

G6845296

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



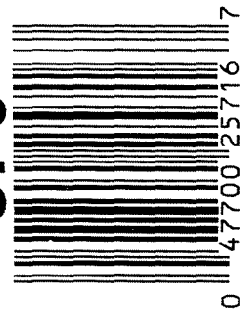
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845296

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6845296

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SP
430	ASSEMBLE TO STOCK		3-17-09	KP
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	RJC
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/20/09	
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		4-9-09	LN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

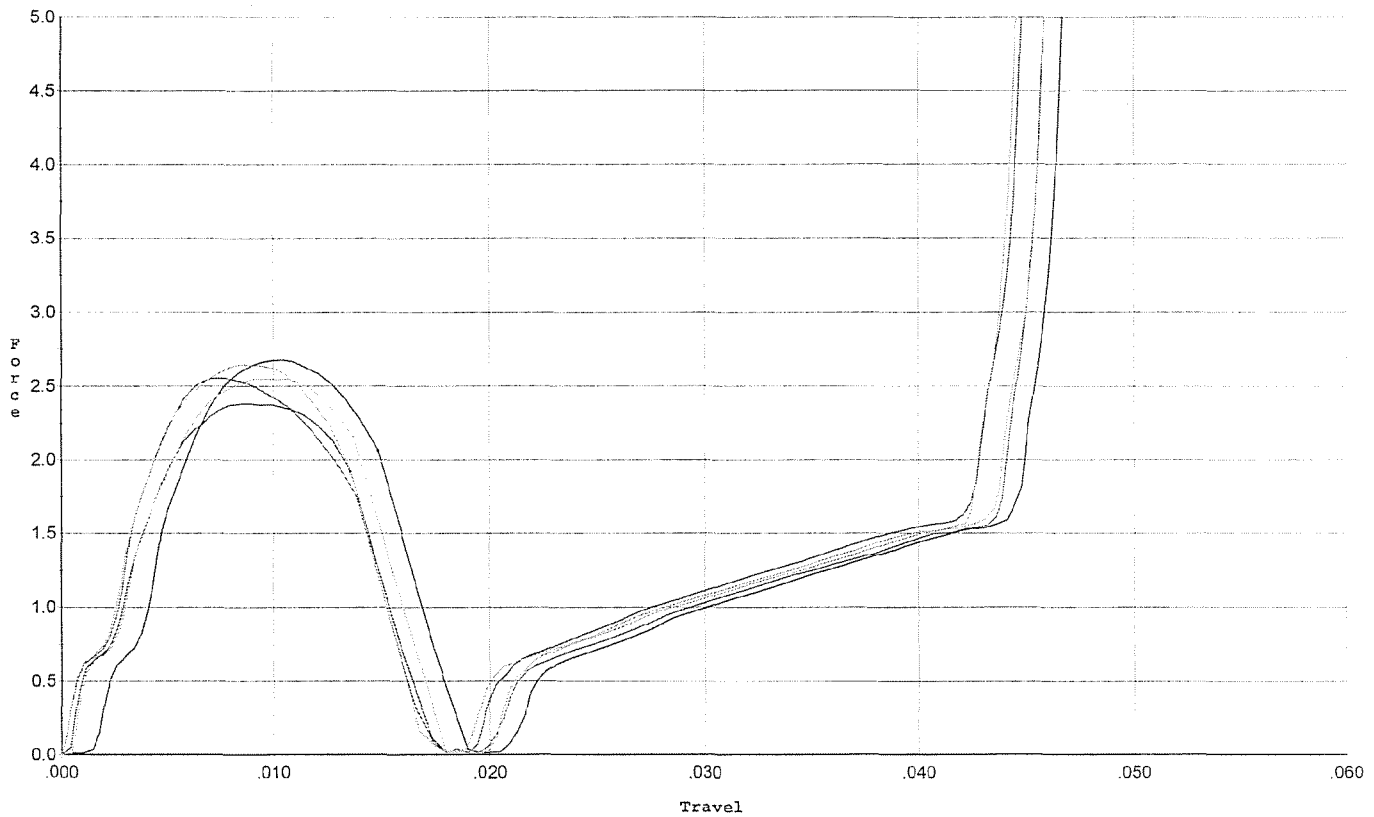
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	4-17-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4</u> <u>4</u>	4-17-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-17-09	WW
	J) ASSEMBLE STOCK		4-9-09	RP
	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	4-14-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	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>2.75</u> <u>2.77</u> <u>2.73</u> <u>2.75</u> <u>2.76</u>	4-15-09	RP
	C) FUNCTION		4-17-09	WW
690	PACK		5/20/09	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



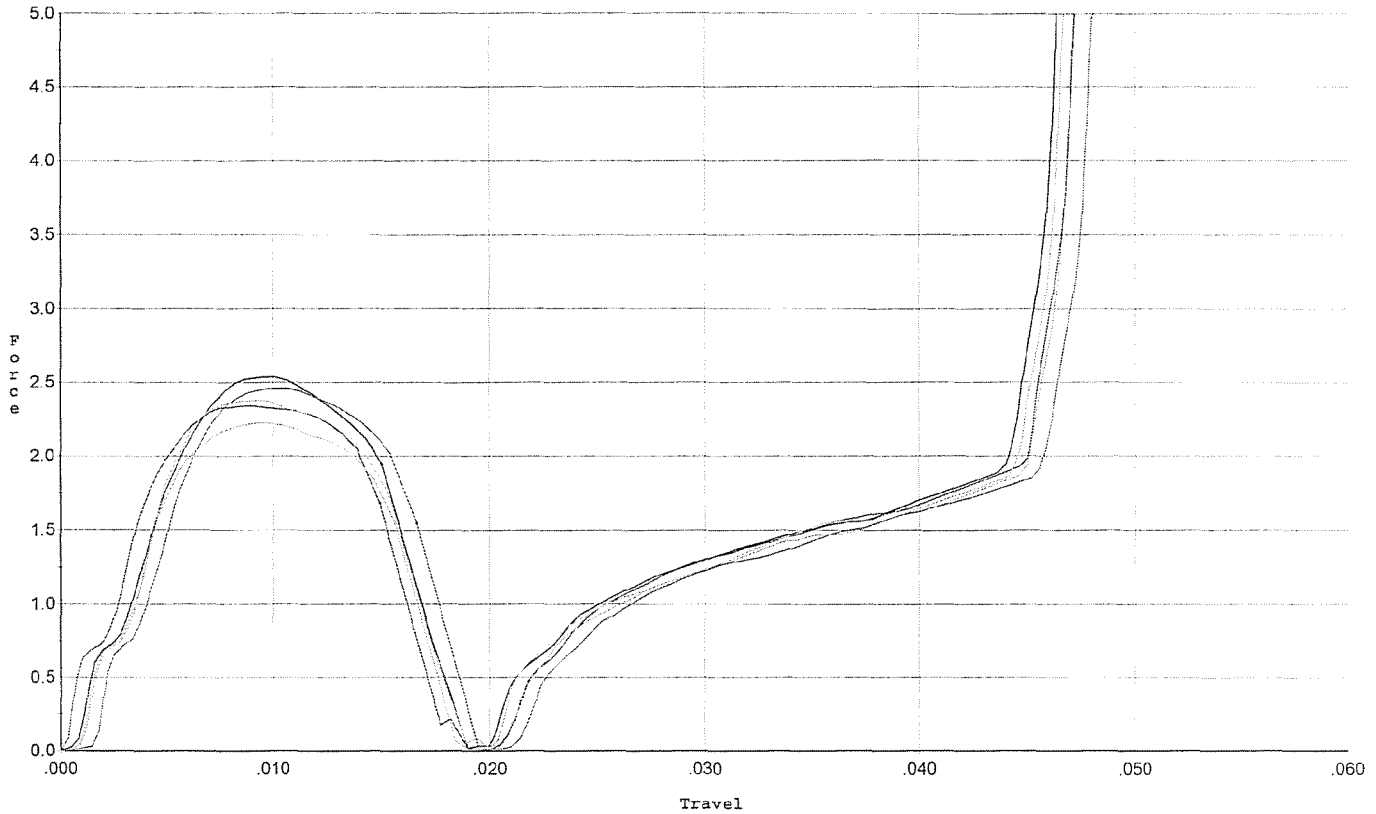
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.384	0.014	0.00	0.036	0.023		Set Trigger
2	2.677	0.015	0.00	0.037	0.025		Set Trigger
3	2.554	0.014	0.00	0.037	0.024		Set Trigger
4	2.550	0.014	0.00	0.036	0.024		Set Trigger
5	2.646	0.014	0.00	0.035	0.025		Set Trigger

A-2-56

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



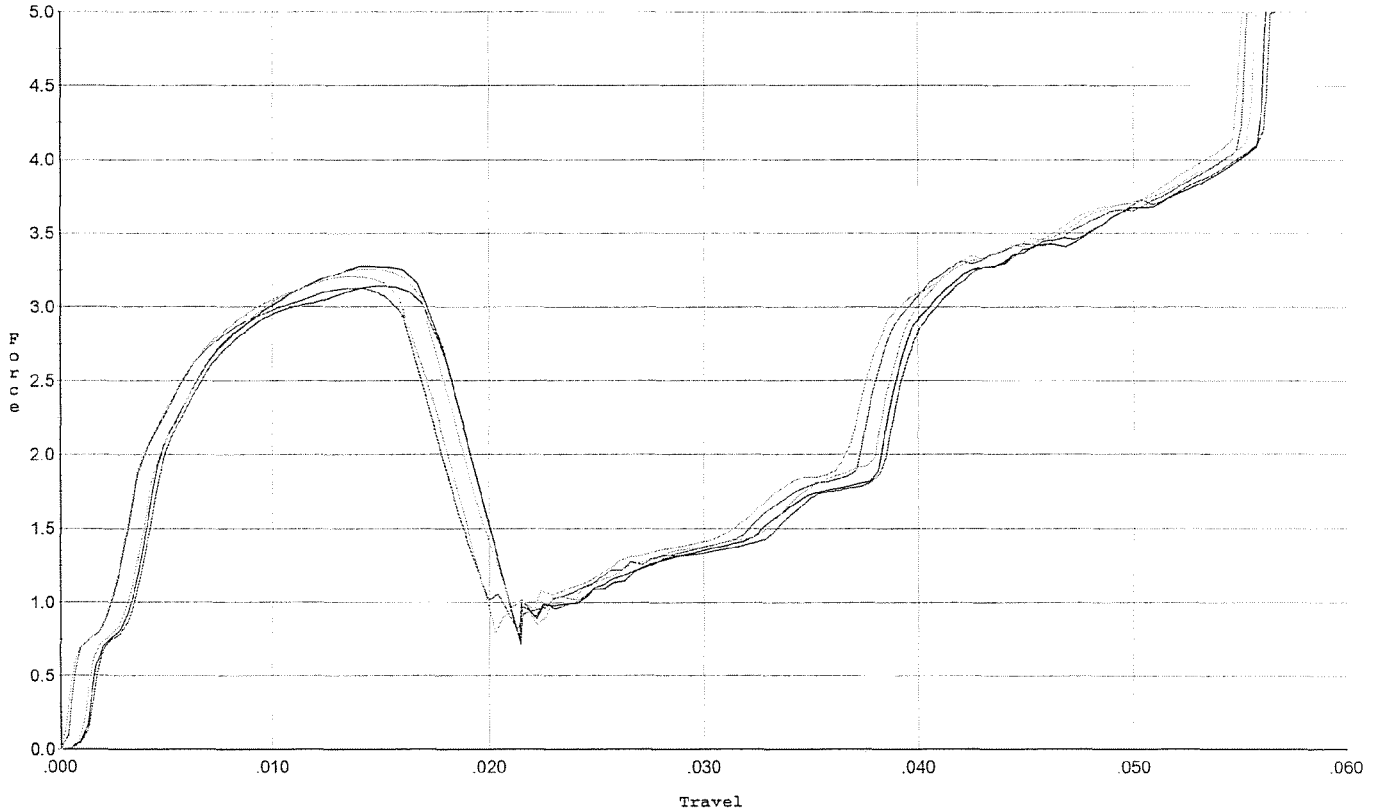
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.342	0.015	0.00	0.037	0.025		Set Trigger
2	2.537	0.015	0.00	0.036	0.026		Set Trigger
3	2.461	0.017	0.00	0.036	0.027		Set Trigger
4	2.378	0.015	0.00	0.036	0.025		Set Trigger
5	2.226	0.016	0.00	0.037	0.024		Set Trigger

A-2-38

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



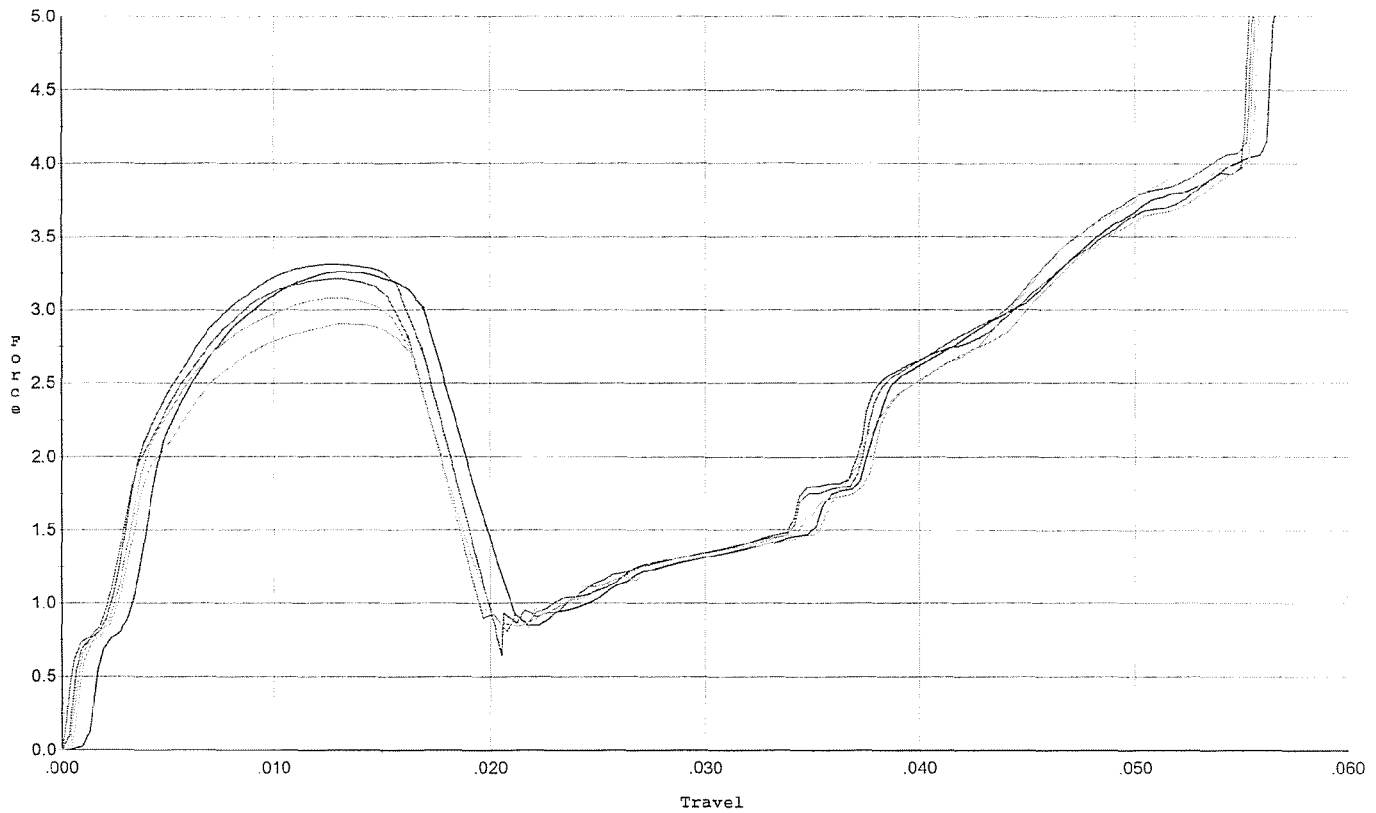
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.142	0.018	0.00	0.040	0.038		Set Trigger
2	3.274	0.018	0.00	0.040	0.039		Set Trigger
3	3.126	0.016	0.00	0.040	0.036		Set Trigger
4	3.255	0.017	0.00	0.040	0.037		Set Trigger
5	3.210	0.017	0.00	0.039	0.039		Set Trigger

A-3.20

Trigger Profile [lbs,inch]

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

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



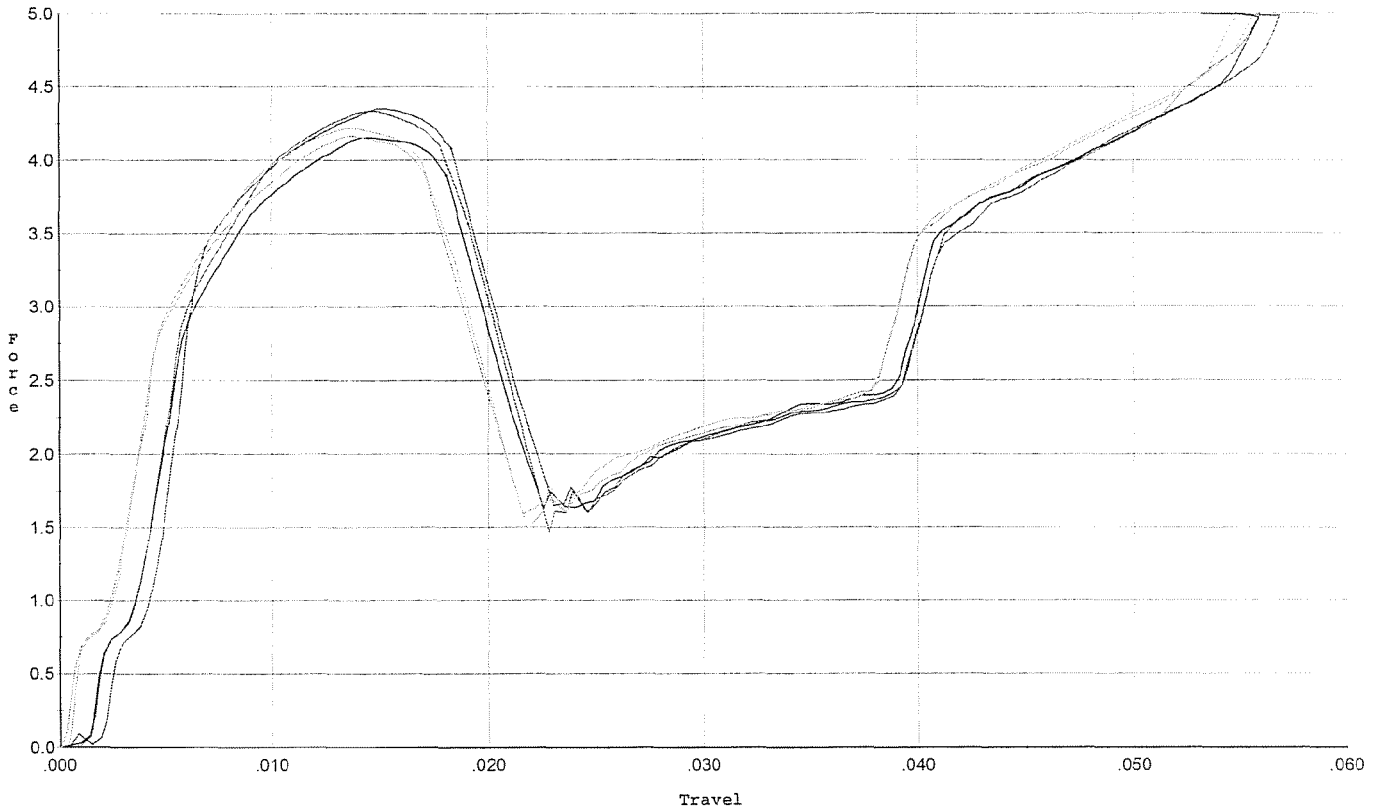
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.312	0.017	0.00	0.040	0.040		Set Trigger
2	3.261	0.017	0.00	0.041	0.037		Set Trigger
3	3.212	0.016	0.00	0.040	0.037		Set Trigger
4	2.905	0.016	0.00	0.041	0.034		Set Trigger
5	3.084	0.016	0.00	0.041	0.036		Set Trigger

A-3.15

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



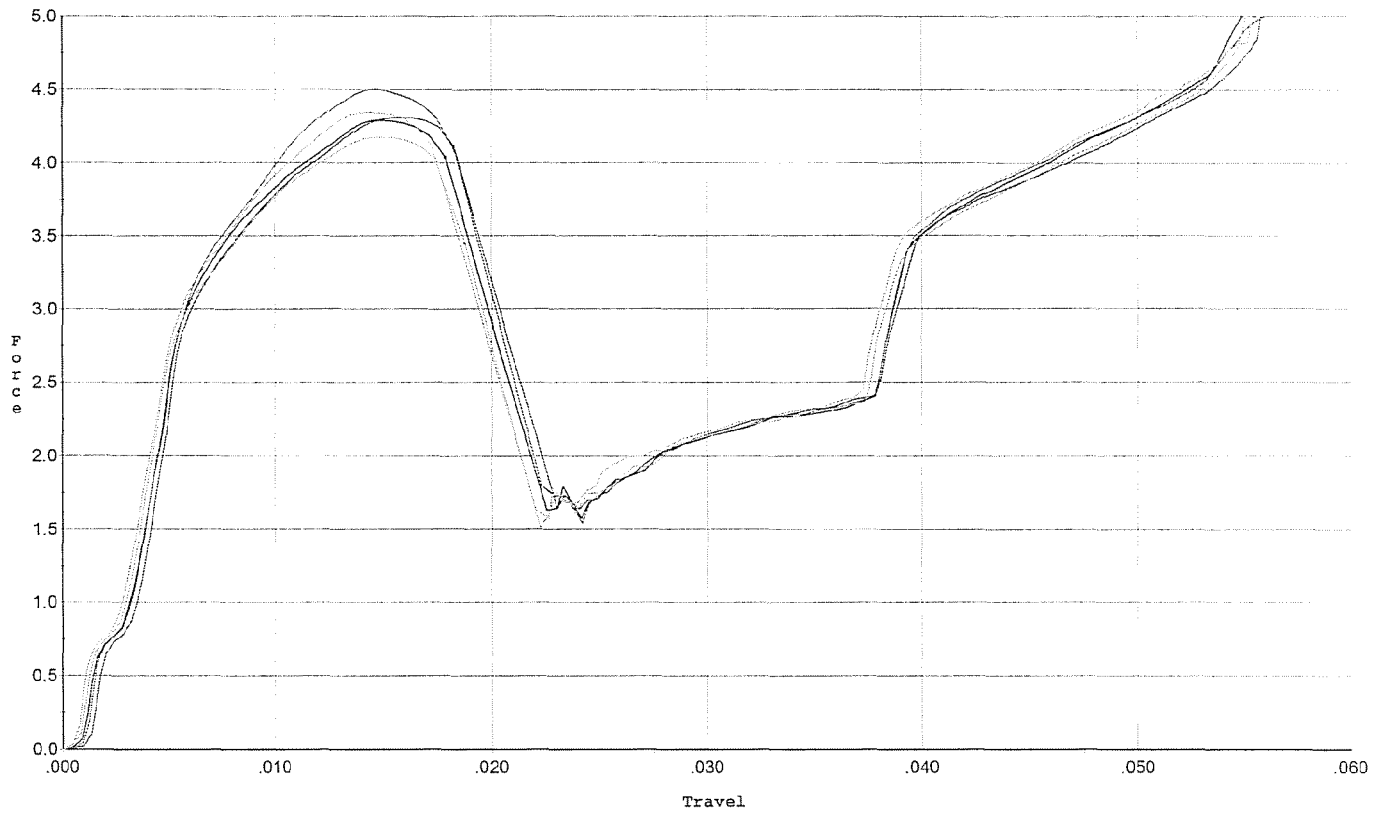
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.350	0.018	0.00	0.039	0.051		Set Trigger
2	4.154	0.018	0.00	0.039	0.049		Set Trigger
3	4.334	0.019	0.00	0.038	0.053		Set Trigger
4	4.218	0.018	0.00	0.038	0.053		Set Trigger
5	4.165	0.017	0.00	0.038	0.048		Set Trigger

A-4.24

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



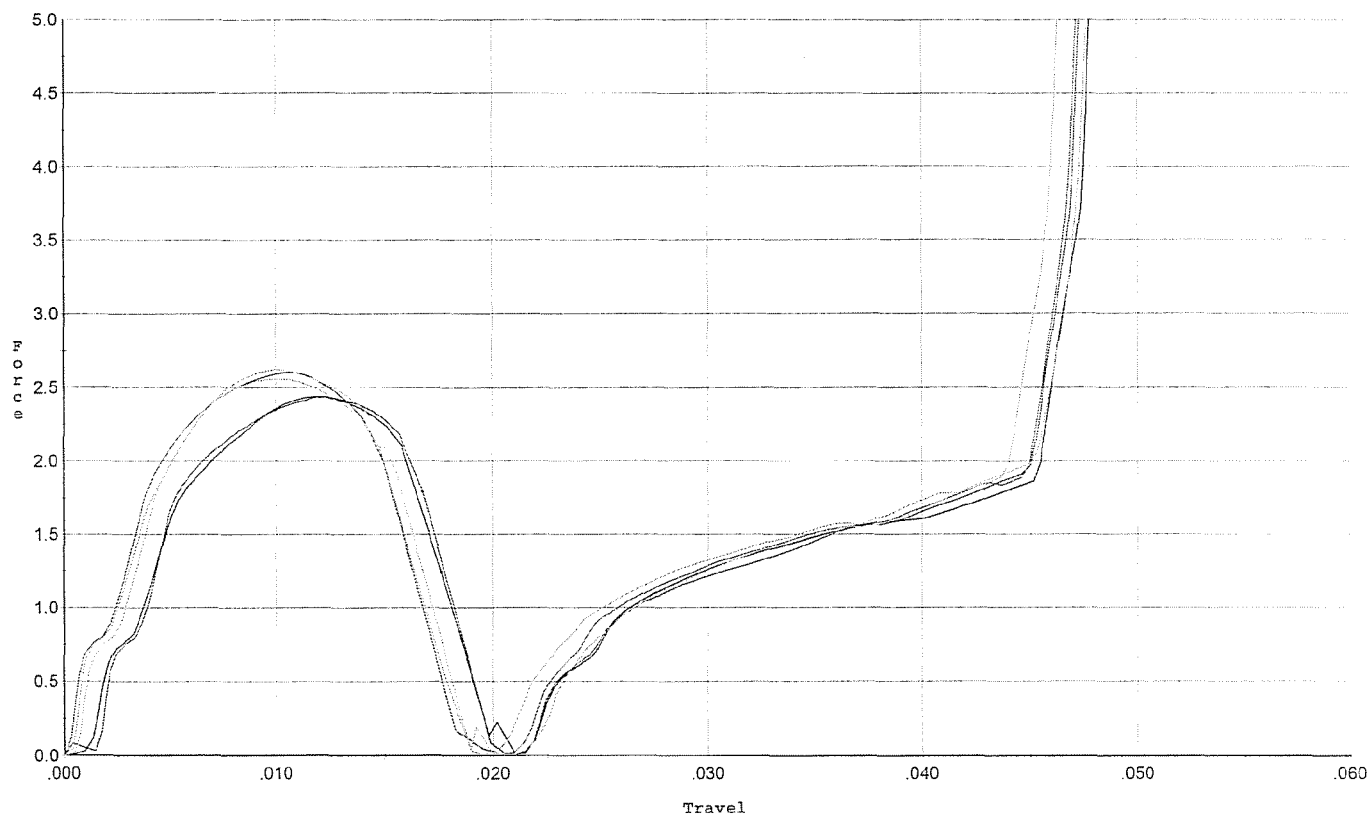
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.307	0.018	0.00	0.037	0.051		Set Trigger
2	4.290	0.018	0.00	0.037	0.050		Set Trigger
3	4.504	0.018	0.00	0.037	0.053		Set Trigger
4	4.175	0.019	0.00	0.037	0.052		Set Trigger
5	4.344	0.020	0.00	0.037	0.056		Set Trigger

1A-4.32

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



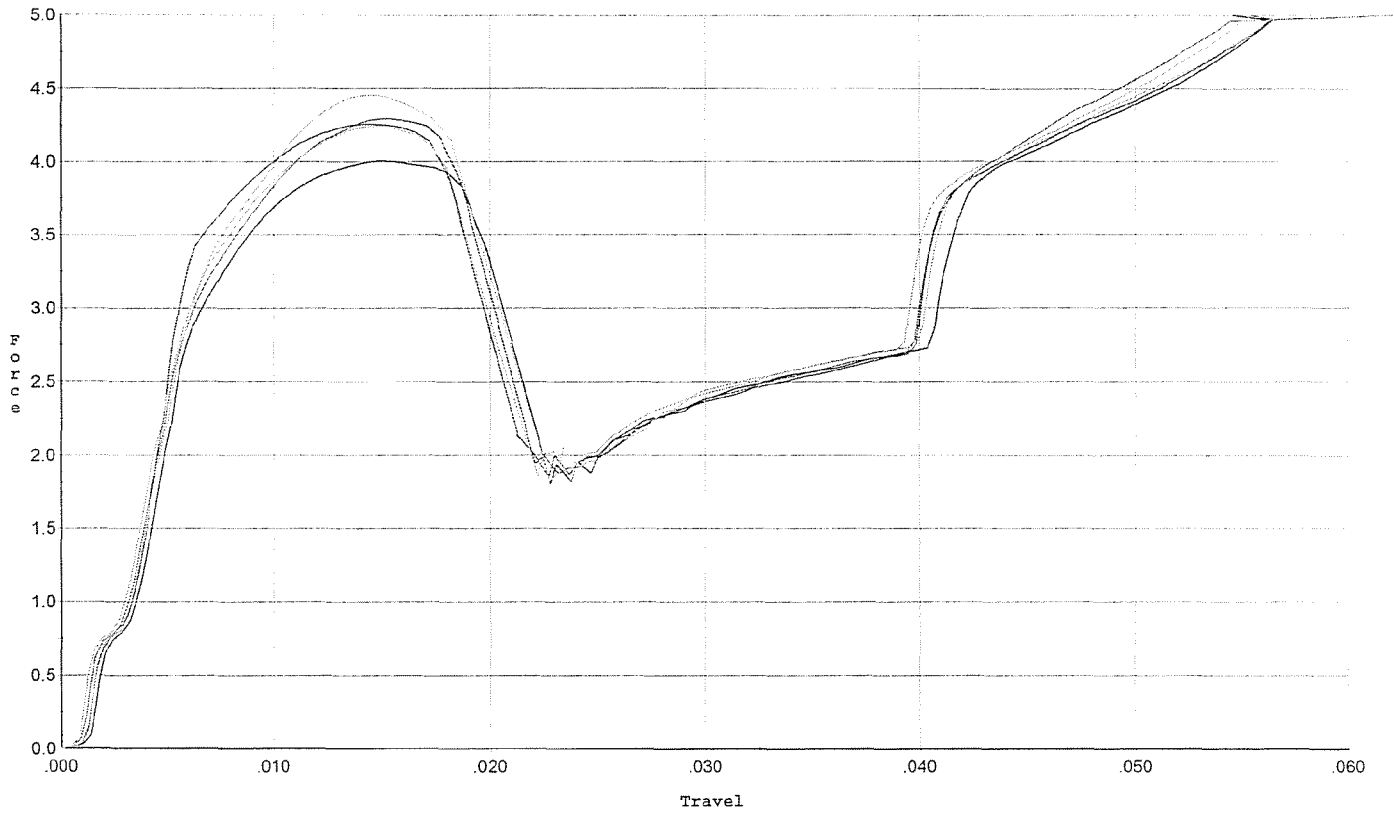
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.017	0.002	0.035	0.028		Set Trigger
2	2.438	0.018	0.00	0.036	0.029		Set Trigger
3	2.603	0.015	0.00	0.037	0.028		Set Trigger
4	2.623	0.016	0.00	0.037	0.028		Set Trigger
5	2.559	0.015	0.00	0.036	0.027		Set Trigger

A-2-53

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 ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.256	0.018	0.00	0.038	0.051		Set Trigger
2	4.006	0.020	0.00	0.038	0.053		Set Trigger
3	4.292	0.019	0.00	0.038	0.053		Set Trigger
4	4.455	0.018	0.00	0.038	0.052		Set Trigger
5	4.245	0.018	0.00	0.038	0.051		Set Trigger

A-4.25