

G 6814703

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



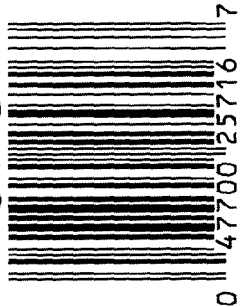
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6814703

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 62147103

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SP
460	CHECK HEADSPACE		3-20-09	SP
470	DIS-ASSEMBLE ACTION		3-20-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-23-09	RJZ
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	3-24-09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-8-09	XJN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

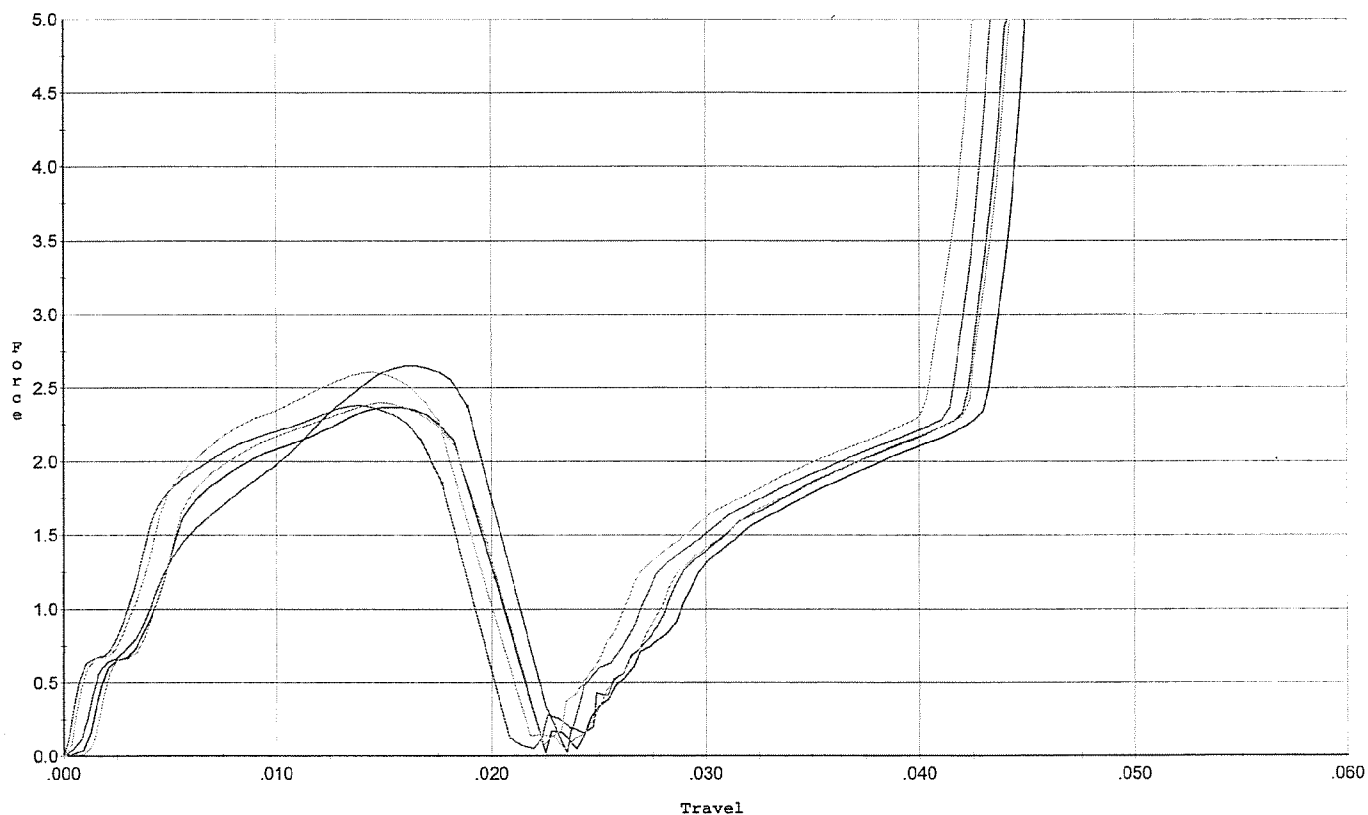
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.8</u> <u>3.0</u> <u>2.8</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.1</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-17-09	RP
	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>FAIL</u> <u>PASS</u> <u>FAIL</u>	4-9-09	WN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.91</u> <u>2.85</u> <u>2.74</u> <u>2.75</u> <u>2.79</u>	4-14-09	WN
	C) FUNCTION		4-17-09	RP
690	PACK		5/27/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



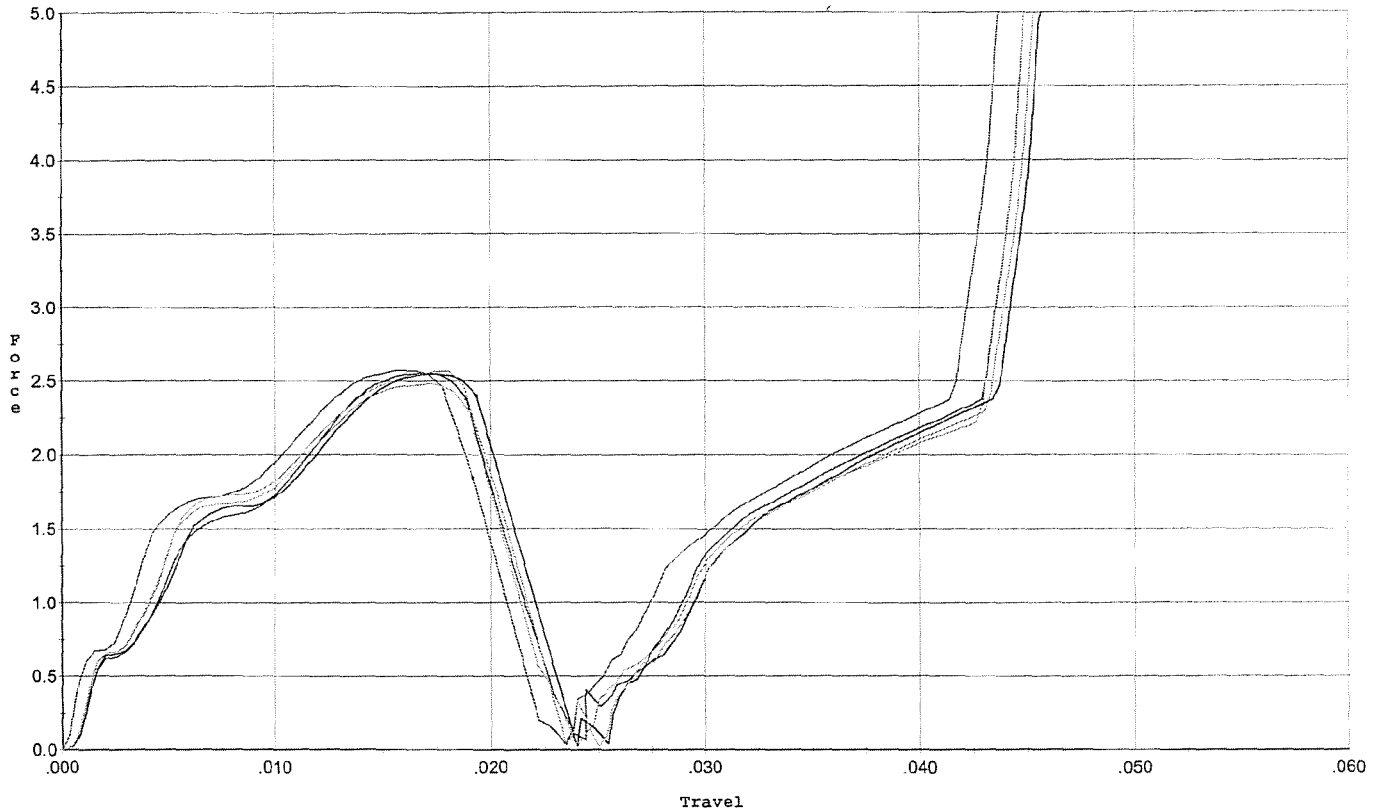
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.652	0.019	0.00	0.029	0.032		Set Trigger
2	2.365	0.020	0.00	0.030	0.032		Set Trigger
3	2.382	0.018	0.00	0.030	0.031		Set Trigger
4	2.607	0.018	0.00	0.029	0.032		Set Trigger
5	2.399	0.020	0.00	0.030	0.032		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



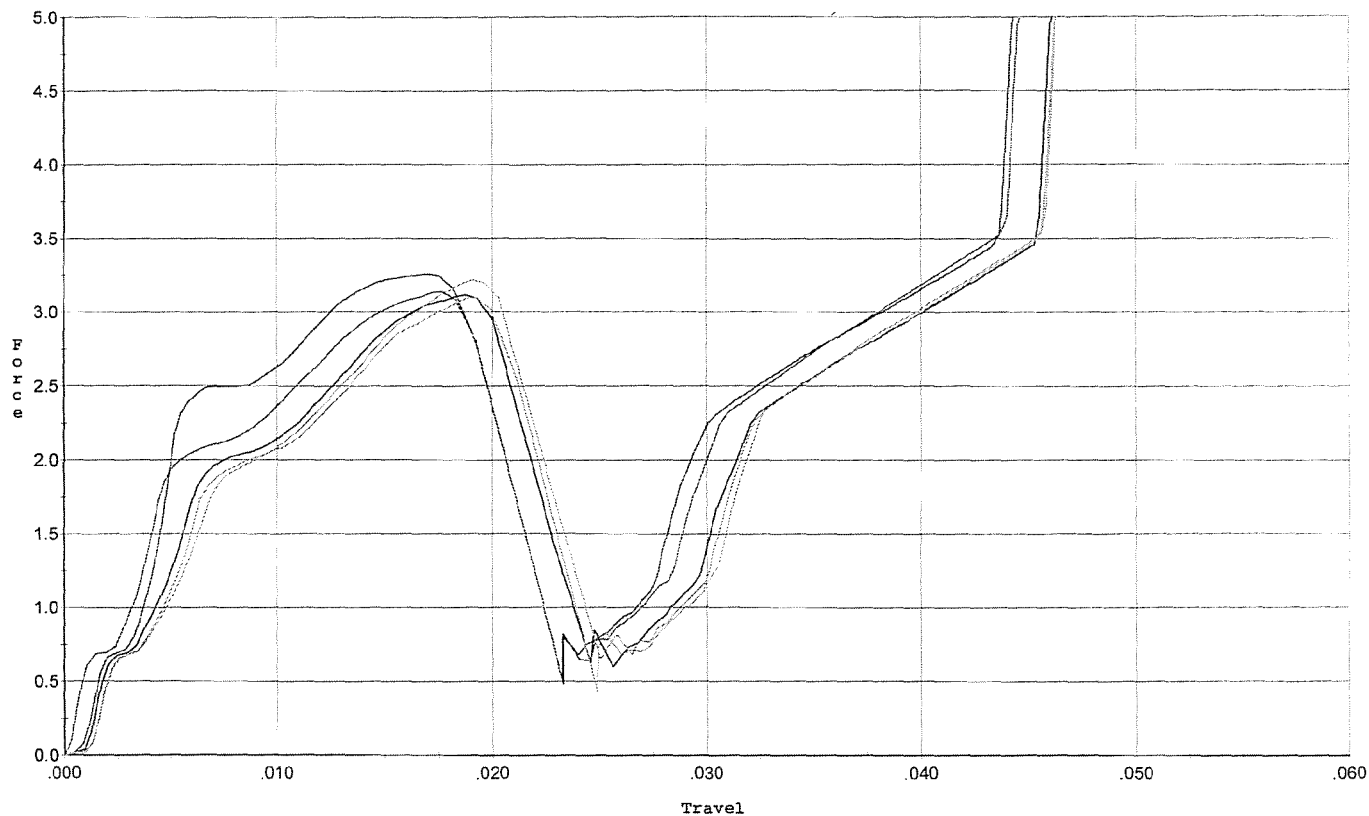
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.019	0.00	0.030	0.030		Set Trigger
2	2.543	0.019	0.00	0.031	0.031		Set Trigger
3	2.566	0.019	0.00	0.029	0.033		Set Trigger
4	2.479	0.019	0.00	0.030	0.031		Set Trigger
5	2.568	0.021	0.00	0.030	0.034		Set Trigger

A-2-54

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



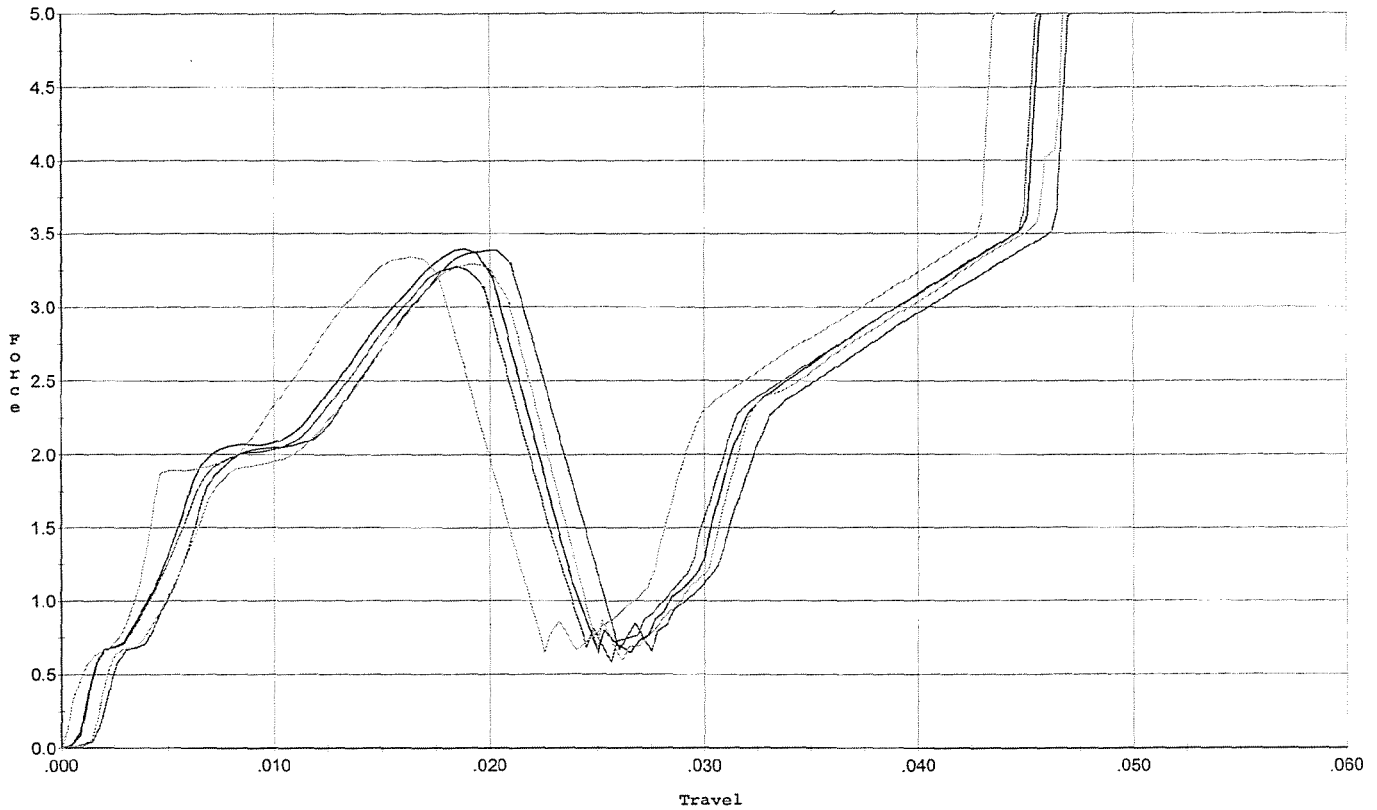
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.019	0.00	0.028	0.042		Set Trigger
2	3.115	0.020	0.00	0.030	0.039		Set Trigger
3	3.135	0.019	0.00	0.029	0.040		Set Trigger
4	3.092	0.021	0.00	0.029	0.040		Set Trigger
5	3.217	0.020	0.00	0.029	0.039		Set Trigger

A-3-16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



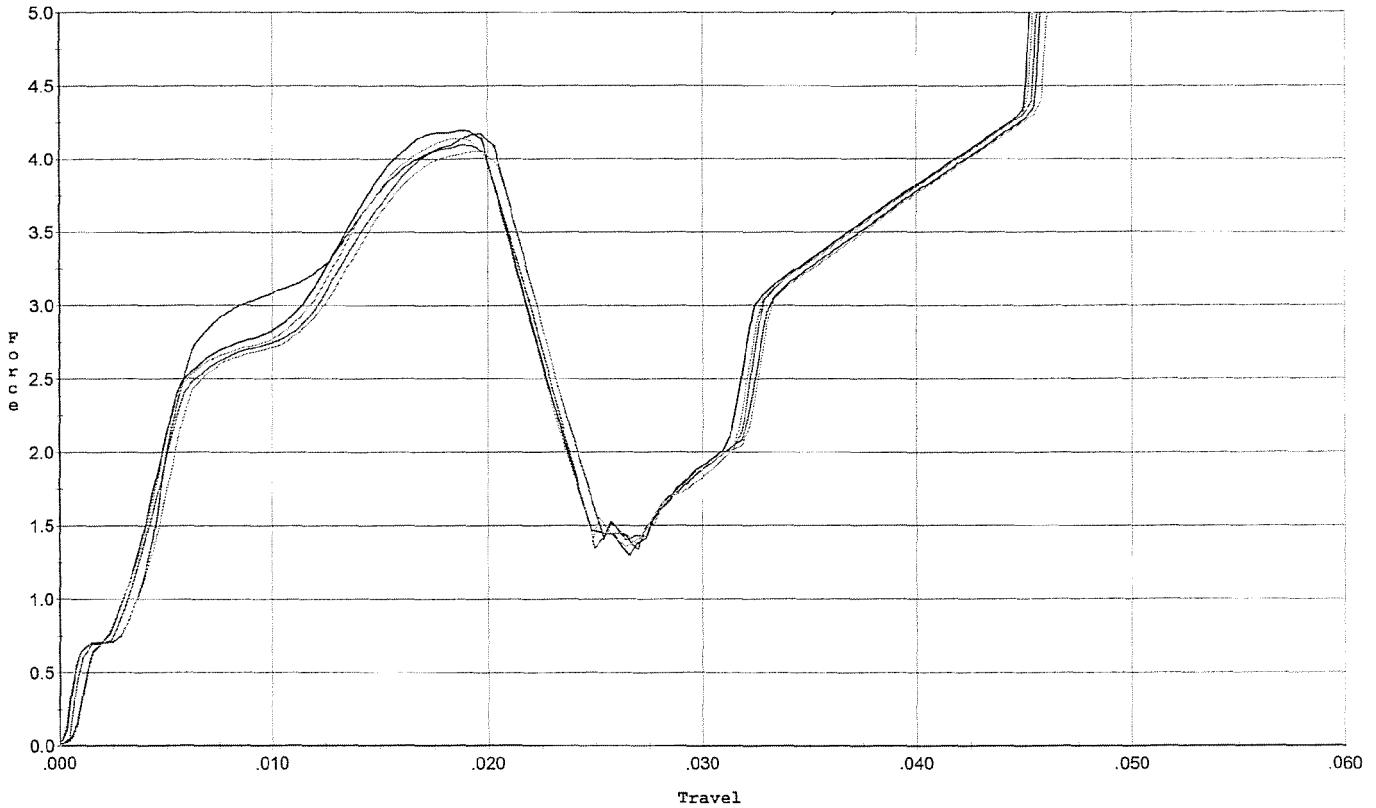
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.383	0.021	0.013	0.029	0.041		Set Trigger
2	3.394	0.020	0.012	0.029	0.040		Set Trigger
3	3.277	0.020	0.00	0.029	0.038		Set Trigger
4	3.293	0.021	0.00	0.029	0.039		Set Trigger
5	3.343	0.020	0.009	0.028	0.041		Set Trigger

A-3-38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



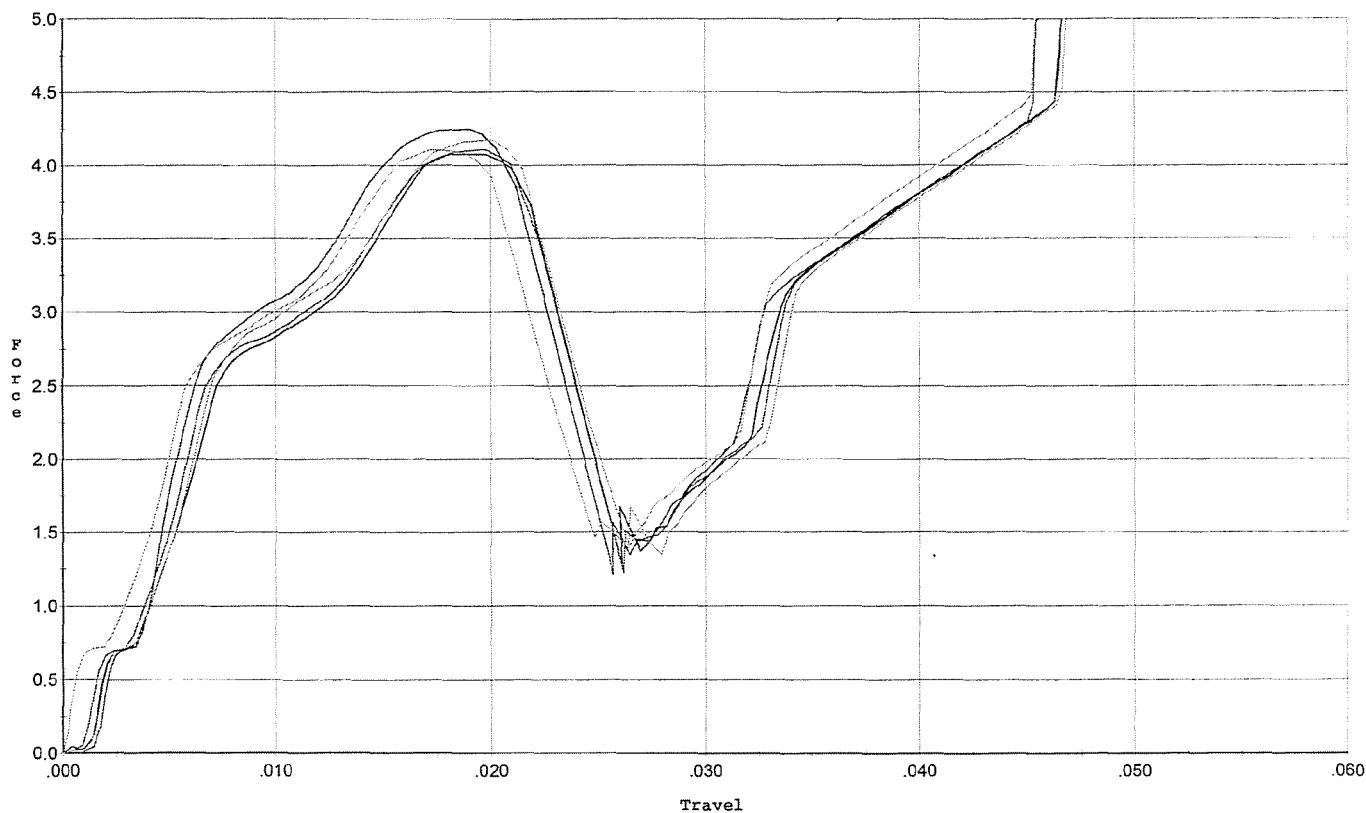
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.174	0.020	0.00	0.027	0.053		Set Trigger
2	4.196	0.020	0.00	0.027	0.052		Set Trigger
3	4.097	0.022	0.00	0.027	0.056		Set Trigger
4	4.140	0.020	0.00	0.027	0.051		Set Trigger
5	4.058	0.020	0.00	0.027	0.051		Set Trigger

A-4-13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



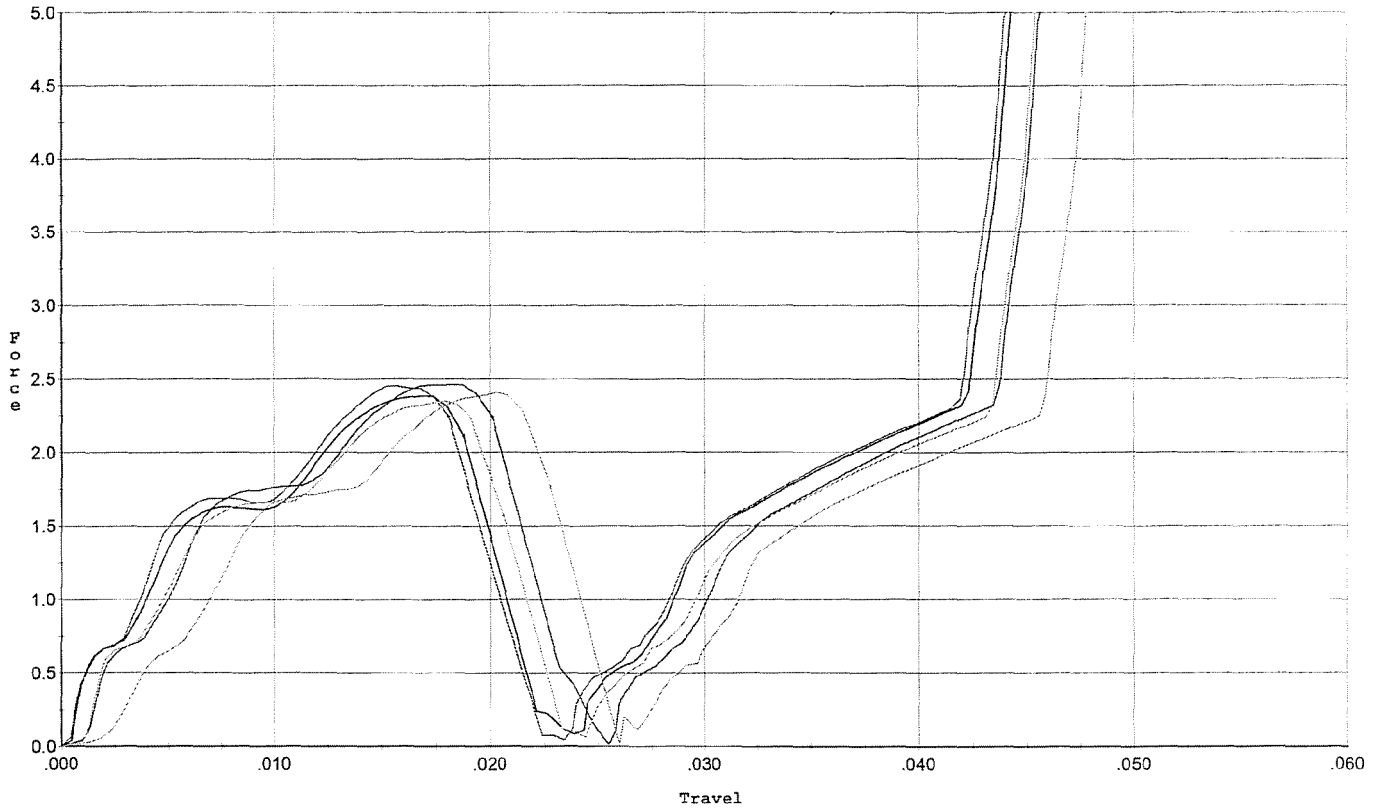
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.247	0.021	0.00	0.026	0.056		Set Trigger
2	4.077	0.022	0.00	0.027	0.055		Set Trigger
3	4.108	0.022	0.00	0.027	0.057		Set Trigger
4	4.108	0.020	0.00	0.027	0.053		Set Trigger
5	4.172	0.021	0.00	0.026	0.055		Set Trigger

A.4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



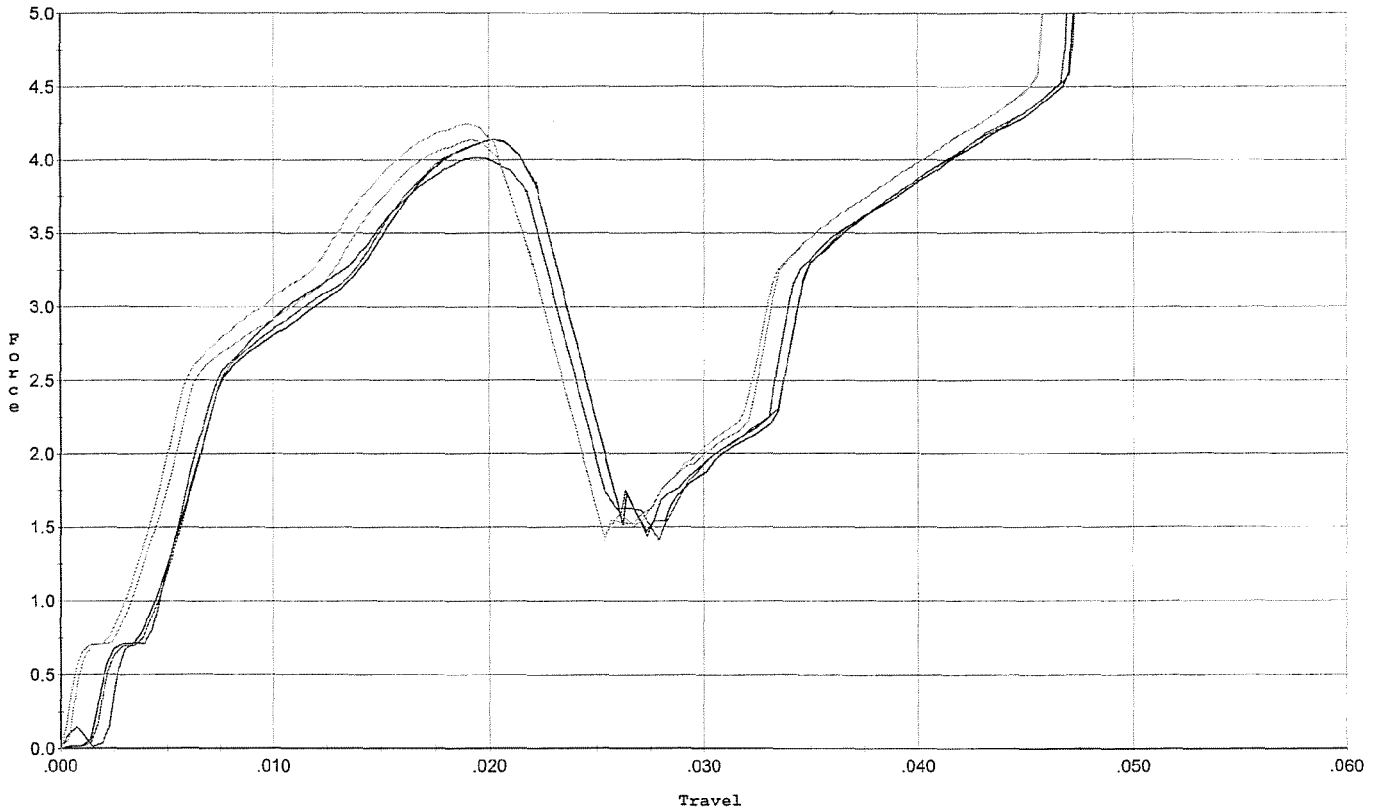
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.462	0.020	0.00	0.030	0.031		Set Trigger
2	2.385	0.019	0.00	0.030	0.029		Set Trigger
3	2.452	0.018	0.00	0.030	0.029		Set Trigger
4	2.352	0.021	0.00	0.030	0.031		Set Trigger
5	2.411	0.023	0.00	0.031	0.032		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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	4.015	0.022	0.00	0.026	0.054		Set Trigger
2	4.142	0.022	0.00	0.026	0.055		Set Trigger
3	4.139	0.022	0.00	0.027	0.055		Set Trigger
4	4.249	0.022	0.00	0.026	0.059		Set Trigger
5	4.139	0.022	0.00	0.026	0.057		Set Trigger

A-4.13