

G684 5293

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



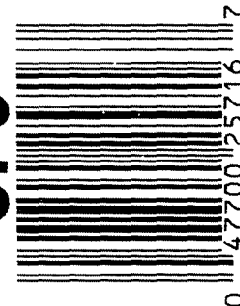
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845293

UPC



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845293

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	RZ
475	DRILL AND TAP SIGHT HOLES		3-19-09	
480	MAGNAFLUX BBL ACTION		3-20-09	(N)
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

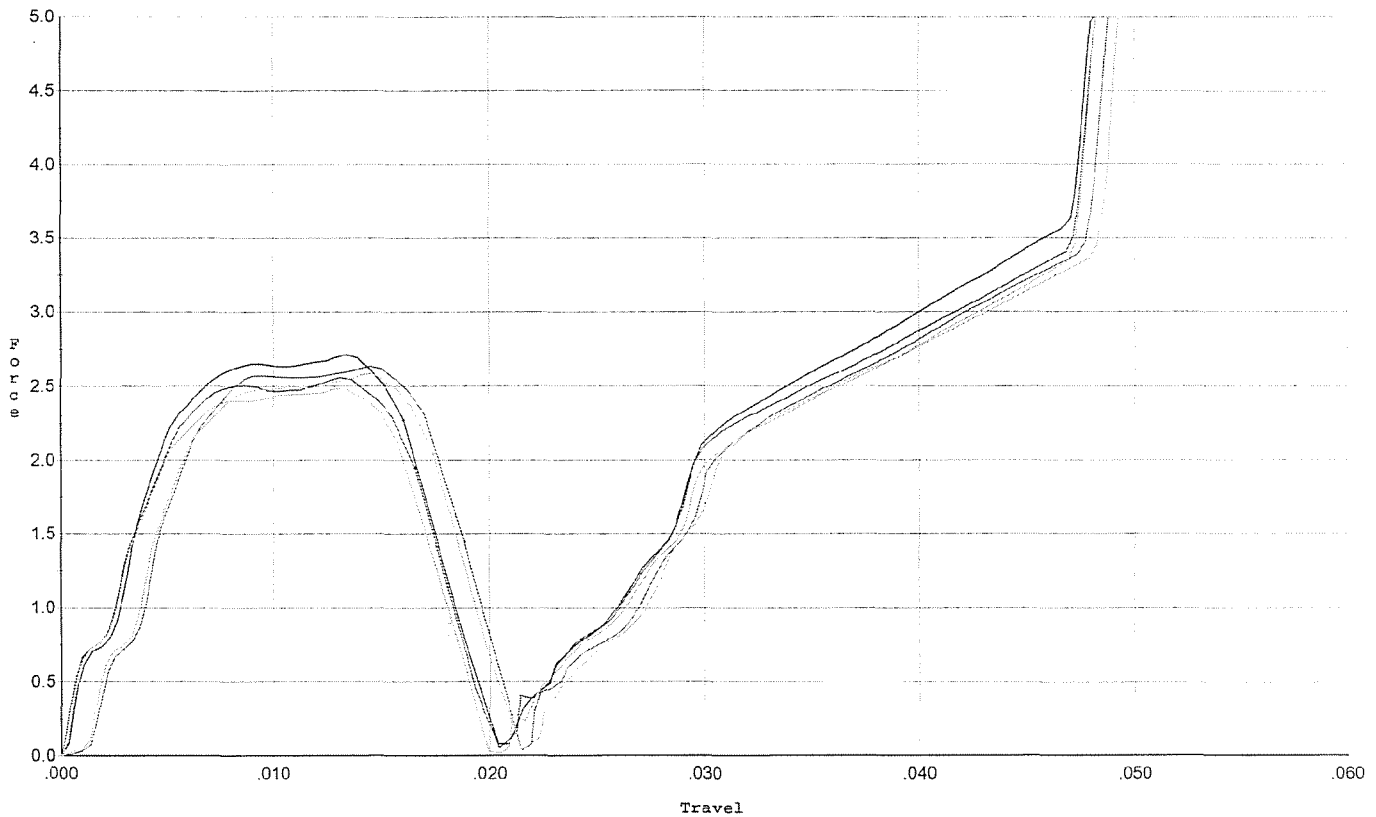
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	4-13-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-13-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-13-09	WV
	J) ASSEMBLE STOCK		4-1-09	L.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			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.89</u> <u>2.84</u> <u>2.89</u> <u>2.48</u> <u>2.87</u>	4-7-09	RP
	C) FUNCTION		4-13-09	WV
690	PACK		6/1/09	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



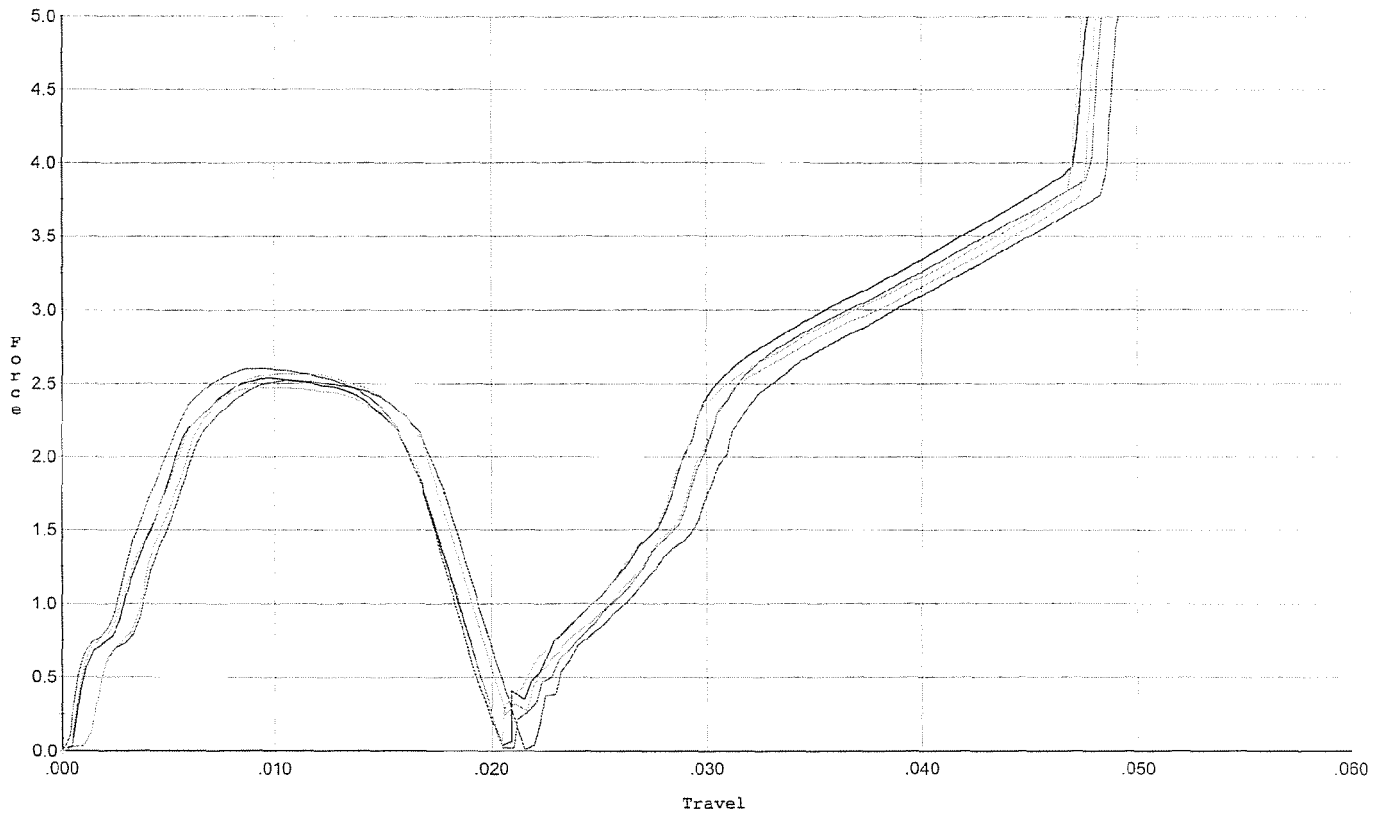
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.017	0.00	0.035	0.031		Set Trigger
2	2.713	0.016	0.00	0.035	0.031		Set Trigger
3	2.633	0.019	0.00	0.034	0.034		Set Trigger
4	2.585	0.017	0.00	0.035	0.031		Set Trigger
5	2.490	0.018	0.00	0.035	0.032		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: 2.5 lbs after 50 cycles+/- .50 lb



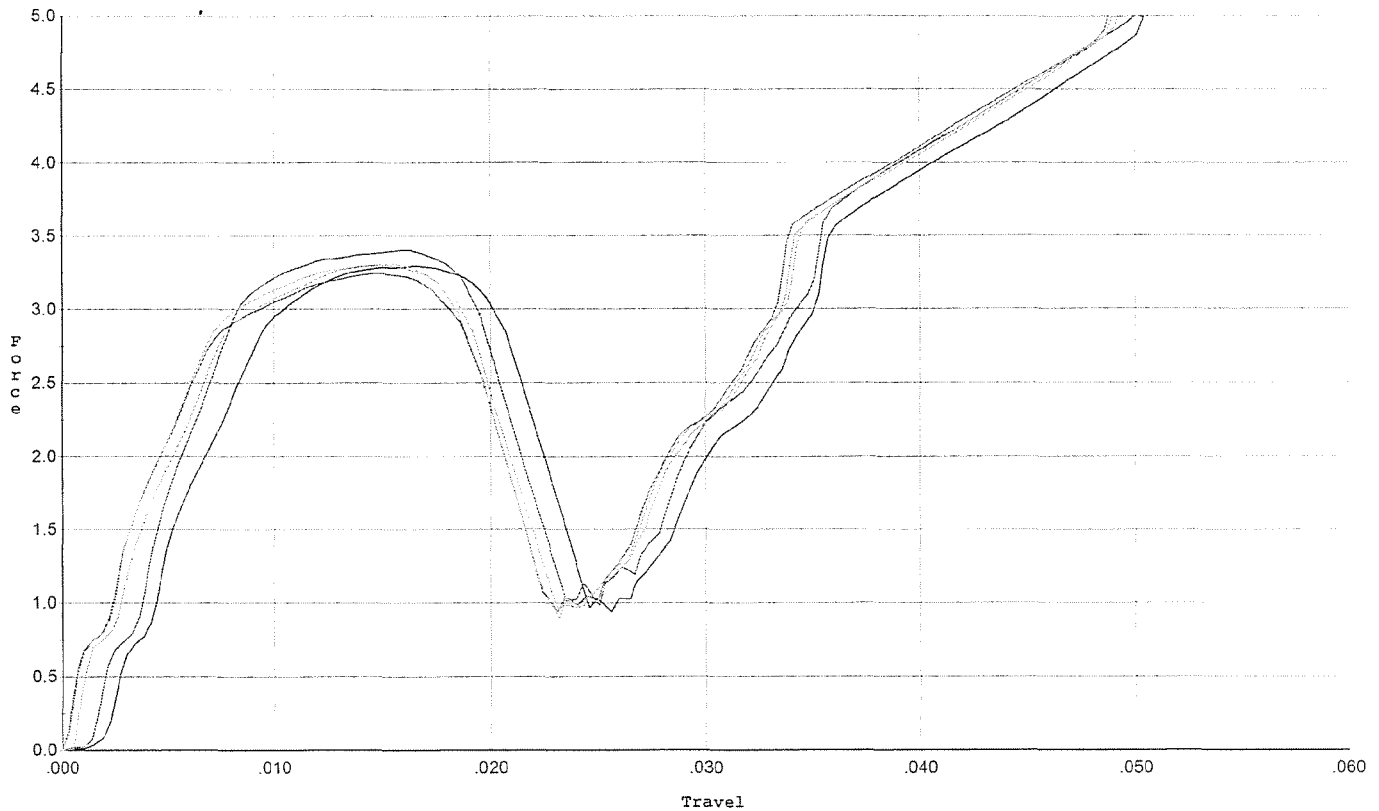
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.528	0.018	0.00	0.034	0.031		Set Trigger
2	2.542	0.019	0.00	0.033	0.033		Set Trigger
3	2.599	0.017	0.00	0.035	0.032		Set Trigger
4	2.475	0.018	0.00	0.033	0.033		Set Trigger
5	2.569	0.019	0.00	0.033	0.033		Set Trigger

A-2-53

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



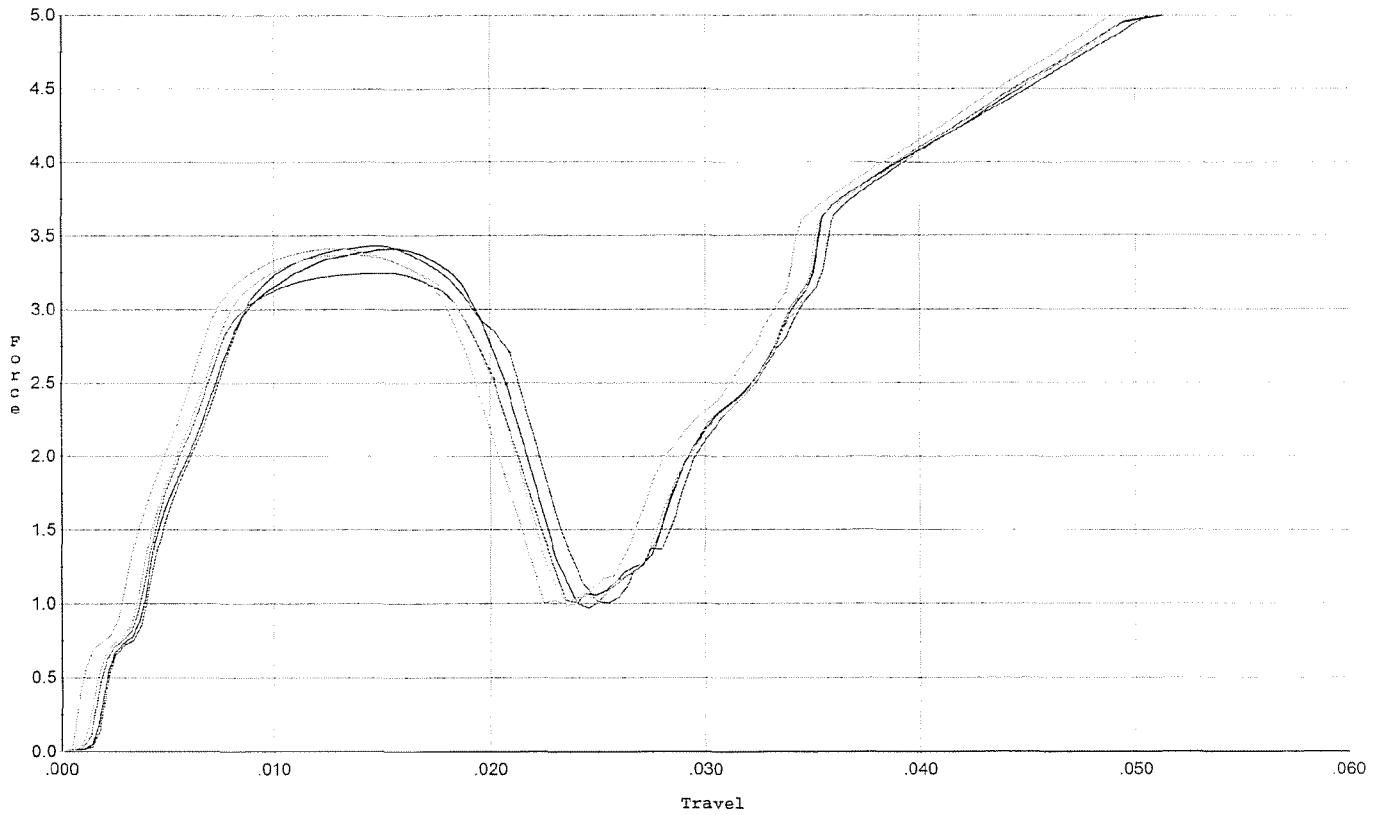
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.400	0.019	0.00	0.032	0.045		Set Trigger
2	3.293	0.022	0.00	0.032	0.049		Set Trigger
3	3.241	0.020	0.00	0.031	0.046		Set Trigger
4	3.307	0.020	0.00	0.032	0.047		Set Trigger
5	3.295	0.019	0.00	0.032	0.044		Set Trigger

A-3-30

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



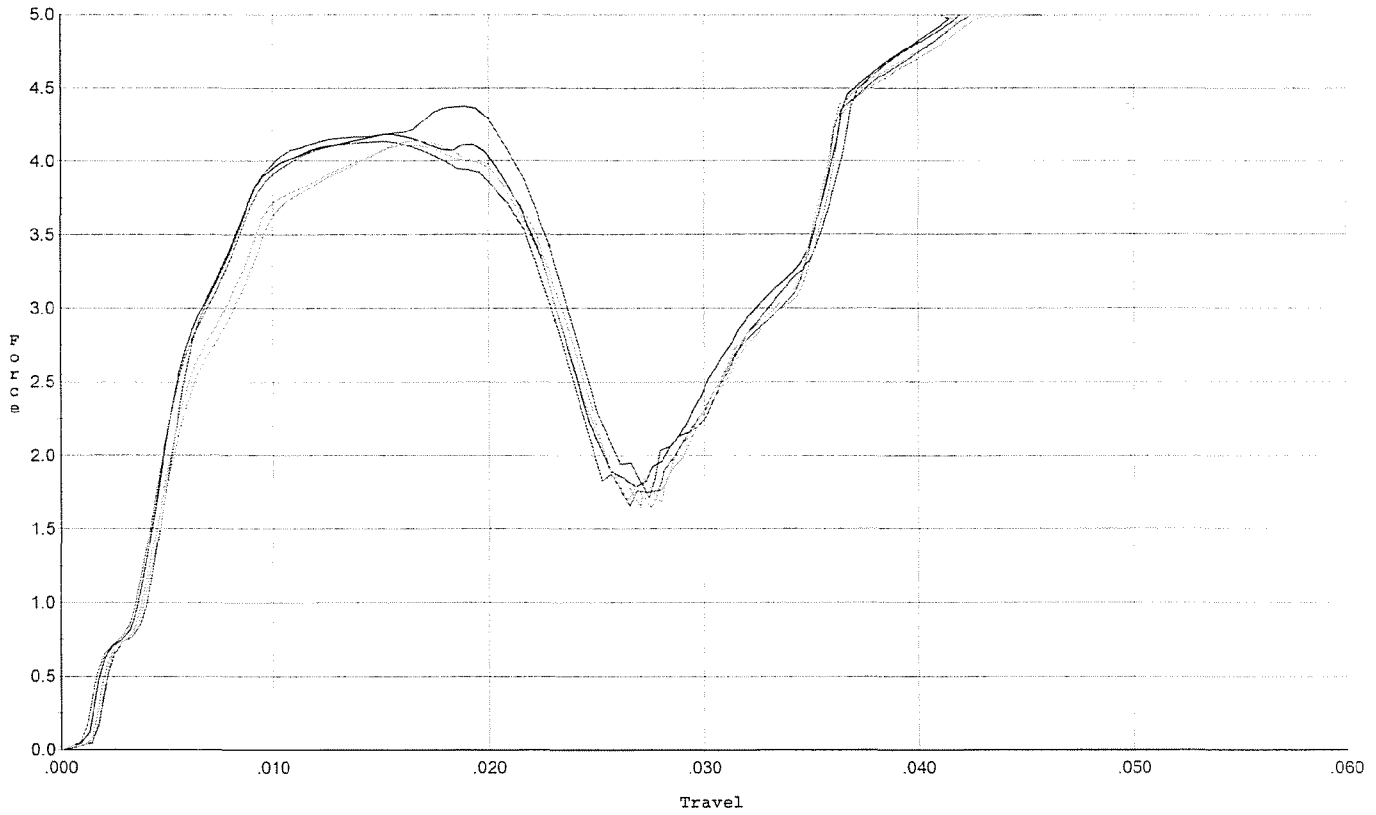
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.434	0.021	0.00	0.032	0.048		Set Trigger
2	3.410	0.021	0.00	0.032	0.047		Set Trigger
3	3.242	0.020	0.00	0.032	0.045		Set Trigger
4	3.371	0.020	0.00	0.032	0.047		Set Trigger
5	3.412	0.021	0.00	0.031	0.049		Set Trigger

A.3-37

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



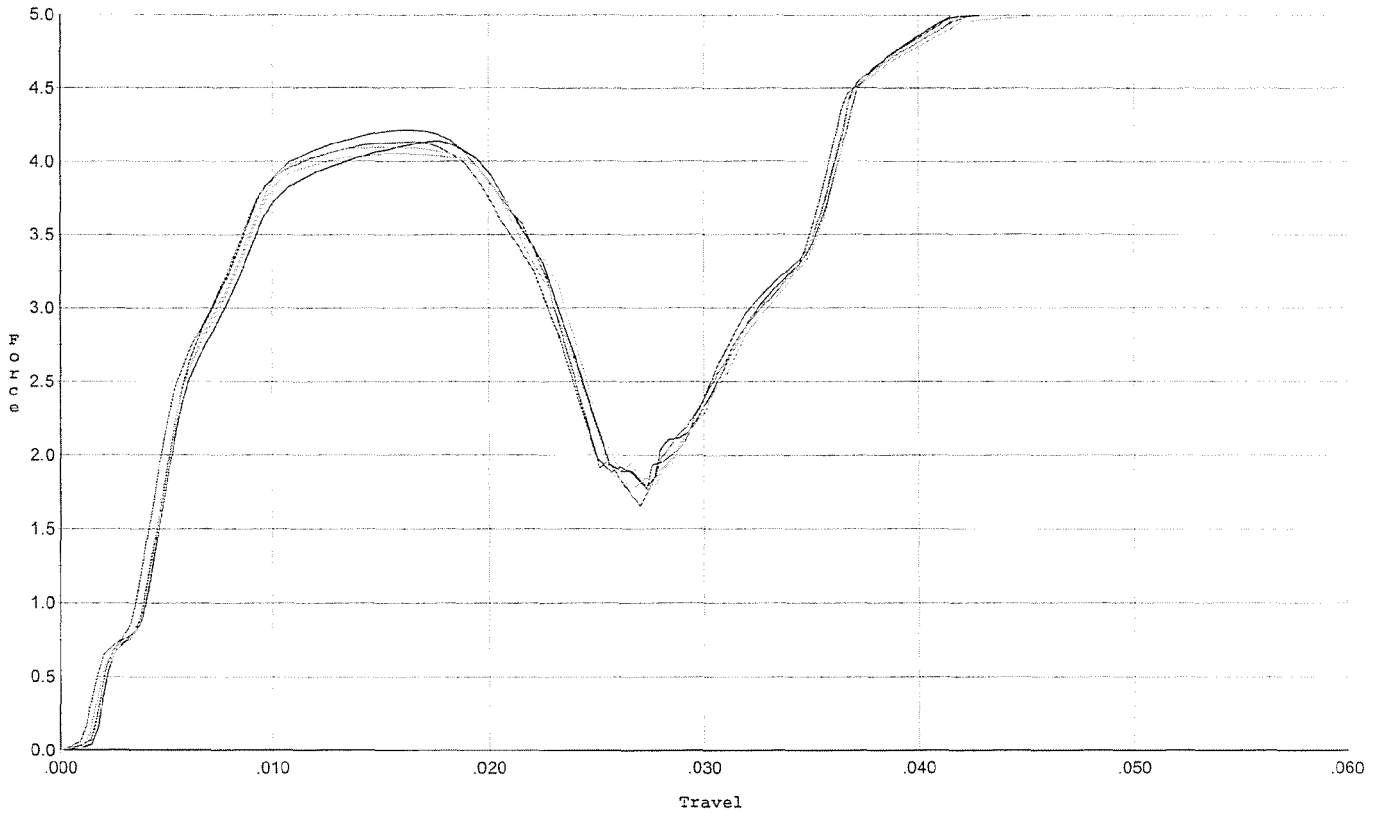
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.372	0.023	0.00	0.029	0.066		Set Trigger
2	4.182	0.022	0.00	0.029	0.064		Set Trigger
3	4.134	0.023	0.00	0.029	0.065		Set Trigger
4	4.107	0.022	0.00	0.029	0.062		Set Trigger
5	4.140	0.024	0.00	0.029	0.065		Set Trigger

A = 4.18

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



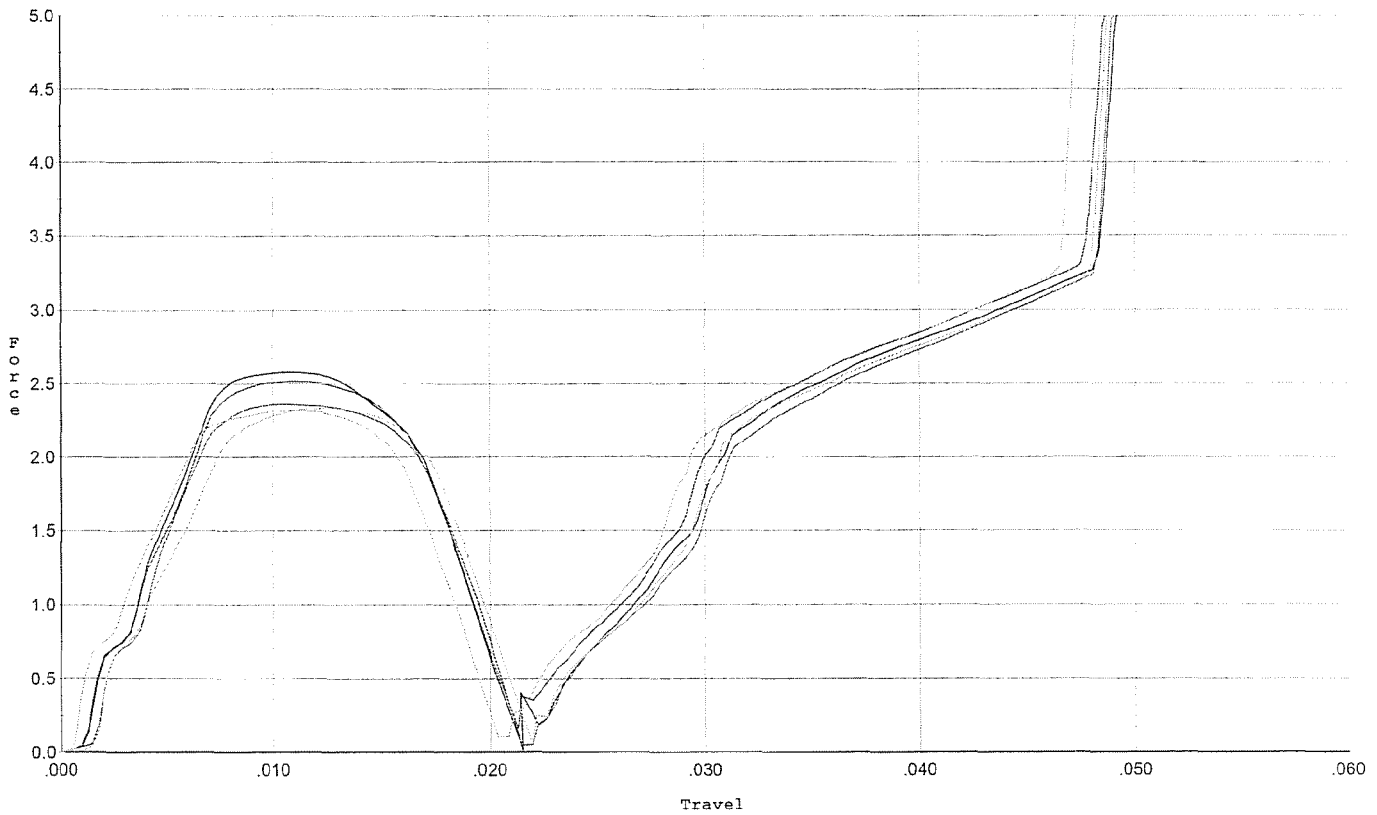
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.213	0.023	0.00	0.029	0.064		Set Trigger
2	4.139	0.024	0.00	0.029	0.066		Set Trigger
3	4.134	0.023	0.00	0.029	0.065		Set Trigger
4	4.054	0.023	0.00	0.029	0.065		Set Trigger
5	4.096	0.024	0.00	0.029	0.067		Set Trigger

A-4012

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



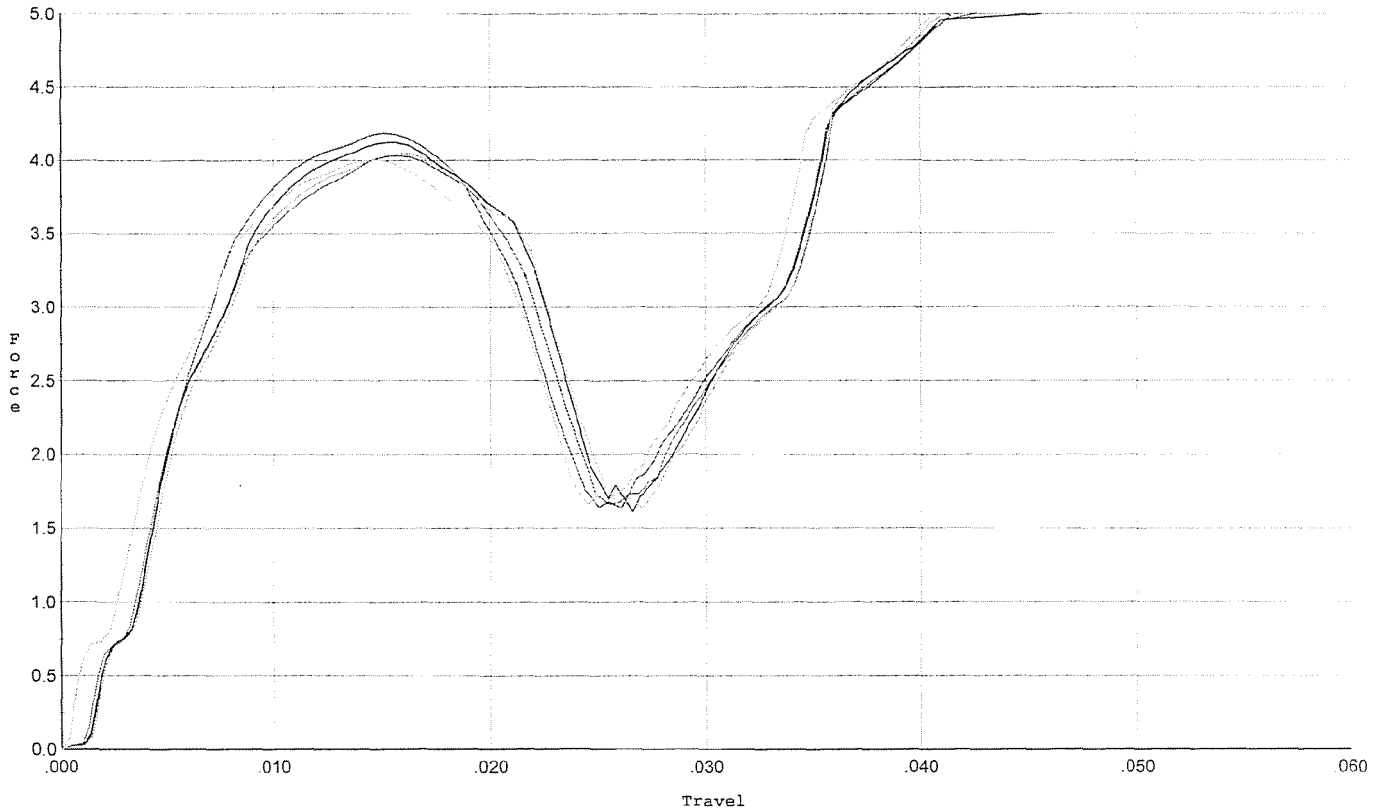
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.516	0.018	0.00	0.034	0.032		Set Trigger
2	2.580	0.018	0.00	0.035	0.032		Set Trigger
3	2.362	0.019	0.00	0.034	0.031		Set Trigger
4	2.332	0.019	0.00	0.034	0.030		Set Trigger
5	2.324	0.019	0.00	0.033	0.031		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	4.188	0.021	0.00	0.030	0.058		Set Trigger
2	4.123	0.022	0.00	0.029	0.061		Set Trigger
3	4.032	0.022	0.00	0.029	0.058		Set Trigger
4	4.004	0.022	0.00	0.029	0.060		Set Trigger
5	4.043	0.022	0.00	0.029	0.059		Set Trigger

A. 4.07