

G6845319

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



BM FORM

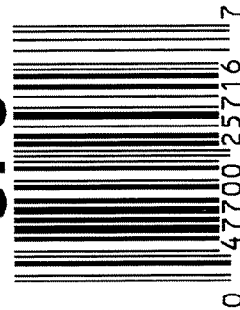
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845319

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6845319

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	RZ
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)		3-27	—
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

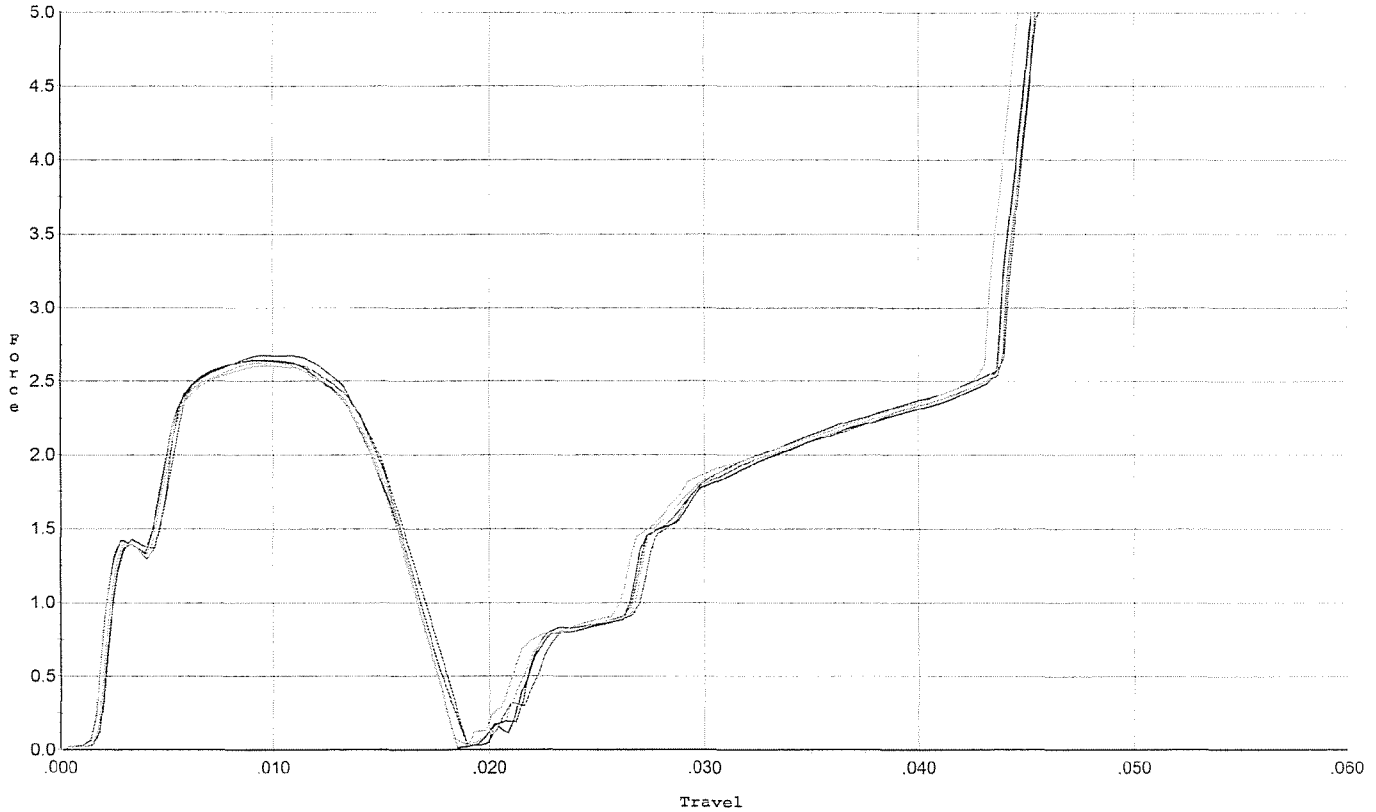
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>25</u> <u>25</u> <u>26</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.6</u> <u>4.6</u> <u>4.5</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-1-09	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-17-09	RP
	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> <u>PASS</u> FAIL FAIL	4-9-09	WW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TQR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.72</u> <u>2.61</u> <u>2.65</u> <u>2.69</u> <u>2.69</u>	4-14-09	WW
	C) FUNCTION		4-17-09	RP
690	PACK		5/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



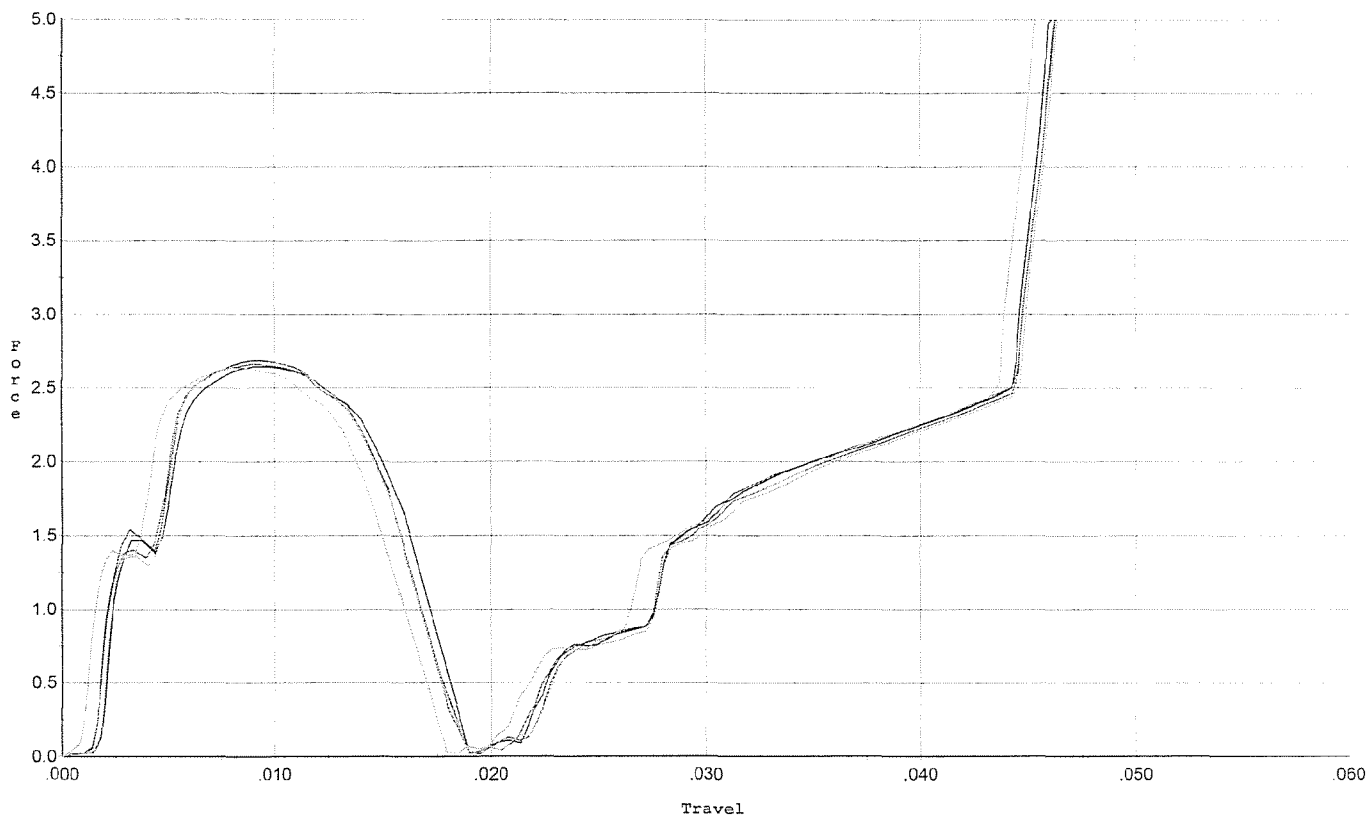
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.676	0.015	0.005	0.034	0.027		Set Trigger
2	2.647	0.016	0.004	0.034	0.028		Set Trigger
3	2.640	0.017	0.00	0.034	0.030		Set Trigger
4	2.604	0.015	0.004	0.034	0.027		Set Trigger
5	2.626	0.016	0.004	0.033	0.028		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



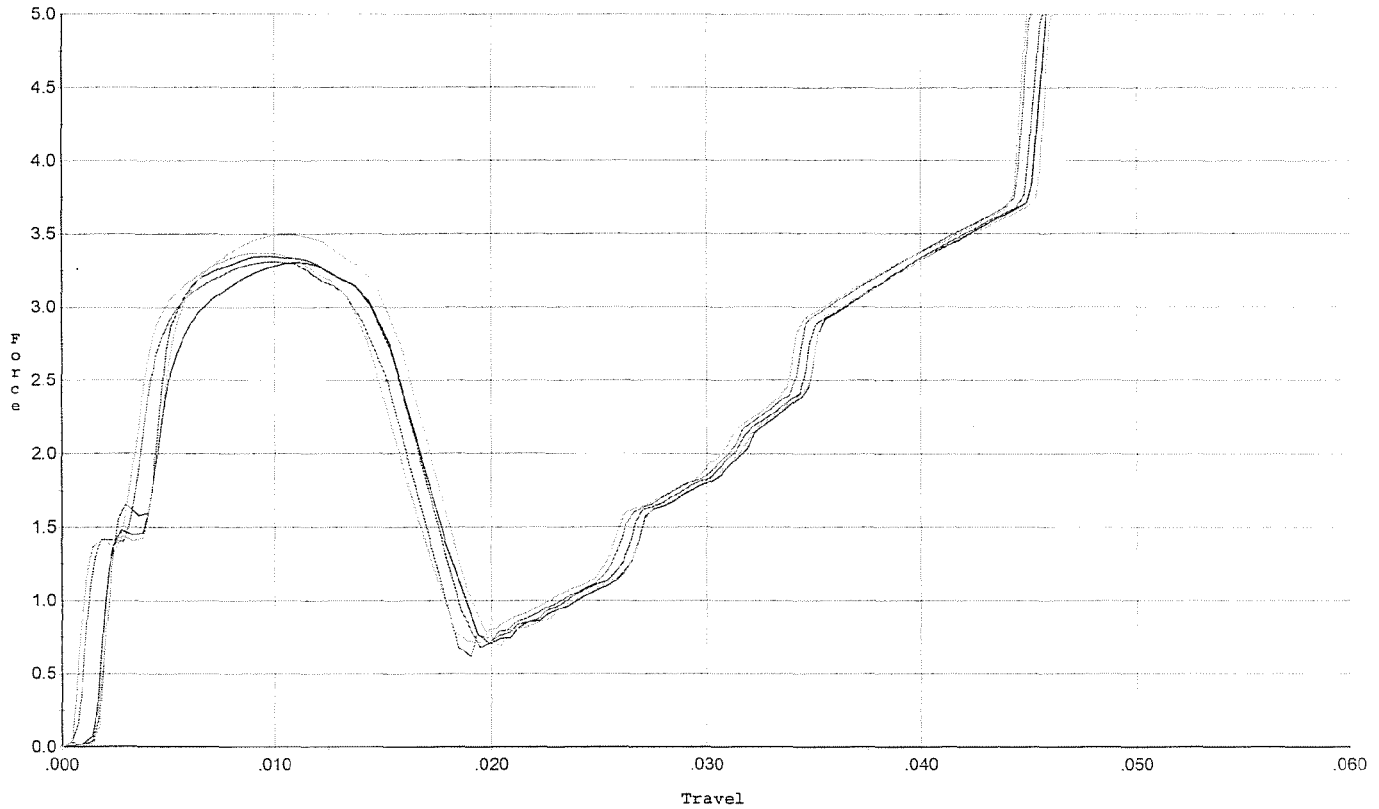
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.687	0.015	0.005	0.035	0.028		Set Trigger
2	2.646	0.016	0.005	0.034	0.028		Set Trigger
3	2.664	0.015	0.00	0.035	0.028		Set Trigger
4	2.682	0.015	0.004	0.035	0.027		Set Trigger
5	2.634	0.016	0.00	0.035	0.029		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



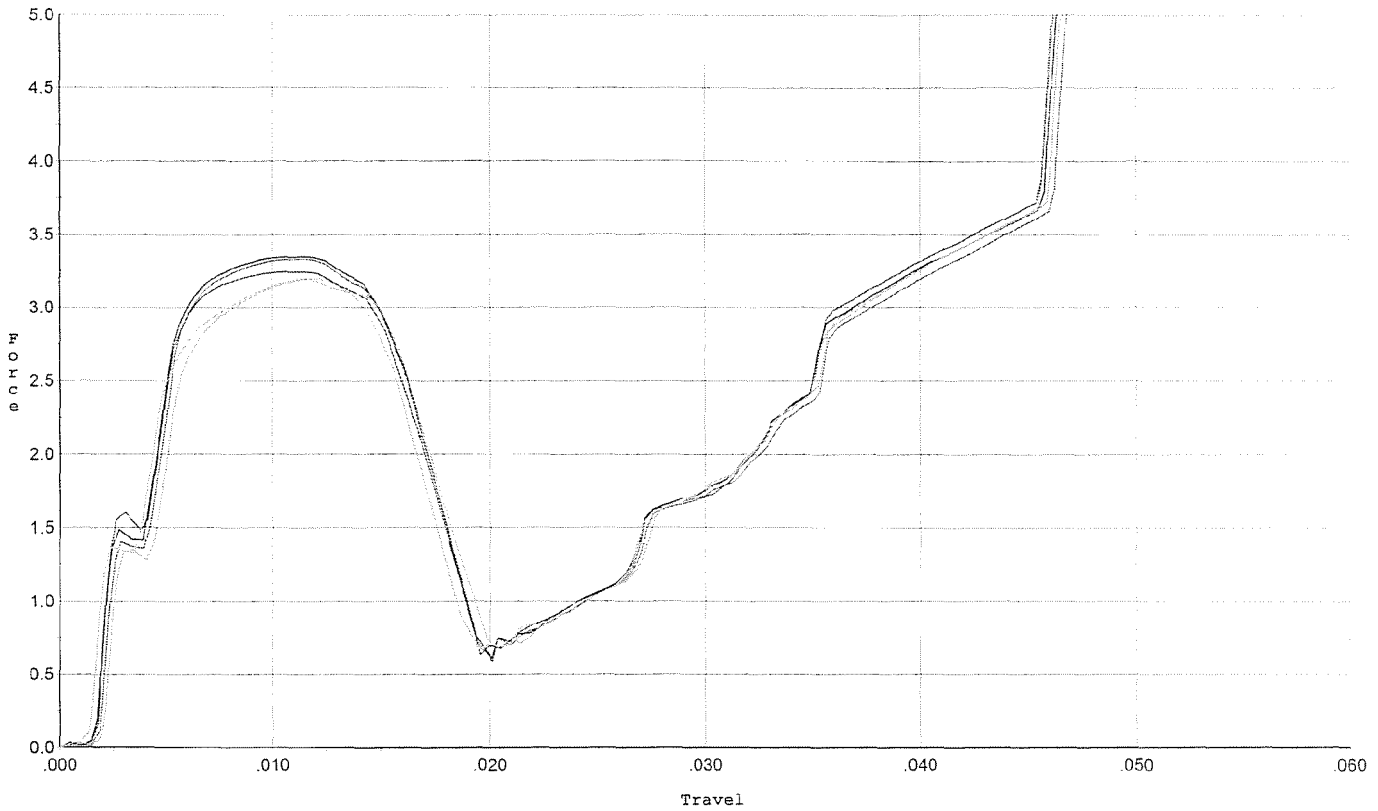
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.346	0.015	0.00	0.033	0.035		Set Trigger
2	3.305	0.015	0.00	0.033	0.034		Set Trigger
3	3.311	0.015	0.003	0.033	0.036		Set Trigger
4	3.496	0.016	0.00	0.033	0.037		Set Trigger
5	3.369	0.014	0.00	0.033	0.034		Set Trigger

A-336

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



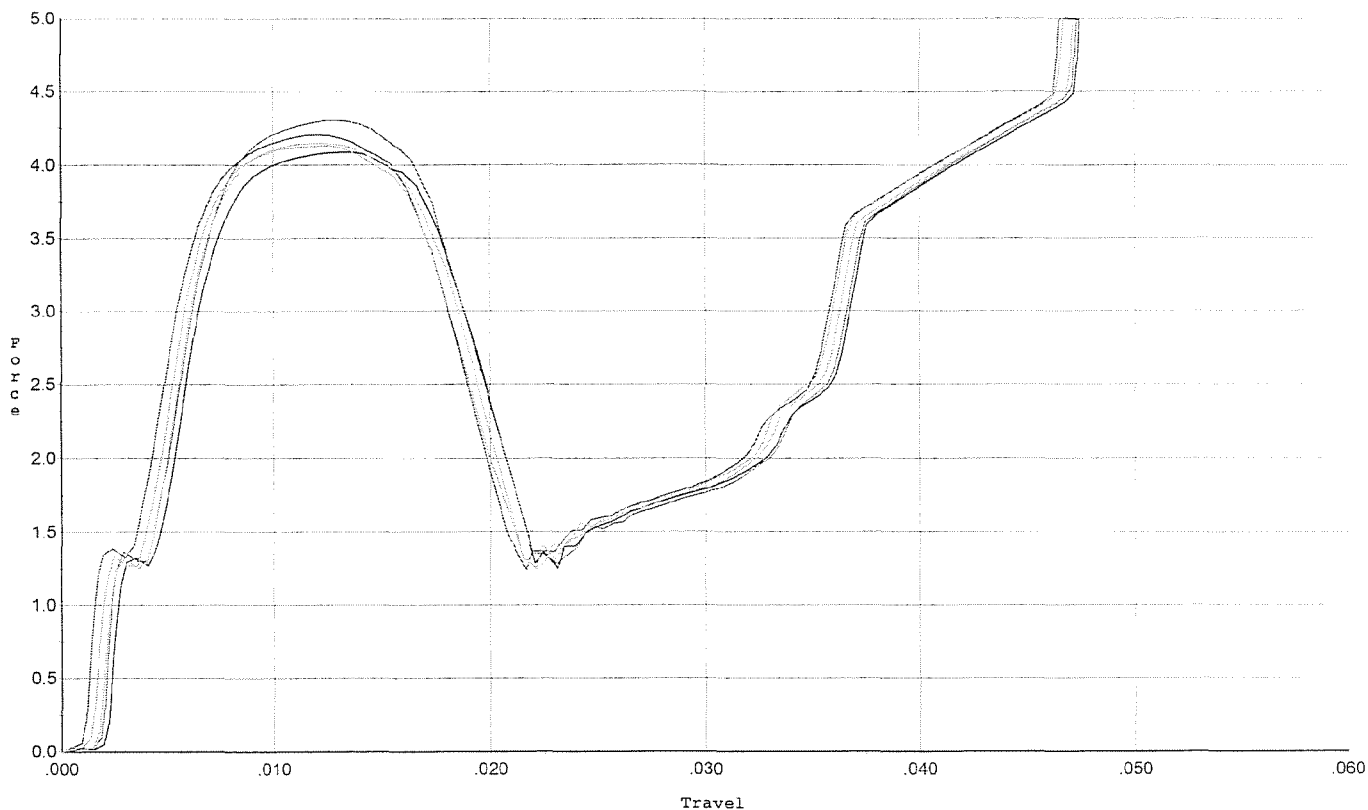
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.245	0.017	0.00	0.033	0.037		Set Trigger
2	3.347	0.016	0.004	0.033	0.037		Set Trigger
3	3.332	0.016	0.004	0.033	0.036		Set Trigger
4	3.198	0.016	0.004	0.033	0.034		Set Trigger
5	3.199	0.016	0.00	0.033	0.034		Set Trigger

A-3-26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



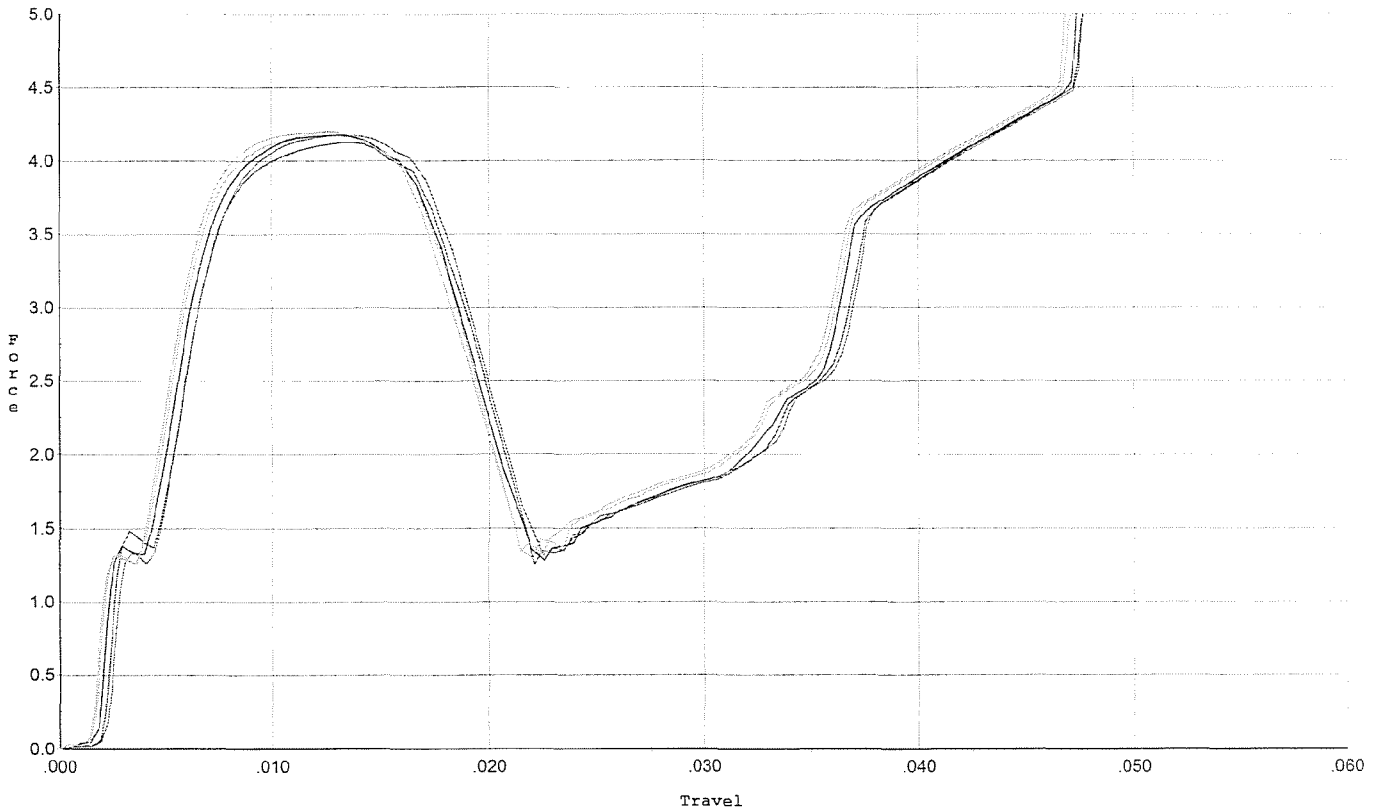
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.204	0.017	0.00	0.031	0.049		Set Trigger
2	4.088	0.019	0.00	0.031	0.051		Set Trigger
3	4.305	0.020	0.002	0.031	0.054		Set Trigger
4	4.146	0.018	0.00	0.031	0.049		Set Trigger
5	4.128	0.017	0.004	0.031	0.047		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



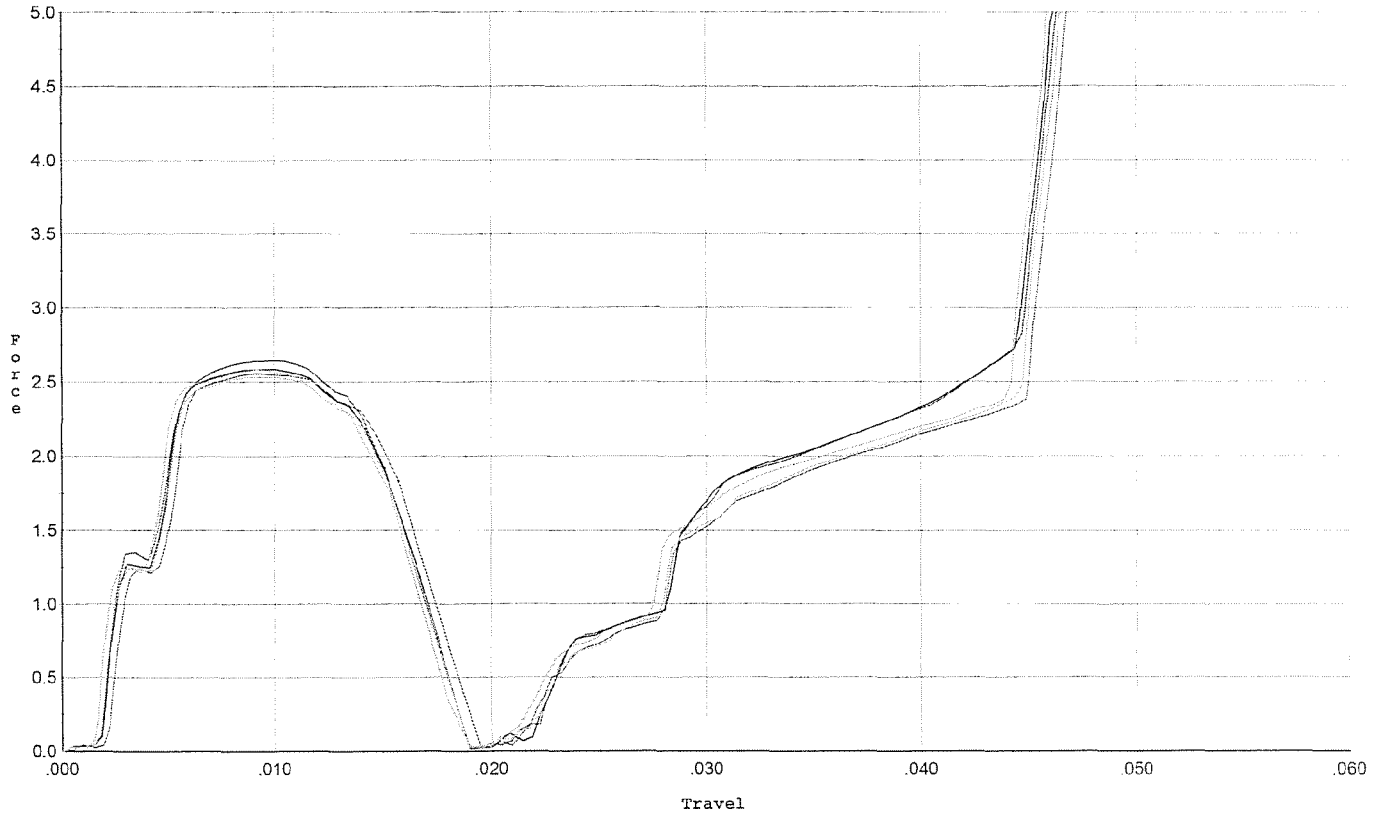
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.126	0.019	0.005	0.031	0.051		Set Trigger
2	4.174	0.018	0.004	0.031	0.049		Set Trigger
3	4.178	0.018	0.00	0.031	0.049		Set Trigger
4	4.196	0.018	0.004	0.031	0.050		Set Trigger
5	4.199	0.019	0.004	0.031	0.053		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



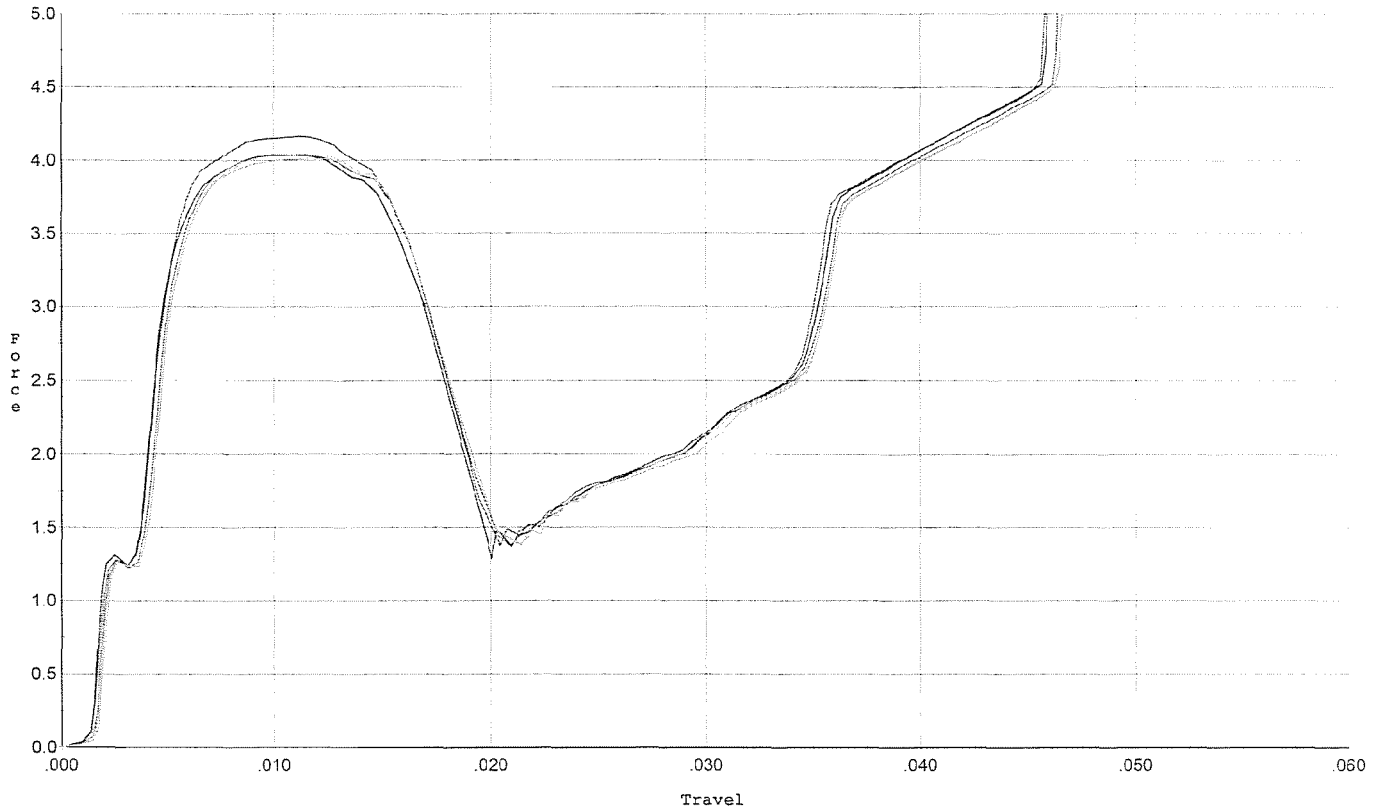
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.015	0.002	0.035	0.027		Set Trigger
2	2.583	0.017	0.004	0.034	0.029		Set Trigger
3	2.555	0.016	0.00	0.035	0.027		Set Trigger
4	2.531	0.017	0.004	0.035	0.029		Set Trigger
5	2.585	0.015	0.00	0.035	0.027		Set Trigger

A-2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.164	0.016	0.00	0.031	0.046		Set Trigger
2	4.038	0.017	0.00	0.031	0.046		Set Trigger
3	4.035	0.016	0.00	0.031	0.044		Set Trigger
4	4.042	0.016	0.004	0.032	0.044		Set Trigger
5	4.013	0.016	0.004	0.032	0.044		Set Trigger

A-4.05