

G6845266

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

- INSTRUCTION BOOK 351B

BM FORM

proof of purchase

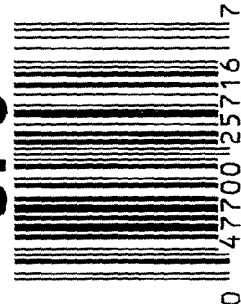


owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6845266	

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6845266

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
472	SERIALIZE BOLT HANDLE		3-8-09	RIC
475	DRILL AND TAP SIGHT HOLES		3-12-09	SP
480	MAGNAFLUX BBL ACTION	(A)	3-20-09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-28-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-28-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-28-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-1-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

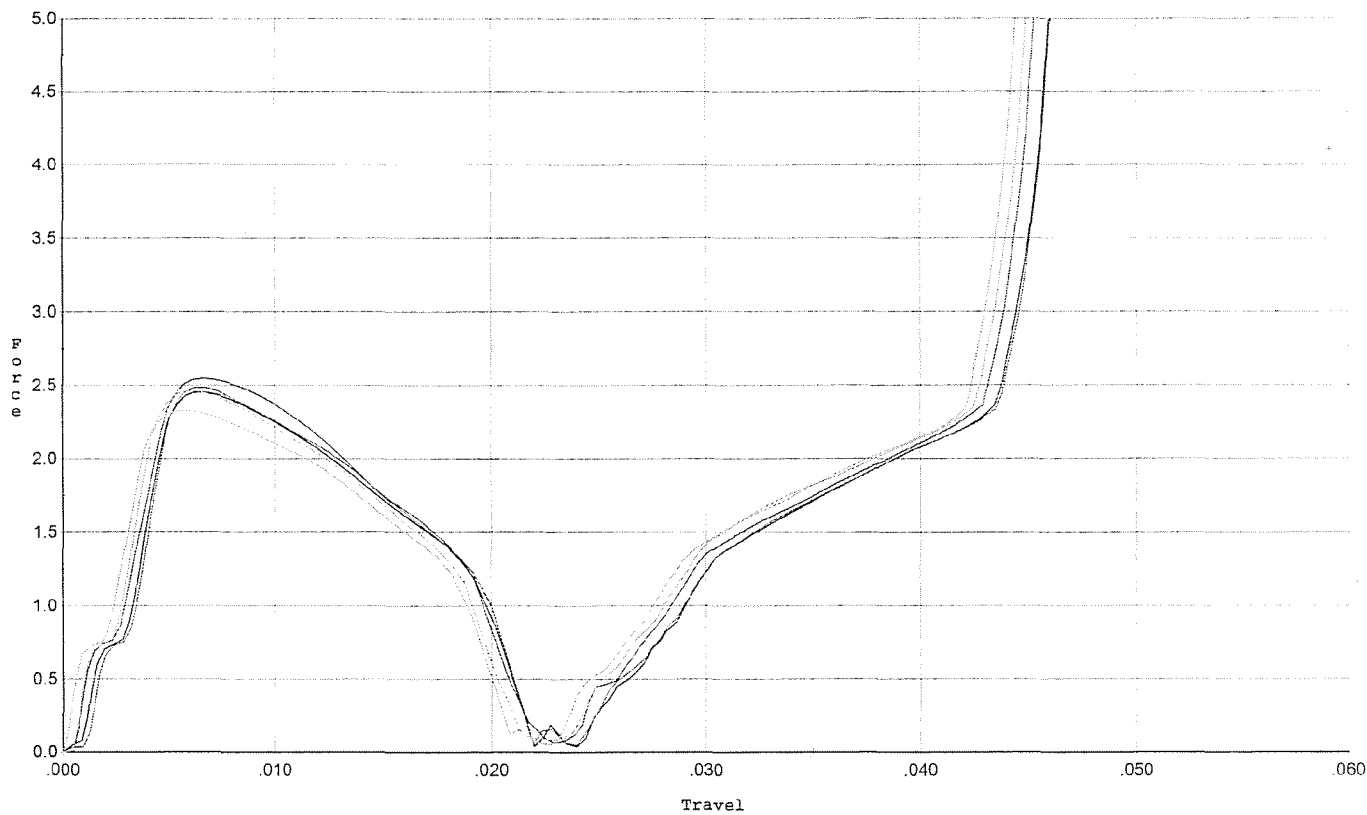
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>7</u> <u>7</u>	4-13-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-13-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	4-13-09	WV
	J) ASSEMBLE STOCK		4-1-09	J.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-13-09	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 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-2-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-2-09	WV
670	FINAL INSPECTION A) HEADSPACE		4-13-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.70</u> <u>2.70</u> <u>2.63</u> <u>2.68</u>	4-4-09	WV
	C) FUNCTION		4-13-09	WV
690	PACK		6/4/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



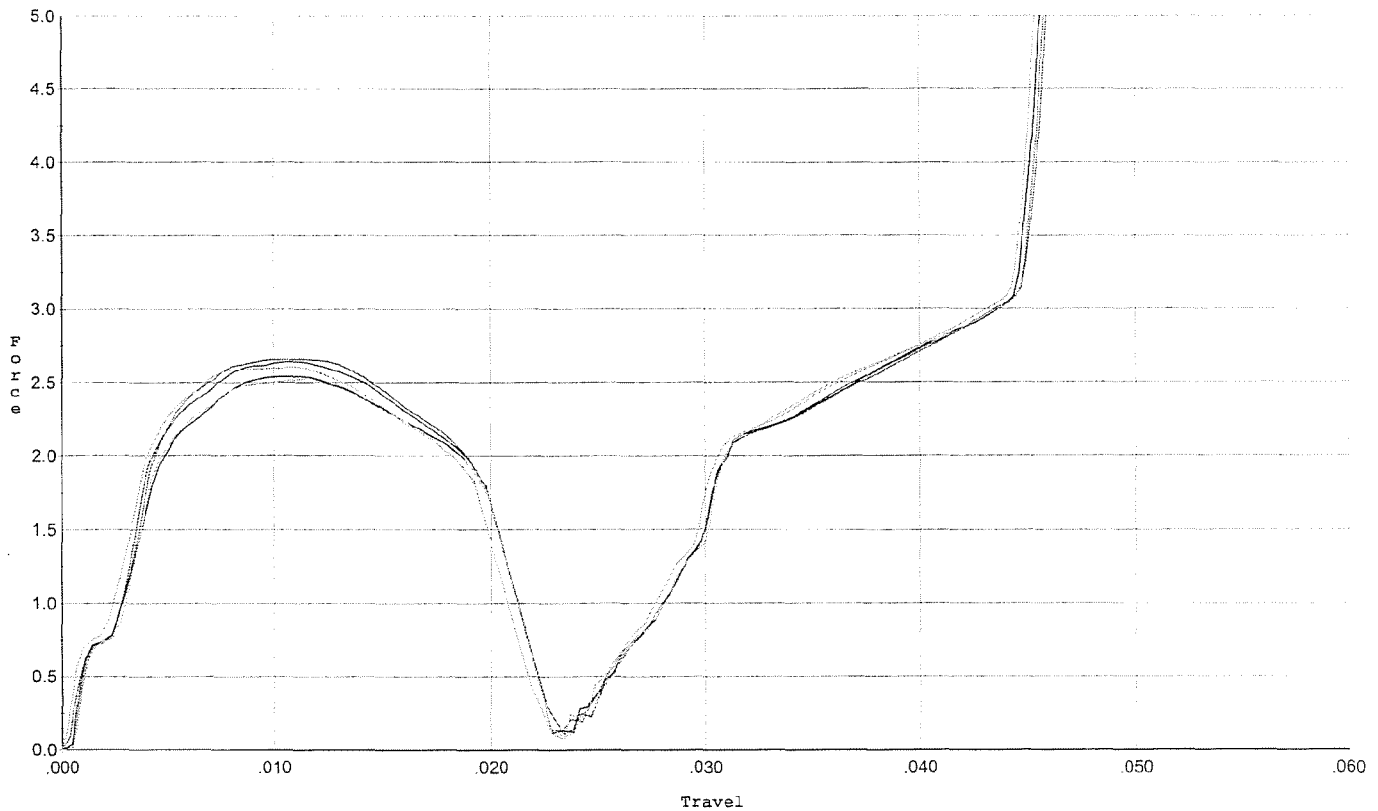
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.019	0.00	0.032	0.033		Set Trigger
2	2.454	0.020	0.00	0.032	0.032		Set Trigger
3	2.486	0.020	0.00	0.032	0.032		Set Trigger
4	2.330	0.019	0.00	0.031	0.031		Set Trigger
5	2.462	0.019	0.00	0.032	0.031		Set Trigger

A-2-45

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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	2.642	0.020	0.00	0.030	0.039		Set Trigger
2	2.542	0.020	0.00	0.030	0.037		Set Trigger
3	2.658	0.020	0.00	0.030	0.039		Set Trigger
4	2.521	0.020	0.00	0.030	0.037		Set Trigger
5	2.607	0.019	0.00	0.030	0.038		Set Trigger

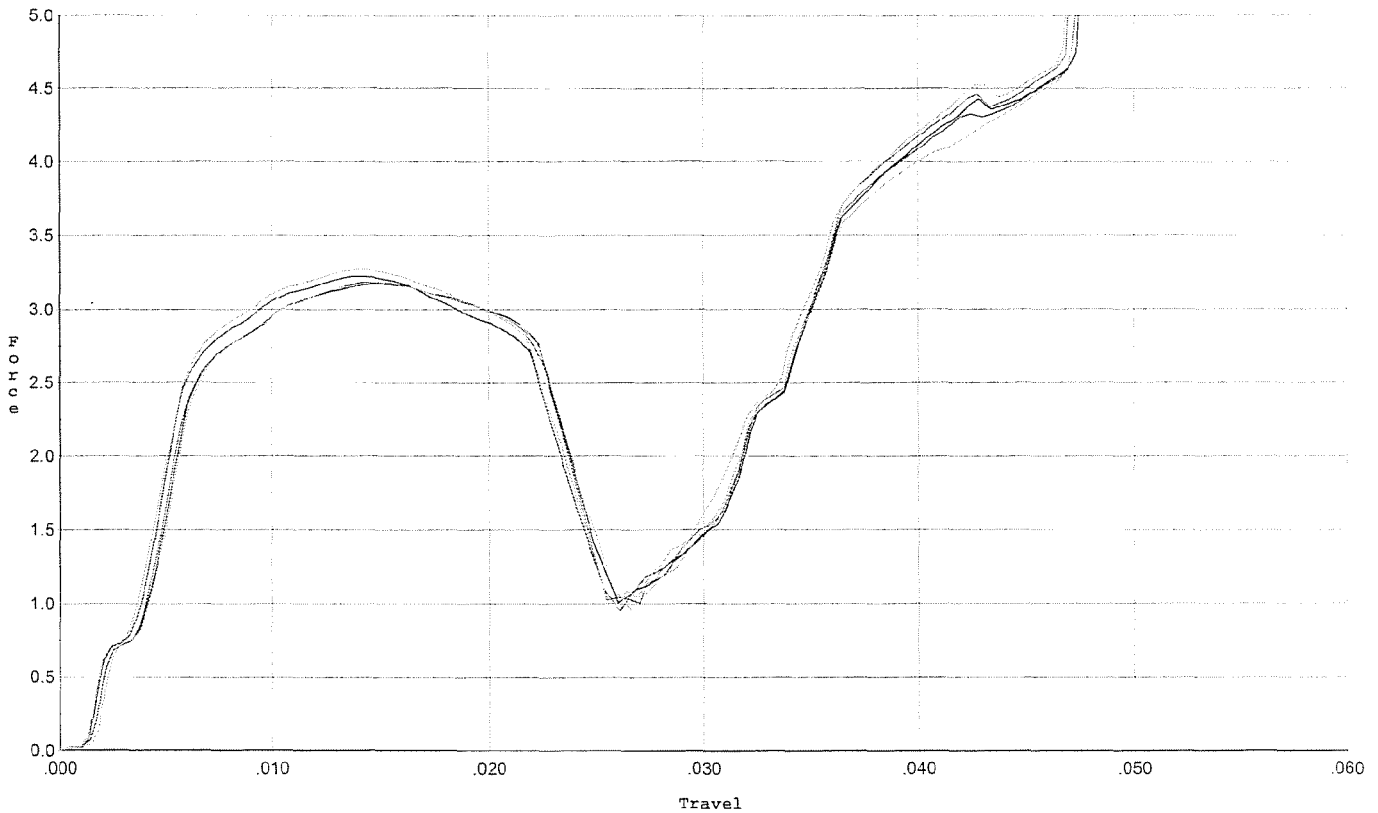
A-2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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

iw
CMS



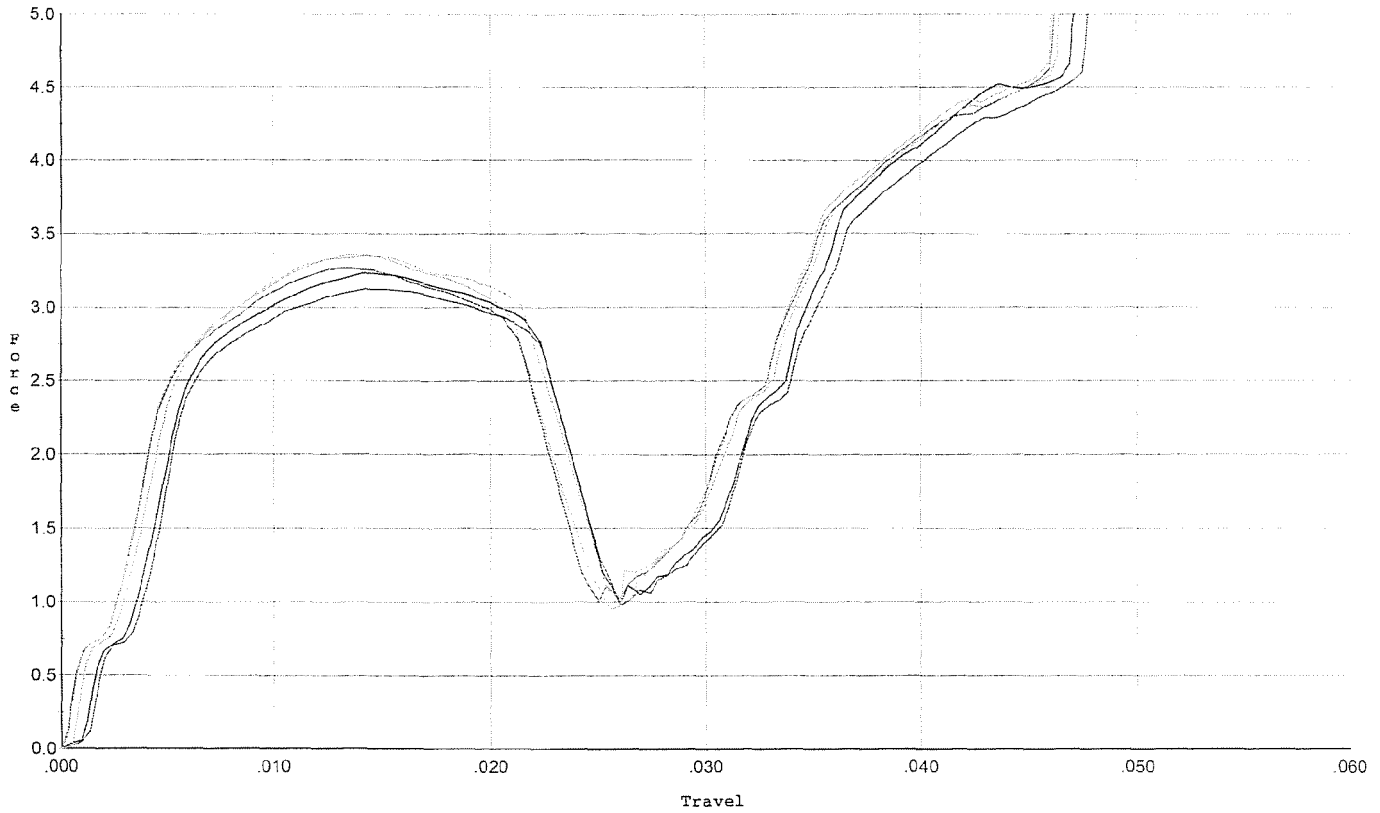
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.223	0.022	0.00	0.029	0.050		Set Trigger
2	3.174	0.022	0.00	0.029	0.050		Set Trigger
3	3.183	0.022	0.00	0.028	0.051		Set Trigger
4	3.181	0.022	0.00	0.029	0.050		Set Trigger
5	3.274	0.023	0.00	0.028	0.055		Set Trigger

A-3.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



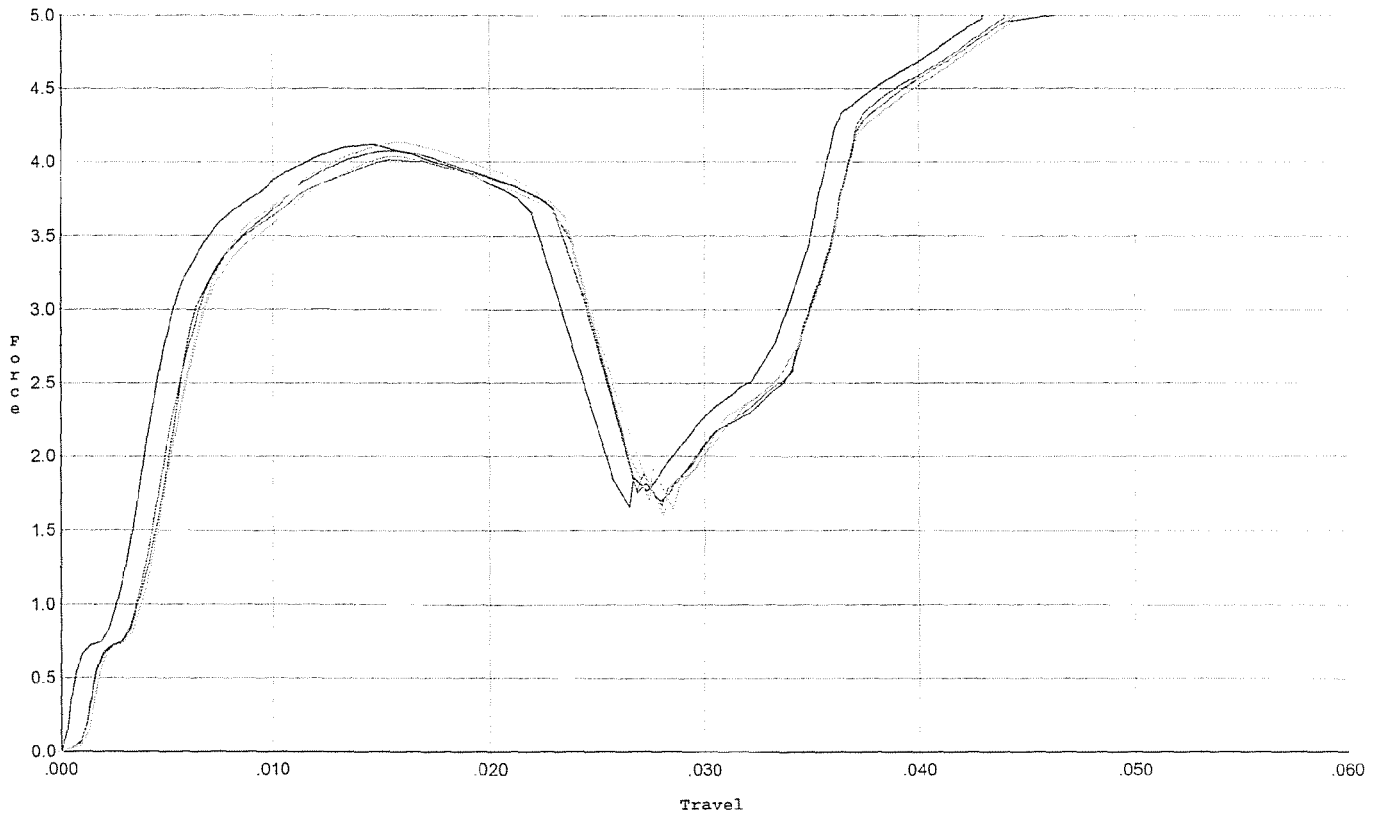
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.124	0.022	0.00	0.029	0.051		Set Trigger
2	3.233	0.022	0.00	0.029	0.052		Set Trigger
3	3.269	0.021	0.00	0.028	0.052		Set Trigger
4	3.359	0.021	0.00	0.028	0.052		Set Trigger
5	3.348	0.023	0.00	0.028	0.057		Set Trigger

A-3-26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



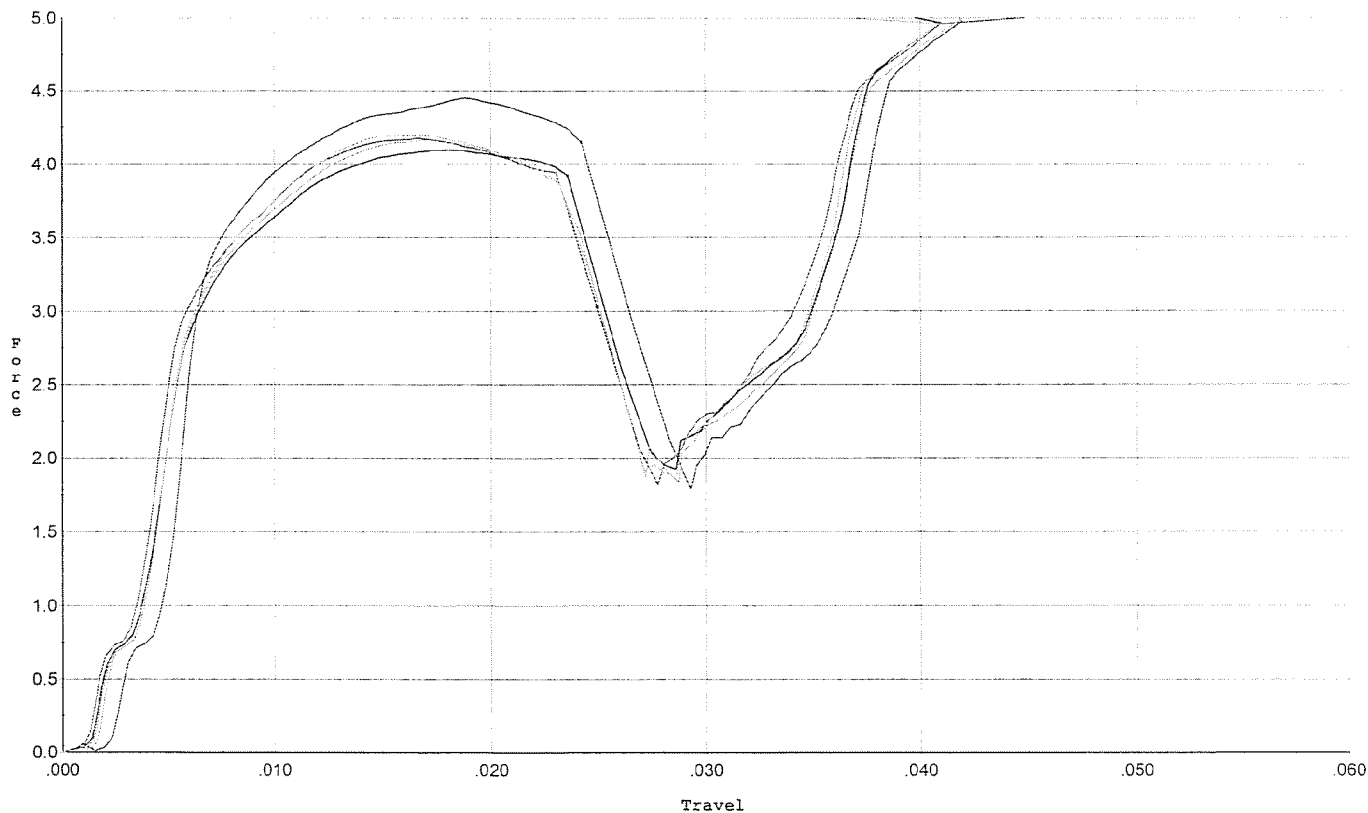
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.073	0.024	0.00	0.022	0.070		Set Trigger
2	4.116	0.022	0.00	0.026	0.066		Set Trigger
3	4.012	0.024	0.00	0.022	0.068		Set Trigger
4	4.134	0.023	0.00	0.022	0.067		Set Trigger
5	4.037	0.024	0.00	0.022	0.067		Set Trigger

A-4.07

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



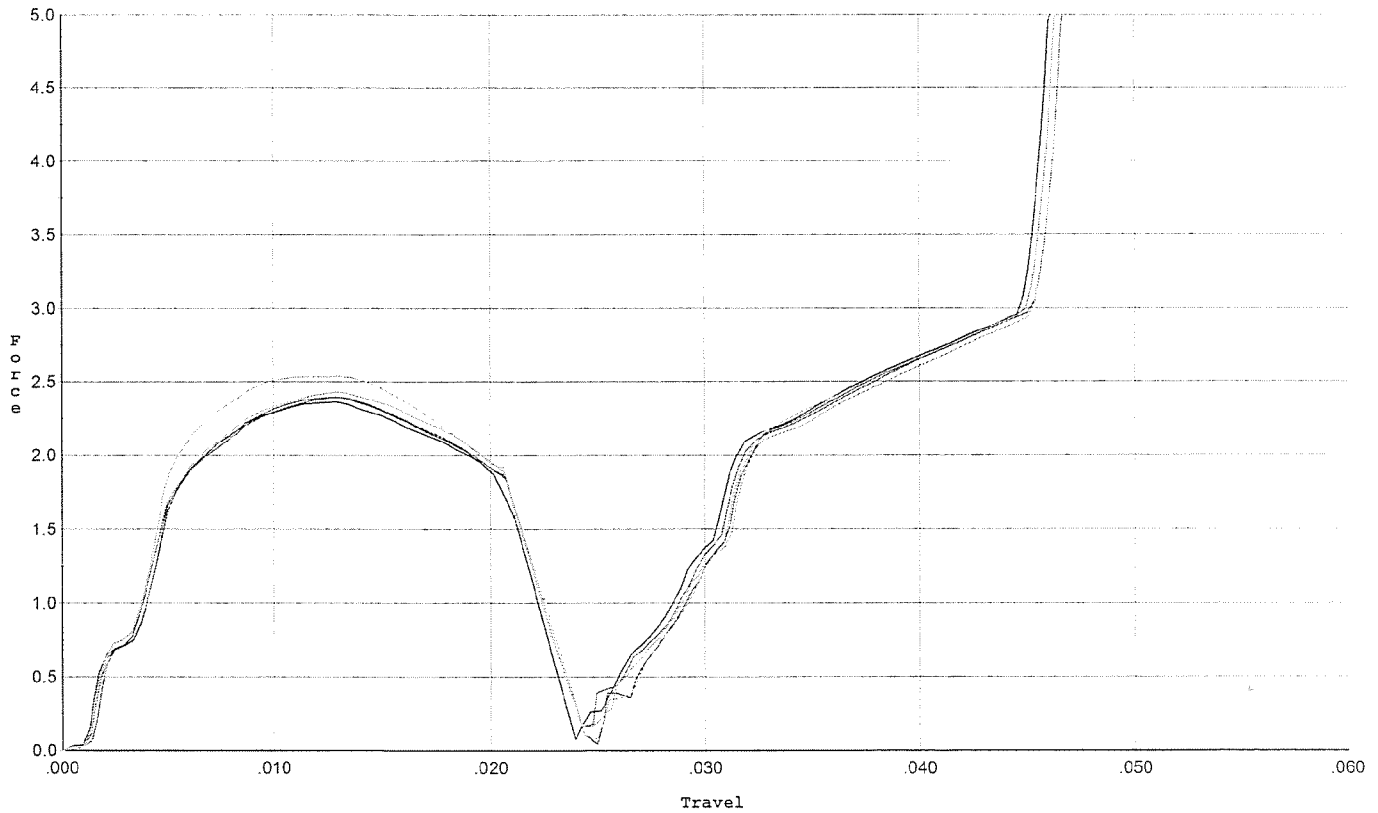
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.452	0.024	0.00	0.021	0.074		Set Trigger
2	4.095	0.024	0.00	0.021	0.069		Set Trigger
3	4.176	0.025	0.00	0.021	0.074		Set Trigger
4	4.196	0.024	0.00	0.022	0.071		Set Trigger
5	4.168	0.024	0.00	0.021	0.072		Set Trigger

A-4.21

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



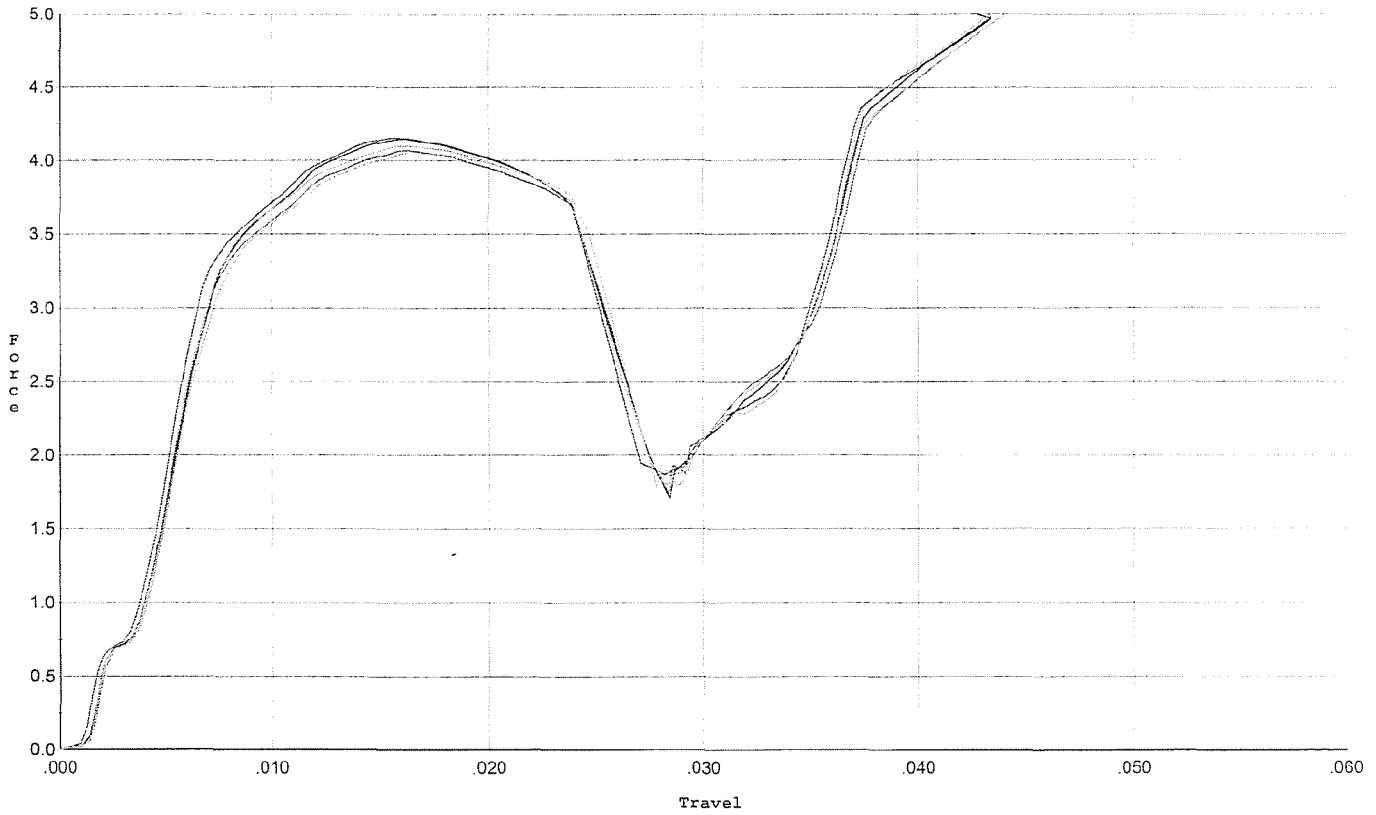
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.394	0.021	0.00	0.031	0.035		Set Trigger
2	2.363	0.021	0.00	0.030	0.036		Set Trigger
3	2.393	0.022	0.00	0.030	0.038		Set Trigger
4	2.536	0.021	0.00	0.030	0.038		Set Trigger
5	2.428	0.021	0.00	0.031	0.036		Set Trigger

A.2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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	4.154	0.024	0.00	0.022	0.070		Set Trigger
2	4.148	0.024	0.00	0.022	0.068		Set Trigger
3	4.066	0.026	0.00	0.022	0.072		Set Trigger
4	4.051	0.025	0.00	0.022	0.070		Set Trigger
5	4.098	0.024	0.00	0.022	0.068		Set Trigger

A-4.10