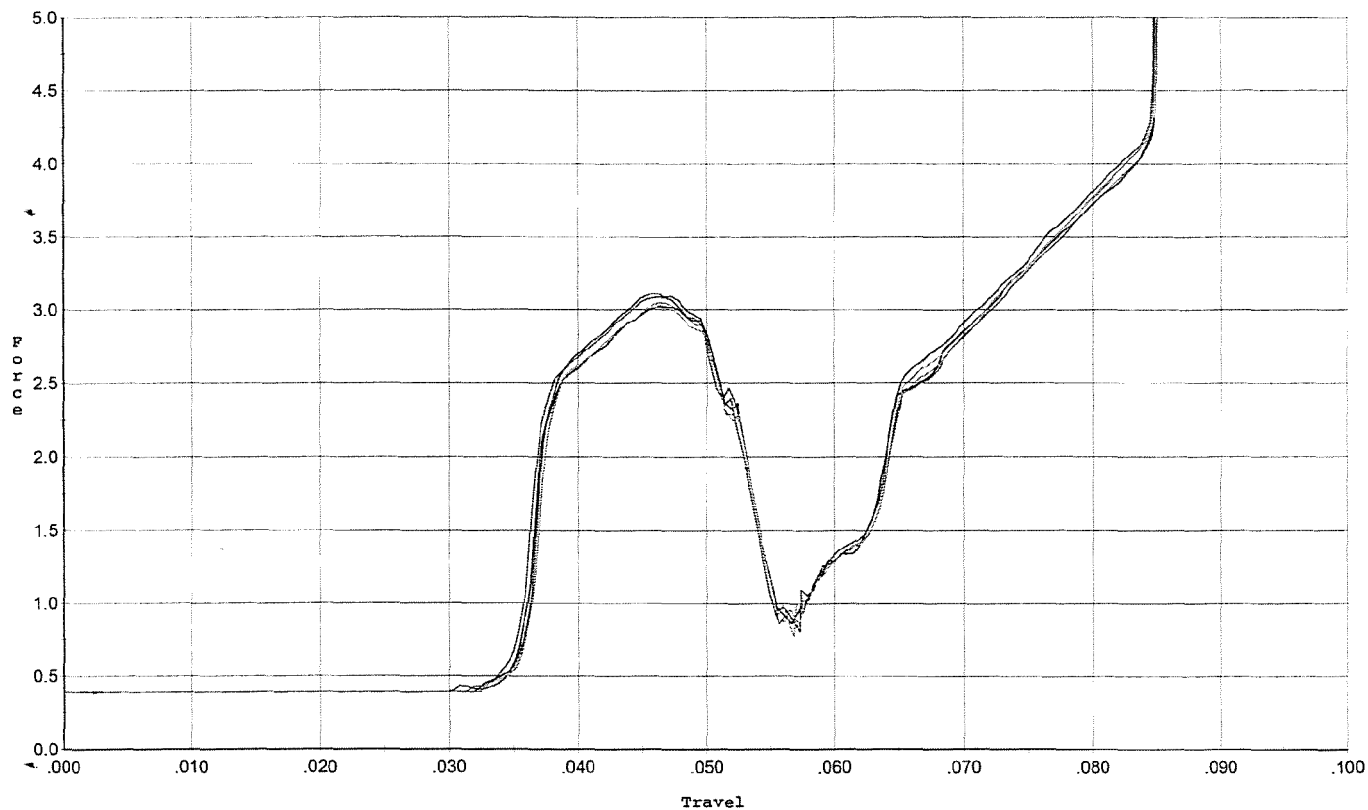
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.054	0.035	0.037	0.052		Set Trigger
2	2.507	0.054	0.035	0.037	0.052		Set Trigger
3	2.585	0.052	0.036	0.037	0.051		Set Trigger
4	2.569	0.052	0.036	0.037	0.051		Set Trigger
5	2.591	0.053	0.036	0.037	0.051		Set Trigger

A-2.54

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



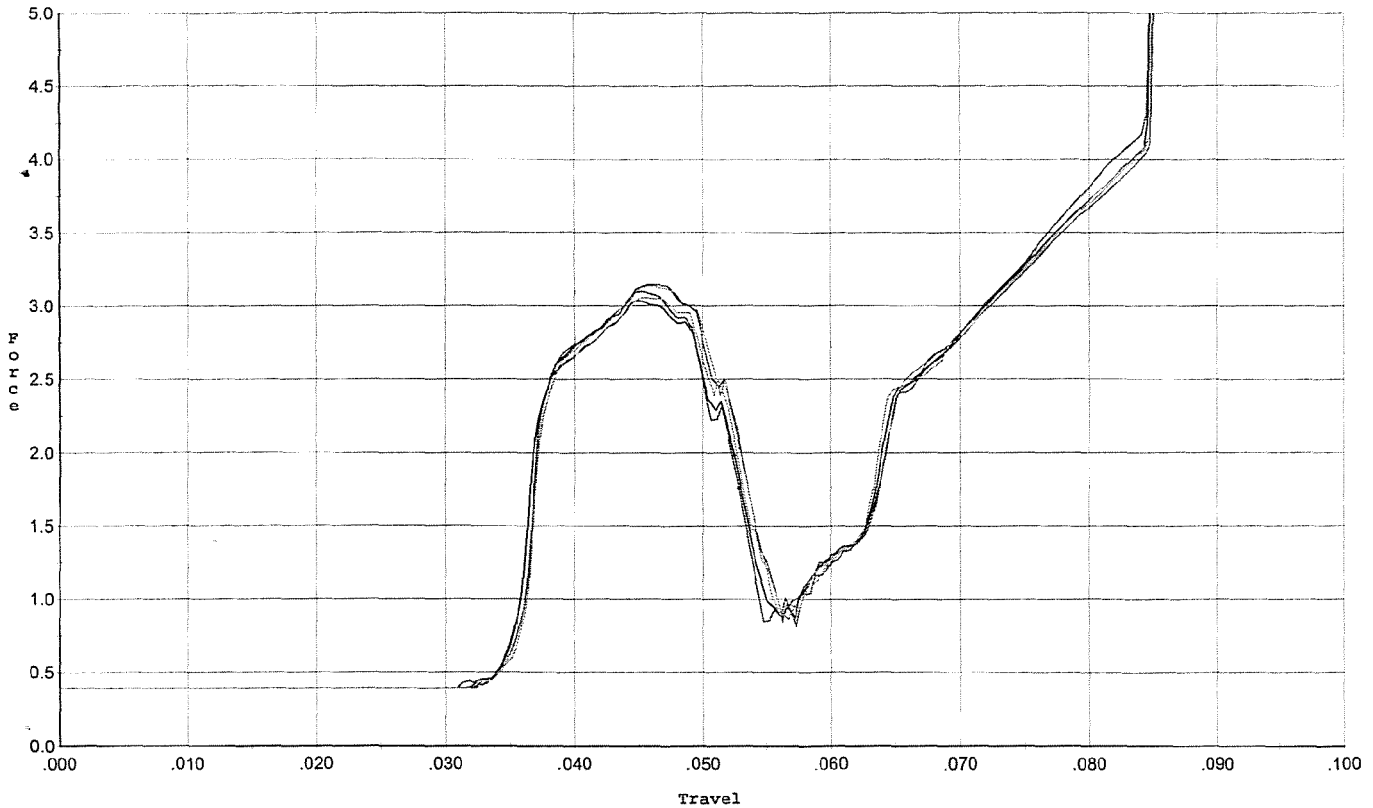
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.113	0.052	0.035	0.037	0.060		Set Trigger
2	3.026	0.052	0.035	0.036	0.059		Set Trigger
3	3.087	0.053	0.035	0.036	0.061		Set Trigger
4	3.051	0.053	0.036	0.037	0.058		Set Trigger
5	3.017	0.053	0.036	0.037	0.058		Set Trigger

A-3.05

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



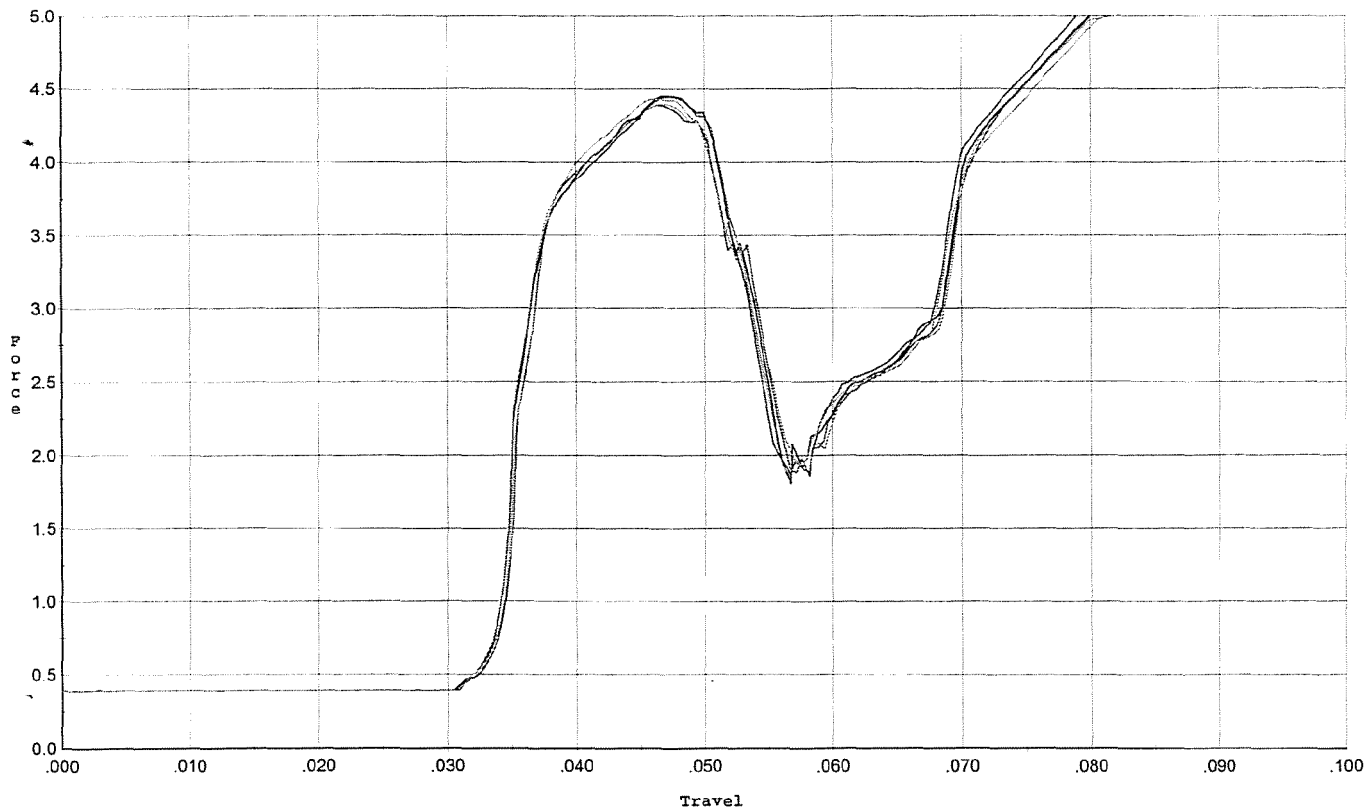
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.098	0.053	0.034	0.036	0.059		Set Trigger
2	3.036	0.052	0.035	0.036	0.059		Set Trigger
3	3.146	0.053	0.035	0.037	0.061		Set Trigger
4	3.055	0.052	0.035	0.037	0.058		Set Trigger
5	3.138	0.053	0.035	0.037	0.060		Set Trigger

A-3.09

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



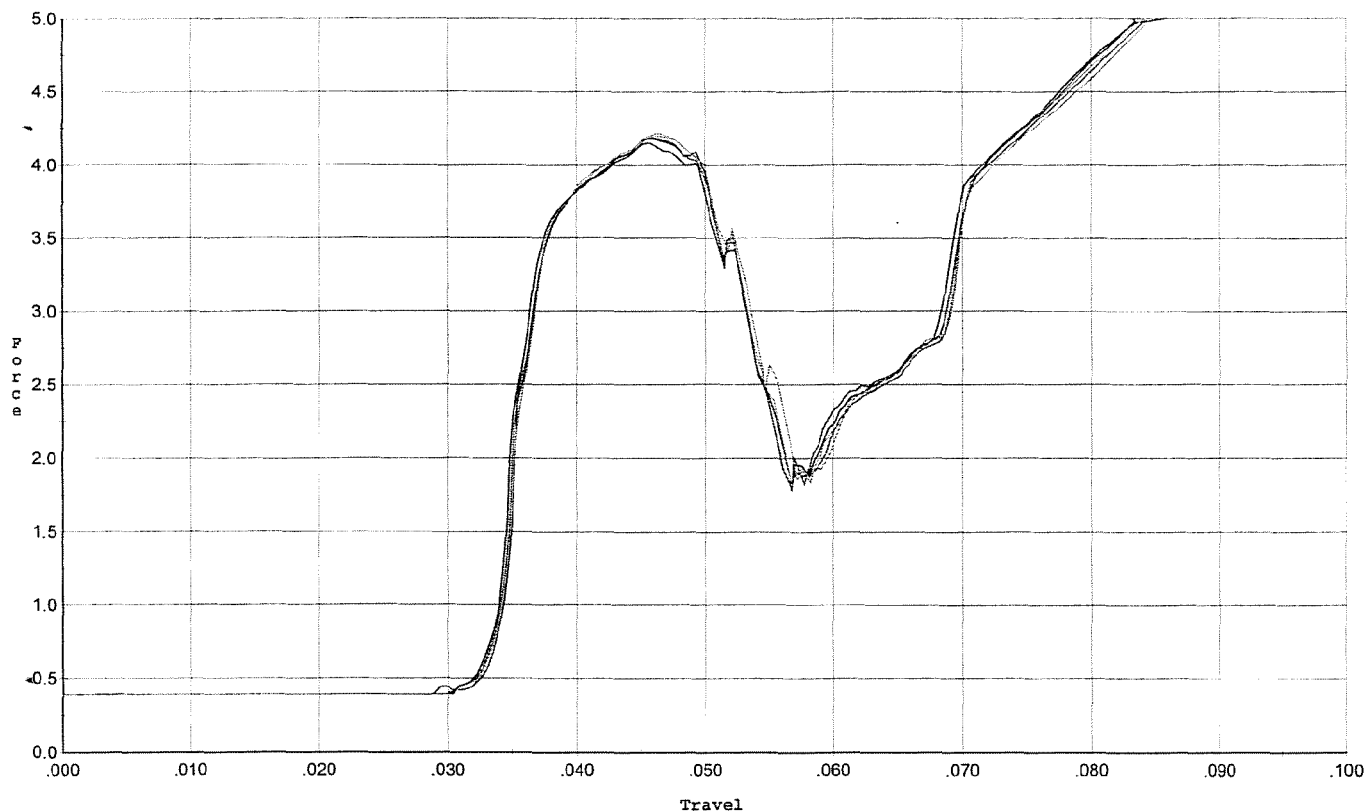
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.393	0.053	0.033	0.034	0.086		Set Trigger
2	4.449	0.054	0.033	0.034	0.089		Set Trigger
3	4.444	0.053	0.033	0.034	0.087		Set Trigger
4	4.396	0.053	0.033	0.034	0.086		Set Trigger
5	4.429	0.053	0.033	0.035	0.086		Set Trigger

A. 4.42

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



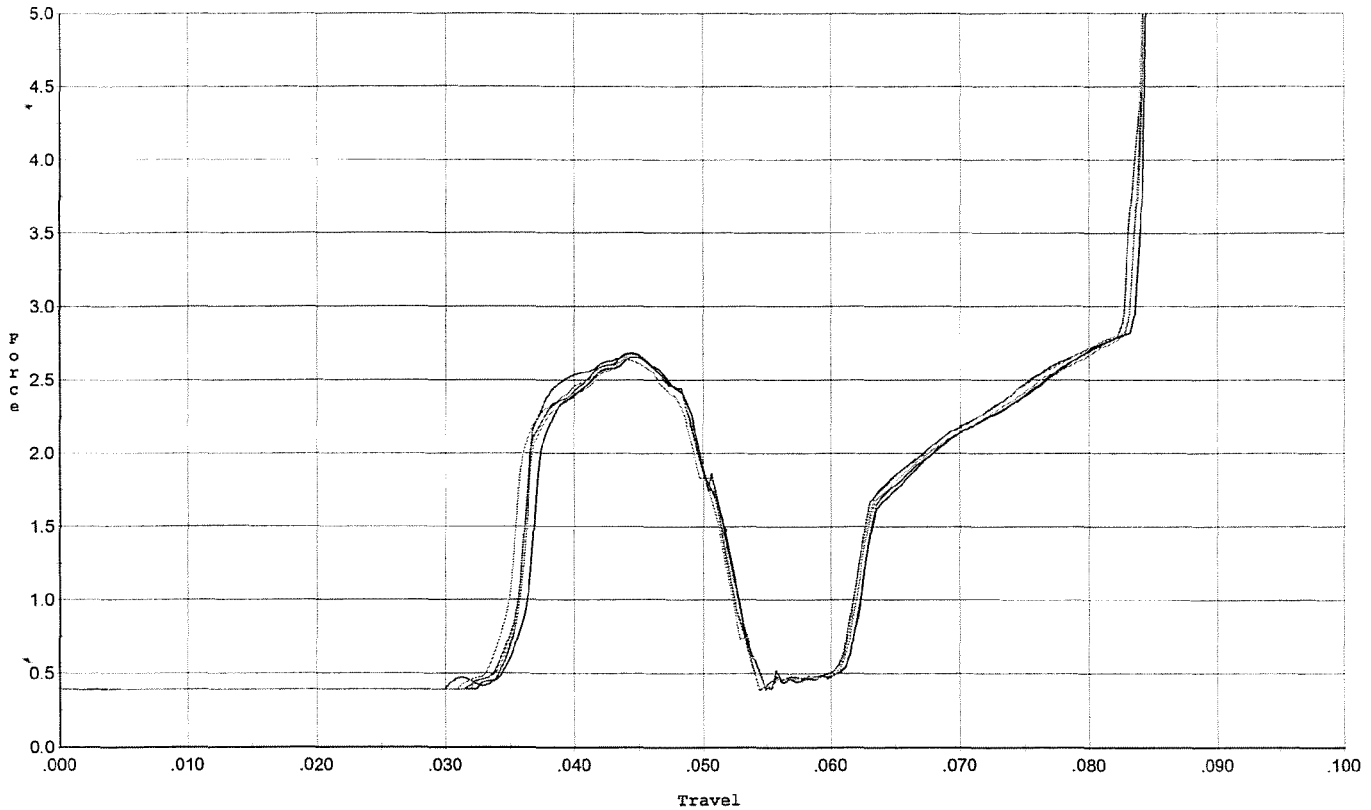
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.150	0.052	0.033	0.035	0.081		Set Trigger
2	4.182	0.052	0.033	0.034	0.082		Set Trigger
3	4.185	0.052	0.033	0.035	0.082		Set Trigger
4	4.197	0.052	0.033	0.035	0.082		Set Trigger
5	4.211	0.053	0.033	0.035	0.084		Set Trigger

A- 4.18

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



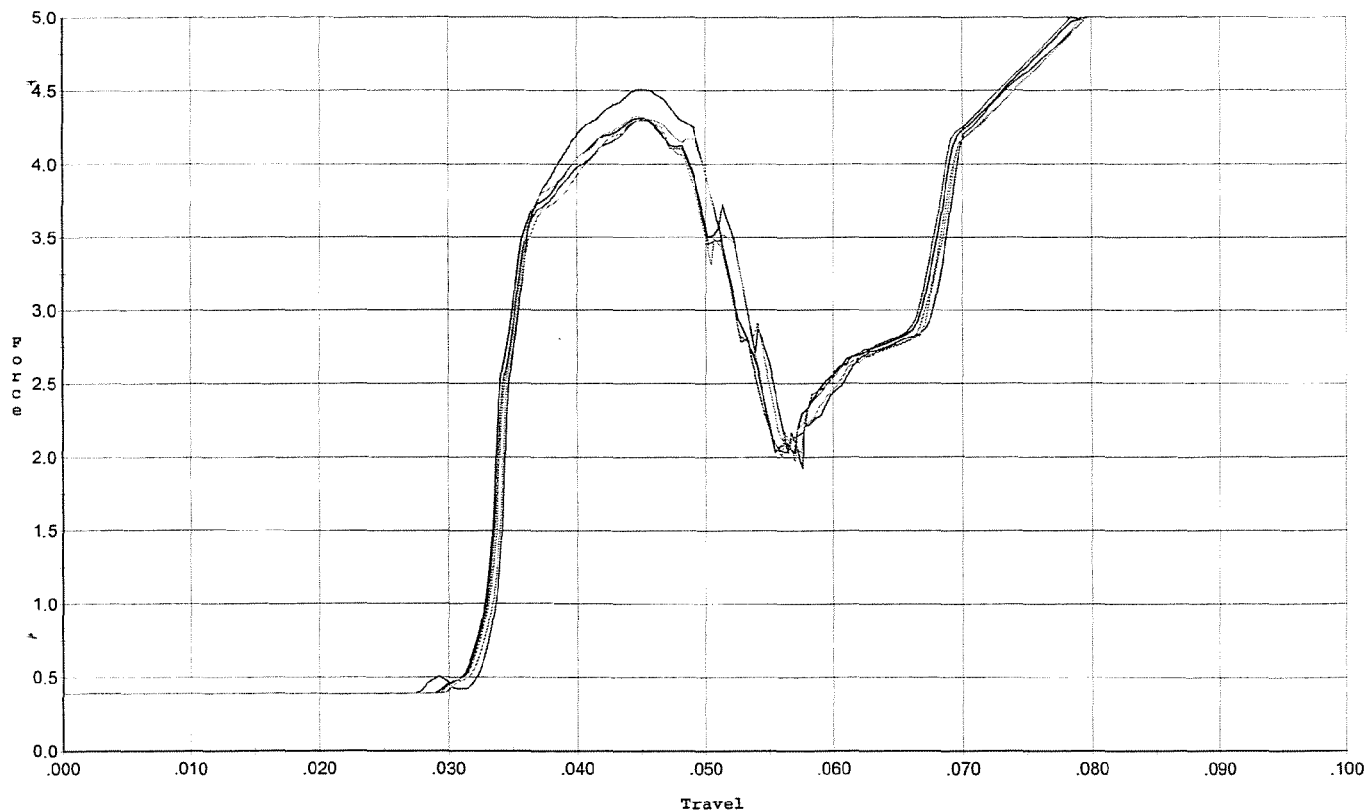
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.685	0.052	0.034	0.037	0.052		Set Trigger
2	2.655	0.052	0.035	0.037	0.050		Set Trigger
3	2.678	0.051	0.034	0.037	0.051		Set Trigger
4	2.660	0.051	0.035	0.037	0.050		Set Trigger
5	2.639	0.051	0.034	0.037	0.052		Set Trigger

A-2.66

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 & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.507	0.052	0.033	0.034	0.088		Set Trigger
2	4.313	0.051	0.032	0.033	0.084		Set Trigger
3	4.299	0.051	0.032	0.034	0.083		Set Trigger
4	4.307	0.054	0.032	0.033	0.090		Set Trigger
5	4.326	0.051	0.032	0.034	0.083		Set Trigger

A 4.35