

G6794776

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



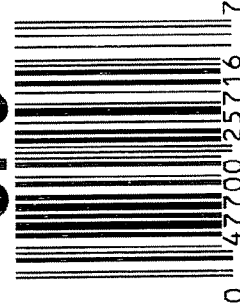
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794776

UPC



GUN SERIAL #

G 6794776

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA FLUX	10-8-08	KS
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (R)	10/11/08	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21-08	SP
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-28-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

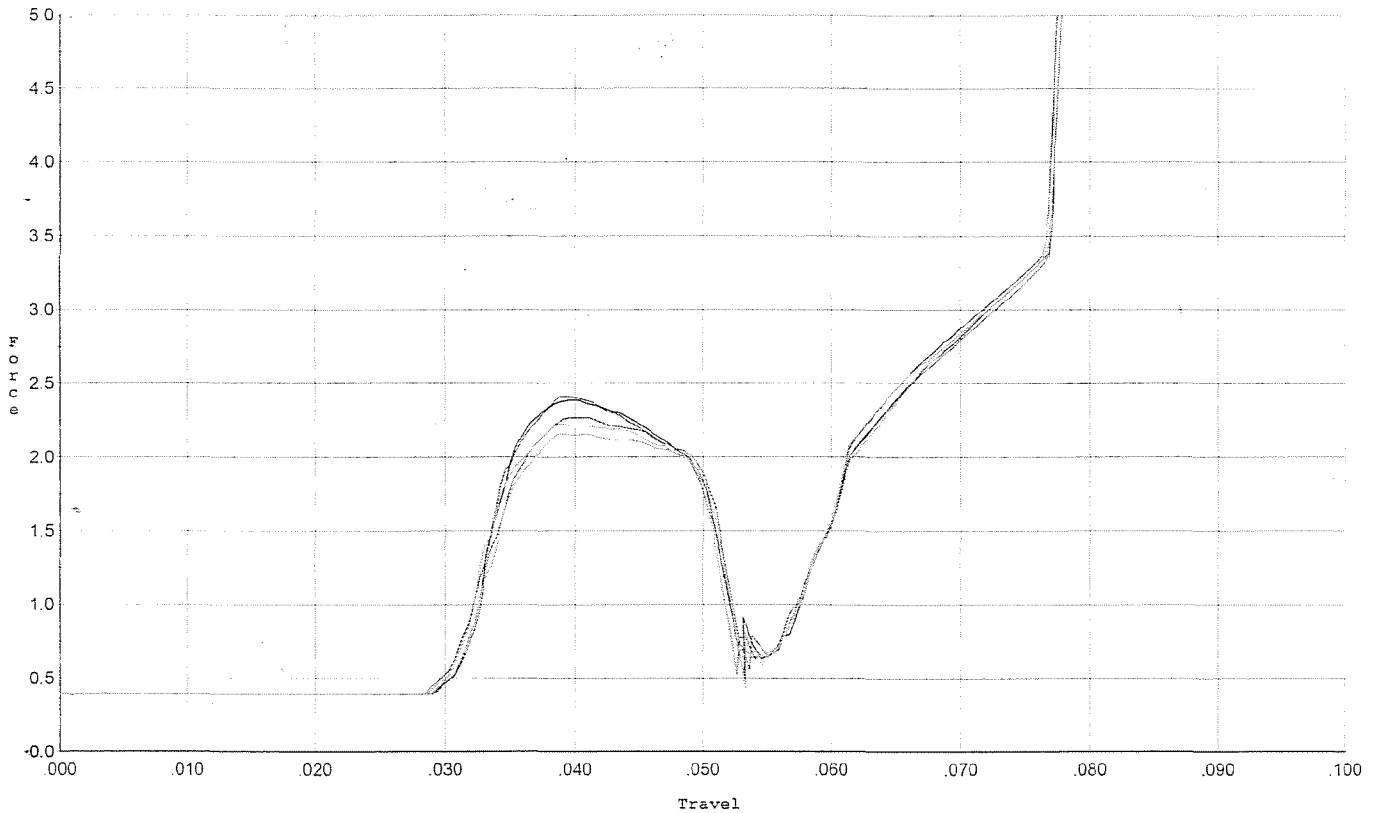
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>5.0</u>	10-30-08	L. D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.0</u>	10-30-08	L. D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-30-08	L. D.
	J) ASSEMBLE STOCK		10-28-08	RT
	K) ASSEMBLE SWIVEL STUDS		10-30-08	L. D.
	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	10-29-08	L. D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-29-08	TL
670	FINAL INSPECTION A) HEADSPACE		10-30-08	L. D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.53</u> <u>2.50</u> <u>2.54</u> <u>2.55</u>	10-29-08	TL
	C) FUNCTION		10-30-08	L. D.
690	PACK		10/31/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs ~~after 50 cycles +/- .50 lbs~~
iw1



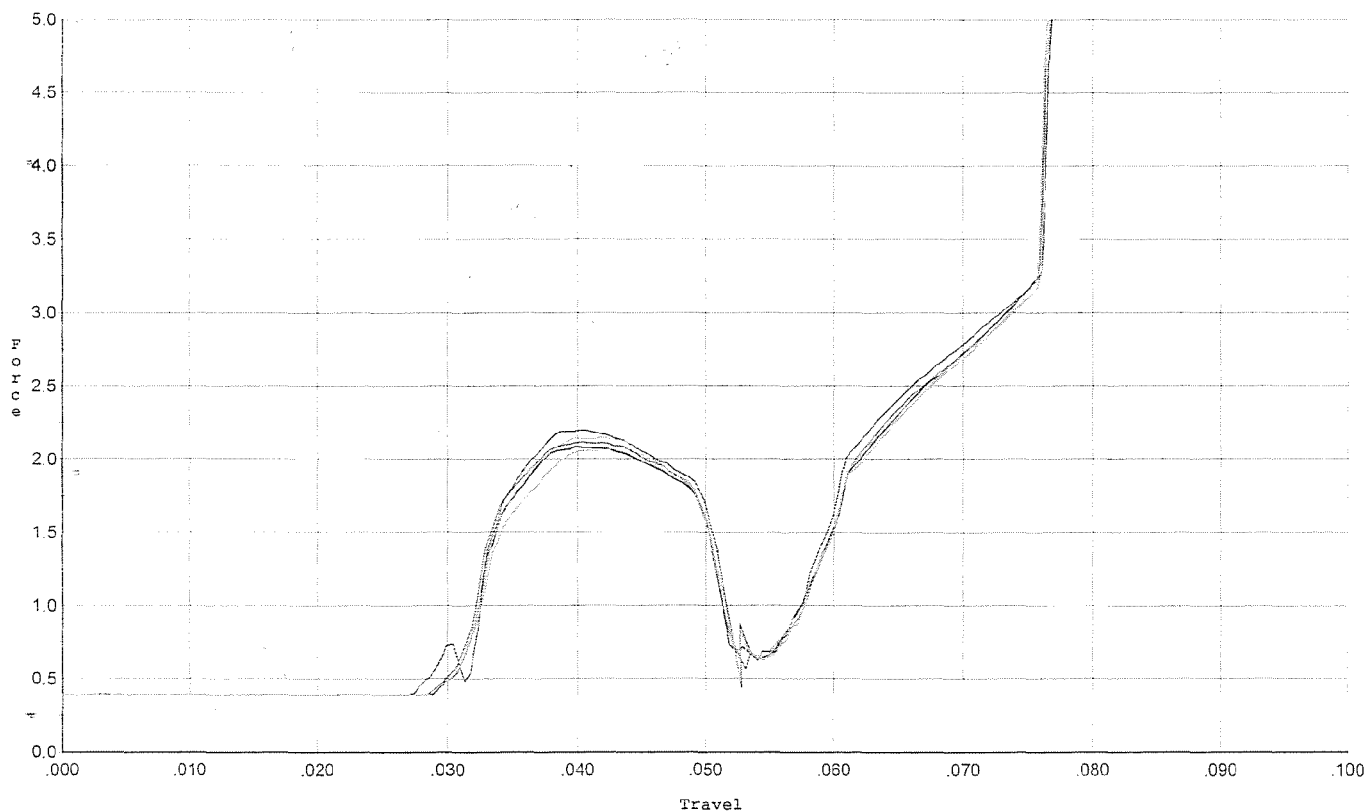
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.410	0.051	0.031	0.033	0.052		Set Trigger
2	2.387	0.052	0.031	0.033	0.053		Set Trigger
3	2.267	0.051	0.031	0.033	0.051		Set Trigger
4	2.222	0.051	0.031	0.033	0.050		Set Trigger
5	2.157	0.051	0.031	0.033	0.050		Set Trigger

A 2.28

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



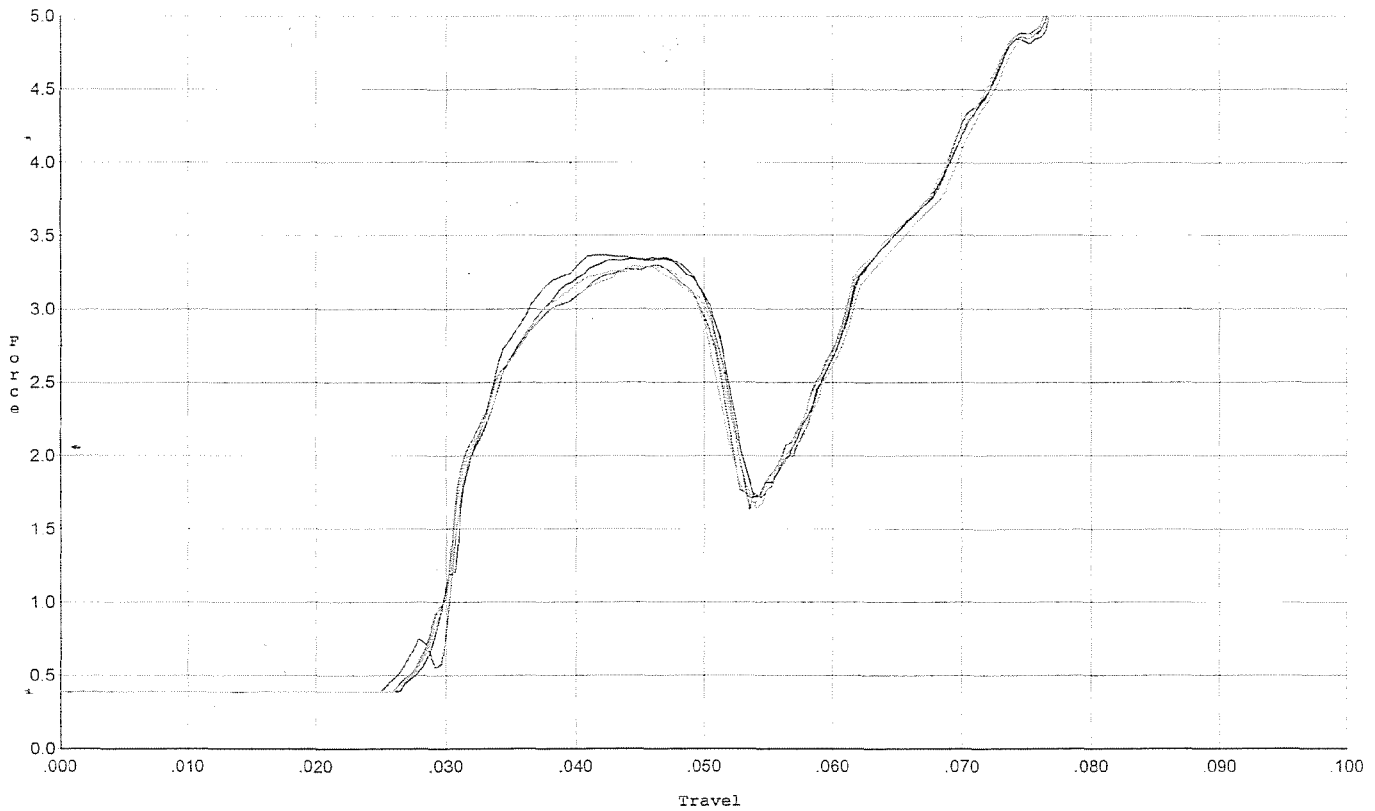
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.196	0.051	0.029	0.032	0.049		Set Trigger
2	2.084	0.050	0.031	0.033	0.047		Set Trigger
3	2.115	0.050	0.031	0.032	0.048		Set Trigger
4	2.067	0.051	0.031	0.032	0.047		Set Trigger
5	2.145	0.050	0.031	0.032	0.047		Set Trigger

A 2.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



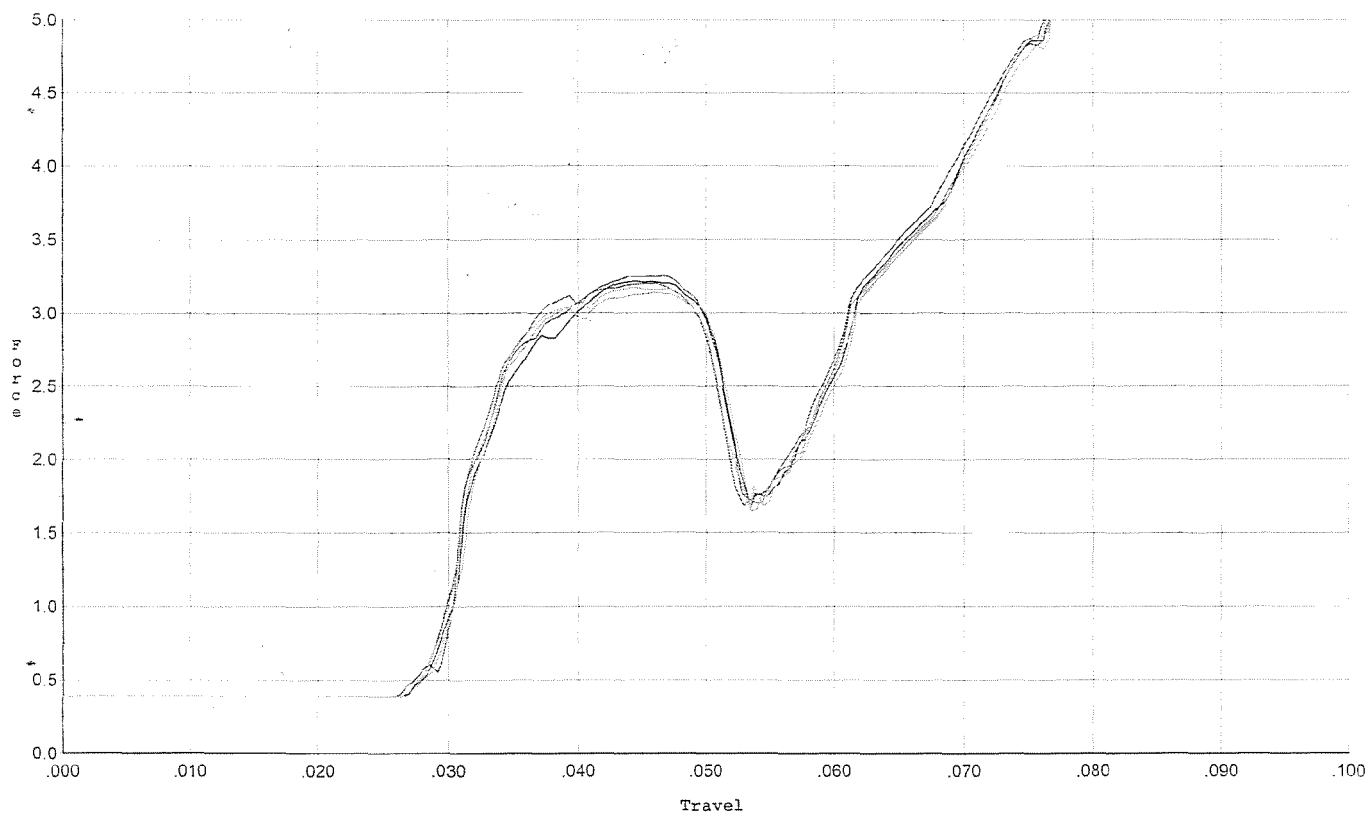
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.366	0.052	0.027	0.030	0.076		Set Trigger
2	3.350	0.051	0.029	0.030	0.075		Set Trigger
3	3.297	0.051	0.028	0.030	0.073		Set Trigger
4	3.289	0.050	0.028	0.030	0.071		Set Trigger
5	3.289	0.051	0.028	0.030	0.073		Set Trigger

A-321

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



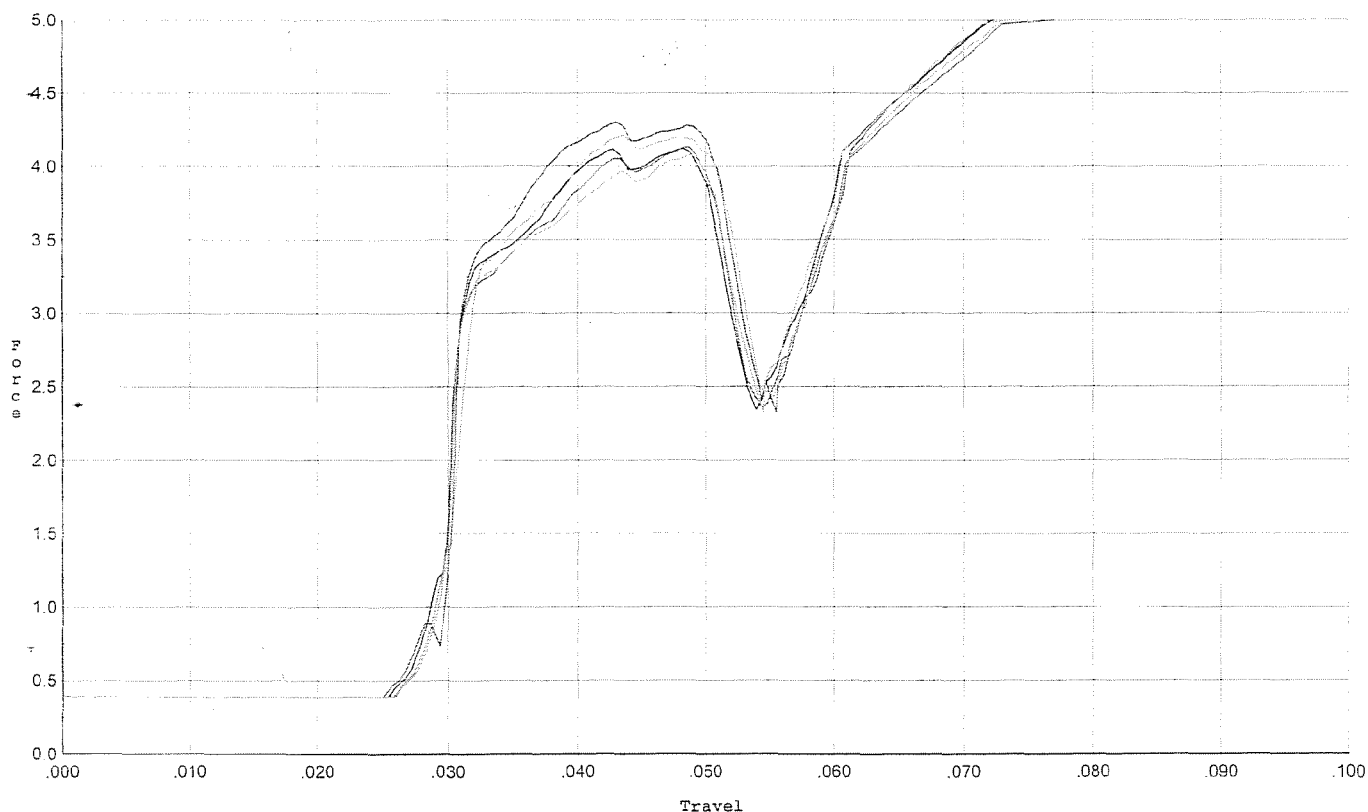
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.257	0.051	0.028	0.030	0.072		Set Trigger
2	3.215	0.051	0.029	0.030	0.070		Set Trigger
3	3.203	0.050	0.029	0.030	0.071		Set Trigger
4	3.173	0.052	0.029	0.030	0.073		Set Trigger
5	3.142	0.050	0.029	0.030	0.069		Set Trigger

A 3.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



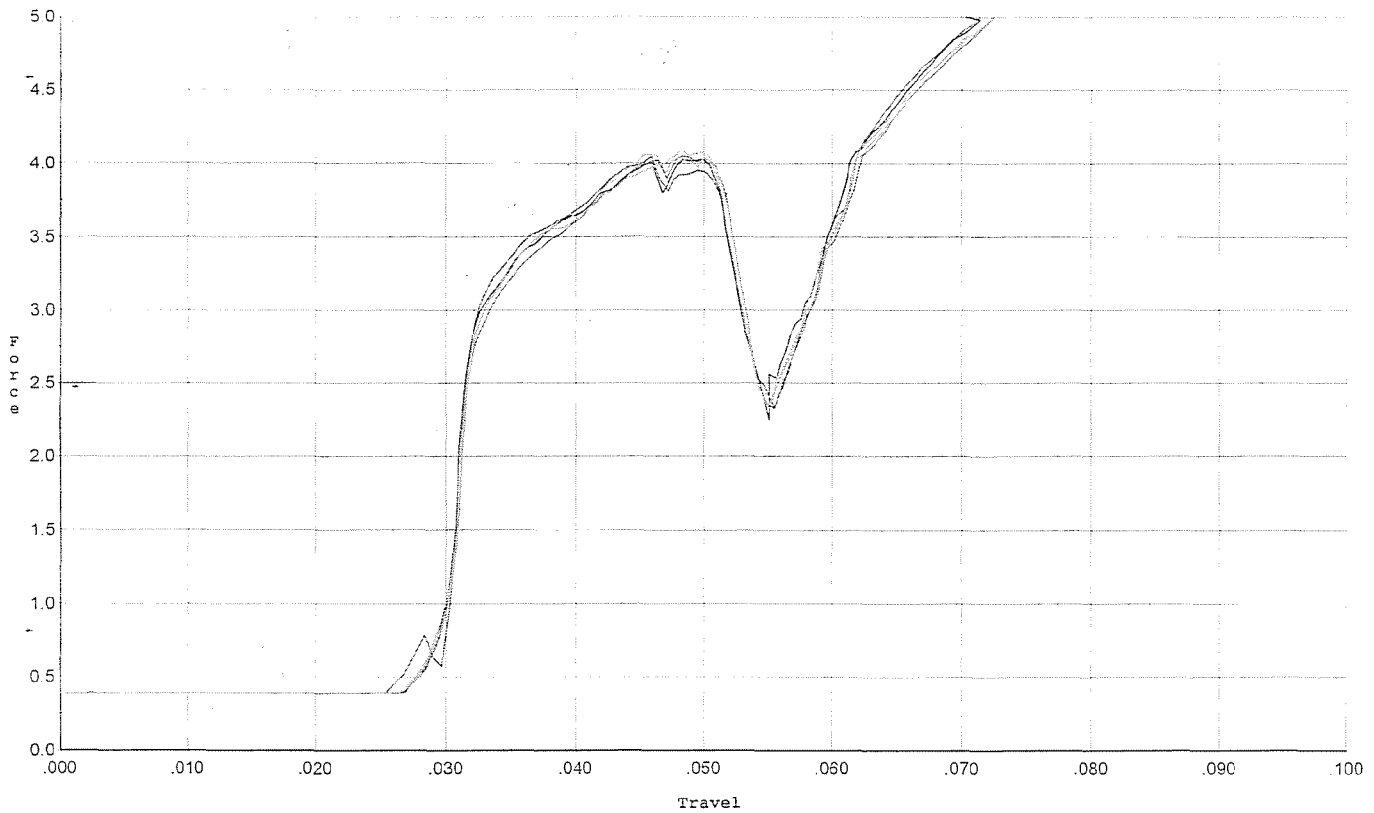
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.297	0.051	0.027	0.027	0.097		Set Trigger
2	4.118	0.050	0.027	0.028	0.091		Set Trigger
3	4.126	0.051	0.028	0.028	0.091		Set Trigger
4	4.078	0.051	0.028	0.028	0.090		Set Trigger
5	4.212	0.052	0.028	0.027	0.096		Set Trigger

A-4-16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



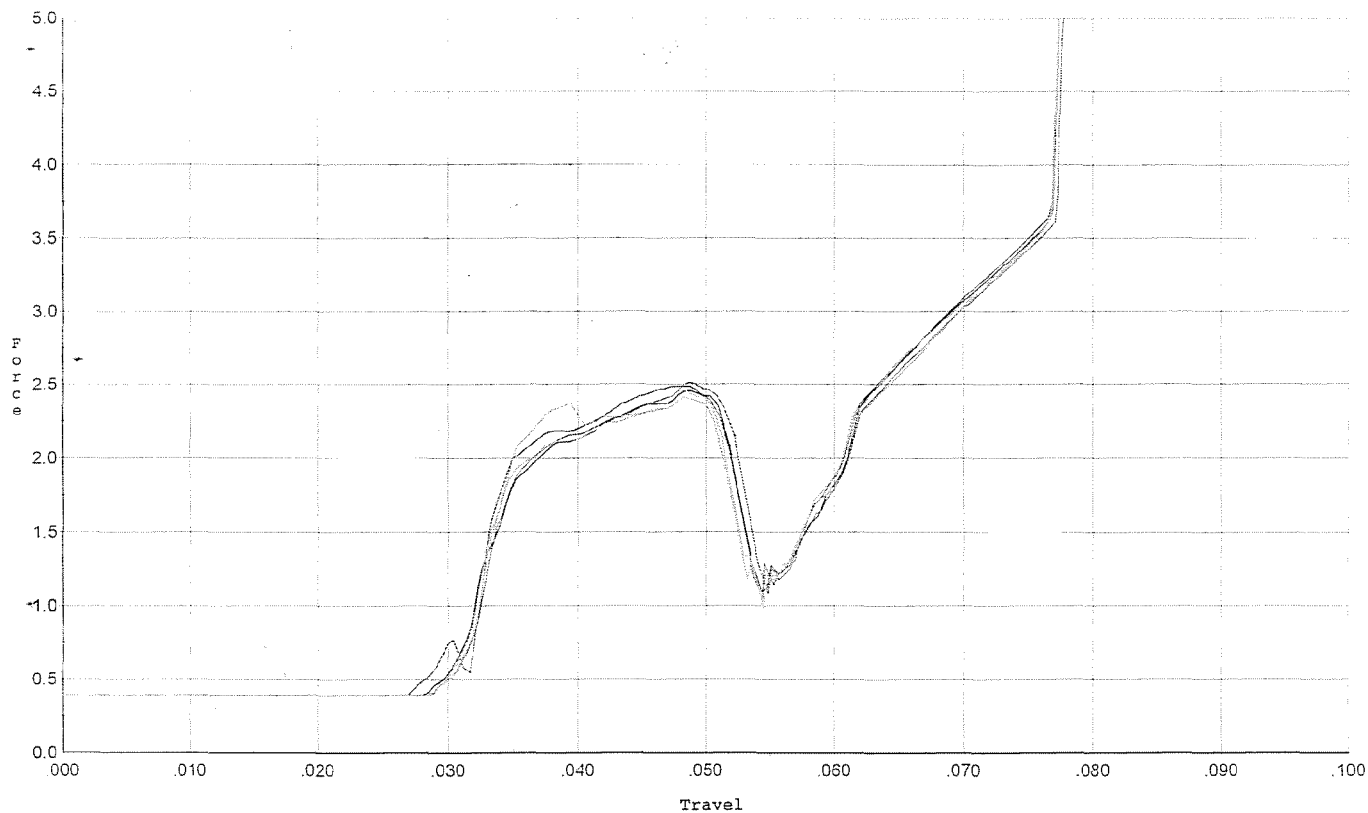
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.041	0.051	0.027	0.028	0.089		Set Trigger
2	4.027	0.051	0.027	0.029	0.089		Set Trigger
3	4.047	0.052	0.029	0.028	0.090		Set Trigger
4	4.091	0.052	0.029	0.028	0.091		Set Trigger
5	4.060	0.051	0.029	0.028	0.088		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



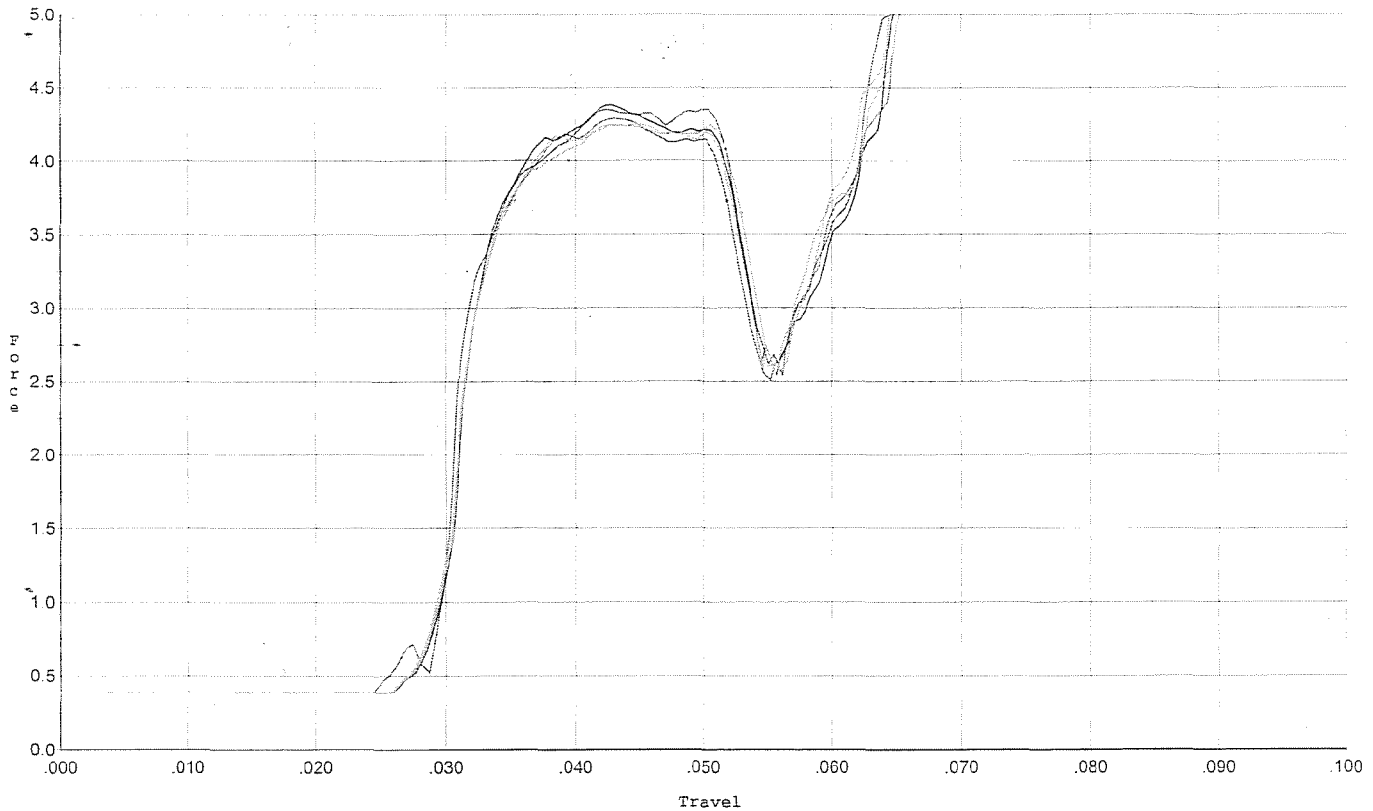
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.485	0.052	0.029	0.032	0.057		Set Trigger
2	2.456	0.052	0.031	0.031	0.056		Set Trigger
3	2.512	0.052	0.031	0.031	0.057		Set Trigger
4	2.461	0.051	0.031	0.032	0.055		Set Trigger
5	2.412	0.052	0.031	0.032	0.056		Set Trigger

A-2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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	4.353	0.052	0.027	0.017	0.101		Set Trigger
2	4.382	0.052	0.028	0.017	0.100		Set Trigger
3	4.290	0.052	0.028	0.017	0.097		Set Trigger
4	4.246	0.052	0.028	0.016	0.100		Set Trigger
5	4.250	0.053	0.028	0.016	0.102		Set Trigger

A-4.30