

G6845279

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

- INSTRUCTION BOOK 3518

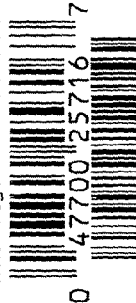


proof of



G6845279

owner registration sticker



G6845279

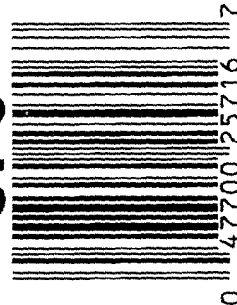
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6845279

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845279

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		3-18-09	RT
475	DRILL AND TAP SIGHT HOLES		3-19-09	SP
480	MAGNAFLUX BBL ACTION		3-20-09	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		2-27	
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

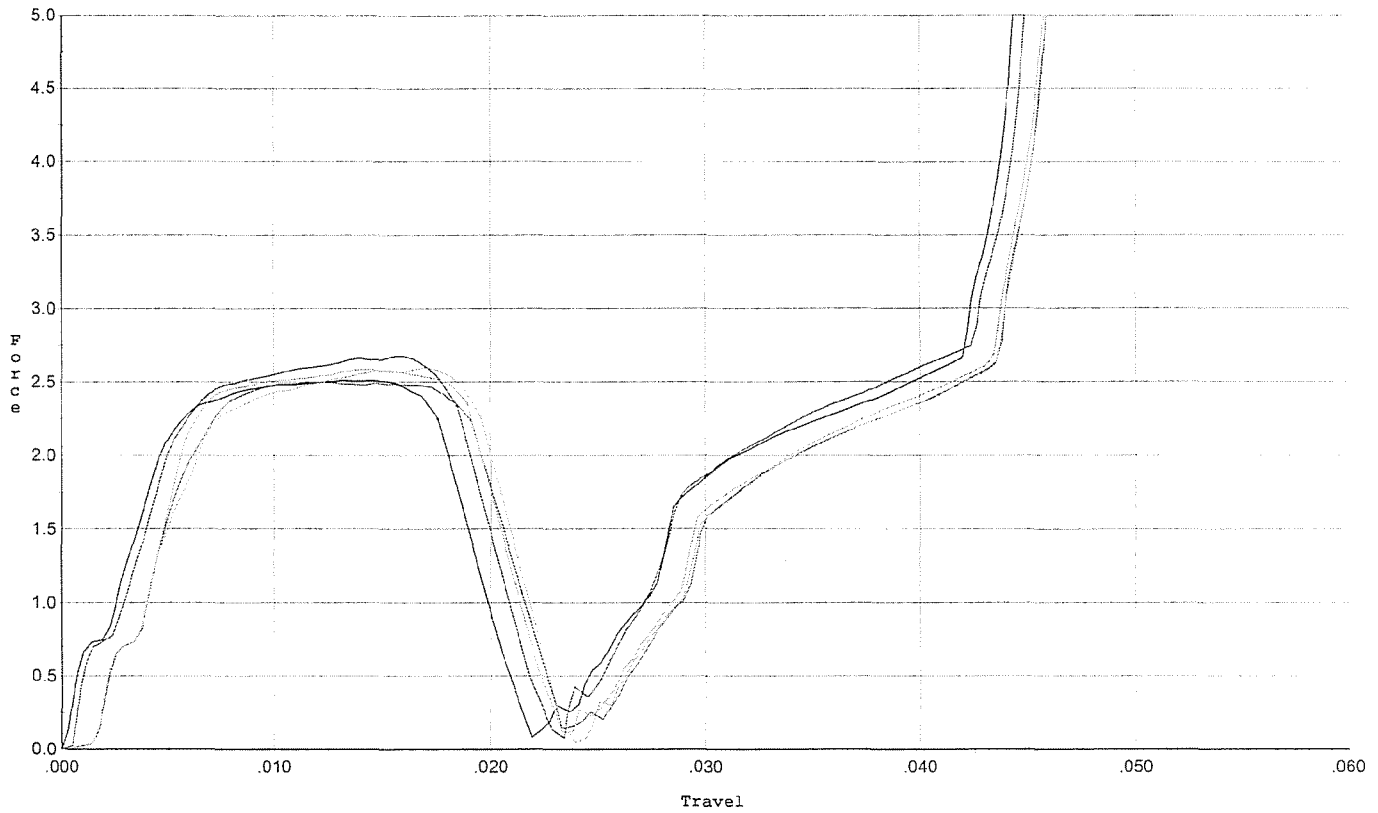
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>55</u> <u>6</u>	4-13-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3-5</u> <u>3.5</u> <u>3.5</u>	4-13-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-13-09	WN
	J) ASSEMBLE STOCK		4-1-09	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-13-09	WN
	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	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-2-09	WN
670	FINAL INSPECTION A) HEADSPACE		4-13-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.33</u> <u>2.43</u> <u>2.39</u> <u>2.42</u>	4-7-09	RP
	C) FUNCTION		4-13-09	WN
690	PACK		6/1/09	Fm

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



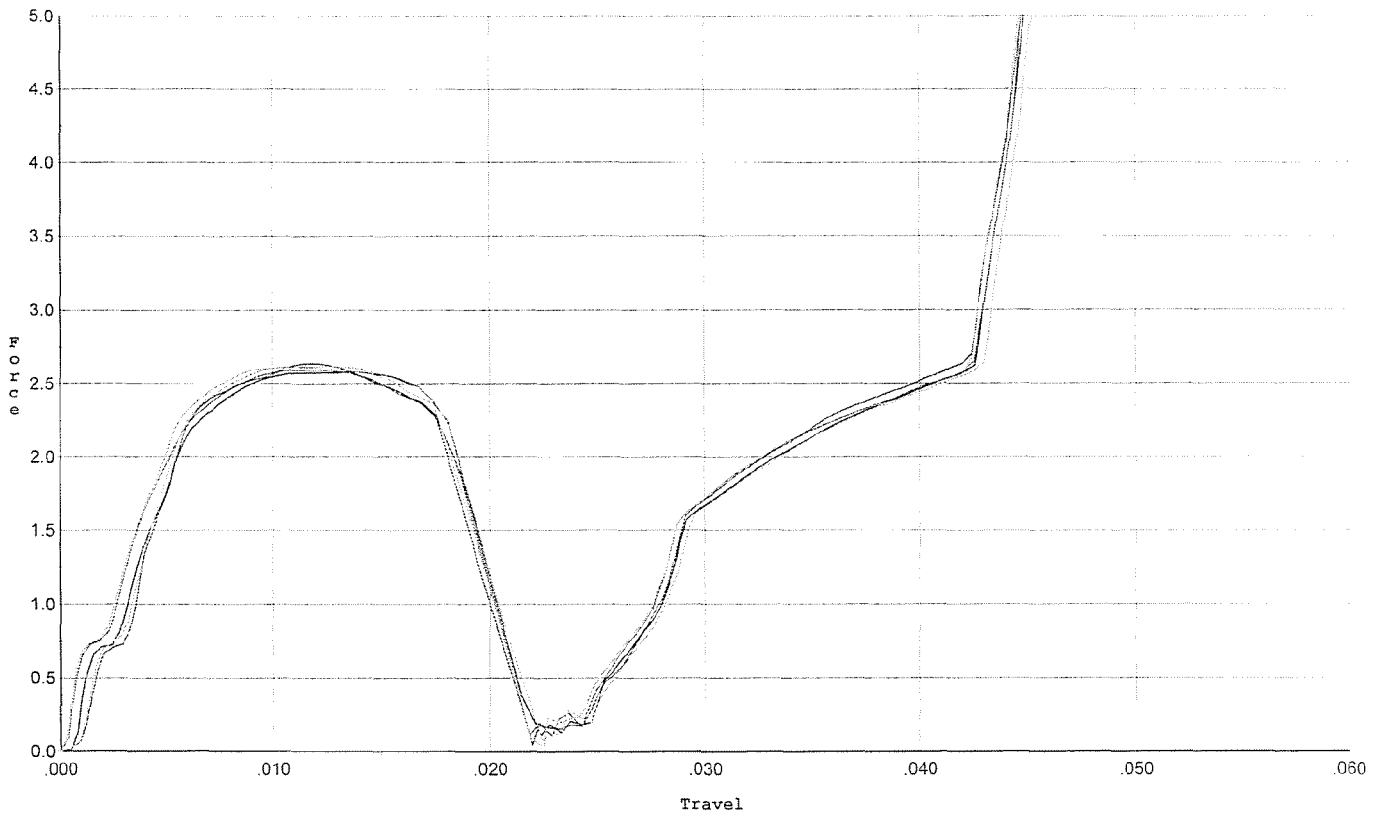
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.677	0.018	0.00	0.030	0.036		Set Trigger
2	2.510	0.018	0.00	0.030	0.034		Set Trigger
3	2.499	0.019	0.00	0.031	0.034		Set Trigger
4	2.599	0.020	0.00	0.030	0.036		Set Trigger
5	2.585	0.019	0.00	0.030	0.035		Set Trigger

A-2.57

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



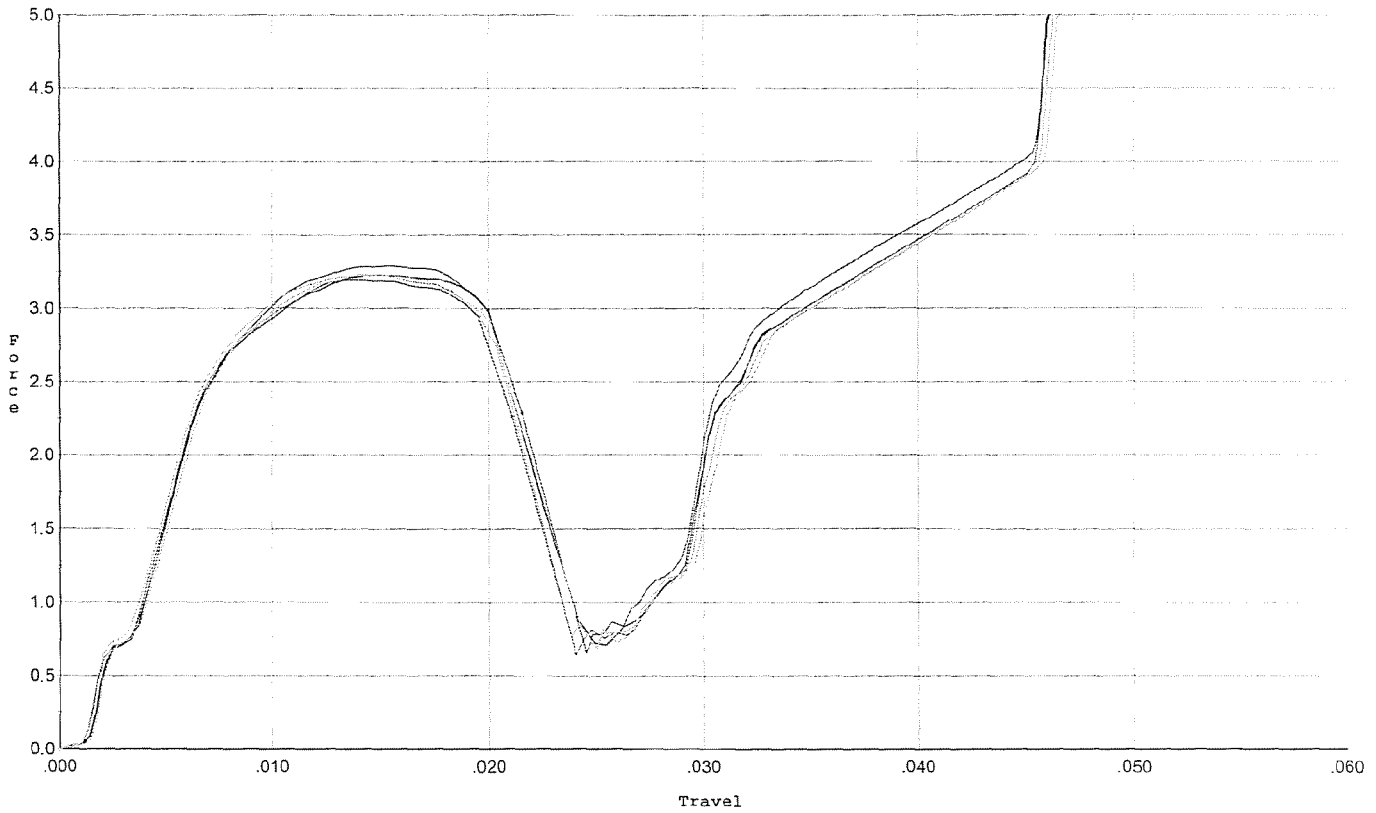
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.638	0.019	0.00	0.030	0.035		Set Trigger
2	2.582	0.018	0.00	0.030	0.034		Set Trigger
3	2.594	0.018	0.00	0.031	0.034		Set Trigger
4	2.613	0.018	0.00	0.031	0.034		Set Trigger
5	2.622	0.019	0.00	0.030	0.038		Set Trigger

A-2-61

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 ini +/- .75 lb



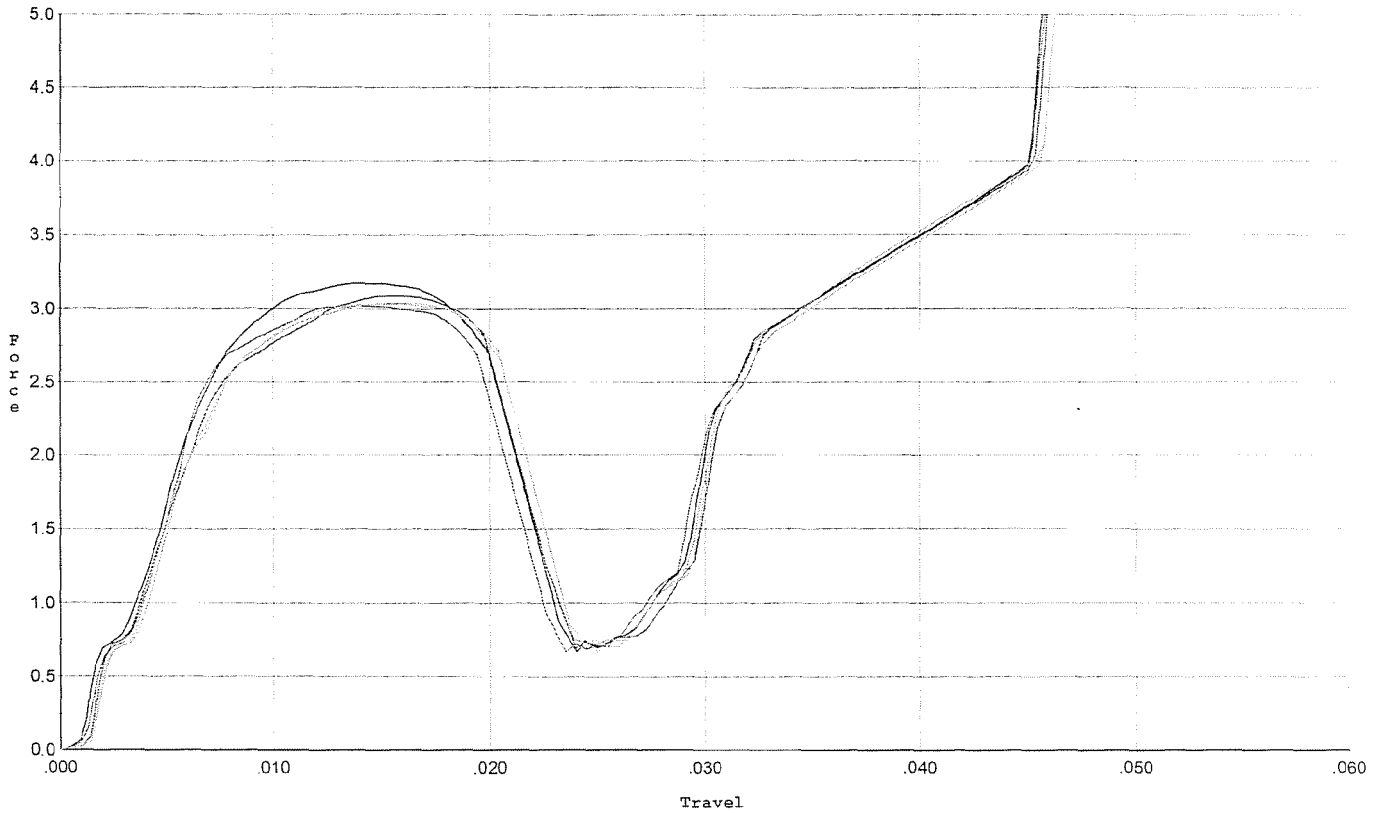
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.290	0.022	0.00	0.029	0.048		Set Trigger
2	3.227	0.020	0.00	0.029	0.044		Set Trigger
3	3.194	0.021	0.00	0.029	0.046		Set Trigger
4	3.233	0.020	0.00	0.030	0.044		Set Trigger
5	3.226	0.020	0.00	0.029	0.046		Set Trigger

A-3.23

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



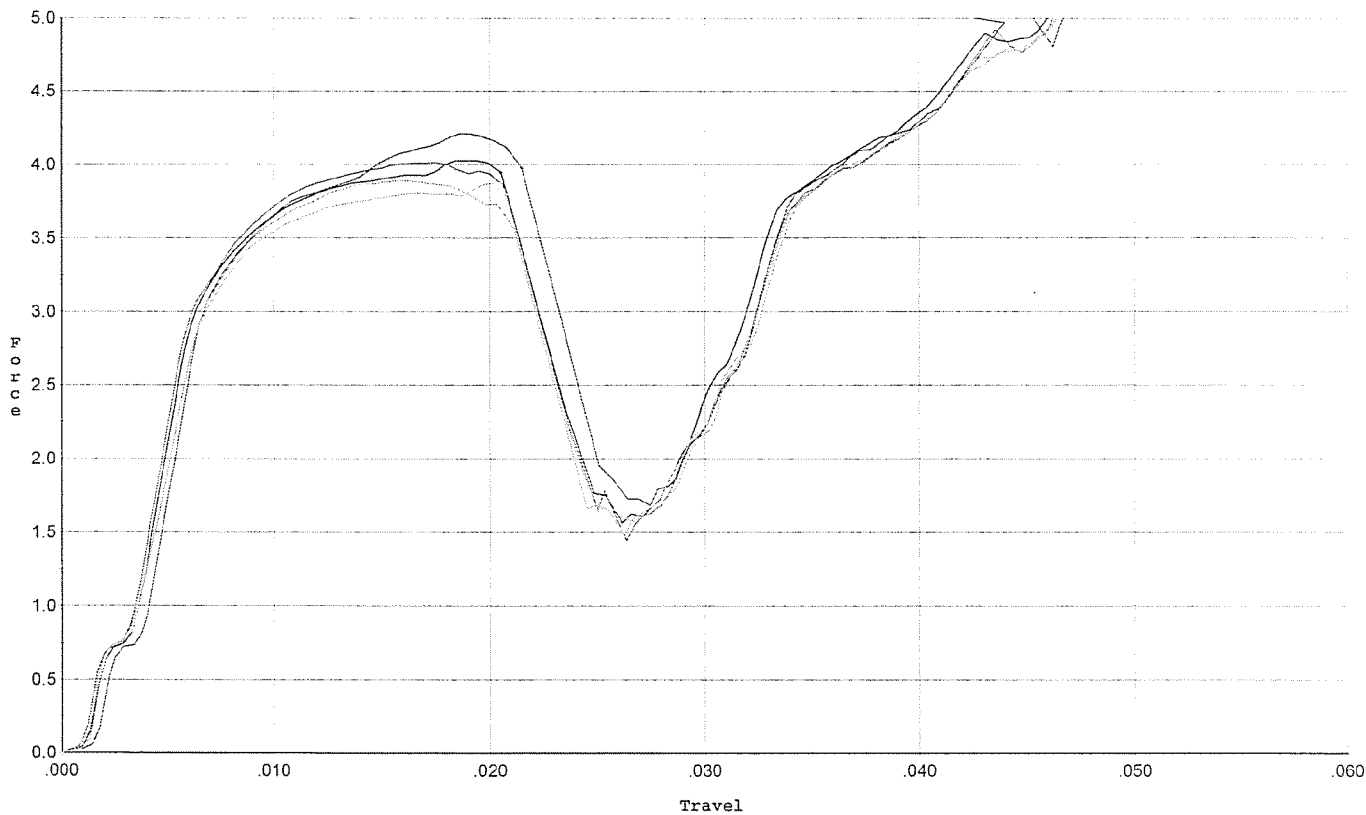
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.086	0.020	0.00	0.030	0.042		Set Trigger
2	3.171	0.020	0.00	0.029	0.044		Set Trigger
3	3.019	0.019	0.00	0.029	0.041		Set Trigger
4	3.039	0.020	0.00	0.030	0.043		Set Trigger
5	3.034	0.020	0.00	0.029	0.043		Set Trigger

A-3-07

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 ini +/- 1.0 lb



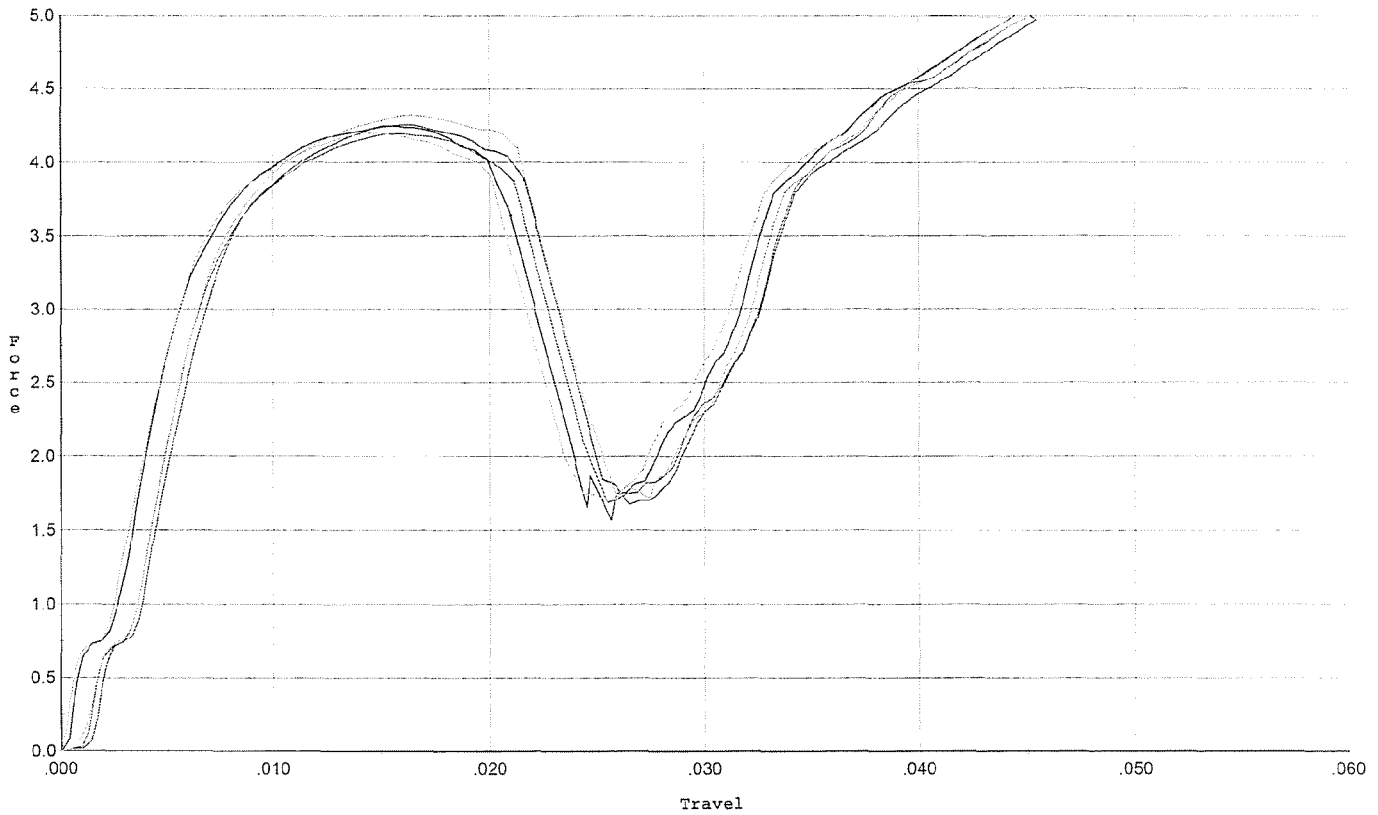
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.209	0.021	0.00	0.026	0.060		Set Trigger
2	4.026	0.020	0.00	0.027	0.057		Set Trigger
3	4.013	0.021	0.00	0.027	0.058		Set Trigger
4	3.877	0.021	0.00	0.028	0.056		Set Trigger
5	3.889	0.021	0.00	0.027	0.057		Set Trigger

A-4.00

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



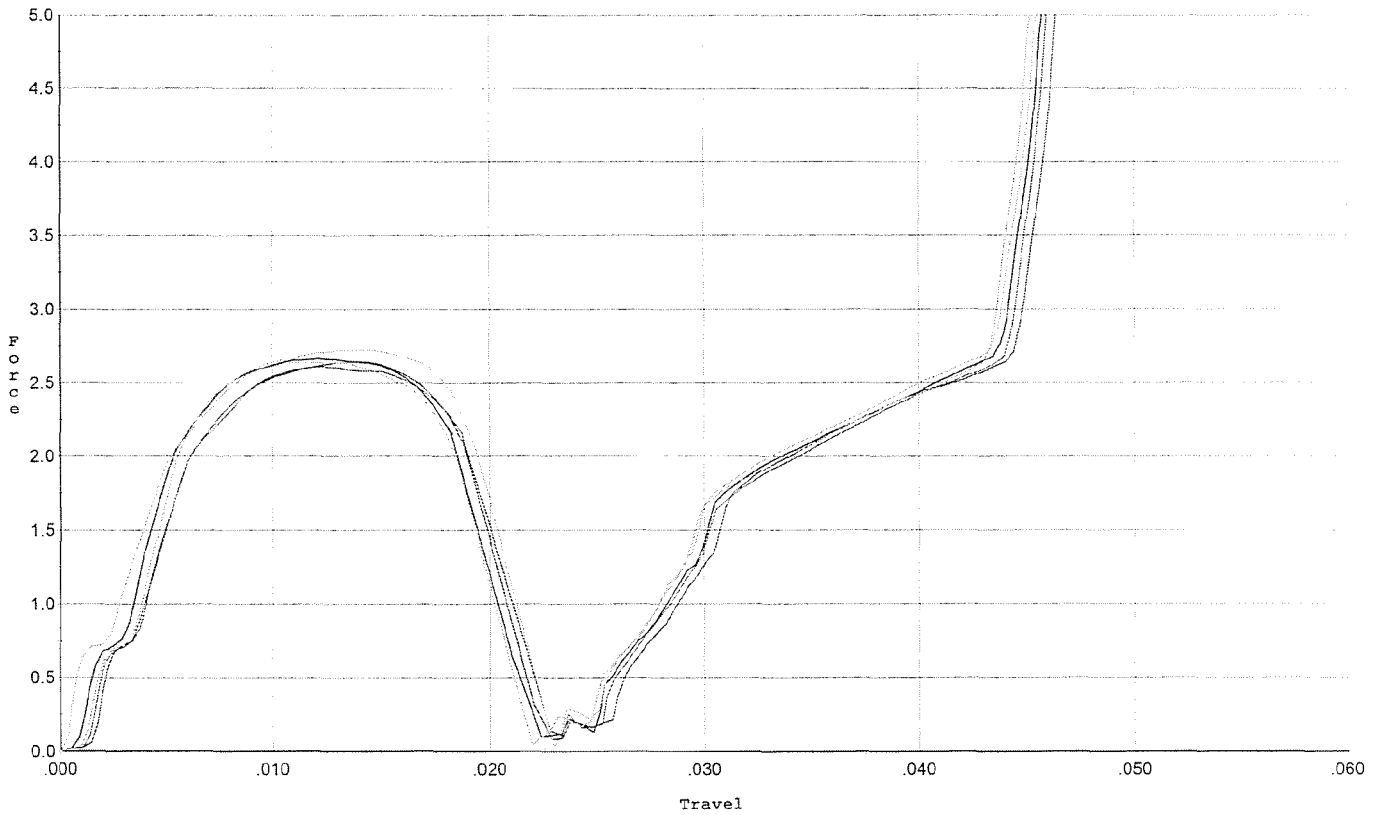
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.253	0.022	0.00	0.026	0.062		Set Trigger
2	4.245	0.021	0.00	0.026	0.063		Set Trigger
3	4.194	0.021	0.00	0.026	0.061		Set Trigger
4	4.201	0.020	0.00	0.026	0.060		Set Trigger
5	4.321	0.021	0.00	0.026	0.063		Set Trigger

A-4-24

Trigger Profile [lbs,inch]

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

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



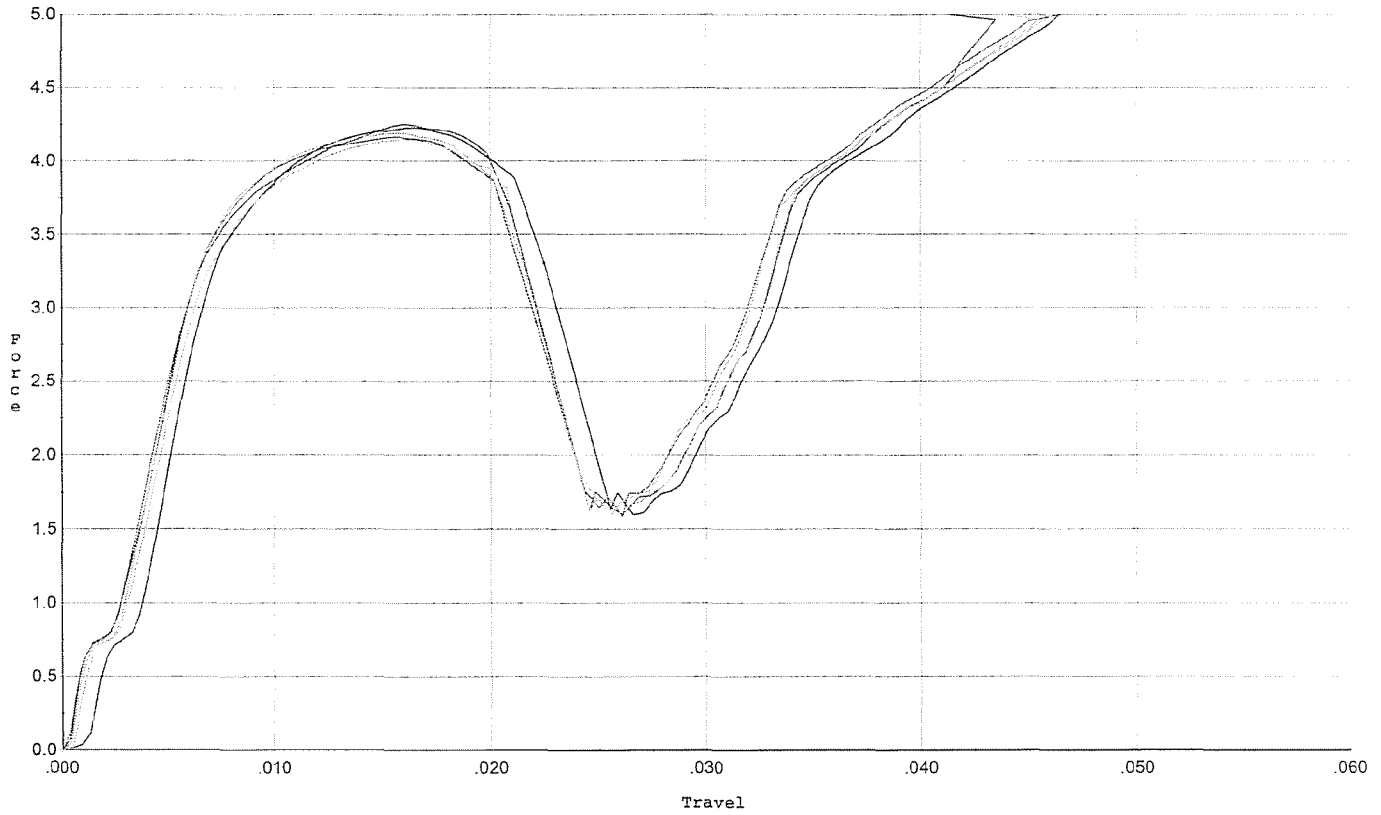
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.019	0.00	0.031	0.034		Set Trigger
2	2.663	0.018	0.00	0.031	0.035		Set Trigger
3	2.609	0.021	0.00	0.031	0.037		Set Trigger
4	2.726	0.019	0.00	0.030	0.037		Set Trigger
5	2.640	0.018	0.00	0.031	0.036		Set Trigger

A-2-65

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	4.249	0.021	0.00	0.026	0.062		Set Trigger
2	4.228	0.022	0.00	0.027	0.065		Set Trigger
3	4.161	0.022	0.00	0.026	0.065		Set Trigger
4	4.146	0.021	0.00	0.027	0.060		Set Trigger
5	4.190	0.021	0.00	0.027	0.063		Set Trigger

A-4.19