

G6845259

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



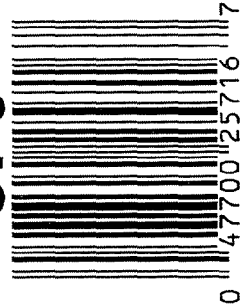
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845259

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 684 5259

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SP
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SP
460	CHECK HEADSPACE		3-17-09	SP
470	DIS-ASSEMBLE ACTION		3-17-09	SP
472	SERIALIZE BOLT HANDLE		3-18-09	RT
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION		3-20-09	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-8-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

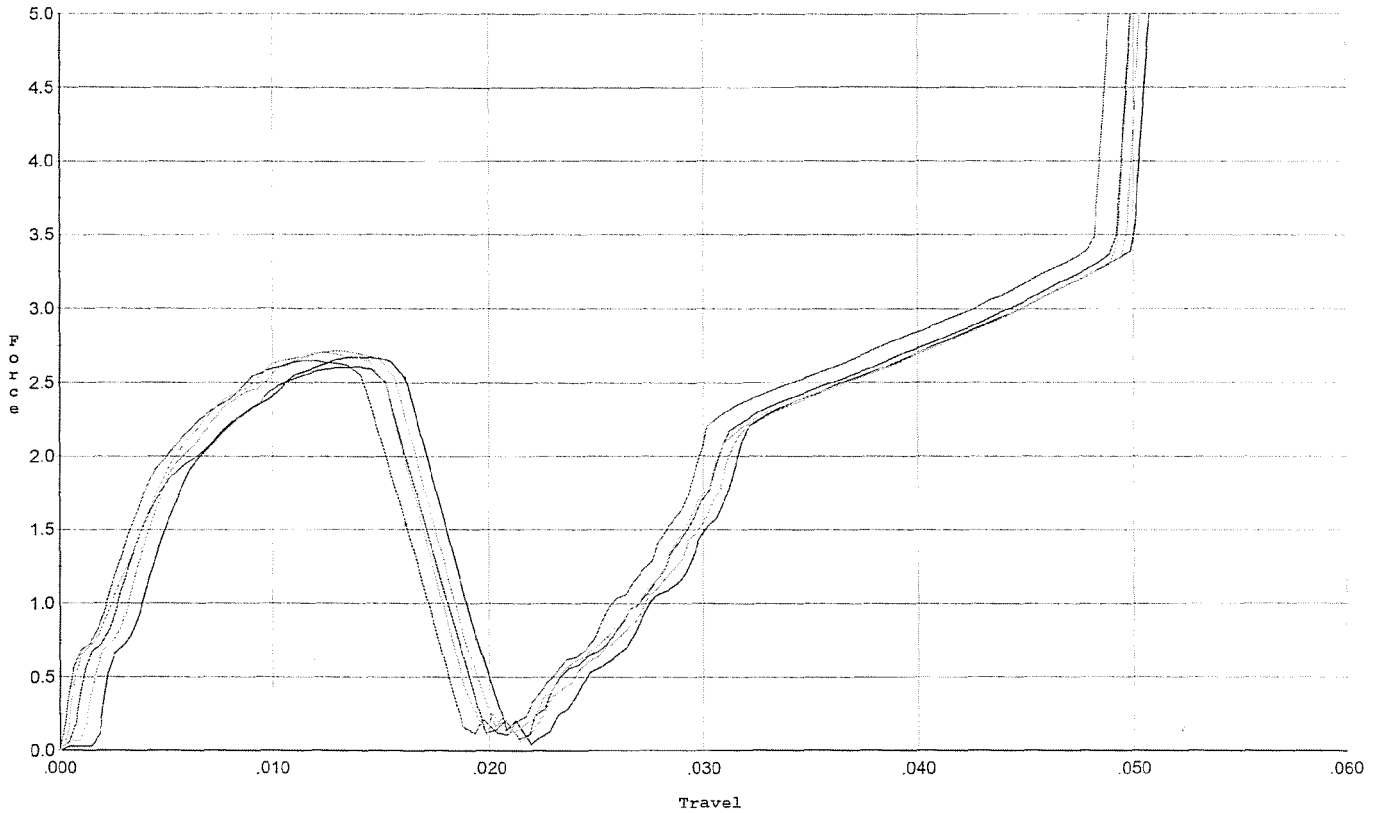
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	4-17-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-17-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	4-17-09	WW
	J) ASSEMBLE STOCK		4-8-09	LSJ
	K) ASSEMBLE SWIVEL STUDS		4-17-09	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	4-17-09	AWD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-14-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-17-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.69</u> <u>2.55</u> <u>2.52</u> <u>2.61</u>	4-16-09	RP
	C) FUNCTION		4-17-09	WW
690	PACK		5/3/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



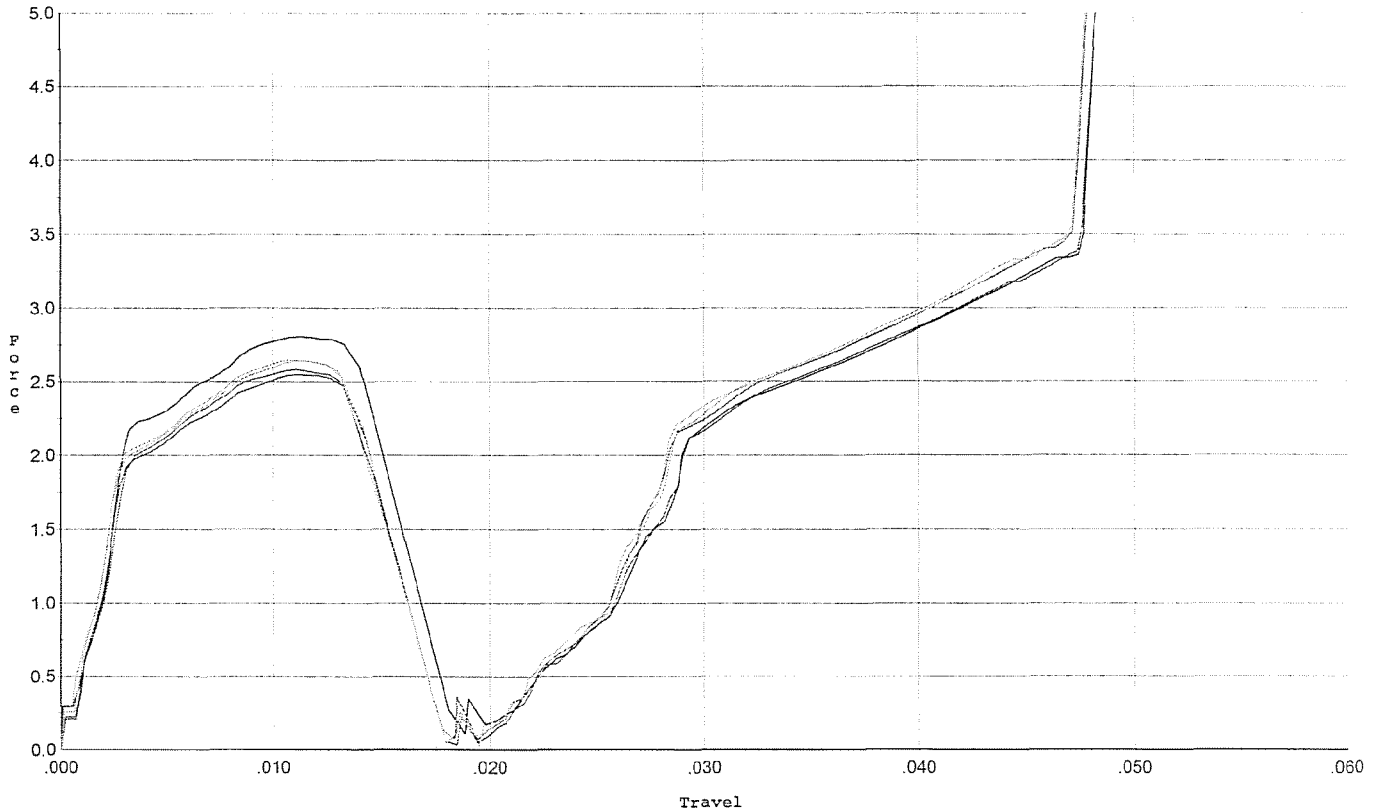
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.015	0.00	0.037	0.027		Set Trigger
2	2.671	0.016	0.002	0.037	0.028		Set Trigger
3	2.650	0.016	0.00	0.036	0.030		Set Trigger
4	2.701	0.015	0.00	0.037	0.029		Set Trigger
5	2.713	0.016	0.00	0.037	0.029		Set Trigger

A-2.66

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



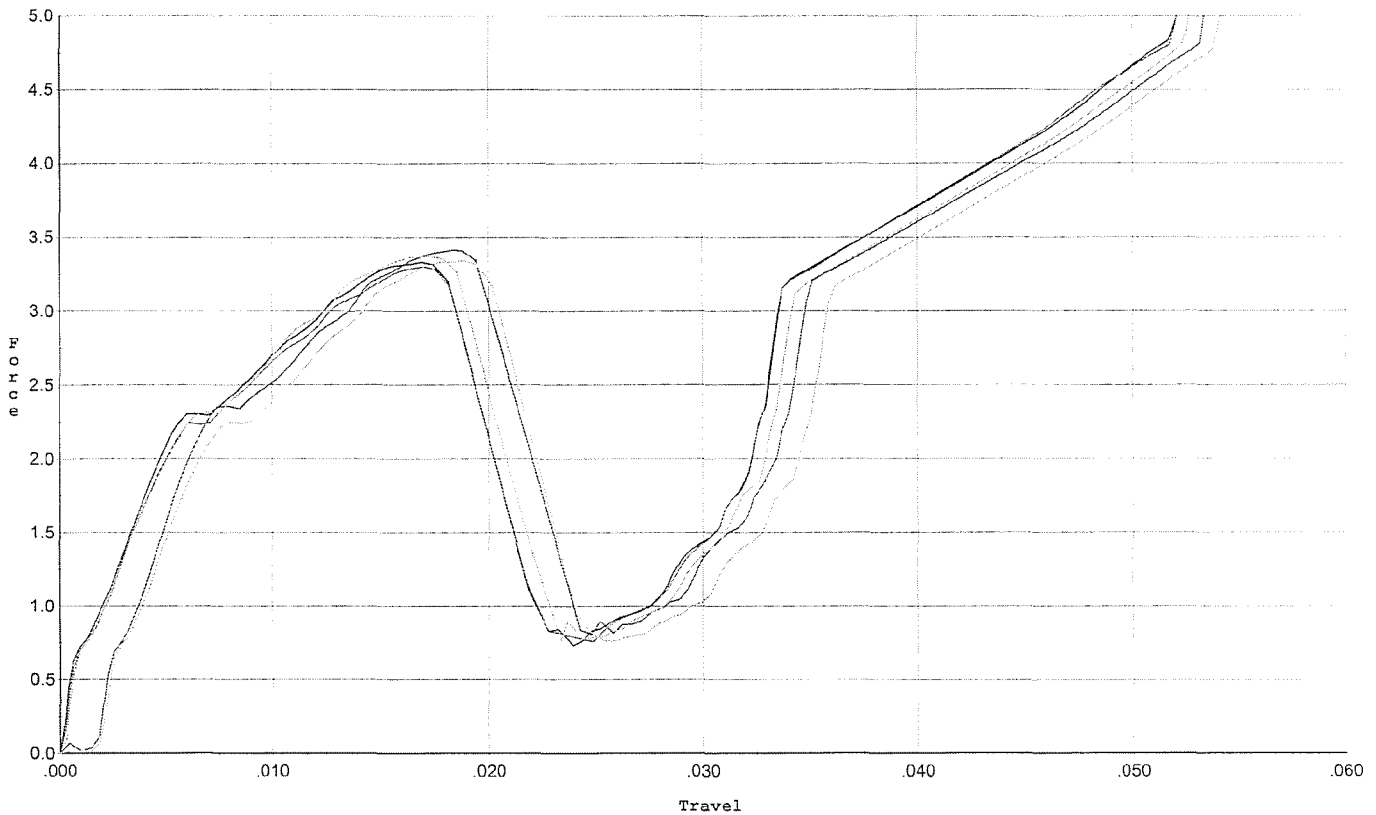
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.547	0.015	0.00	0.036	0.027		Set Trigger
2	2.807	0.014	0.00	0.036	0.029		Set Trigger
3	2.582	0.014	0.00	0.036	0.027		Set Trigger
4	2.650	0.015	0.00	0.036	0.029		Set Trigger
5	2.640	0.014	0.00	0.036	0.027		Set Trigger

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Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



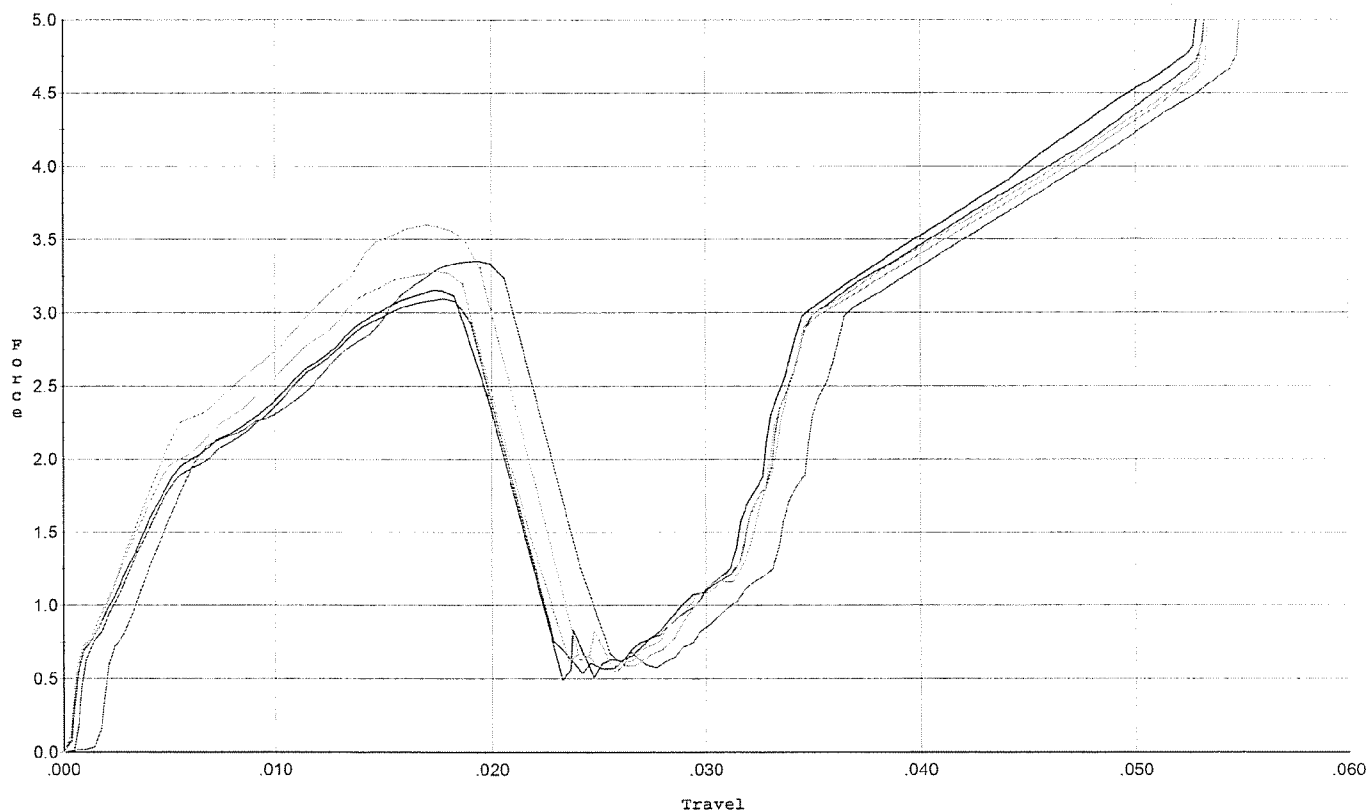
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.415	0.019	0.00	0.034	0.042		Set Trigger
2	3.334	0.018	0.00	0.034	0.041		Set Trigger
3	3.303	0.018	0.00	0.034	0.040		Set Trigger
4	3.345	0.020	0.002	0.035	0.042		Set Trigger
5	3.371	0.019	0.00	0.034	0.042		Set Trigger

A.3.35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



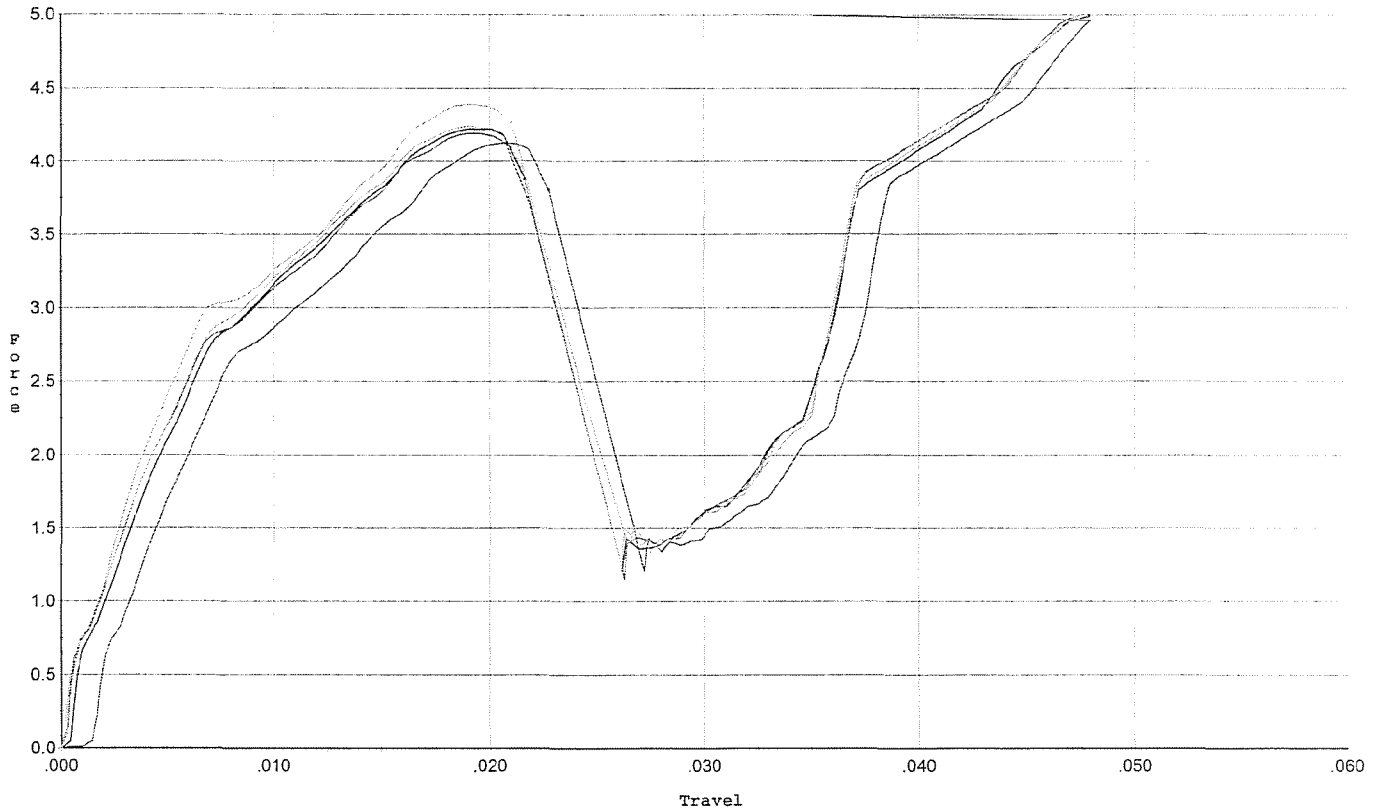
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.019	0.00	0.035	0.039		Set Trigger
2	3.151	0.020	0.00	0.034	0.041		Set Trigger
3	3.350	0.021	0.00	0.035	0.043		Set Trigger
4	3.279	0.019	0.00	0.035	0.041		Set Trigger
5	3.599	0.019	0.00	0.034	0.047		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



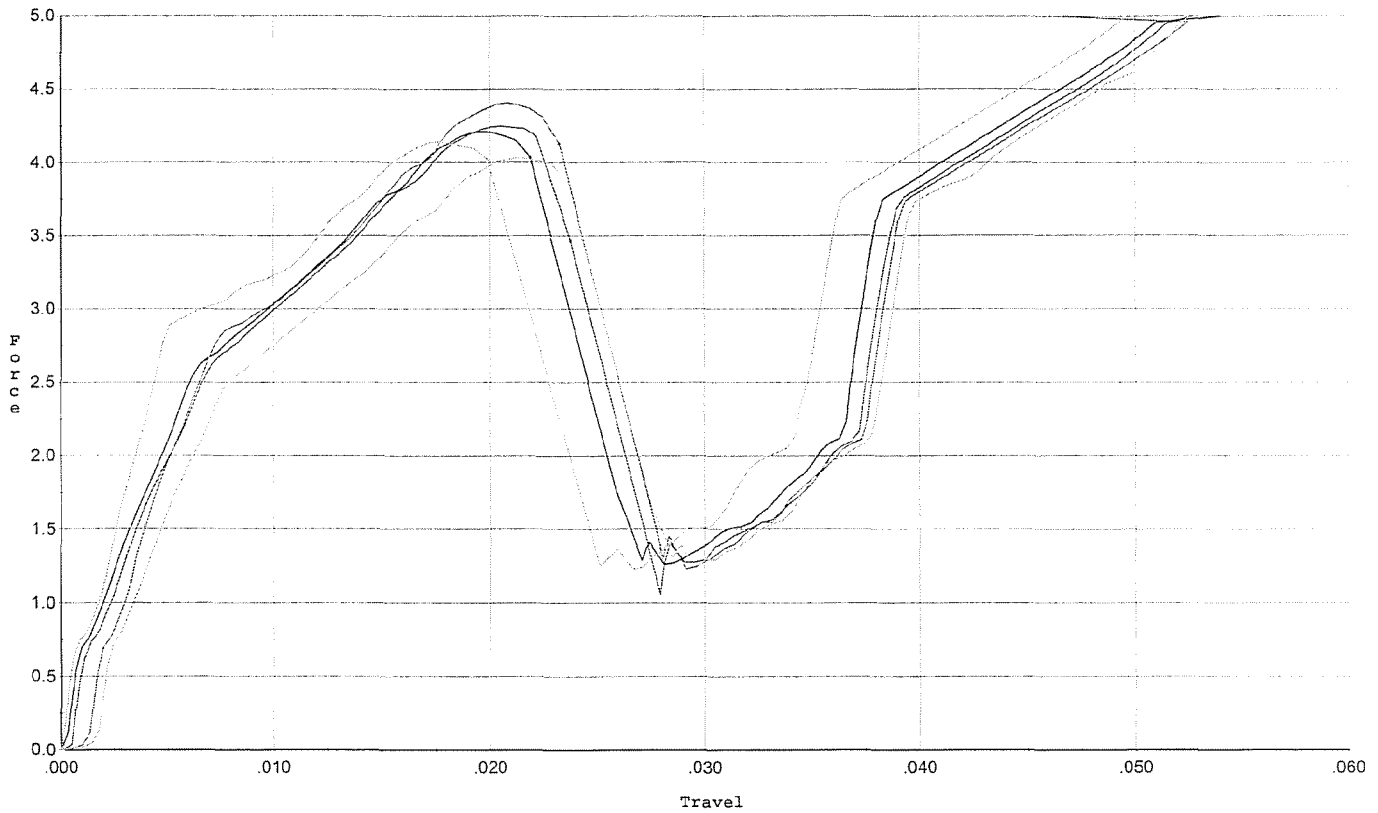
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.125	0.023	0.00	0.034	0.059		Set Trigger
2	4.223	0.022	0.00	0.034	0.060		Set Trigger
3	4.193	0.022	0.00	0.034	0.061		Set Trigger
4	4.242	0.021	0.00	0.034	0.061		Set Trigger
5	4.388	0.021	0.00	0.034	0.061		Set Trigger

A-4.23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



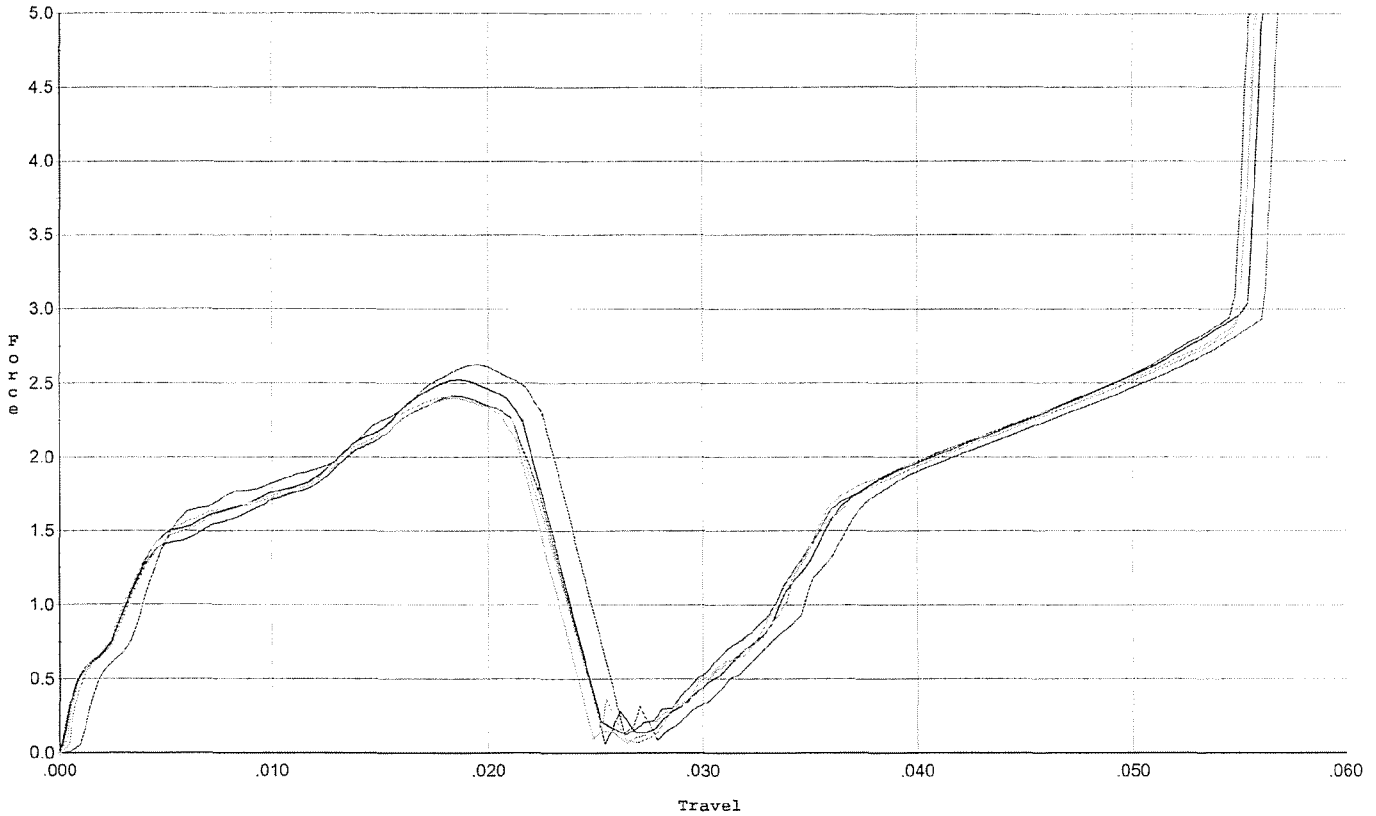
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.247	0.024	0.00	0.034	0.065		Set Trigger
2	4.213	0.022	0.00	0.035	0.061		Set Trigger
3	4.406	0.023	0.00	0.034	0.065		Set Trigger
4	4.034	0.024	0.00	0.034	0.060		Set Trigger
5	4.140	0.020	0.00	0.034	0.056		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



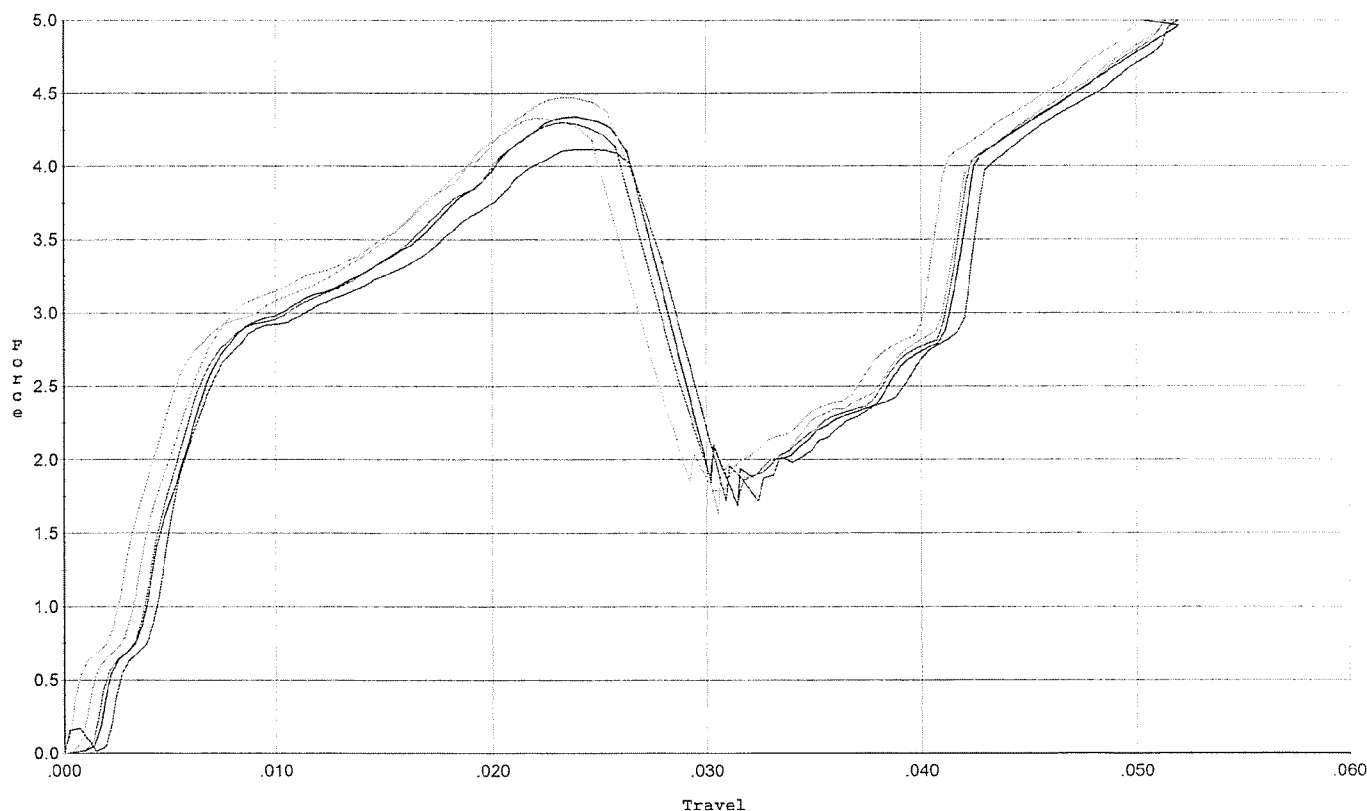
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.414	0.022	0.00	0.037	0.036		Set Trigger
2	2.523	0.022	0.00	0.038	0.037		Set Trigger
3	2.627	0.023	0.00	0.038	0.039		Set Trigger
4	2.409	0.021	0.00	0.038	0.035		Set Trigger
5	2.399	0.023	0.00	0.038	0.037		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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	4.115	0.028	0.00	0.026	0.075		Set Trigger
2	4.342	0.026	0.00	0.031	0.073		Set Trigger
3	4.300	0.026	0.00	0.030	0.071		Set Trigger
4	4.330	0.025	0.00	0.030	0.071		Set Trigger
5	4.474	0.027	0.00	0.027	0.078		Set Trigger

A-4.31