

G6794777

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



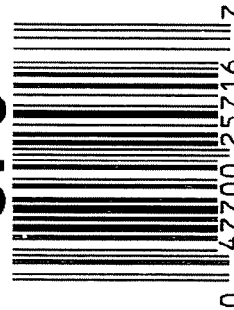
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794777

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794777

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SPD
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SPD
460	CHECK HEADSPACE		10-7-08	SPD
470	DIS-ASSEMBLE ACTION		10-7-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-8-08	Rsn
475	DRILL AND TAP SIGHT HOLES	2008	10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (KS)	10/11/08	(KS)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-28-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

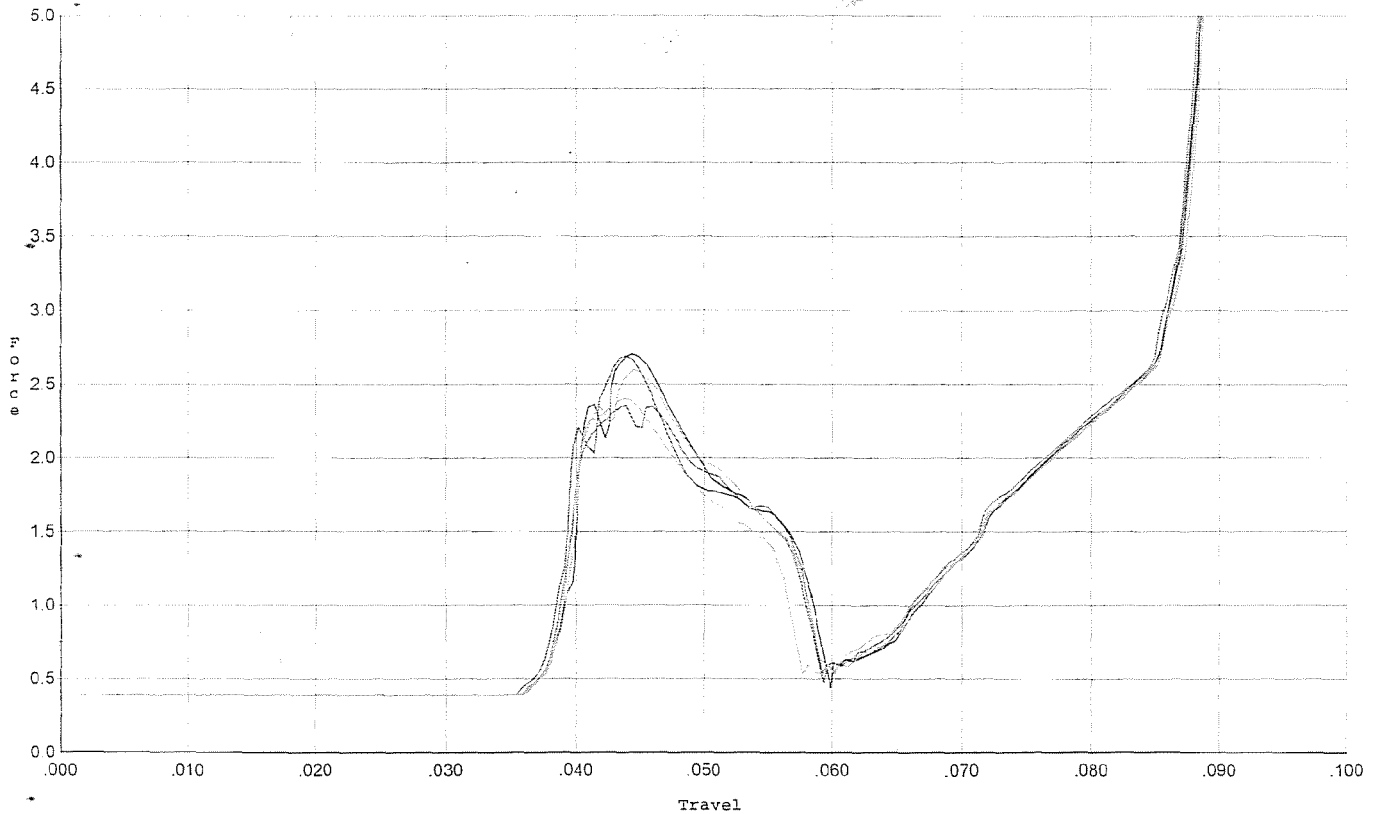
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	11-3-08	LD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	11-3-08	LD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	11-3-08	LD
	J) ASSEMBLE STOCK		10-28-08	RT
	K) ASSEMBLE SWIVEL STUDS		11-3-08	LD
	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	10-29-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-29-08	LD
670	FINAL INSPECTION A) HEADSPACE		11-3-08	LD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.40</u> <u>2.39</u> <u>2.36</u> <u>2.37</u>	10/24/08	CM5
	C) FUNCTION		11-3-08	LD
690	PACK		11/4/08	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



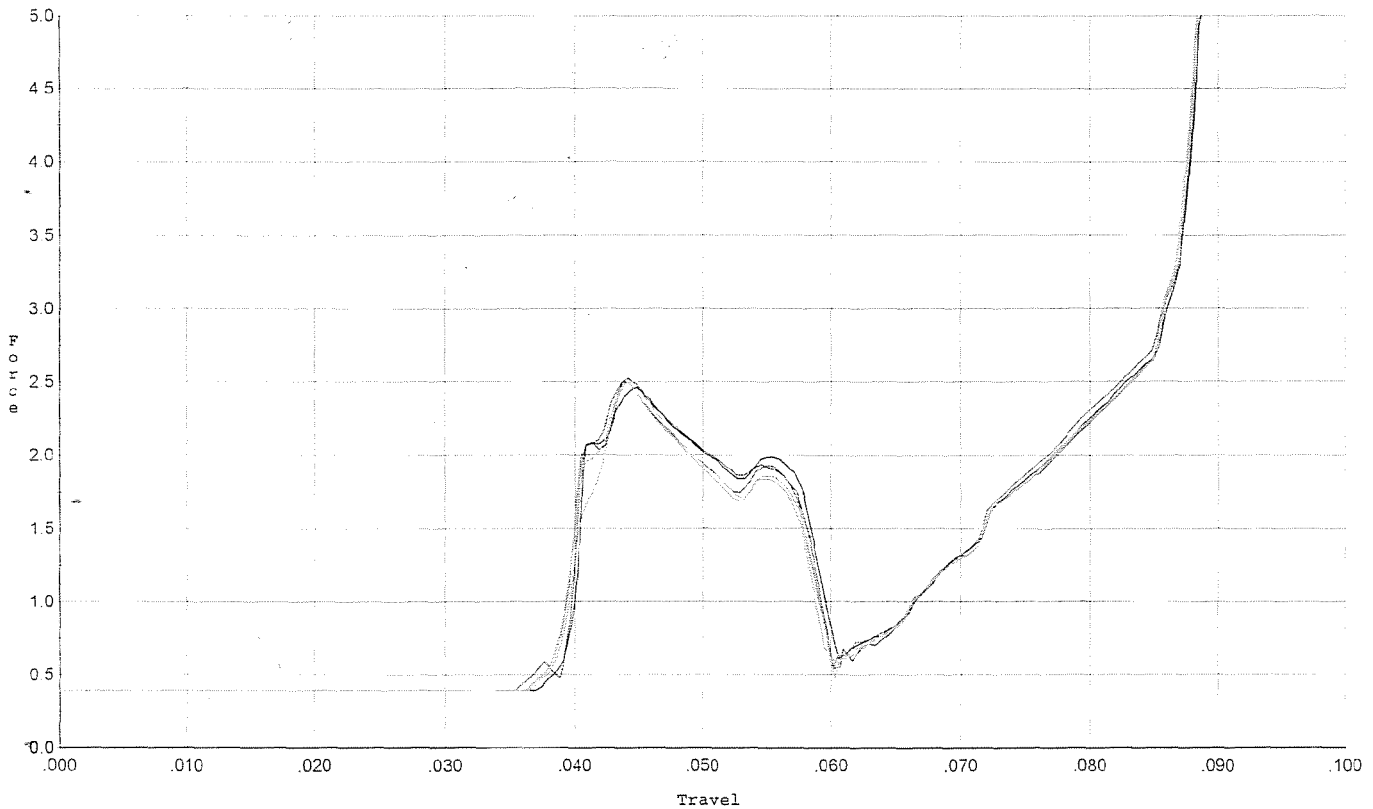
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.692	0.058	0.038	0.038	0.053		Set Trigger
2	2.706	0.058	0.038	0.037	0.054		Set Trigger
3	2.358	0.058	0.038	0.038	0.052		Set Trigger
4	2.407	0.056	0.038	0.039	0.048		Set Trigger
5	2.602	0.058	0.038	0.038	0.053		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



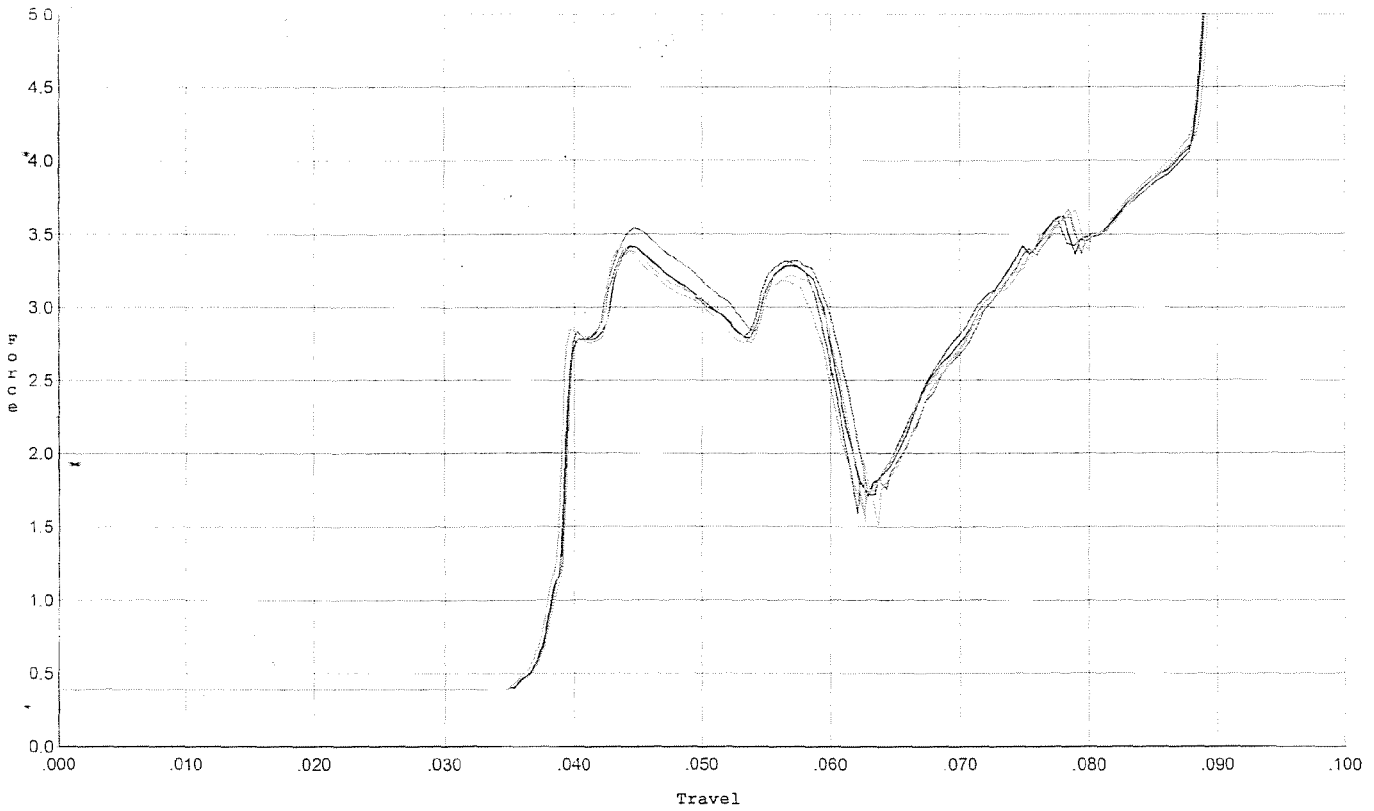
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.525	0.058	0.039	0.037	0.054		Set Trigger
2	2.458	0.058	0.039	0.037	0.053		Set Trigger
3	2.498	0.057	0.038	0.037	0.053		Set Trigger
4	2.491	0.058	0.038	0.037	0.052		Set Trigger
5	2.501	0.059	0.039	0.037	0.053		Set Trigger

A 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



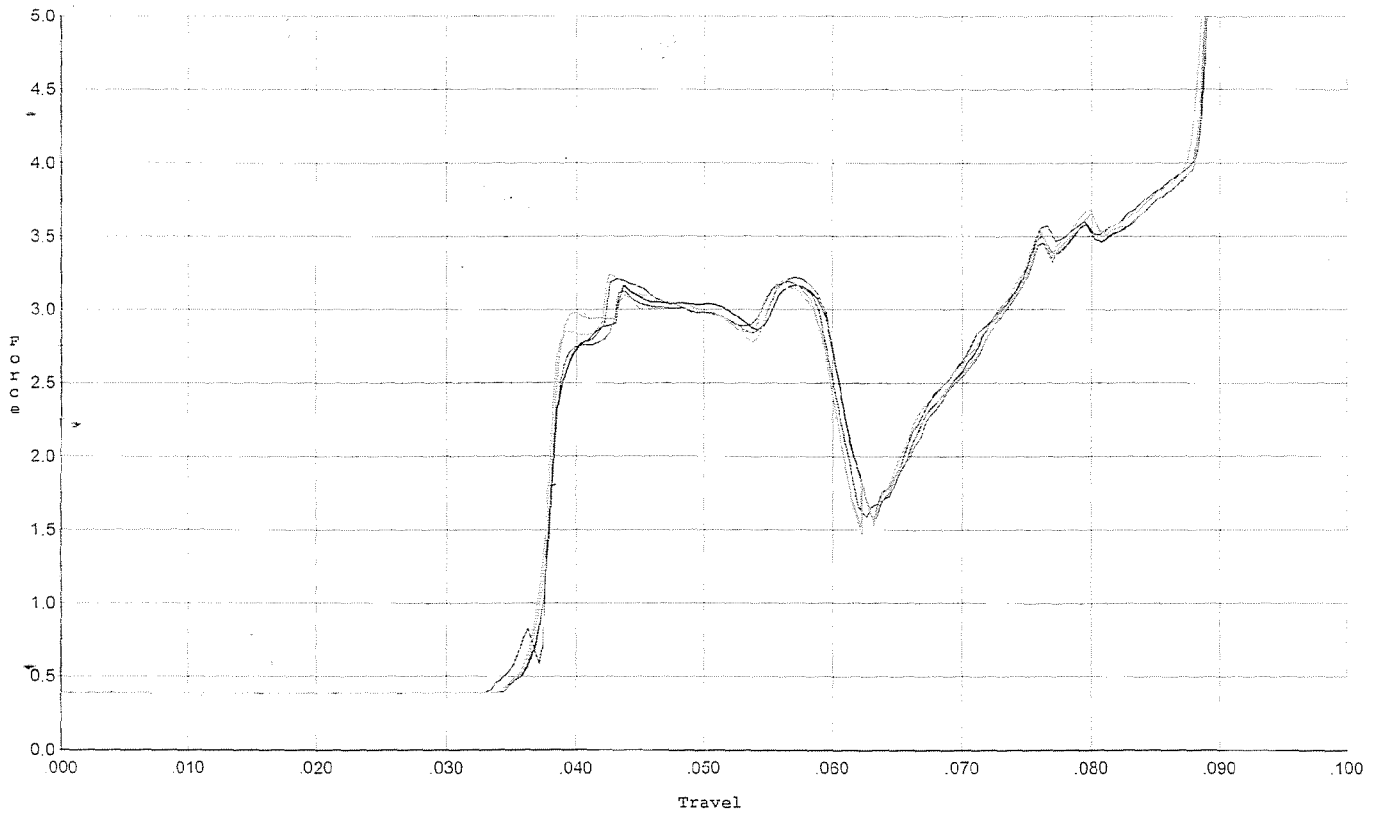
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.422	0.060	0.037	0.034	0.081		Set Trigger
2	3.415	0.059	0.037	0.034	0.080		Set Trigger
3	3.539	0.061	0.037	0.033	0.086		Set Trigger
4	3.390	0.061	0.037	0.034	0.081		Set Trigger
5	3.409	0.059	0.037	0.034	0.079		Set Trigger

A 3-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



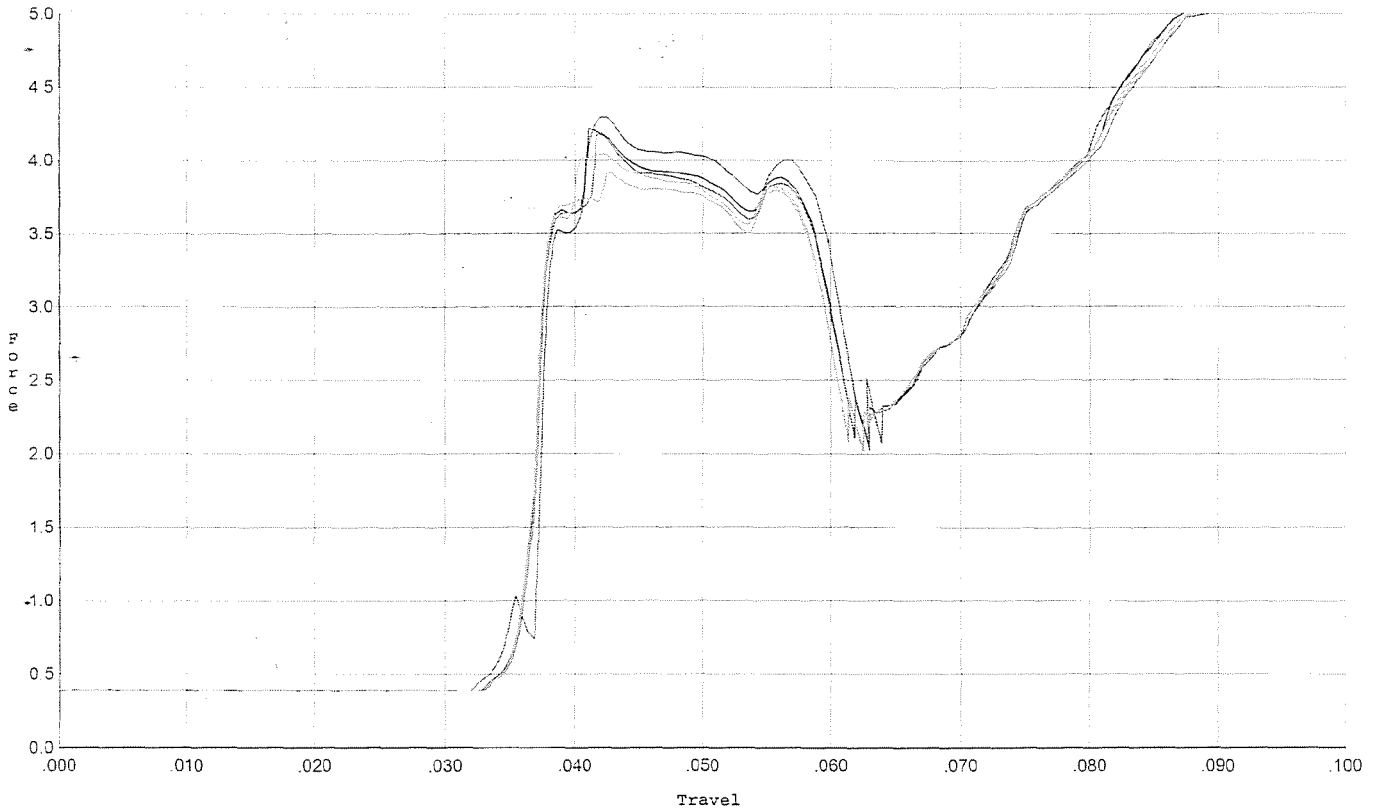
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.210	0.059	0.036	0.034	0.080		Set Trigger
2	3.169	0.060	0.036	0.034	0.081		Set Trigger
3	3.219	0.059	0.037	0.034	0.080		Set Trigger
4	3.240	0.059	0.036	0.034	0.081		Set Trigger
5	3.152	0.059	0.036	0.034	0.080		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



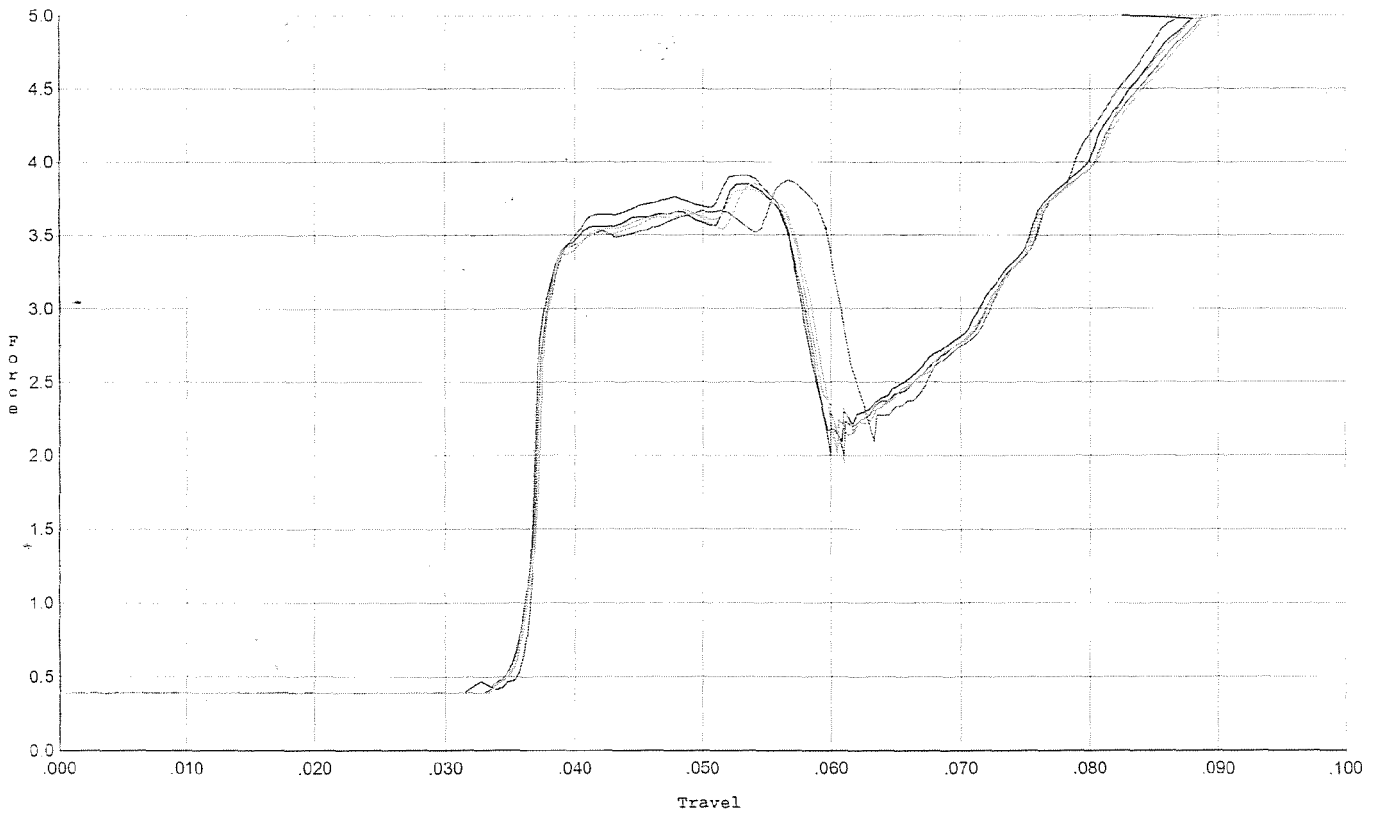
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.292	0.060	0.034	0.032	0.104		Set Trigger
2	4.218	0.060	0.035	0.032	0.103		Set Trigger
3	4.190	0.060	0.035	0.032	0.102		Set Trigger
4	4.042	0.059	0.035	0.033	0.100		Set Trigger
5	3.923	0.059	0.035	0.033	0.098		Set Trigger

A 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



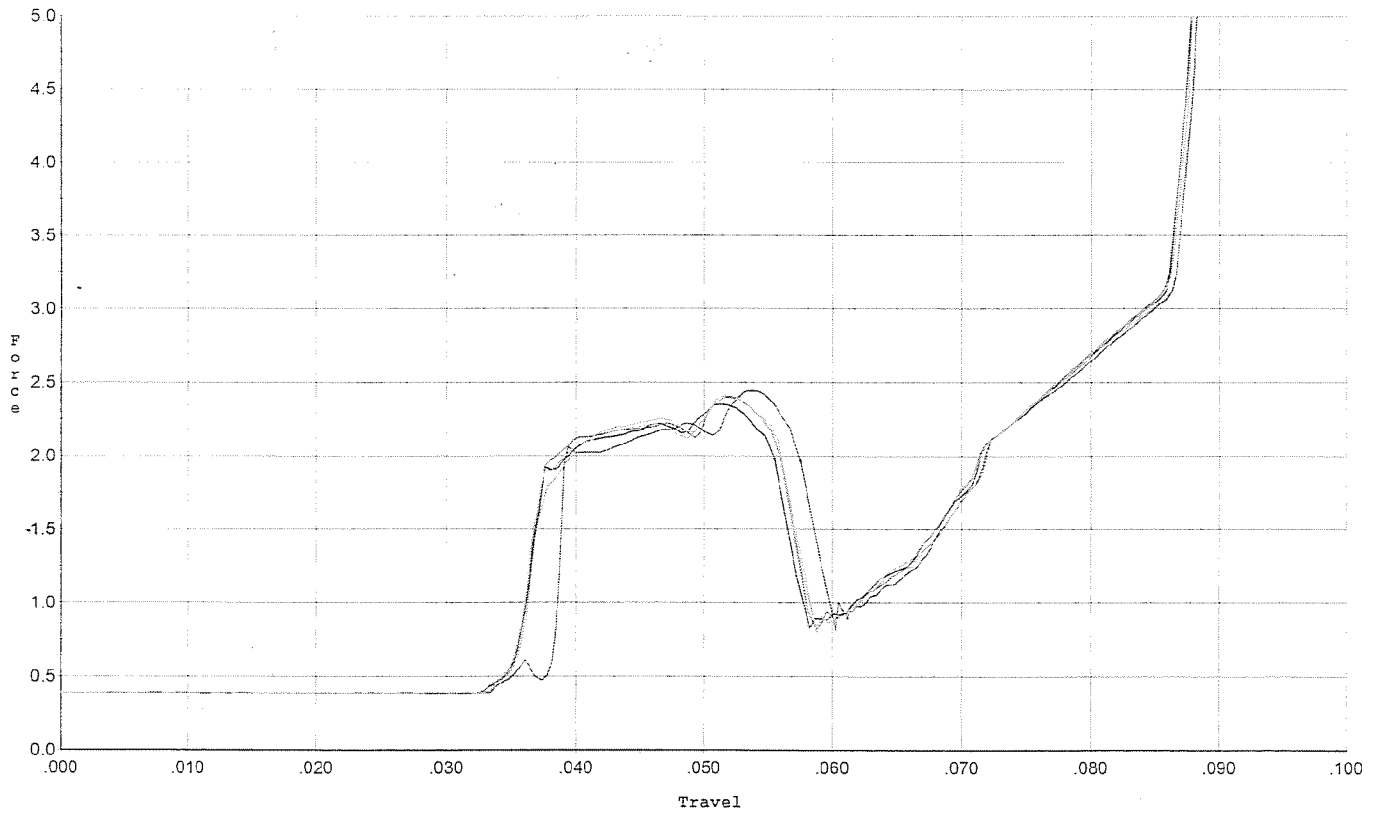
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.908	0.058	0.036	0.035	0.091		Set Trigger
2	3.850	0.057	0.035	0.035	0.088		Set Trigger
3	3.874	0.060	0.035	0.033	0.098		Set Trigger
4	3.854	0.058	0.036	0.035	0.091		Set Trigger
5	3.809	0.057	0.036	0.035	0.089		Set Trigger

A 385

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



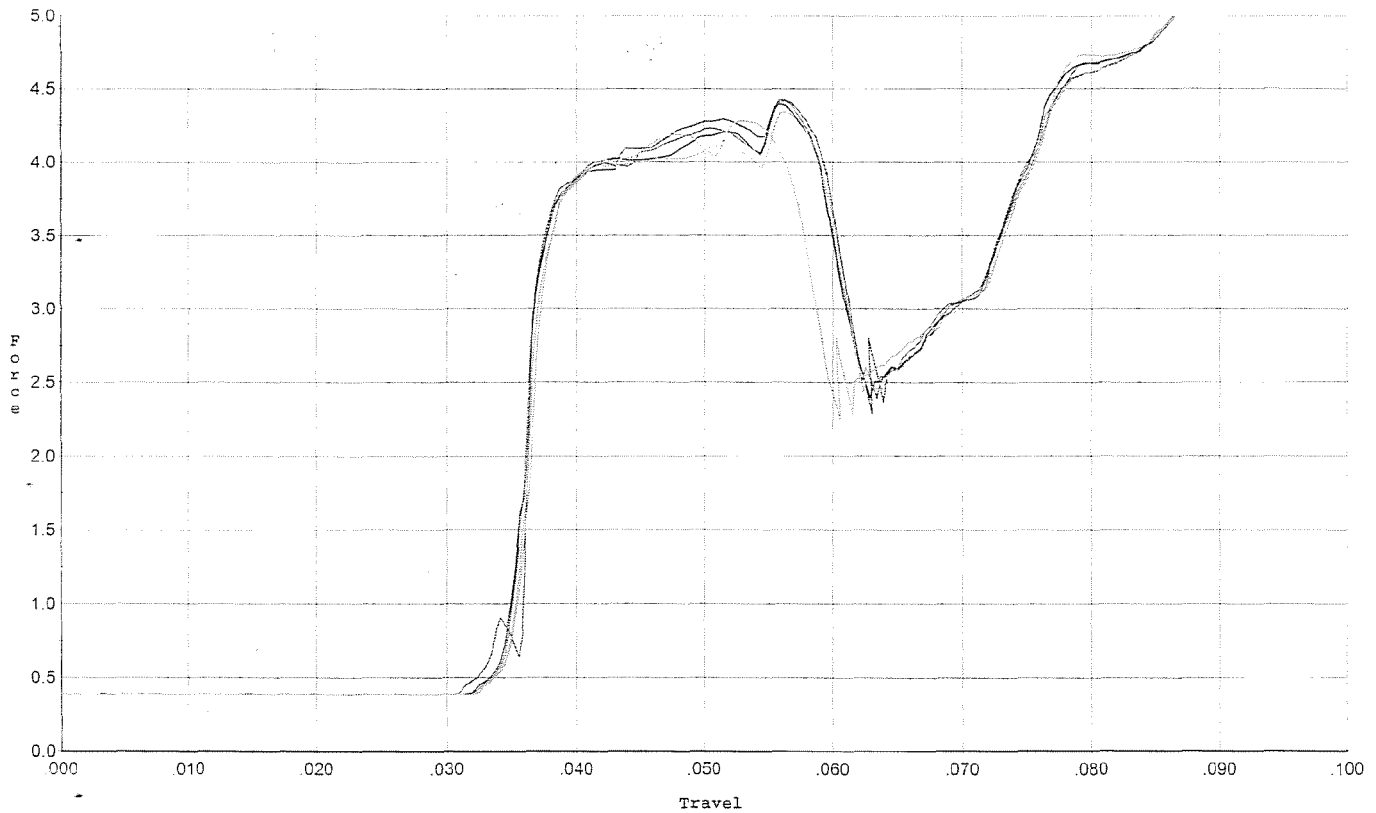
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.058	0.038	0.037	0.057		Set Trigger
2	2.352	0.055	0.035	0.037	0.056		Set Trigger
3	2.402	0.056	0.035	0.036	0.058		Set Trigger
4	2.412	0.056	0.035	0.036	0.057		Set Trigger
5	2.397	0.056	0.036	0.037	0.057		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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	4.428	0.060	0.033	0.032	0.112		Set Trigger
2	4.397	0.059	0.034	0.032	0.109		Set Trigger
3	4.422	0.059	0.034	0.032	0.109		Set Trigger
4	4.345	0.060	0.035	0.032	0.110		Set Trigger
5	4.281	0.057	0.035	0.034	0.101		Set Trigger

A 4.37