

G 680 7807

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



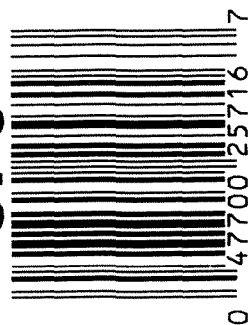
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807807

UPC



GUN SERIAL # G6807807

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE		2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RTZ
480	MAGNAFLUX BBL ACTION	ERROR (A)	3/5/09	MR
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	107
540	APPLY COATINGS (BARREL ACTION)		3/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-12-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

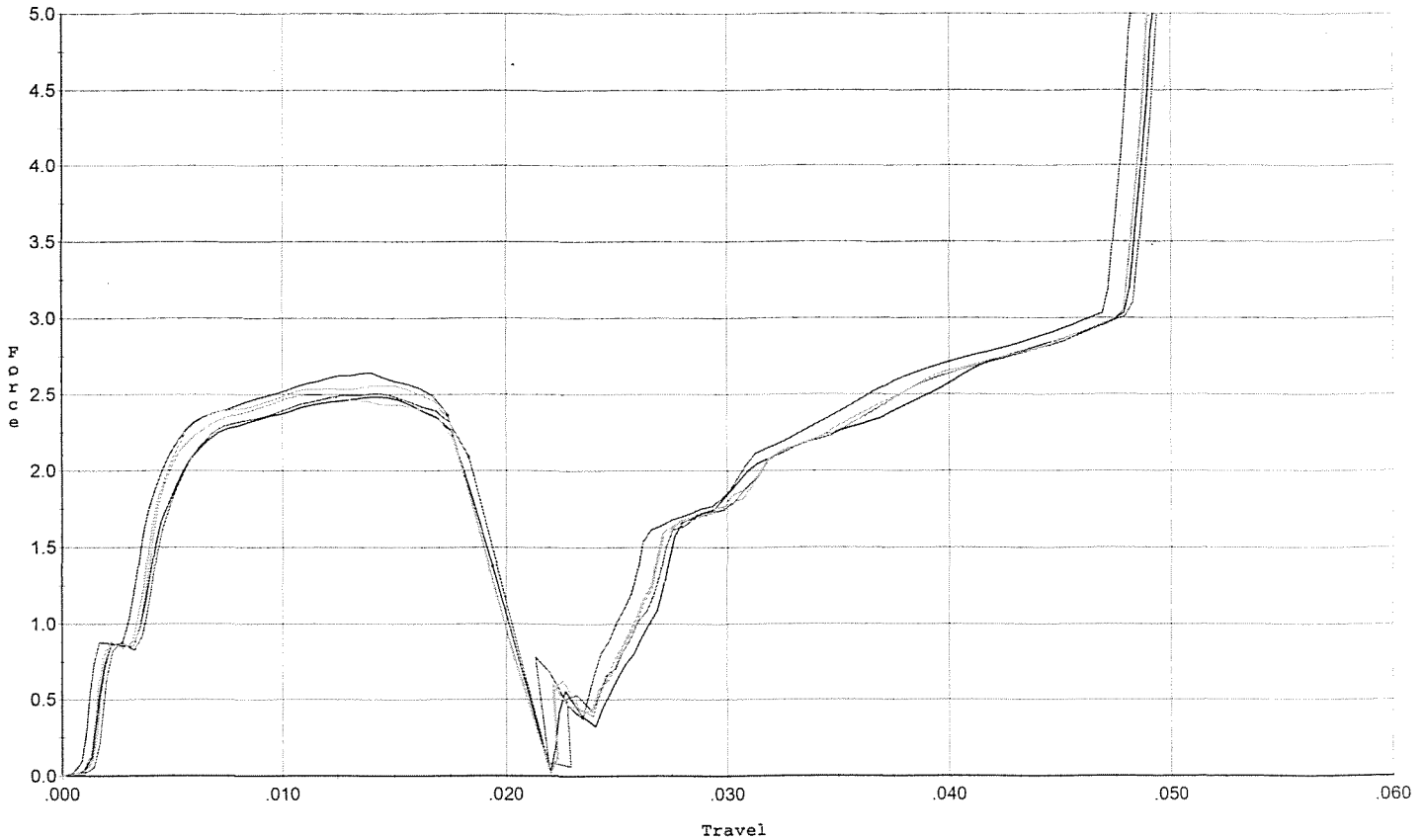
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-19-09	WW
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-19-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-19-09	WW
	J) ASSEMBLE STOCK			3-12-09	JD
	K) ASSEMBLE SWIVEL STUDS			3-19-09	WW
	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	3-17-09	TC
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			3-17-09	WW
670	FINAL INSPECTION A) HEADSPACE			3-19-09	WW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.70</u> <u>2.69</u> <u>2.63</u> <u>2.74</u>	3-18-09	WW
	C) FUNCTION			3-19-09	WW
690	PACK			3/19/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



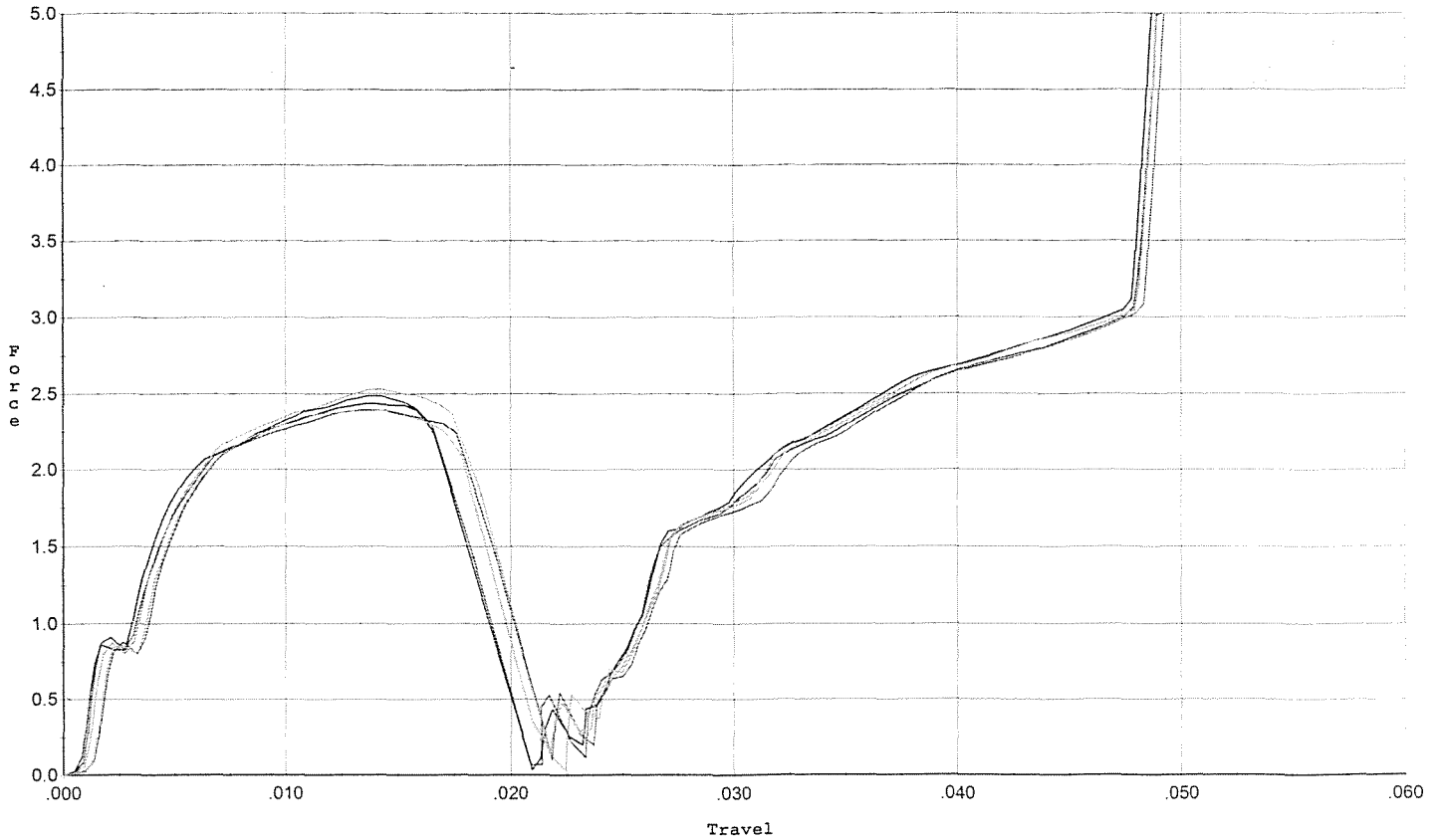
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.642	0.017	0.003	0.034	0.034		Set Trigger
2	2.482	0.019	0.004	0.034	0.035		Set Trigger
3	2.507	0.018	0.00	0.034	0.033		Set Trigger
4	2.557	0.017	0.00	0.035	0.033		Set Trigger
5	2.495	0.018	0.003	0.034	0.032		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



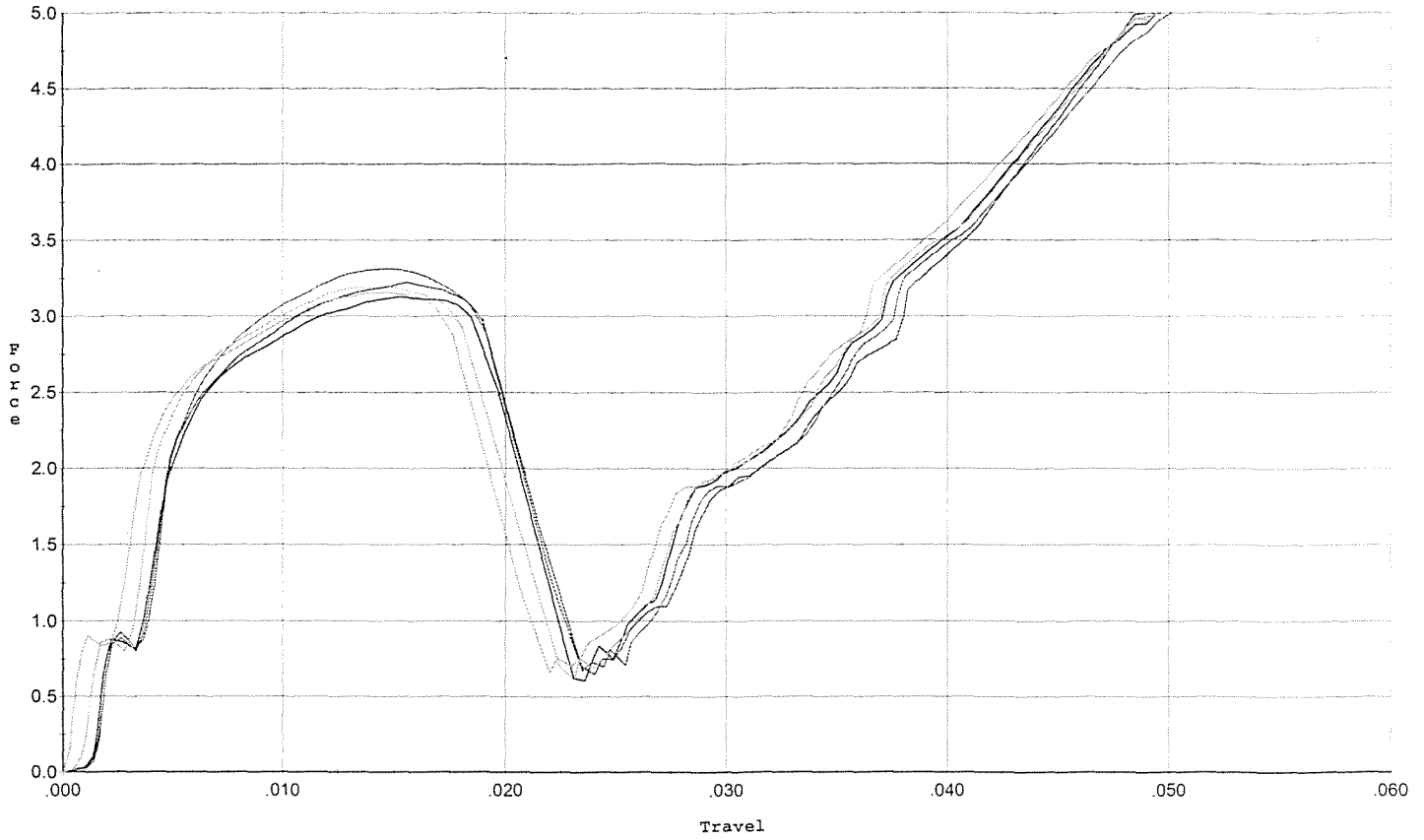
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.487	0.018	0.00	0.035	0.032		Set Trigger
2	2.436	0.017	0.003	0.035	0.029		Set Trigger
3	2.394	0.019	0.00	0.034	0.033		Set Trigger
4	2.396	0.018	0.00	0.035	0.031		Set Trigger
5	2.530	0.019	0.00	0.034	0.034		Set Trigger

A-2-44

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



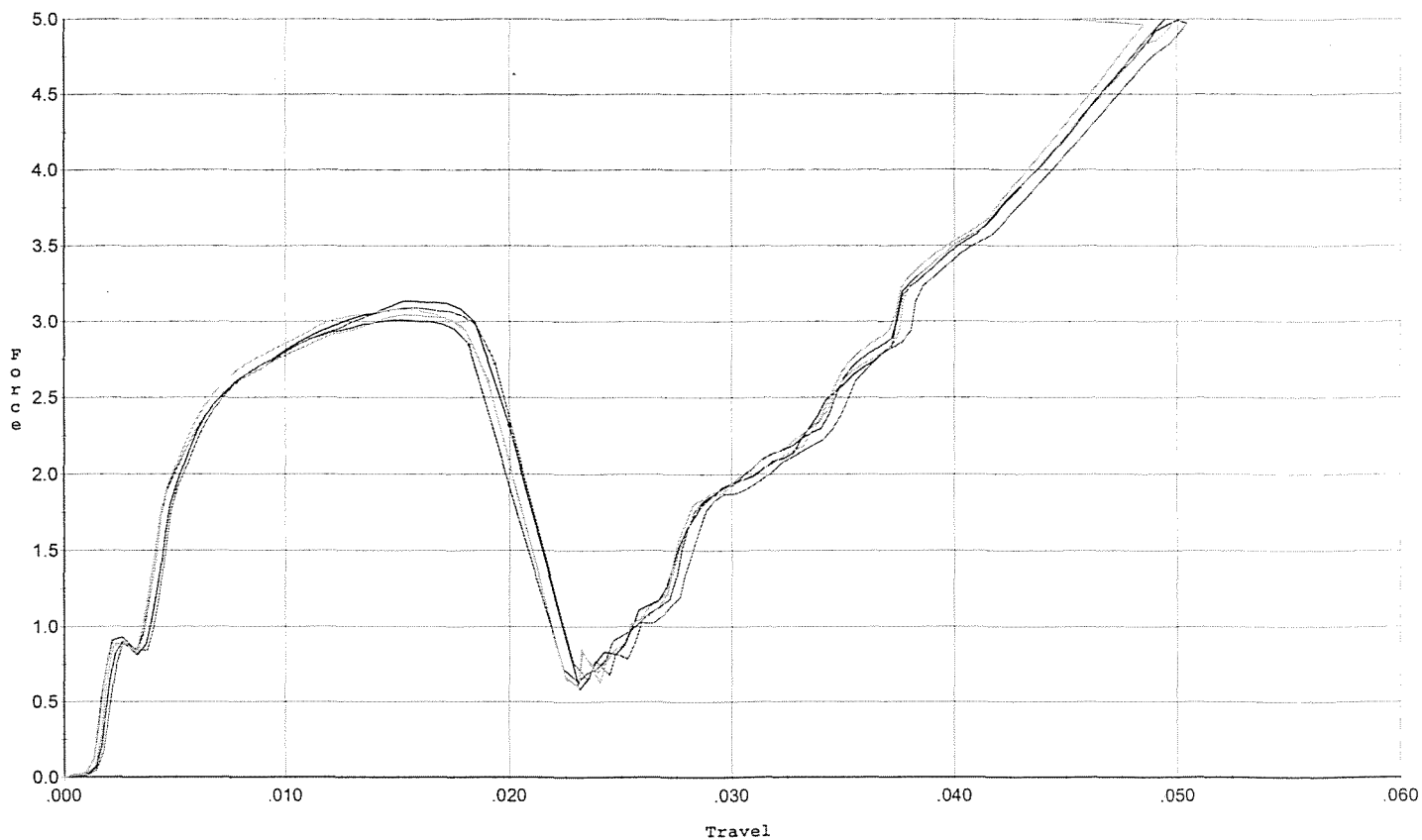
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.225	0.019	0.00	0.034	0.042		Set Trigger
2	3.127	0.020	0.004	0.033	0.043		Set Trigger
3	3.313	0.019	0.00	0.033	0.044		Set Trigger
4	3.202	0.018	0.00	0.033	0.041		Set Trigger
5	3.157	0.018	0.00	0.033	0.041		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



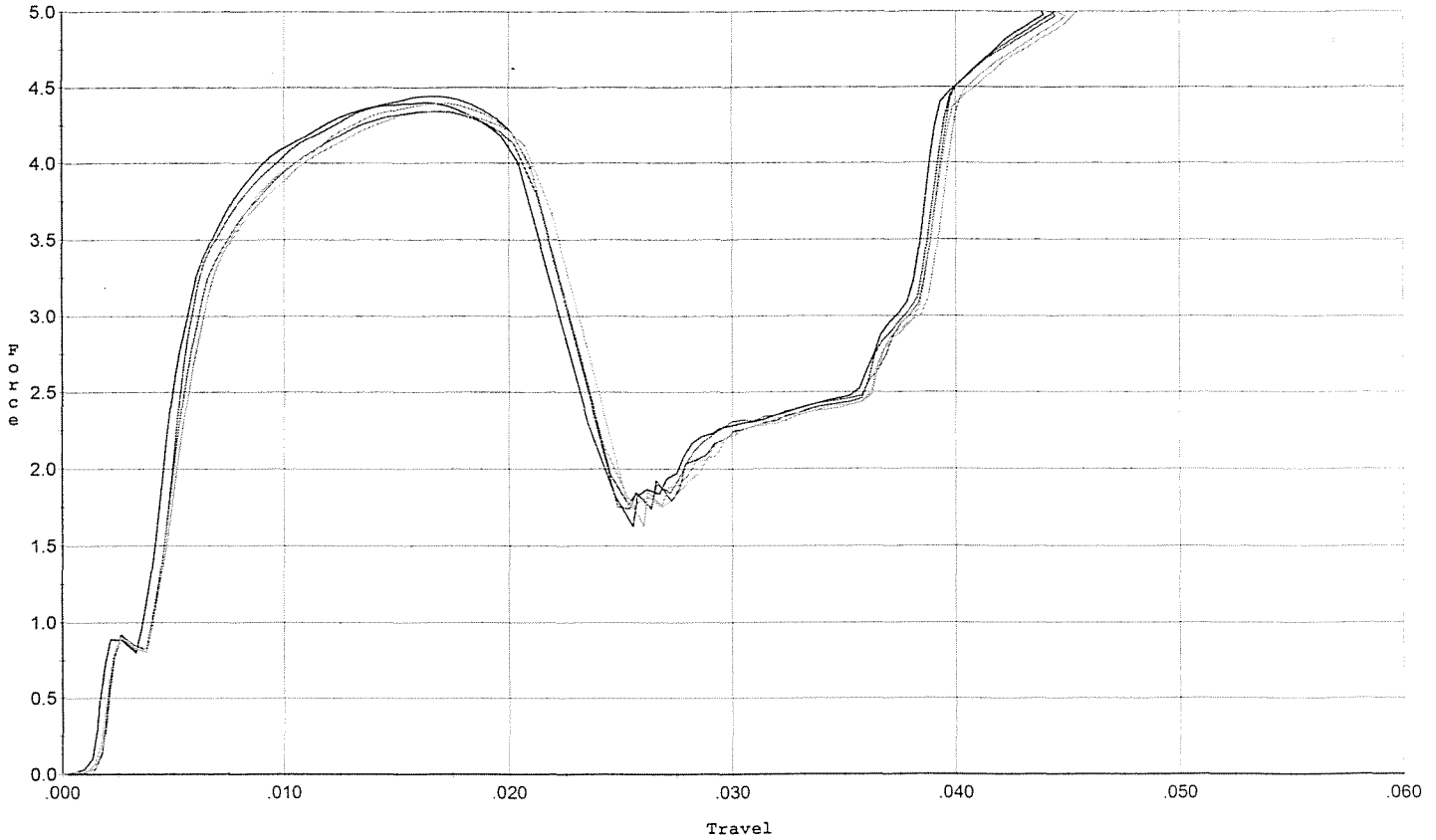
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.010	0.018	0.00	0.034	0.038		Set Trigger
2	3.131	0.020	0.00	0.033	0.043		Set Trigger
3	3.090	0.019	0.004	0.034	0.041		Set Trigger
4	3.080	0.019	0.00	0.034	0.041		Set Trigger
5	3.043	0.019	0.003	0.033	0.041		Set Trigger

A-3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



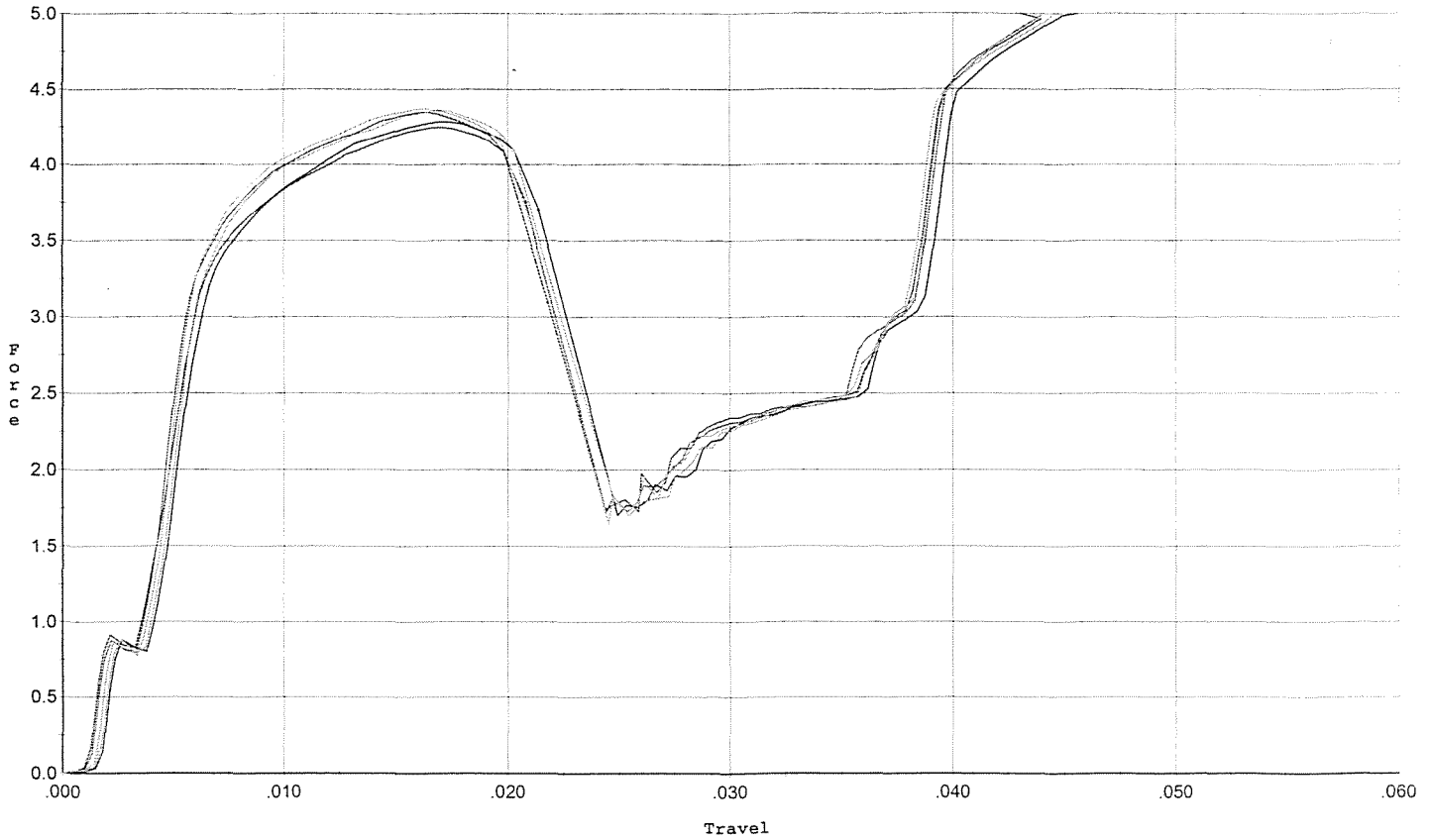
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.445	0.021	0.004	0.030	0.063		Set Trigger
2	4.402	0.020	0.004	0.030	0.062		Set Trigger
3	4.344	0.021	0.00	0.030	0.062		Set Trigger
4	4.346	0.022	0.004	0.030	0.064		Set Trigger
5	4.398	0.021	0.004	0.030	0.061		Set Trigger

A-4-38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



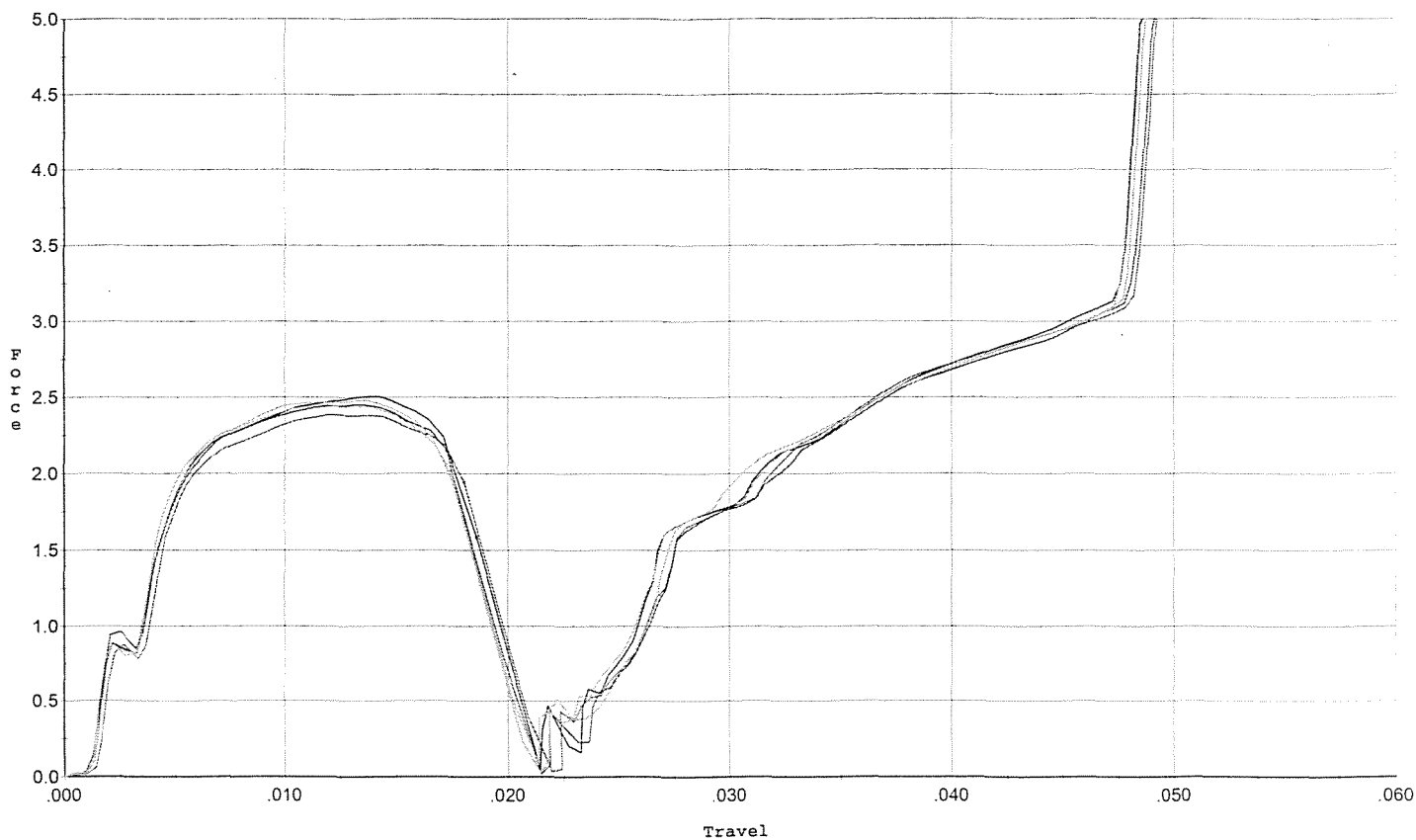
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.248	0.021	0.004	0.029	0.060		Set Trigger
2	4.287	0.021	0.004	0.030	0.061		Set Trigger
3	4.350	0.022	0.004	0.030	0.064		Set Trigger
4	4.373	0.021	0.00	0.030	0.062		Set Trigger
5	4.363	0.020	0.00	0.030	0.059		Set Trigger

A 4.32

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



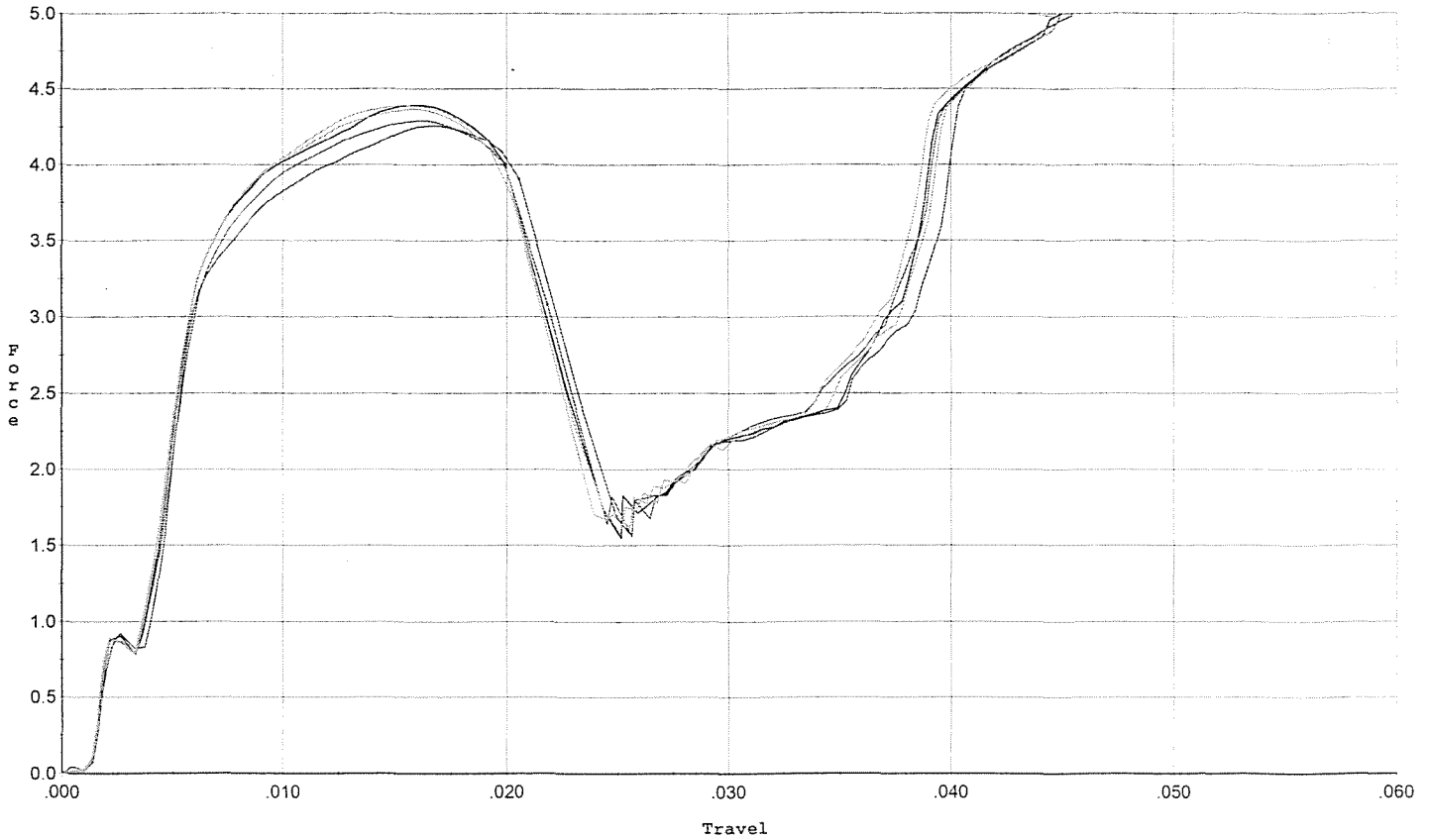
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.451	0.017	0.00	0.035	0.030		Set Trigger
2	2.506	0.019	0.004	0.034	0.033		Set Trigger
3	2.384	0.018	0.00	0.035	0.031		Set Trigger
4	2.450	0.017	0.004	0.035	0.031		Set Trigger
5	2.479	0.018	0.00	0.034	0.031		Set Trigger

A.2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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	4.258	0.021	0.00	0.027	0.059		Set Trigger
2	4.392	0.020	0.00	0.027	0.059		Set Trigger
3	4.292	0.022	0.004	0.027	0.063		Set Trigger
4	4.368	0.020	0.004	0.027	0.060		Set Trigger
5	4.387	0.020	0.004	0.028	0.059		Set Trigger

A. 4.33