

G 680 1472

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



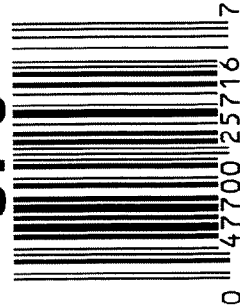
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801472

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801472

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RR
430	ASSEMBLE TO STOCK		3-6-09	RR
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RR
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-9-09	RR
475	DRILL AND TAP SIGHT HOLES		3-9-09	JP
480	MAGNAFLUX BBL ACTION	OPERATOR (JP)	3/13/09	JP
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-26-09	JP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

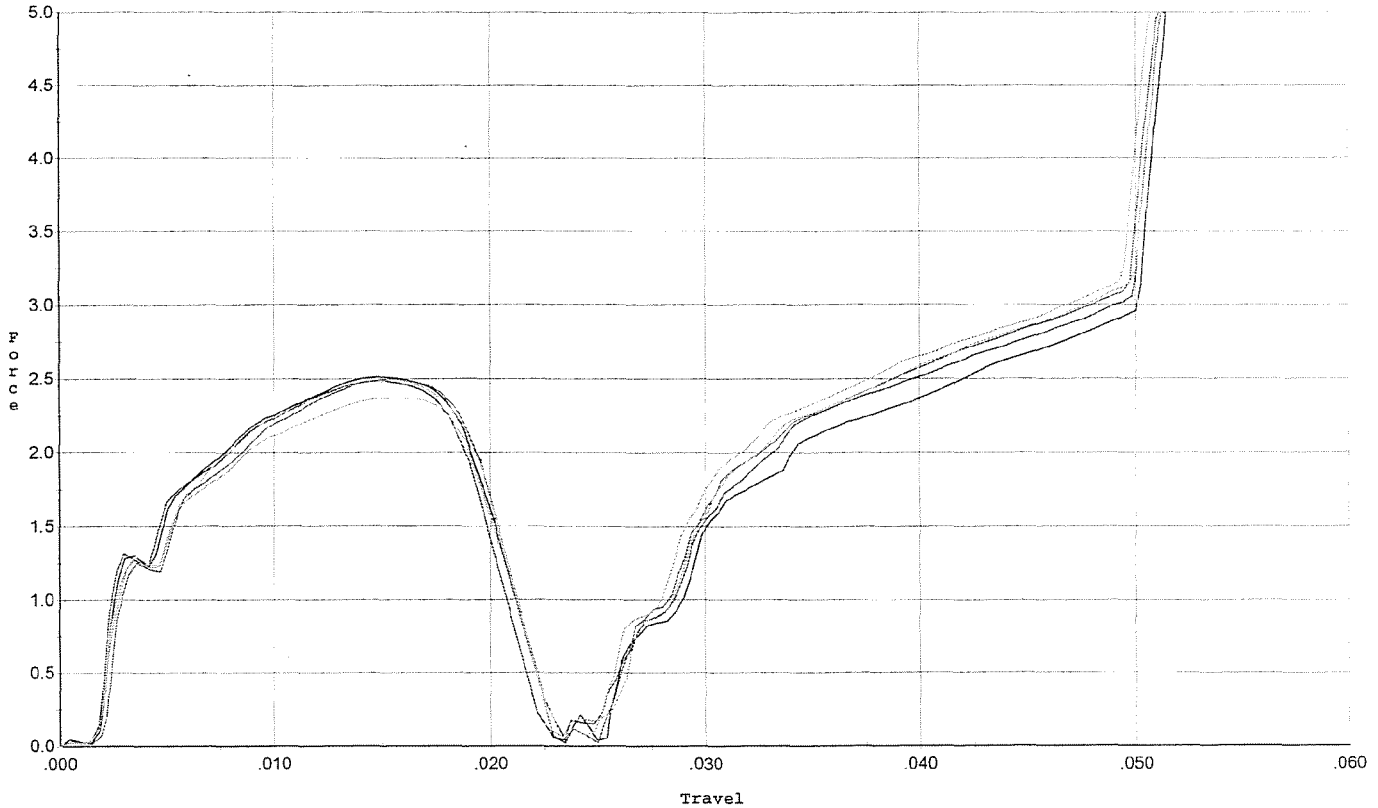
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	3-30-09	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>50</u>	3-30-09	R N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-30-09	L N
	J) ASSEMBLE STOCK		3-26-09	L N
	K) ASSEMBLE SWIVEL STUDS		3-30-09	L N
	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	3-27-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	W N
670	FINAL INSPECTION A) HEADSPACE		3-30-09	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.51</u> <u>2.46</u> <u>2.53</u> <u>2.42</u>	3-28-09	TL
	C) FUNCTION		3-30-09	L N
690	PACK		3/31/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



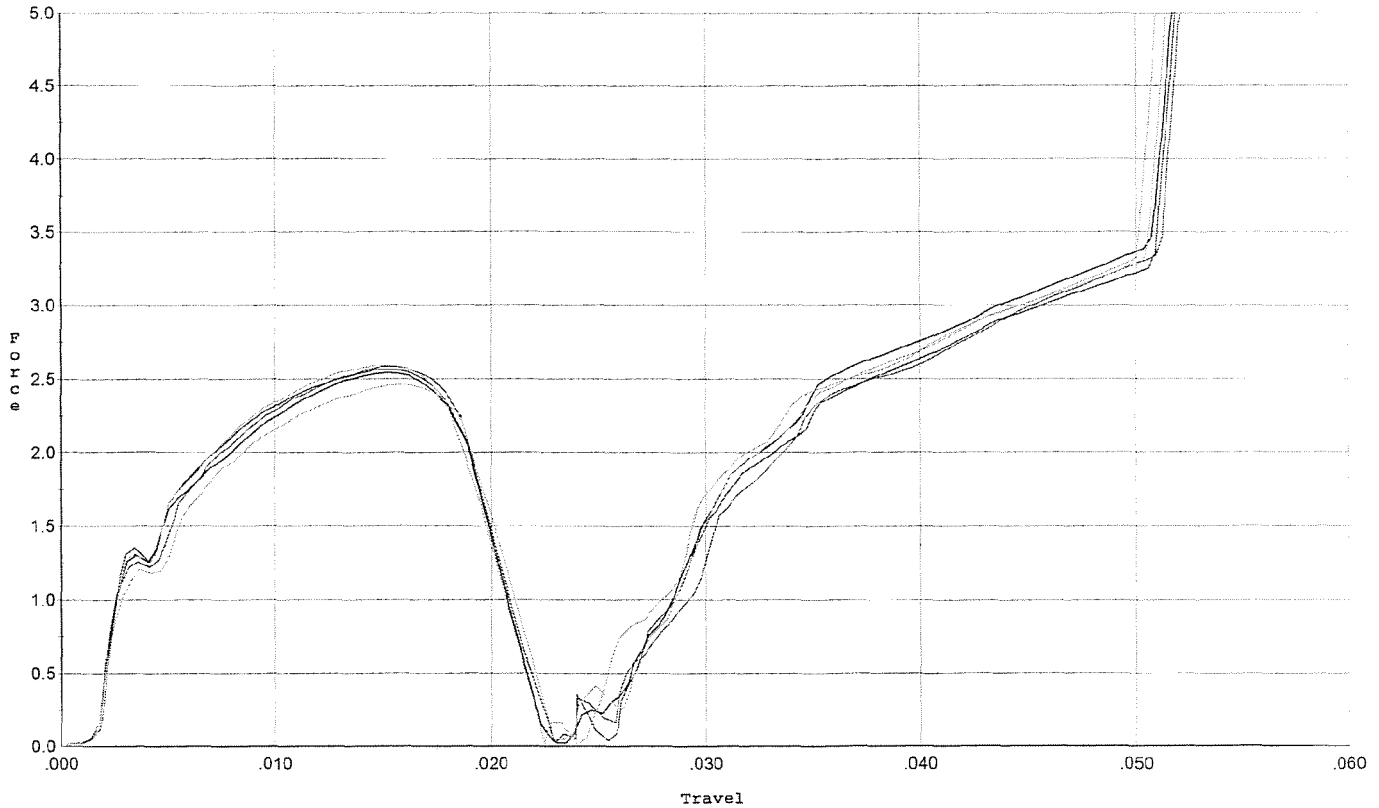
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.482	0.019	0.004	0.036	0.033		Set Trigger
2	2.512	0.020	0.002	0.036	0.035		Set Trigger
3	2.499	0.020	0.002	0.035	0.033		Set Trigger
4	2.370	0.020	0.005	0.035	0.034		Set Trigger
5	2.490	0.020	0.00	0.035	0.034		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



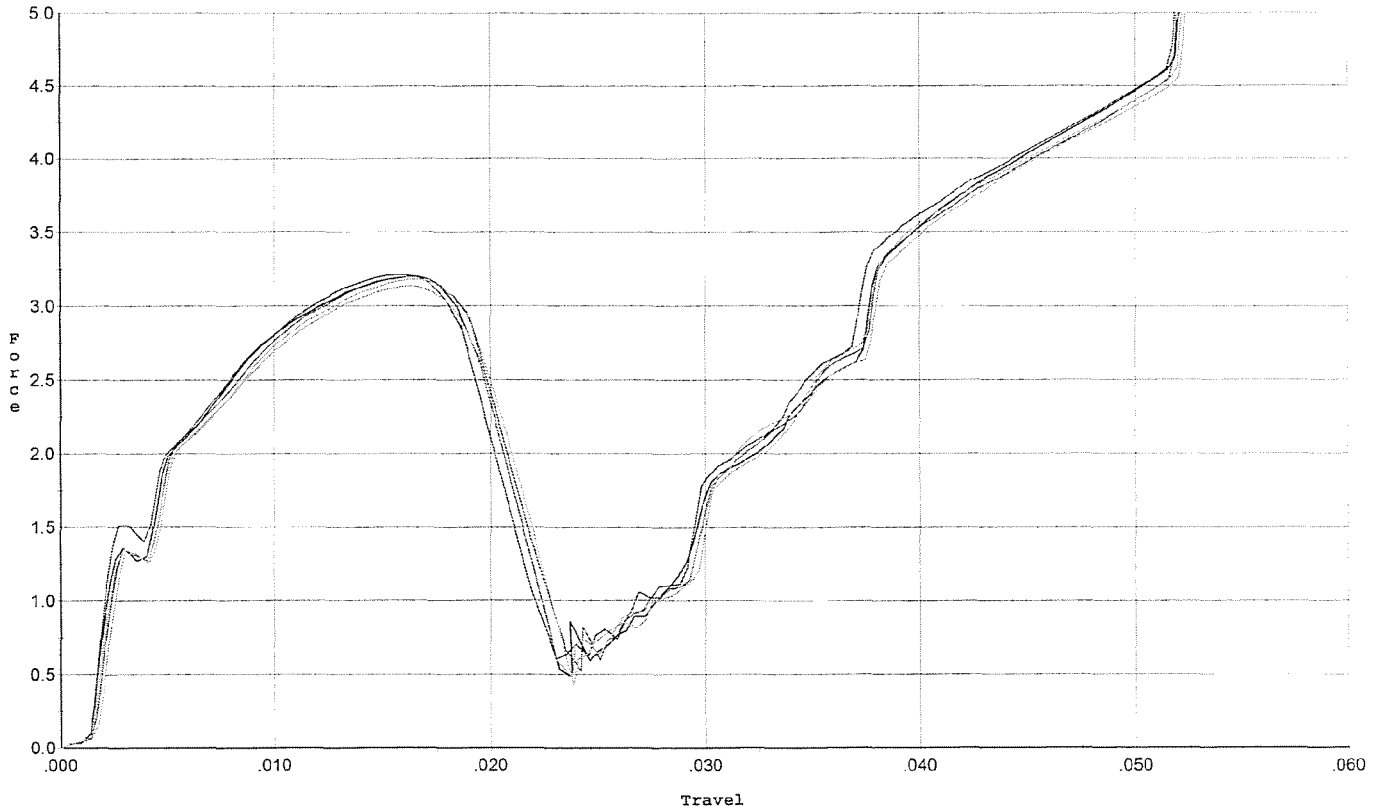
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.019	0.00	0.036	0.034		Set Trigger
2	2.541	0.019	0.00	0.036	0.033		Set Trigger
3	2.585	0.019	0.00	0.036	0.033		Set Trigger
4	2.463	0.020	0.00	0.035	0.034		Set Trigger
5	2.591	0.019	0.00	0.035	0.035		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



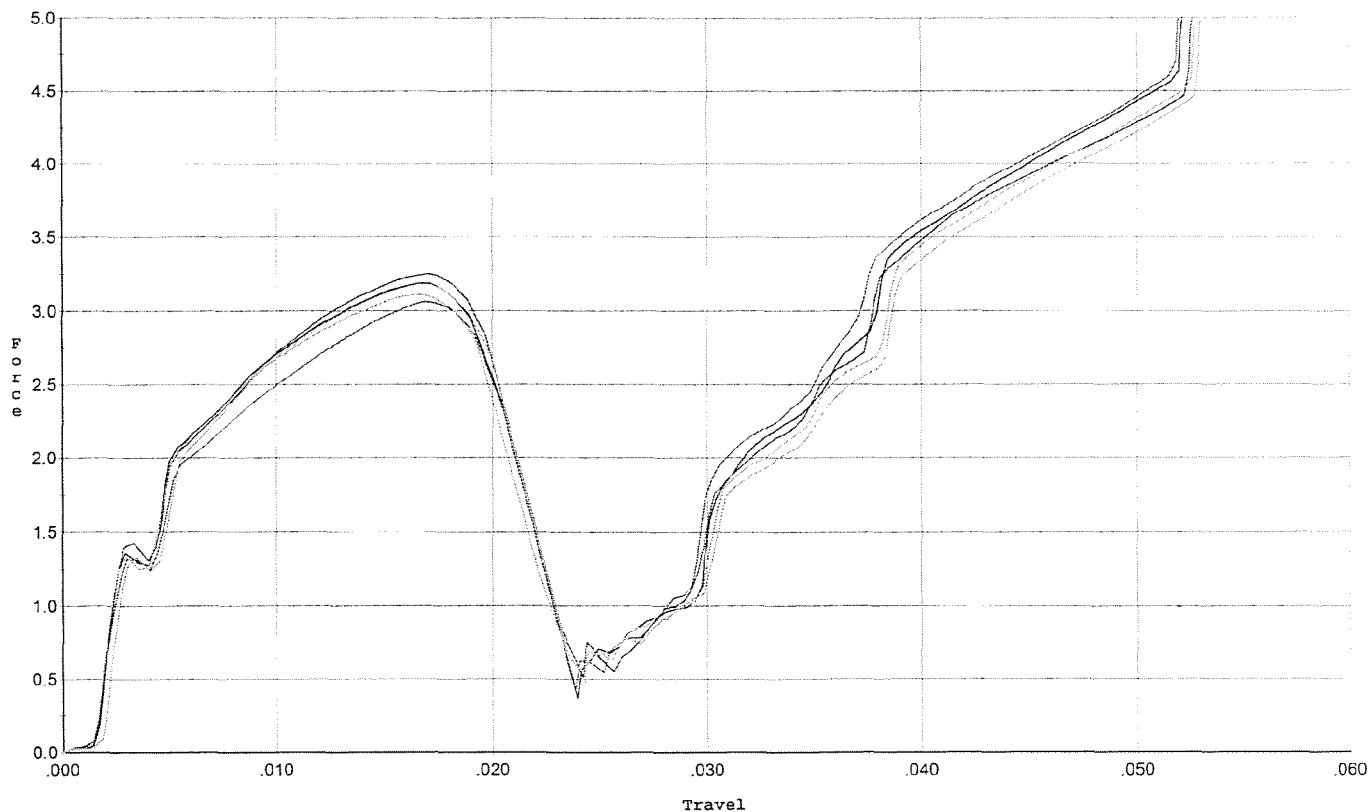
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.019	0.004	0.035	0.041		Set Trigger
2	3.199	0.020	0.00	0.035	0.043		Set Trigger
3	3.196	0.019	0.004	0.035	0.041		Set Trigger
4	3.179	0.021	0.00	0.034	0.044		Set Trigger
5	3.134	0.019	0.004	0.035	0.041		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



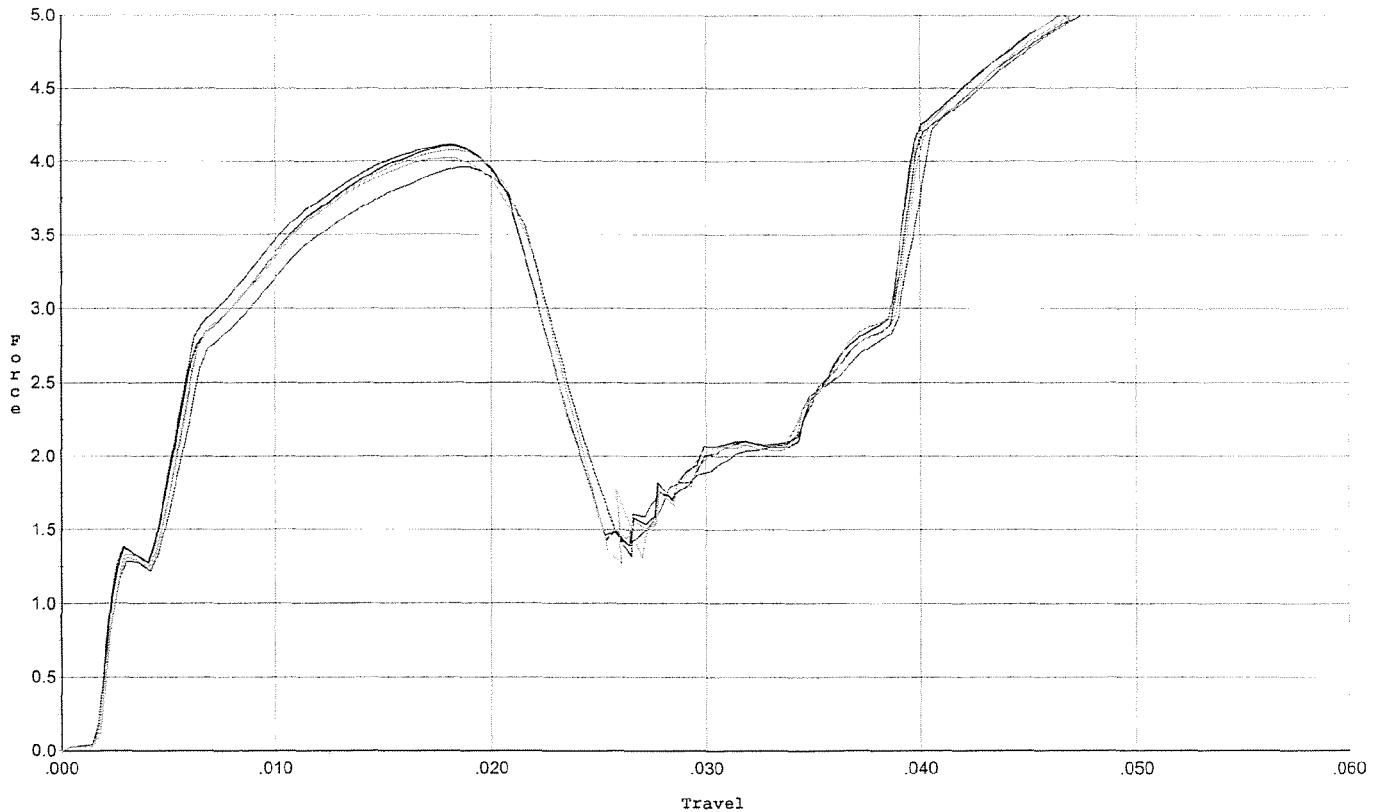
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.249	0.020	0.00	0.035	0.043		Set Trigger
2	3.187	0.020	0.004	0.034	0.044		Set Trigger
3	3.061	0.020	0.004	0.034	0.042		Set Trigger
4	3.111	0.019	0.00	0.035	0.041		Set Trigger
5	3.183	0.020	0.00	0.035	0.042		Set Trigger

A-3.15

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



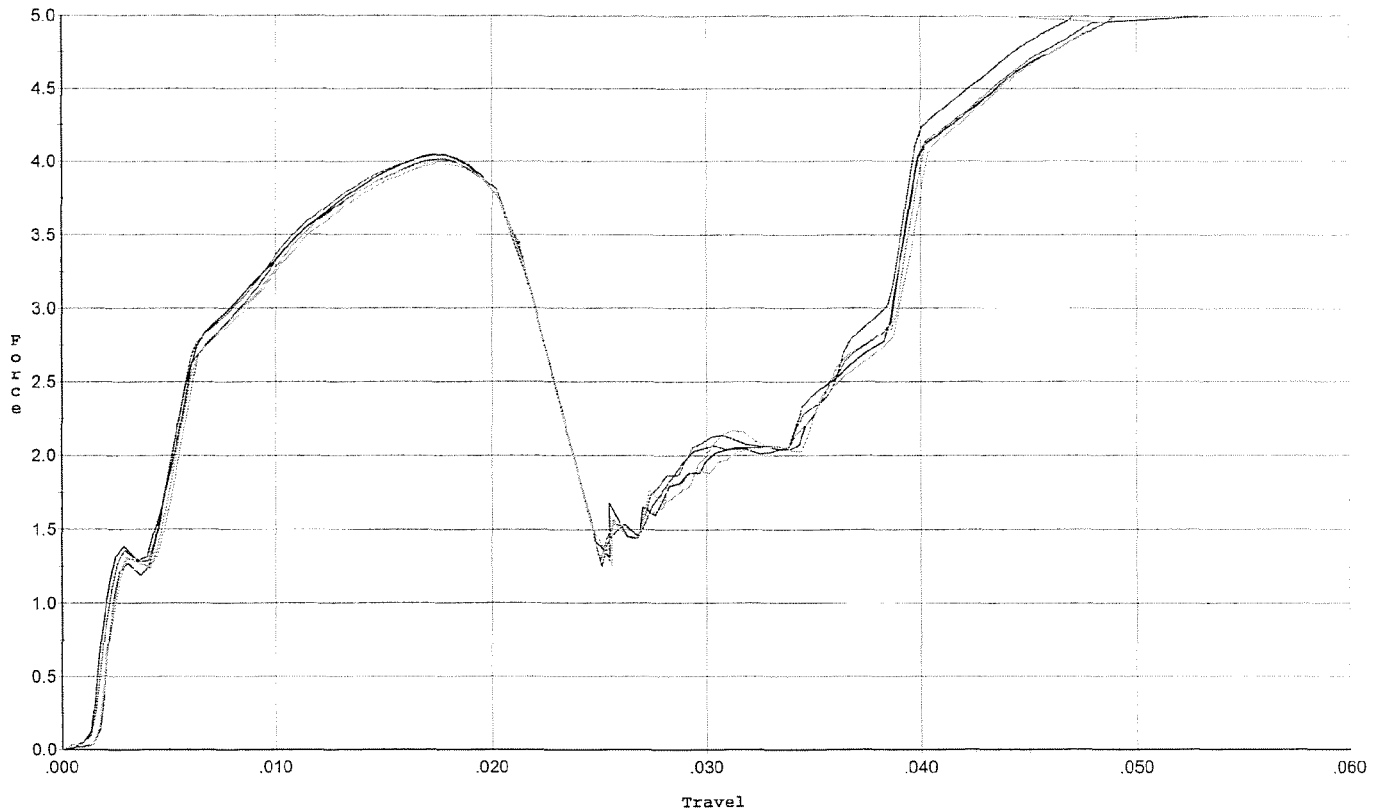
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.115	0.021	0.004	0.033	0.057		Set Trigger
2	4.107	0.021	0.004	0.033	0.056		Set Trigger
3	3.958	0.022	0.004	0.033	0.057		Set Trigger
4	4.073	0.022	0.002	0.033	0.059		Set Trigger
5	4.020	0.021	0.002	0.033	0.056		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



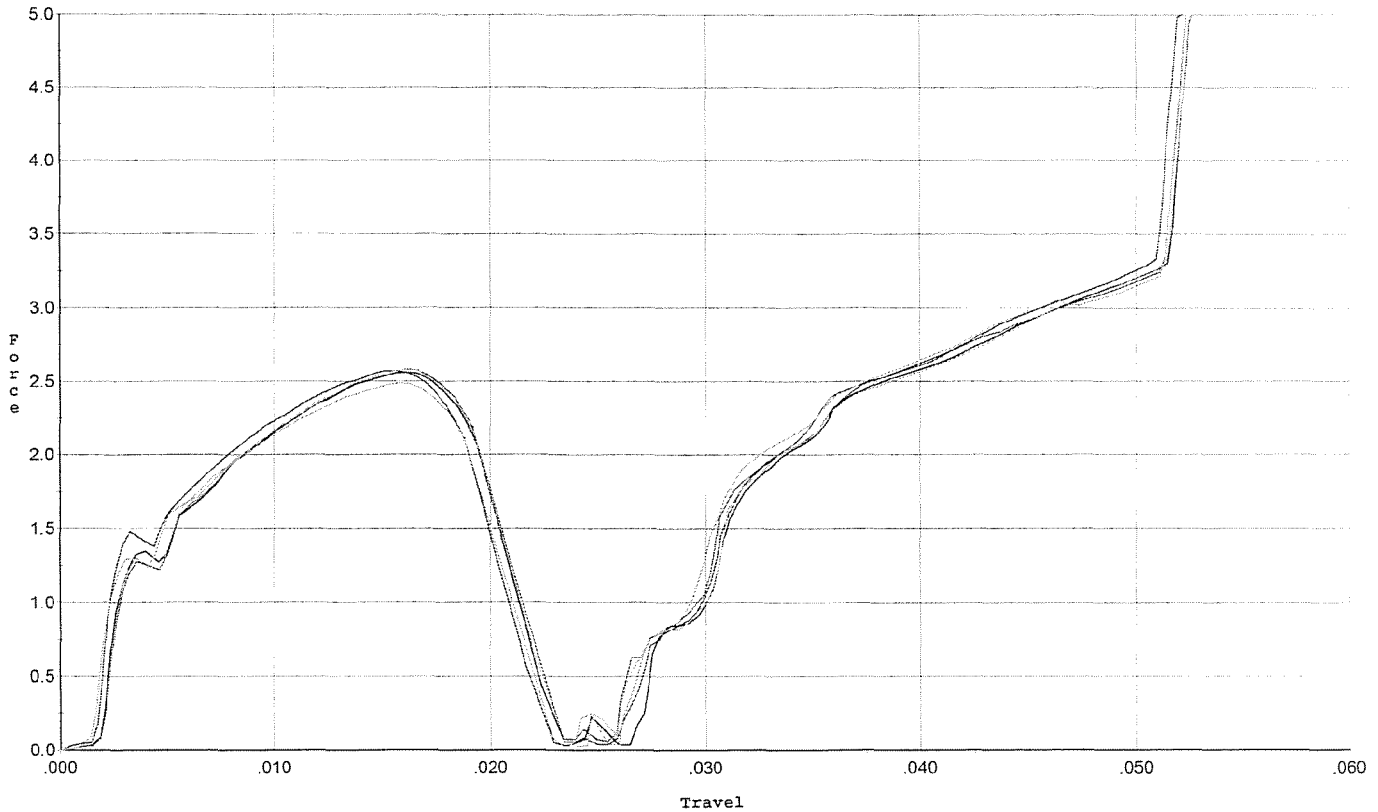
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.011	0.021	0.00	0.033	0.057		Set Trigger
2	4.047	0.021	0.00	0.033	0.057		Set Trigger
3	4.042	0.022	0.004	0.033	0.058		Set Trigger
4	3.980	0.022	0.002	0.034	0.057		Set Trigger
5	3.995	0.021	0.002	0.034	0.056		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



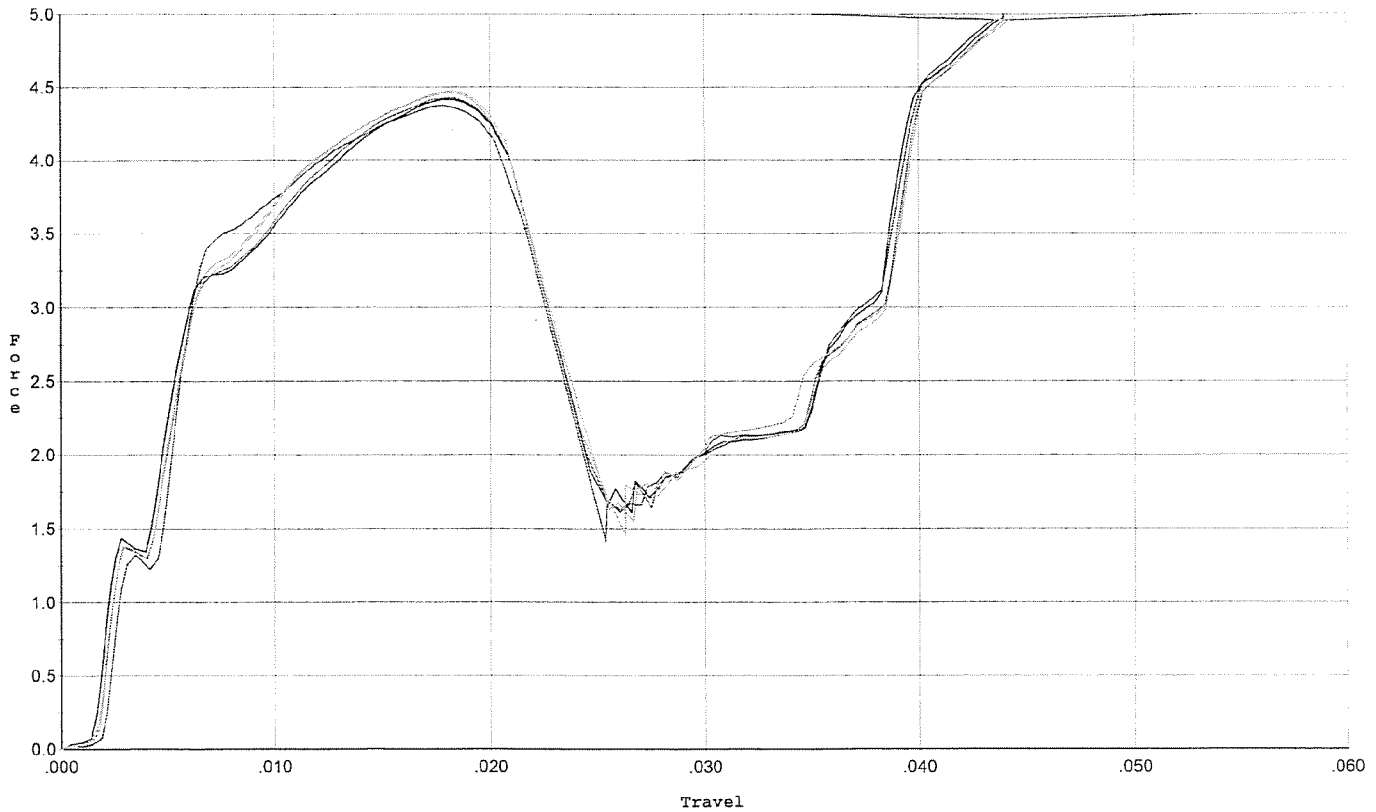
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.019	0.005	0.036	0.033		Set Trigger
2	2.559	0.019	0.00	0.036	0.033		Set Trigger
3	2.582	0.019	0.005	0.036	0.033		Set Trigger
4	2.580	0.019	0.005	0.036	0.033		Set Trigger
5	2.488	0.019	0.004	0.037	0.032		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.374	0.022	0.00	0.033	0.063		Set Trigger
2	4.417	0.021	0.004	0.032	0.061		Set Trigger
3	4.428	0.021	0.004	0.033	0.061		Set Trigger
4	4.474	0.021	0.004	0.033	0.061		Set Trigger
5	4.463	0.021	0.004	0.033	0.061		Set Trigger

A-4.43