

G6814704

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



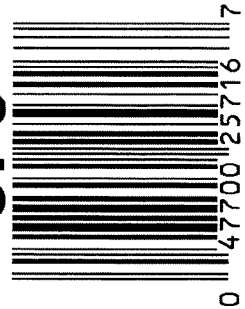
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6814704

UPC



GUN SERIAL #

G 6814704

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RJL
480	MAGNAFLUX BBL ACTION		3/9/09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	SP
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-31-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

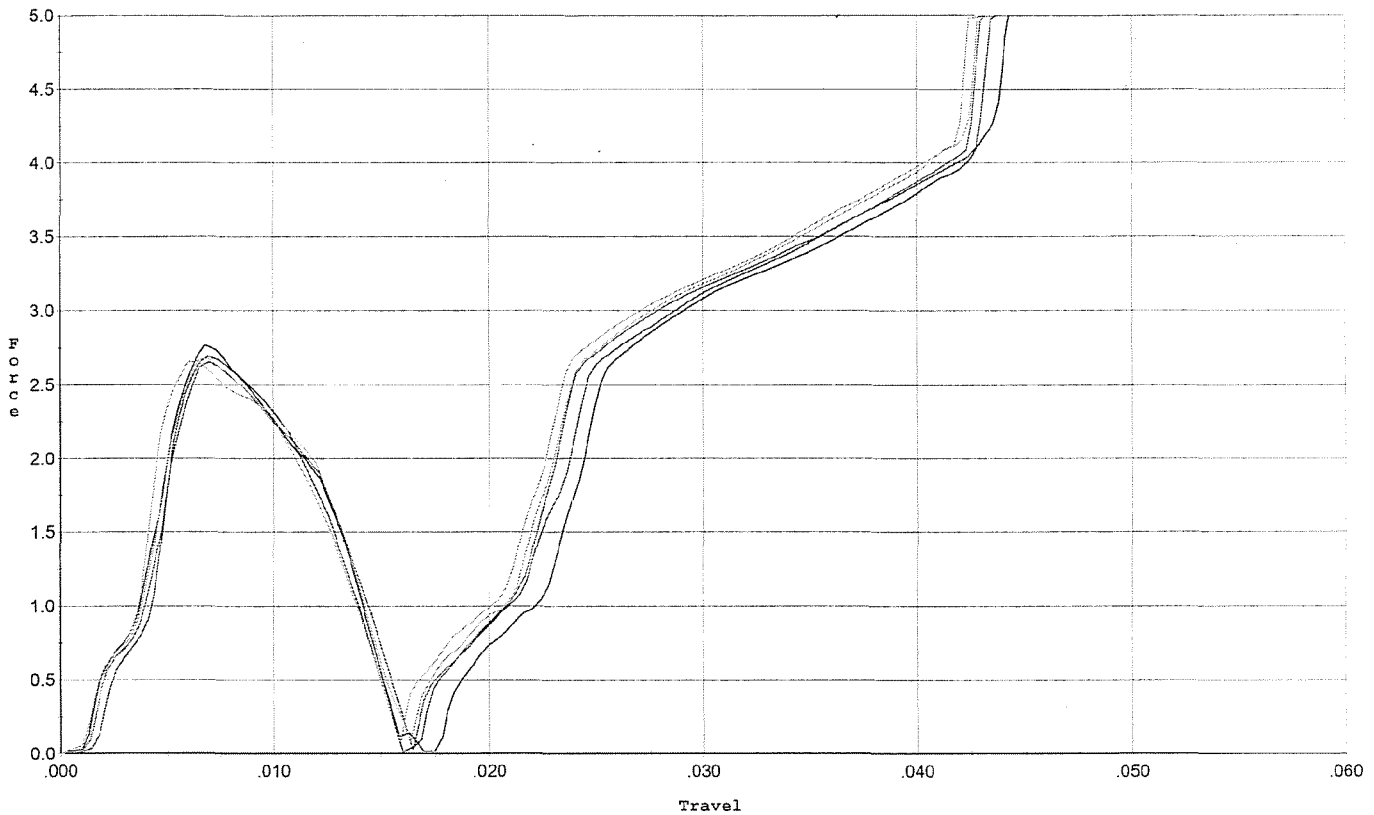
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	4-1-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	4-1-09	3/W
	J) ASSEMBLE STOCK		3-31-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-1-09	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	4-1-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.52</u> <u>2.66</u> <u>2.34</u> <u>2.40</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		4/9/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



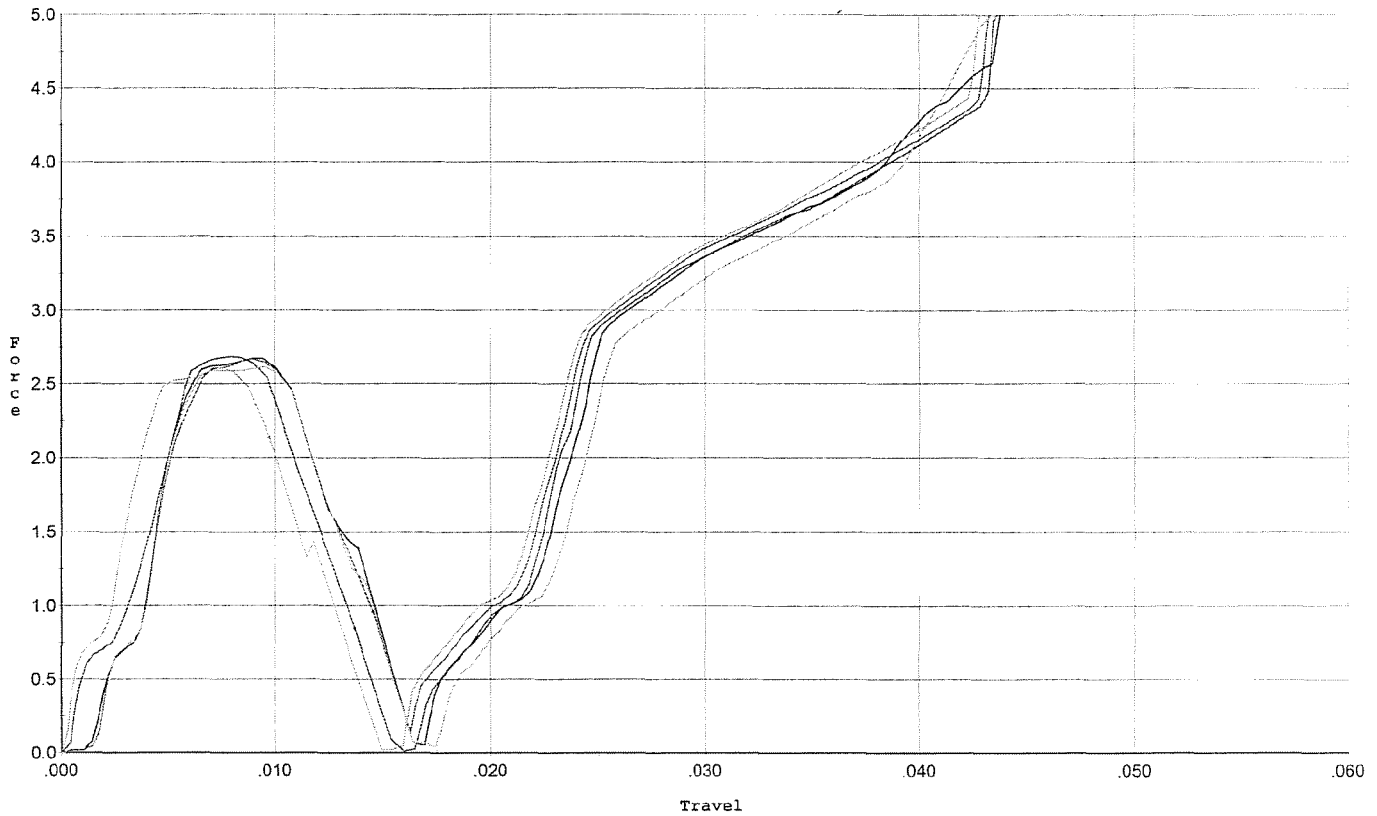
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.699	0.014	0.00	0.033	0.021		Set Trigger
2	2.772	0.013	0.00	0.034	0.021		Set Trigger
3	2.655	0.015	0.00	0.032	0.022		Set Trigger
4	2.682	0.013	0.00	0.032	0.021		Set Trigger
5	2.669	0.014	0.00	0.032	0.022		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



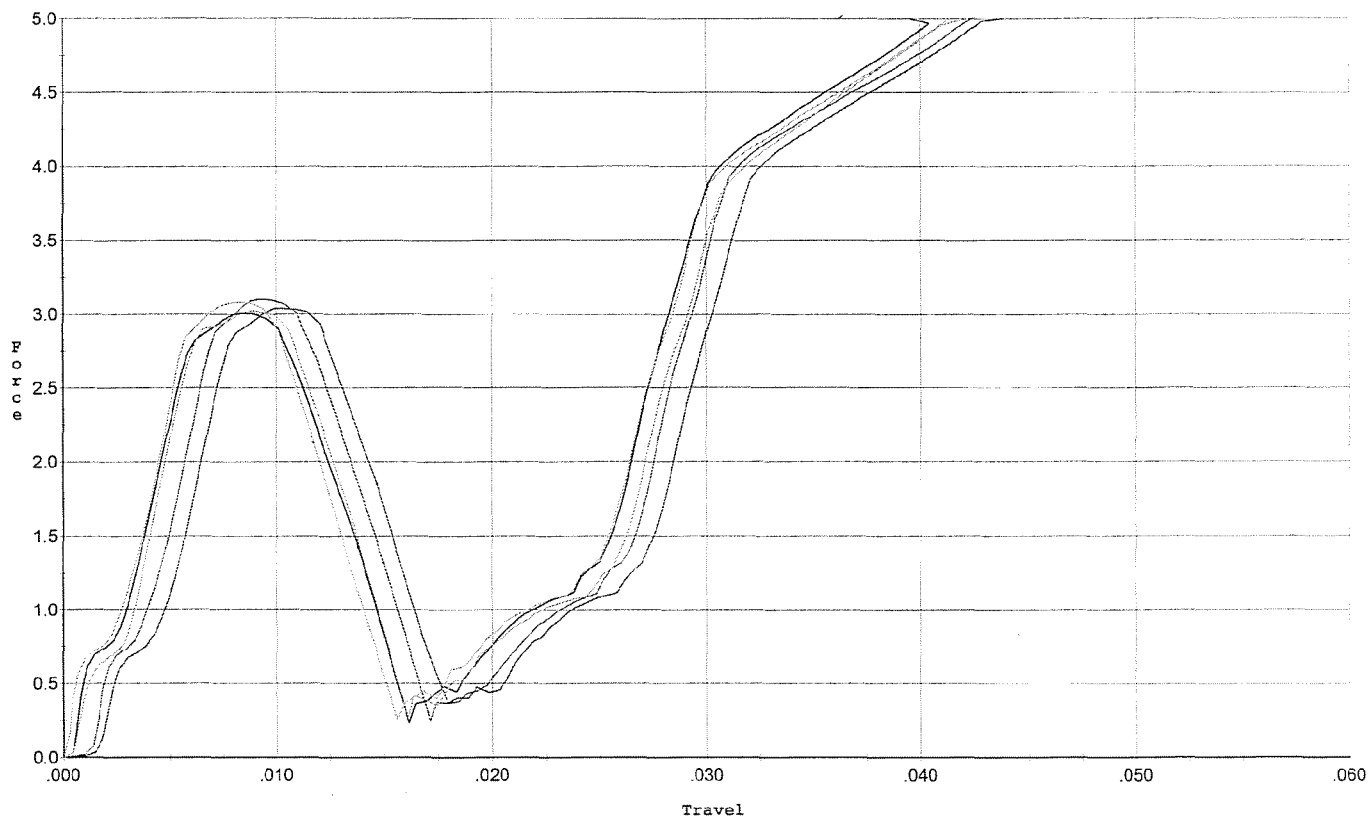
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.684	0.014	0.00	0.033	0.022		Set Trigger
2	2.672	0.014	0.00	0.033	0.022		Set Trigger
3	2.669	0.015	0.00	0.032	0.023		Set Trigger
4	2.618	0.014	0.00	0.033	0.022		Set Trigger
5	2.611	0.010	0.00	0.034	0.017		Set Trigger

A-2-65

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



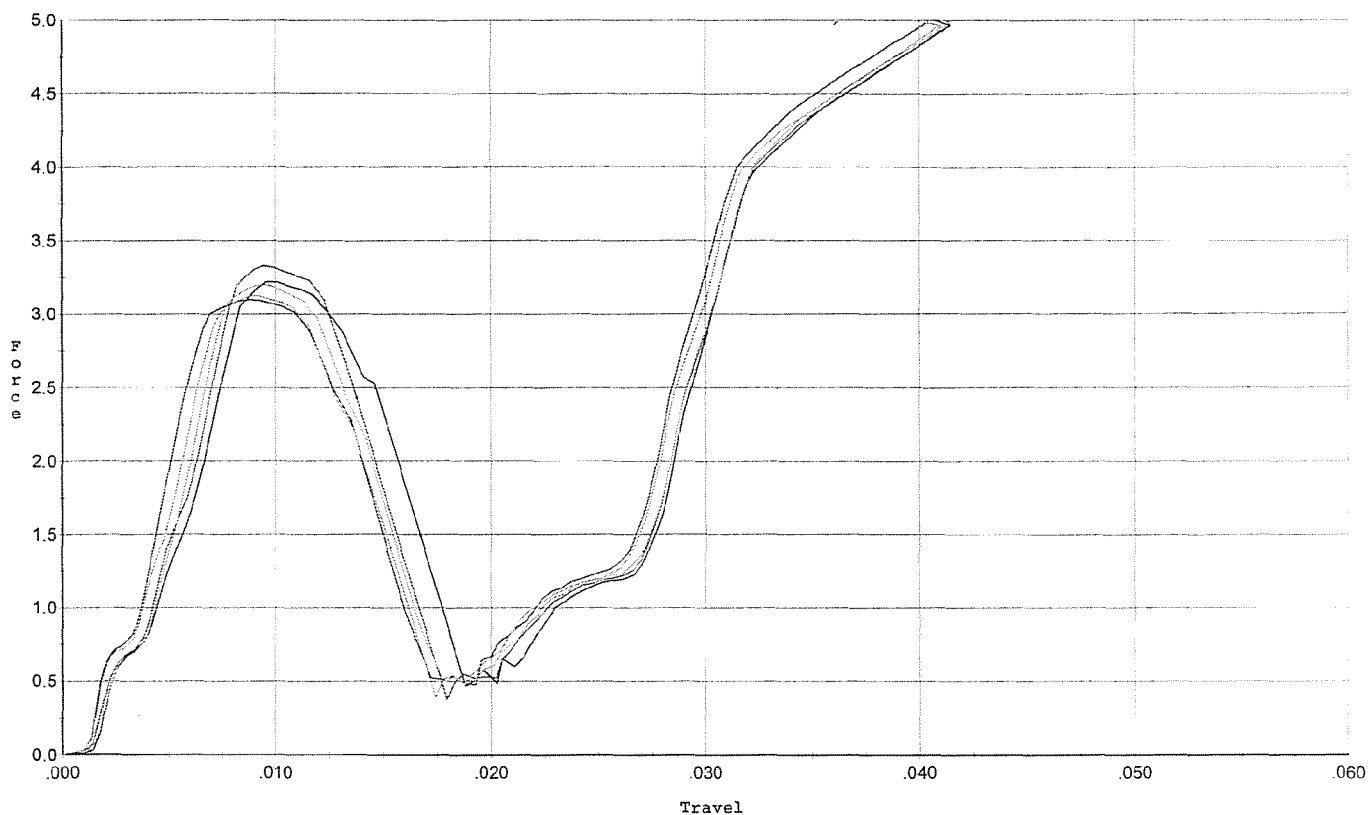
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.038	0.015	0.00	0.035	0.025		Set Trigger
2	3.009	0.014	0.00	0.034	0.026		Set Trigger
3	3.101	0.015	0.00	0.035	0.026		Set Trigger
4	3.081	0.012	0.00	0.036	0.023		Set Trigger
5	3.023	0.014	0.00	0.035	0.025		Set Trigger

A-3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



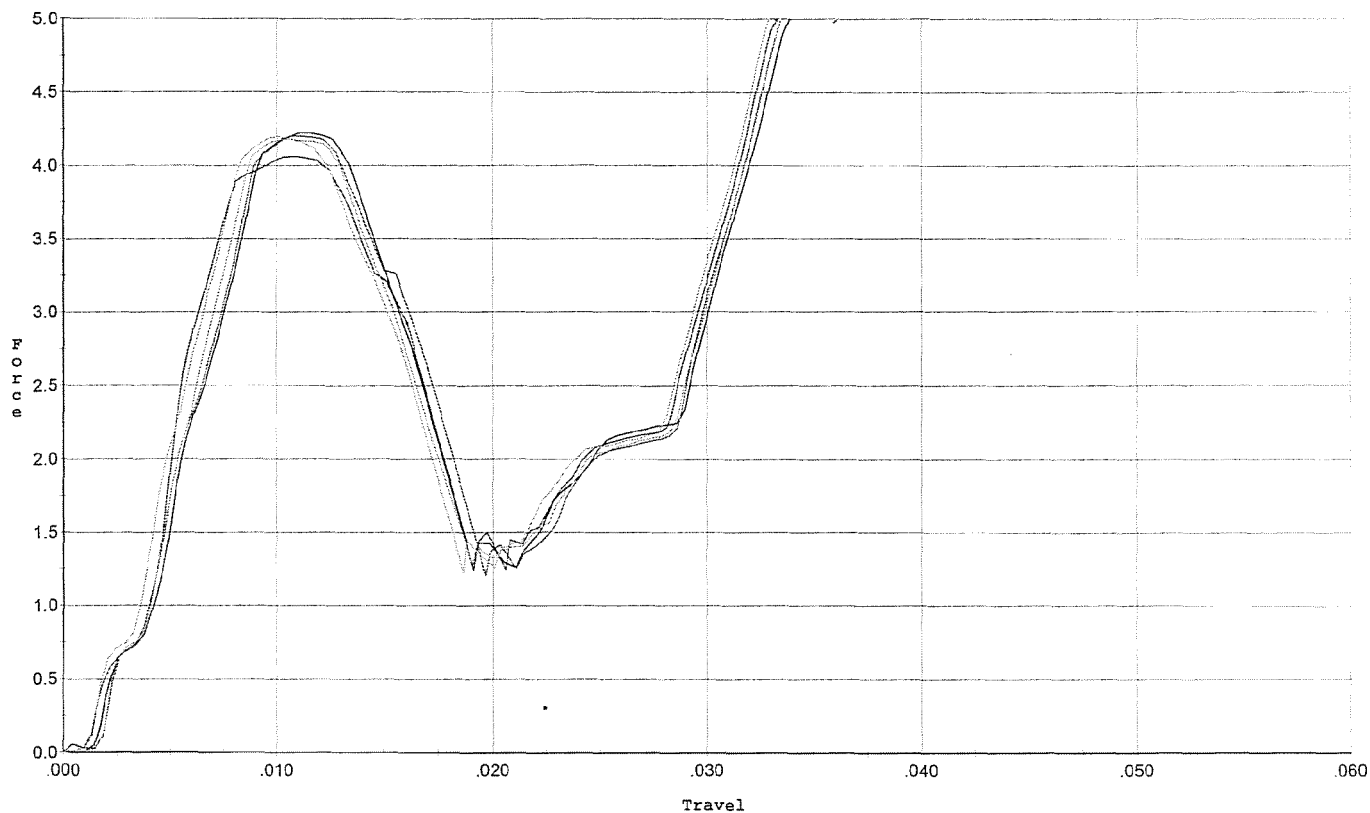
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.099	0.014	0.00	0.033	0.026		Set Trigger
2	3.221	0.017	0.00	0.034	0.030		Set Trigger
3	3.331	0.014	0.00	0.035	0.026		Set Trigger
4	3.199	0.014	0.00	0.035	0.026		Set Trigger
5	3.121	0.015	0.00	0.035	0.028		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



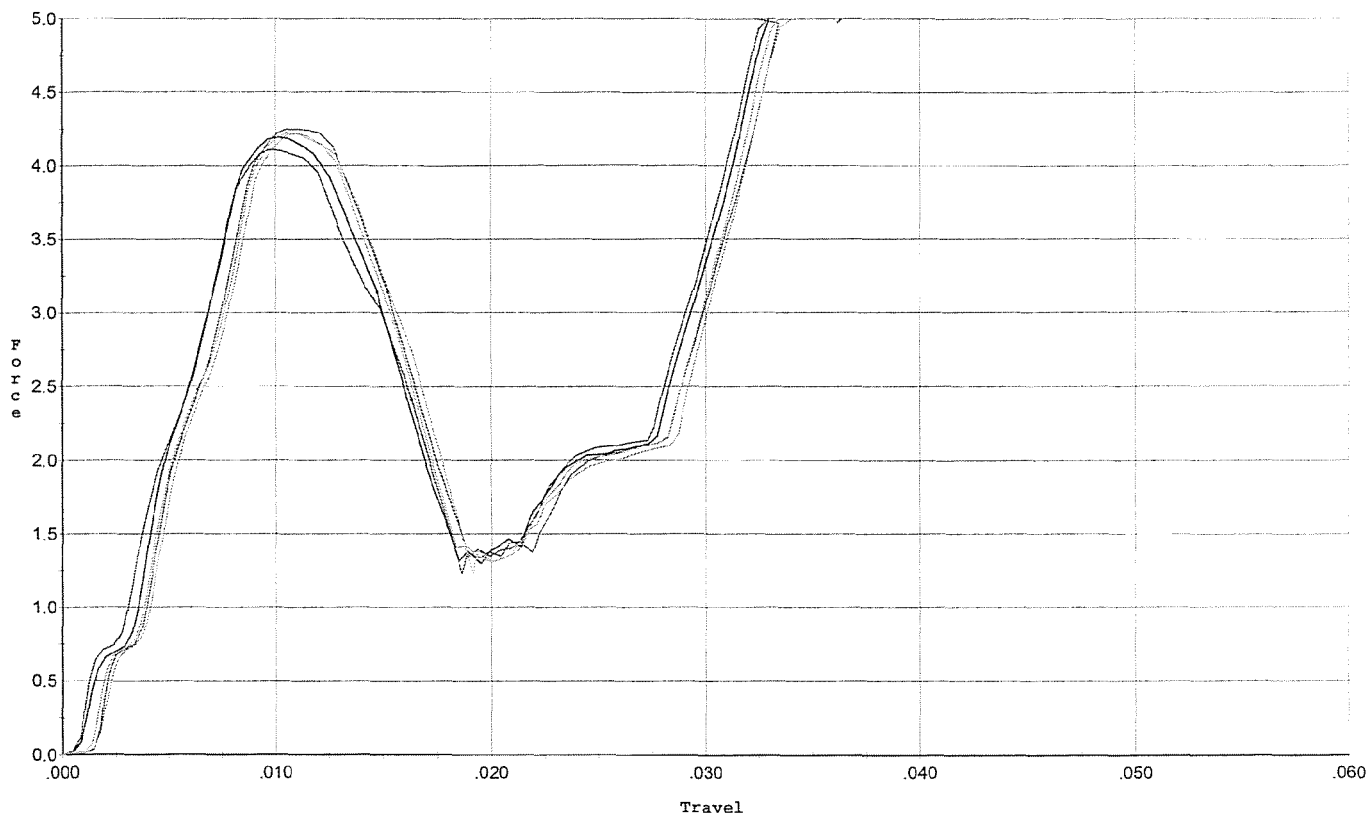
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.061	0.016	0.002	0.028	0.039		Set Trigger
2	4.223	0.016	0.00	0.029	0.039		Set Trigger
3	4.199	0.017	0.00	0.028	0.041		Set Trigger
4	4.197	0.016	0.00	0.028	0.039		Set Trigger
5	4.177	0.015	0.00	0.029	0.036		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



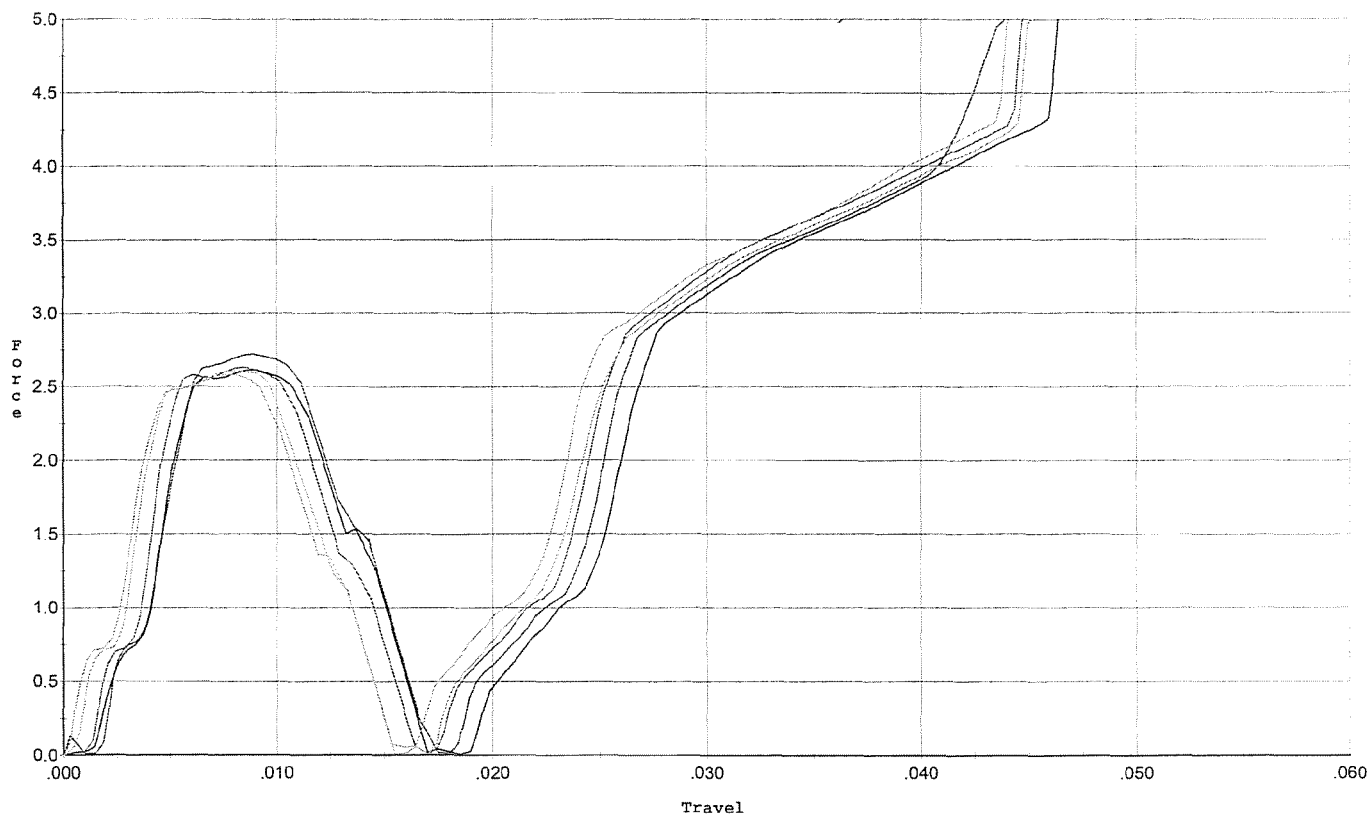
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.110	0.016	0.00	0.028	0.039		Set Trigger
2	4.194	0.015	0.00	0.029	0.036		Set Trigger
3	4.250	0.015	0.00	0.029	0.036		Set Trigger
4	4.226	0.016	0.00	0.029	0.037		Set Trigger
5	4.223	0.016	0.00	0.029	0.038		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



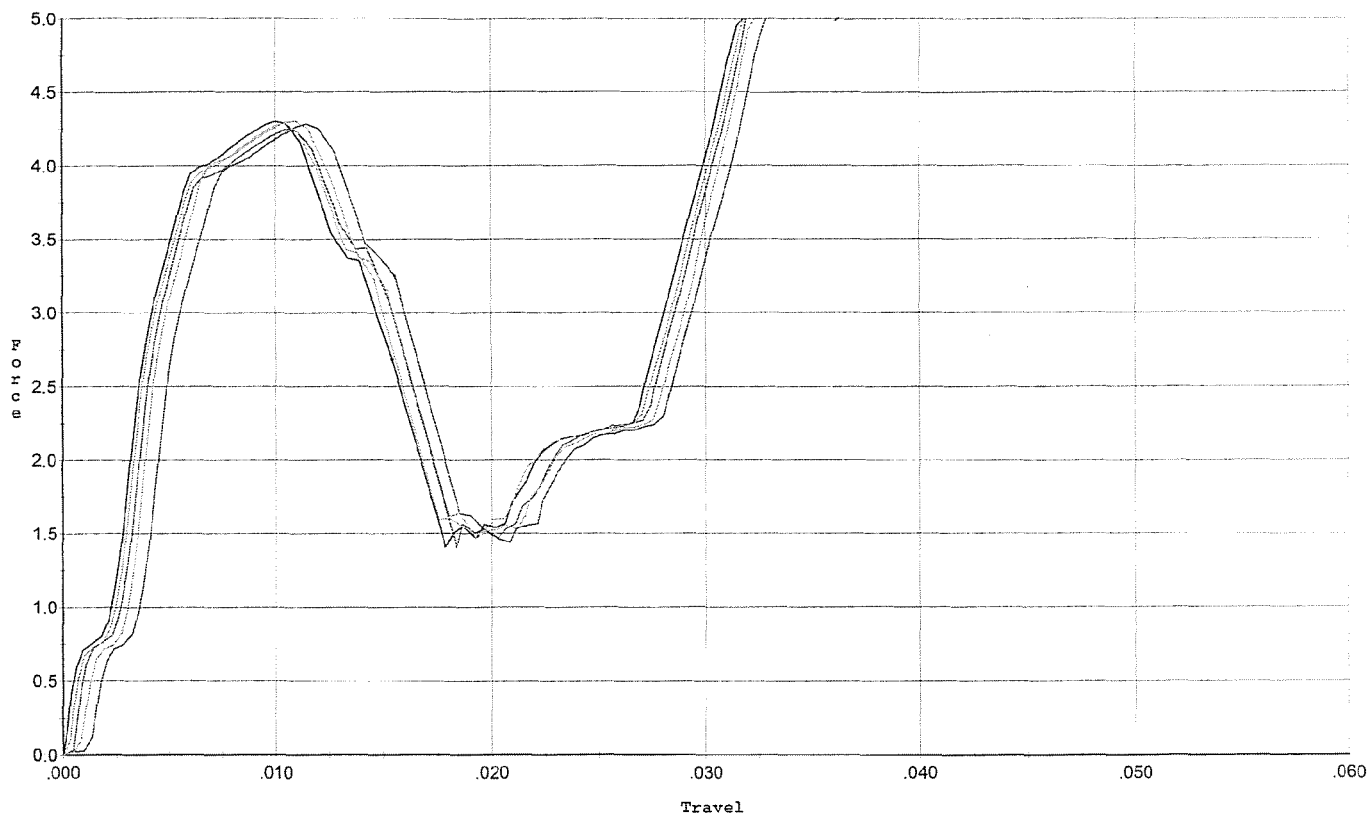
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.720	0.014	0.002	0.034	0.023		Set Trigger
2	2.613	0.015	0.00	0.035	0.023		Set Trigger
3	2.631	0.014	0.00	0.034	0.023		Set Trigger
4	2.609	0.013	0.00	0.035	0.022		Set Trigger
5	2.580	0.013	0.00	0.034	0.022		Set Trigger

A-2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.283	0.016	0.00	0.027	0.040		Set Trigger
2	4.301	0.015	0.00	0.025	0.043		Set Trigger
3	4.249	0.015	0.00	0.026	0.042		Set Trigger
4	4.285	0.015	0.00	0.026	0.040		Set Trigger
5	4.304	0.015	0.00	0.026	0.041		Set Trigger

A-4.28