

G680 7811

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



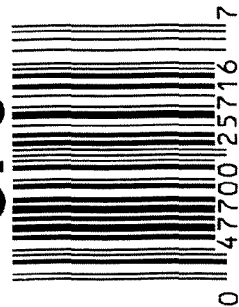
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807811

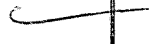
UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807811

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
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	mon
540	APPLY COATINGS (BARREL ACTION)		5/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-19-09	R 92
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

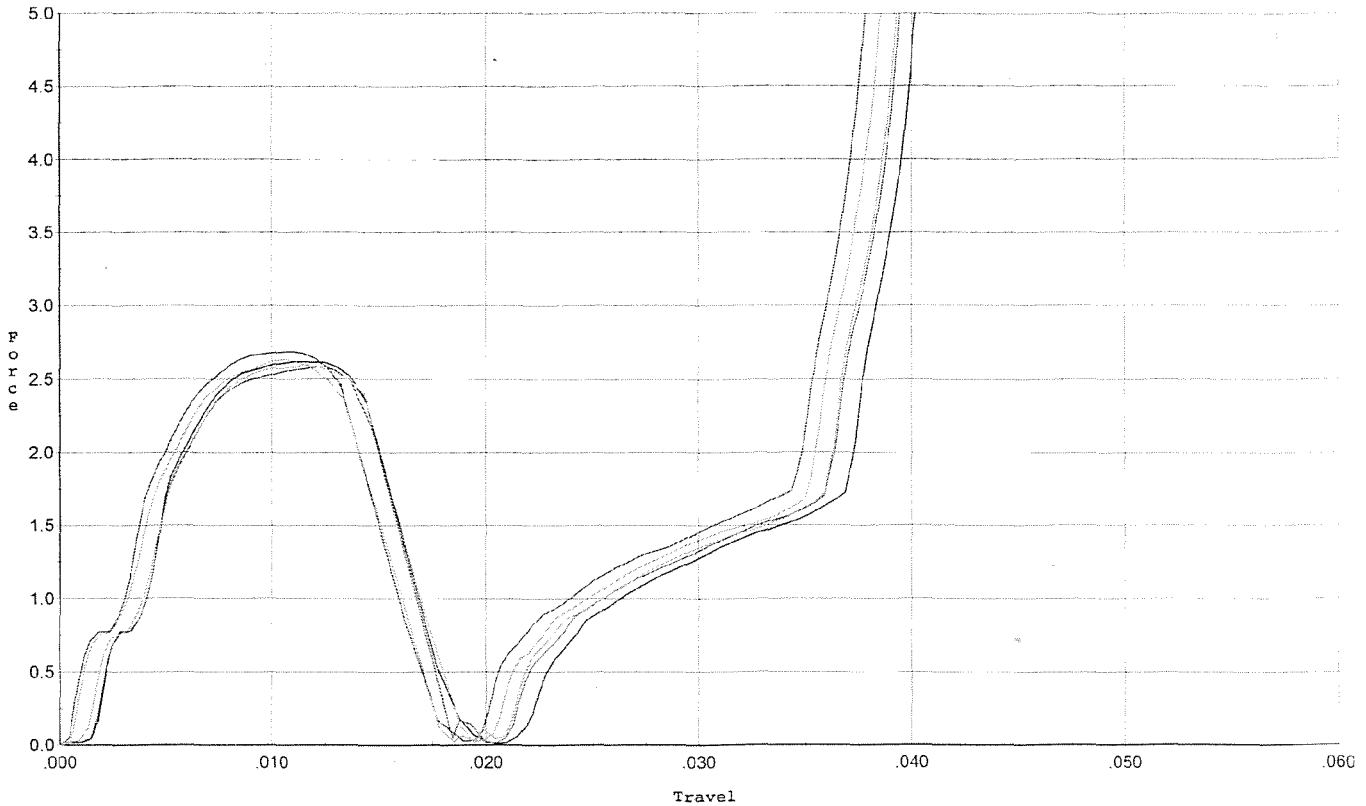
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>4</u> <u>4</u>	3-24-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4</u> <u>4</u>	3-24-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-24-09	WV
	J) ASSEMBLE STOCK		3-17-09	X JV
	K) ASSEMBLE SWIVEL STUDS		3-24-09	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 &	FUNCTION TEST AND	<u>PASS</u> FAIL	3-20-09	RP
650	TARGET	<u>PASS</u> FAIL		
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-20-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-24-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.58</u> <u>2.54</u> <u>2.43</u> <u>2.42</u>	3-23-09	TL
	C) FUNCTION		3-24-09	WV
690	PACK		3/25/09	FAN

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



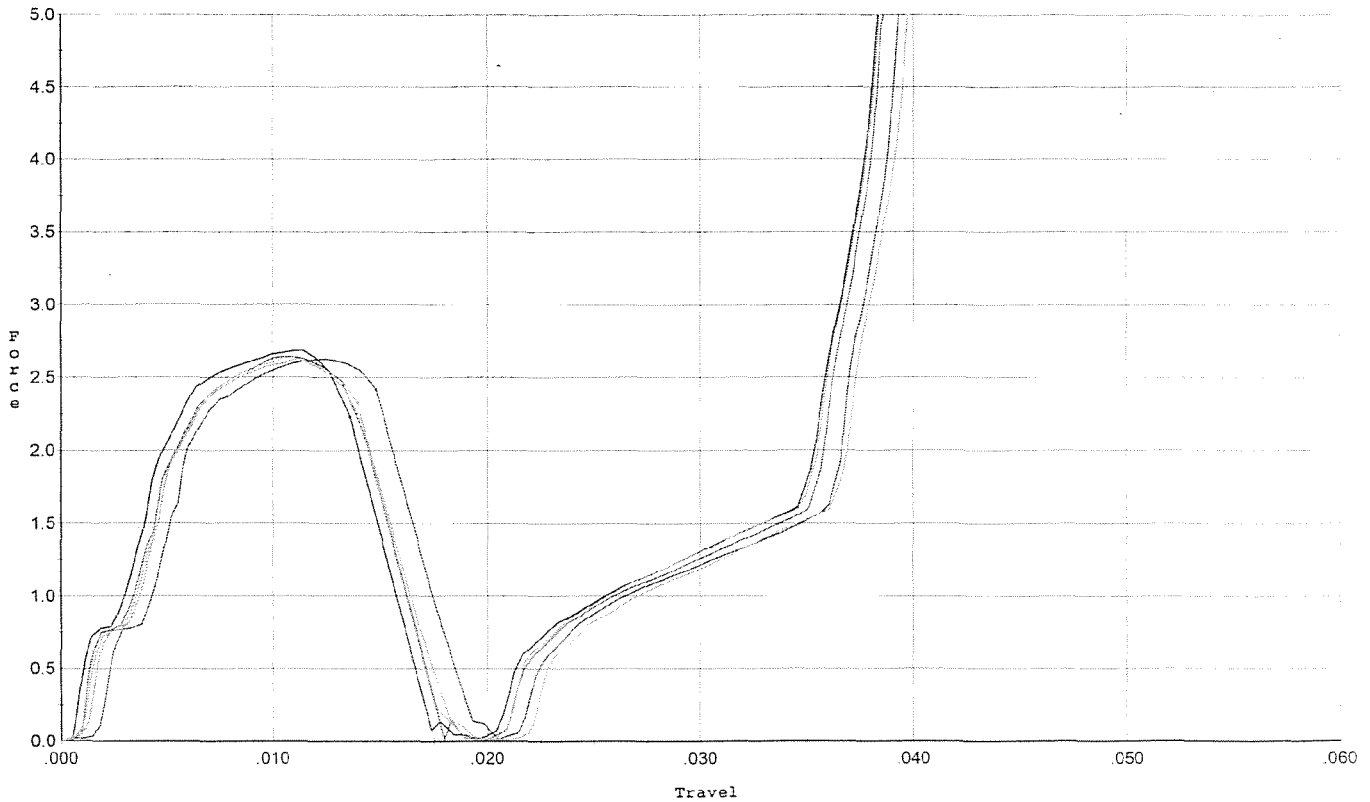
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.686	0.013	0.00	0.028	0.024		Set Trigger
2	2.617	0.014	0.00	0.030	0.025		Set Trigger
3	2.582	0.015	0.00	0.030	0.025		Set Trigger
4	2.598	0.014	0.00	0.029	0.024		Set Trigger
5	2.633	0.016	0.00	0.029	0.027		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



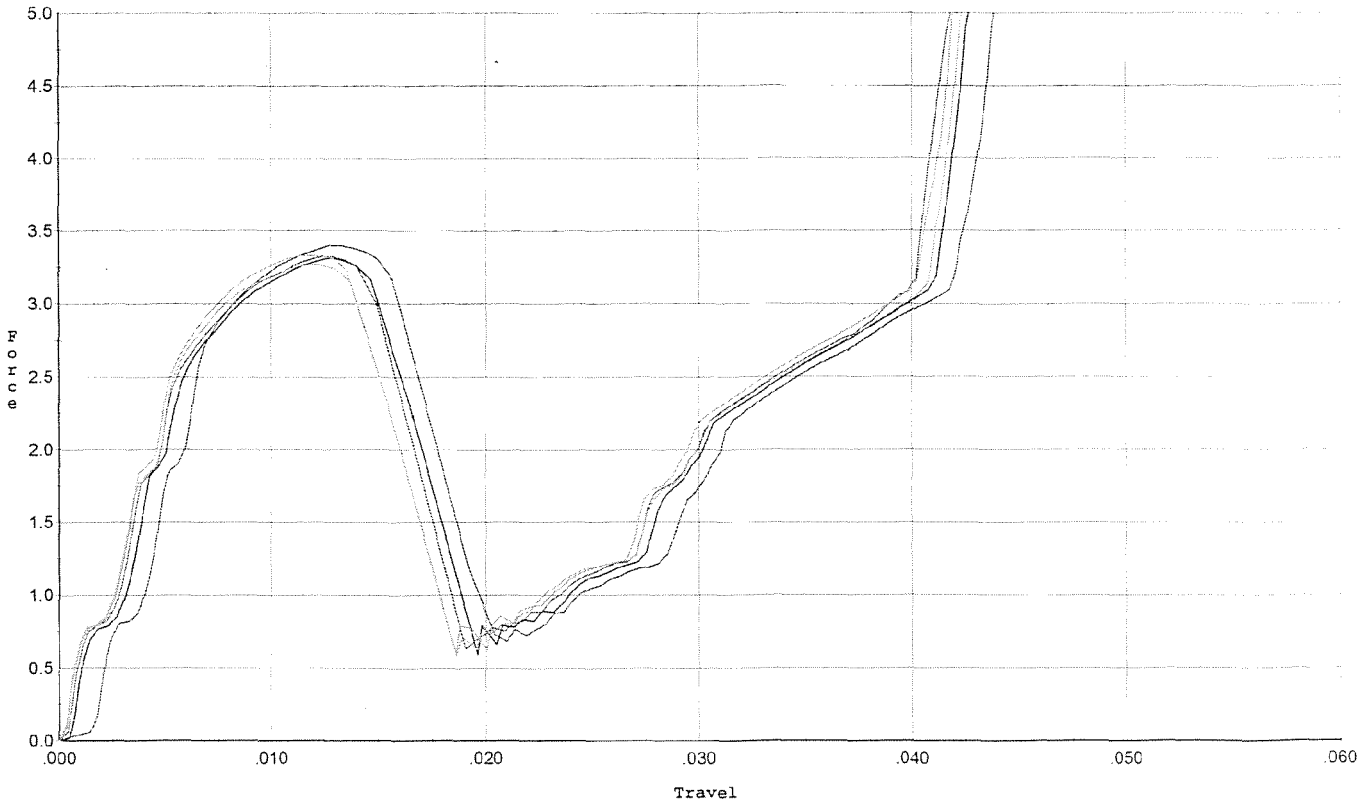
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.624	0.015	0.00	0.029	0.025		Set Trigger
2	2.686	0.014	0.00	0.029	0.025		Set Trigger
3	2.642	0.014	0.00	0.029	0.025		Set Trigger
4	2.636	0.014	0.00	0.030	0.025		Set Trigger
5	2.621	0.014	0.00	0.029	0.024		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



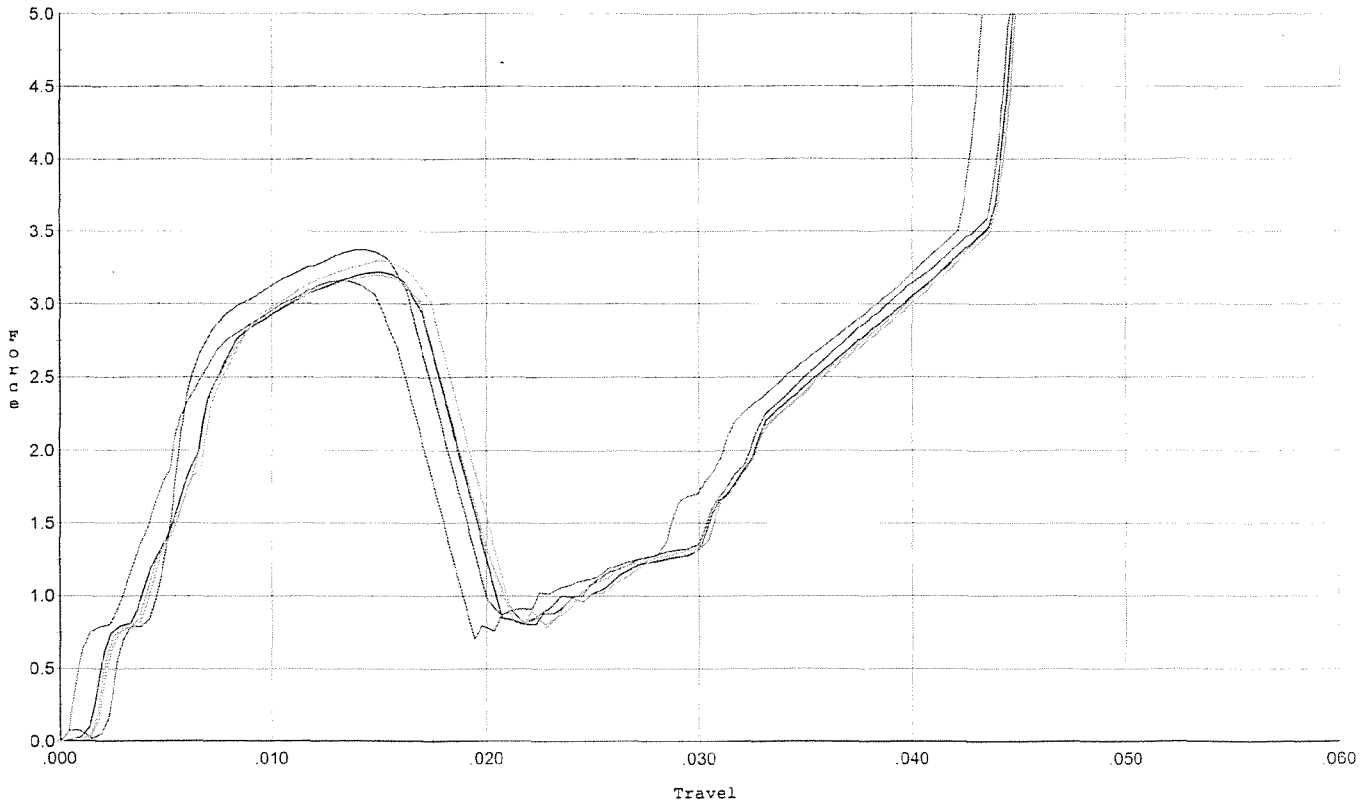
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.399	0.016	0.00	0.031	0.034		Set Trigger
2	3.312	0.017	0.00	0.030	0.036		Set Trigger
3	3.326	0.015	0.00	0.030	0.033		Set Trigger
4	3.269	0.016	0.00	0.030	0.034		Set Trigger
5	3.331	0.016	0.00	0.030	0.035		Set Trigger

A-3-32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



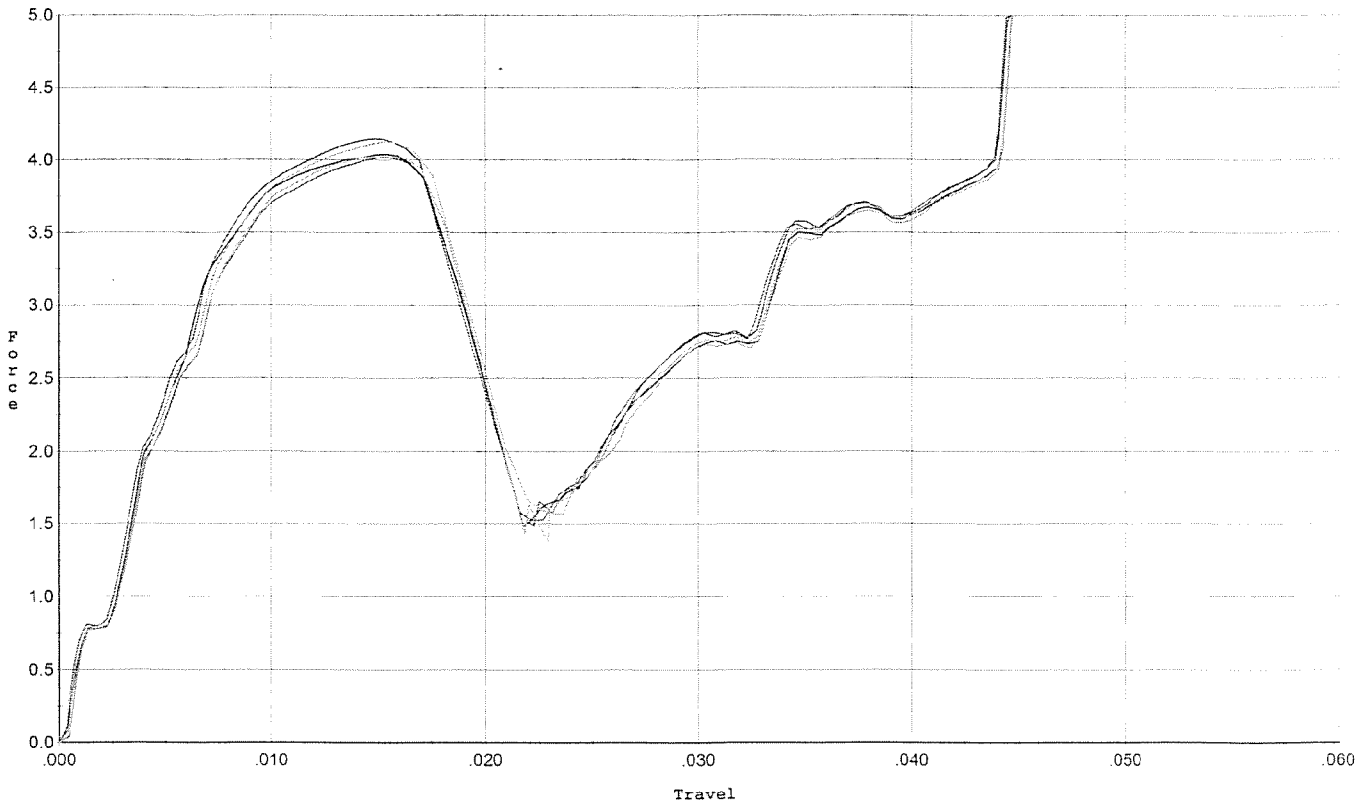
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.372	0.016	0.00	0.031	0.034		Set Trigger
2	3.217	0.017	0.00	0.031	0.035		Set Trigger
3	3.159	0.016	0.00	0.030	0.033		Set Trigger
4	3.196	0.017	0.00	0.031	0.034		Set Trigger
5	3.298	0.017	0.00	0.030	0.036		Set Trigger

A-3.24

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



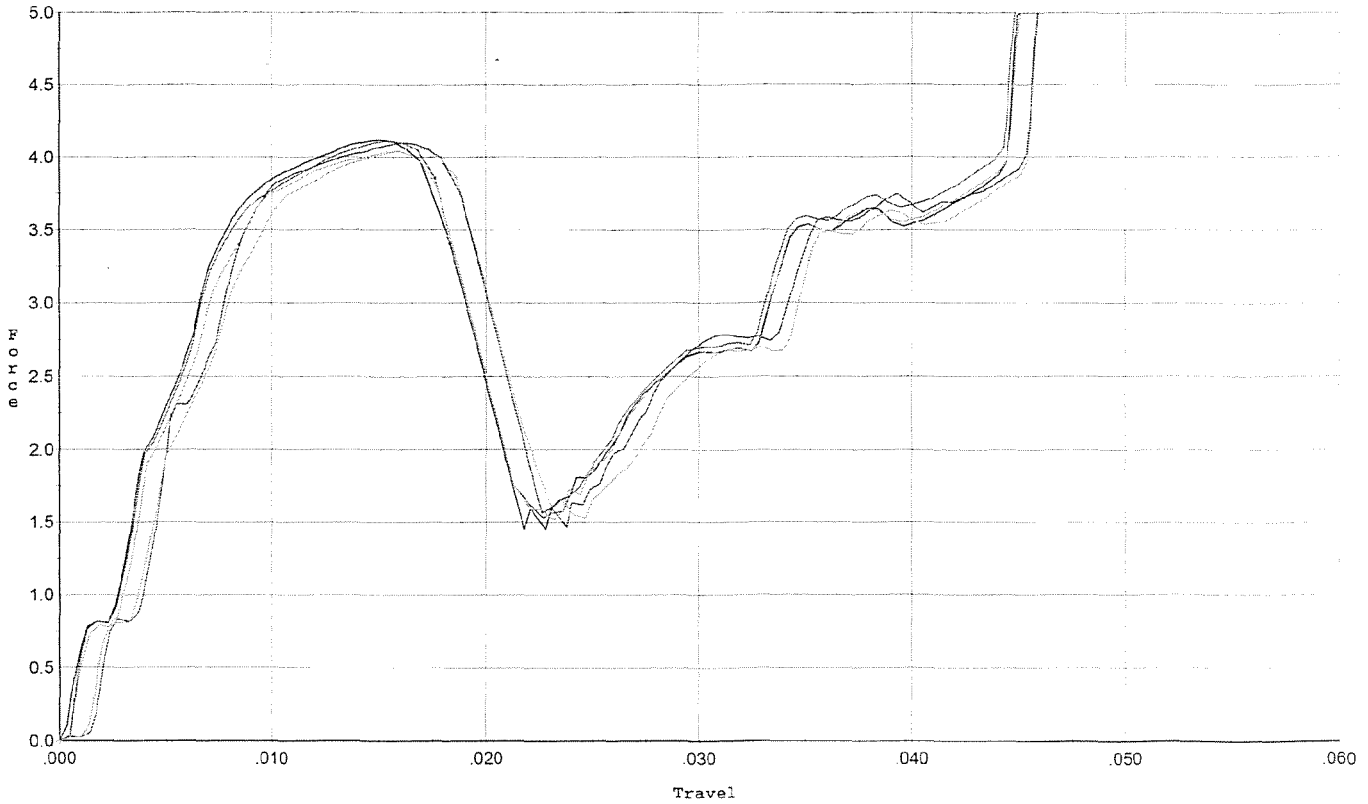
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.019	0.00	0.027	0.052		Set Trigger
2	4.035	0.019	0.00	0.027	0.051		Set Trigger
3	4.017	0.017	0.00	0.028	0.045		Set Trigger
4	4.044	0.018	0.00	0.027	0.048		Set Trigger
5	4.120	0.018	0.00	0.027	0.048		Set Trigger

1A-4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



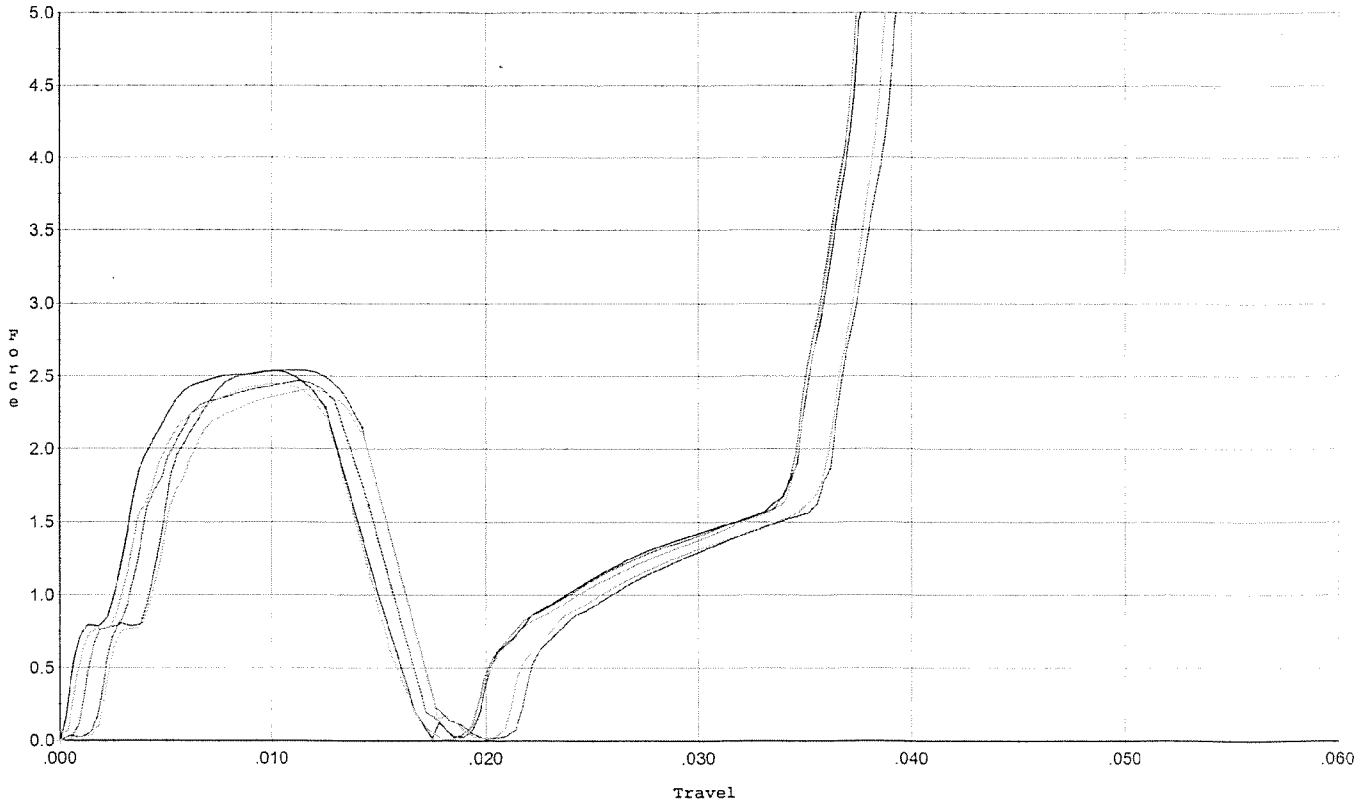
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.100	0.019	0.00	0.028	0.050		Set Trigger
2	4.119	0.018	0.00	0.027	0.050		Set Trigger
3	4.109	0.018	0.00	0.027	0.048		Set Trigger
4	4.068	0.019	0.00	0.028	0.048		Set Trigger
5	4.043	0.018	0.00	0.028	0.047		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



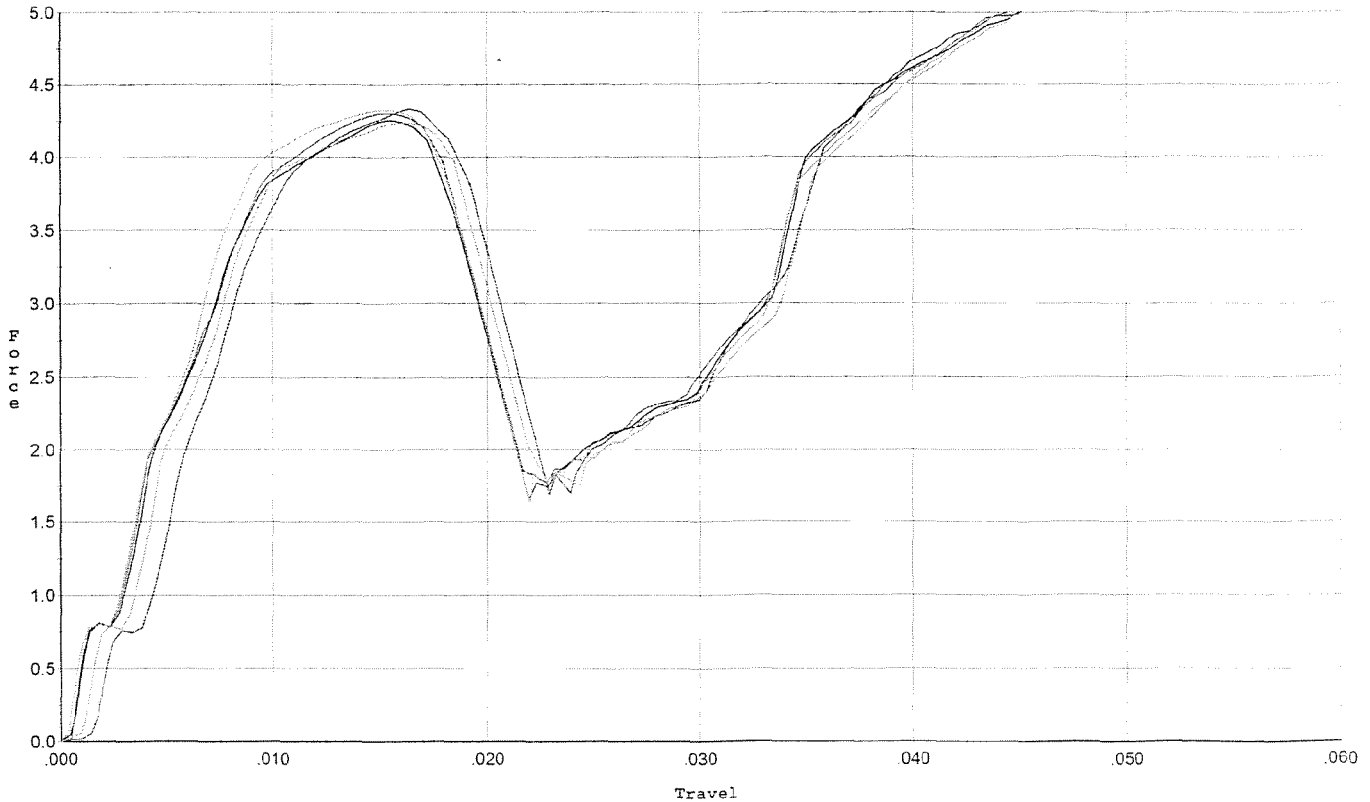
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.014	0.00	0.030	0.023		Set Trigger
2	2.539	0.013	0.00	0.029	0.023		Set Trigger
3	2.468	0.015	0.00	0.028	0.024		Set Trigger
4	2.410	0.014	0.00	0.029	0.022		Set Trigger
5	2.450	0.013	0.00	0.029	0.021		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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	4.335	0.019	0.00	0.027	0.051		Set Trigger
2	4.253	0.019	0.00	0.027	0.051		Set Trigger
3	4.302	0.018	0.00	0.027	0.050		Set Trigger
4	4.326	0.018	0.00	0.027	0.052		Set Trigger
5	4.238	0.018	0.00	0.027	0.050		Set Trigger

A-4.29