

G6814699

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



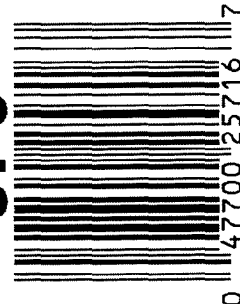
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6814699

UPC



GUN SERIAL #

G 6814699

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SP
460	CHECK HEADSPACE		3-20-09	SP
470	DIS-ASSEMBLE ACTION		3-20-09	SP
472	SERIALIZE BOLT HANDLE		3-23-09	RT
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/25/09	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	B+
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-7-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

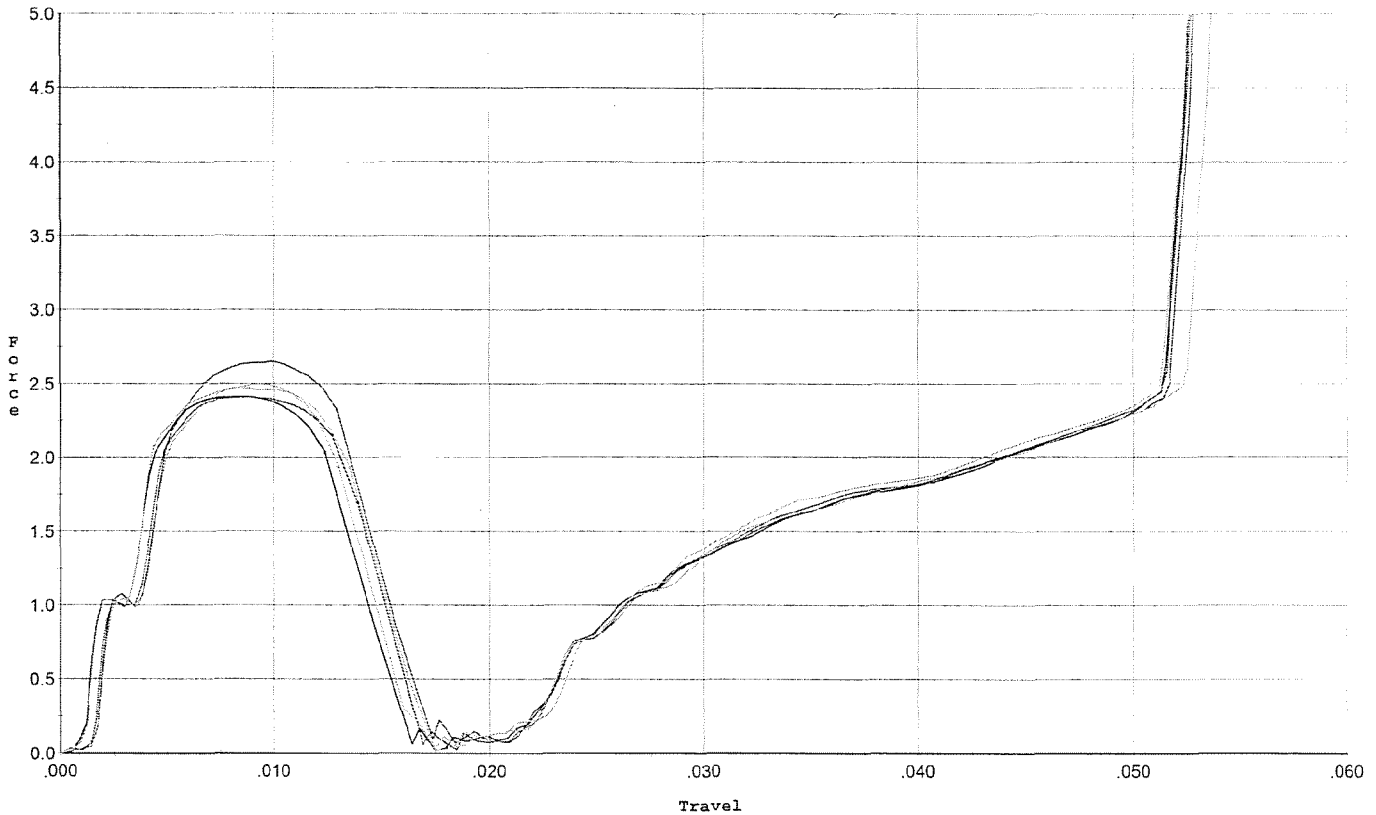
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.8</u> <u>2.7</u> <u>2.7</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.3</u> <u>4.4</u> <u>4.3</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-17-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-17-09	RP
	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	4-9-09	WW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.72</u> <u>2.66</u> <u>2.78</u> <u>2.70</u> <u>2.67</u>	4-14-09	WW
	C) FUNCTION		4-17-09	RP
690	PACK		4-29-09	WW

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



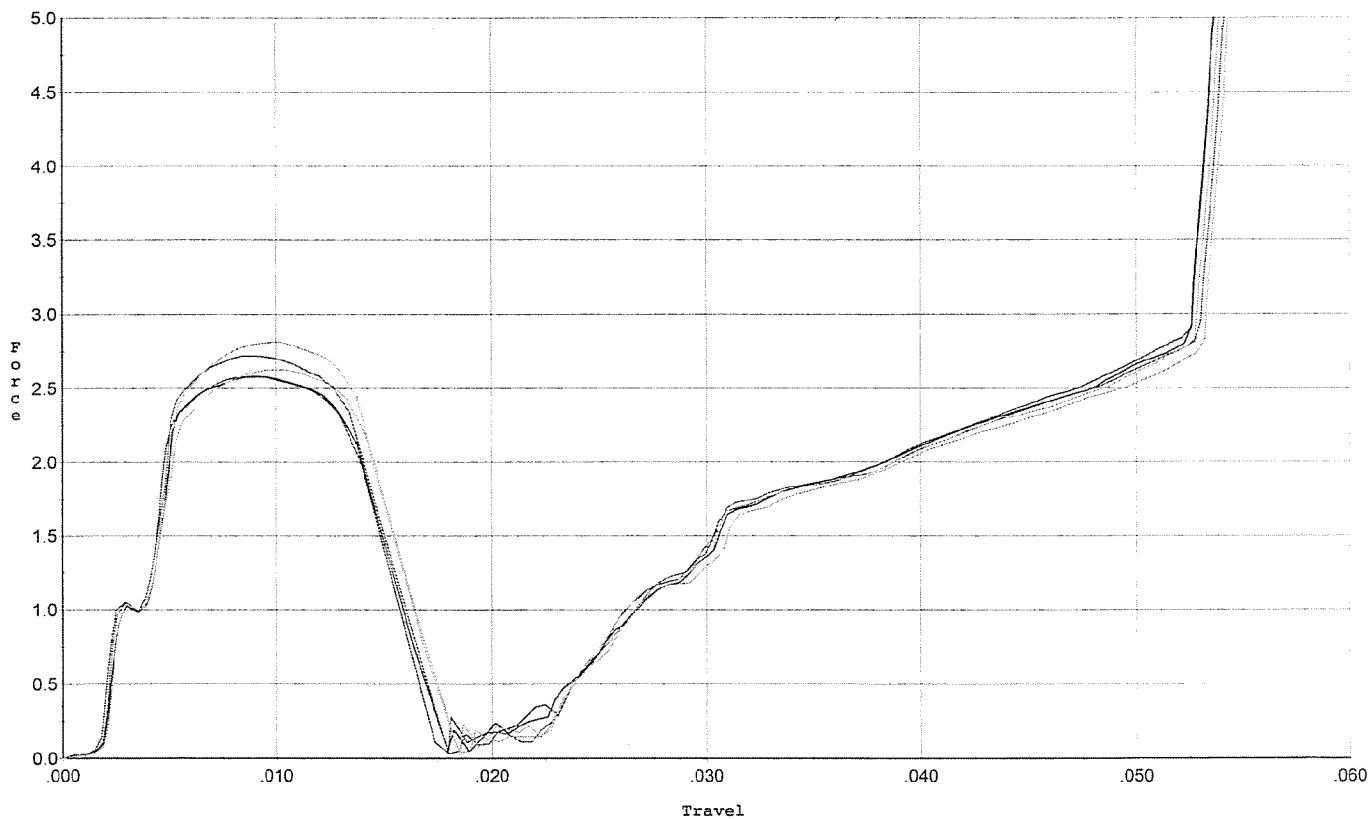
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.650	0.013	0.00	0.043	0.023		Set Trigger
2	2.412	0.012	0.003	0.044	0.021		Set Trigger
3	2.411	0.014	0.004	0.043	0.023		Set Trigger
4	2.468	0.013	0.00	0.043	0.022		Set Trigger
5	2.499	0.014	0.00	0.044	0.022		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



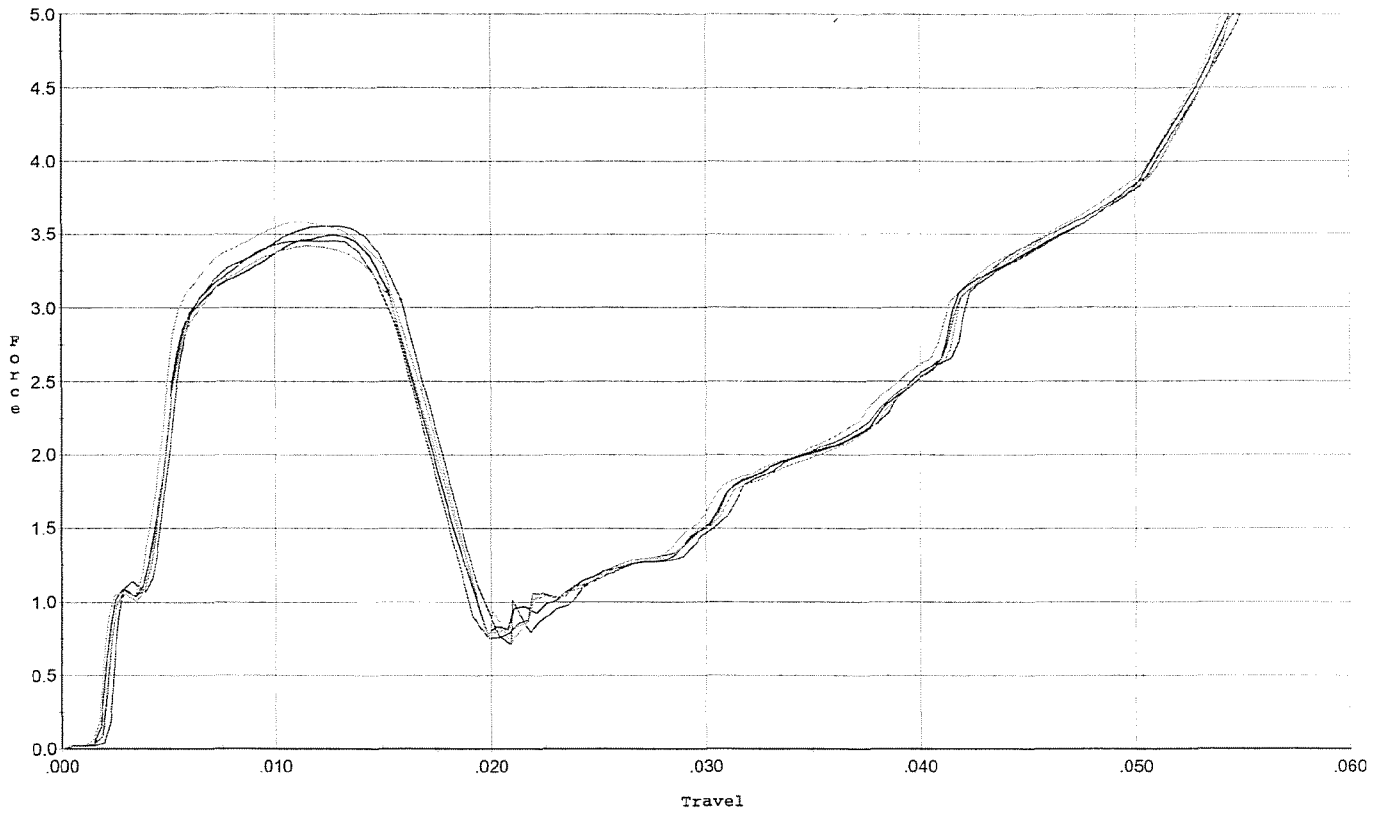
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.582	0.014	0.00	0.043	0.024		Set Trigger
2	2.578	0.014	0.00	0.043	0.023		Set Trigger
3	2.718	0.013	0.00	0.044	0.024		Set Trigger
4	2.627	0.014	0.00	0.043	0.024		Set Trigger
5	2.812	0.014	0.00	0.043	0.025		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



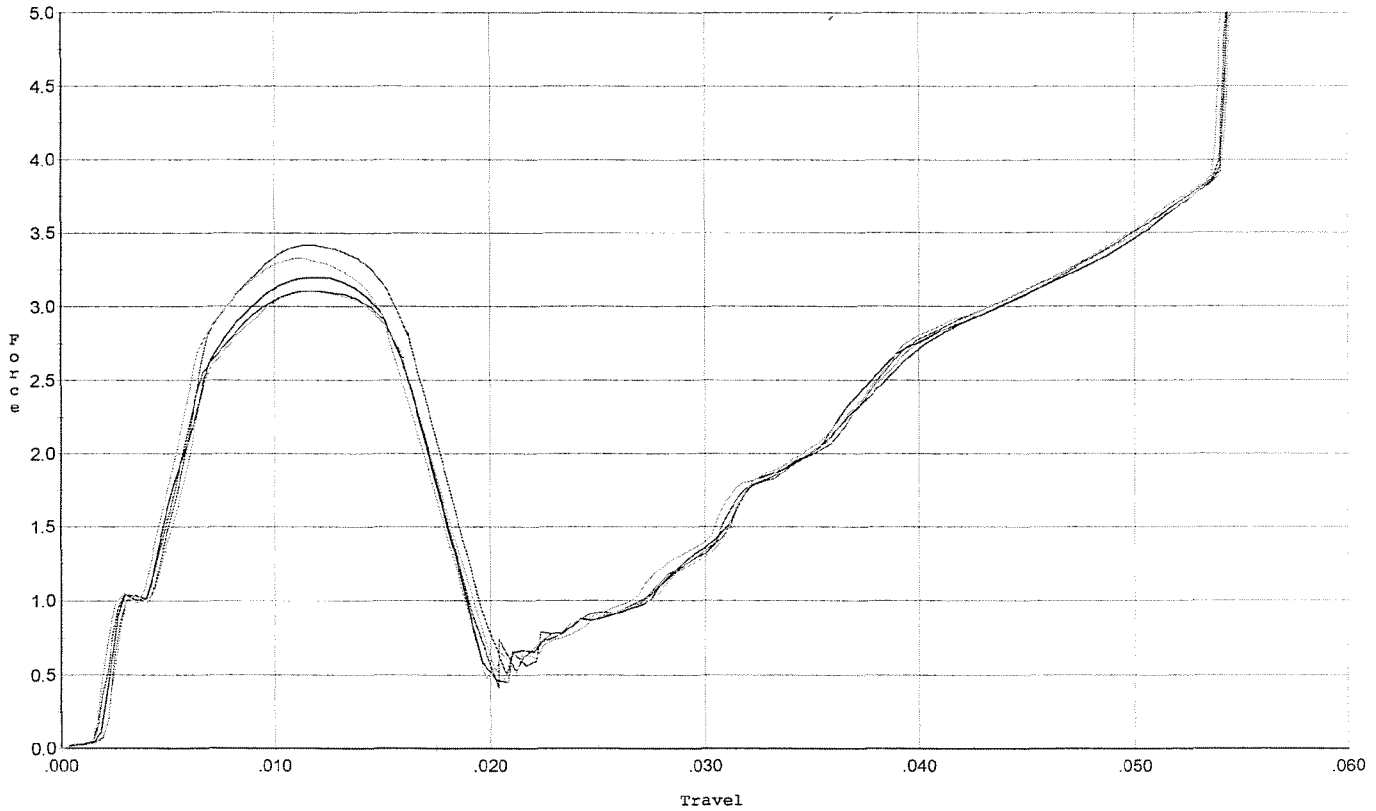
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.553	0.016	0.002	0.040	0.036		Set Trigger
2	3.497	0.015	0.00	0.040	0.035		Set Trigger
3	3.454	0.016	0.002	0.040	0.035		Set Trigger
4	3.584	0.017	0.00	0.039	0.040		Set Trigger
5	3.419	0.018	0.00	0.040	0.039		Set Trigger

A-3.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schuits 2/25/2009

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



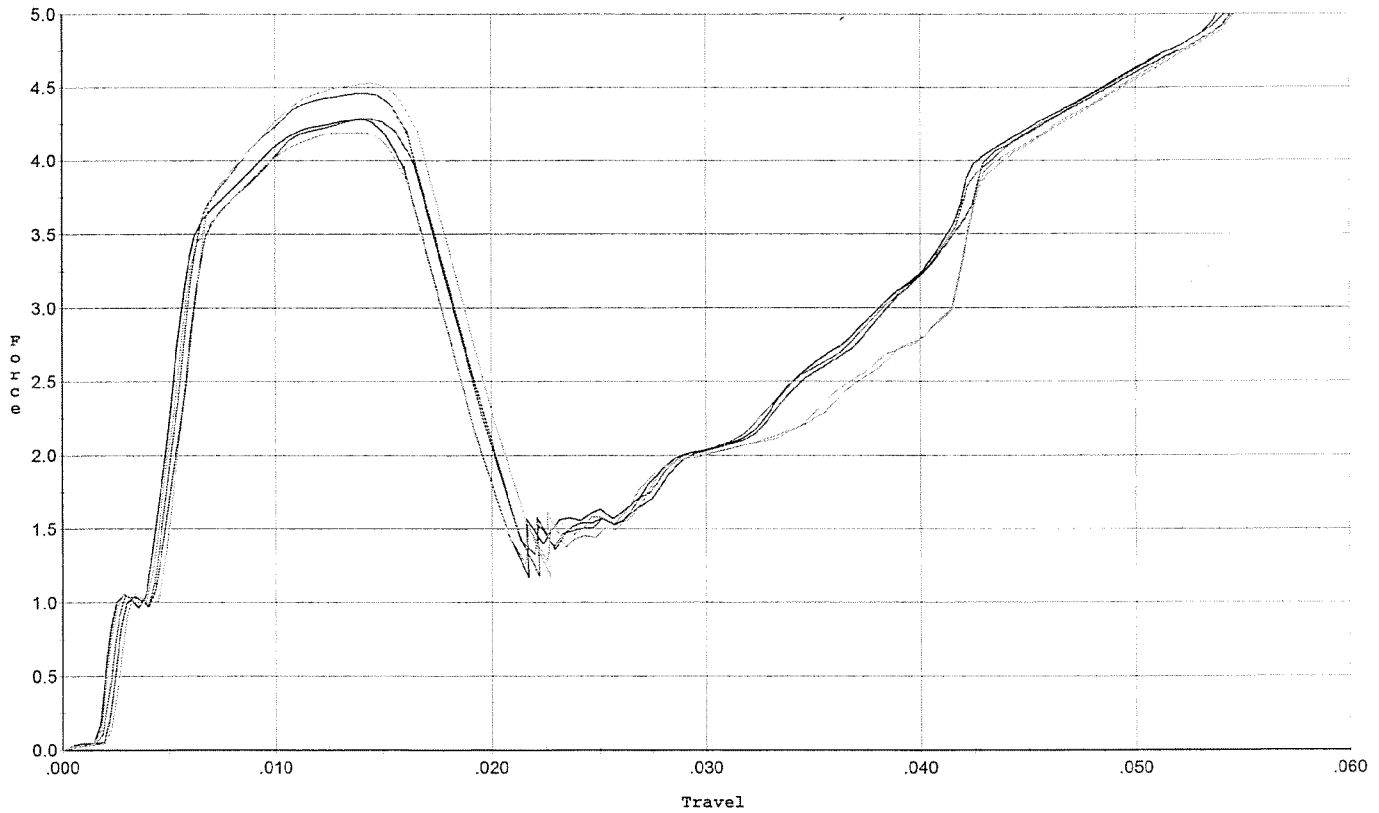
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.107	0.016	0.004	0.040	0.032		Set Trigger
2	3.196	0.016	0.004	0.040	0.033		Set Trigger
3	3.418	0.016	0.00	0.039	0.035		Set Trigger
4	3.101	0.016	0.00	0.040	0.031		Set Trigger
5	3.328	0.017	0.00	0.039	0.036		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



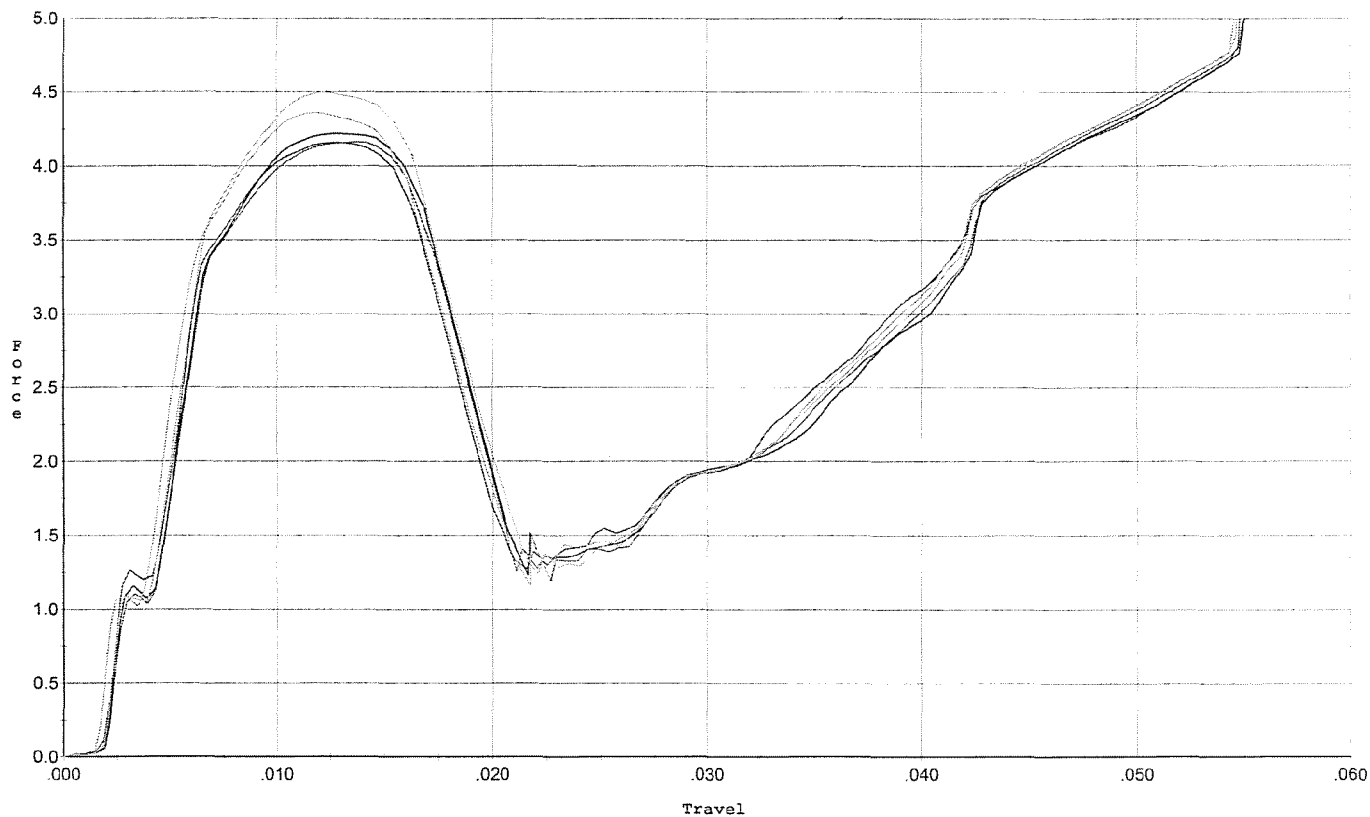
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.286	0.016	0.00	0.037	0.044		Set Trigger
2	4.288	0.016	0.00	0.037	0.044		Set Trigger
3	4.459	0.016	0.002	0.037	0.045		Set Trigger
4	4.528	0.017	0.00	0.038	0.046		Set Trigger
5	4.191	0.016	0.00	0.038	0.043		Set Trigger

A-4.35

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



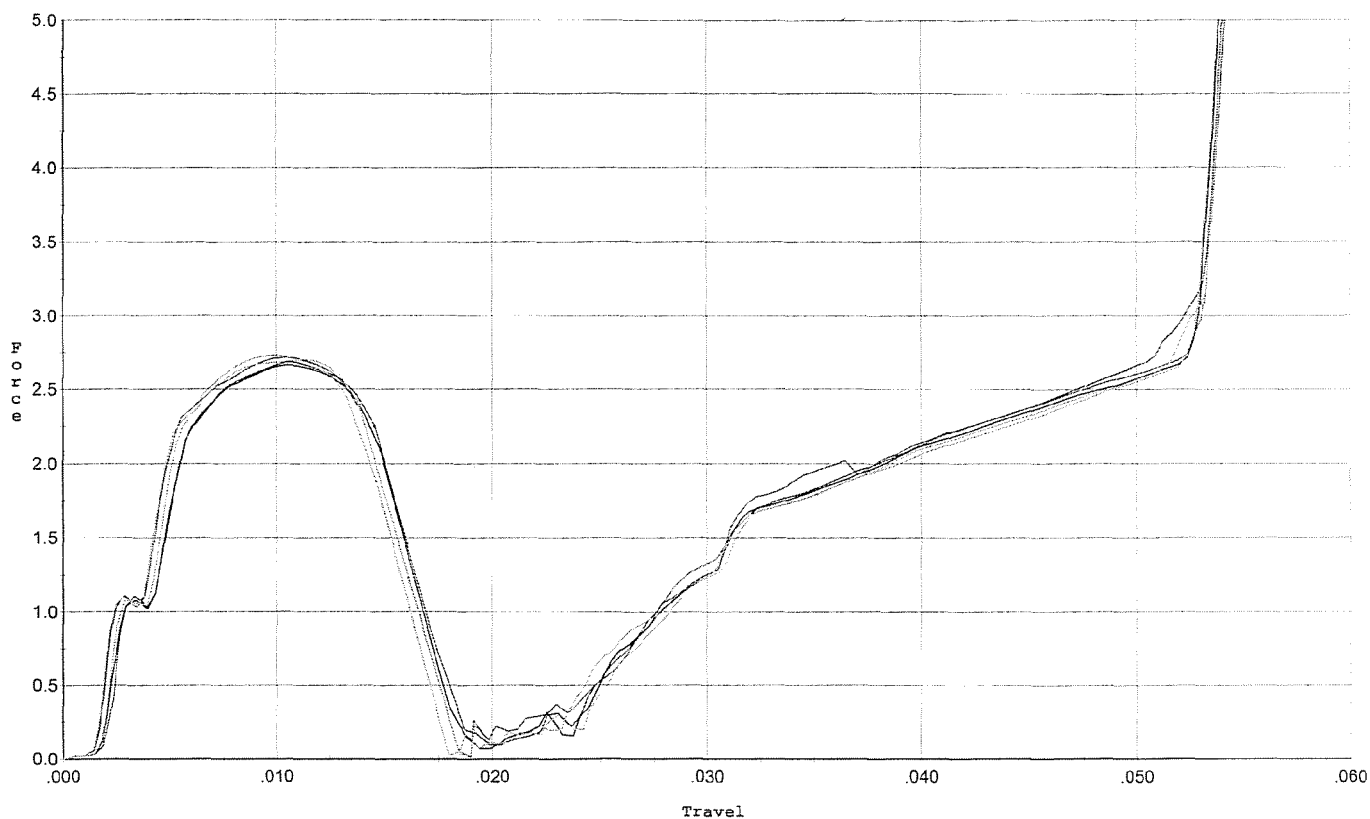
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.016	0.00	0.038	0.043		Set Trigger
2	4.215	0.017	0.00	0.038	0.045		Set Trigger
3	4.161	0.017	0.00	0.038	0.045		Set Trigger
4	4.498	0.016	0.004	0.038	0.046		Set Trigger
5	4.361	0.016	0.00	0.038	0.044		Set Trigger

A.4.27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



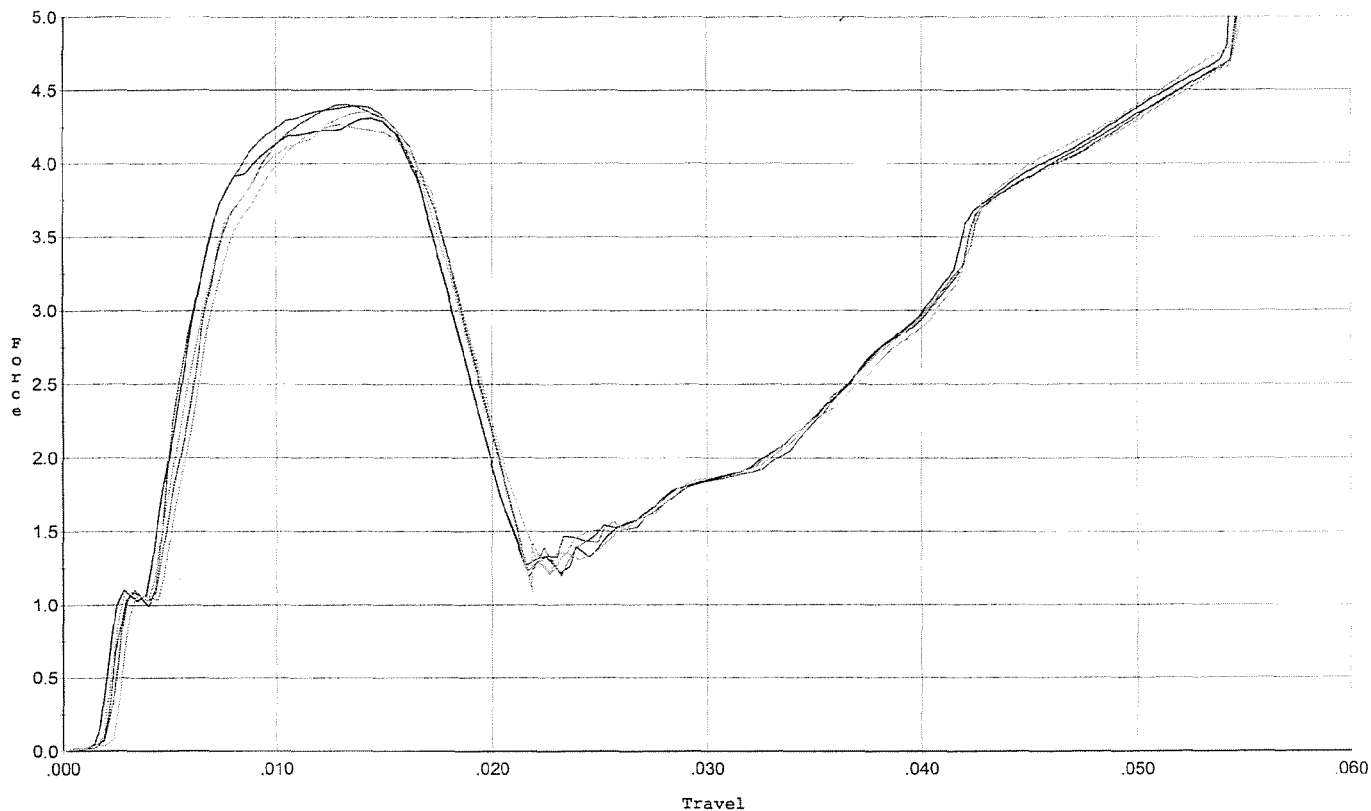
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.681	0.015	0.00	0.042	0.025		Set Trigger
2	2.664	0.015	0.00	0.042	0.026		Set Trigger
3	2.715	0.016	0.00	0.043	0.029		Set Trigger
4	2.703	0.014	0.004	0.043	0.025		Set Trigger
5	2.730	0.015	0.00	0.043	0.026		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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	4.392	0.016	0.00	0.037	0.045		Set Trigger
2	4.307	0.017	0.00	0.037	0.045		Set Trigger
3	4.400	0.017	0.00	0.037	0.047		Set Trigger
4	4.350	0.018	0.002	0.038	0.049		Set Trigger
5	4.266	0.017	0.005	0.037	0.045		Set Trigger

A. 4.34