

G6810337

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



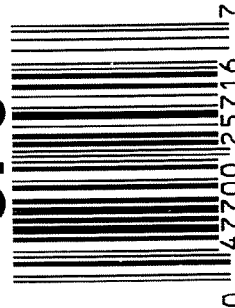
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6810337

UPC



GUN SERIAL #

G 6810337

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RJZ
430	ASSEMBLE TO STOCK		3-6-09	RK
440	PROOF		3-6-09	TK
460	CHECK HEADSPACE		3-6-09	TK
470	DIS-ASSEMBLE ACTION		3-6-09	RJZ
472	SERIALIZE BOLT HANDLE		3-6-09	RJZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION	OPERATION (H)	3/9/09	(H)
490	MAGNAFLUX BOLT		3/9/09	mc
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	mc
542	APPLY COATINGS (BARREL ACTION)		3-20	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	AGJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

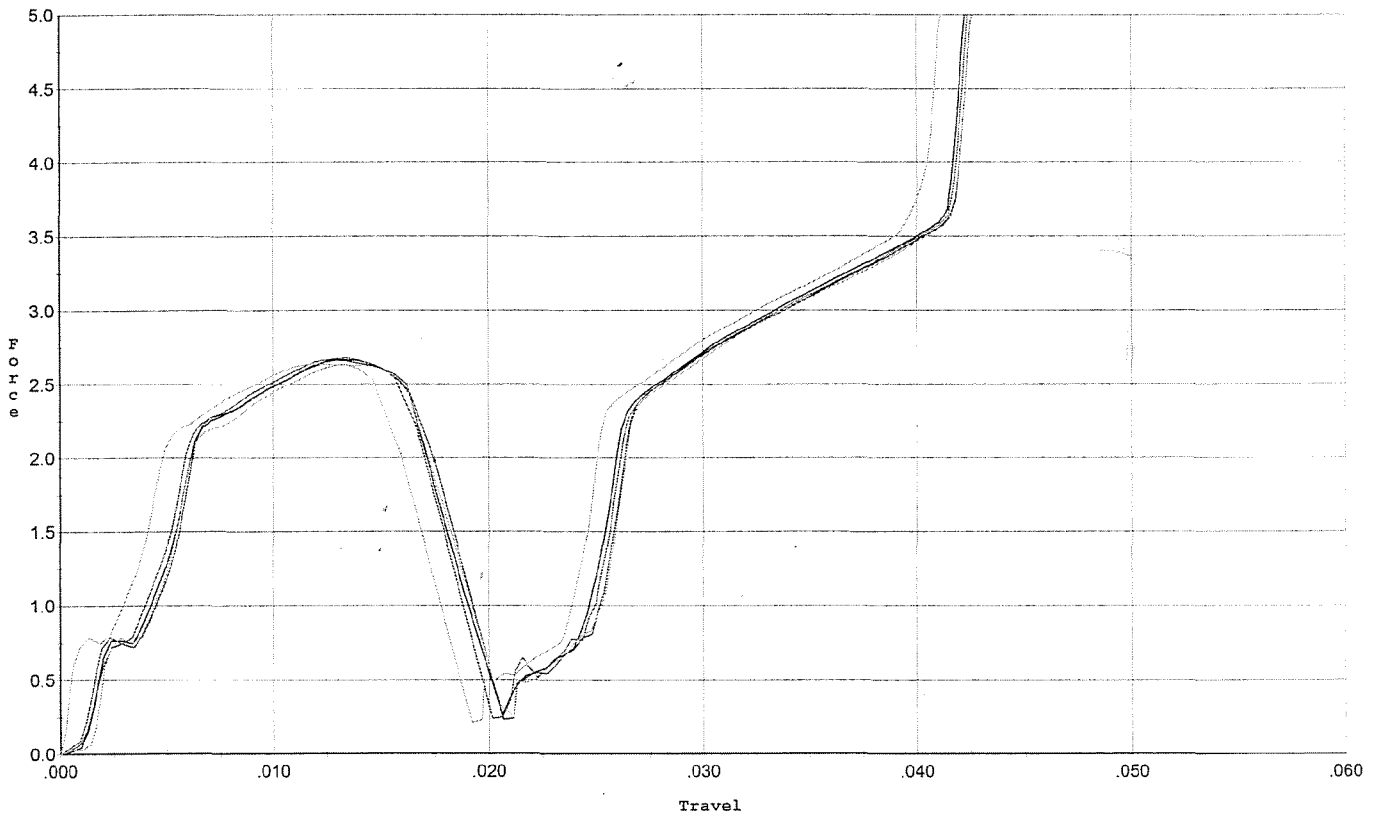
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-25-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-25-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-25-09	WV
	J) ASSEMBLE STOCK		3-23-09	290
	K) ASSEMBLE SWIVEL STUDS		3-25-09	WV
	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	3-24-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	3/W
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.37</u> <u>2.37</u> <u>2.37</u> <u>2.34</u>	3-24-09	TL
	C) FUNCTION		3-25-09	WV
690	PACK		3-25-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



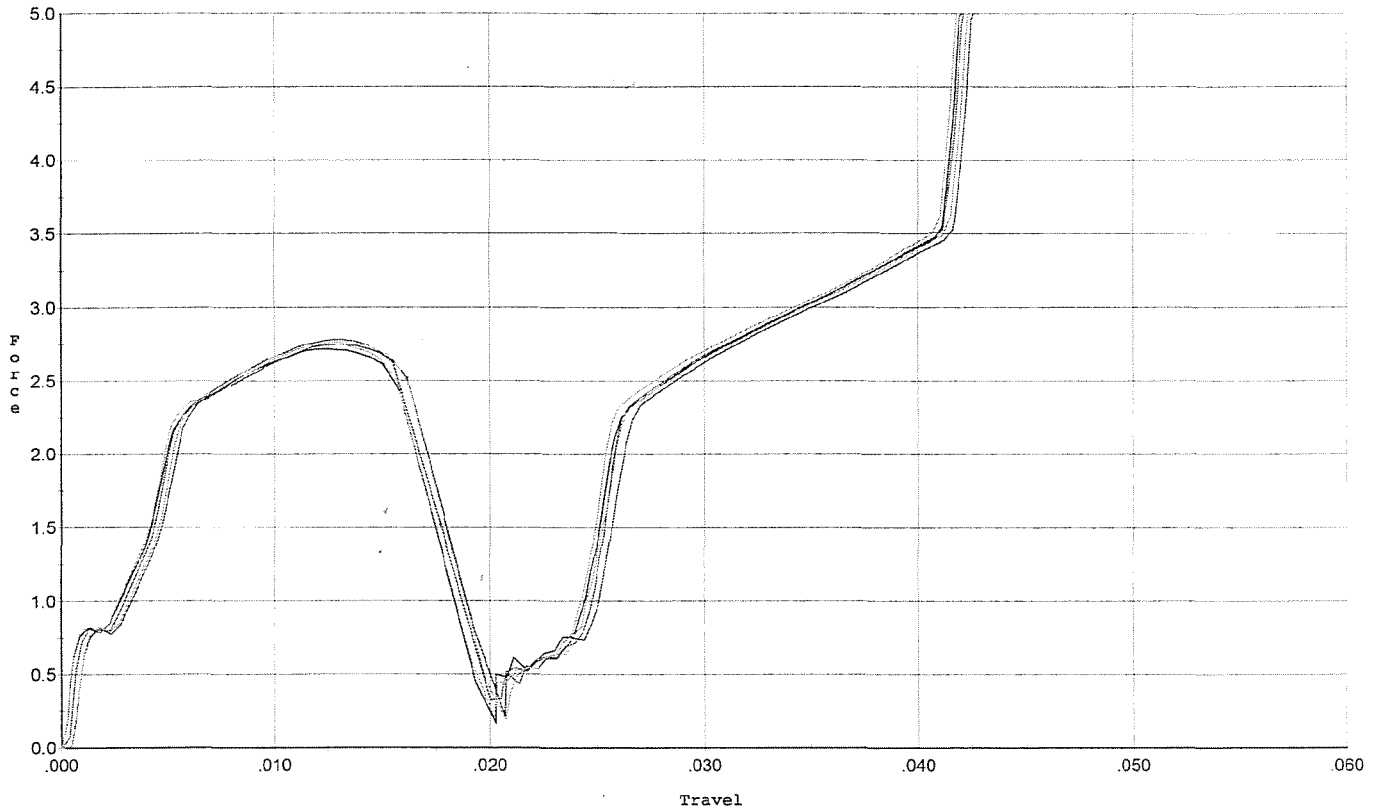
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.017	0.00	0.028	0.031		Set Trigger
2	2.665	0.016	0.004	0.028	0.029		Set Trigger
3	2.676	0.017	0.00	0.028	0.030		Set Trigger
4	2.628	0.018	0.00	0.028	0.031		Set Trigger
5	2.636	0.016	0.00	0.028	0.030		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



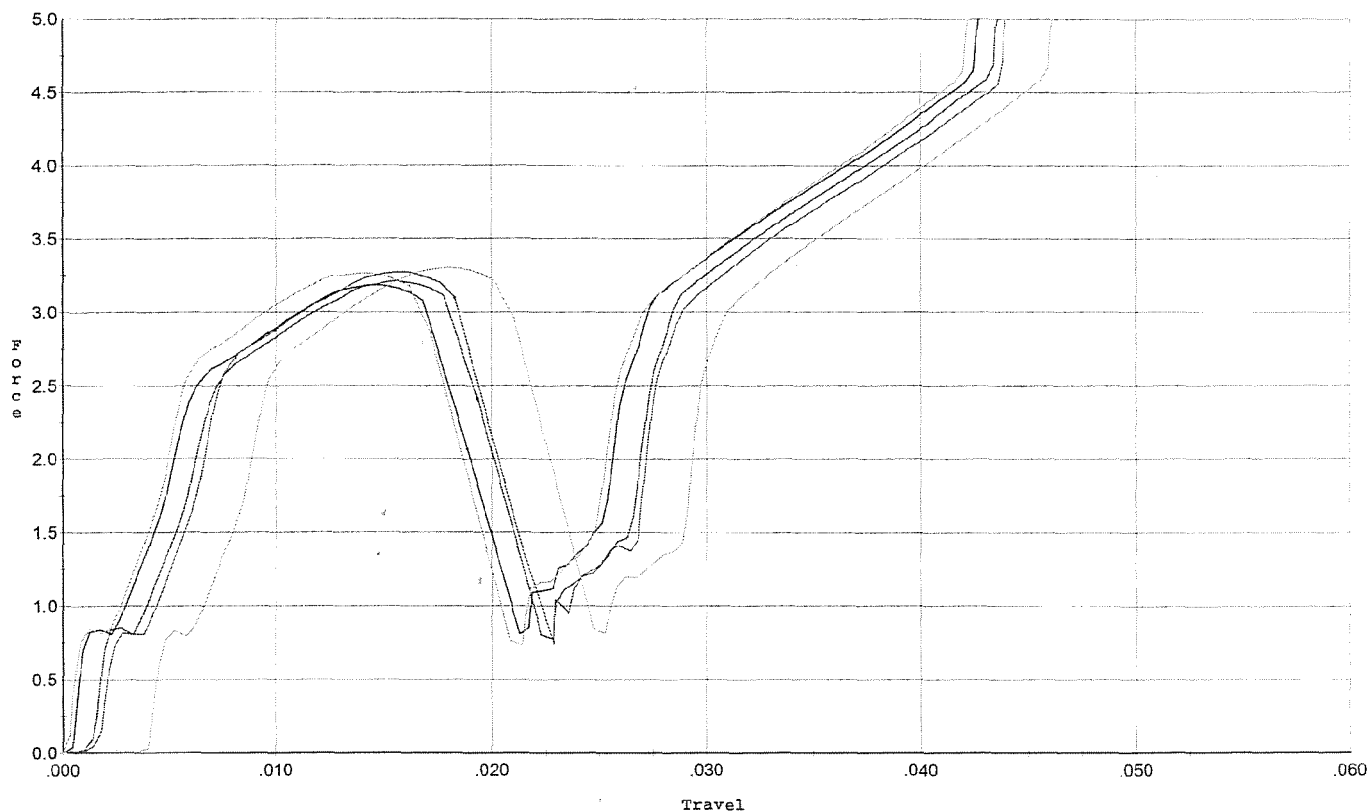
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.747	0.016	0.00	0.029	0.031		Set Trigger
2	2.718	0.016	0.00	0.029	0.031		Set Trigger
3	2.781	0.018	0.003	0.028	0.034		Set Trigger
4	2.761	0.016	0.00	0.028	0.031		Set Trigger
5	2.750	0.016	0.00	0.028	0.031		Set Trigger

A-2-75

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



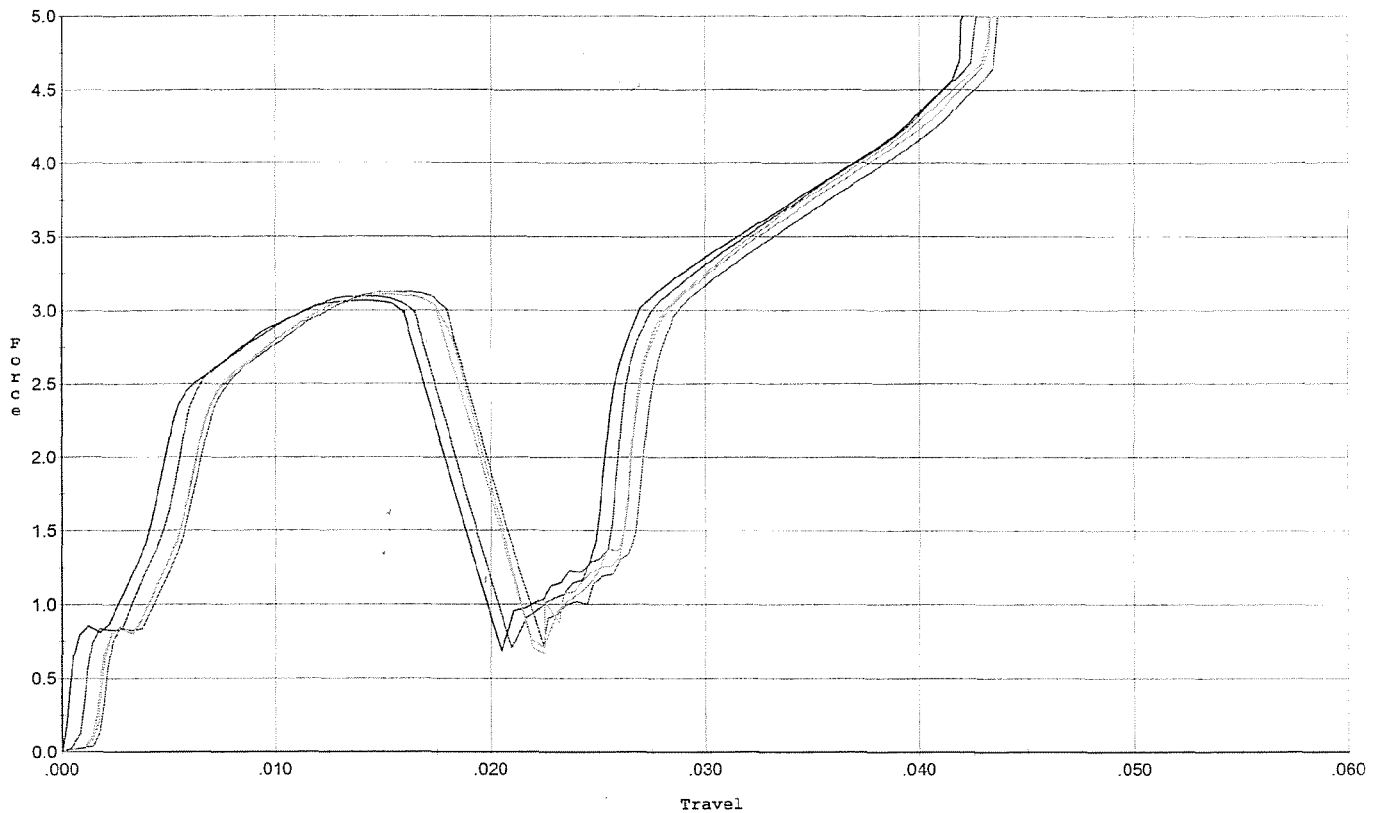
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.212	0.019	0.00	0.027	0.041		Set Trigger
2	3.186	0.019	0.00	0.026	0.041		Set Trigger
3	3.269	0.018	0.004	0.027	0.038		Set Trigger
4	3.305	0.021	0.004	0.028	0.041		Set Trigger
5	3.264	0.017	0.00	0.026	0.039		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



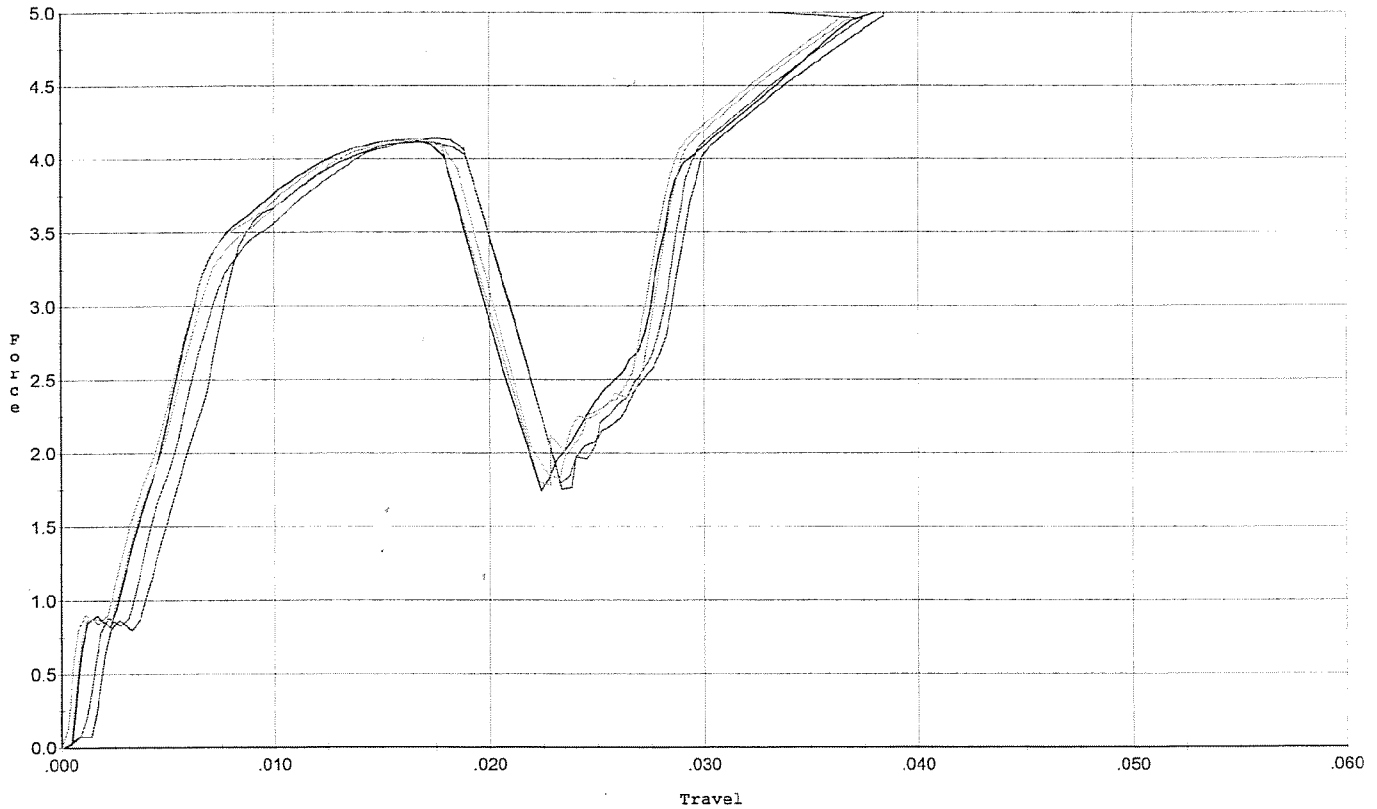
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.095	0.016	0.003	0.027	0.035		Set Trigger
2	3.067	0.016	0.00	0.027	0.034		Set Trigger
3	3.126	0.018	0.00	0.027	0.036		Set Trigger
4	3.128	0.019	0.00	0.027	0.039		Set Trigger
5	3.111	0.018	0.00	0.027	0.037		Set Trigger

A-3-10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



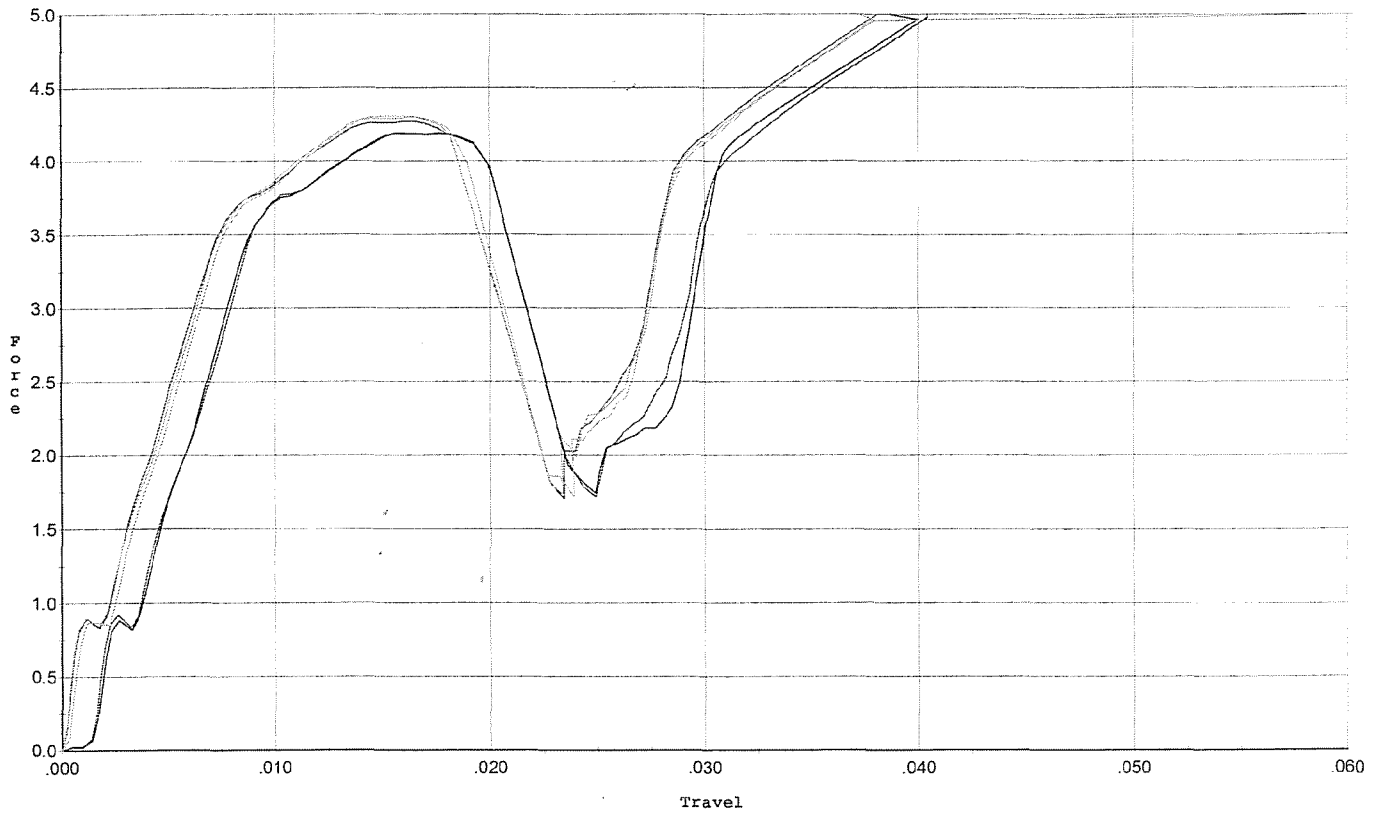
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.114	0.021	0.00	0.025	0.055		Set Trigger
2	4.131	0.018	0.00	0.025	0.050		Set Trigger
3	4.137	0.019	0.00	0.025	0.051		Set Trigger
4	4.131	0.019	0.003	0.025	0.052		Set Trigger
5	4.136	0.020	0.00	0.025	0.056		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



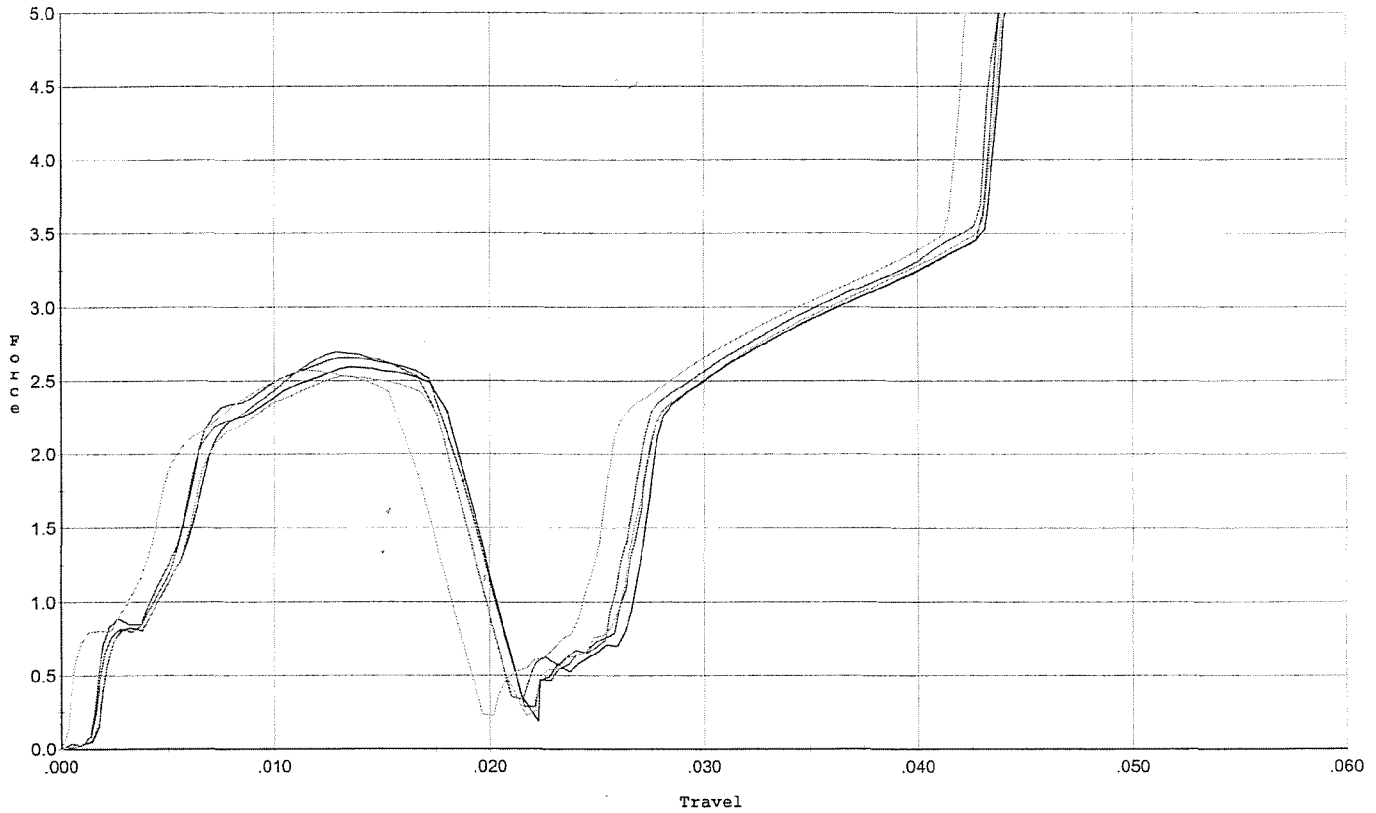
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.185	0.020	0.00	0.026	0.054		Set Trigger
2	4.191	0.020	0.00	0.025	0.054		Set Trigger
3	4.270	0.020	0.00	0.025	0.059		Set Trigger
4	4.301	0.019	0.002	0.025	0.055		Set Trigger
5	4.309	0.020	0.00	0.025	0.059		Set Trigger

A 4.25

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



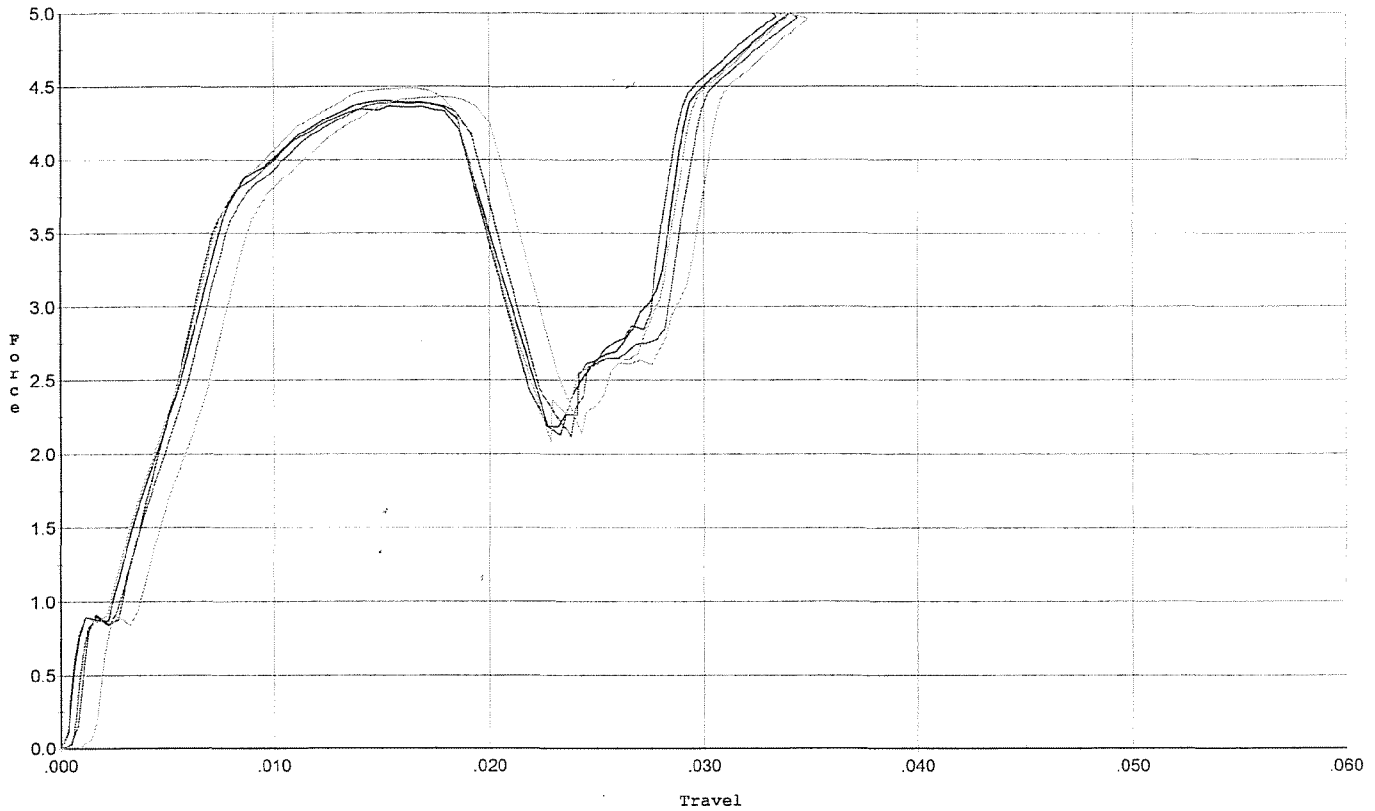
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.656	0.019	0.004	0.028	0.034		Set Trigger
2	2.596	0.018	0.00	0.029	0.031		Set Trigger
3	2.698	0.018	0.00	0.029	0.031		Set Trigger
4	2.573	0.017	0.00	0.029	0.030		Set Trigger
5	2.531	0.018	0.00	0.029	0.030		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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	4.364	0.019	0.00	0.015	0.055		Set Trigger
2	4.404	0.018	0.002	0.016	0.055		Set Trigger
3	4.389	0.019	0.00	0.016	0.056		Set Trigger
4	4.429	0.020	0.00	0.015	0.057		Set Trigger
5	4.490	0.018	0.00	0.016	0.056		Set Trigger

A 4.41