

G6801435

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

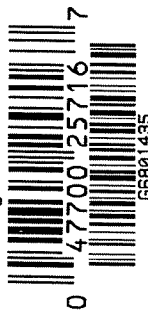
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



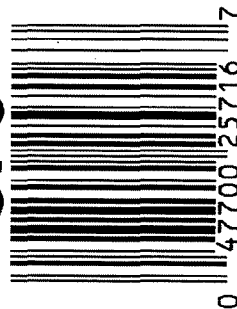
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801435

UPC



24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801435

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION	MAGNA - FLUX MAR 23 2009 OPERATOR 10	3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RTC
475	DRILL AND TAP SIGHT HOLES		3-23-09	JP
480	MAGNAFLUX BBL ACTION		3-25-09	RP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-25-09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-29	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	LD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

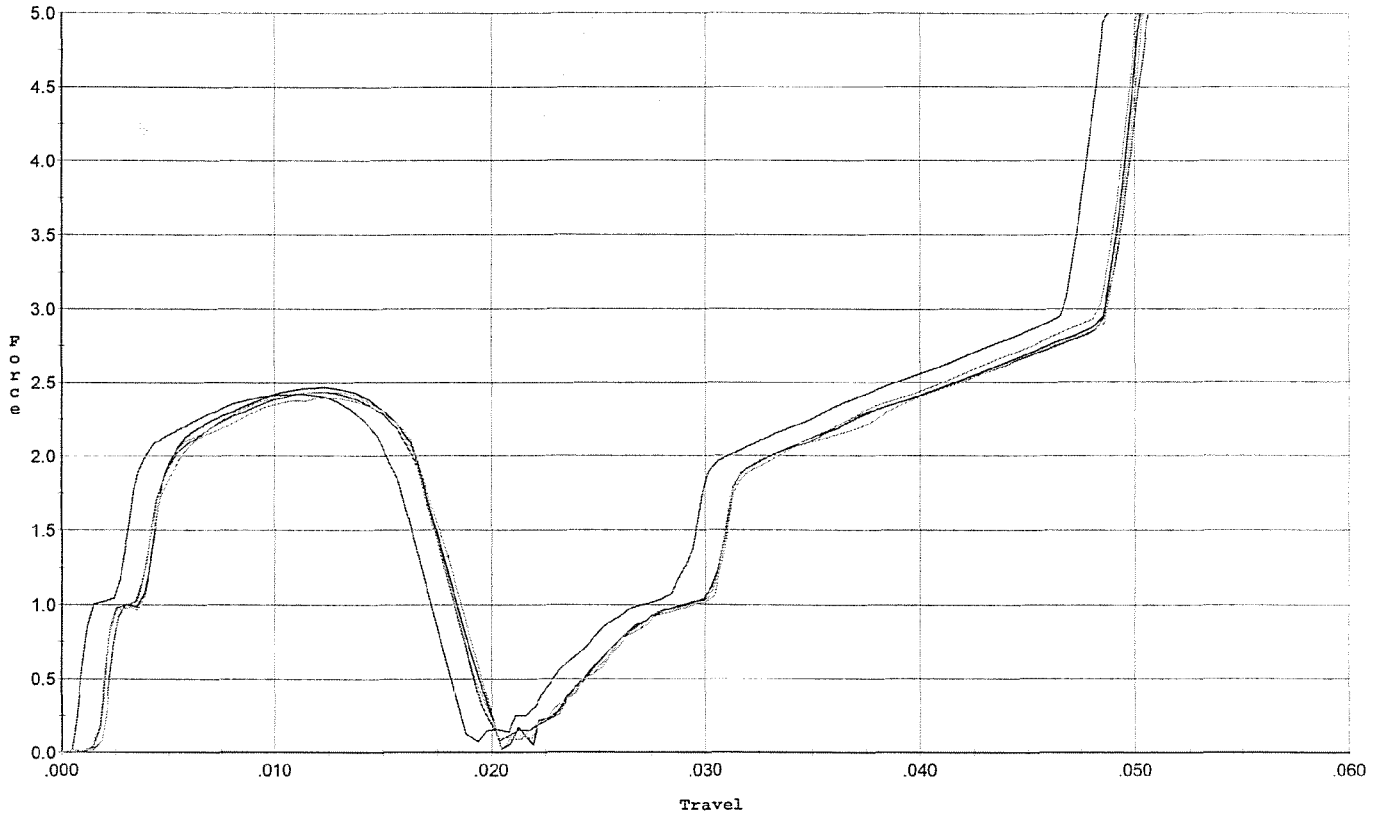
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.8</u> <u>2.8</u> <u>2.8</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.6</u> <u>4.8</u> <u>4.8</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-2-09	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	4-9-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TQR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.92</u> <u>2.95</u> <u>2.88</u> <u>2.89</u> <u>2.83</u>	4-14-09	RP
	C) FUNCTION		4-12-09	RP
690	PACK		5/29/09	RP

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



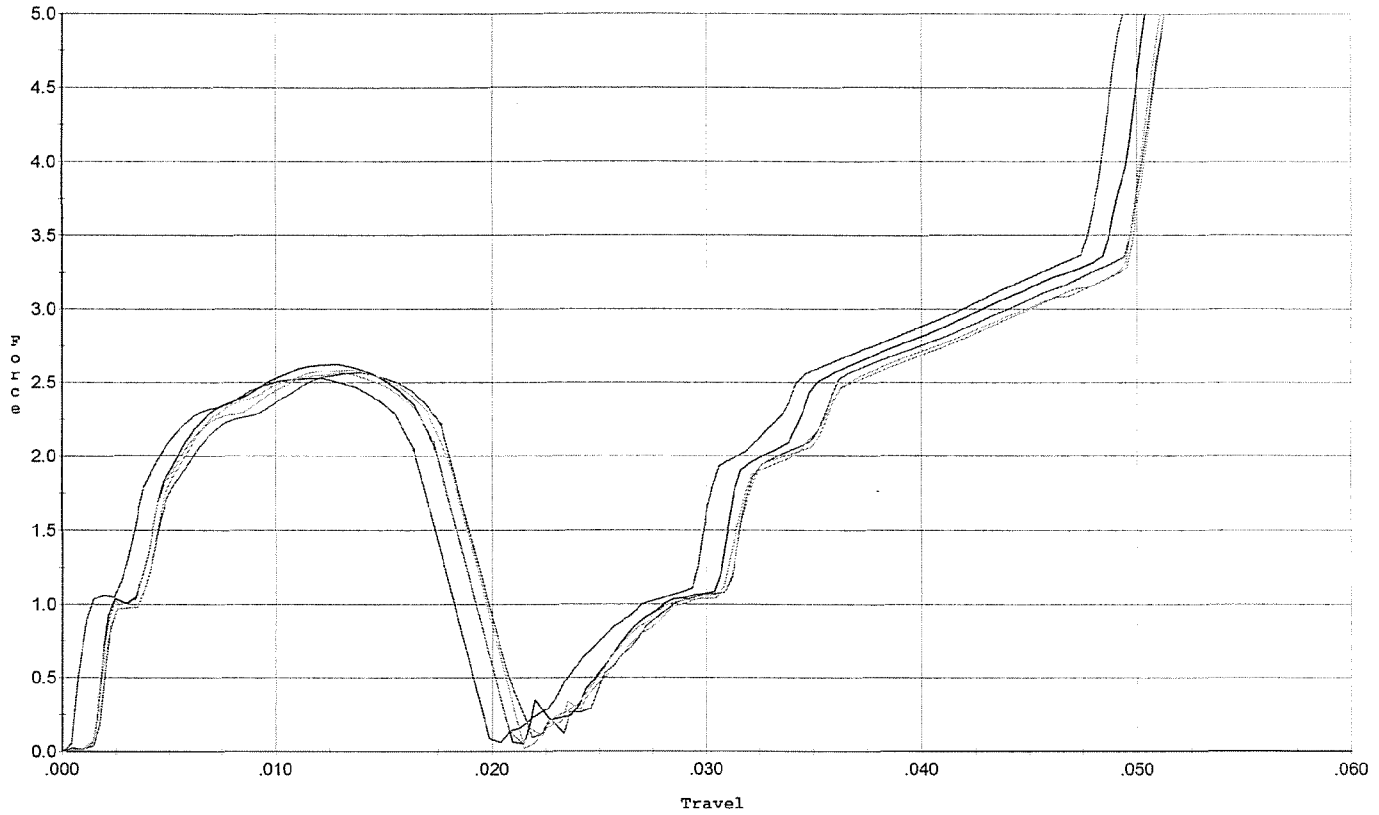
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.016	0.00	0.036	0.029		Set Trigger
2	2.467	0.016	0.00	0.037	0.028		Set Trigger
3	2.434	0.017	0.00	0.038	0.028		Set Trigger
4	2.400	0.016	0.00	0.038	0.028		Set Trigger
5	2.435	0.018	0.002	0.037	0.031		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



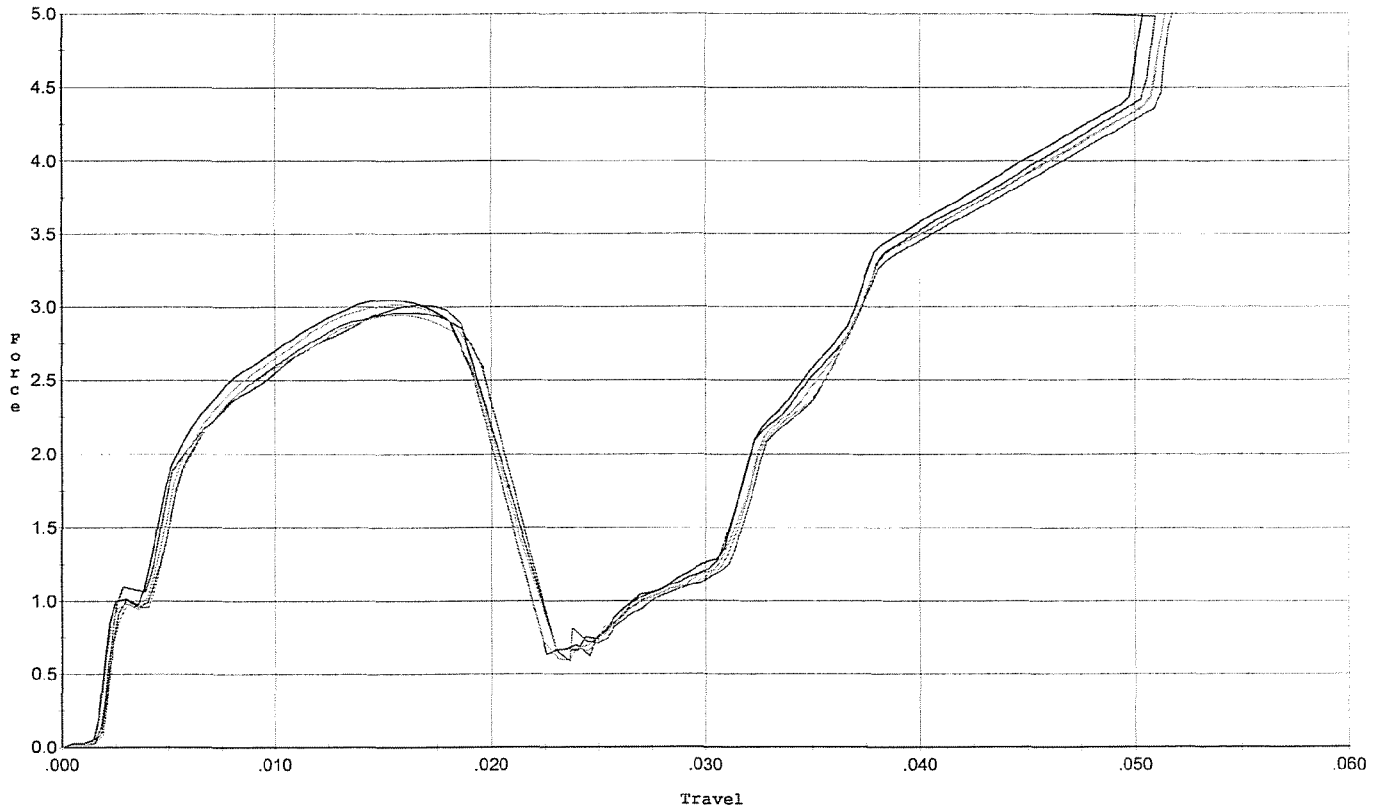
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.529	0.016	0.00	0.036	0.031		Set Trigger
2	2.620	0.017	0.00	0.036	0.032		Set Trigger
3	2.565	0.018	0.004	0.036	0.031		Set Trigger
4	2.585	0.018	0.00	0.036	0.033		Set Trigger
5	2.567	0.017	0.00	0.037	0.031		Set Trigger

A-257

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



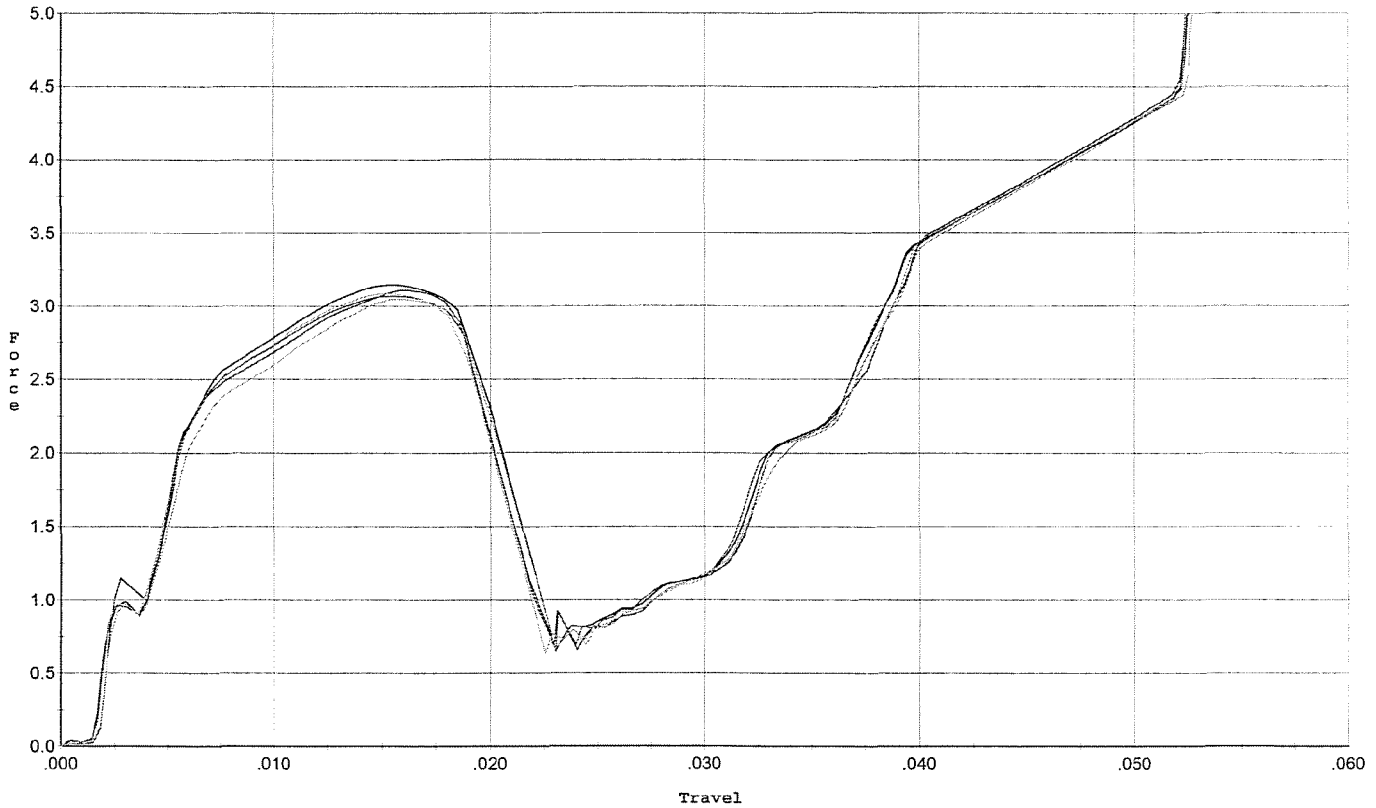
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.012	0.021	0.004	0.034	0.042		Set Trigger
2	3.049	0.019	0.00	0.034	0.040		Set Trigger
3	2.961	0.020	0.002	0.035	0.039		Set Trigger
4	3.015	0.019	0.00	0.035	0.038		Set Trigger
5	2.945	0.019	0.002	0.035	0.038		Set Trigger

14-2-99

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



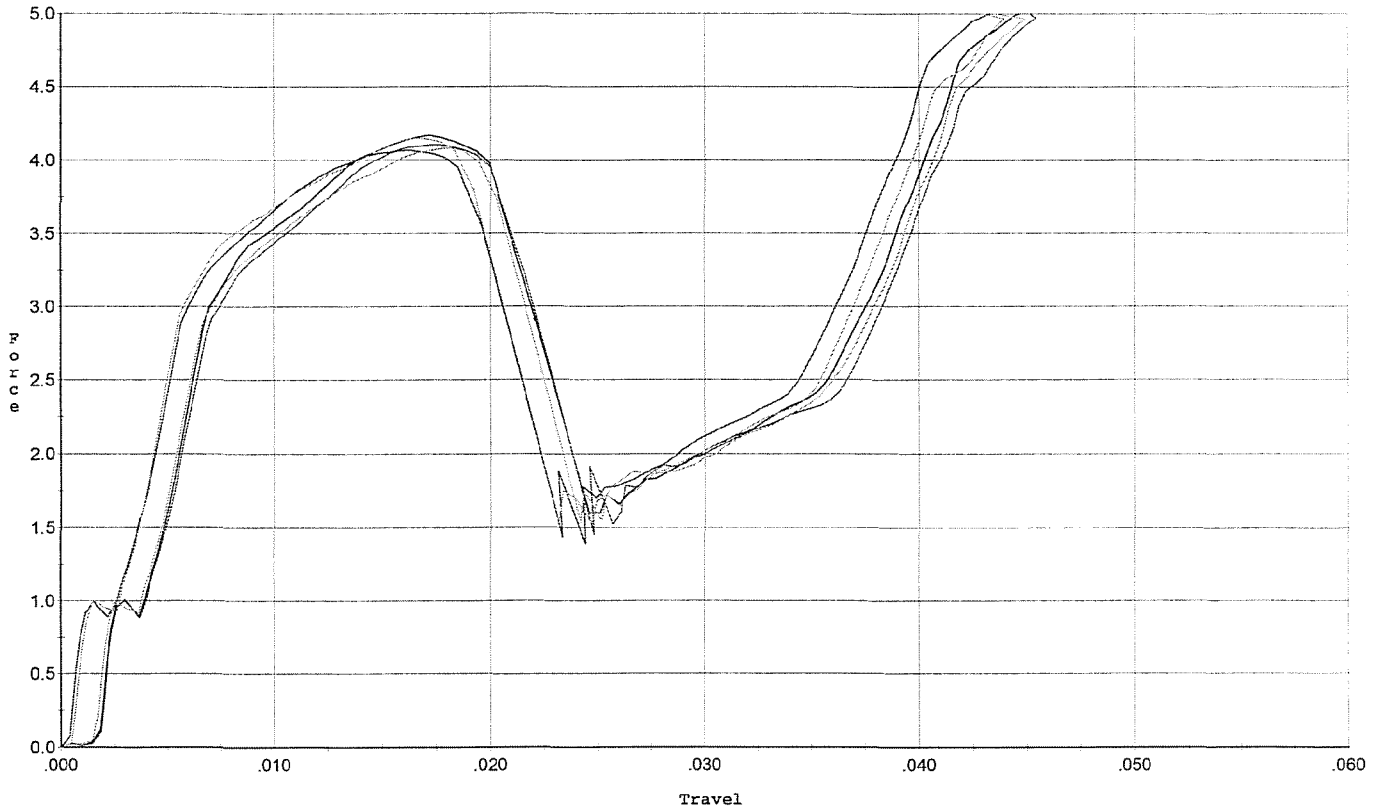
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.108	0.019	0.004	0.036	0.039		Set Trigger
2	3.145	0.020	0.00	0.035	0.042		Set Trigger
3	3.068	0.019	0.004	0.036	0.039		Set Trigger
4	3.087	0.019	0.004	0.036	0.040		Set Trigger
5	3.047	0.020	0.002	0.036	0.041		Set Trigger

A-3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



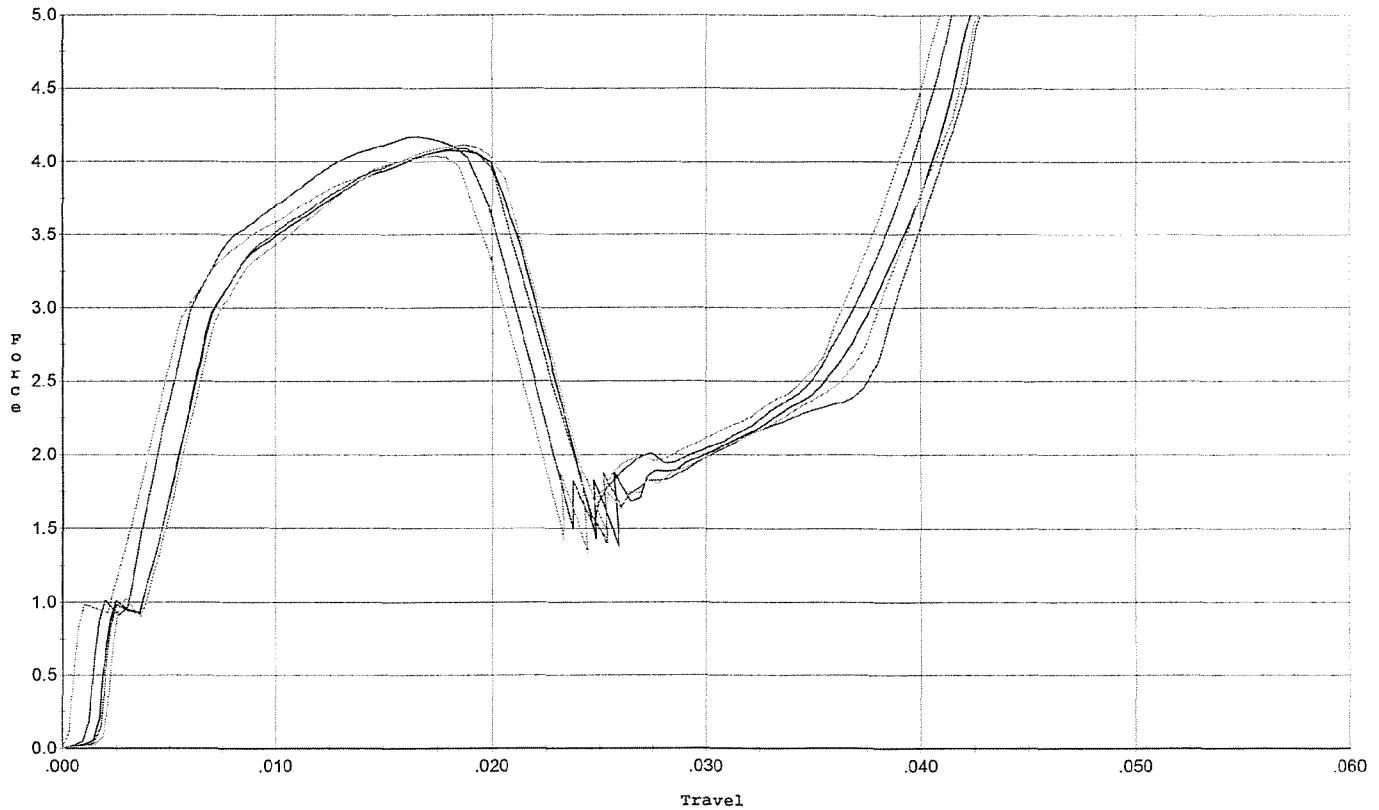
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.067	0.020	0.00	0.033	0.055		Set Trigger
2	4.169	0.022	0.00	0.033	0.060		Set Trigger
3	4.101	0.022	0.00	0.033	0.058		Set Trigger
4	4.079	0.020	0.004	0.033	0.055		Set Trigger
5	4.150	0.019	0.003	0.033	0.055		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



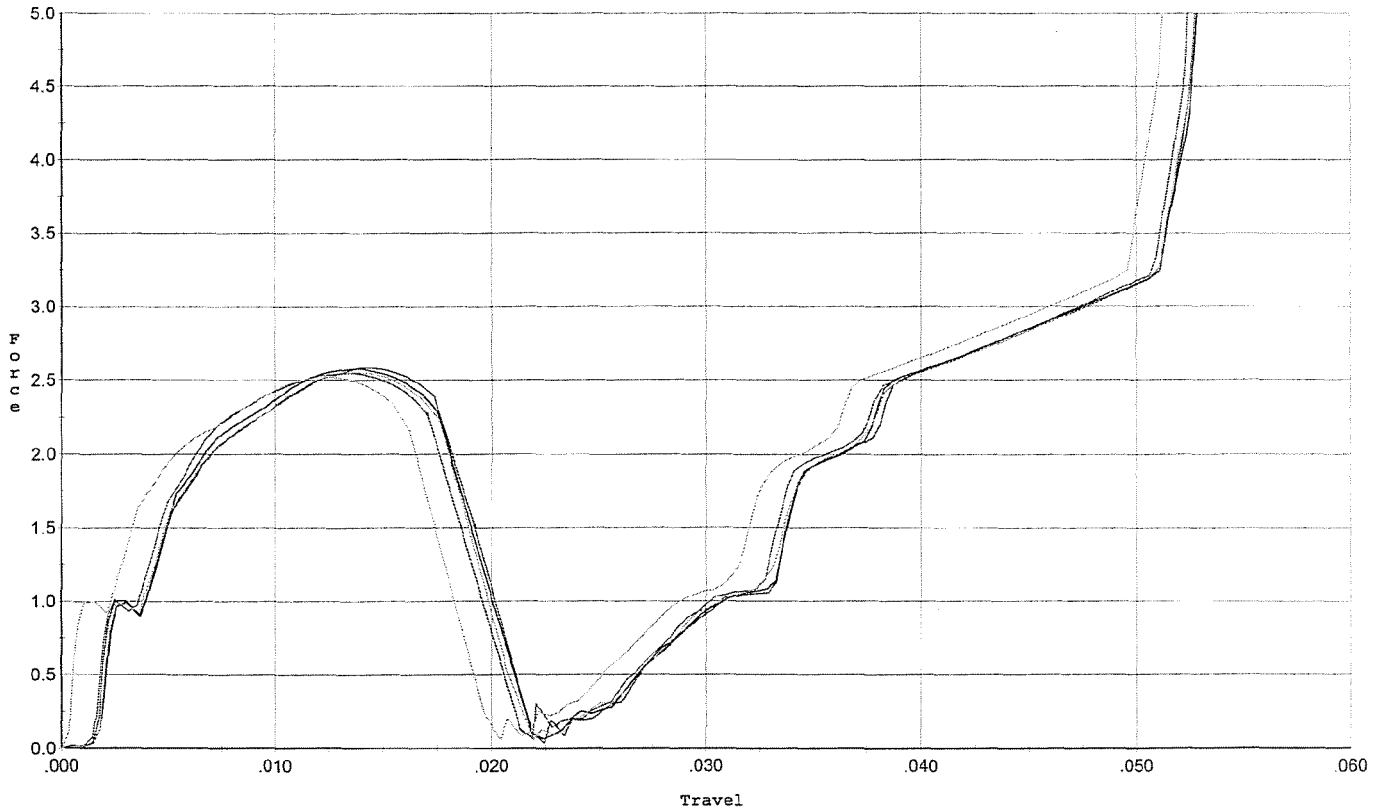
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.020	0.00	0.027	0.056		Set Trigger
2	4.072	0.021	0.004	0.030	0.057		Set Trigger
3	4.091	0.020	0.004	0.031	0.054		Set Trigger
4	4.113	0.021	0.00	0.030	0.055		Set Trigger
5	4.037	0.020	0.002	0.030	0.056		Set Trigger

A-4.09

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



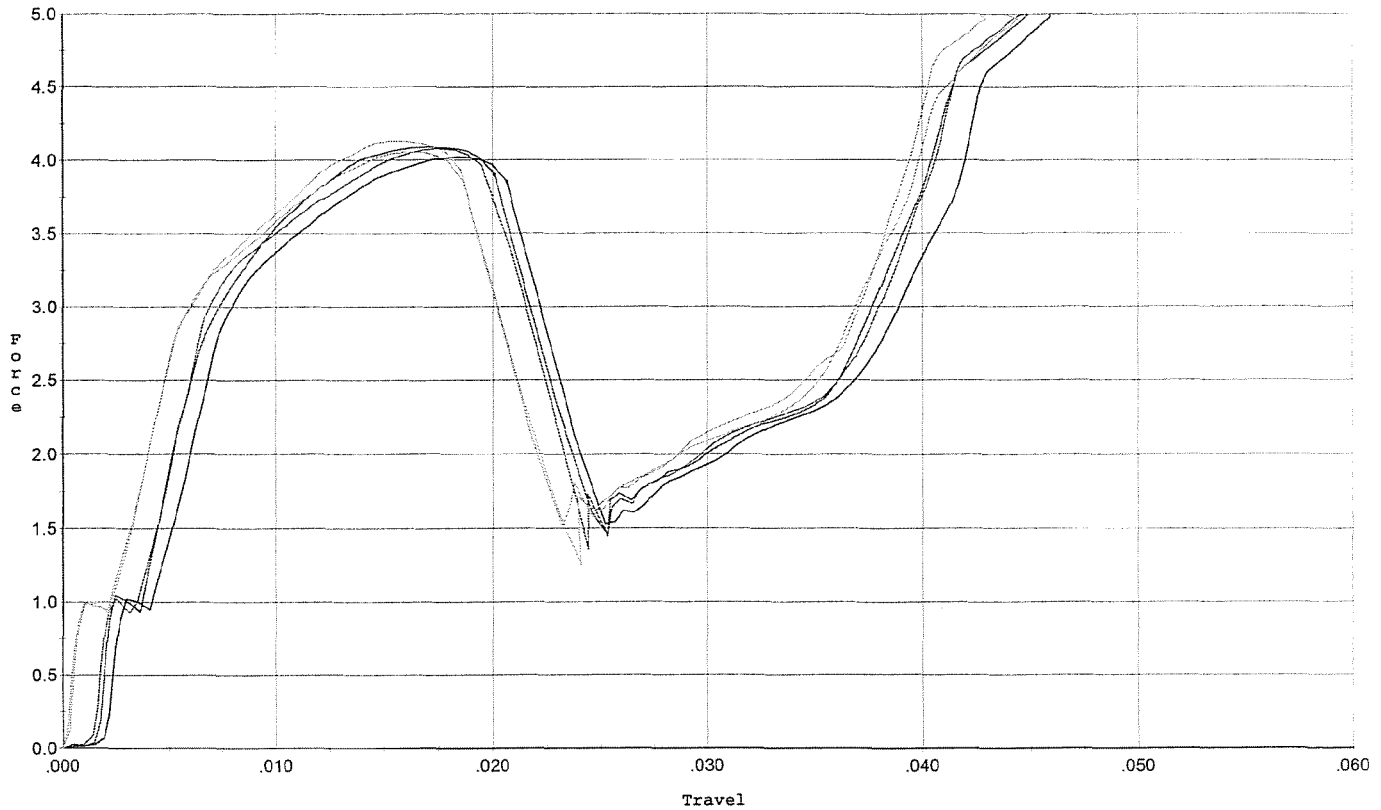
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.585	0.019	0.004	0.038	0.034		Set Trigger
2	2.574	0.018	0.00	0.038	0.031		Set Trigger
3	2.547	0.017	0.00	0.038	0.030		Set Trigger
4	2.526	0.016	0.00	0.038	0.030		Set Trigger
5	2.552	0.018	0.004	0.038	0.031		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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	4.086	0.020	0.004	0.033	0.055		Set Trigger
2	4.021	0.021	0.004	0.034	0.054		Set Trigger
3	4.073	0.021	0.00	0.034	0.057		Set Trigger
4	4.132	0.019	0.002	0.034	0.053		Set Trigger
5	4.054	0.019	0.002	0.033	0.052		Set Trigger

A-4.07