

G6814702

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

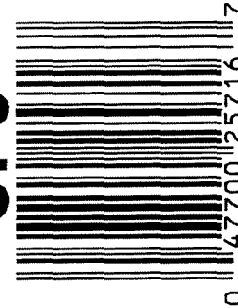
24"

CAPACITY

6

G6814702

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6814702

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	RTZ
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-6-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	Sp
480	MAGNAFLUX BBL ACTION	OPERATOR (JD)	3/9/09	(JD)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	mon
542	APPLY COATINGS (BARREL ACTION)		3-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	Sp
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	Sp
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	Sp
	D) OIL FIRING PIN ASSEMBLY		3-23-09	WAD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

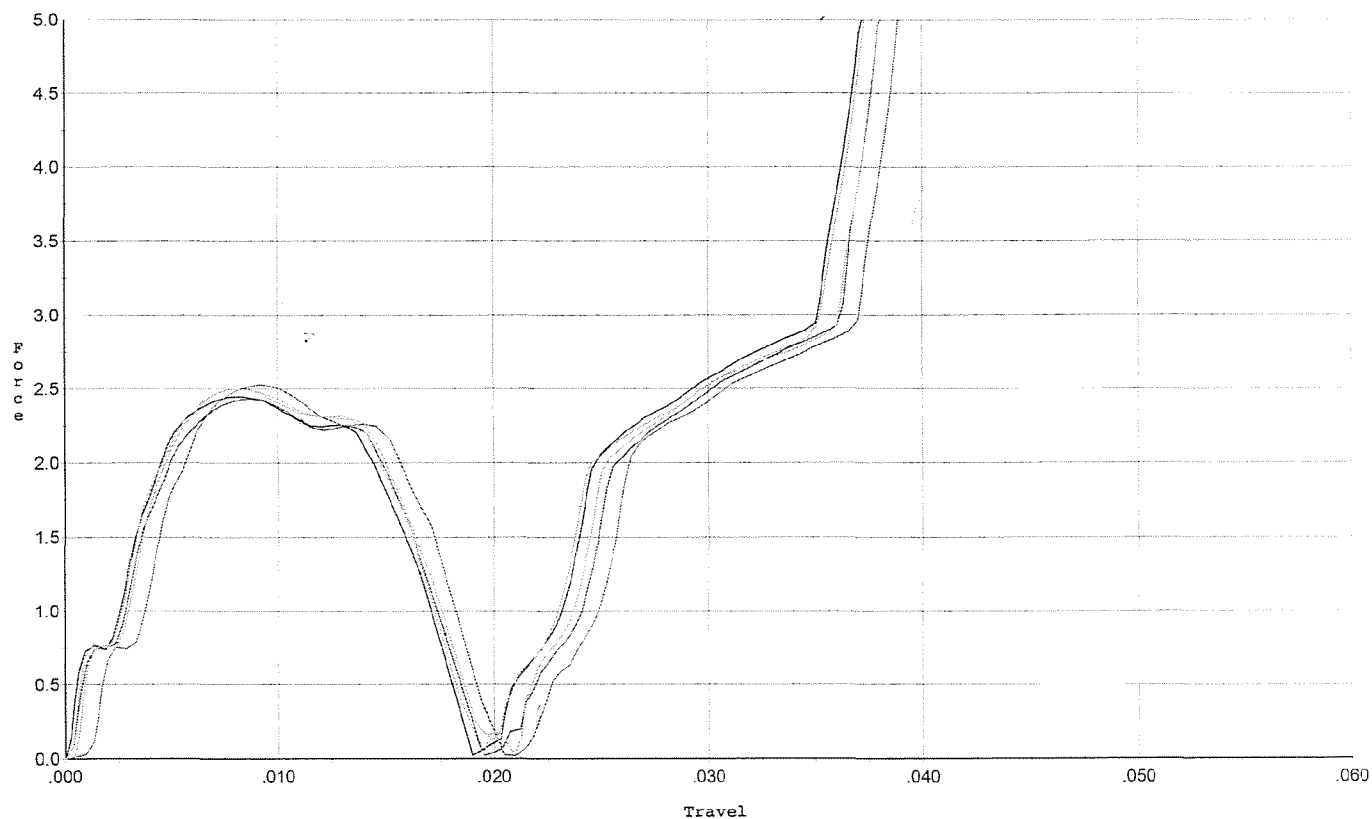
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	3-26-09	L.P.D.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	3-26-09	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	3-26-09	L.P.D.
	J) ASSEMBLE STOCK		3-23-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		3-26-09	L.P.D.
	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	3-25-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WZ
670	FINAL INSPECTION A) HEADSPACE		3-26-09	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.49</u> <u>2.41</u> <u>2.40</u> <u>2.37</u>	3-25-09	TC
	C) FUNCTION		3-26-09	L.P.D.
690	PACK		3/27/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



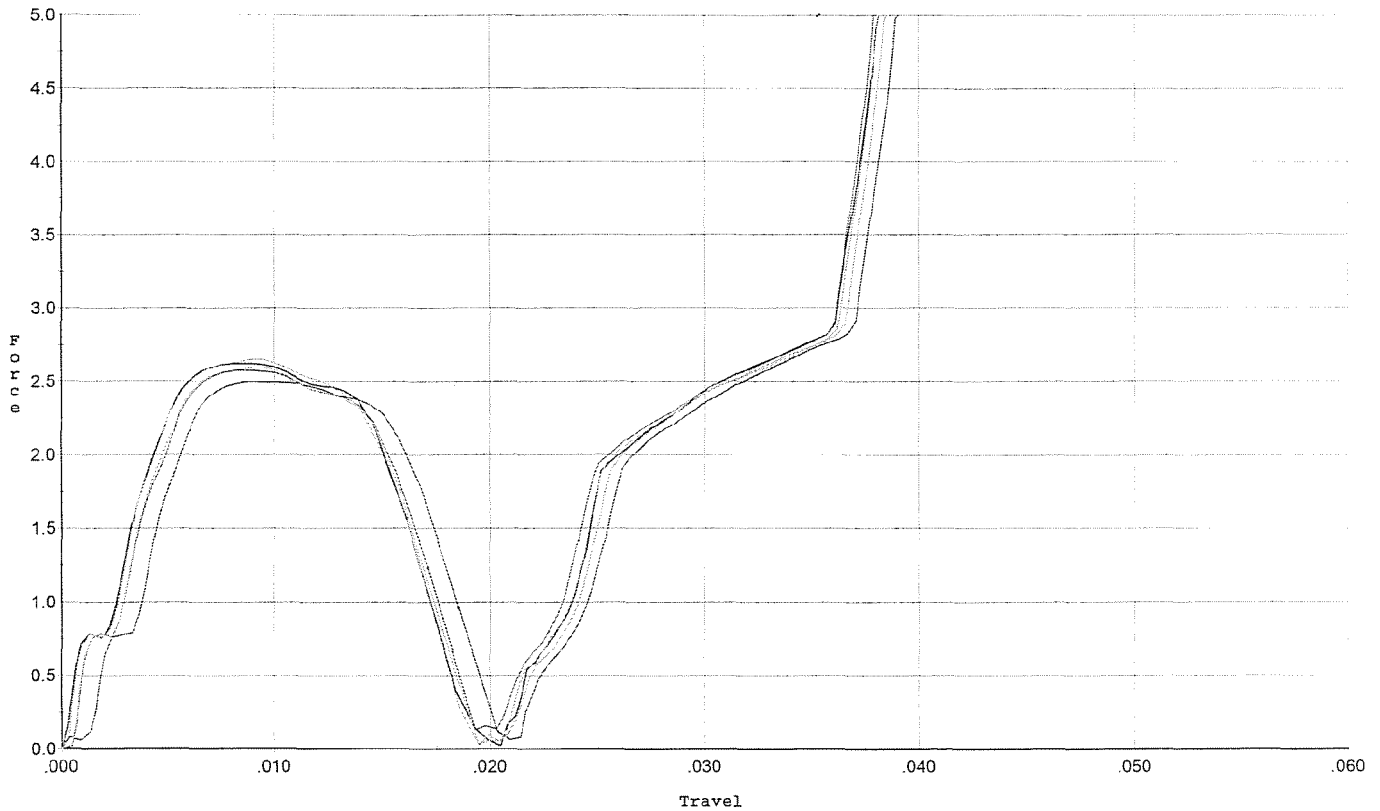
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.431	0.018	0.00	0.026	0.030		Set Trigger
2	2.446	0.017	0.00	0.025	0.029		Set Trigger
3	2.527	0.017	0.00	0.026	0.029		Set Trigger
4	2.496	0.016	0.00	0.026	0.029		Set Trigger
5	2.495	0.017	0.00	0.025	0.030		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



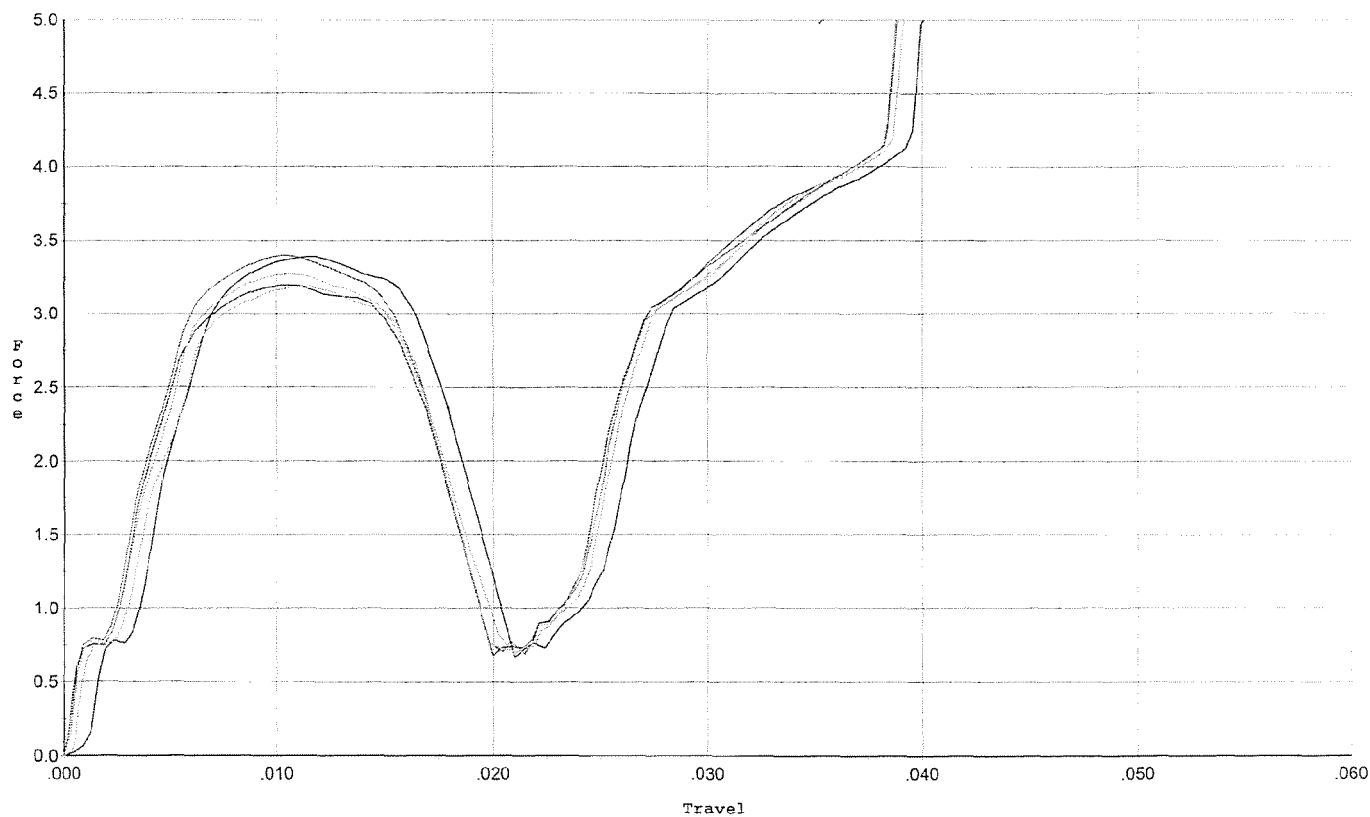
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.019	0.00	0.026	0.032		Set Trigger
2	2.621	0.016	0.00	0.026	0.031		Set Trigger
3	2.576	0.017	0.00	0.026	0.031		Set Trigger
4	2.595	0.016	0.00	0.027	0.029		Set Trigger
5	2.651	0.016	0.00	0.026	0.031		Set Trigger

A. 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



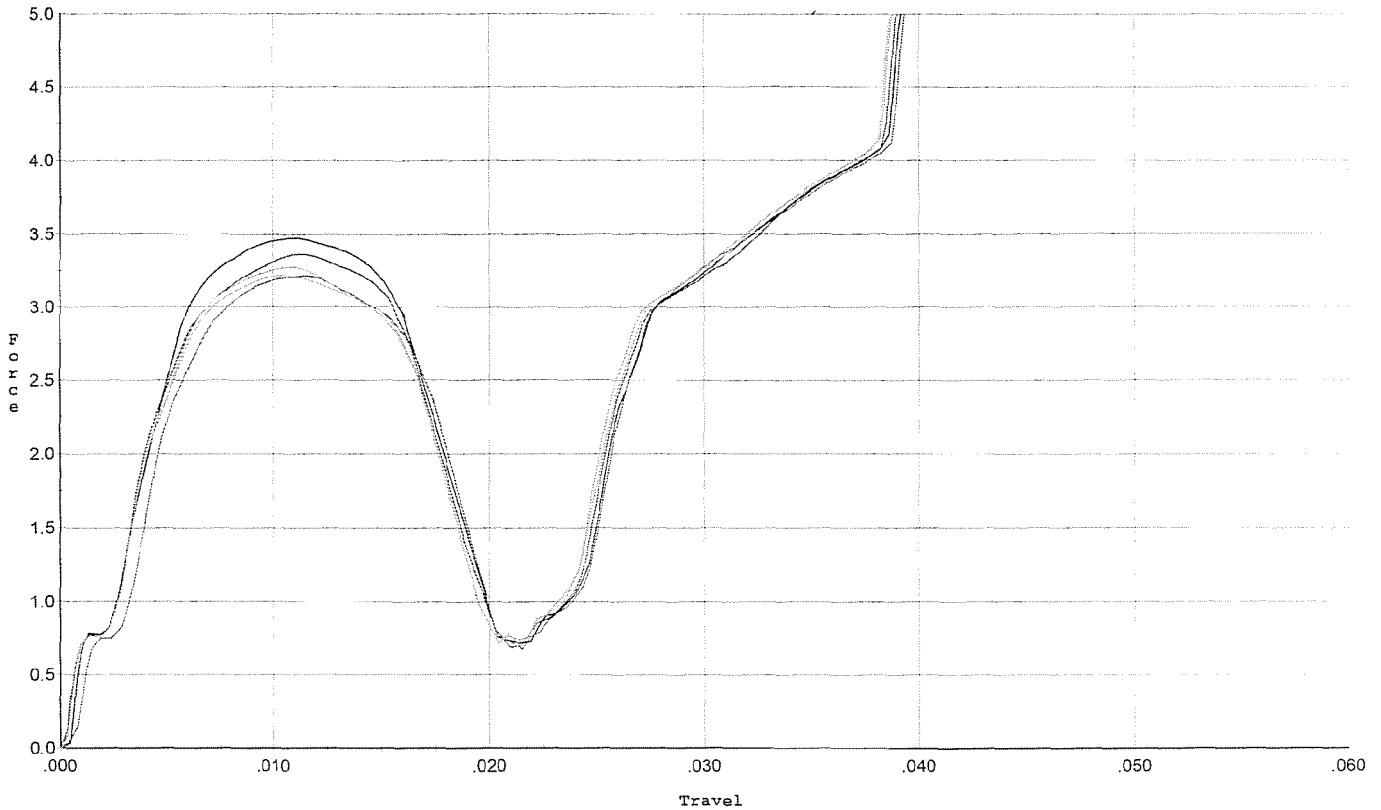
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.194	0.017	0.00	0.025	0.039		Set Trigger
2	3.389	0.018	0.00	0.026	0.041		Set Trigger
3	3.400	0.017	0.00	0.025	0.040		Set Trigger
4	3.270	0.017	0.00	0.025	0.038		Set Trigger
5	3.191	0.016	0.00	0.025	0.036		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



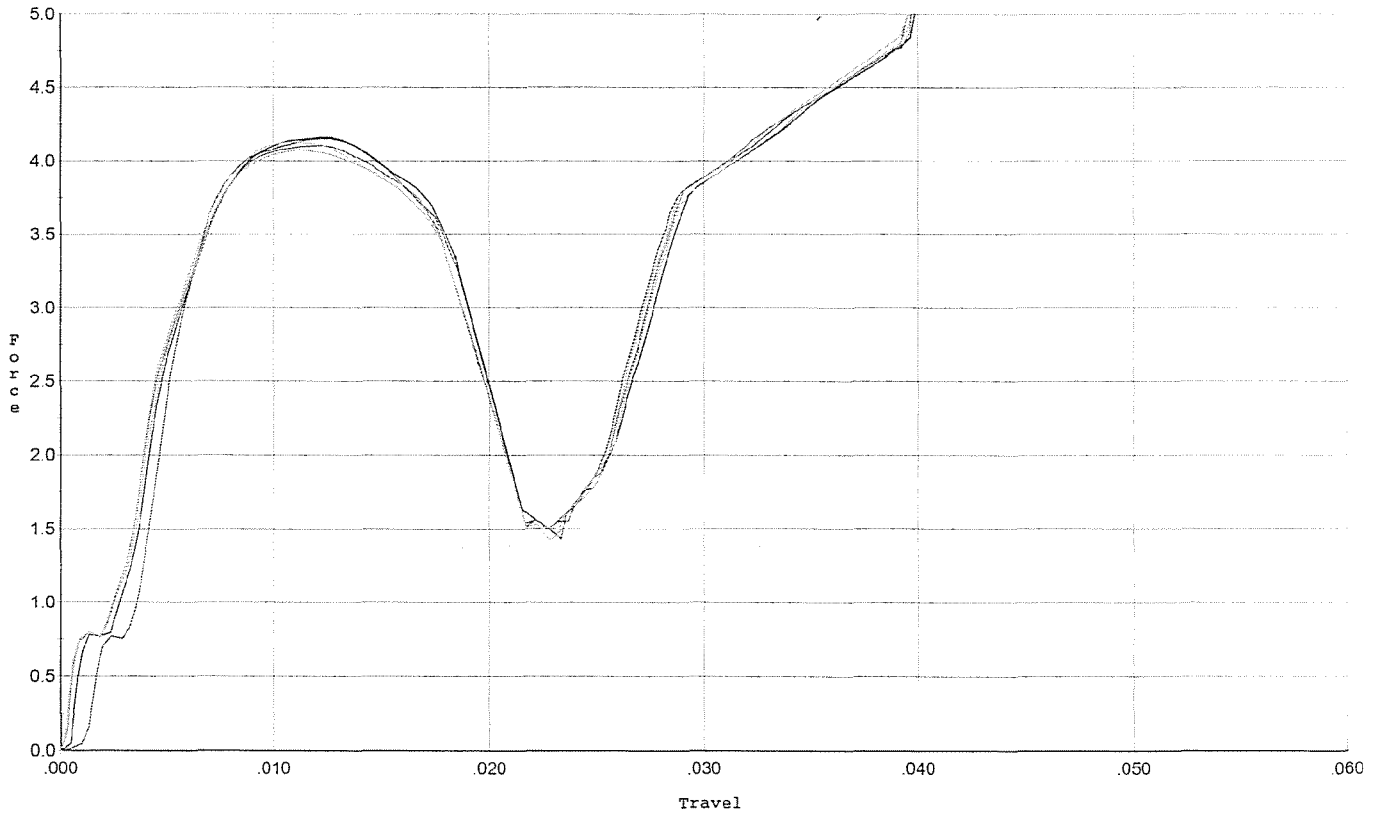
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.363	0.016	0.00	0.025	0.038		Set Trigger
2	3.473	0.016	0.00	0.025	0.038		Set Trigger
3	3.214	0.017	0.00	0.025	0.038		Set Trigger
4	3.213	0.017	0.00	0.025	0.038		Set Trigger
5	3.273	0.017	0.00	0.025	0.038		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



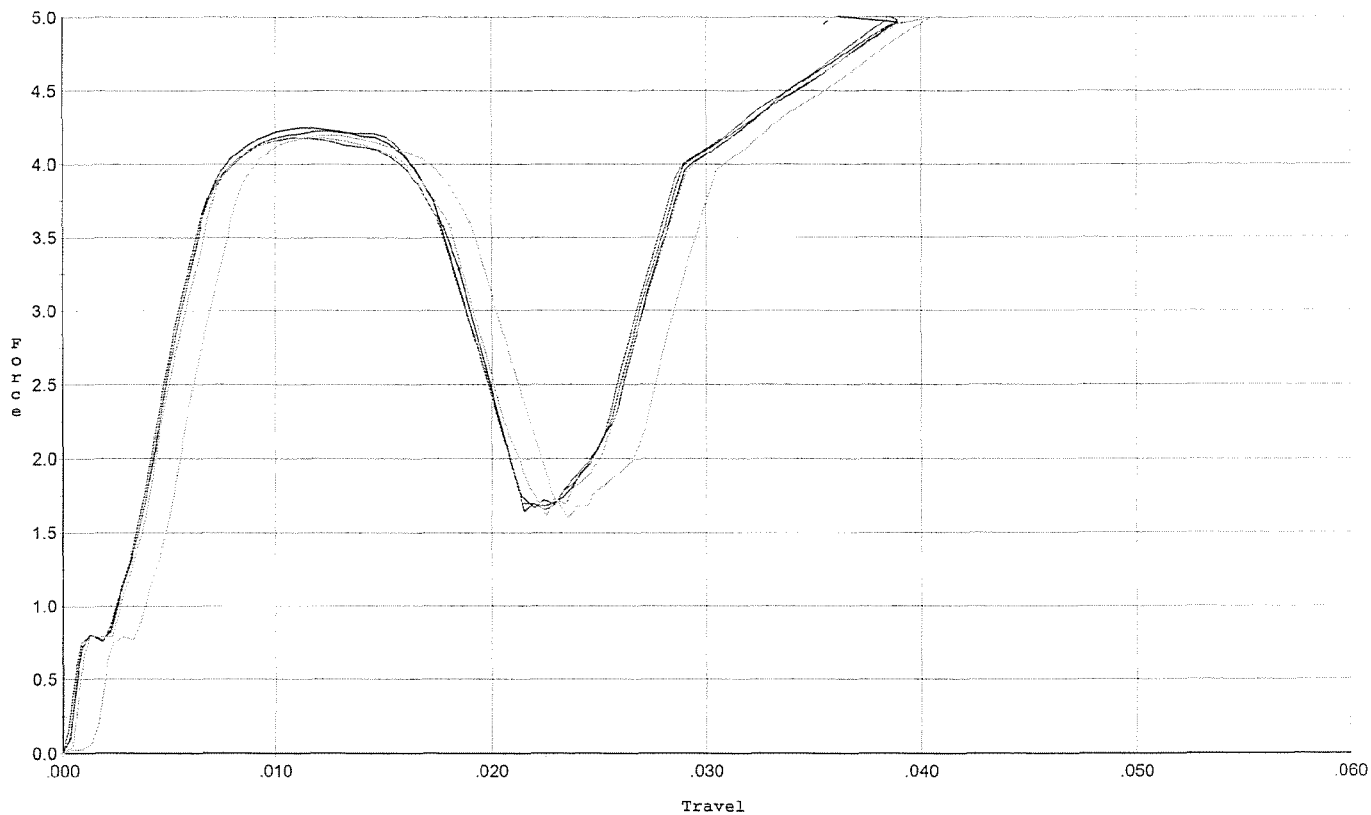
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.150	0.019	0.00	0.024	0.051		Set Trigger
2	4.161	0.018	0.00	0.024	0.052		Set Trigger
3	4.104	0.020	0.00	0.024	0.055		Set Trigger
4	4.127	0.019	0.00	0.024	0.055		Set Trigger
5	4.078	0.019	0.00	0.024	0.054		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



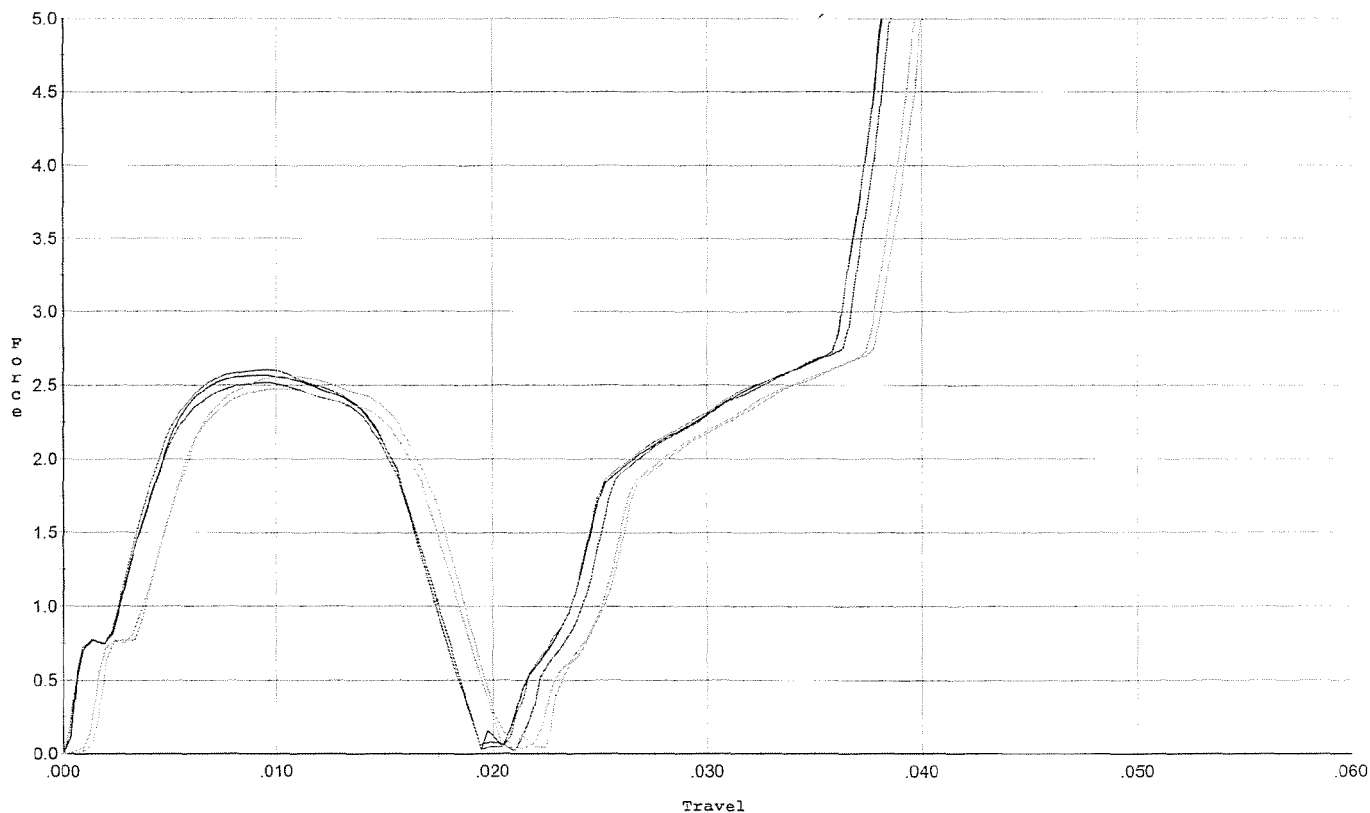
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.226	0.019	0.00	0.023	0.056		Set Trigger
2	4.248	0.019	0.00	0.023	0.054		Set Trigger
3	4.182	0.019	0.00	0.023	0.055		Set Trigger
4	4.199	0.019	0.00	0.024	0.052		Set Trigger
5	4.184	0.018	0.003	0.023	0.052		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



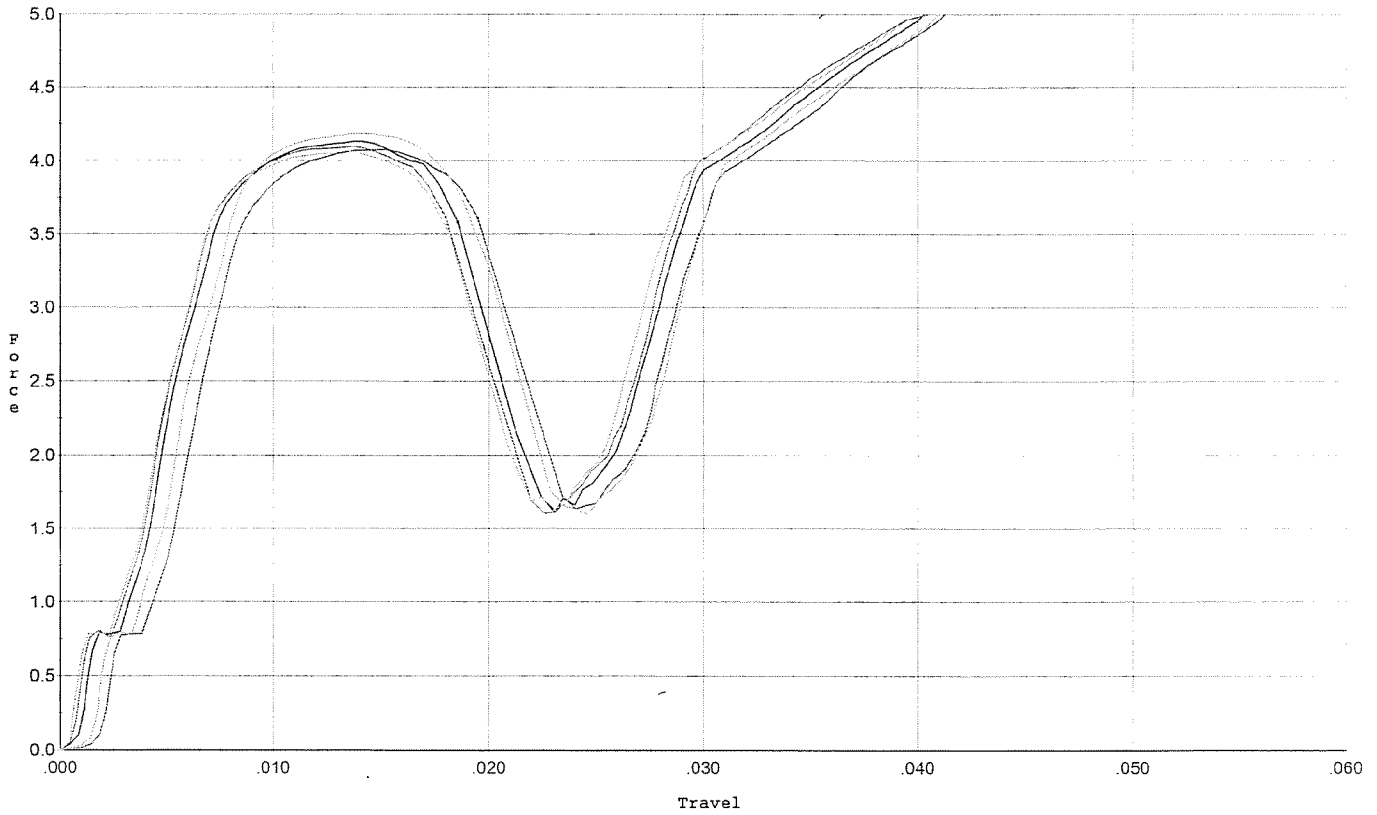
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.016	0.00	0.027	0.029		Set Trigger
2	2.567	0.017	0.00	0.026	0.032		Set Trigger
3	2.604	0.017	0.00	0.026	0.033		Set Trigger
4	2.476	0.017	0.00	0.027	0.029		Set Trigger
5	2.559	0.017	0.00	0.027	0.030		Set Trigger

A-2-54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schulis 3/23/2009

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	4.073	0.020	0.004	0.023	0.051		Set Trigger
2	4.130	0.019	0.00	0.023	0.051		Set Trigger
3	4.096	0.018	0.00	0.023	0.050		Set Trigger
4	4.063	0.018	0.003	0.023	0.051		Set Trigger
5	4.185	0.020	0.00	0.023	0.055		Set Trigger

A-4.10