

66807737

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



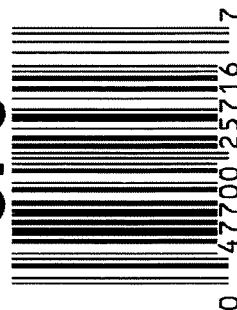
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807737

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807737

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
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 	3/9/09	
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	TL
542	APPLY COATINGS (BARREL ACTION)		3-20	TL
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

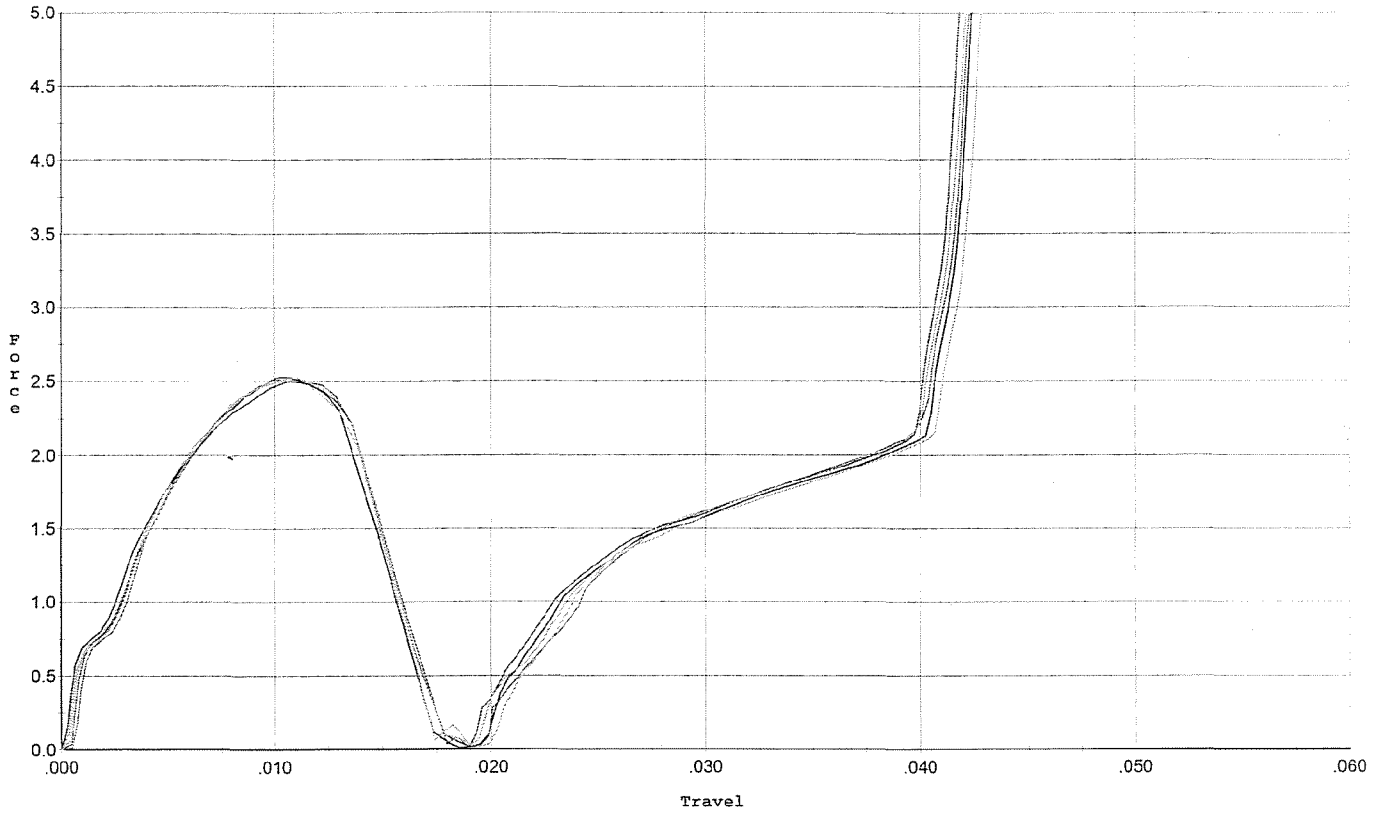
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-25-09	WN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-25-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-25-09	WN
	J) ASSEMBLE STOCK		3-23-09	SP
	K) ASSEMBLE SWIVEL STUDS		3-25-09	WN
	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	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WN
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.16</u> <u>2.57</u> <u>2.63</u> <u>2.69</u> <u>2.65</u>	3-25-09	TL
	C) FUNCTION		3-25-09	WN
690	PACK		3-25-09	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



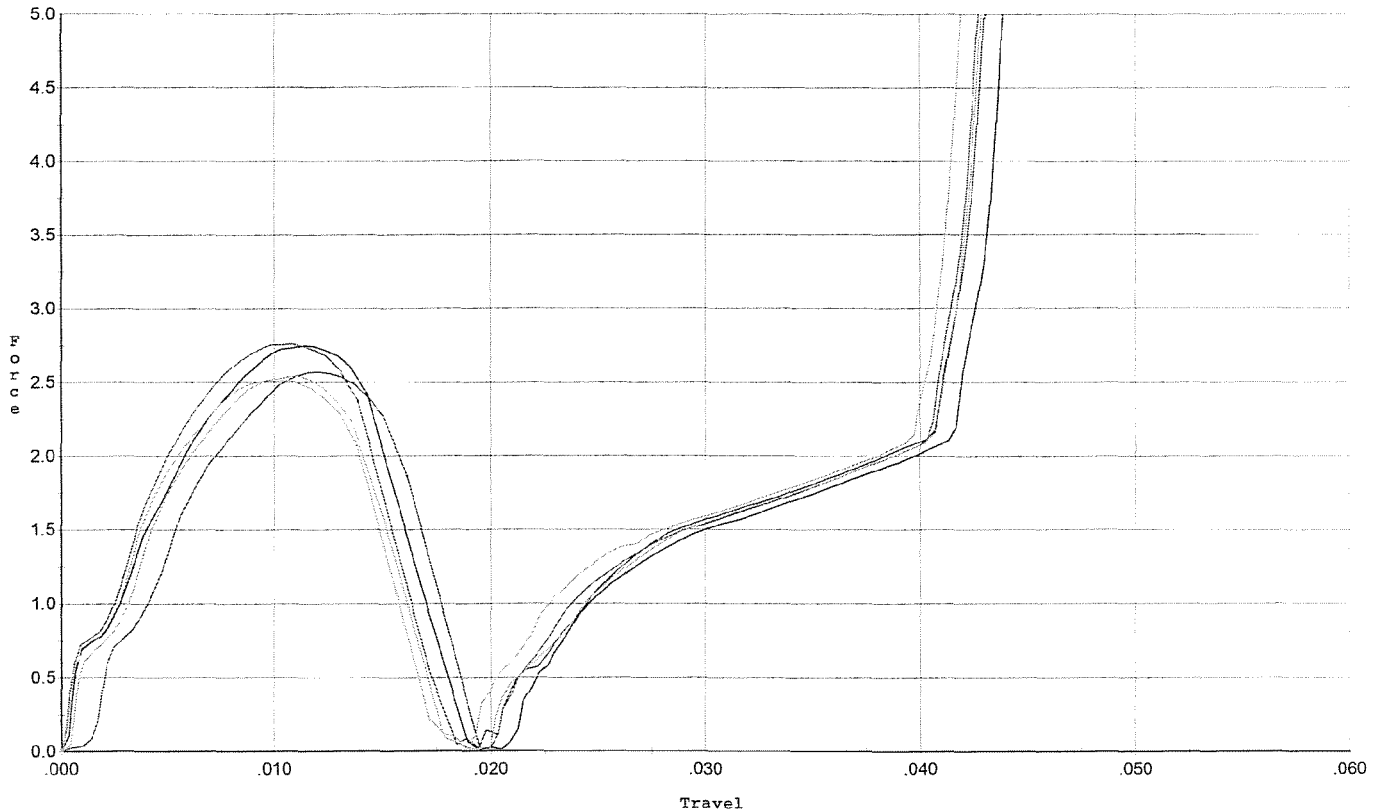
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.014	0.00	0.032	0.023		Set Trigger
2	2.517	0.015	0.00	0.032	0.025		Set Trigger
3	2.528	0.014	0.00	0.032	0.023		Set Trigger
4	2.523	0.014	0.00	0.033	0.023		Set Trigger
5	2.516	0.014	0.00	0.032	0.024		Set Trigger

A2.51

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



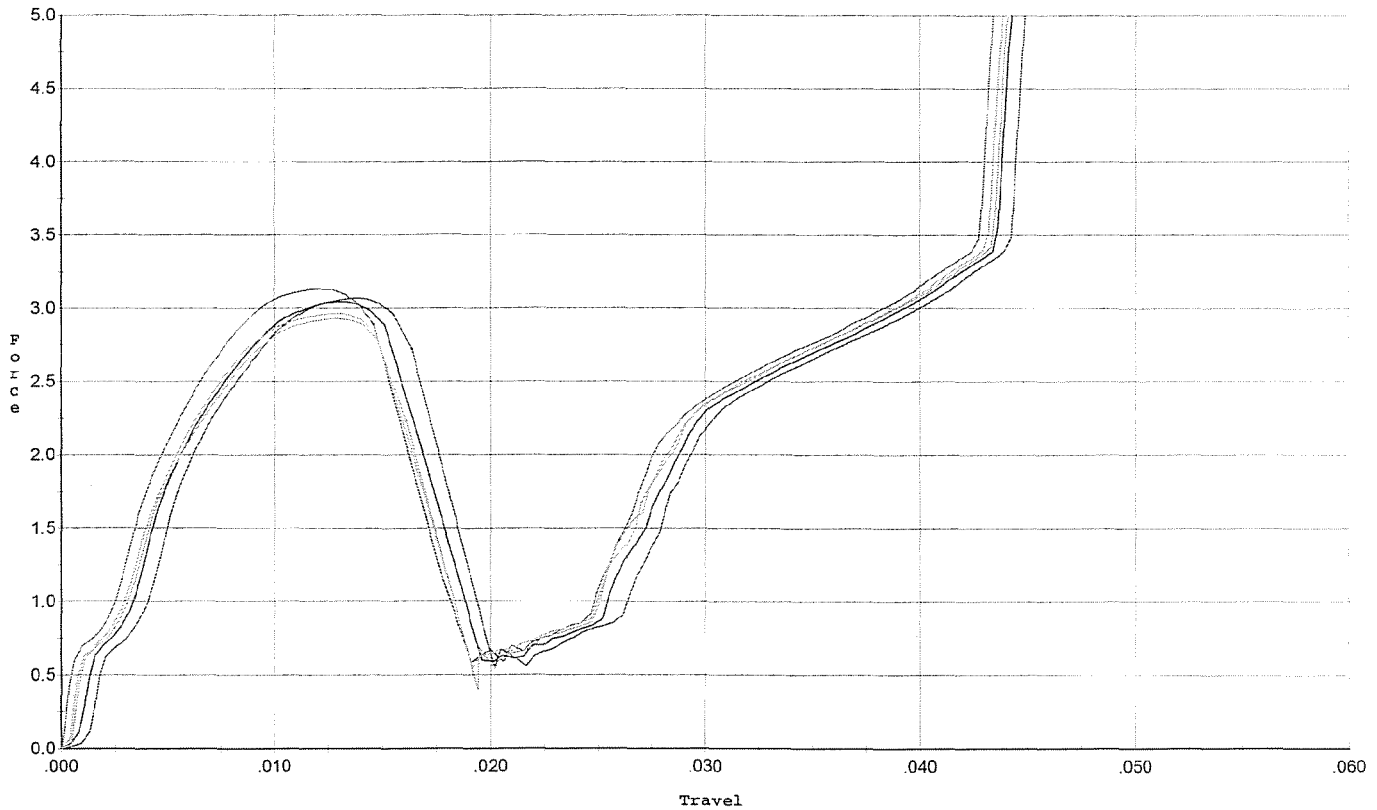
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.570	0.016	0.00	0.032	0.026		Set Trigger
2	2.749	0.014	0.00	0.033	0.026		Set Trigger
3	2.763	0.014	0.00	0.032	0.026		Set Trigger
4	2.515	0.014	0.00	0.032	0.024		Set Trigger
5	2.545	0.015	0.00	0.032	0.026		Set Trigger

A-2.62

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



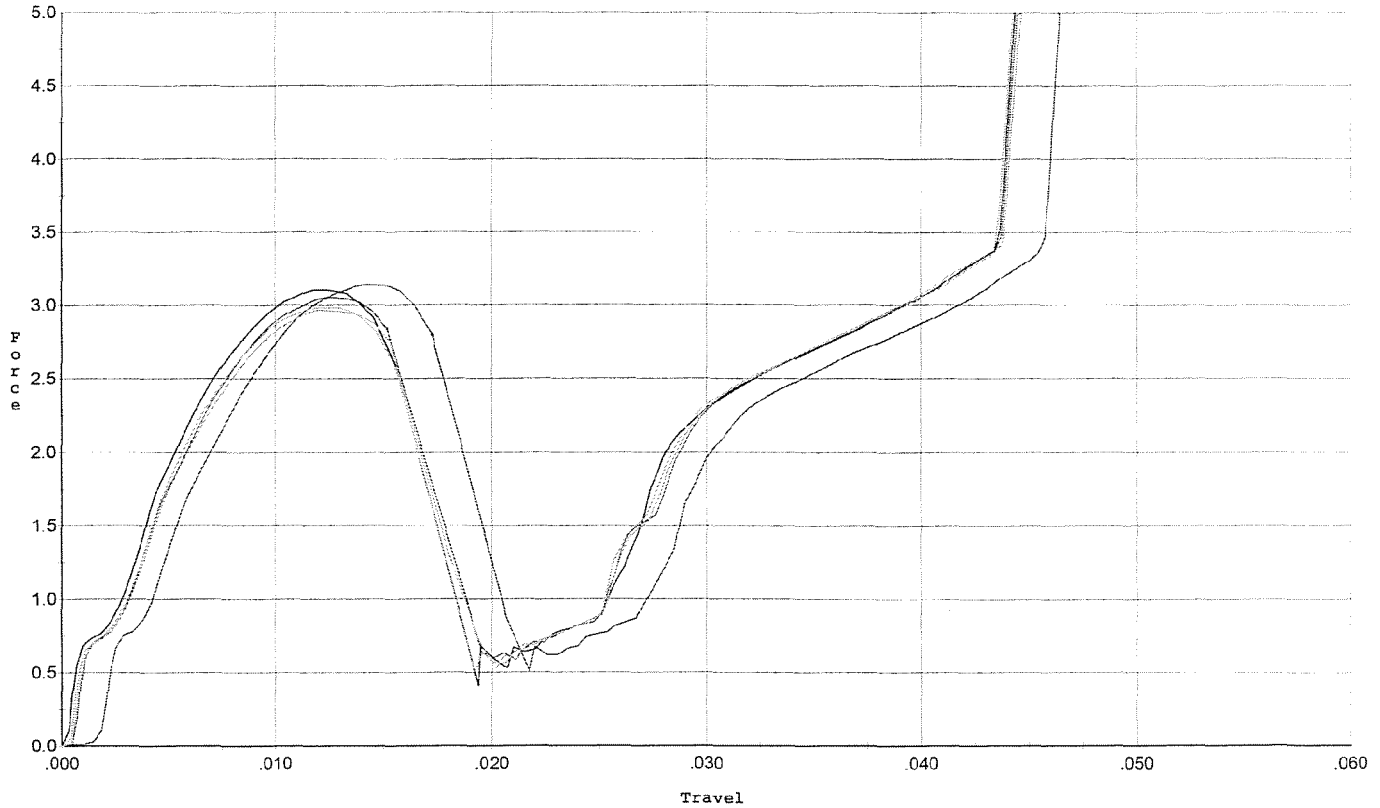
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.070	0.016	0.00	0.031	0.032		Set Trigger
2	3.046	0.017	0.00	0.030	0.034		Set Trigger
3	3.129	0.015	0.00	0.030	0.031		Set Trigger
4	2.964	0.017	0.00	0.030	0.033		Set Trigger
5	2.928	0.016	0.00	0.031	0.031		Set Trigger

A-3.02

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 cycles+/- .75 lb



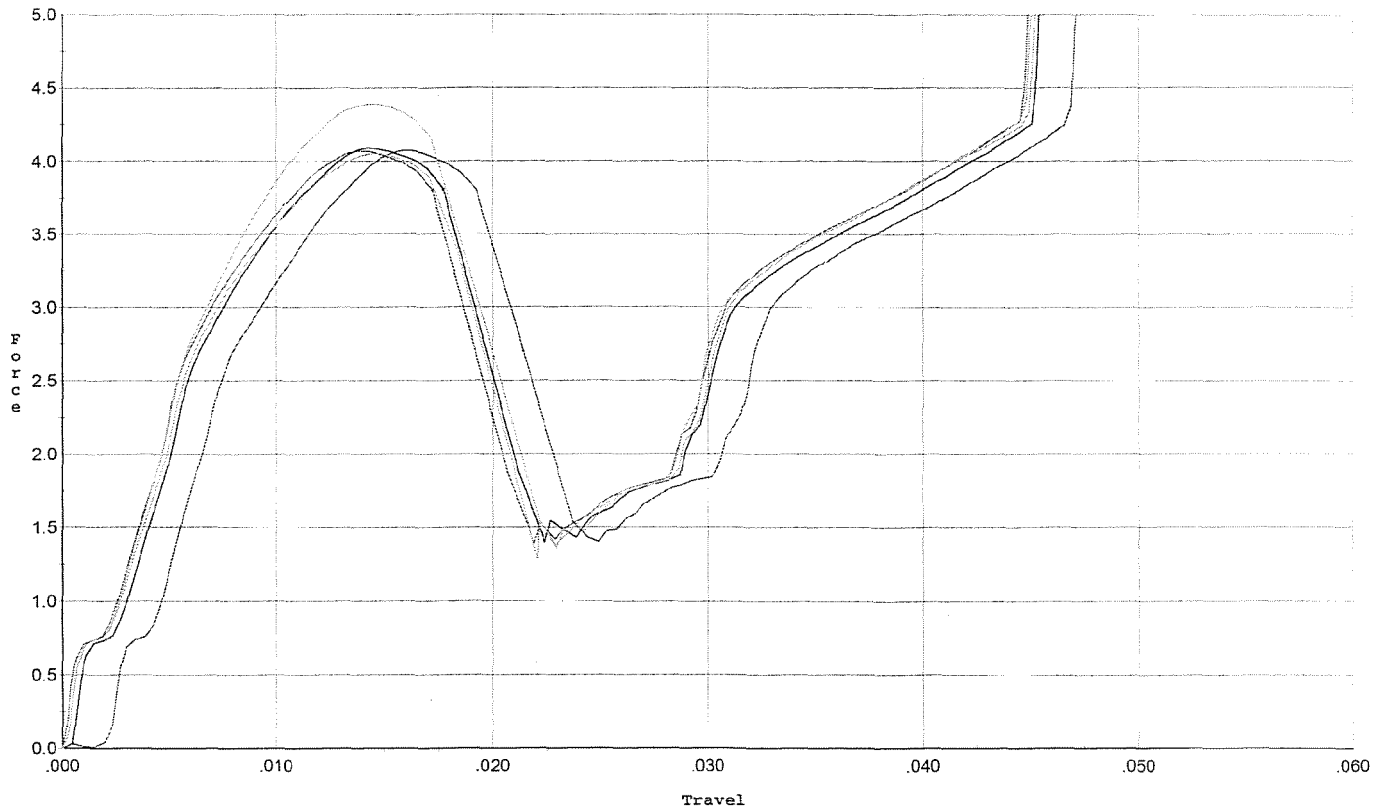
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.139	0.017	0.00	0.032	0.034		Set Trigger
2	3.103	0.016	0.00	0.031	0.032		Set Trigger
3	3.053	0.015	0.00	0.031	0.030		Set Trigger
4	2.981	0.016	0.00	0.031	0.031		Set Trigger
5	2.966	0.015	0.00	0.031	0.030		Set Trigger

A-3.04

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



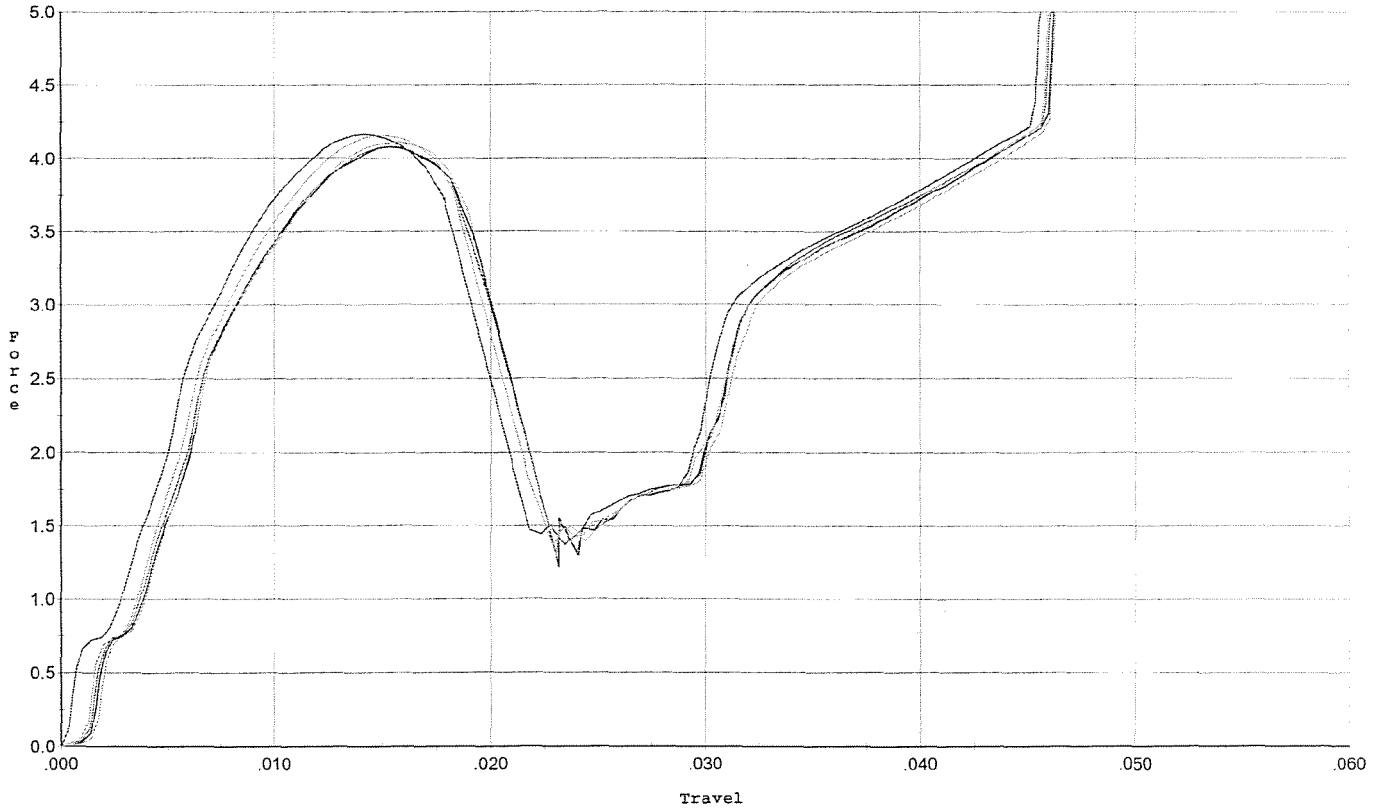
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.070	0.021	0.002	0.029	0.052		Set Trigger
2	4.091	0.018	0.00	0.029	0.046		Set Trigger
3	4.068	0.017	0.00	0.028	0.046		Set Trigger
4	4.048	0.018	0.00	0.029	0.048		Set Trigger
5	4.389	0.020	0.00	0.028	0.055		Set Trigger

A-413

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



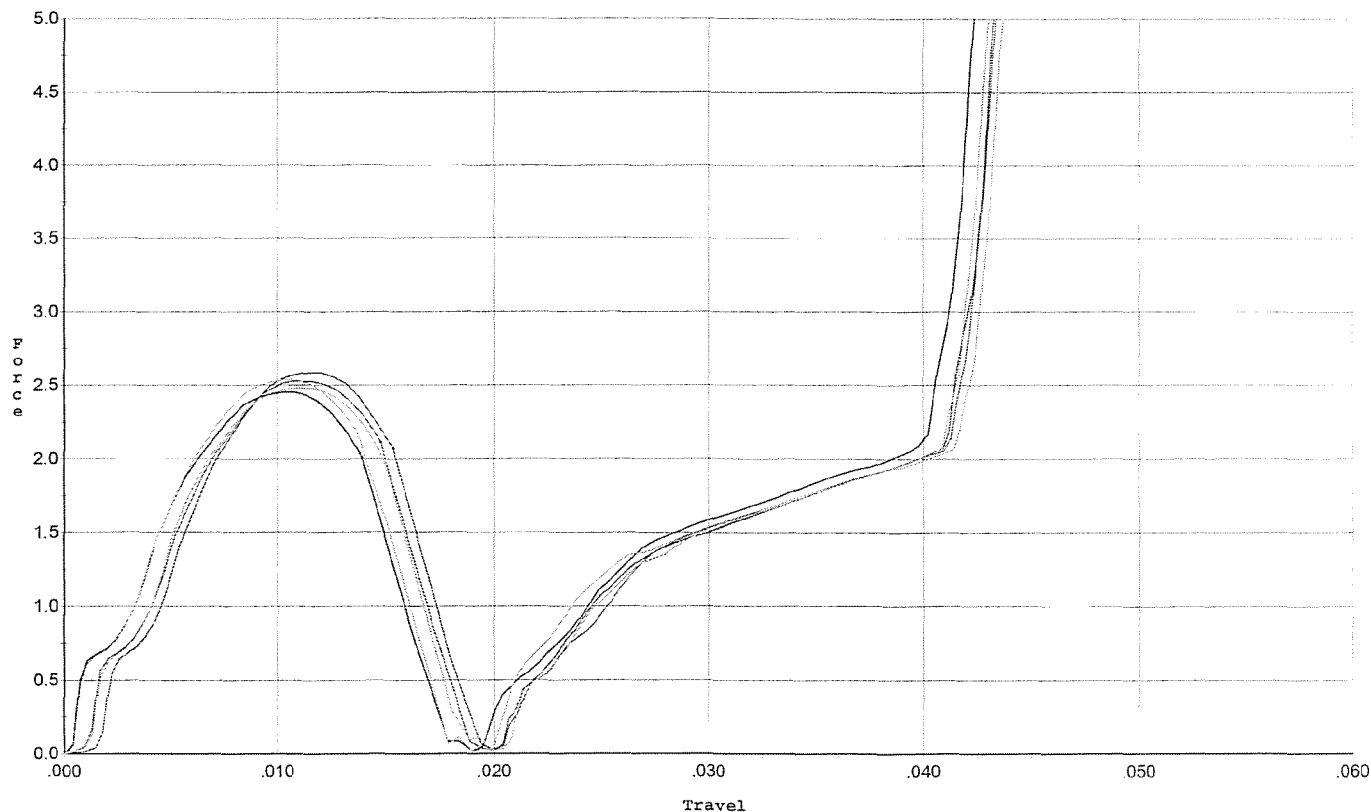
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.166	0.018	0.00	0.029	0.048		Set Trigger
2	4.080	0.019	0.00	0.029	0.049		Set Trigger
3	4.082	0.020	0.00	0.029	0.050		Set Trigger
4	4.112	0.019	0.00	0.029	0.048		Set Trigger
5	4.159	0.018	0.00	0.029	0.047		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: reset to 2.5 lbs +/- .50 lb for target & accuracy



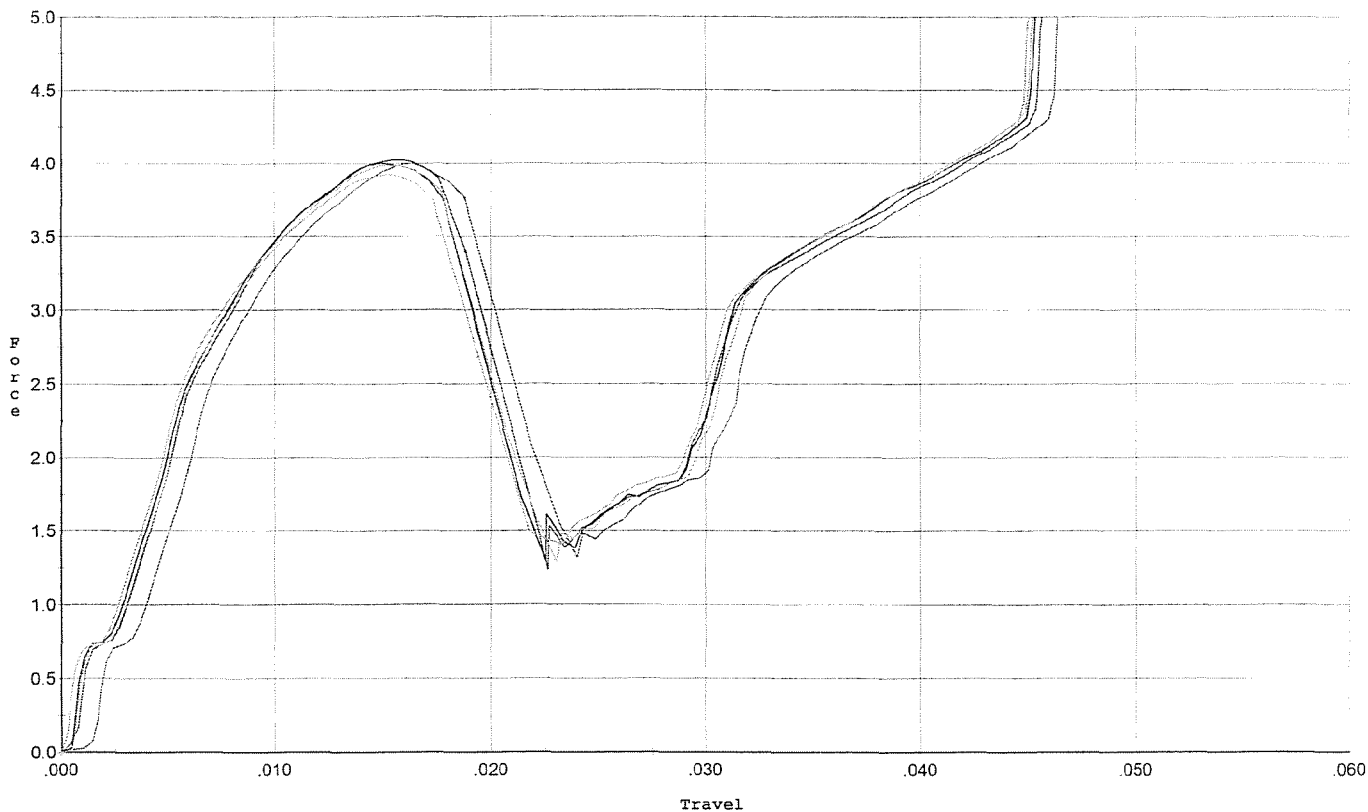
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.586	0.015	0.00	0.032	0.024		Set Trigger
2	2.452	0.014	0.00	0.032	0.023		Set Trigger
3	2.530	0.015	0.00	0.033	0.024		Set Trigger
4	2.539	0.015	0.00	0.033	0.026		Set Trigger
5	2.483	0.015	0.00	0.033	0.024		Set Trigger

A-251

Trigger Profile [lbs,inch]

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

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



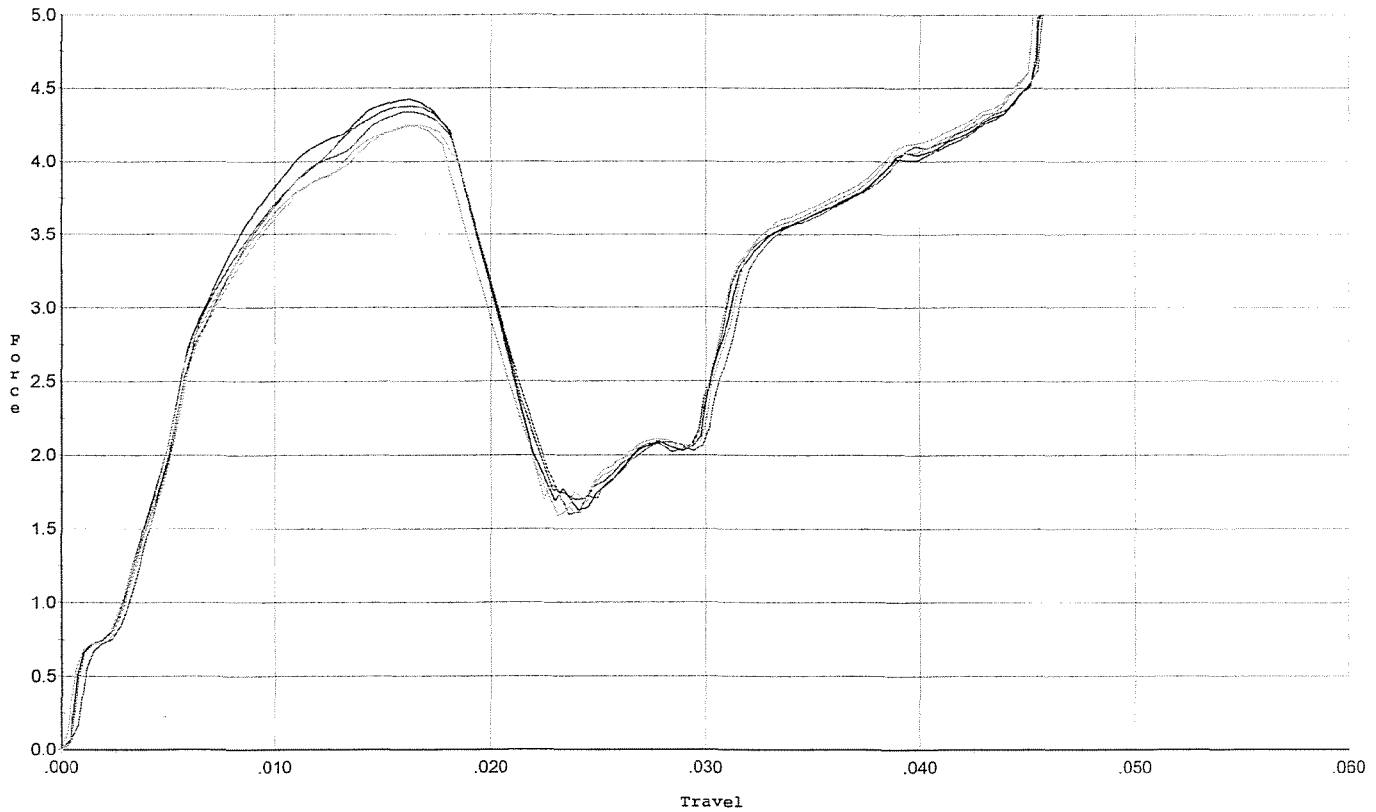
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.026	0.019	0.00	0.029	0.049		Set Trigger
2	4.004	0.018	0.00	0.029	0.046		Set Trigger
3	4.000	0.019	0.00	0.029	0.046		Set Trigger
4	3.986	0.018	0.00	0.029	0.045		Set Trigger
5	3.919	0.019	0.00	0.029	0.050		Set Trigger

A-3.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 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	4.380	0.018	0.00	0.027	0.050		Set Trigger
2	4.426	0.018	0.00	0.028	0.052		Set Trigger
3	4.338	0.018	0.00	0.028	0.050		Set Trigger
4	4.251	0.018	0.00	0.027	0.050		Set Trigger
5	4.239	0.018	0.00	0.028	0.049		Set Trigger

A. 4.32