

66784986

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



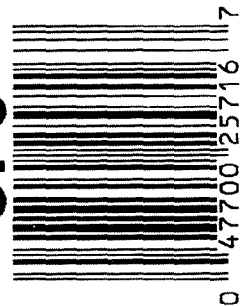
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6784986

UPC



GUN SERIAL #

66784986

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-18-08	SP
430	ASSEMBLE TO STOCK		9-18-08	SP
440	PROOF		9-18-08	SP
460	CHECK HEADSPACE		9-18-08	SP
470	DIS-ASSEMBLE ACTION		9-18-08	SP
472	SERIALIZE BOLT HANDLE		10-7-08	RT
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX UCI 08 2008 OPERATOR KA	10-7-08	SP
480	MAGNAFLUX BBL ACTION		10/8/08	RT
490	MAGNAFLUX BOLT		10/8/08	RT
500	ROLLMARK CALIBER		10/8/08	RT
520	GOFF BLAST BBL / REC		10/9/08	DS
542	APPLY COATINGS (BARREL ACTION)		10/13	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/13/08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/13/08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/13/08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

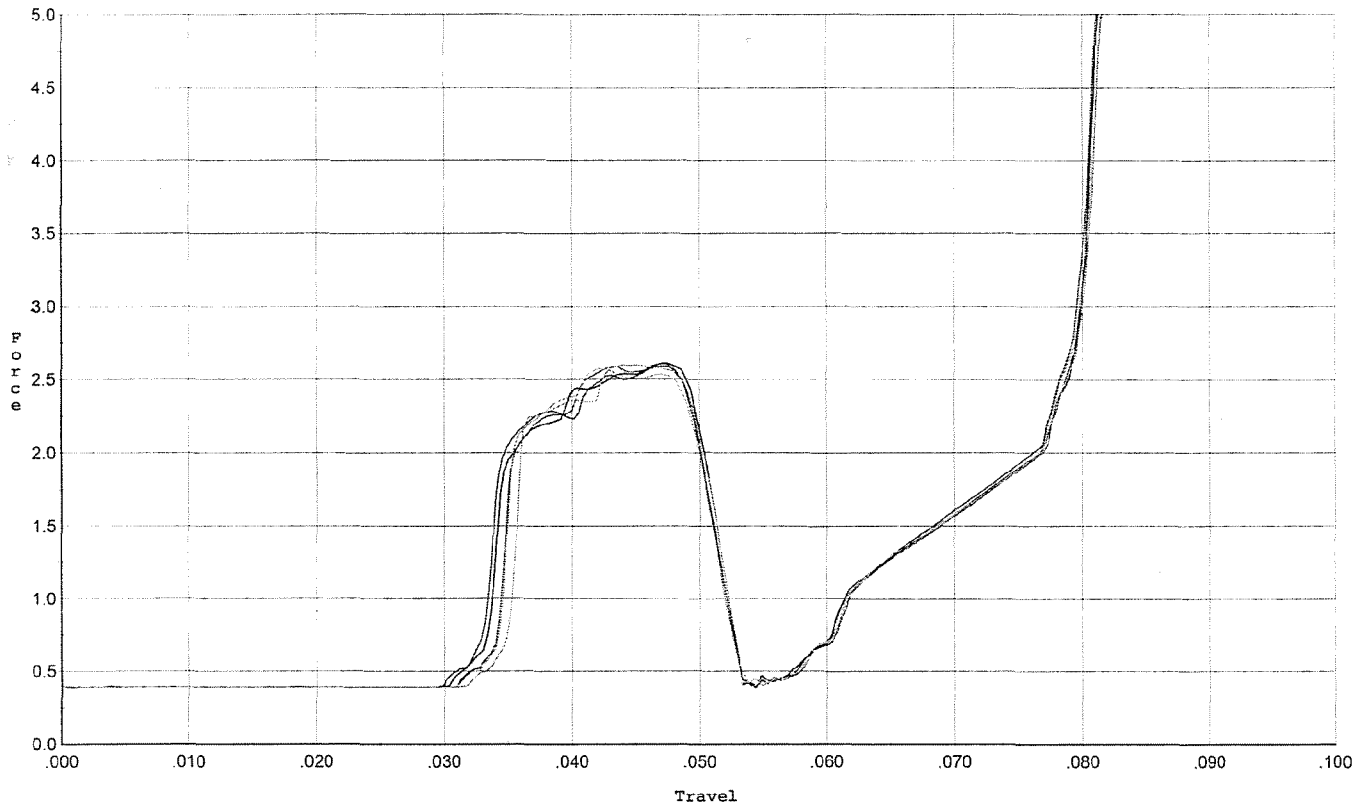
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>3.5</u> <u>35</u>	11-18-08	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	11-18-08	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-18-08	LN
	J) ASSEMBLE STOCK		11-22-08	TC
	K) ASSEMBLE SWIVEL STUDS		11-18-08	LN
	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	11-13-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-13-08	LN
670	FINAL INSPECTION A) HEADSPACE		11-15-08	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.54</u> <u>2.60</u> <u>2.60</u> <u>2.56</u>	11-14-08	TC
	C) FUNCTION		11-18-08	LN
690	PACK		12-2-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



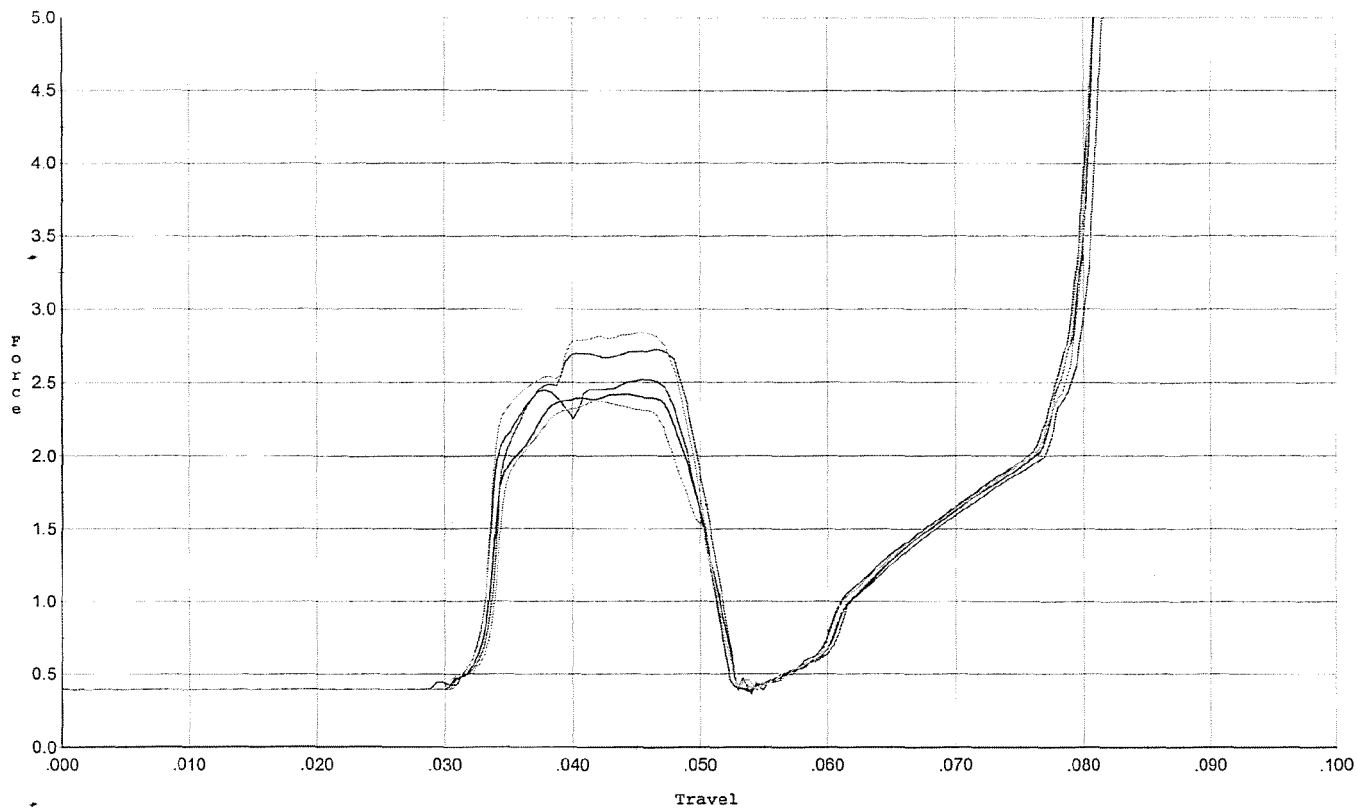
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.590	0.050	0.030	0.035	0.052		Set Trigger
2	2.607	0.051	0.031	0.035	0.053		Set Trigger
3	2.603	0.050	0.034	0.035	0.051		Set Trigger
4	2.576	0.050	0.034	0.035	0.051		Set Trigger
5	2.600	0.051	0.034	0.036	0.051		Set Trigger

A2-59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



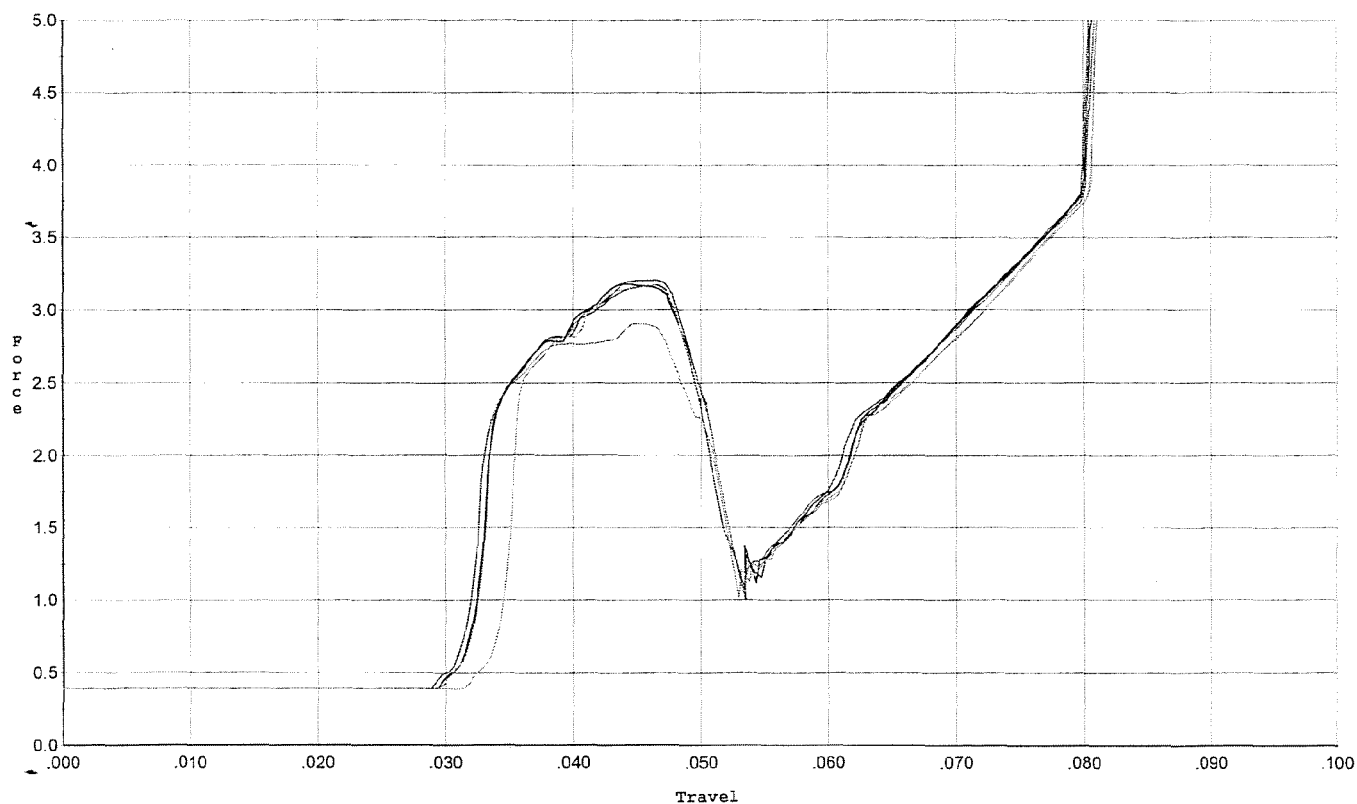
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.519	0.050	0.032	0.035	0.052		Set Trigger
2	2.420	0.051	0.033	0.035	0.052		Set Trigger
3	2.723	0.050	0.033	0.035	0.055		Set Trigger
4	2.838	0.049	0.032	0.035	0.056		Set Trigger
5	2.374	0.050	0.031	0.036	0.048		Set Trigger

A-257

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



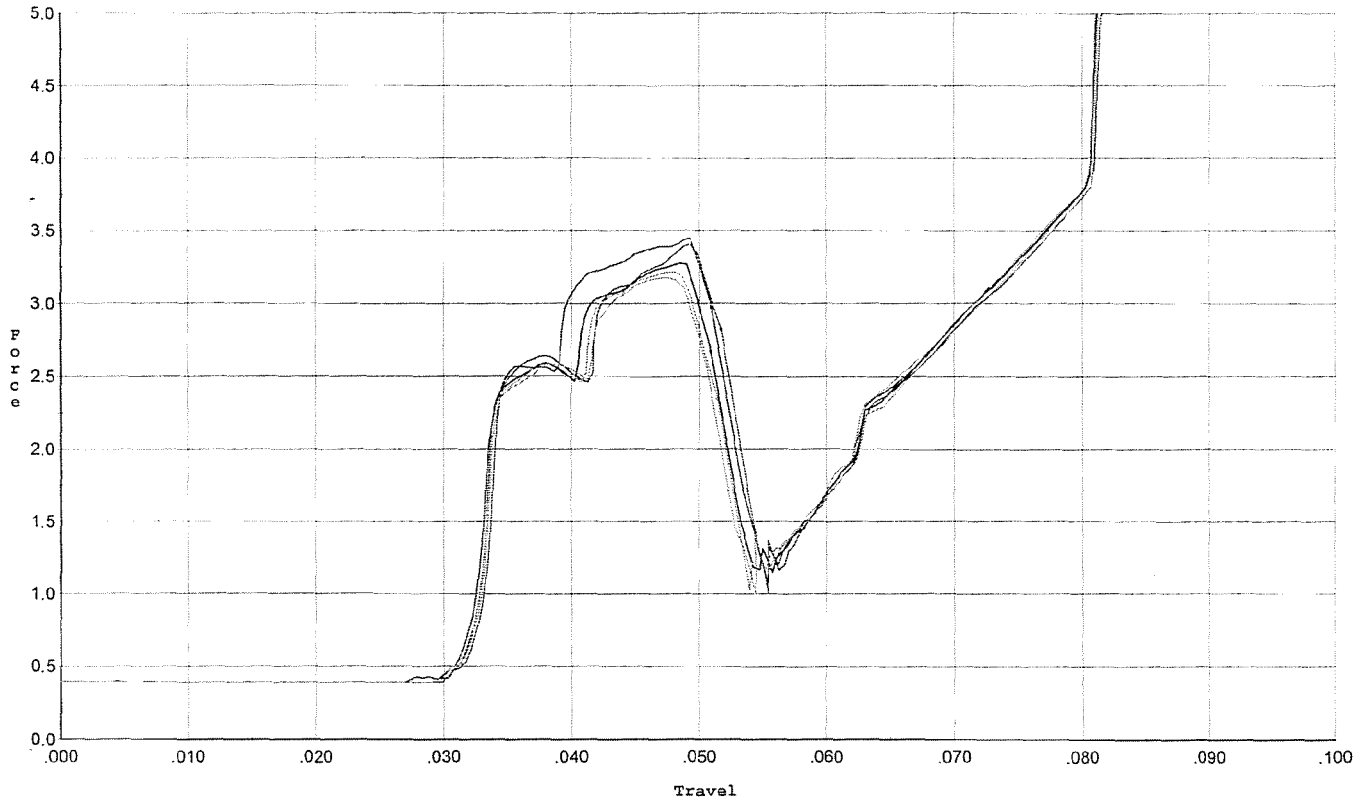
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.203	0.050	0.030	0.033	0.064		Set Trigger
2	3.179	0.050	0.032	0.033	0.064		Set Trigger
3	3.173	0.050	0.031	0.034	0.063		Set Trigger
4	3.169	0.050	0.032	0.035	0.059		Set Trigger
5	2.908	0.051	0.030	0.034	0.061		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



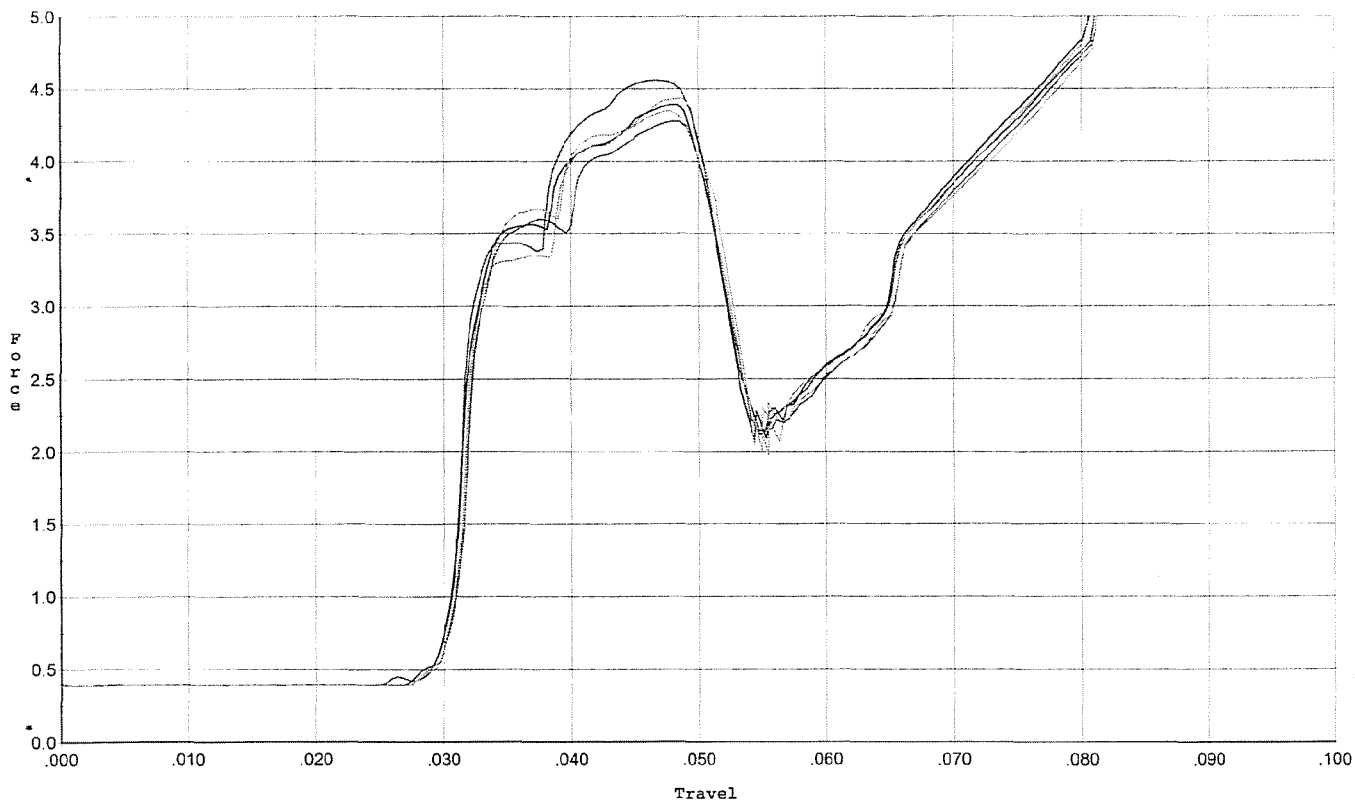
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.447	0.051	0.031	0.033	0.069		Set Trigger
2	3.276	0.051	0.032	0.033	0.065		Set Trigger
3	3.407	0.052	0.032	0.034	0.067		Set Trigger
4	3.176	0.051	0.032	0.034	0.062		Set Trigger
5	3.217	0.051	0.032	0.033	0.065		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



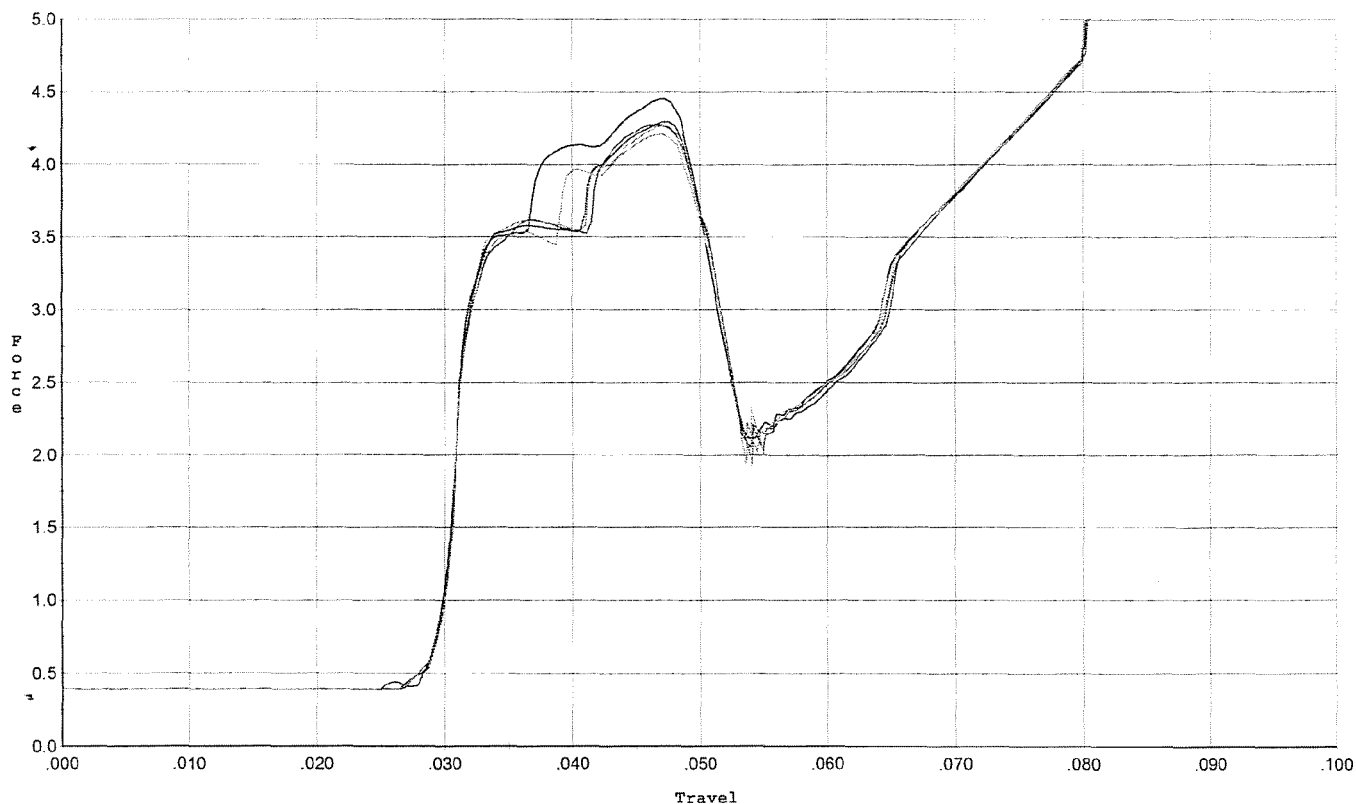
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.560	0.051	0.029	0.031	0.092		Set Trigger
2	4.393	0.051	0.030	0.031	0.090		Set Trigger
3	4.277	0.051	0.030	0.032	0.088		Set Trigger
4	4.436	0.051	0.030	0.032	0.091		Set Trigger
5	4.351	0.052	0.030	0.031	0.091		Set Trigger

A-4.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



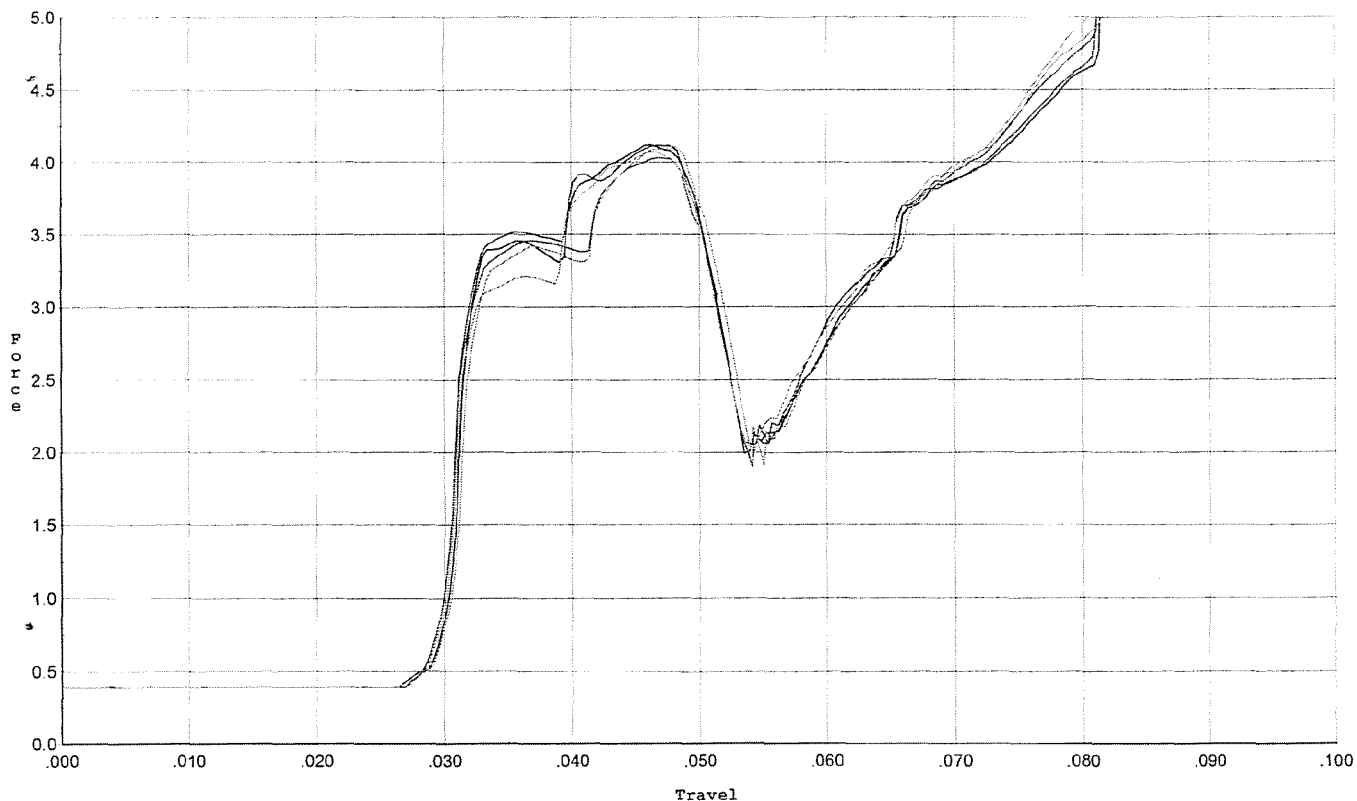
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.294	0.051	0.028	0.031	0.088		Set Trigger
2	4.455	0.050	0.029	0.031	0.089		Set Trigger
3	4.274	0.051	0.029	0.031	0.089		Set Trigger
4	4.210	0.051	0.029	0.031	0.089		Set Trigger
5	4.269	0.051	0.029	0.031	0.088		Set Trigger

A-430

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



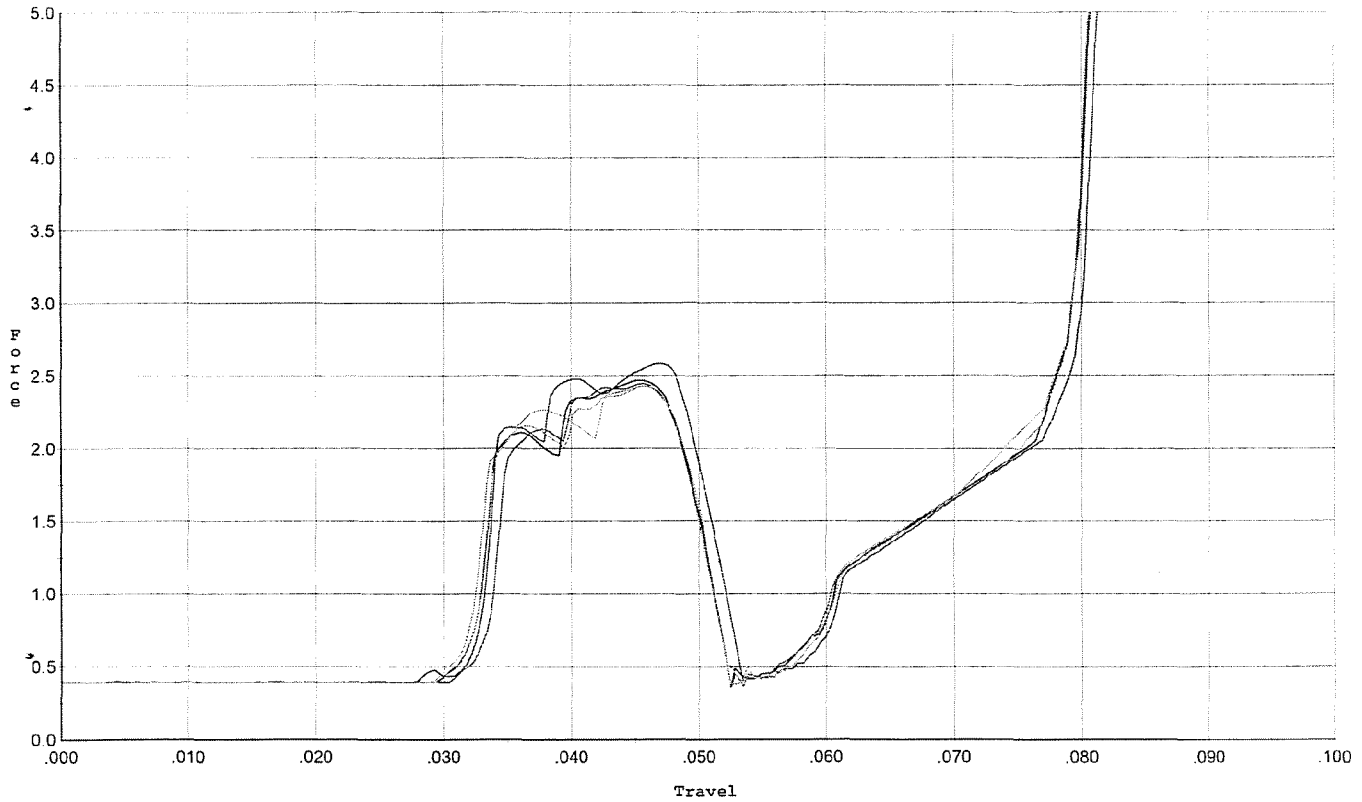
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.119	0.051	0.029	0.031	0.089		Set Trigger
2	4.123	0.051	0.029	0.031	0.087		Set Trigger
3	4.031	0.052	0.029	0.031	0.087		Set Trigger
4	4.076	0.050	0.029	0.032	0.083		Set Trigger
5	4.110	0.052	0.030	0.032	0.087		Set Trigger

A. 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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	2.586	0.052	0.032	0.034	0.055		Set Trigger
2	2.468	0.050	0.032	0.035	0.051		Set Trigger
3	2.446	0.050	0.033	0.035	0.049		Set Trigger
4	2.432	0.050	0.032	0.035	0.051		Set Trigger
5	2.429	0.051	0.032	0.035	0.051		Set Trigger

A-2.46