

GC794619

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

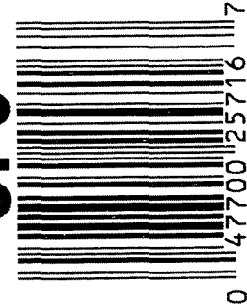
24"

CAPACITY

6

G6794619

UPC



GUN SERIAL #

G 6794619

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE		10-28-08	BS
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/29/08	(RB)
490	MAGNAFLUX BOLT		10/29/08	MR
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC		10/30/08	DG
542	APPLY COATINGS (BARREL ACTION)		11-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-11-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

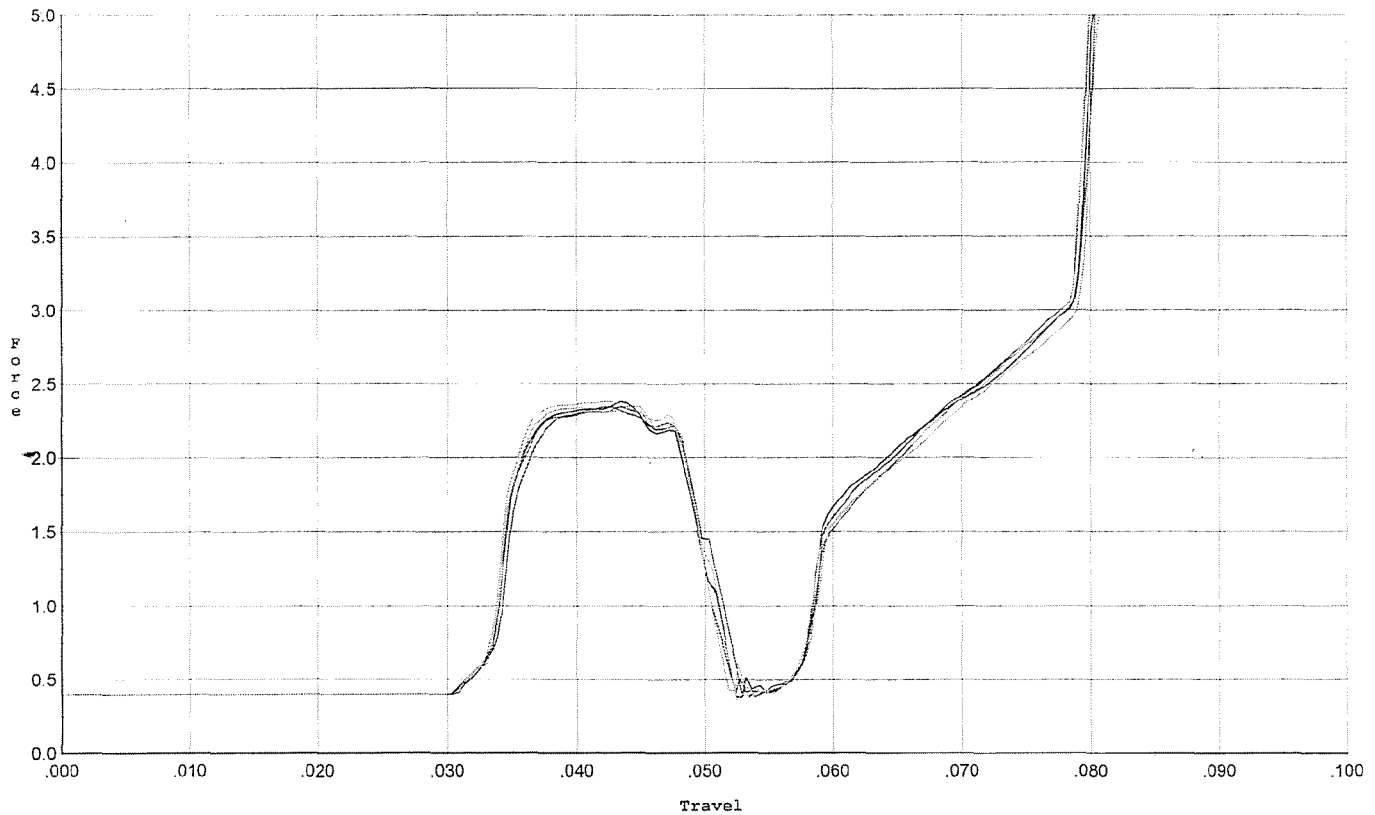
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	11-18-08	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	11-18-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	11-18-08	L. J.
	J) ASSEMBLE STOCK		11-11-08	FSW
	K) ASSEMBLE SWIVEL STUDS		11-18-08	L. J.
	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>	11-12-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-12-08	L. J.
670	FINAL INSPECTION A) HEADSPACE		11-18-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.77</u> <u>2.74</u> <u>2.73</u> <u>2.66</u>	11-14-08	TL
	C) FUNCTION		11-18-08	L. J.
690	PACK		12-2-08	TL

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



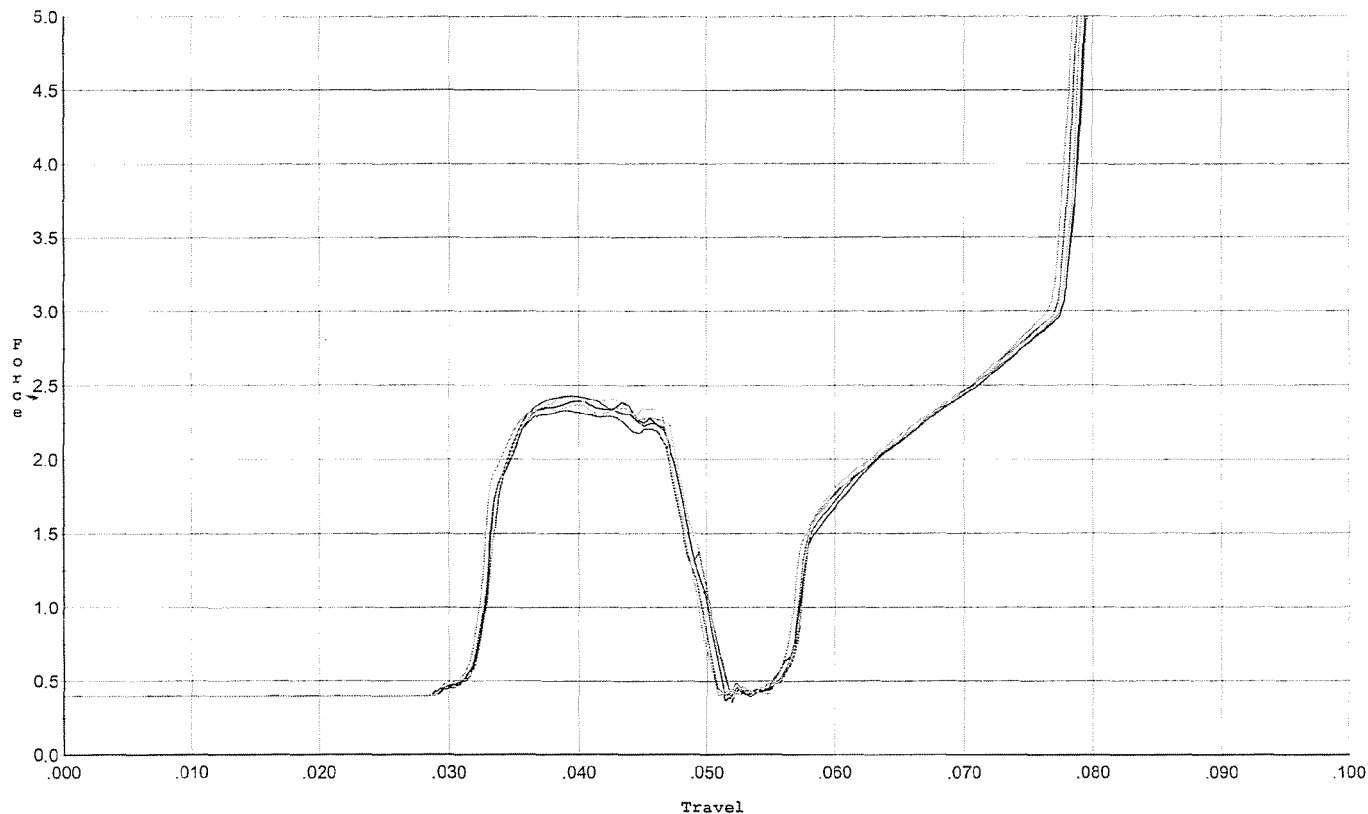
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.346	0.048	0.033	0.036	0.046		Set Trigger
2	2.378	0.051	0.033	0.035	0.049		Set Trigger
3	2.343	0.048	0.033	0.036	0.046		Set Trigger
4	2.382	0.051	0.033	0.035	0.050		Set Trigger
5	2.350	0.048	0.033	0.036	0.047		Set Trigger

A-2.36

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



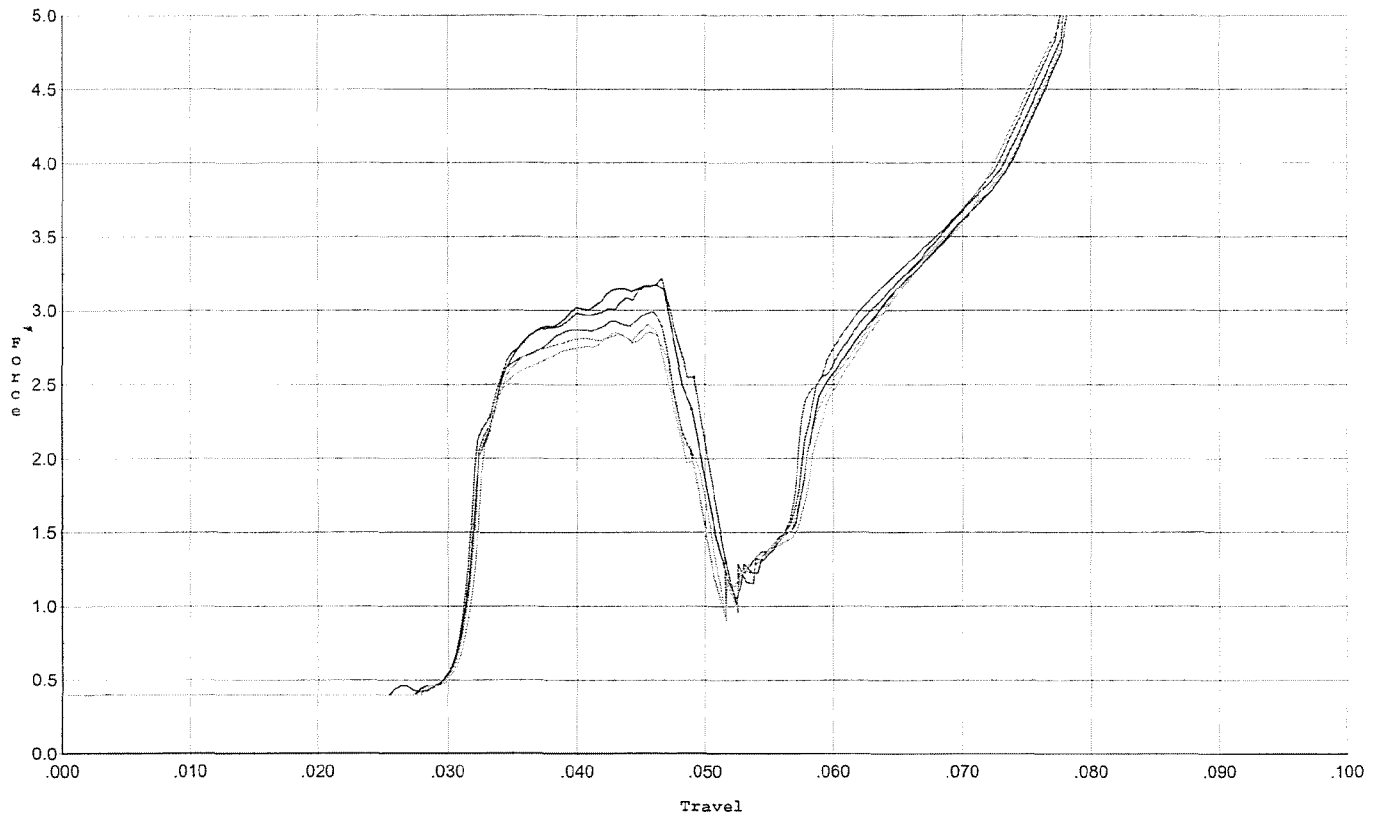
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.430	0.049	0.032	0.035	0.049		Set Trigger
2	2.392	0.050	0.032	0.035	0.049		Set Trigger
3	2.330	0.047	0.032	0.036	0.045		Set Trigger
4	2.370	0.047	0.032	0.035	0.046		Set Trigger
5	2.418	0.048	0.032	0.035	0.048		Set Trigger

A- 2-38

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



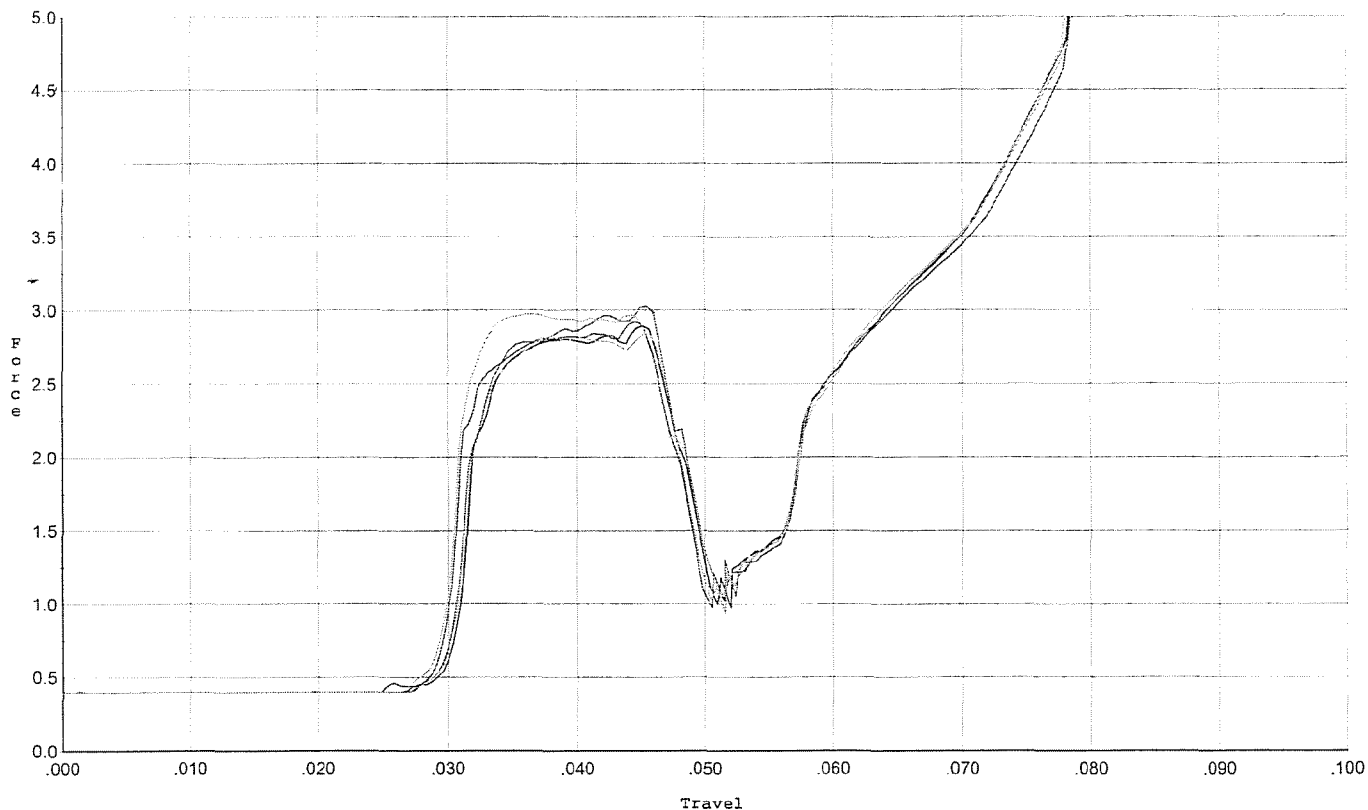
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.215	0.049	0.031	0.032	0.063		Set Trigger
2	3.174	0.049	0.031	0.032	0.062		Set Trigger
3	2.991	0.049	0.031	0.032	0.059		Set Trigger
4	2.907	0.049	0.031	0.033	0.058		Set Trigger
5	2.852	0.050	0.031	0.033	0.059		Set Trigger

A-3.02

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



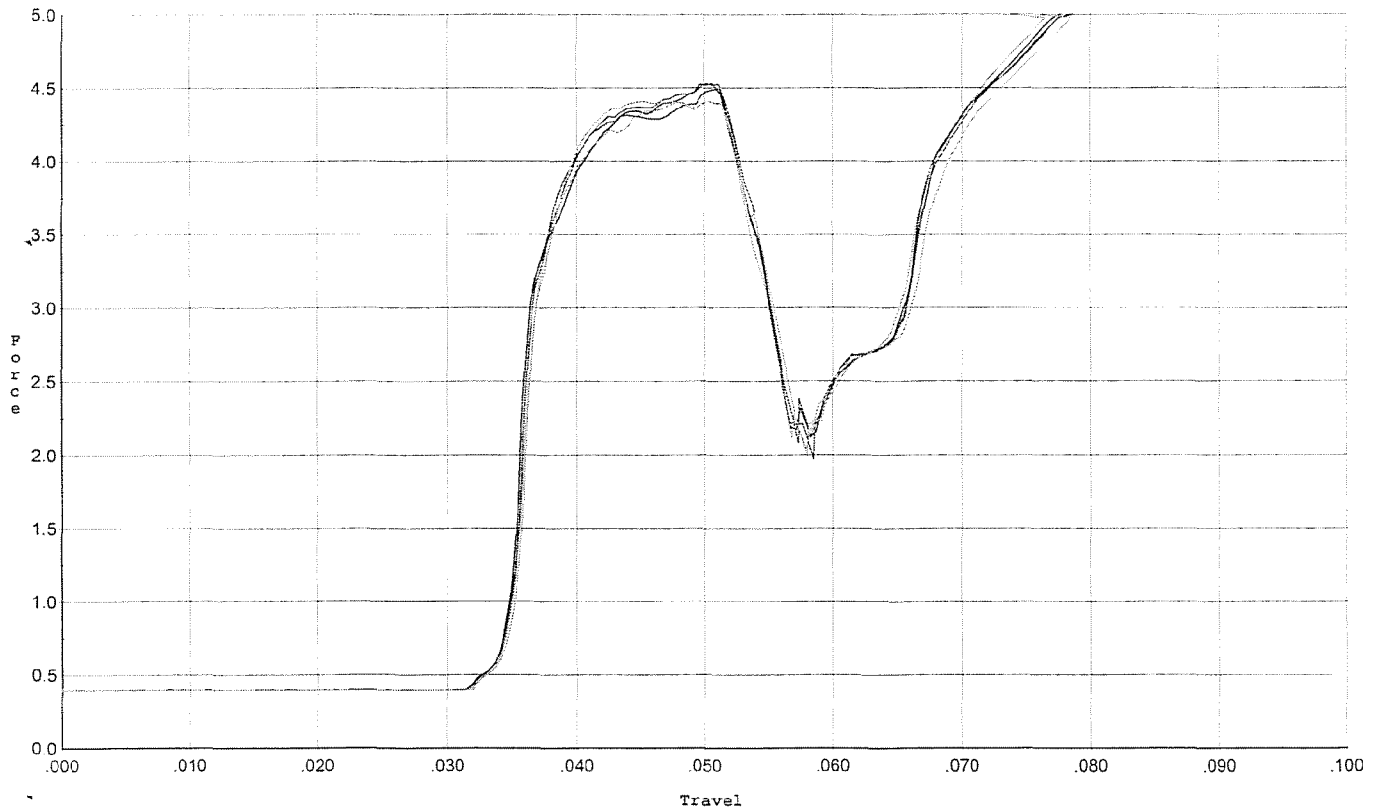
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.923	0.048	0.029	0.033	0.059		Set Trigger
2	2.894	0.049	0.030	0.033	0.058		Set Trigger
3	3.028	0.046	0.030	0.034	0.056		Set Trigger
4	2.973	0.048	0.029	0.033	0.061		Set Trigger
5	2.840	0.048	0.030	0.033	0.058		Set Trigger

A-2.93

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 lbs



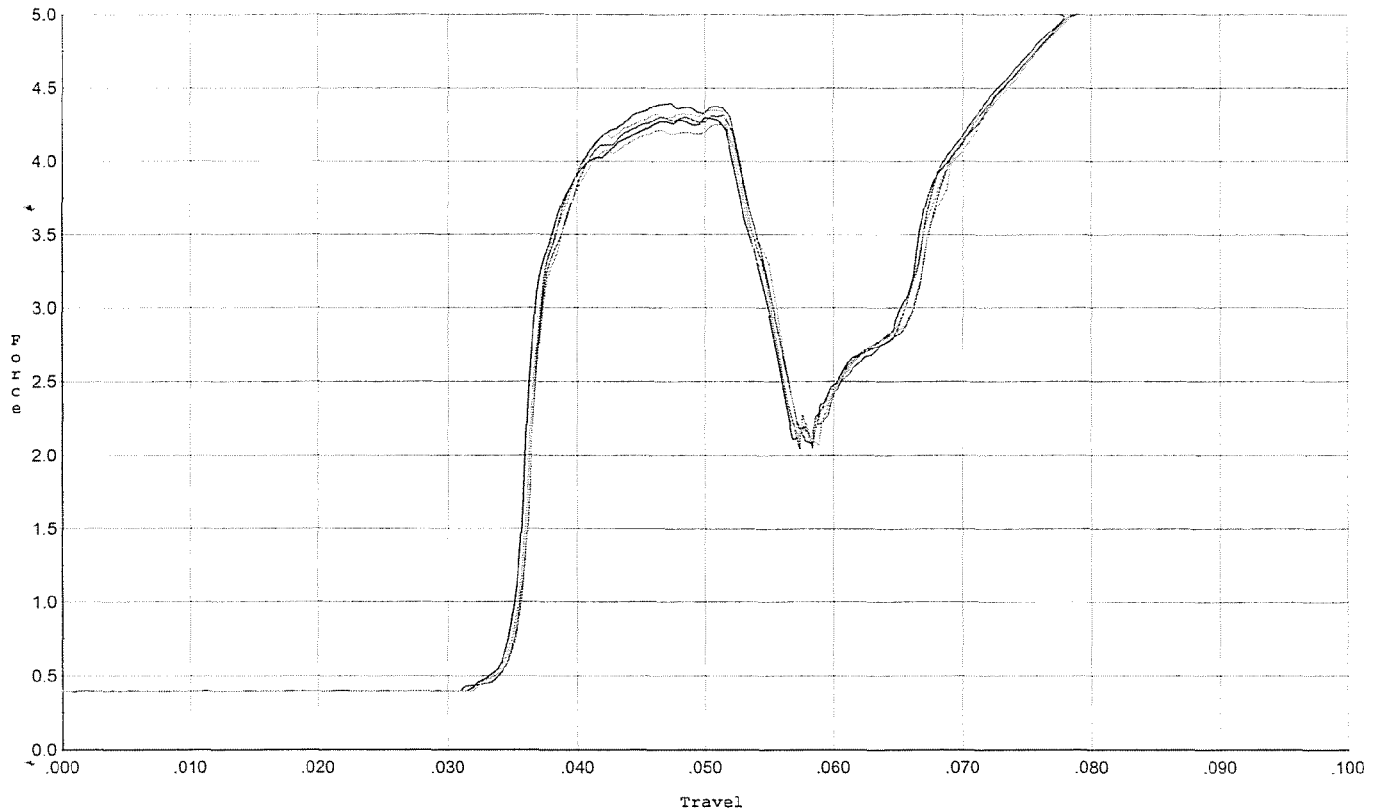
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.490	0.054	0.034	0.033	0.092		Set Trigger
2	4.526	0.054	0.034	0.033	0.092		Set Trigger
3	4.529	0.054	0.032	0.033	0.092		Set Trigger
4	4.412	0.055	0.032	0.033	0.093		Set Trigger
5	4.410	0.055	0.034	0.033	0.092		Set Trigger

A-4.47

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 lbs



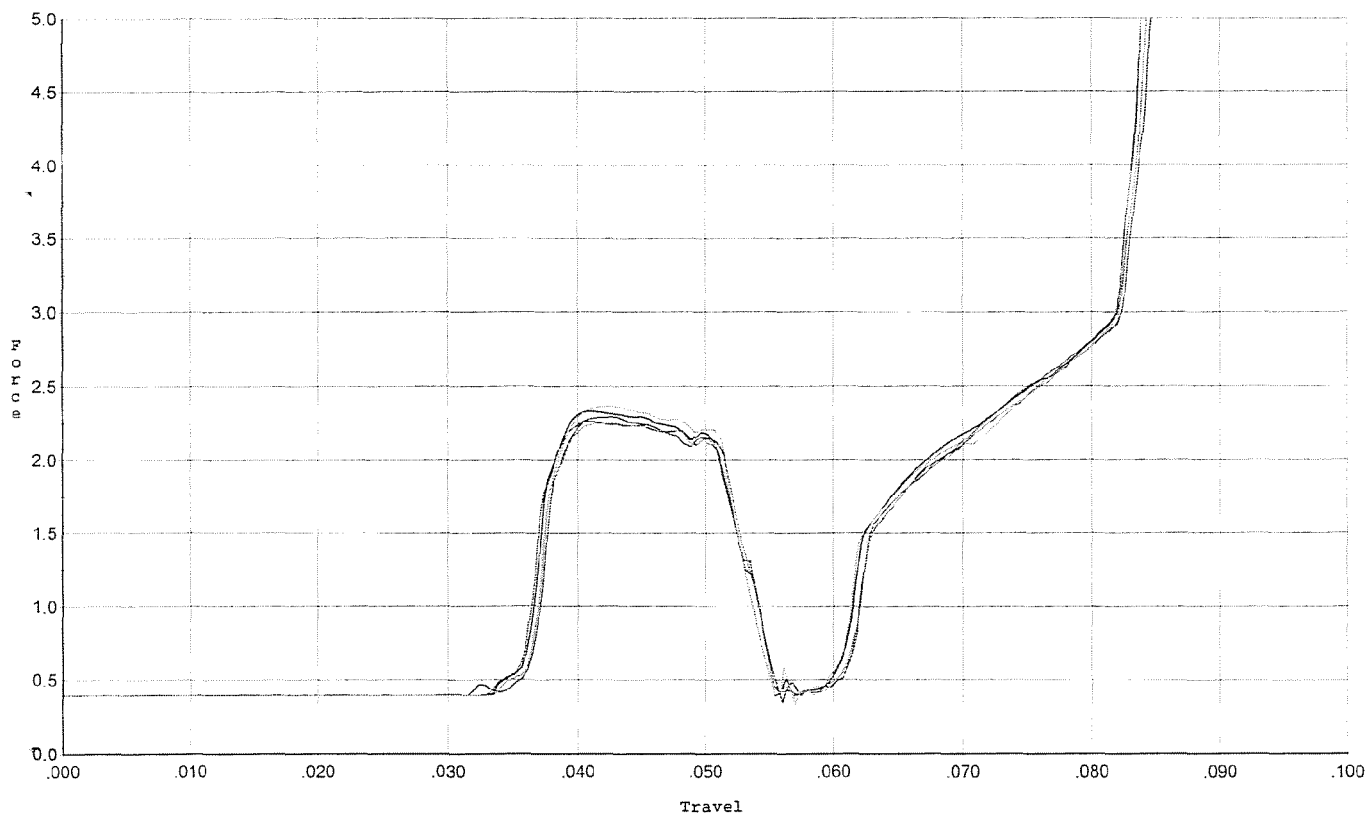
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.396	0.056	0.035	0.033	0.092		Set Trigger
2	4.299	0.055	0.034	0.033	0.090		Set Trigger
3	4.315	0.054	0.035	0.033	0.089		Set Trigger
4	4.351	0.055	0.035	0.033	0.090		Set Trigger
5	4.251	0.055	0.035	0.033	0.089		Set Trigger

A. 4.32

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



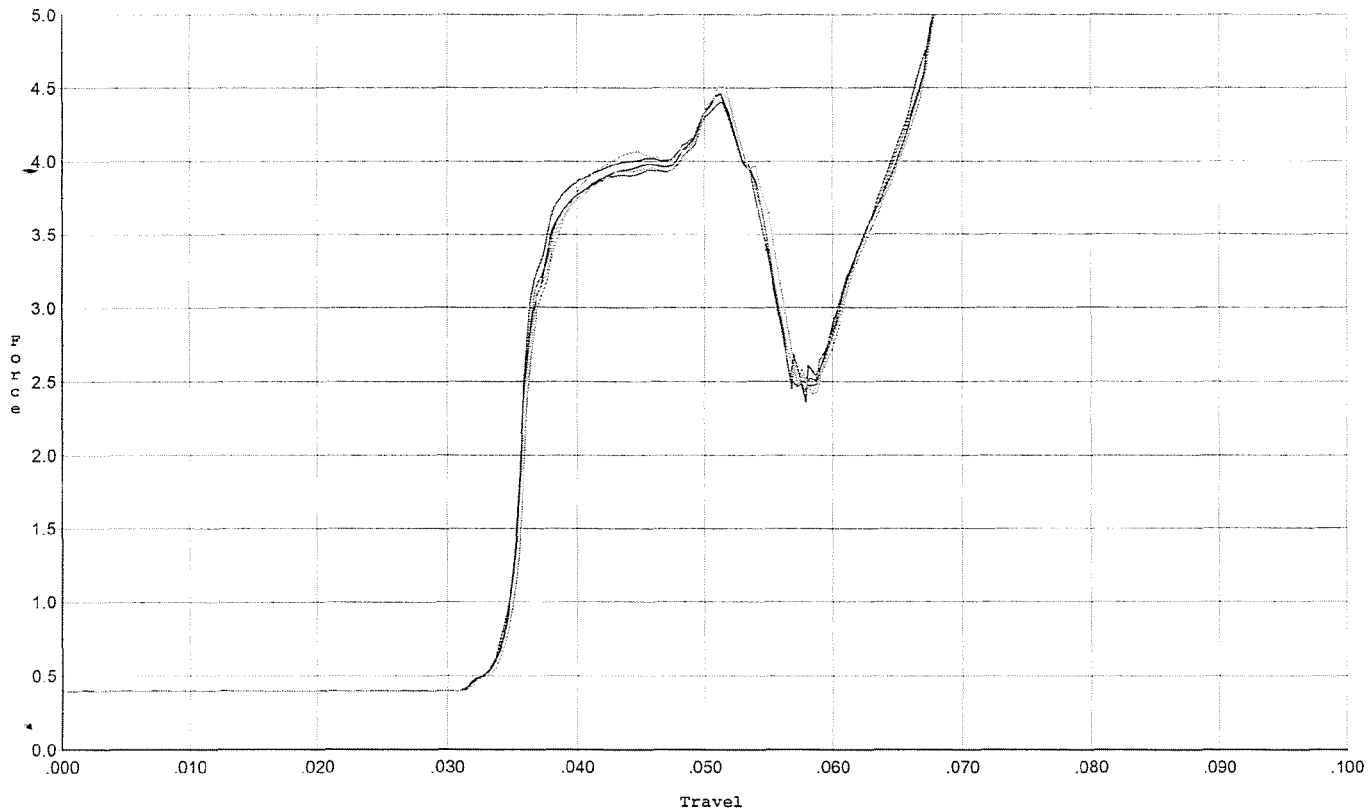
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.293	0.051	0.036	0.038	0.047		Set Trigger
2	2.333	0.054	0.034	0.037	0.050		Set Trigger
3	2.261	0.054	0.036	0.037	0.050		Set Trigger
4	2.369	0.054	0.036	0.037	0.050		Set Trigger
5	2.253	0.052	0.036	0.037	0.047		Set Trigger

A-230

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 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.458	0.055	0.034	0.017	0.092		Set Trigger
2	4.457	0.054	0.034	0.017	0.090		Set Trigger
3	4.405	0.054	0.034	0.017	0.090		Set Trigger
4	4.479	0.054	0.034	0.017	0.089		Set Trigger
5	4.513	0.055	0.034	0.017	0.092		Set Trigger

A-4.46