

G6794651

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

- INSTUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



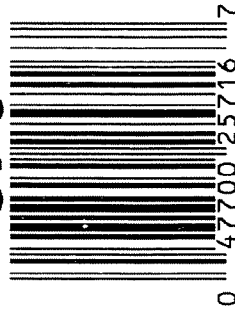
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794651

UPC



GUN SERIAL #

G 6794651

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	RBR
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/29/08	RT
490	MAGNAFLUX BOLT		10-27-08	RT
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		11-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-5-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-7-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

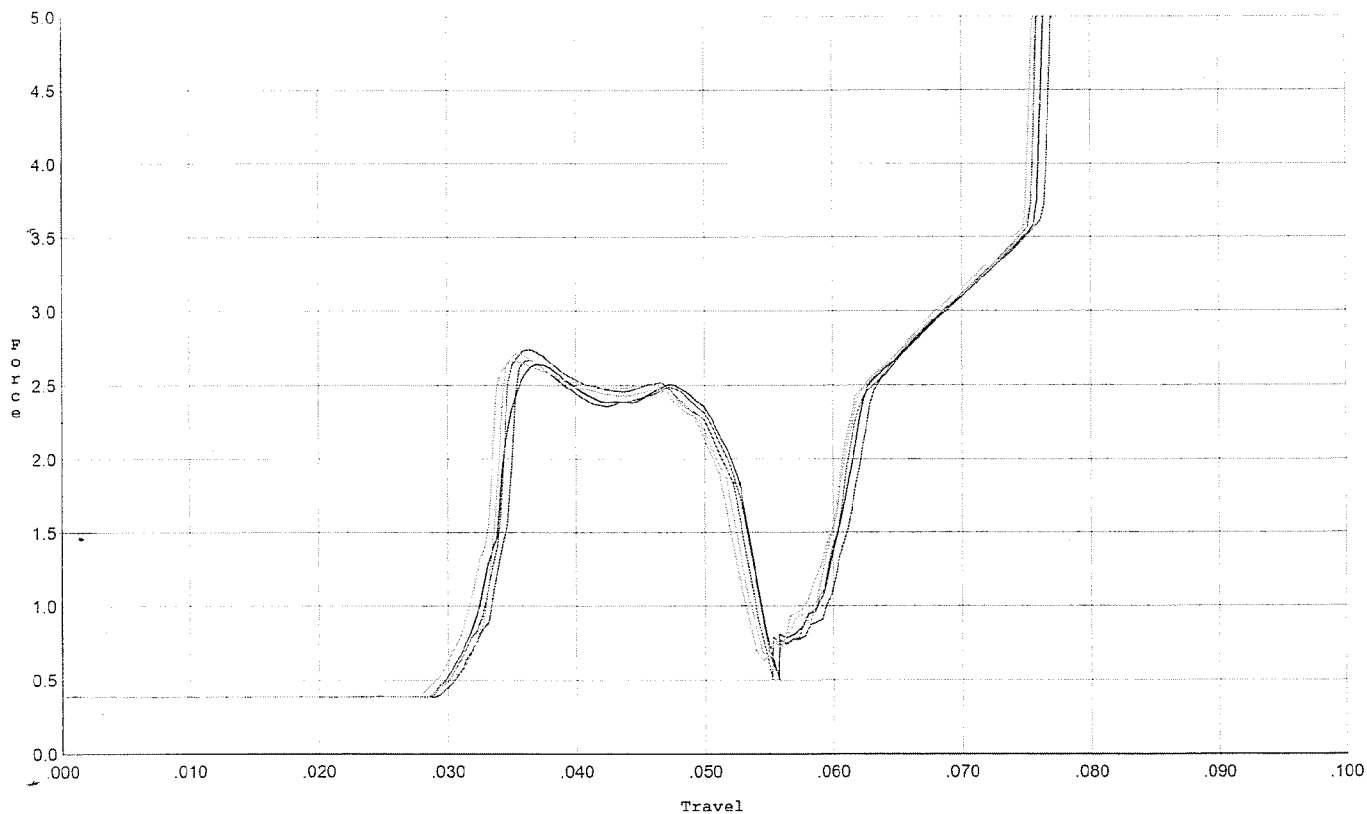
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>5.5</u>	11-17-08	TC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	11-17-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.025</u>	11-17-08	TC
	J) ASSEMBLE STOCK		11-7-08	SPD
	K) ASSEMBLE SWIVEL STUDS		11-17-08	TC
	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	11-11-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-11-08	8
670	FINAL INSPECTION A) HEADSPACE		11-17-08	TC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.81</u> <u>2.74</u> <u>2.78</u> <u>2.78</u> <u>2.78</u>	11-12-08	TC
	C) FUNCTION		11-17-08	TC
690	PACK		12-1-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



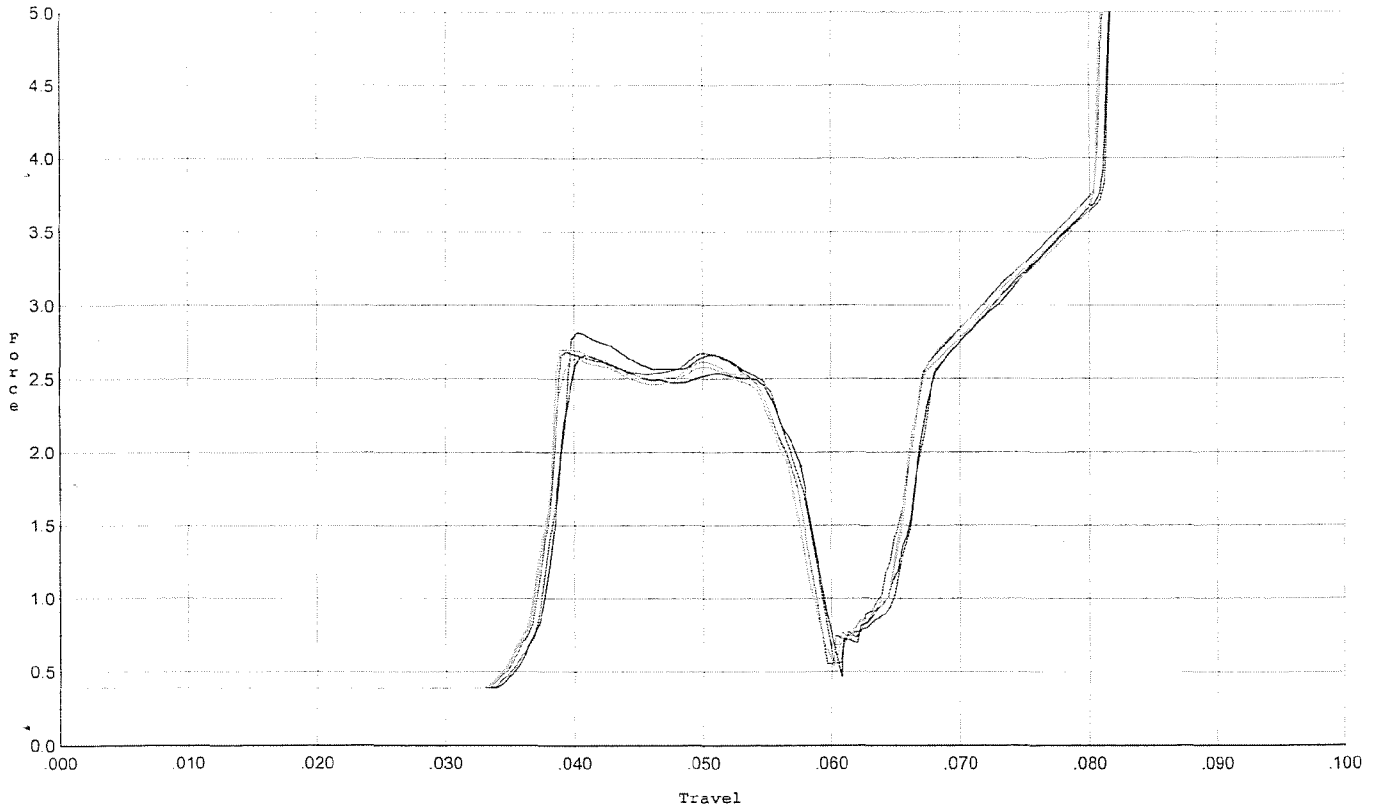
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.053	0.031	0.030	0.059		Set Trigger
2	2.639	0.053	0.031	0.030	0.060		Set Trigger
3	2.739	0.052	0.031	0.030	0.060		Set Trigger
4	2.712	0.052	0.032	0.030	0.058		Set Trigger
5	2.658	0.051	0.030	0.030	0.059		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



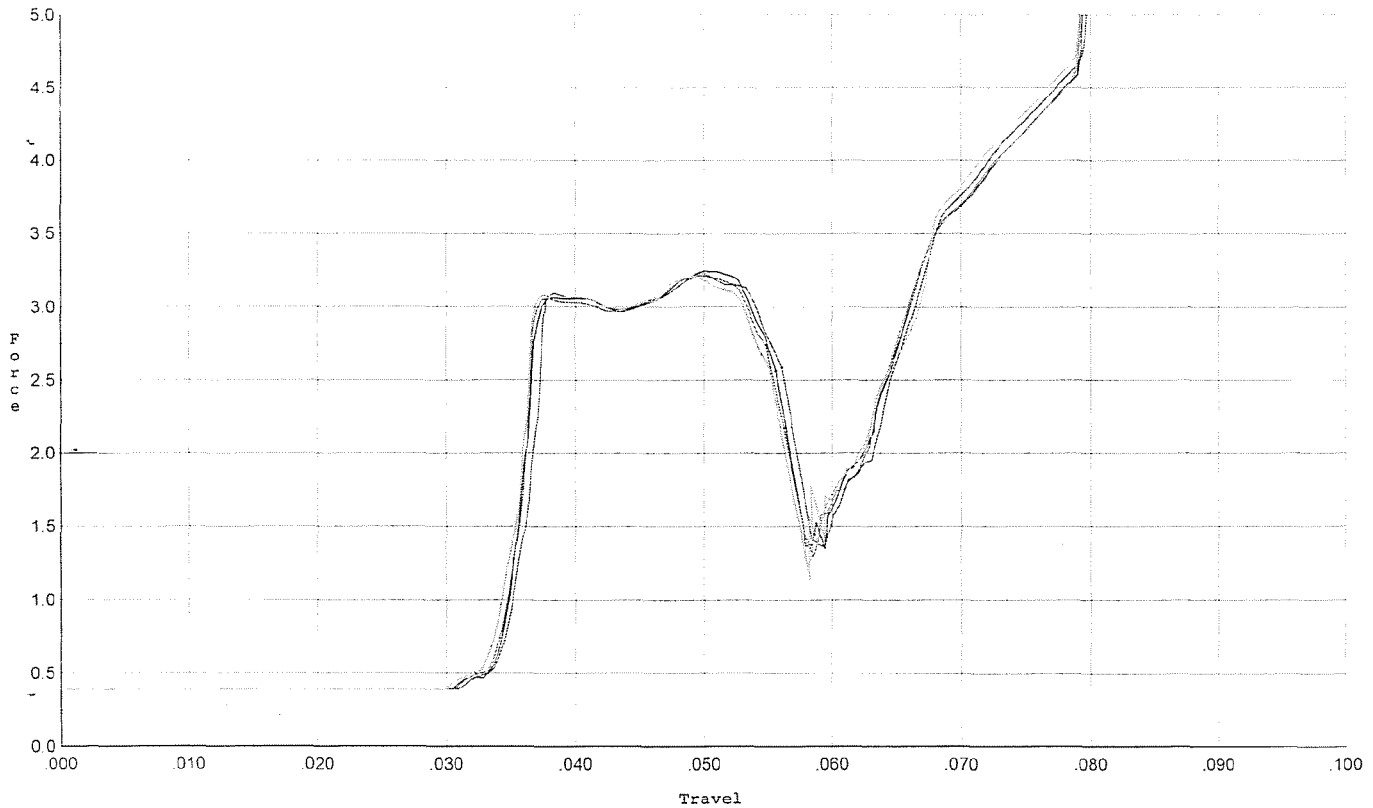
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.818	0.058	0.036	0.030	0.065		Set Trigger
2	2.662	0.058	0.036	0.030	0.063		Set Trigger
3	2.683	0.057	0.035	0.030	0.064		Set Trigger
4	2.639	0.057	0.035	0.030	0.064		Set Trigger
5	2.698	0.057	0.035	0.030	0.063		Set Trigger

A2-70

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



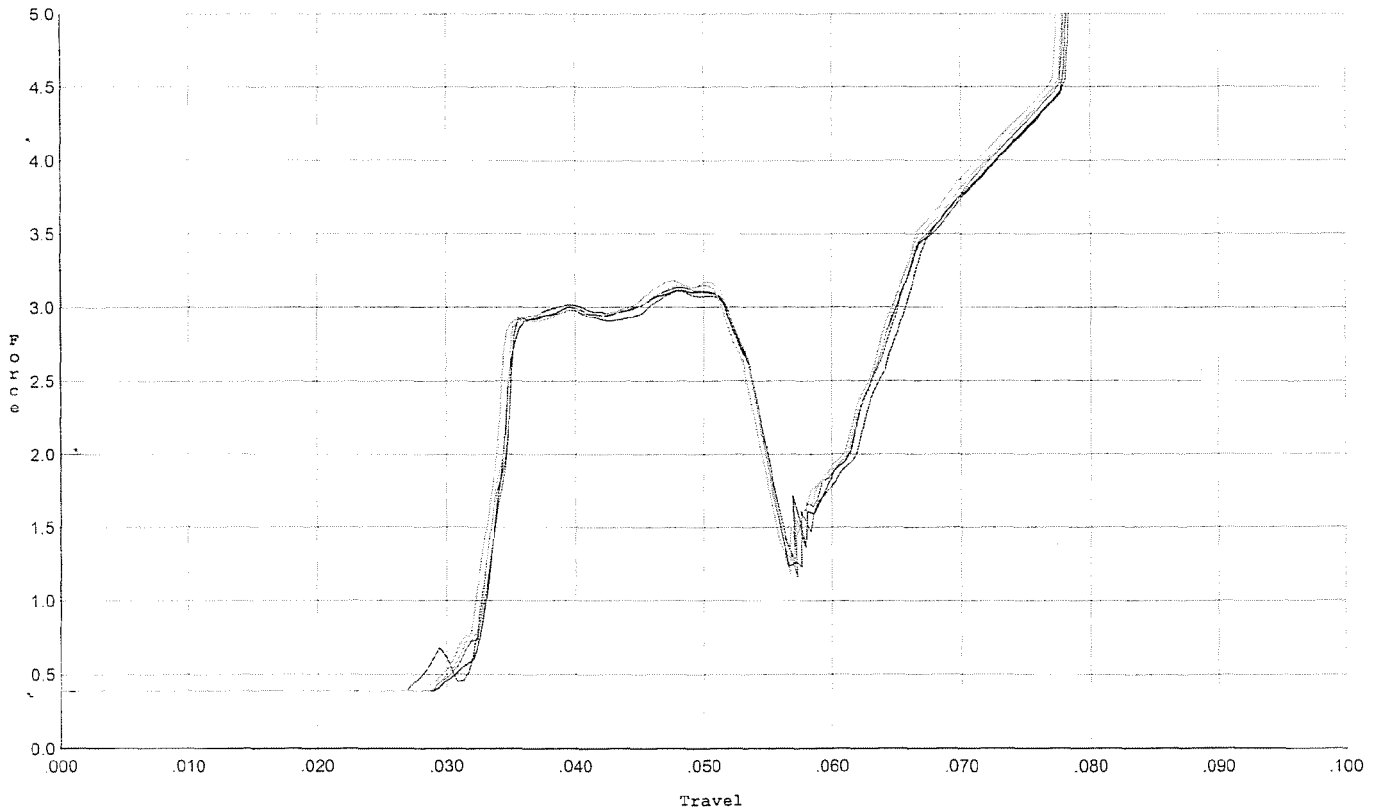
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.212	0.056	0.034	0.029	0.076		Set Trigger
2	3.244	0.056	0.034	0.029	0.076		Set Trigger
3	3.224	0.056	0.034	0.029	0.076		Set Trigger
4	3.210	0.055	0.033	0.029	0.075		Set Trigger
5	3.205	0.055	0.033	0.029	0.075		Set Trigger

A-321

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



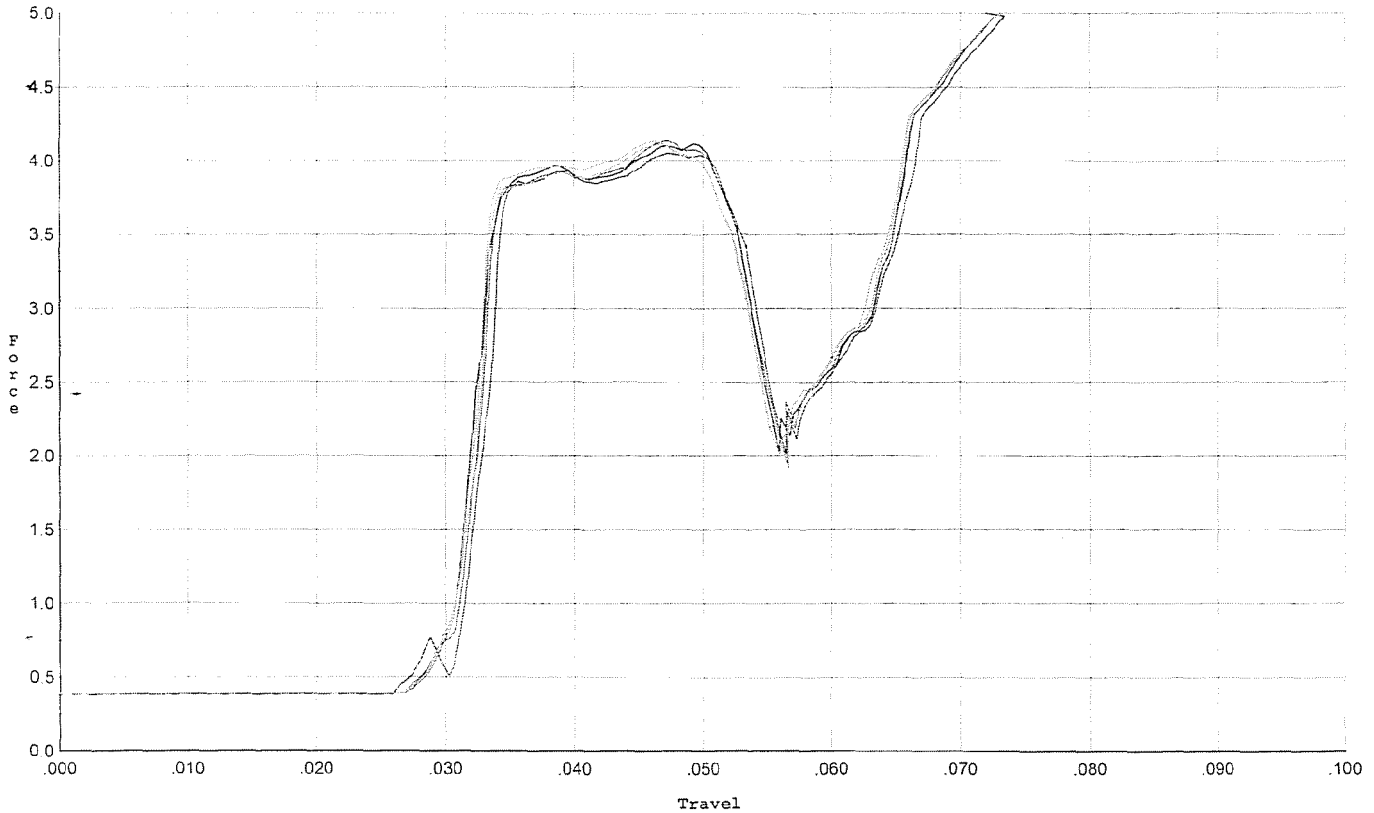
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.138	0.055	0.029	0.029	0.076		Set Trigger
2	3.112	0.054	0.032	0.030	0.073		Set Trigger
3	3.109	0.054	0.031	0.029	0.072		Set Trigger
4	3.172	0.053	0.031	0.029	0.074		Set Trigger
5	3.180	0.053	0.031	0.029	0.073		Set Trigger

A-3.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs ini +/- .75 lbs



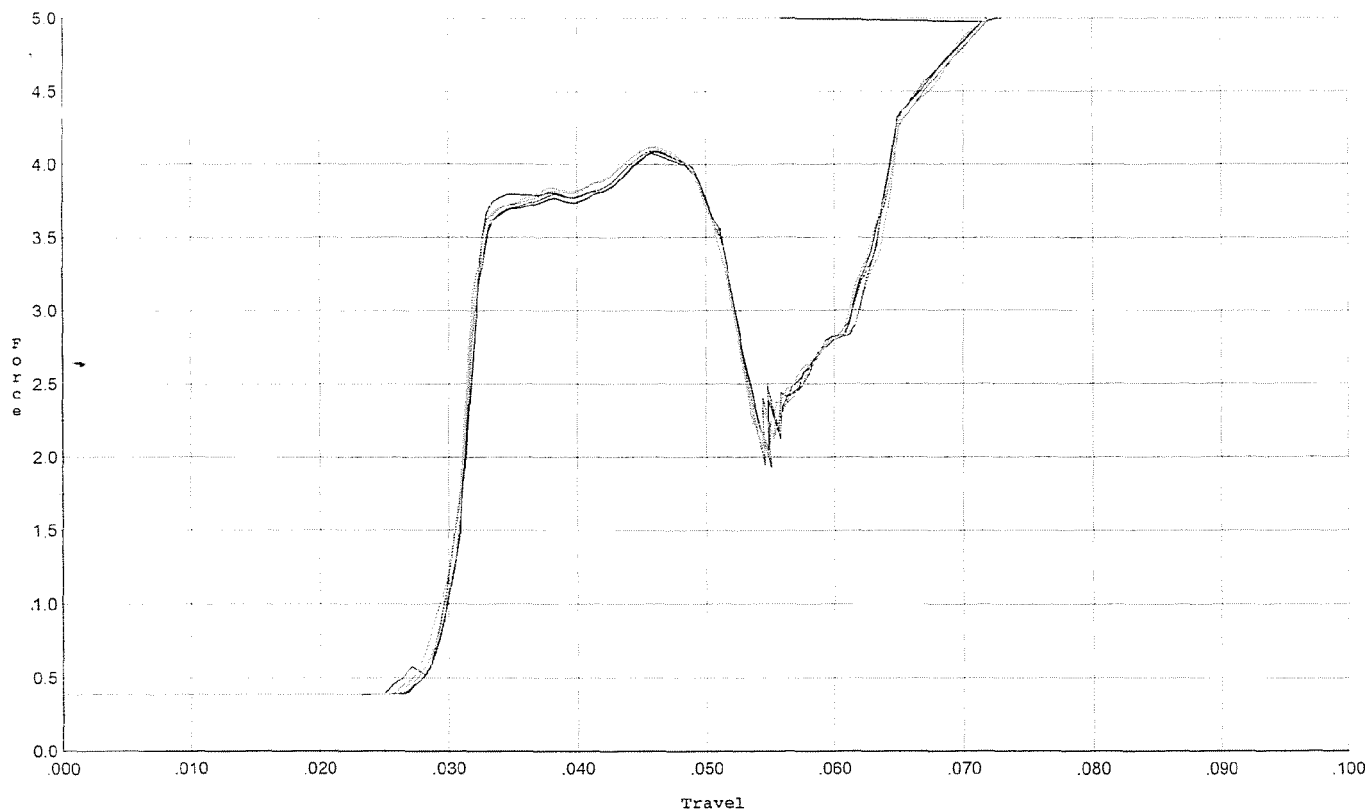
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.054	0.053	0.028	0.028	0.094		Set Trigger
2	4.116	0.053	0.029	0.028	0.095		Set Trigger
3	4.142	0.053	0.029	0.028	0.094		Set Trigger
4	4.137	0.053	0.029	0.028	0.096		Set Trigger
5	4.116	0.053	0.029	0.028	0.095		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs after 20 cycles+/- .75 lbs



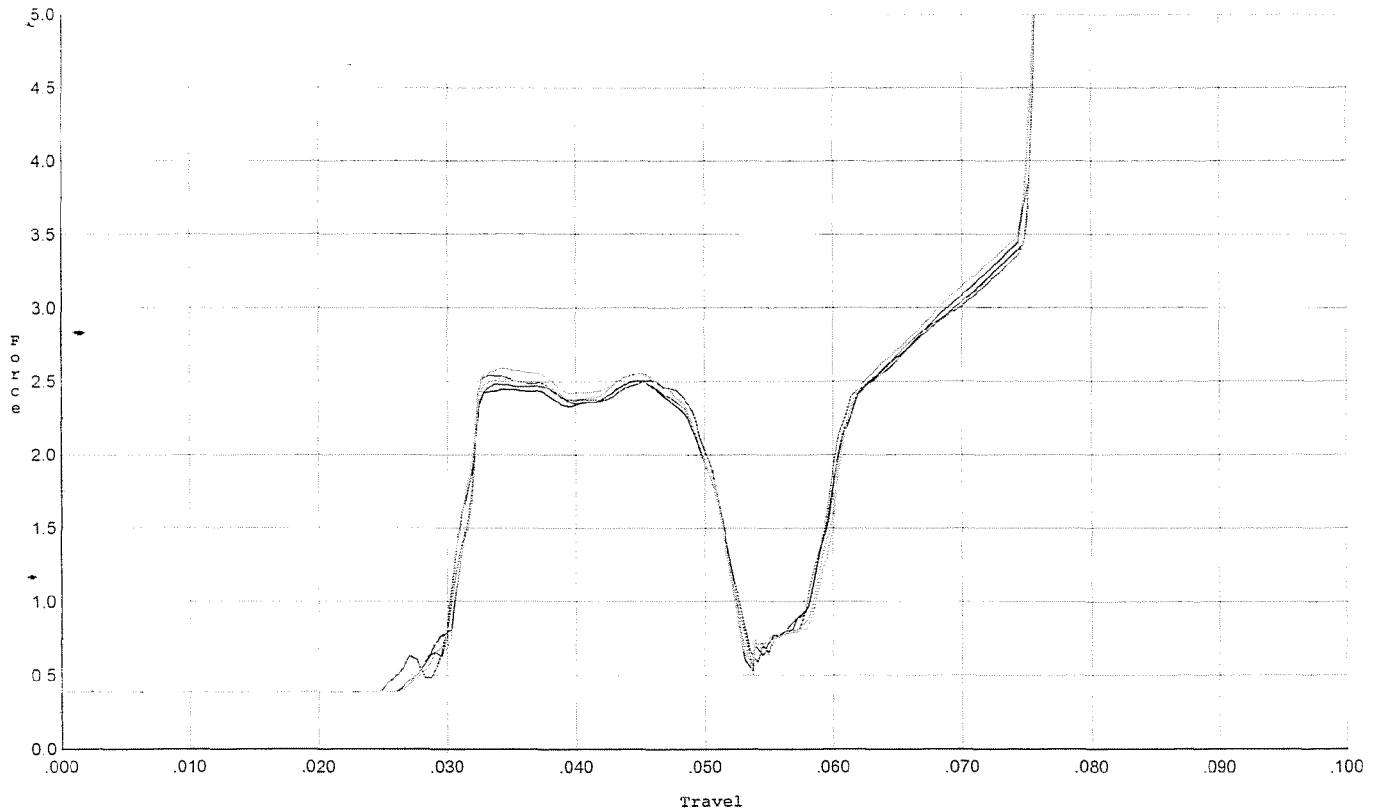
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.070	0.051	0.029	0.028	0.091		Set Trigger
2	4.080	0.051	0.029	0.028	0.090		Set Trigger
3	4.091	0.051	0.029	0.028	0.090		Set Trigger
4	4.120	0.051	0.028	0.028	0.091		Set Trigger
5	4.115	0.052	0.028	0.028	0.092		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



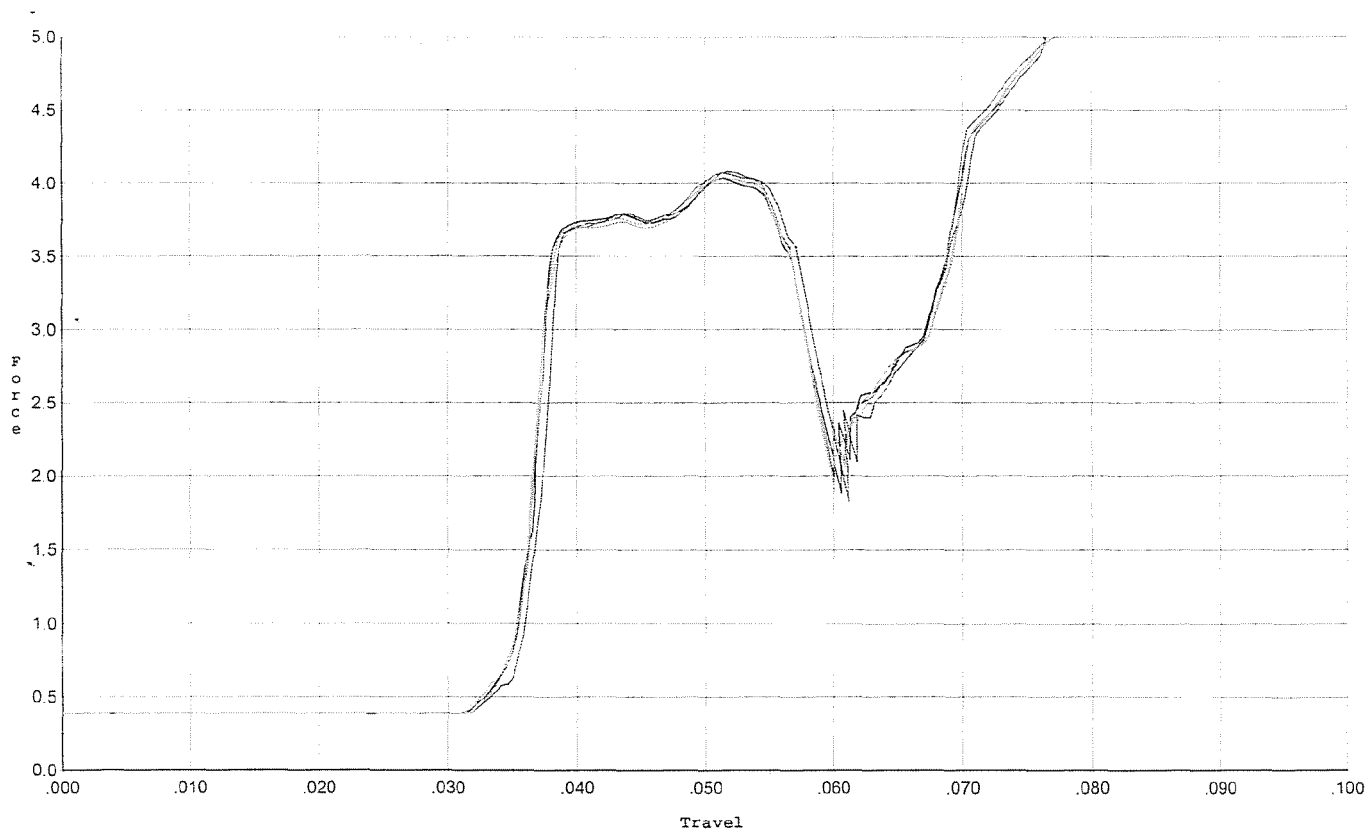
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.509	0.051	0.027	0.030	0.060		Set Trigger
2	2.504	0.051	0.029	0.030	0.059		Set Trigger
3	2.539	0.051	0.028	0.030	0.060		Set Trigger
4	2.588	0.051	0.028	0.030	0.061		Set Trigger
5	2.555	0.051	0.029	0.030	0.059		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.083	0.057	0.035	0.028	0.093		Set Trigger
2	4.034	0.057	0.035	0.028	0.093		Set Trigger
3	4.072	0.057	0.034	0.028	0.093		Set Trigger
4	4.040	0.057	0.035	0.028	0.092		Set Trigger
5	4.042	0.057	0.034	0.028	0.093		Set Trigger

A-4.05