

G6814684

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



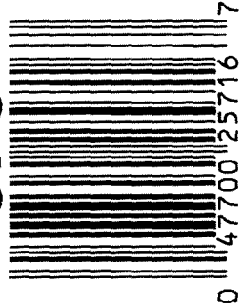
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6814684

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6814684

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RTZ
480	MAGNAFLUX BBL ACTION	(A)	3/9/09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-28-09	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>7</u> <u>4.5</u> <u>4.5</u>	4-1-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-1-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	4-1-09	WV
	J) ASSEMBLE STOCK		3-28-09	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-1-09	WV
	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	3-31-09	S.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.23</u> <u>2.24</u> <u>2.21</u> <u>2.43</u>	4-1-09	WV
	C) FUNCTION		4-1-09	WV
690	PACK		4/9/09	Fry

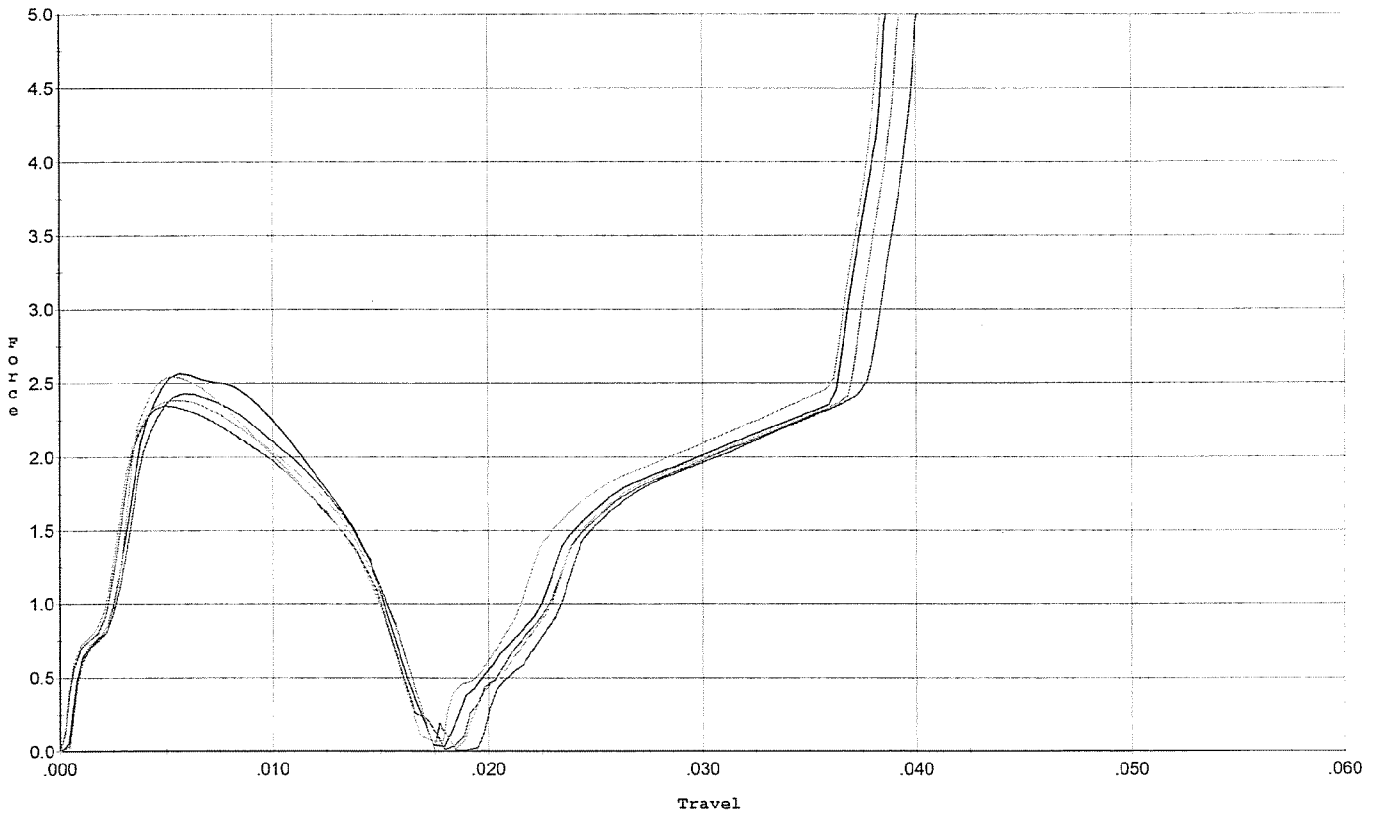
F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

Model: M/24
Serial No: Form #F005
Trigger: ~~250102 5 lbs in 1/2~~

2-50 lbs - iwi +/- .50 lb
cms



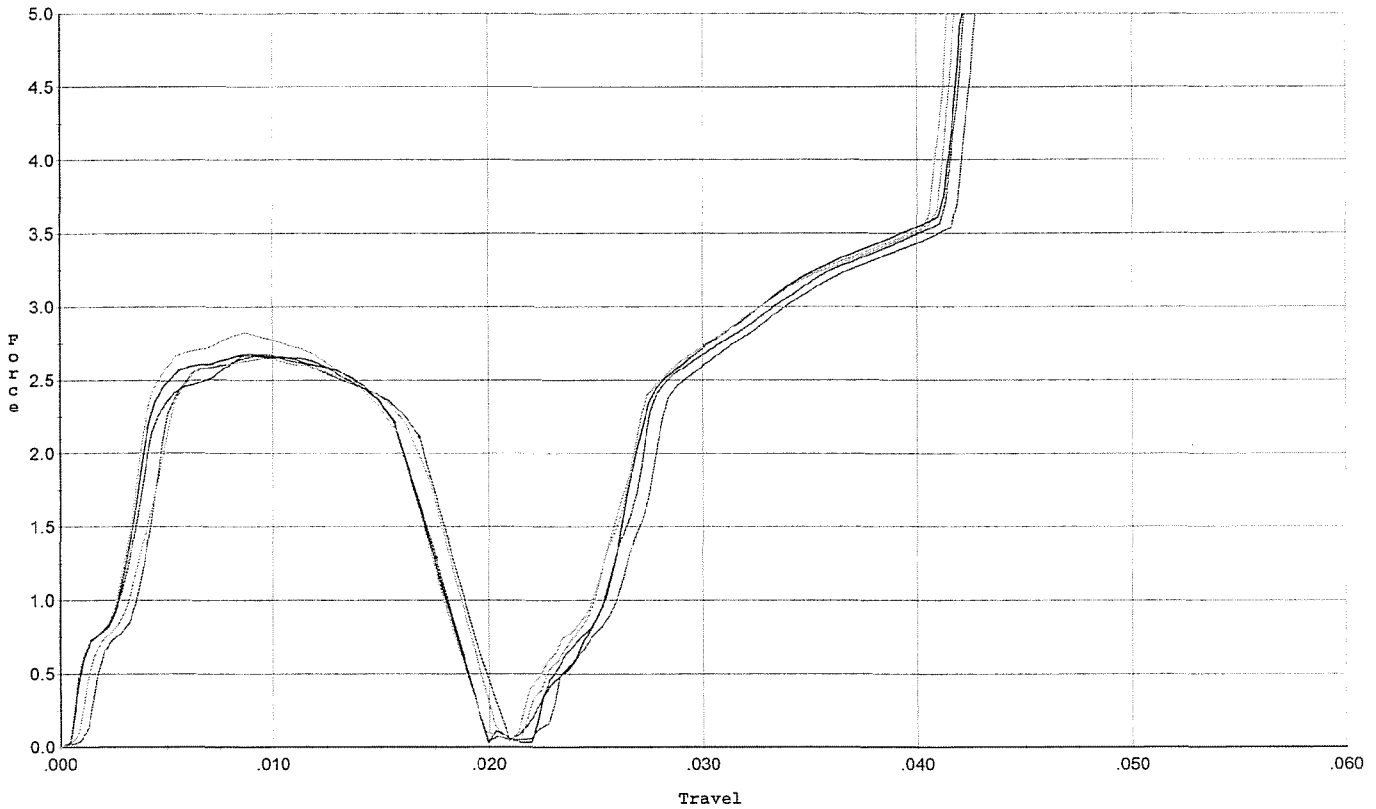
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.429	0.016	0.00	0.030	0.025		Set Trigger
2	2.564	0.015	0.00	0.029	0.025		Set Trigger
3	2.347	0.015	0.00	0.030	0.024		Set Trigger
4	2.544	0.016	0.00	0.029	0.026		Set Trigger
5	2.383	0.015	0.00	0.028	0.025		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



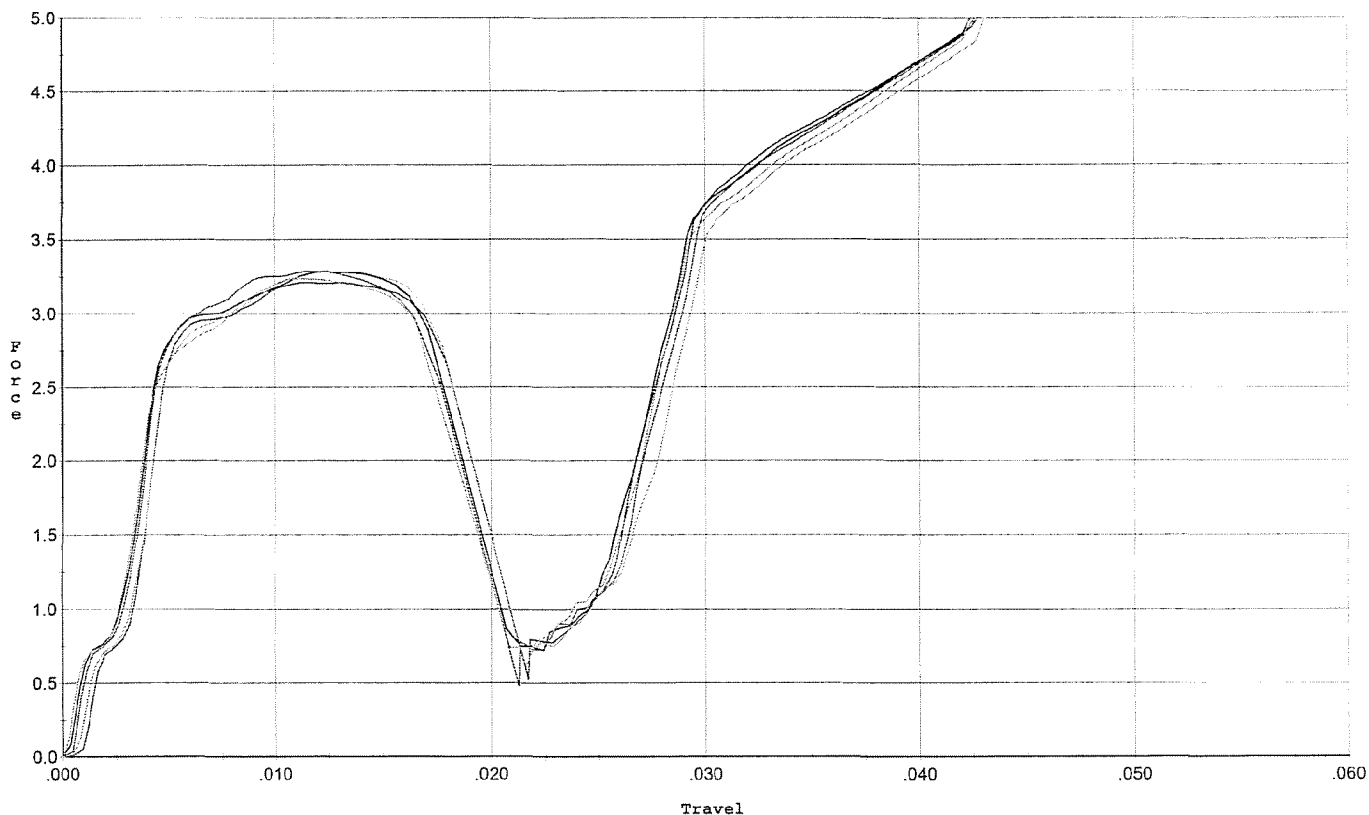
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.018	0.00	0.029	0.034		Set Trigger
2	2.682	0.016	0.00	0.029	0.031		Set Trigger
3	2.676	0.017	0.00	0.029	0.031		Set Trigger
4	2.824	0.016	0.00	0.029	0.032		Set Trigger
5	2.648	0.017	0.00	0.028	0.032		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



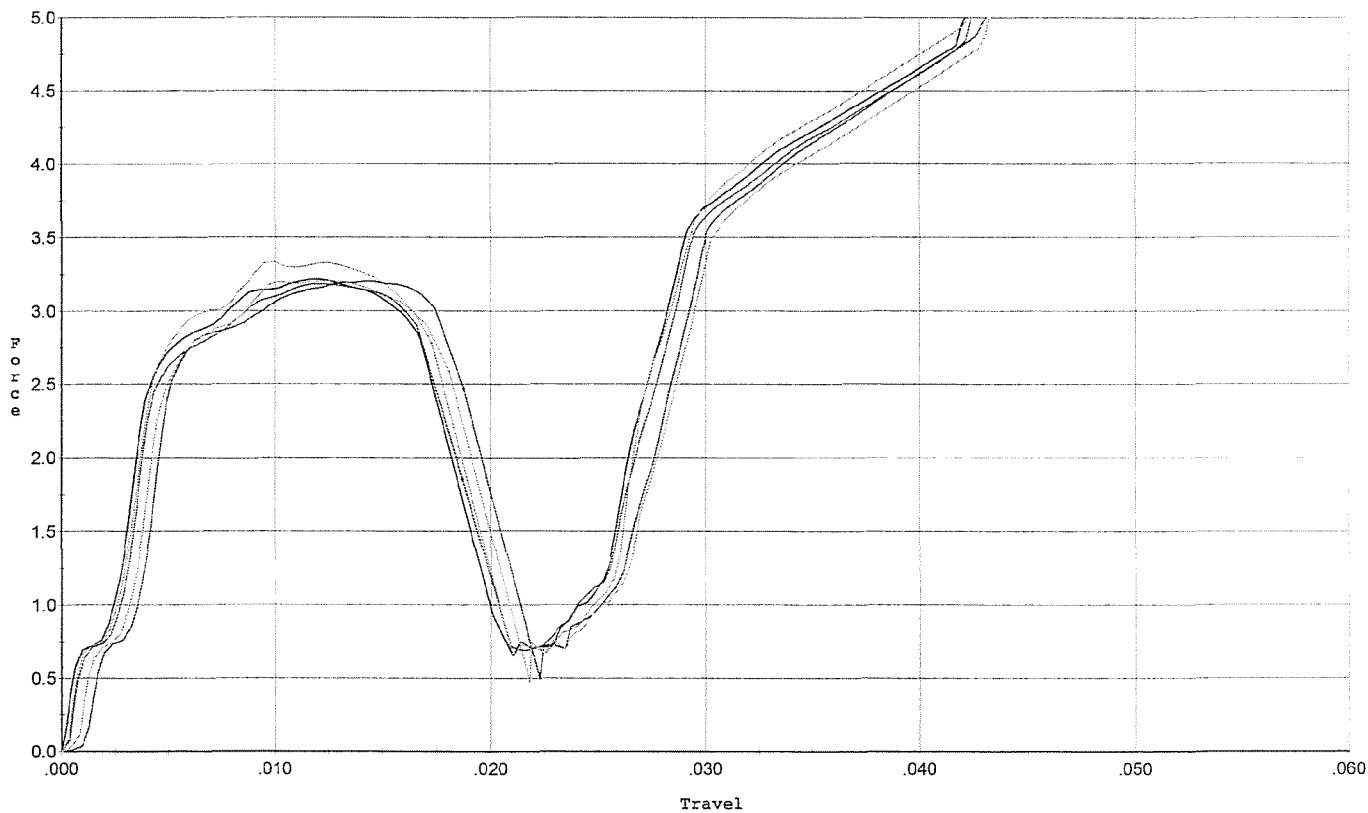
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.209	0.018	0.00	0.027	0.041		Set Trigger
2	3.286	0.017	0.00	0.027	0.041		Set Trigger
3	3.286	0.018	0.00	0.028	0.042		Set Trigger
4	3.281	0.018	0.00	0.028	0.041		Set Trigger
5	3.234	0.019	0.00	0.027	0.043		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



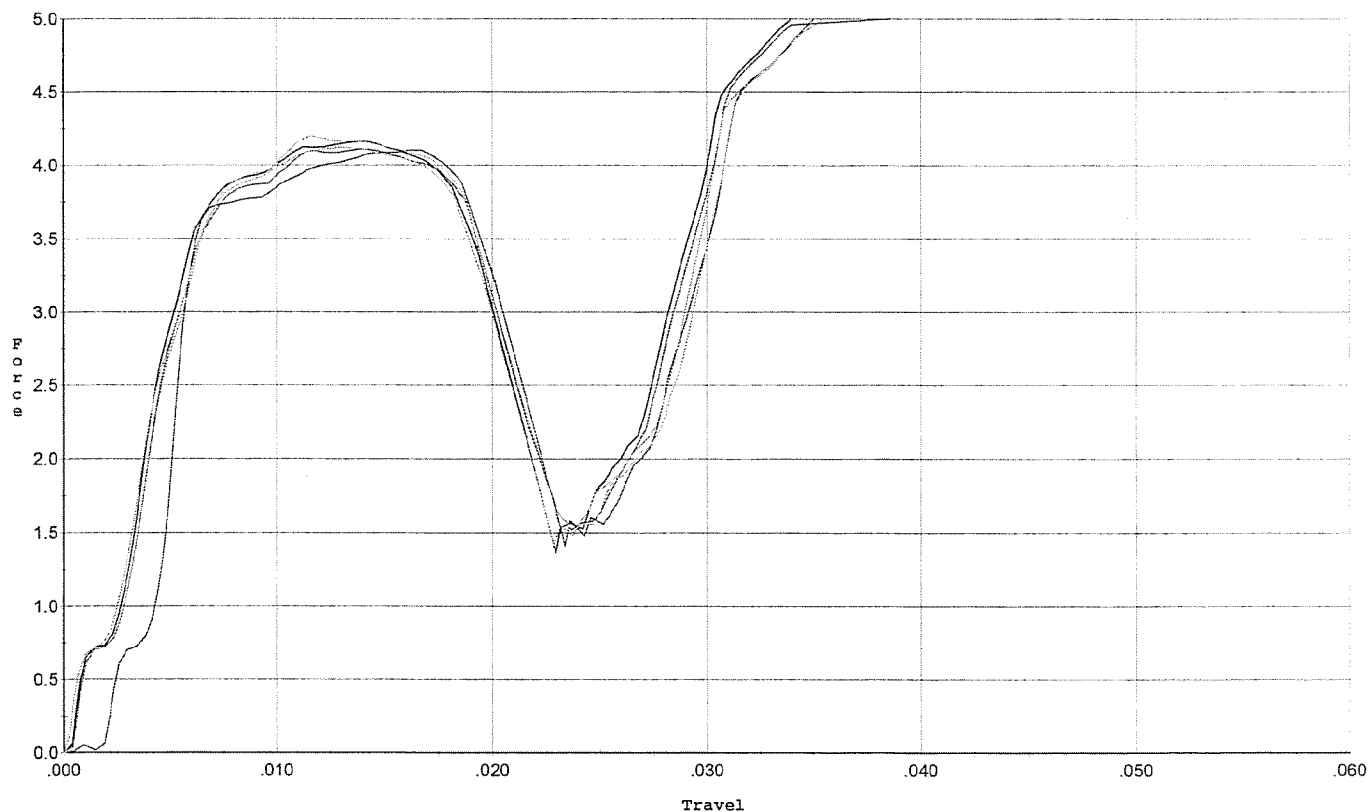
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.200	0.019	0.00	0.028	0.042		Set Trigger
2	3.215	0.017	0.00	0.027	0.039		Set Trigger
3	3.184	0.019	0.00	0.027	0.043		Set Trigger
4	3.204	0.018	0.00	0.028	0.041		Set Trigger
5	3.338	0.017	0.00	0.027	0.042		Set Trigger

A.3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



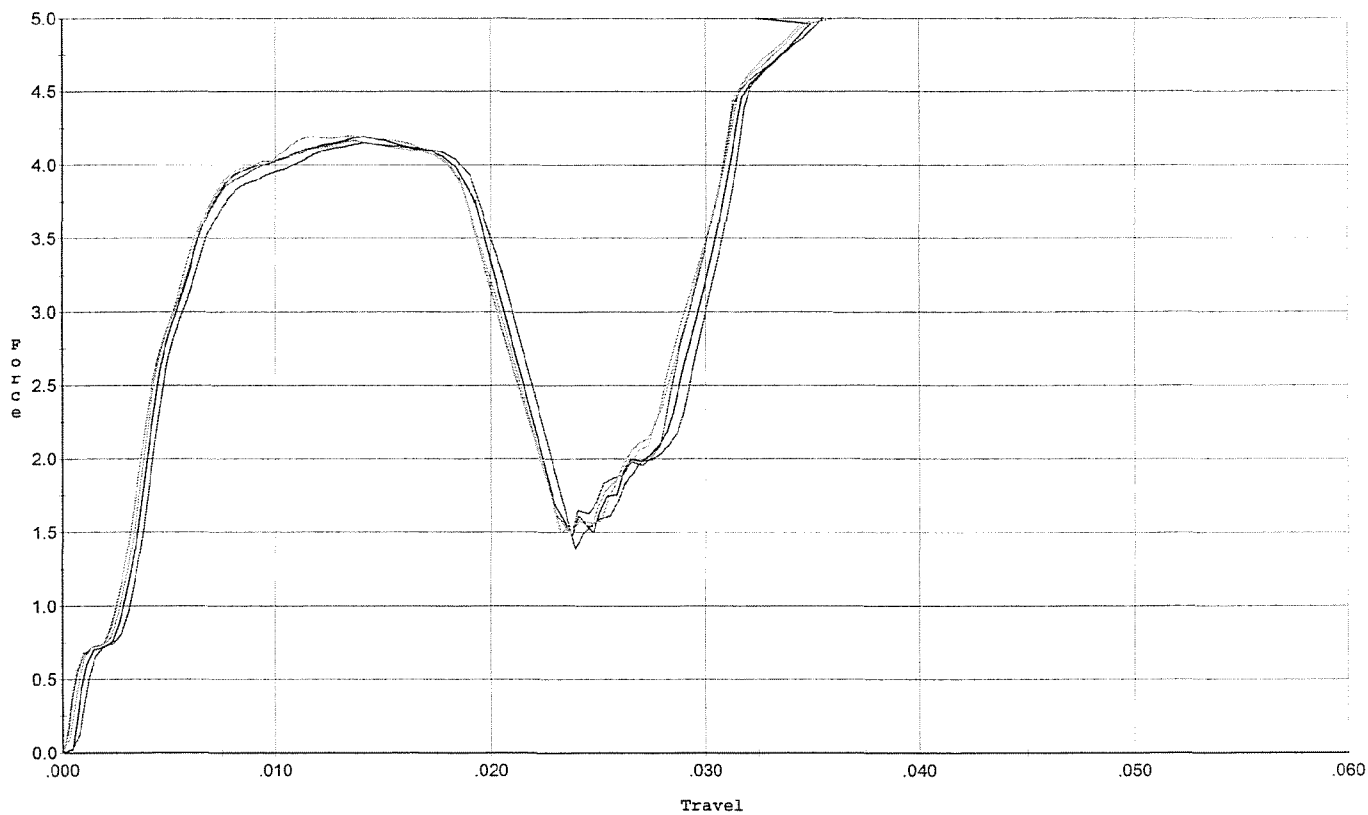
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.104	0.020	0.00	0.026	0.055		Set Trigger
2	4.162	0.019	0.00	0.025	0.057		Set Trigger
3	4.109	0.019	0.00	0.025	0.054		Set Trigger
4	4.201	0.019	0.00	0.026	0.055		Set Trigger
5	4.122	0.020	0.00	0.025	0.057		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



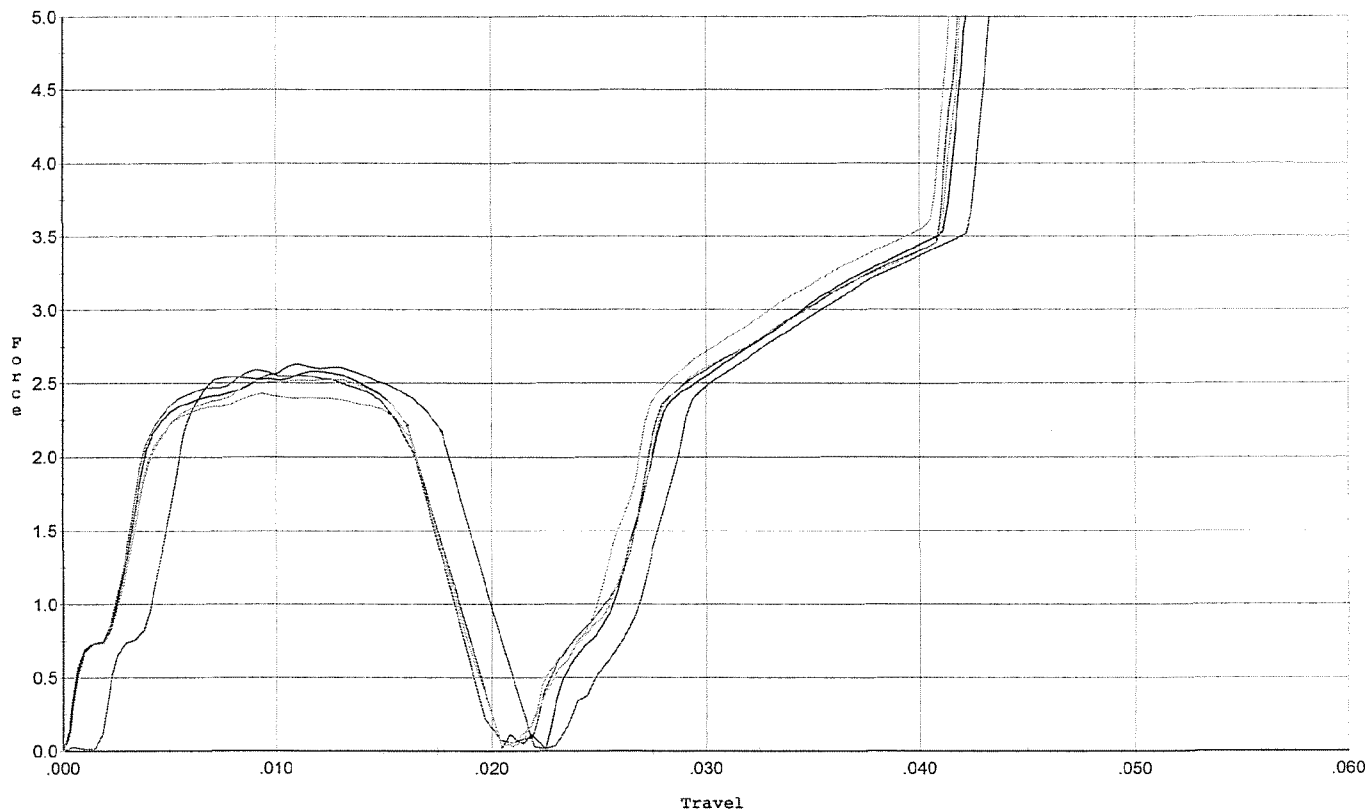
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.150	0.021	0.00	0.026	0.060		Set Trigger
2	4.191	0.019	0.00	0.026	0.057		Set Trigger
3	4.165	0.019	0.00	0.026	0.055		Set Trigger
4	4.163	0.019	0.00	0.026	0.055		Set Trigger
5	4.199	0.020	0.00	0.025	0.061		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



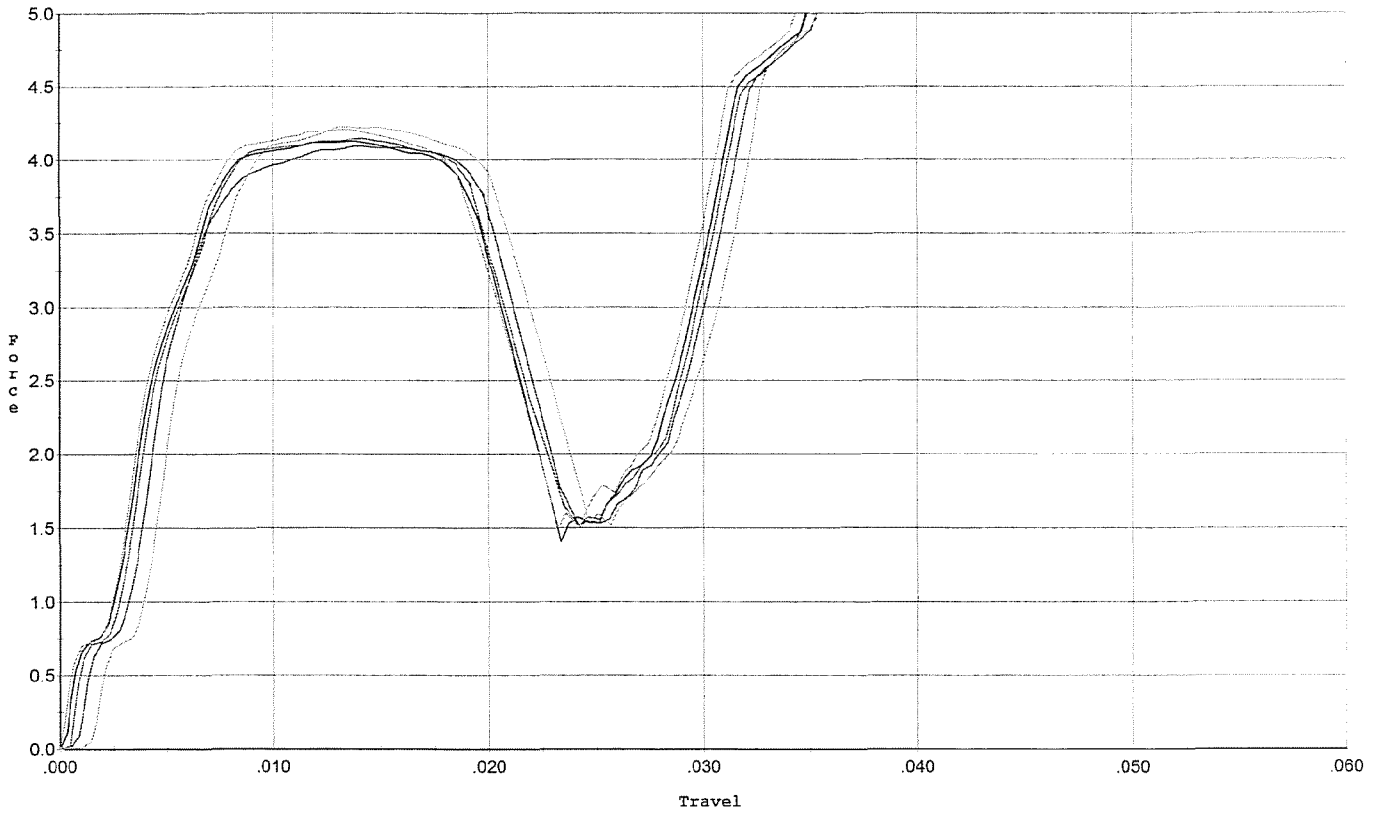
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.629	0.018	0.002	0.029	0.032		Set Trigger
2	2.578	0.016	0.00	0.029	0.031		Set Trigger
3	2.590	0.016	0.00	0.028	0.032		Set Trigger
4	2.523	0.018	0.00	0.028	0.034		Set Trigger
5	2.429	0.016	0.00	0.028	0.030		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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	4.091	0.020	0.00	0.016	0.057		Set Trigger
2	4.128	0.020	0.00	0.017	0.058		Set Trigger
3	4.145	0.019	0.00	0.017	0.056		Set Trigger
4	4.223	0.022	0.00	0.016	0.063		Set Trigger
5	4.204	0.020	0.00	0.016	0.061		Set Trigger

A 4.15