

G6845313

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



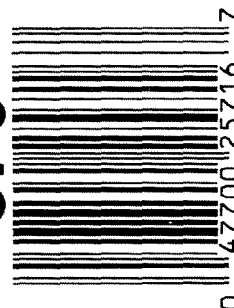
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845313

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6845313

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	MAGNAFLUX	3-18-09	RT
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(P)</u>	3/20/09	(P)
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

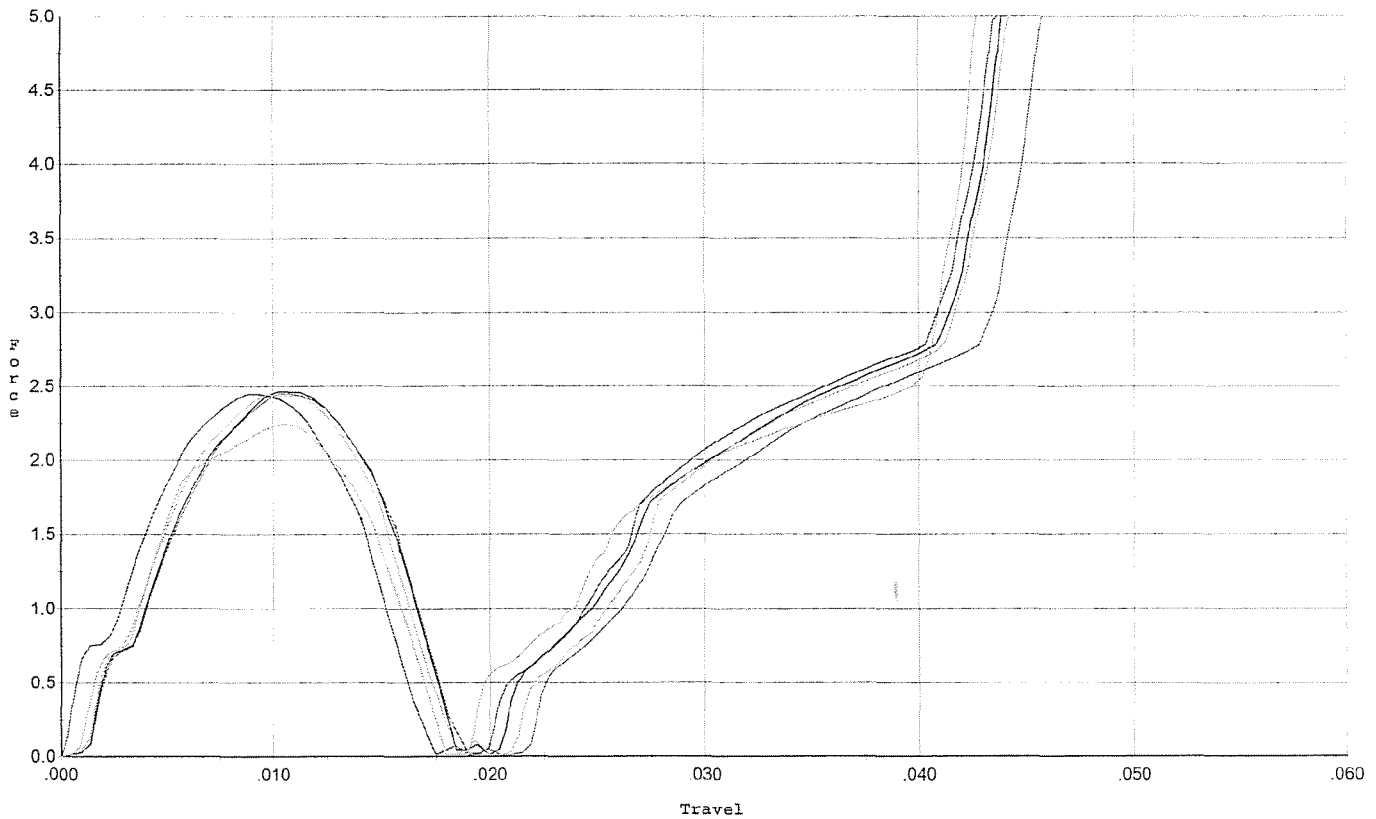
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	4-13-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-13-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	4-13-09	NW
	J) ASSEMBLE STOCK		4-1-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-13-09	NW
	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	4-4-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-4-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-13-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.48</u> <u>2.50</u> <u>2.50</u> <u>2.58</u>	4-7-09	RP
	C) FUNCTION		4-13-09	NW
690	PACK		6/4/09	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



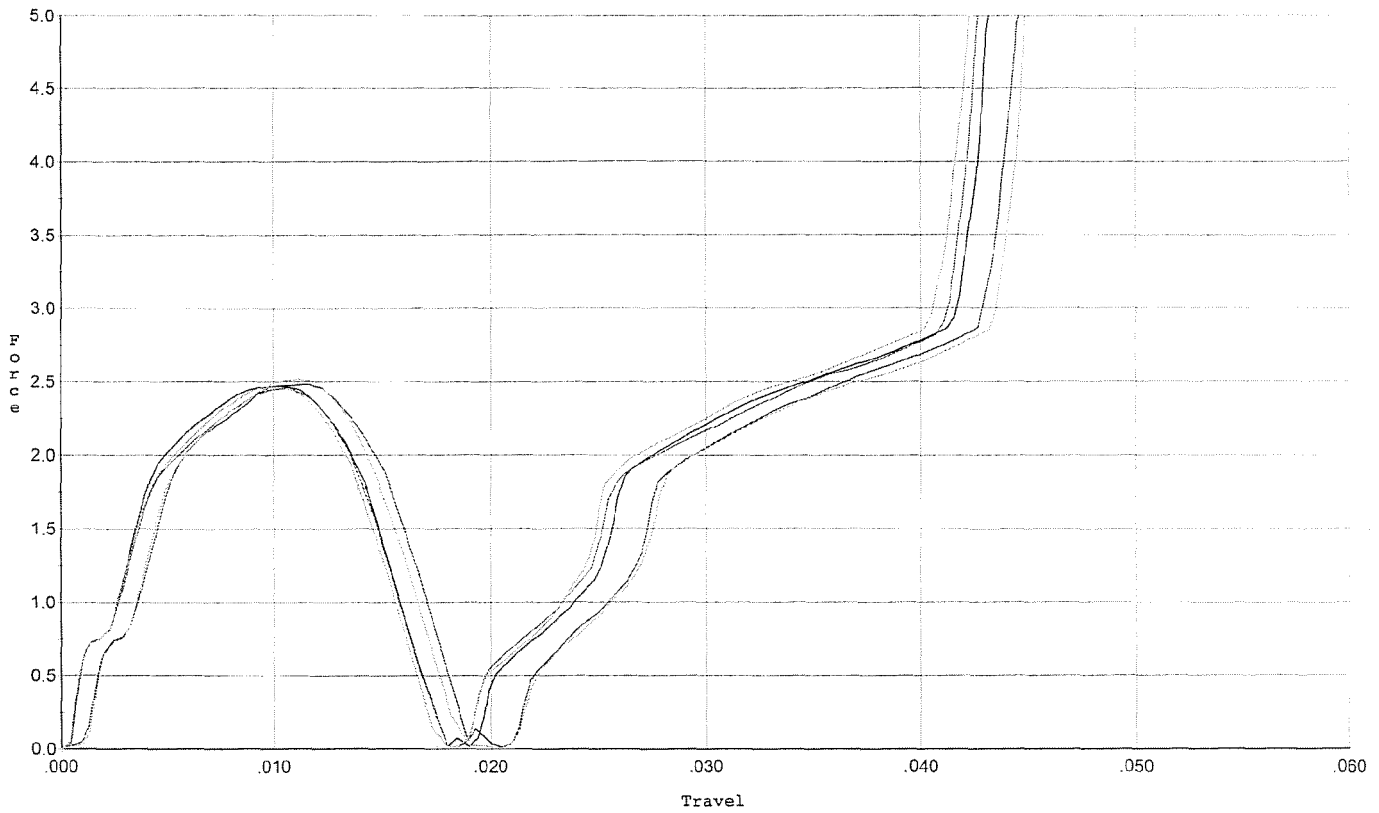
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.014	0.00	0.033	0.023		Set Trigger
2	2.466	0.016	0.00	0.033	0.025		Set Trigger
3	2.450	0.016	0.00	0.034	0.024		Set Trigger
4	2.445	0.015	0.00	0.034	0.024		Set Trigger
5	2.245	0.016	0.00	0.032	0.023		Set Trigger

A-2.41

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



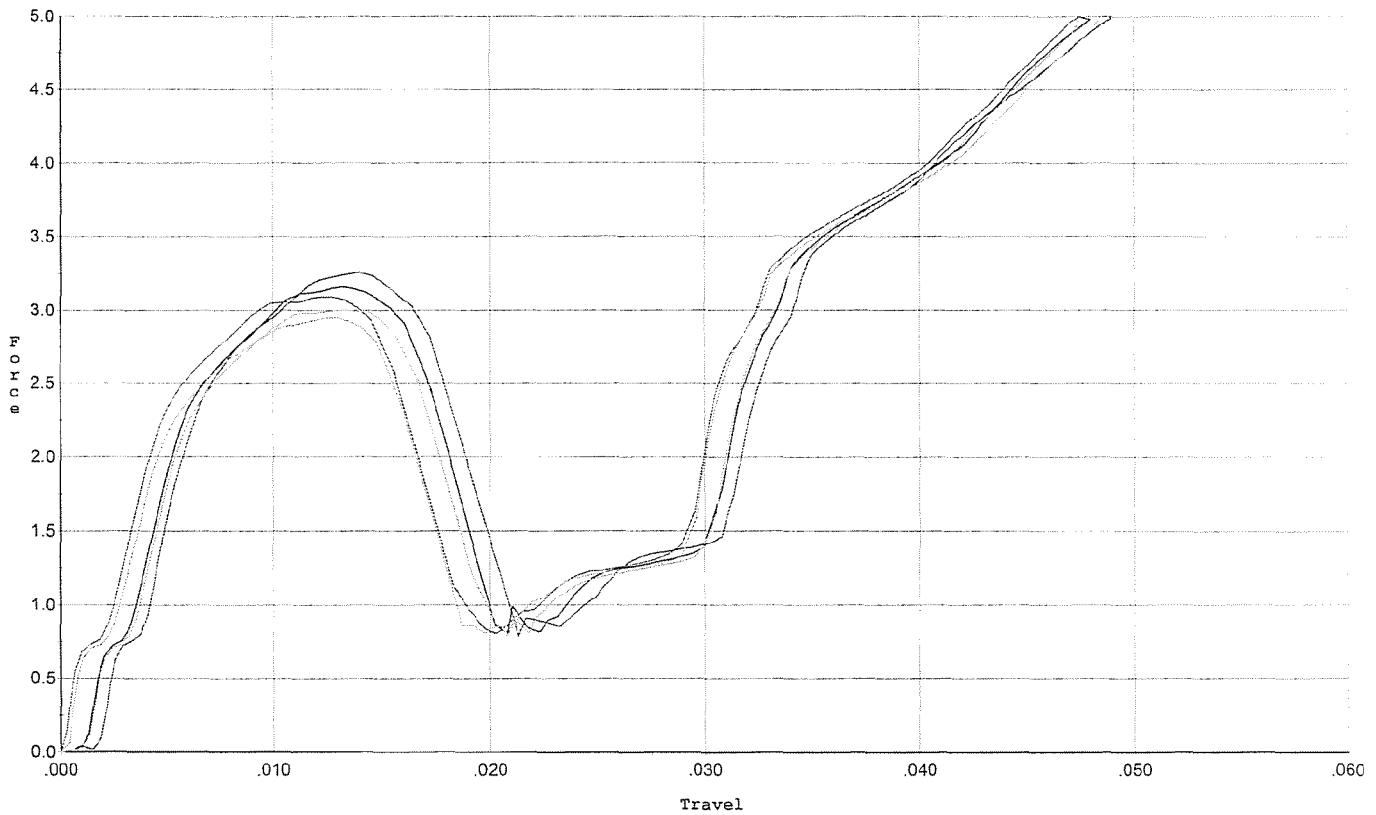
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.480	0.017	0.00	0.033	0.027		Set Trigger
2	2.467	0.014	0.00	0.032	0.025		Set Trigger
3	2.453	0.015	0.00	0.032	0.024		Set Trigger
4	2.520	0.016	0.00	0.033	0.026		Set Trigger
5	2.465	0.015	0.00	0.031	0.025		Set Trigger

A-2.47

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



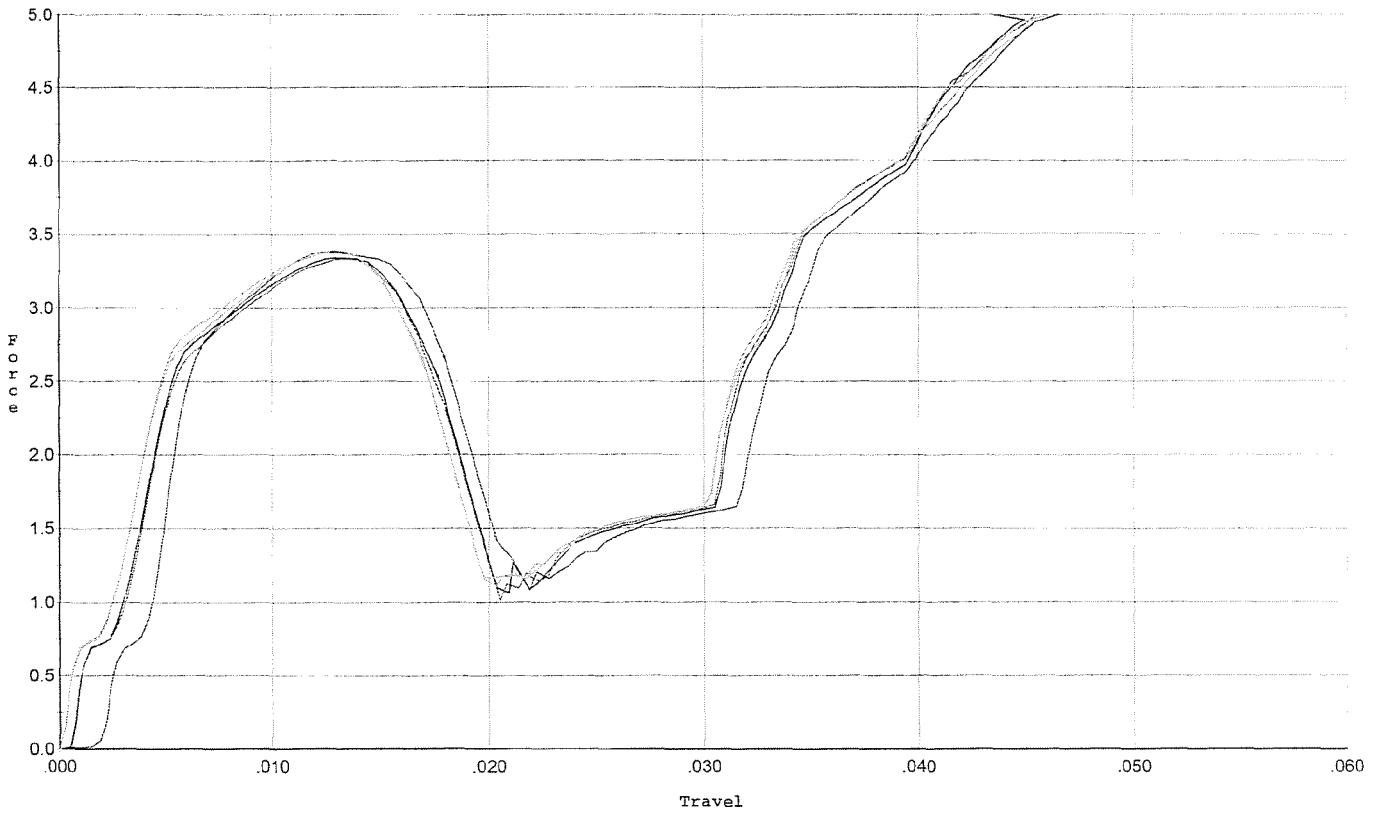
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.259	0.019	0.00	0.033	0.040		Set Trigger
2	3.161	0.017	0.00	0.033	0.036		Set Trigger
3	3.092	0.016	0.00	0.033	0.034		Set Trigger
4	3.003	0.017	0.00	0.033	0.033		Set Trigger
5	2.947	0.016	0.00	0.033	0.032		Set Trigger

A-3-09

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



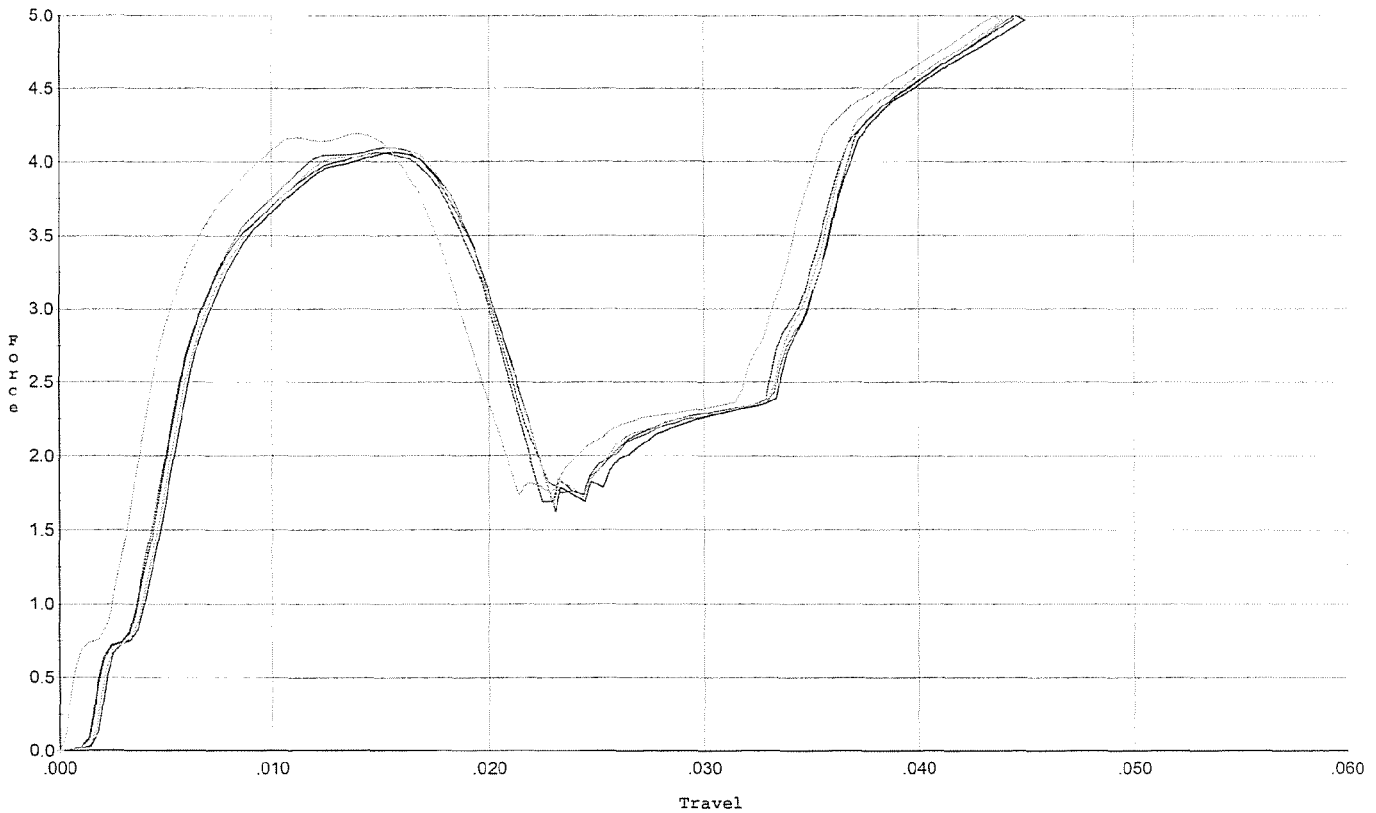
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.389	0.018	0.002	0.033	0.039		Set Trigger
2	3.339	0.018	0.00	0.032	0.040		Set Trigger
3	3.333	0.018	0.00	0.032	0.041		Set Trigger
4	3.385	0.017	0.00	0.032	0.040		Set Trigger
5	3.377	0.017	0.00	0.032	0.040		Set Trigger

A-3.36

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



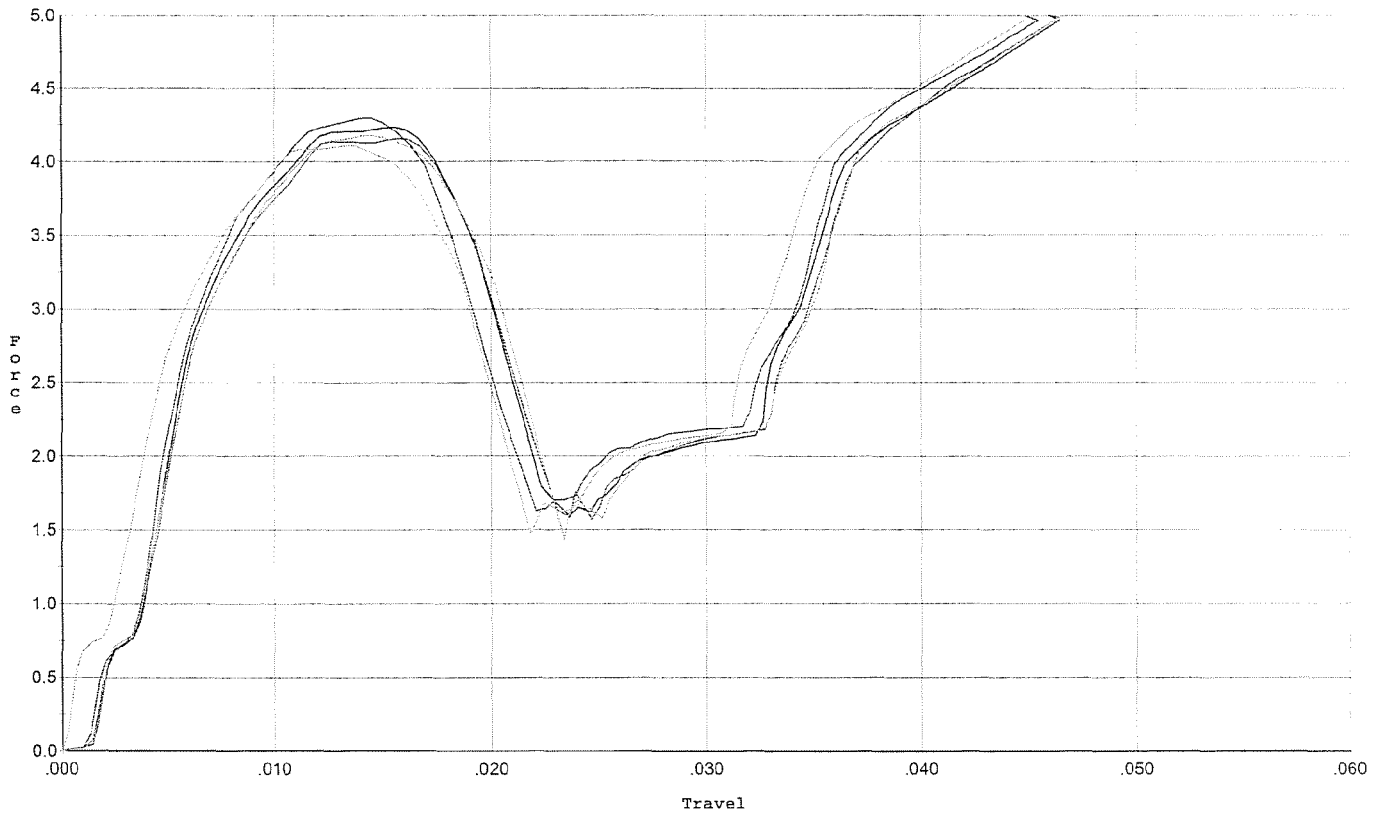
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.064	0.020	0.00	0.031	0.052		Set Trigger
2	4.063	0.021	0.00	0.031	0.055		Set Trigger
3	4.093	0.019	0.00	0.031	0.052		Set Trigger
4	4.092	0.021	0.00	0.031	0.056		Set Trigger
5	4.191	0.018	0.00	0.031	0.051		Set Trigger

A. 4.10

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



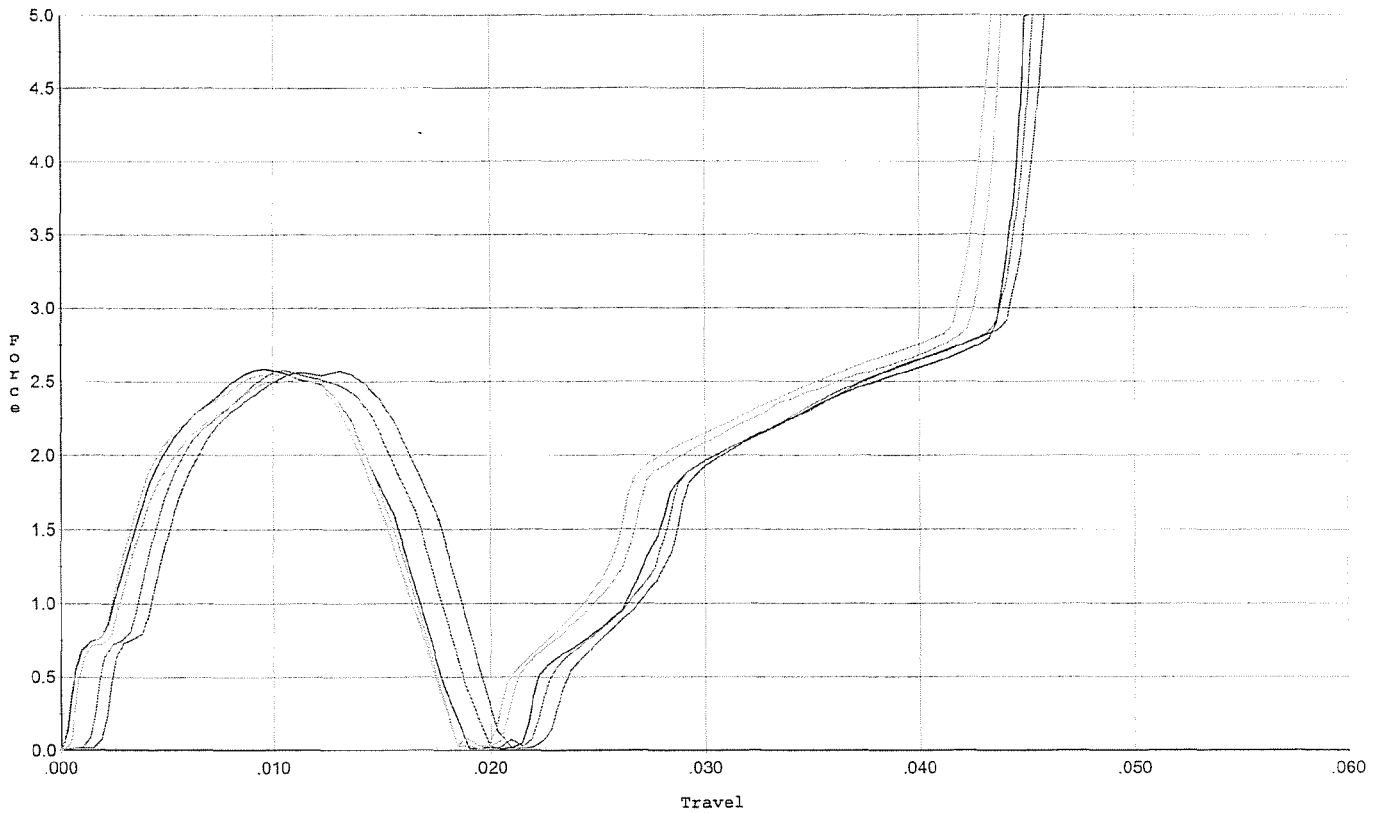
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.297	0.018	0.00	0.032	0.049		Set Trigger
2	4.231	0.019	0.00	0.031	0.052		Set Trigger
3	4.153	0.019	0.00	0.032	0.051		Set Trigger
4	4.104	0.019	0.00	0.031	0.052		Set Trigger
5	4.174	0.020	0.00	0.031	0.054		Set Trigger

A-4.19

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



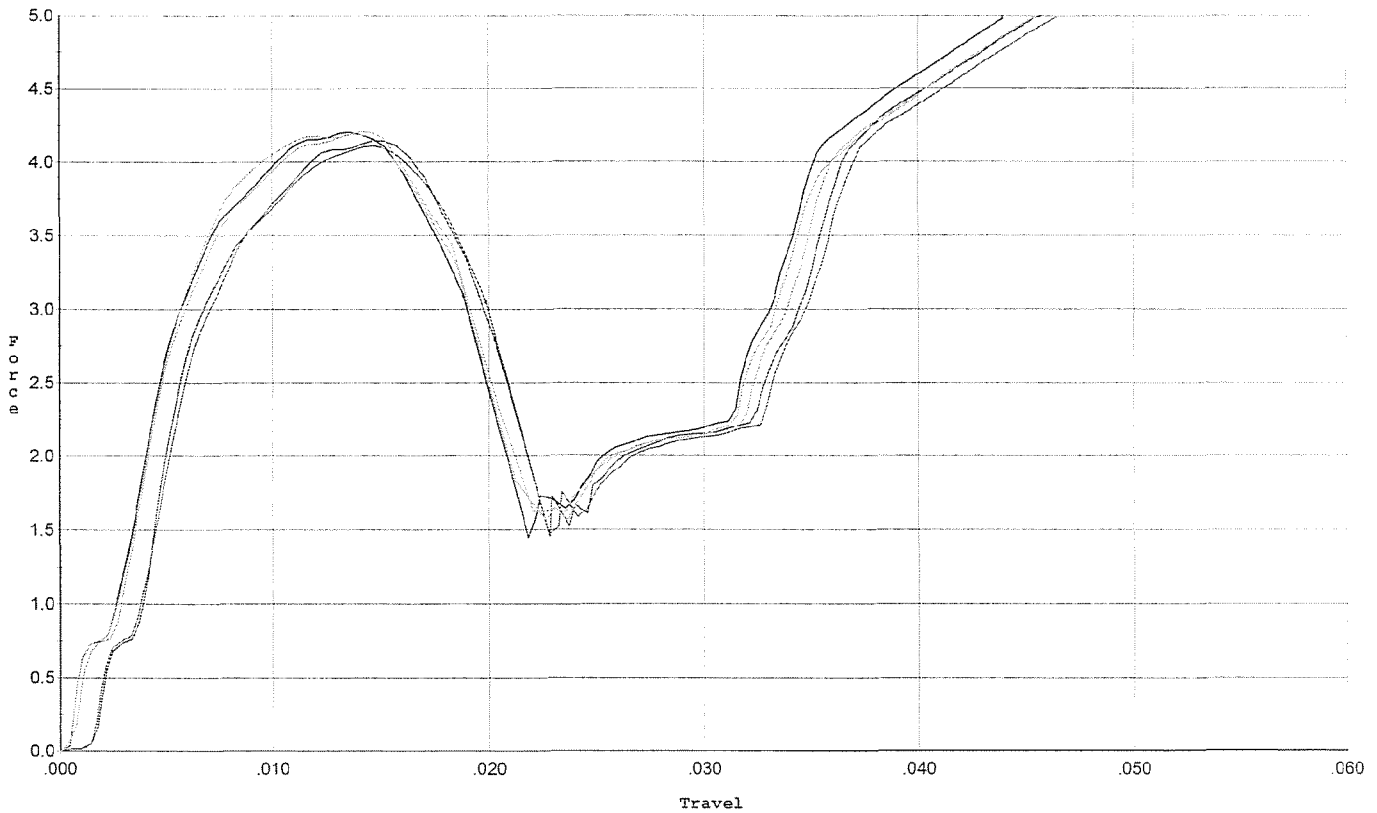
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.018	0.002	0.032	0.029		Set Trigger
2	2.582	0.016	0.00	0.033	0.028		Set Trigger
3	2.573	0.017	0.00	0.033	0.028		Set Trigger
4	2.549	0.017	0.00	0.032	0.030		Set Trigger
5	2.518	0.016	0.00	0.032	0.028		Set Trigger

A-2-55

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	4.142	0.020	0.00	0.031	0.053		Set Trigger
2	4.201	0.019	0.00	0.031	0.053		Set Trigger
3	4.107	0.020	0.00	0.032	0.052		Set Trigger
4	4.186	0.018	0.00	0.032	0.051		Set Trigger
5	4.205	0.018	0.00	0.032	0.052		Set Trigger

A-4.16