

66794554

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

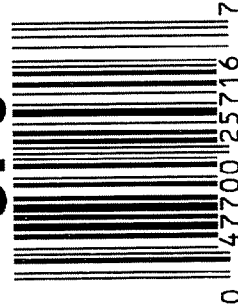
24"

CAPACITY

6

G6794554

UPC



GUN SERIAL #

G 6794554

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SP
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SP
460	CHECK HEADSPACE		9-30-08	SP
470	DIS-ASSEMBLE ACTION		9-30-08	SP
472	SERIALIZE BOLT HANDLE		10-1-08	ESN
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	(K9)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10 8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-29-08	ESN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

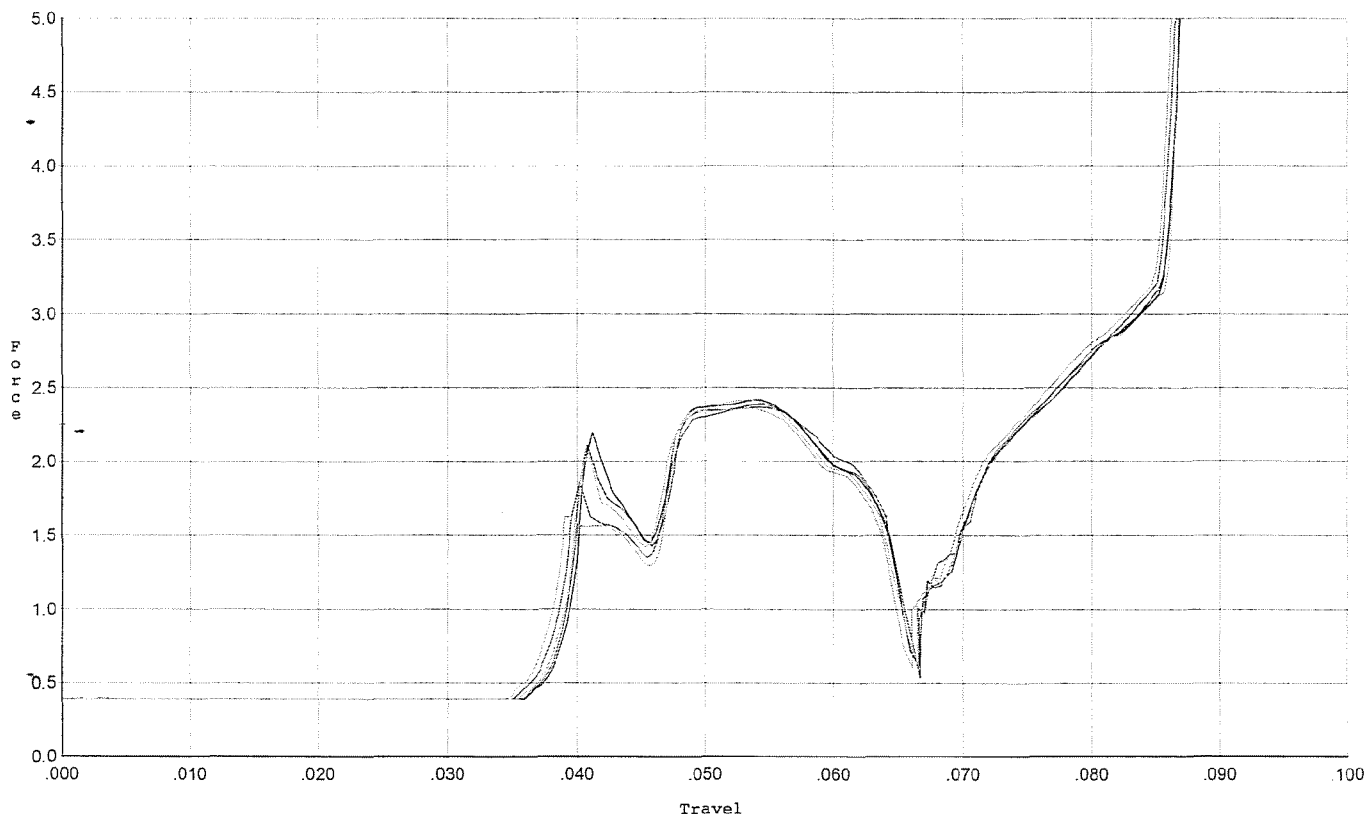
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>4.0</u>	11-7-08	PSW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>4.0</u> <u>3.0</u>	11-7-08	PSW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	11-7-08	PSW
	J) ASSEMBLE STOCK		10-29-08	PSW
	K) ASSEMBLE SWIVEL STUDS		11-7-08	PSW
	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	10-30-08	PSW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-7-08	PSW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.25</u> <u>2.23</u> <u>2.30</u> <u>2.27</u>	11-5-08	Fm
	C) FUNCTION		11-7-08	PSW
690	PACK		11/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



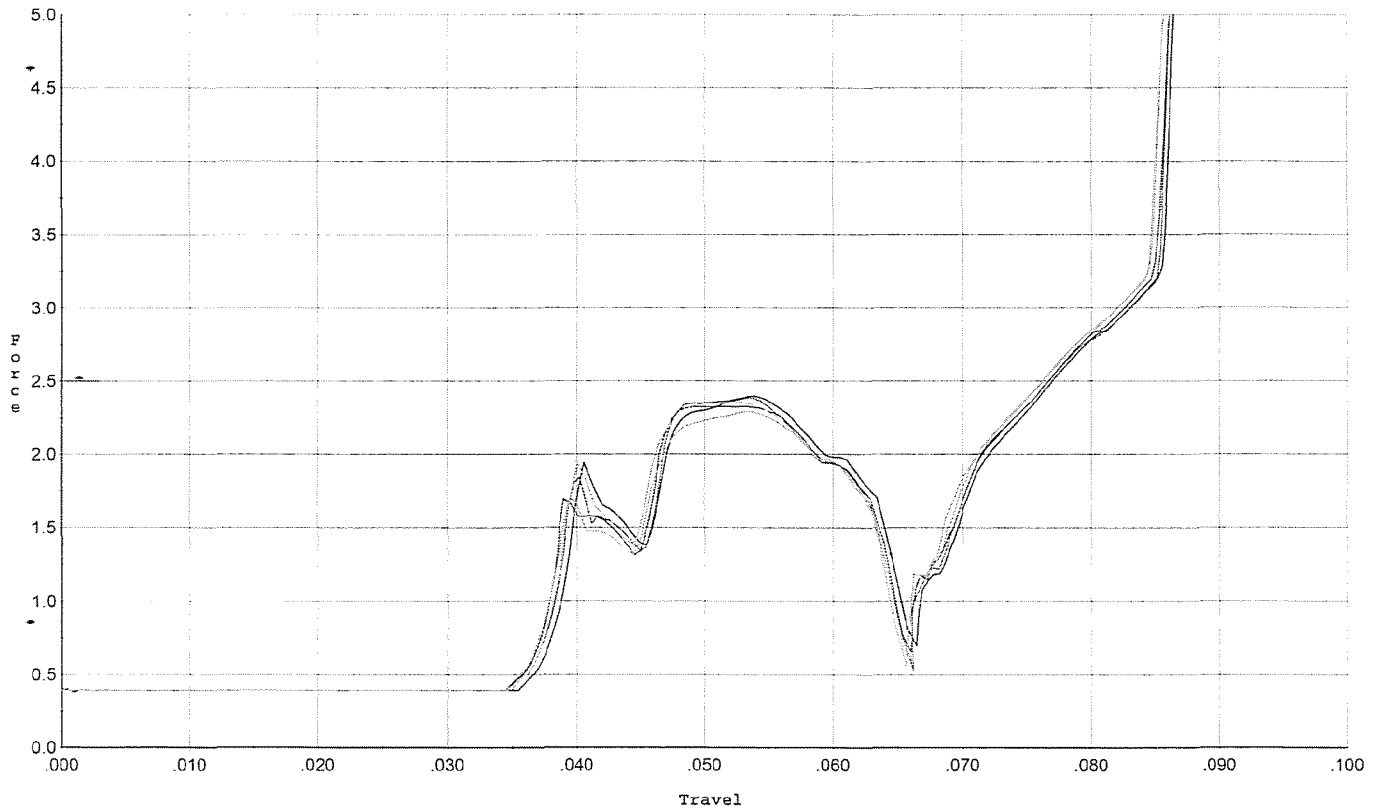
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.389	0.064	0.038	0.029	0.066		Set Trigger
2	2.418	0.064	0.038	0.029	0.066		Set Trigger
3	2.369	0.064	0.037	0.029	0.066		Set Trigger
4	2.415	0.063	0.038	0.030	0.065		Set Trigger
5	2.360	0.064	0.037	0.029	0.064		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



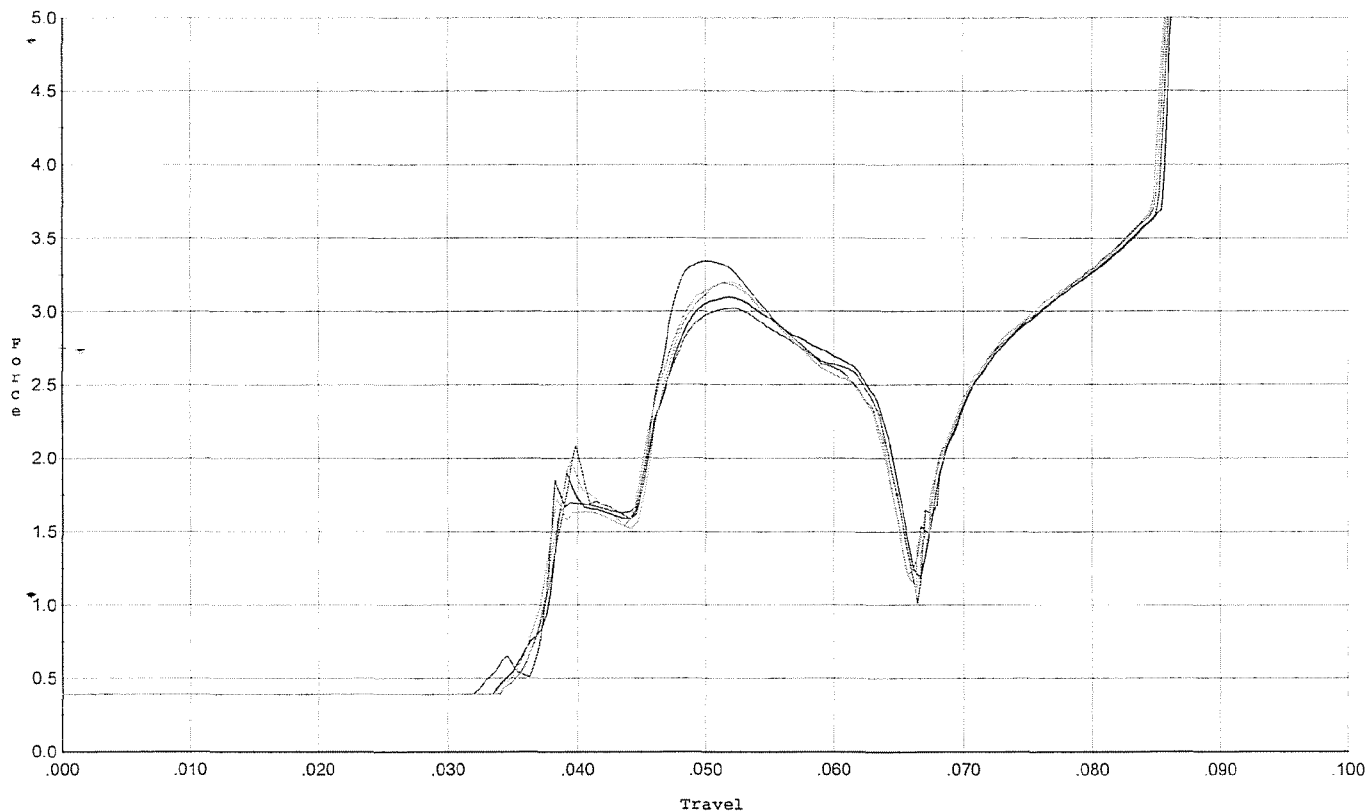
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.326	0.063	0.037	0.030	0.064		Set Trigger
2	2.396	0.064	0.037	0.029	0.066		Set Trigger
3	2.383	0.064	0.037	0.029	0.065		Set Trigger
4	2.353	0.063	0.037	0.029	0.065		Set Trigger
5	2.291	0.064	0.037	0.029	0.064		Set Trigger

A-2.35

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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

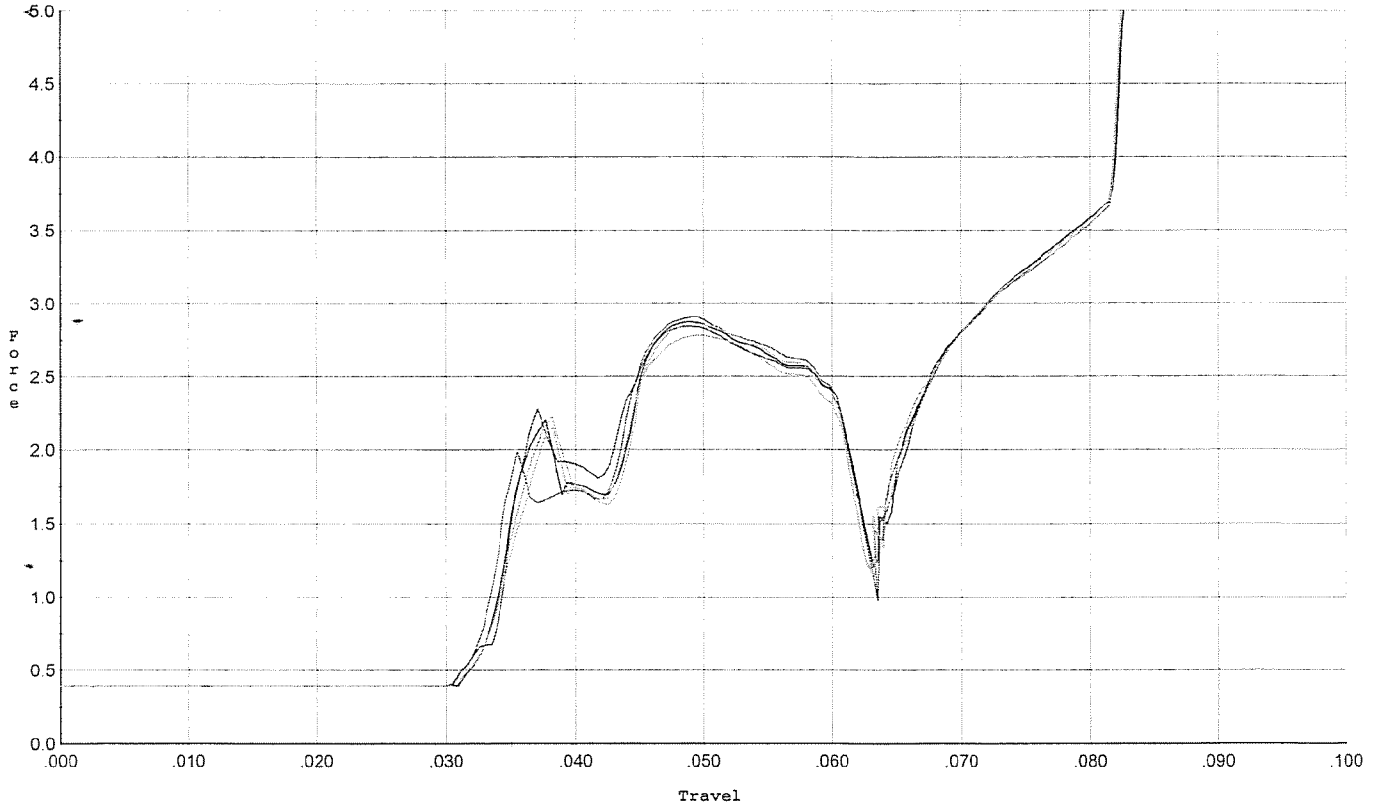


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.345	0.065	0.034	0.028	0.083		Set Trigger
2	3.097	0.064	0.036	0.028	0.081		Set Trigger
3	3.020	0.064	0.036	0.028	0.079		Set Trigger
4	3.199	0.064	0.036	0.028	0.079		Set Trigger
5	3.188	0.064	0.036	0.028	0.080		Set Trigger

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



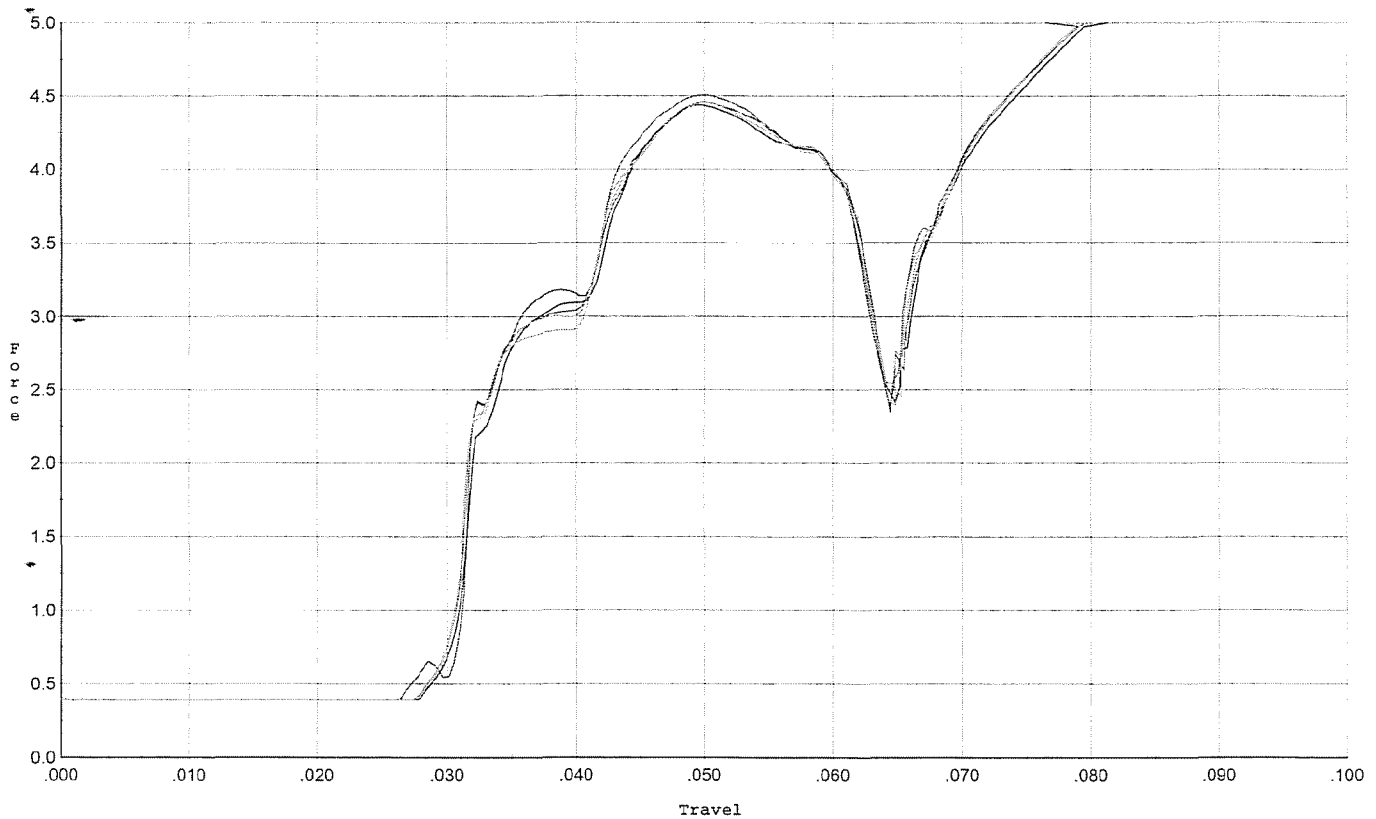
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.845	0.062	0.031	0.027	0.079		Set Trigger
2	2.873	0.062	0.031	0.027	0.078		Set Trigger
3	2.907	0.062	0.031	0.027	0.079		Set Trigger
4	2.862	0.061	0.031	0.027	0.075		Set Trigger
5	2.784	0.061	0.031	0.028	0.075		Set Trigger

A-2.85

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



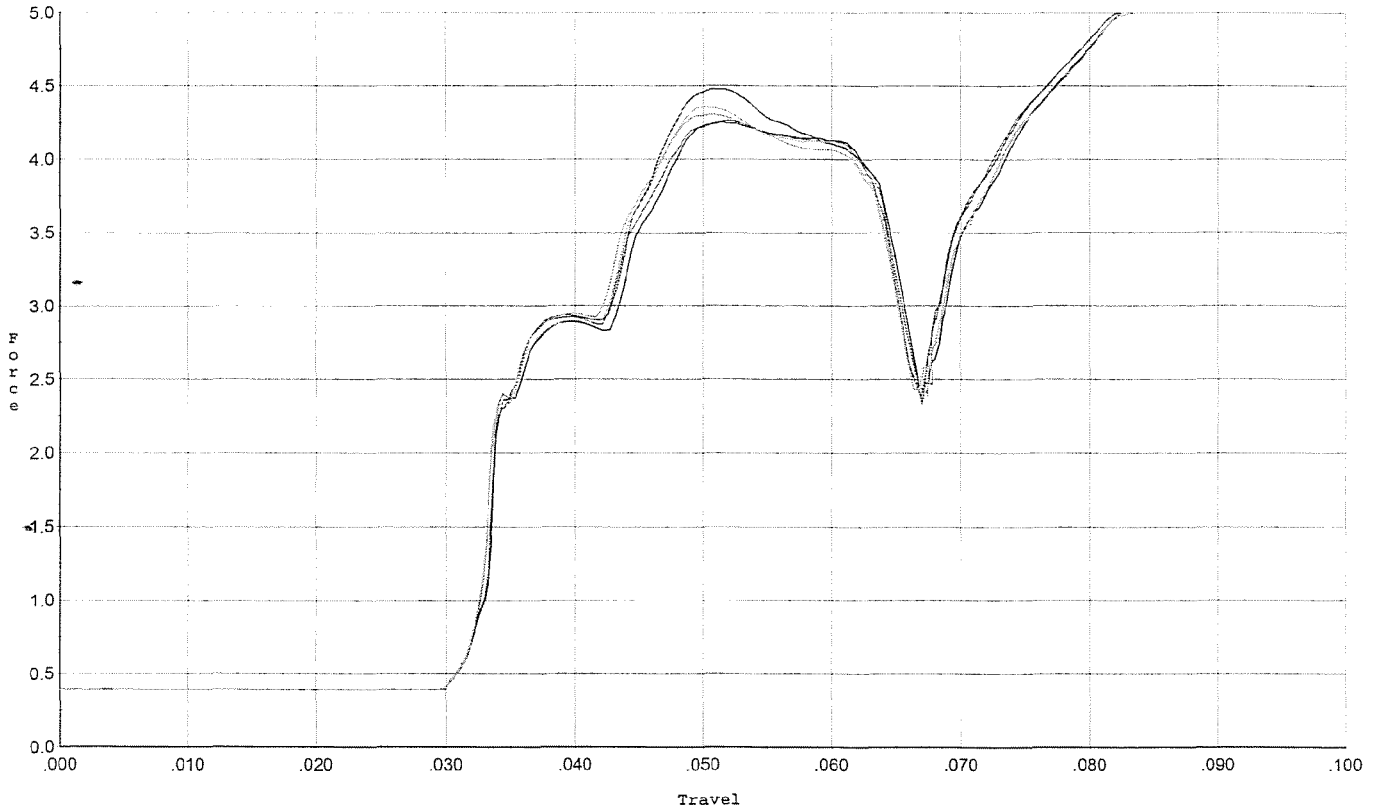
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.436	0.061	0.027	0.024	0.125		Set Trigger
2	4.455	0.062	0.028	0.024	0.126		Set Trigger
3	4.506	0.063	0.028	0.024	0.129		Set Trigger
4	4.453	0.062	0.028	0.024	0.127		Set Trigger
5	4.450	0.062	0.028	0.024	0.127		Set Trigger

A-4.46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



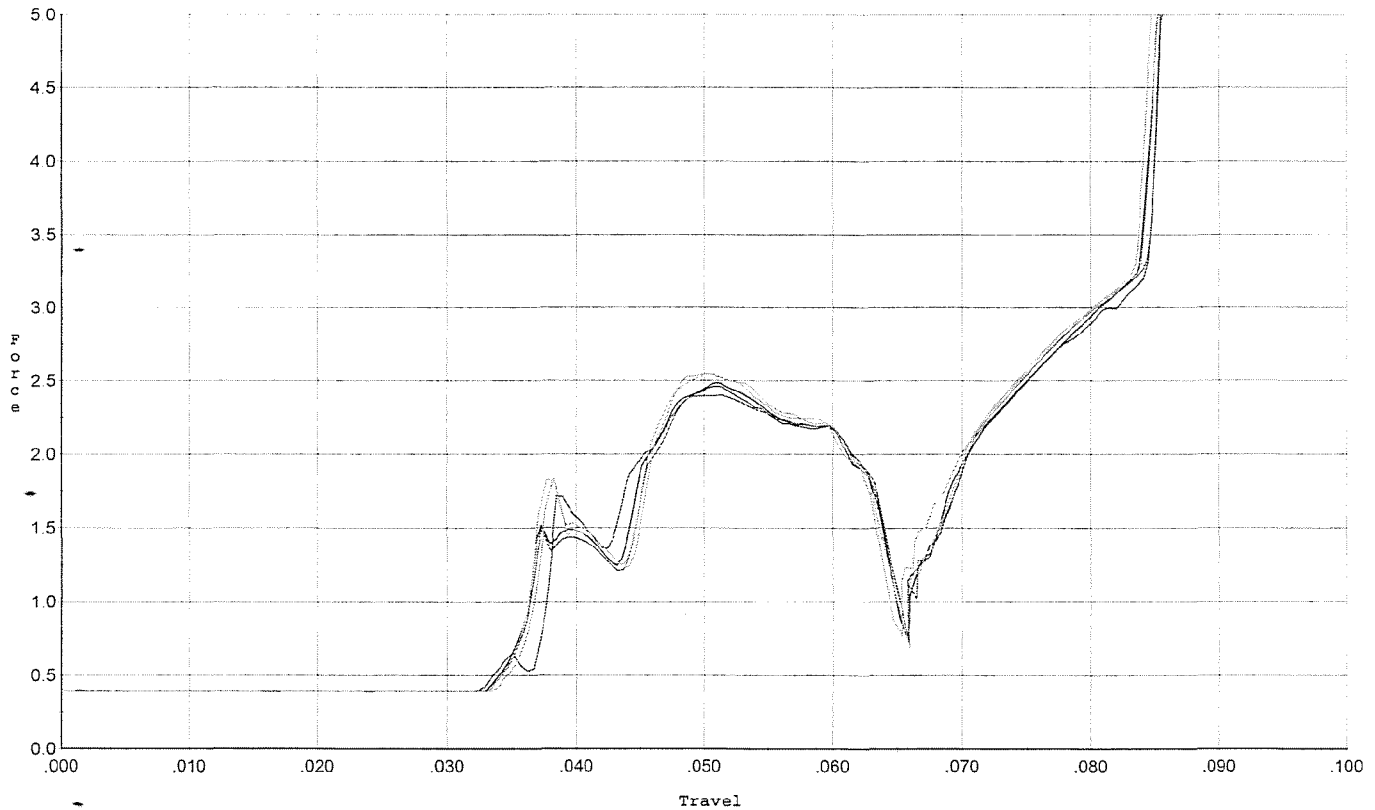
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.478	0.064	0.030	0.025	0.127		Set Trigger
2	4.263	0.065	0.032	0.025	0.126		Set Trigger
3	4.249	0.064	0.032	0.025	0.125		Set Trigger
4	4.353	0.064	0.032	0.025	0.126		Set Trigger
5	4.301	0.064	0.030	0.025	0.127		Set Trigger

A 4.32

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



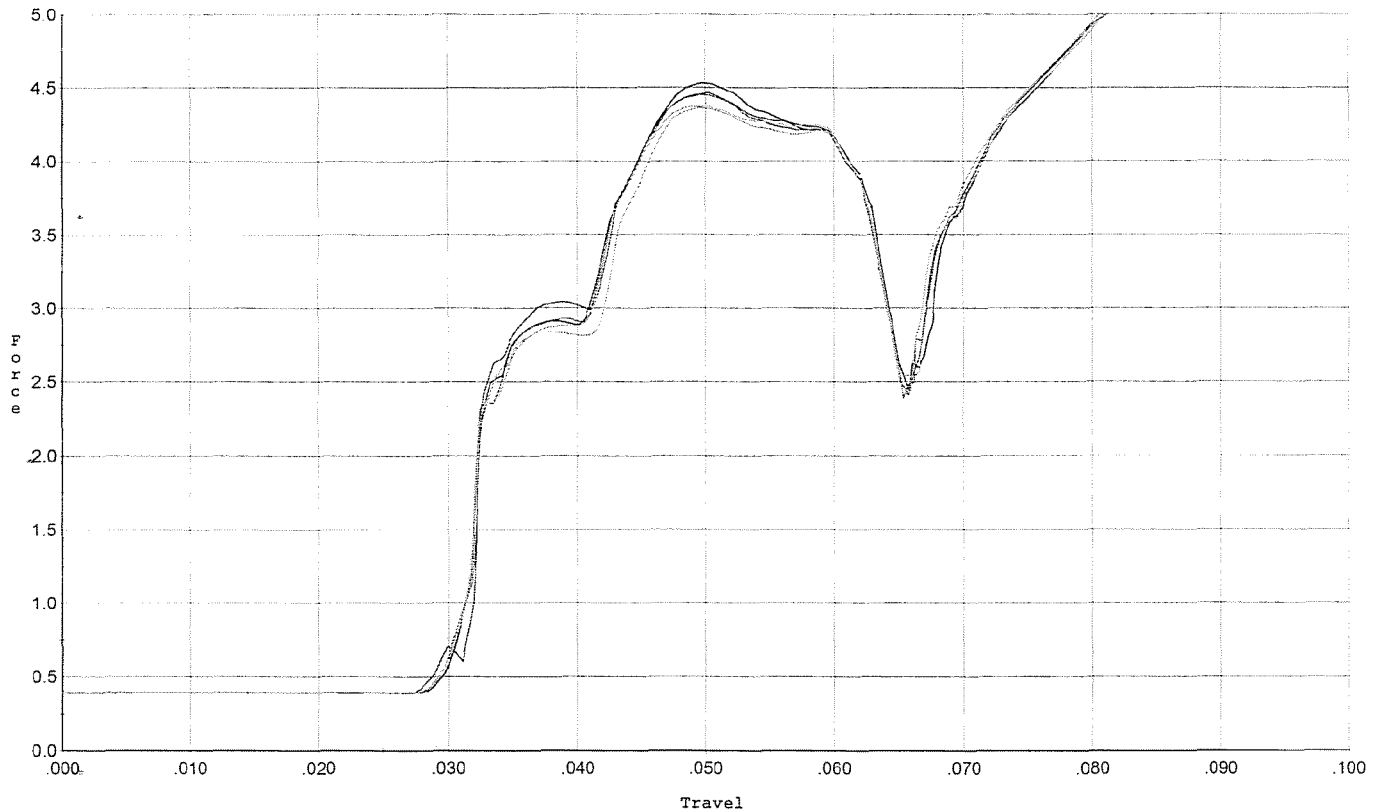
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.460	0.063	0.037	0.029	0.068		Set Trigger
2	2.482	0.064	0.035	0.028	0.068		Set Trigger
3	2.402	0.063	0.034	0.029	0.067		Set Trigger
4	2.545	0.063	0.034	0.028	0.068		Set Trigger
5	2.551	0.064	0.034	0.028	0.069		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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	4.467	0.063	0.029	0.025	0.130		Set Trigger
2	4.528	0.063	0.030	0.025	0.129		Set Trigger
3	4.453	0.064	0.030	0.025	0.130		Set Trigger
4	4.374	0.063	0.030	0.024	0.129		Set Trigger
5	4.361	0.063	0.030	0.025	0.127		Set Trigger

A-4.43