

G6778847

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



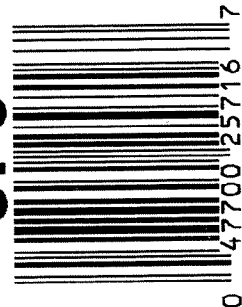
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6778847

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6778847

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	SP
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	SP
460	CHECK HEADSPACE		8-20-08	SP
470	DIS-ASSEMBLE ACTION		8-20-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	8-21-08	RT
475	DRILL AND TAP SIGHT HOLES	200 22 2008	8-21-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>BM</u>	8-22-08	BM
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-22-08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-09-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-09-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-09-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-22-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

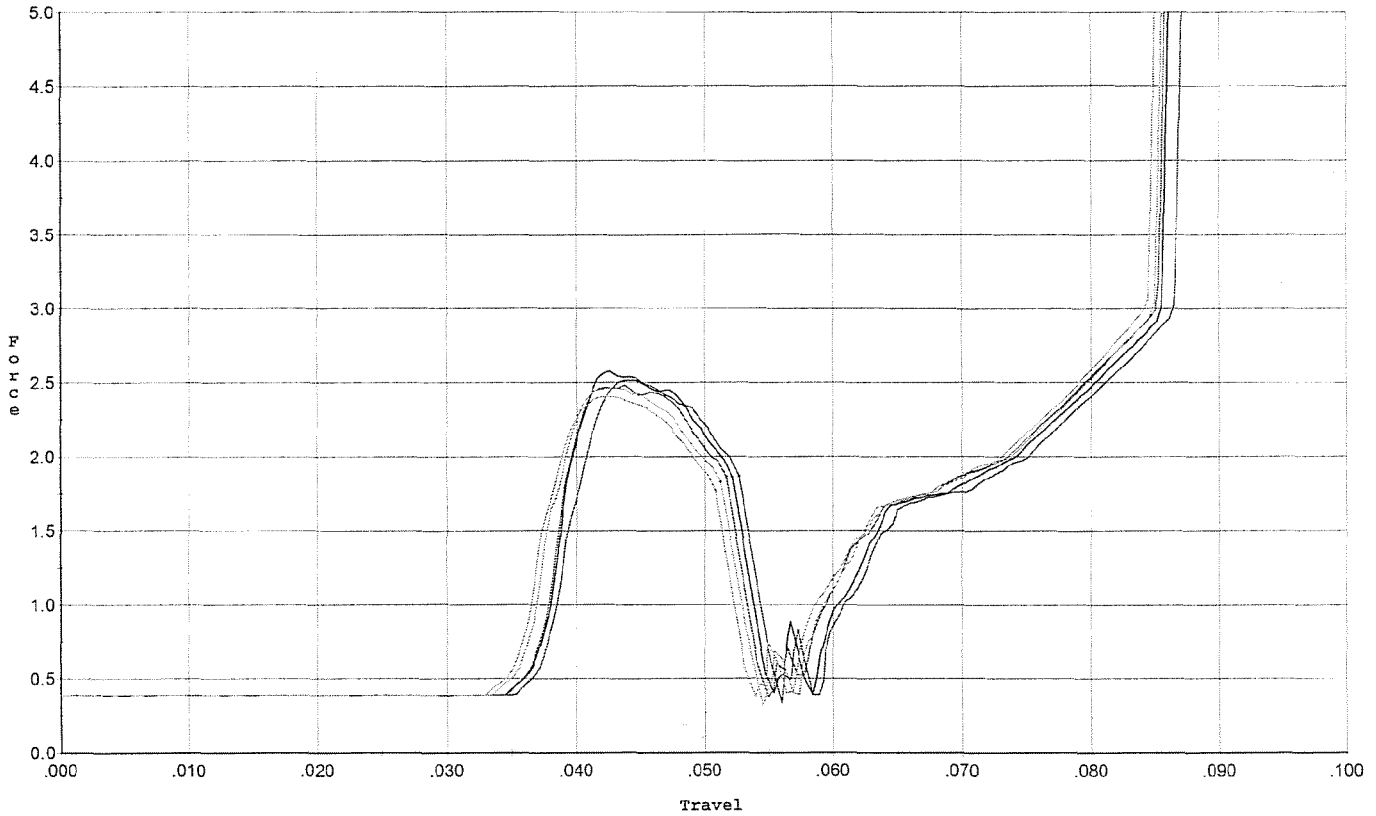
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	10-28-08	RJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>50</u> <u>50</u>	10-28-08	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-28-08	RJ
	J) ASSEMBLE STOCK		10-28-08	L.H.D.
	K) ASSEMBLE SWIVEL STUDS		10-28-08	RJ
	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	10-24-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	ESW
670	FINAL INSPECTION A) HEADSPACE		10-28-08	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.23</u> <u>2.22</u> <u>2.21</u> <u>2.14</u> <u>2.21</u>	10-27-08	TC
	C) FUNCTION		10-28-08	RJ
690	PACK		11-6-08	Fmj

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



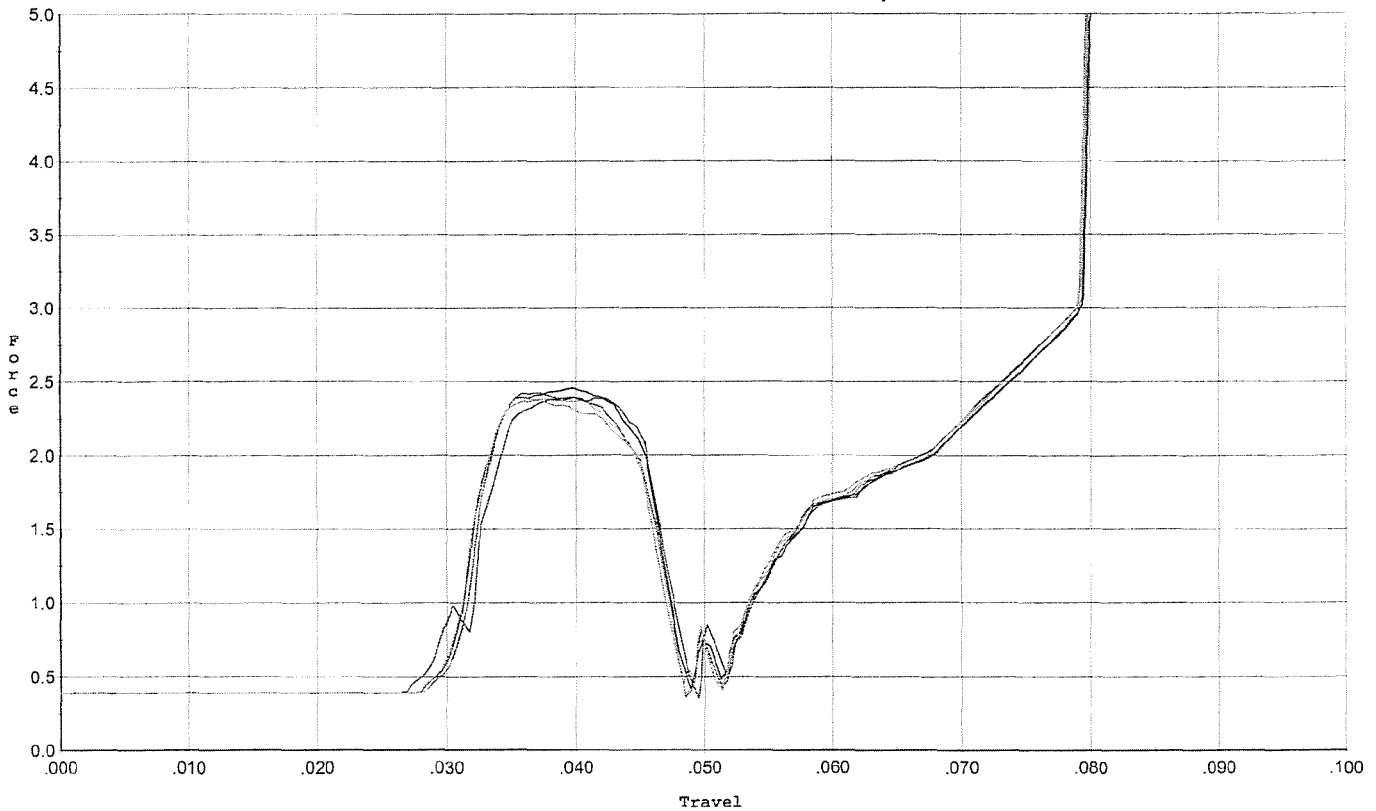
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.512	0.053	0.037	0.039	0.047		Set Trigger
2	2.580	0.052	0.037	0.039	0.048		Set Trigger
3	2.481	0.052	0.037	0.039	0.046		Set Trigger
4	2.466	0.051	0.036	0.038	0.046		Set Trigger
5	2.408	0.051	0.035	0.038	0.046		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



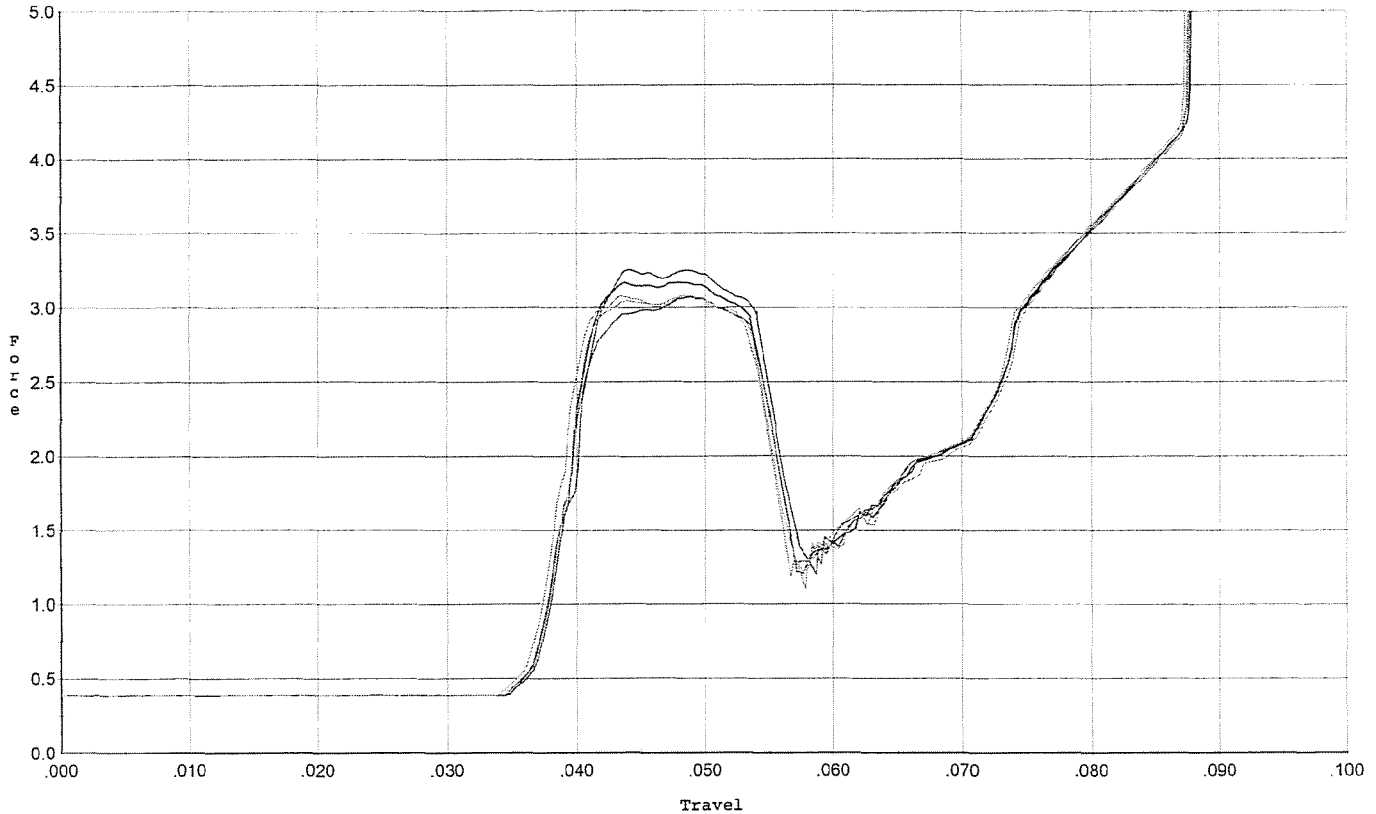
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.391	0.045	0.029	0.037	0.044		Set Trigger
2	2.455	0.045	0.031	0.037	0.045		Set Trigger
3	2.424	0.046	0.030	0.037	0.045		Set Trigger
4	2.387	0.046	0.031	0.037	0.044		Set Trigger
5	2.374	0.045	0.030	0.038	0.043		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



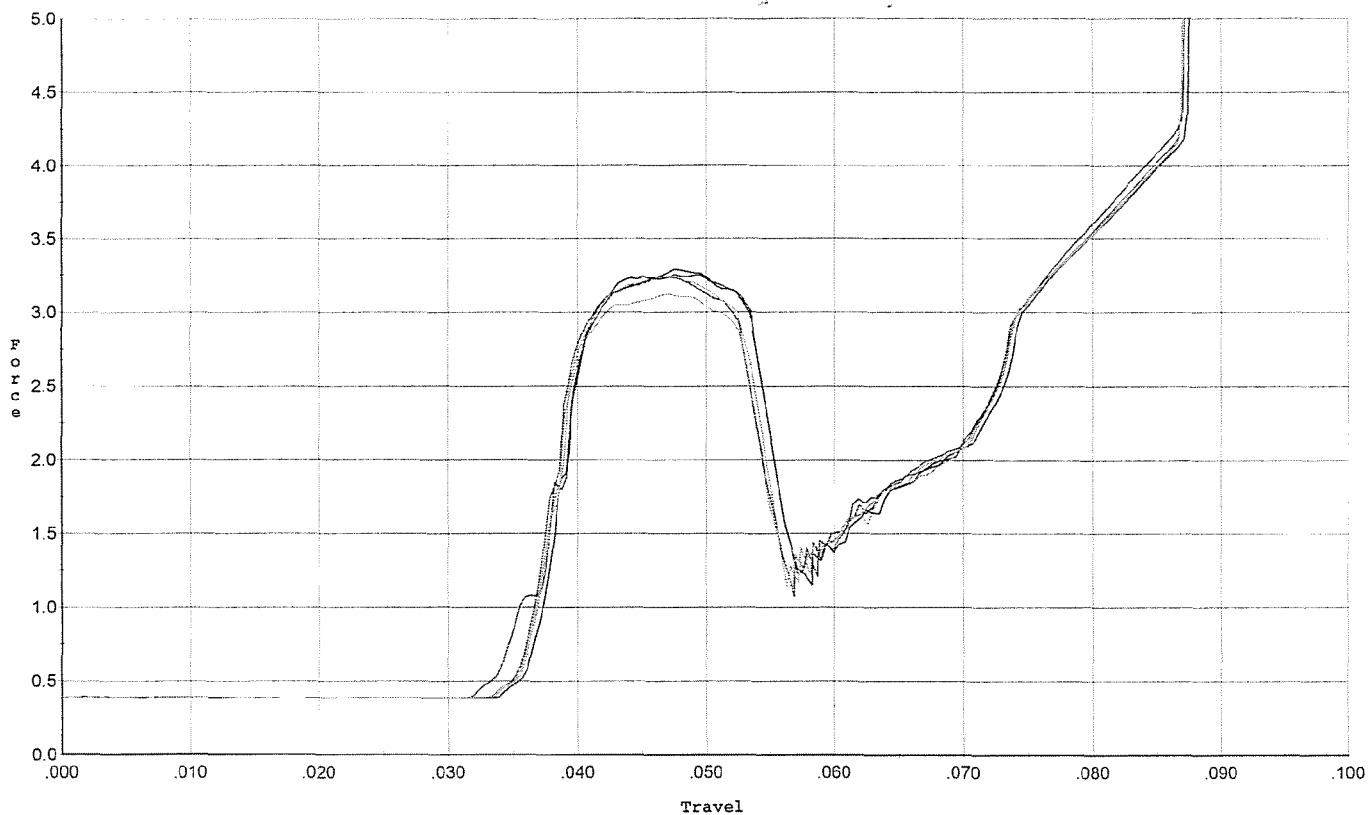
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.254	0.054	0.037	0.038	0.064		Set Trigger
2	3.169	0.055	0.037	0.038	0.065		Set Trigger
3	3.070	0.055	0.037	0.038	0.063		Set Trigger
4	3.082	0.054	0.037	0.038	0.061		Set Trigger
5	3.078	0.054	0.036	0.037	0.063		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



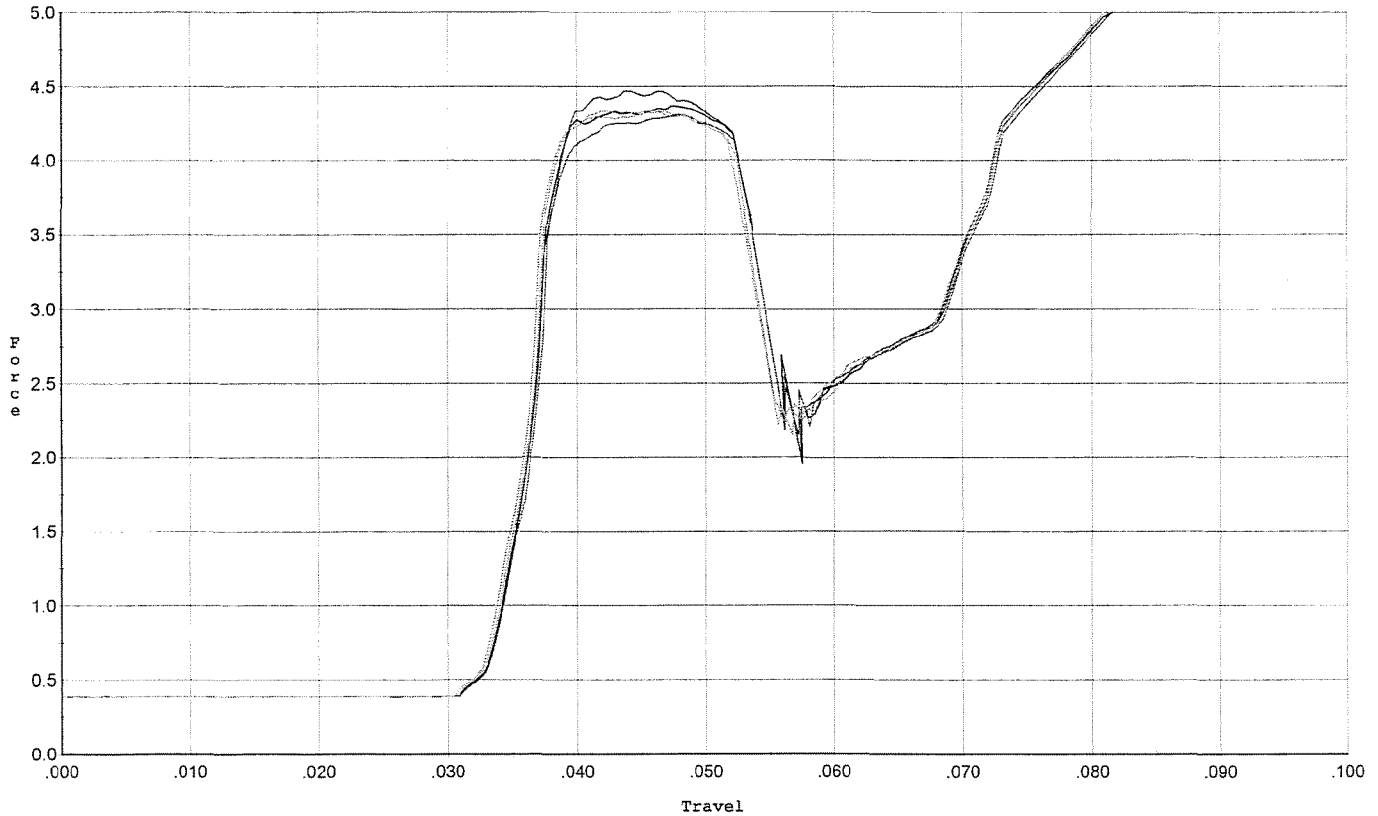
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.253	0.053	0.034	0.037	0.066		Set Trigger
2	3.292	0.053	0.036	0.037	0.065		Set Trigger
3	3.241	0.053	0.036	0.037	0.063		Set Trigger
4	3.243	0.053	0.036	0.037	0.064		Set Trigger
5	3.121	0.053	0.036	0.037	0.061		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



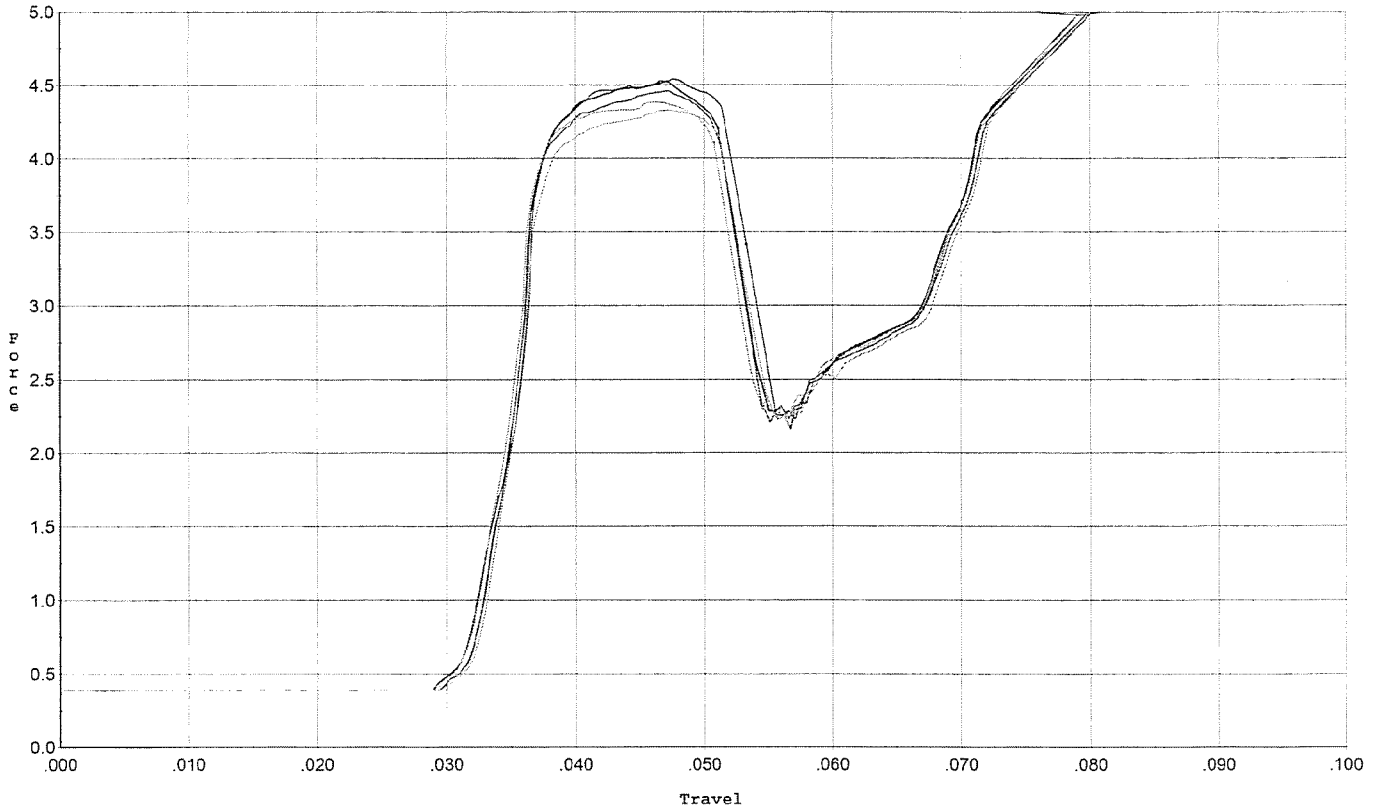
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.472	0.054	0.031	0.035	0.090		Set Trigger
2	4.368	0.053	0.033	0.035	0.090		Set Trigger
3	4.304	0.054	0.033	0.035	0.088		Set Trigger
4	4.331	0.053	0.033	0.034	0.089		Set Trigger
5	4.337	0.052	0.033	0.035	0.087		Set Trigger

A-436

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



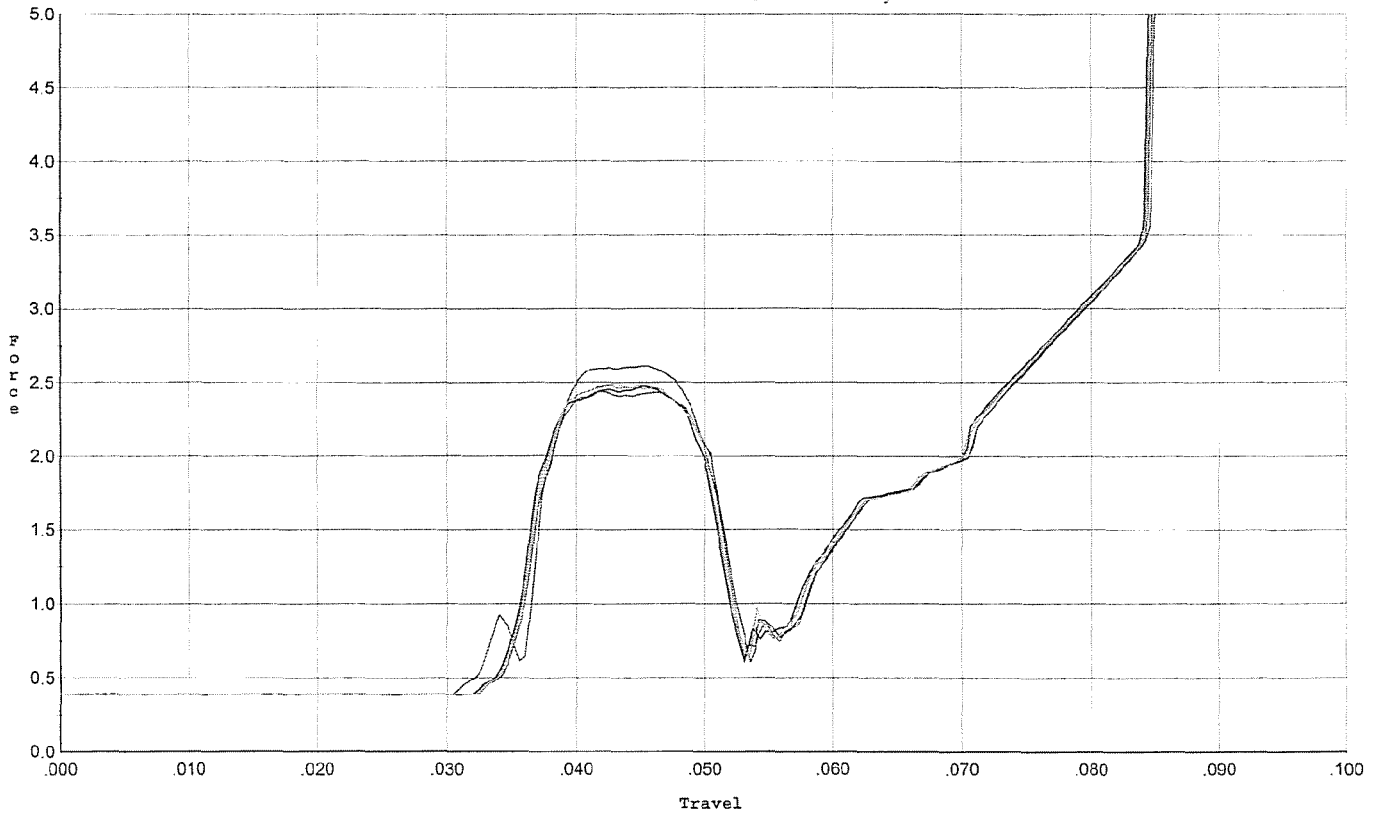
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.542	0.053	0.031	0.033	0.094		Set Trigger
2	4.529	0.051	0.032	0.034	0.088		Set Trigger
3	4.463	0.051	0.032	0.033	0.088		Set Trigger
4	4.329	0.051	0.032	0.034	0.085		Set Trigger
5	4.385	0.051	0.031	0.034	0.086		Set Trigger

A-4.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



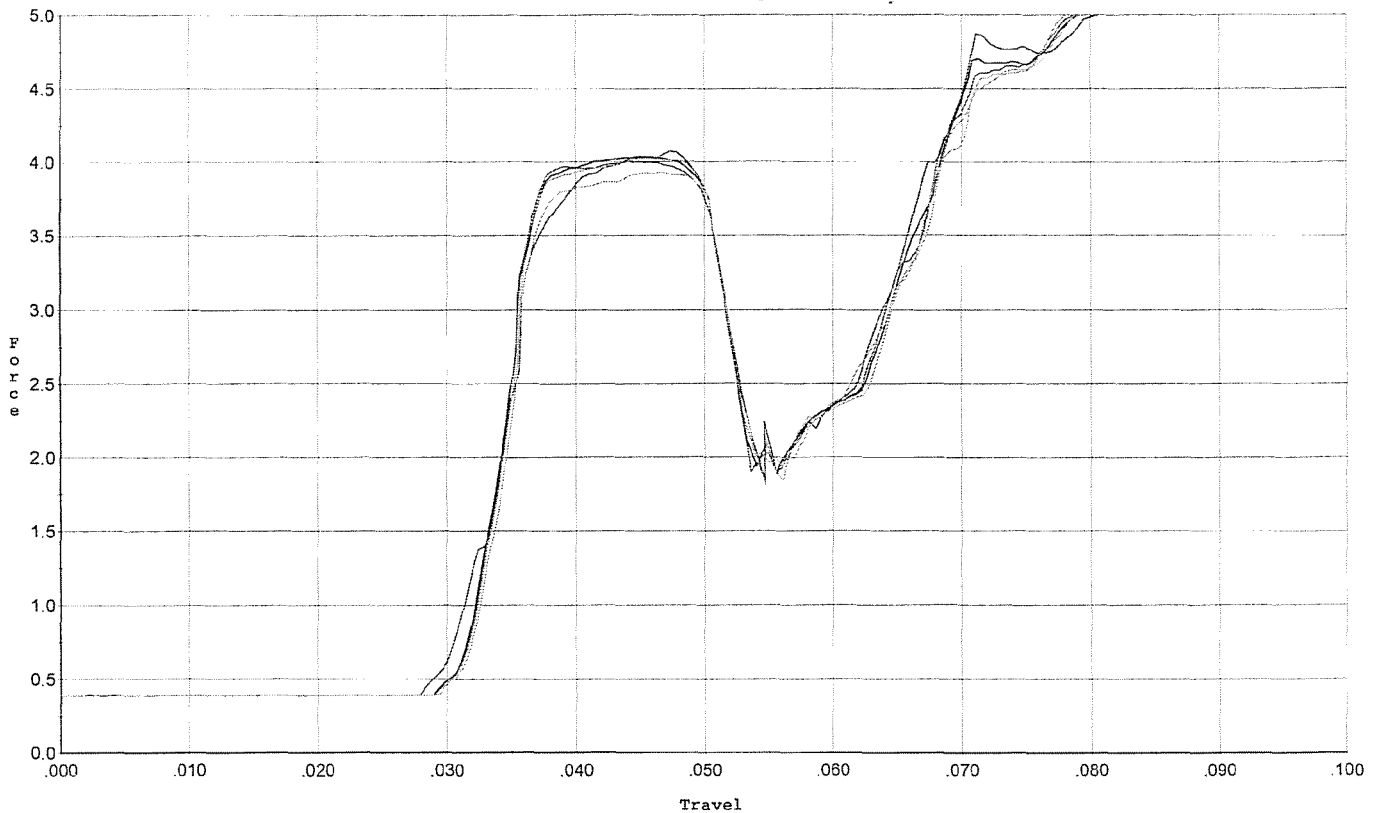
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.610	0.050	0.033	0.038	0.049		Set Trigger
2	2.474	0.050	0.034	0.038	0.047		Set Trigger
3	2.436	0.051	0.035	0.038	0.048		Set Trigger
4	2.483	0.050	0.035	0.038	0.047		Set Trigger
5	2.477	0.050	0.035	0.038	0.047		Set Trigger

A - 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.073	0.050	0.028	0.035	0.080		Set Trigger
2	4.036	0.050	0.031	0.035	0.080		Set Trigger
3	4.009	0.050	0.031	0.034	0.080		Set Trigger
4	3.931	0.050	0.030	0.035	0.077		Set Trigger
5	4.034	0.050	0.031	0.034	0.079		Set Trigger

A-4.01