

G6801353

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



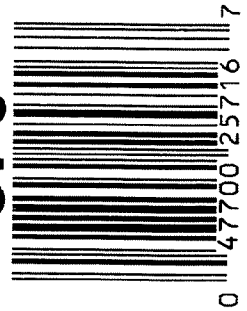
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801353

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801353

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	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	(15)	3/9/09	(15)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-21-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

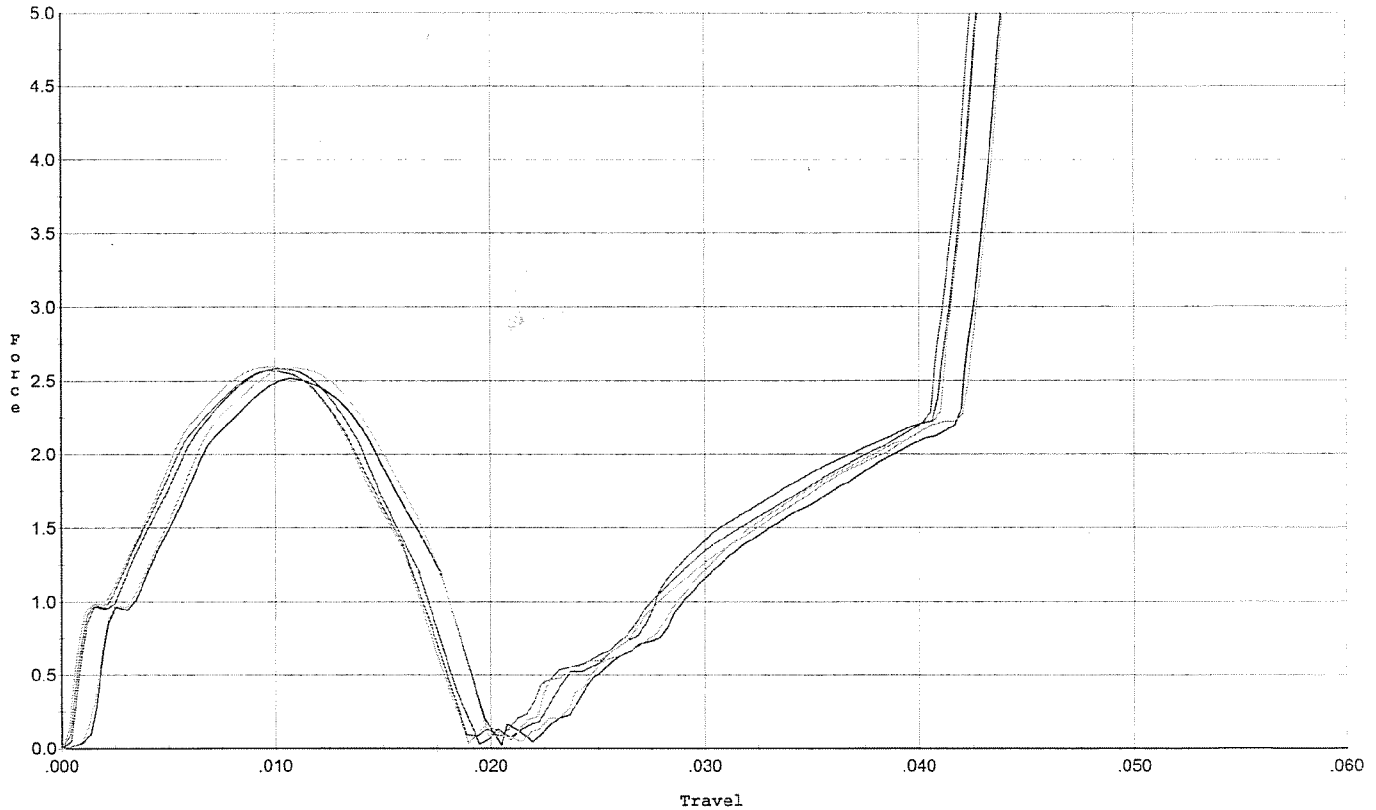
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.3</u> <u>2.3</u> <u>2.3</u>	3/23/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.1</u> <u>4.1</u> <u>4.0</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3/21/09	FTC
	K) ASSEMBLE SWIVEL STUDS		3/23/09	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	3-23-09	TL
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WV
670	FINAL INSPECTION A) HEADSPACE		3/23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.66</u> <u>2.67</u> <u>2.62</u> <u>2.56</u>	3-23-09	TL
	C) FUNCTION		3/23/09	RP
690	PACK		3/23/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



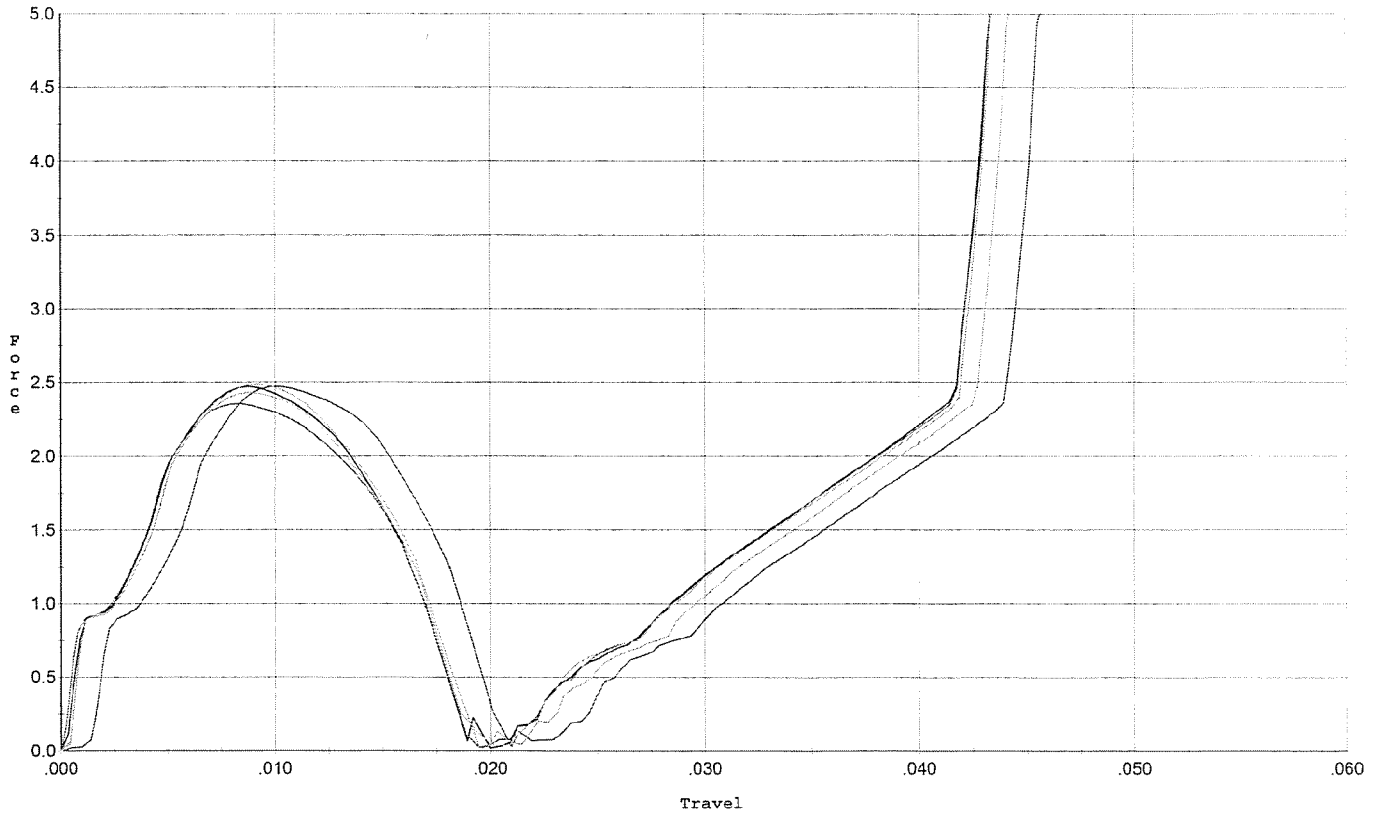
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.586	0.017	0.00	0.032	0.029		Set Trigger
2	2.518	0.018	0.00	0.032	0.028		Set Trigger
3	2.569	0.017	0.00	0.032	0.030		Set Trigger
4	2.590	0.018	0.00	0.032	0.030		Set Trigger
5	2.595	0.016	0.00	0.032	0.028		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



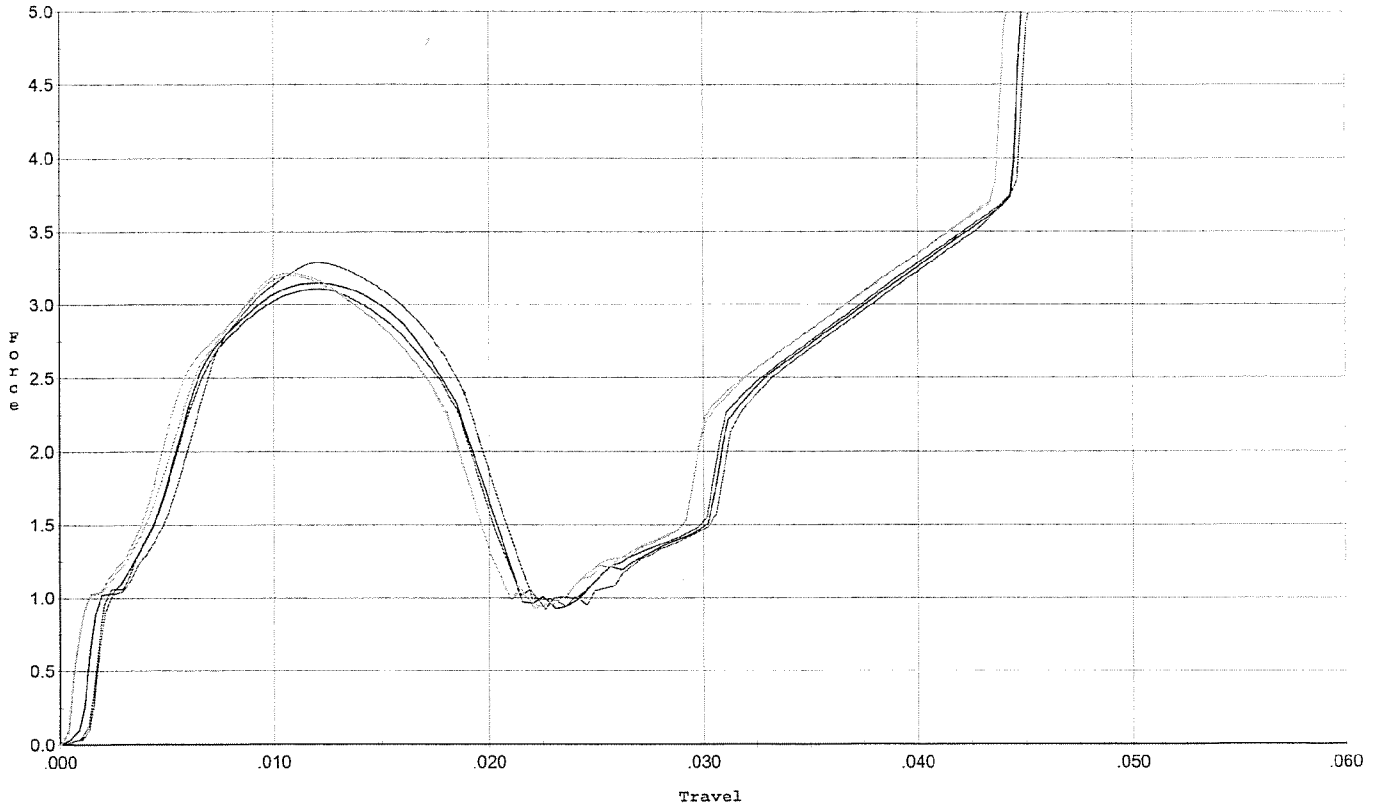
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.470	0.018	0.00	0.034	0.029		Set Trigger
2	2.471	0.017	0.00	0.032	0.029		Set Trigger
3	2.355	0.017	0.00	0.032	0.028		Set Trigger
4	2.432	0.017	0.00	0.032	0.028		Set Trigger
5	2.488	0.017	0.00	0.033	0.028		Set Trigger

A-2-44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



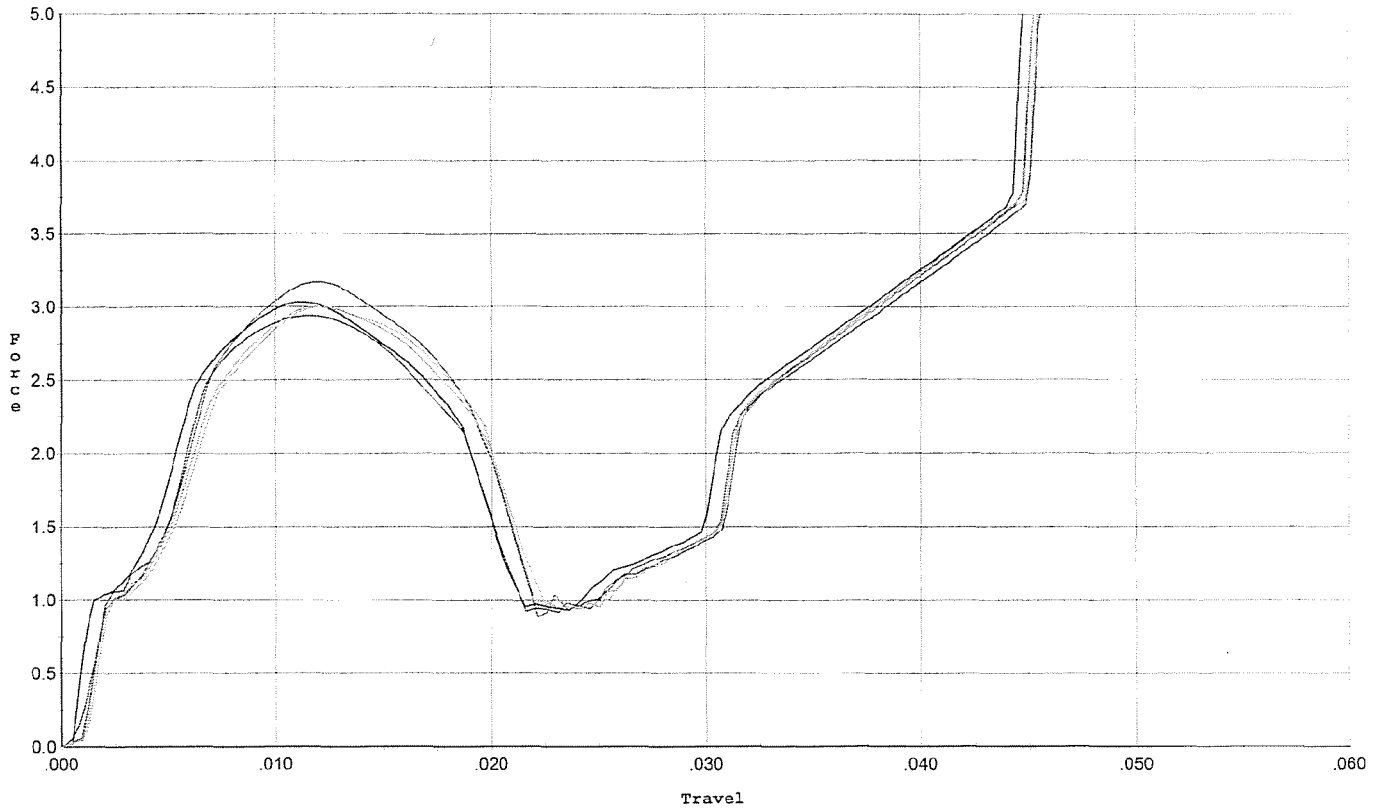
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.107	0.019	0.00	0.030	0.039		Set Trigger
2	3.149	0.020	0.00	0.030	0.043		Set Trigger
3	3.291	0.019	0.00	0.030	0.041		Set Trigger
4	3.218	0.018	0.00	0.030	0.040		Set Trigger
5	3.199	0.018	0.00	0.030	0.040		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



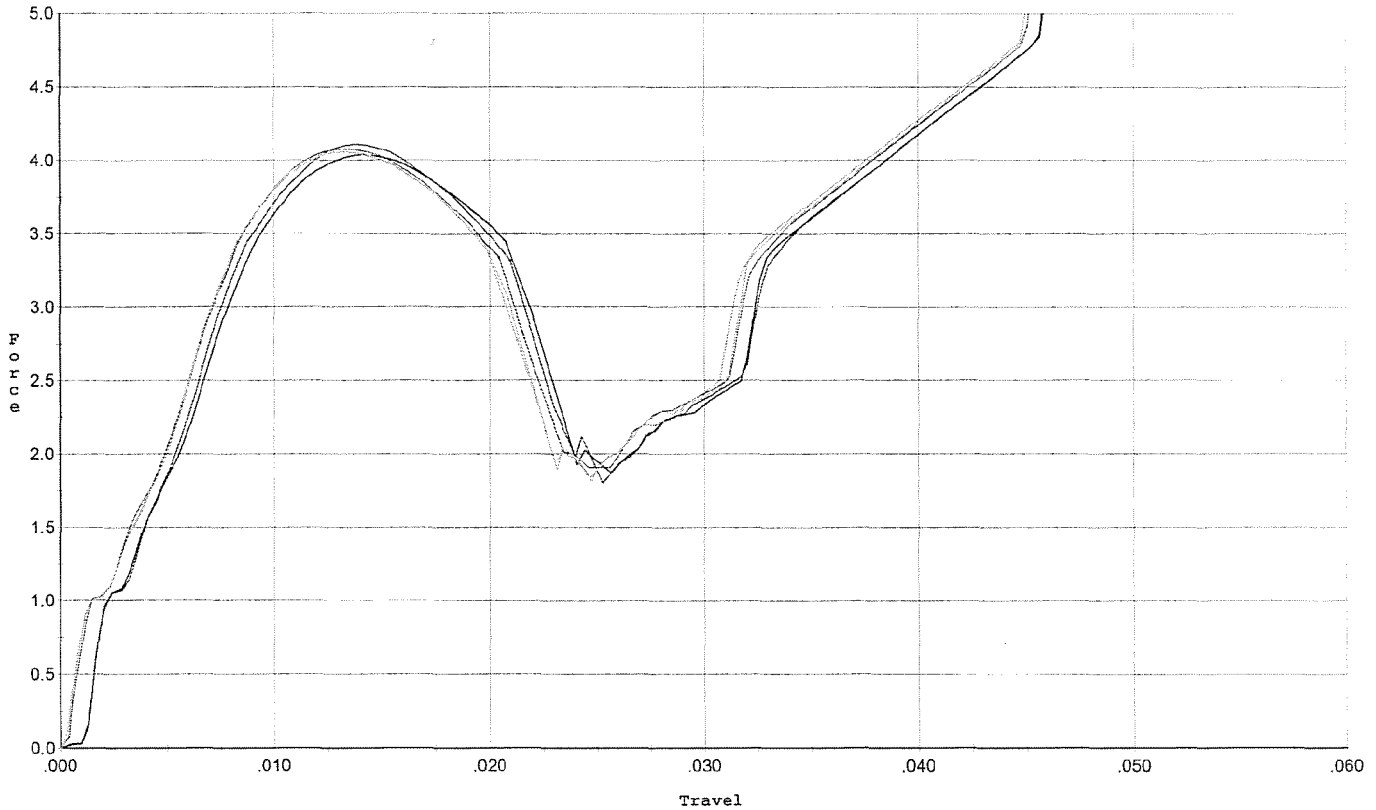
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.943	0.019	0.00	0.031	0.038		Set Trigger
2	3.030	0.019	0.00	0.030	0.039		Set Trigger
3	3.167	0.020	0.00	0.030	0.042		Set Trigger
4	3.001	0.020	0.00	0.030	0.040		Set Trigger
5	3.003	0.020	0.00	0.030	0.040		Set Trigger

A-3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



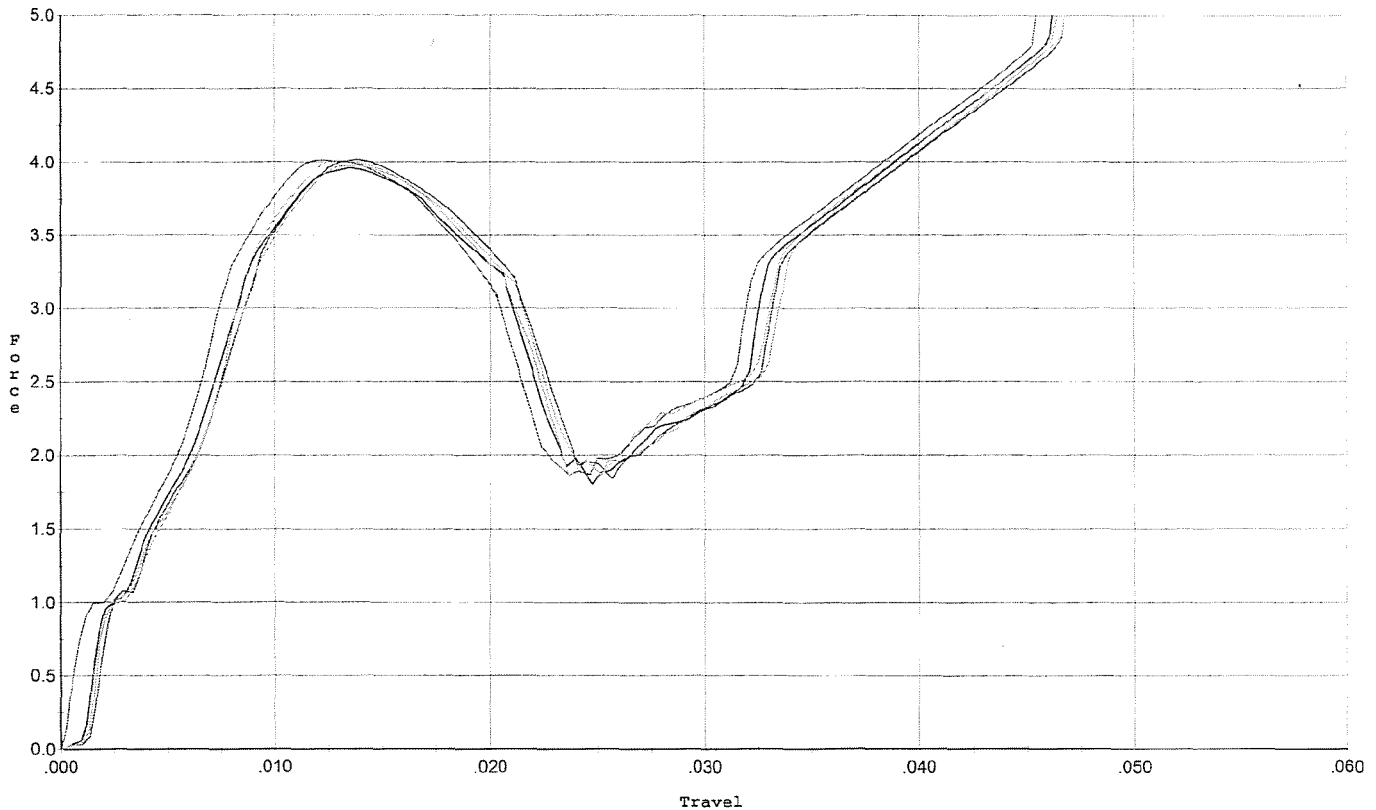
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.108	0.021	0.00	0.026	0.057		Set Trigger
2	4.036	0.022	0.00	0.026	0.059		Set Trigger
3	4.074	0.020	0.00	0.026	0.057		Set Trigger
4	4.061	0.021	0.00	0.026	0.058		Set Trigger
5	4.056	0.021	0.00	0.026	0.059		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



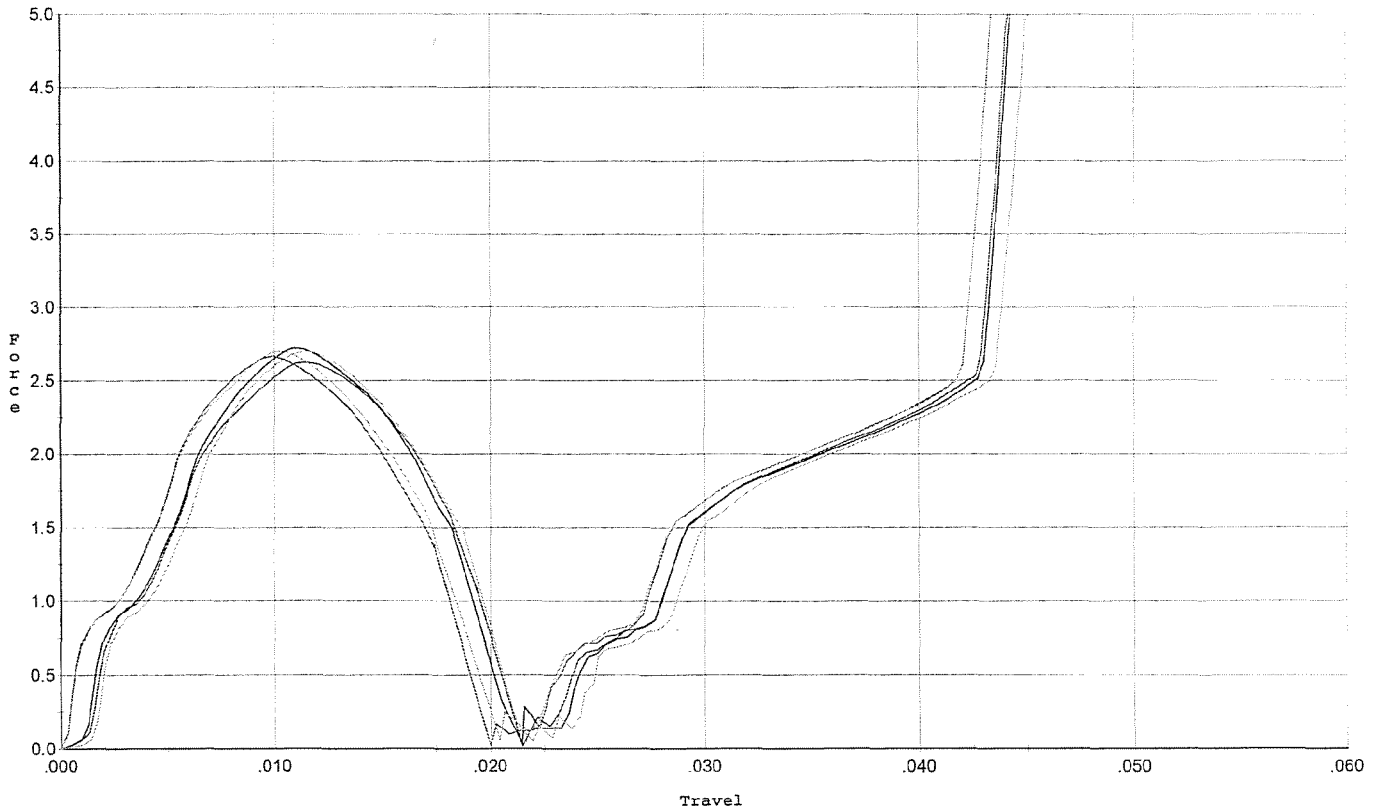
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.015	0.021	0.00	0.027	0.054		Set Trigger
2	3.960	0.021	0.00	0.027	0.053		Set Trigger
3	4.010	0.020	0.00	0.027	0.054		Set Trigger
4	4.013	0.022	0.00	0.027	0.056		Set Trigger
5	3.974	0.021	0.00	0.027	0.054		Set Trigger

A-3.99

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



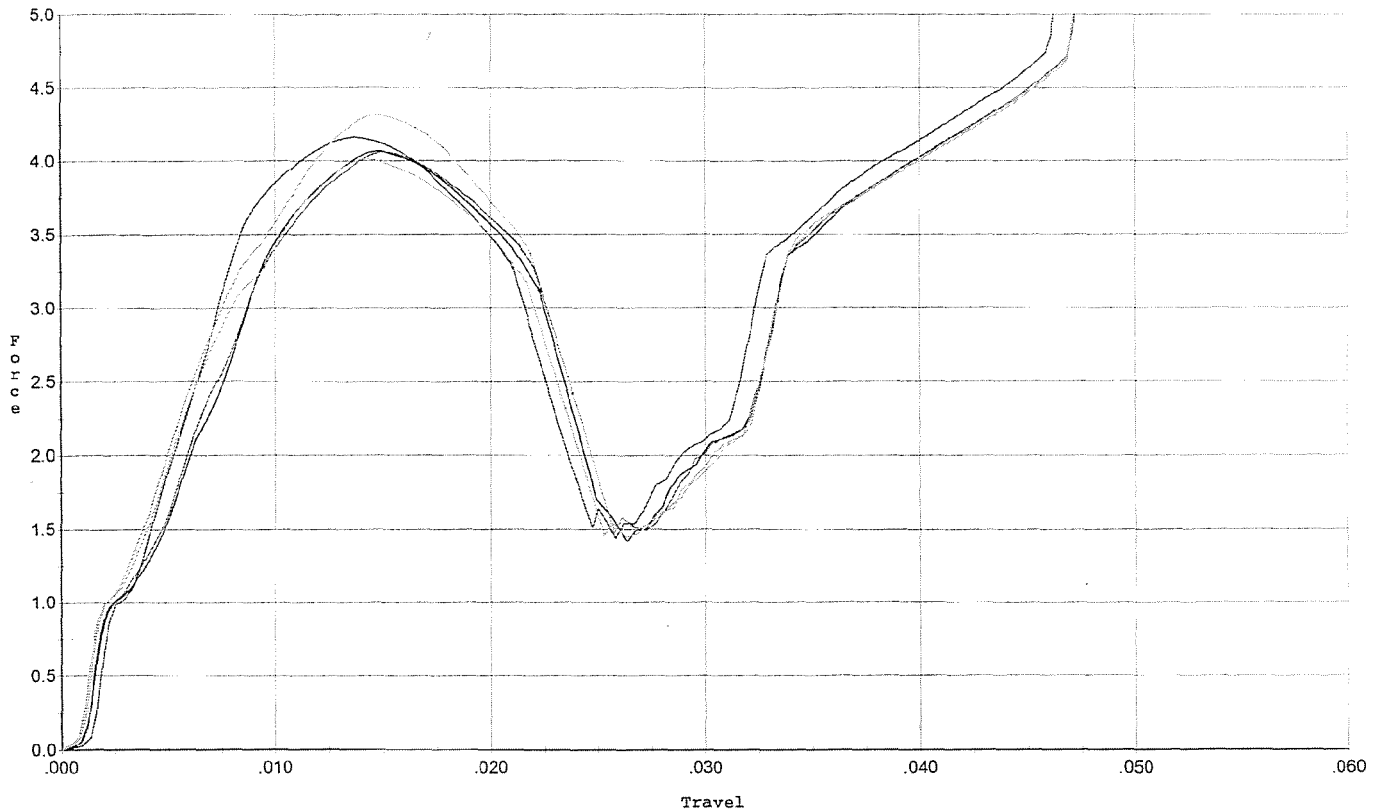
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.623	0.019	0.00	0.030	0.033		Set Trigger
2	2.720	0.018	0.00	0.031	0.032		Set Trigger
3	2.667	0.017	0.00	0.031	0.031		Set Trigger
4	2.701	0.019	0.00	0.031	0.032		Set Trigger
5	2.701	0.019	0.00	0.031	0.033		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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	4.164	0.021	0.00	0.027	0.057		Set Trigger
2	4.069	0.022	0.00	0.028	0.059		Set Trigger
3	4.060	0.024	0.00	0.027	0.063		Set Trigger
4	4.012	0.023	0.00	0.028	0.063		Set Trigger
5	4.315	0.022	0.00	0.028	0.062		Set Trigger

A-4.12