

96807762

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



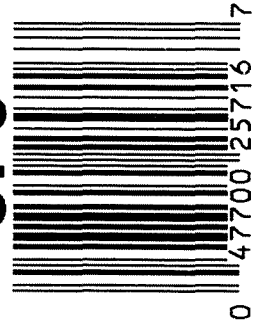
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807762

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807762

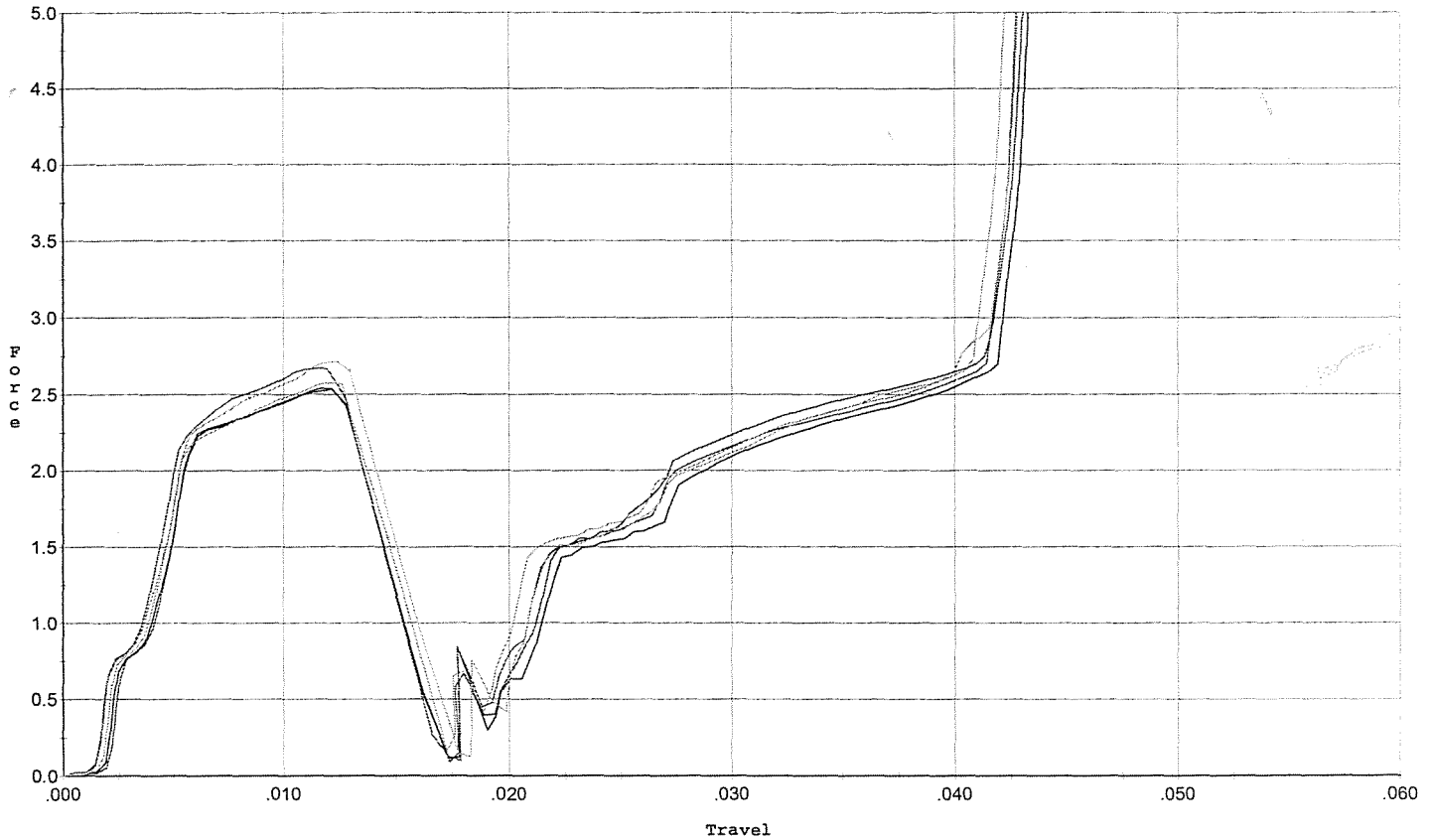
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAGNA-FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RTG
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/4/09	
490	MAGNAFLUX BOLT		3/5/09	ML
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	mon
540	APPLY COATINGS (BARREL ACTION)		3/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-12-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>55</u>	3-20-09	N/N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-20-09	N/N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-20-09	N/N
	J) ASSEMBLE STOCK		3-16-09	X D
	K) ASSEMBLE SWIVEL STUDS		3-20-09	N/N
	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	3-18-09	L.P.P.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-18-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	N/N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.51</u> <u>2.49</u> <u>2.60</u> <u>2.53</u>	3-19-09	TL
	C) FUNCTION		3-20-09	N/N
690	PACK		3-20-09	TL

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



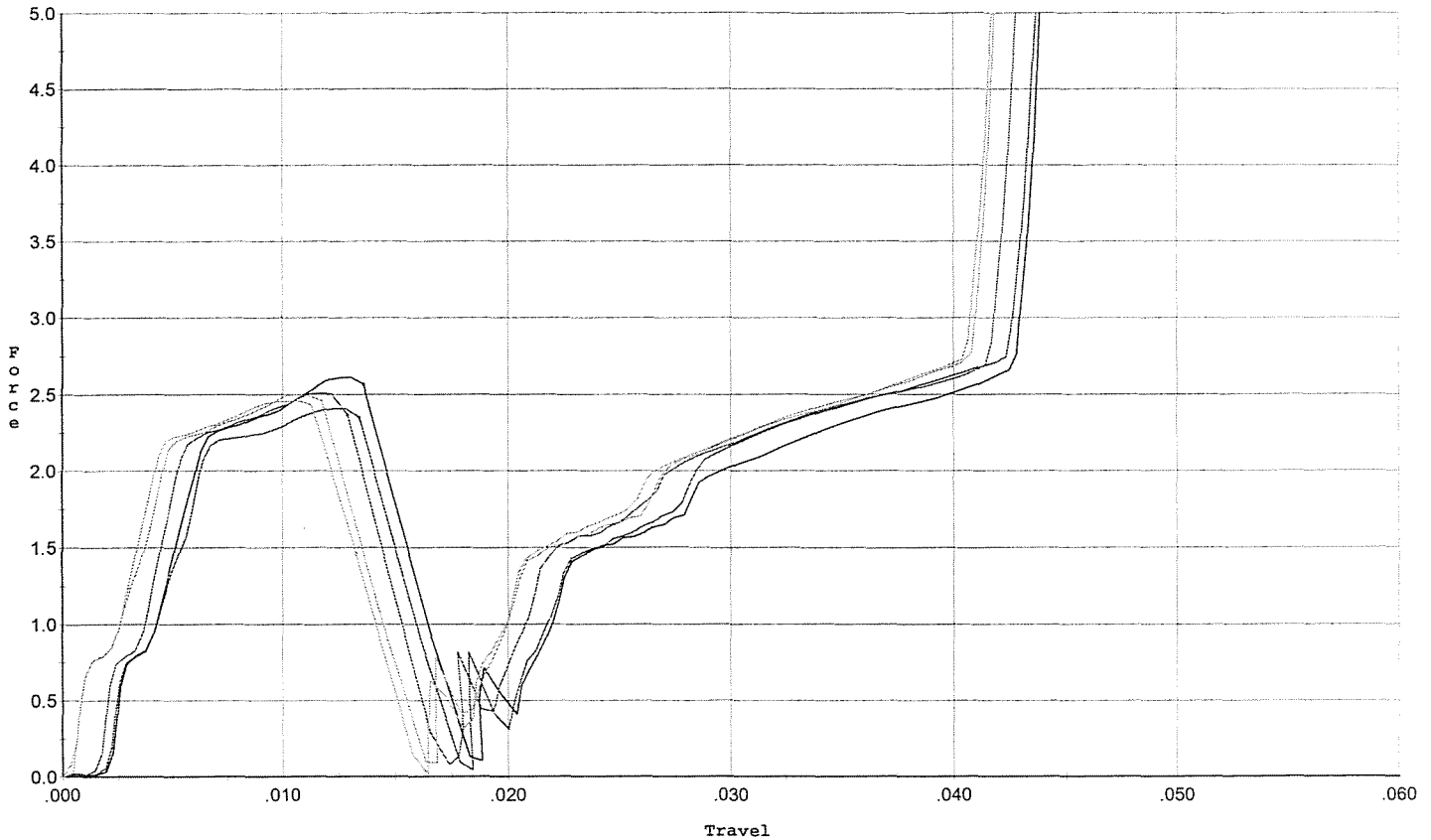
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.534	0.013	0.002	0.033	0.020		Set Trigger
2	2.539	0.013	0.00	0.033	0.020		Set Trigger
3	2.671	0.013	0.00	0.033	0.022		Set Trigger
4	2.716	0.013	0.00	0.032	0.022		Set Trigger
5	2.578	0.015	0.00	0.032	0.024		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



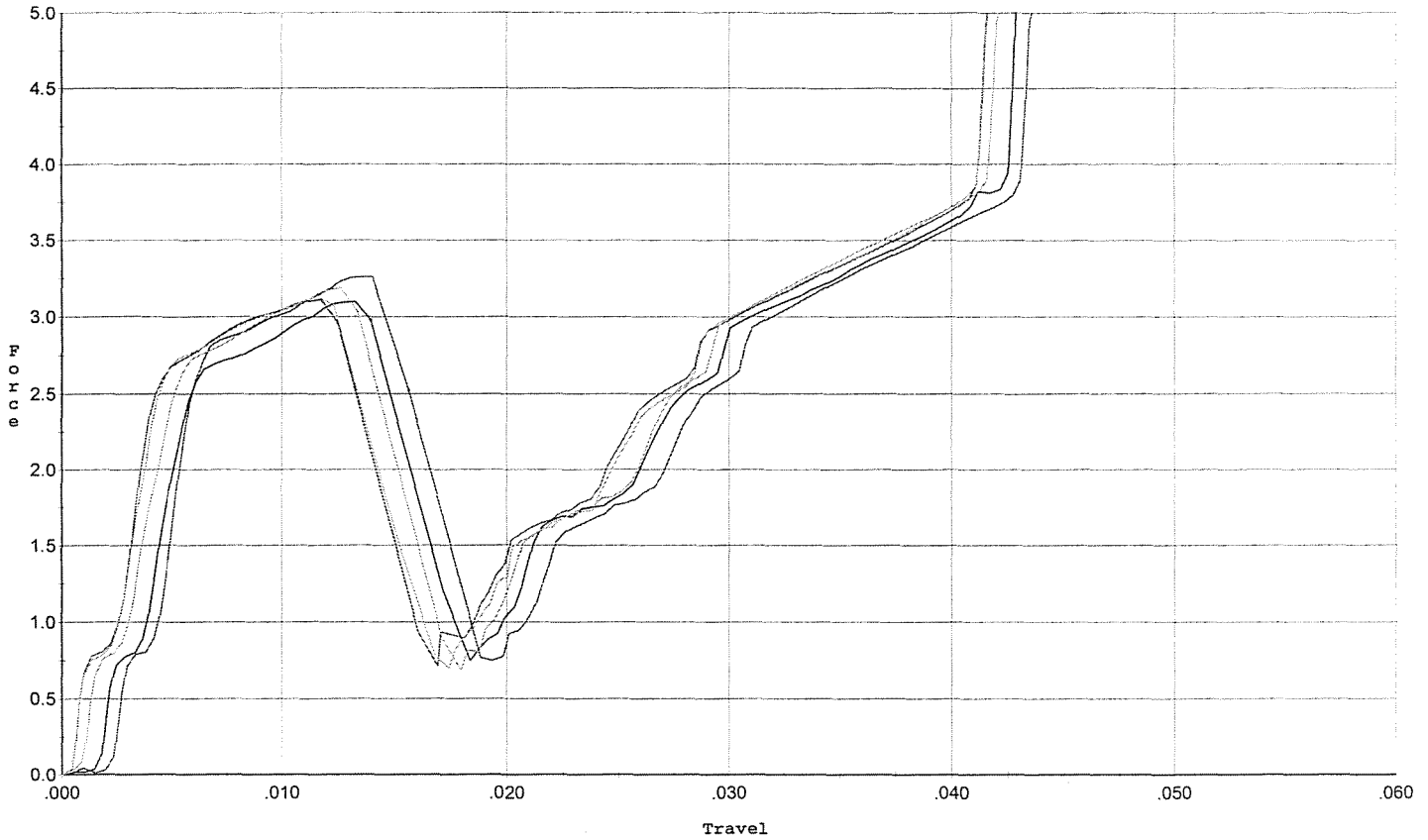
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.408	0.013	0.002	0.033	0.020		Set Trigger
2	2.613	0.014	0.002	0.033	0.022		Set Trigger
3	2.509	0.013	0.00	0.032	0.021		Set Trigger
4	2.459	0.013	0.00	0.032	0.023		Set Trigger
5	2.500	0.012	0.00	0.032	0.020		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



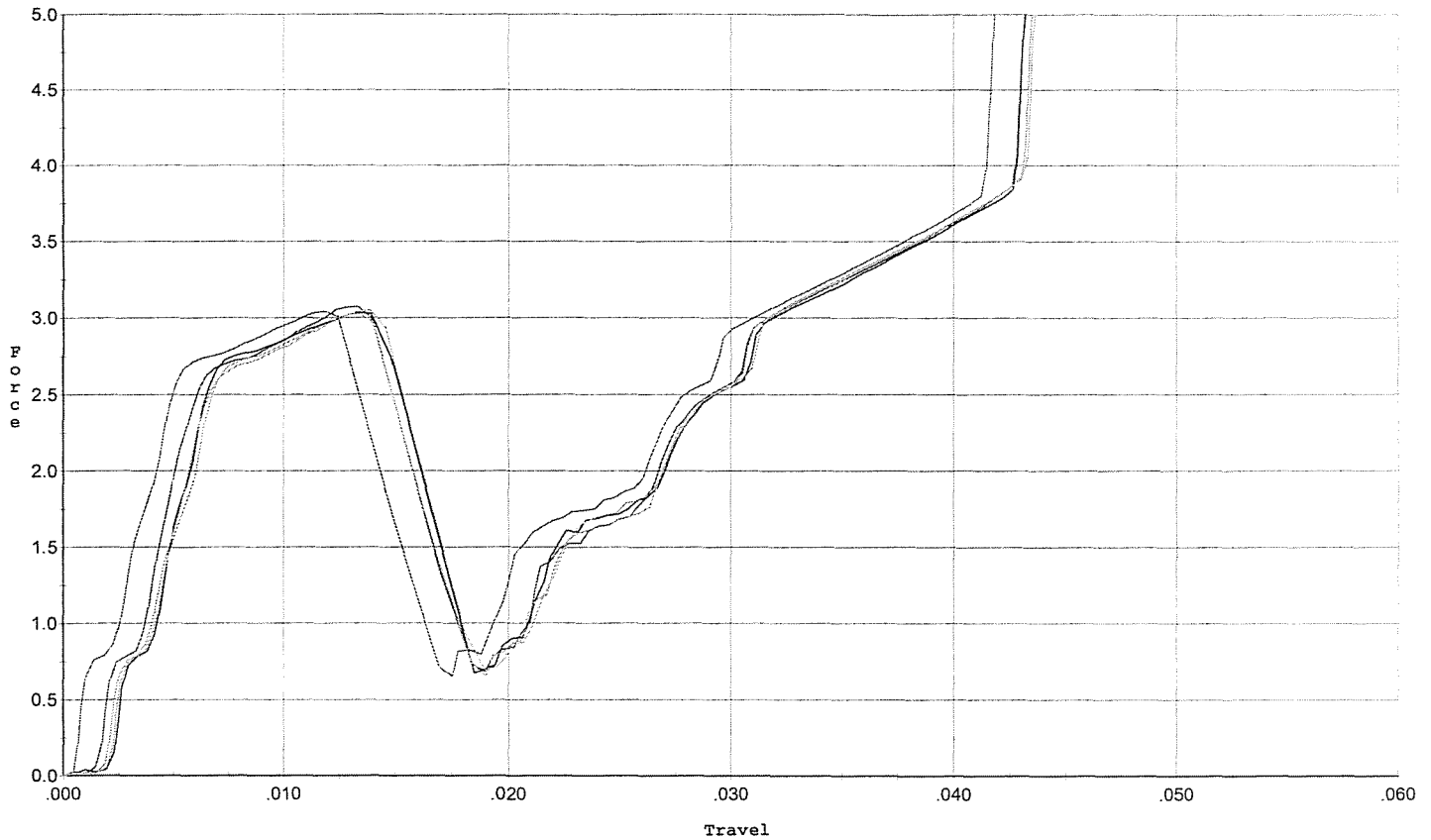
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.258	0.016	0.00	0.030	0.031		Set Trigger
2	3.099	0.014	0.00	0.030	0.027		Set Trigger
3	3.109	0.012	0.00	0.030	0.027		Set Trigger
4	3.120	0.012	0.00	0.030	0.026		Set Trigger
5	3.189	0.013	0.00	0.030	0.028		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



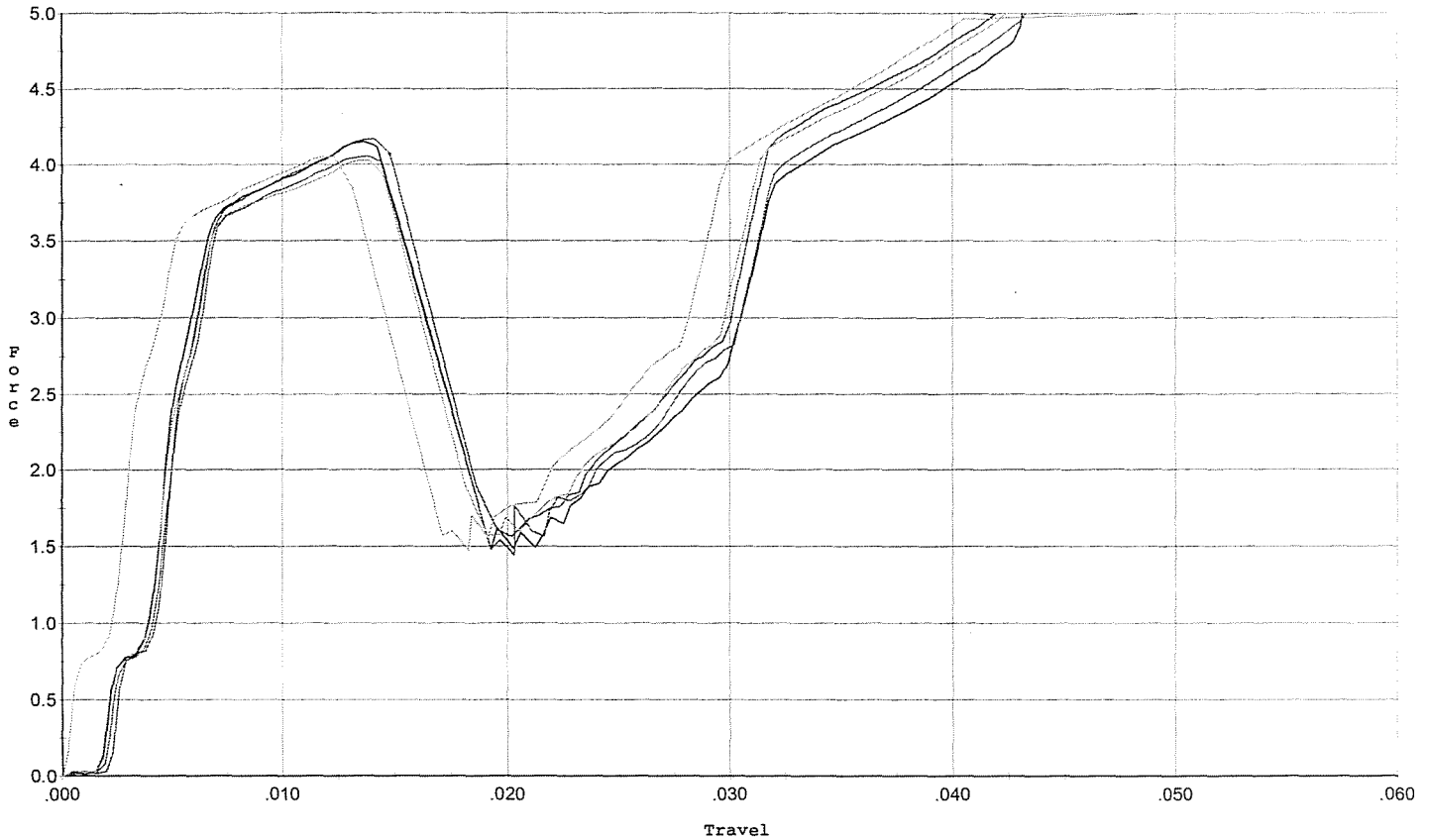
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.072	0.014	0.00	0.030	0.027		Set Trigger
2	3.034	0.015	0.00	0.030	0.028		Set Trigger
3	3.042	0.012	0.00	0.030	0.025		Set Trigger
4	3.052	0.015	0.00	0.031	0.027		Set Trigger
5	3.026	0.014	0.002	0.030	0.026		Set Trigger

A-3-04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



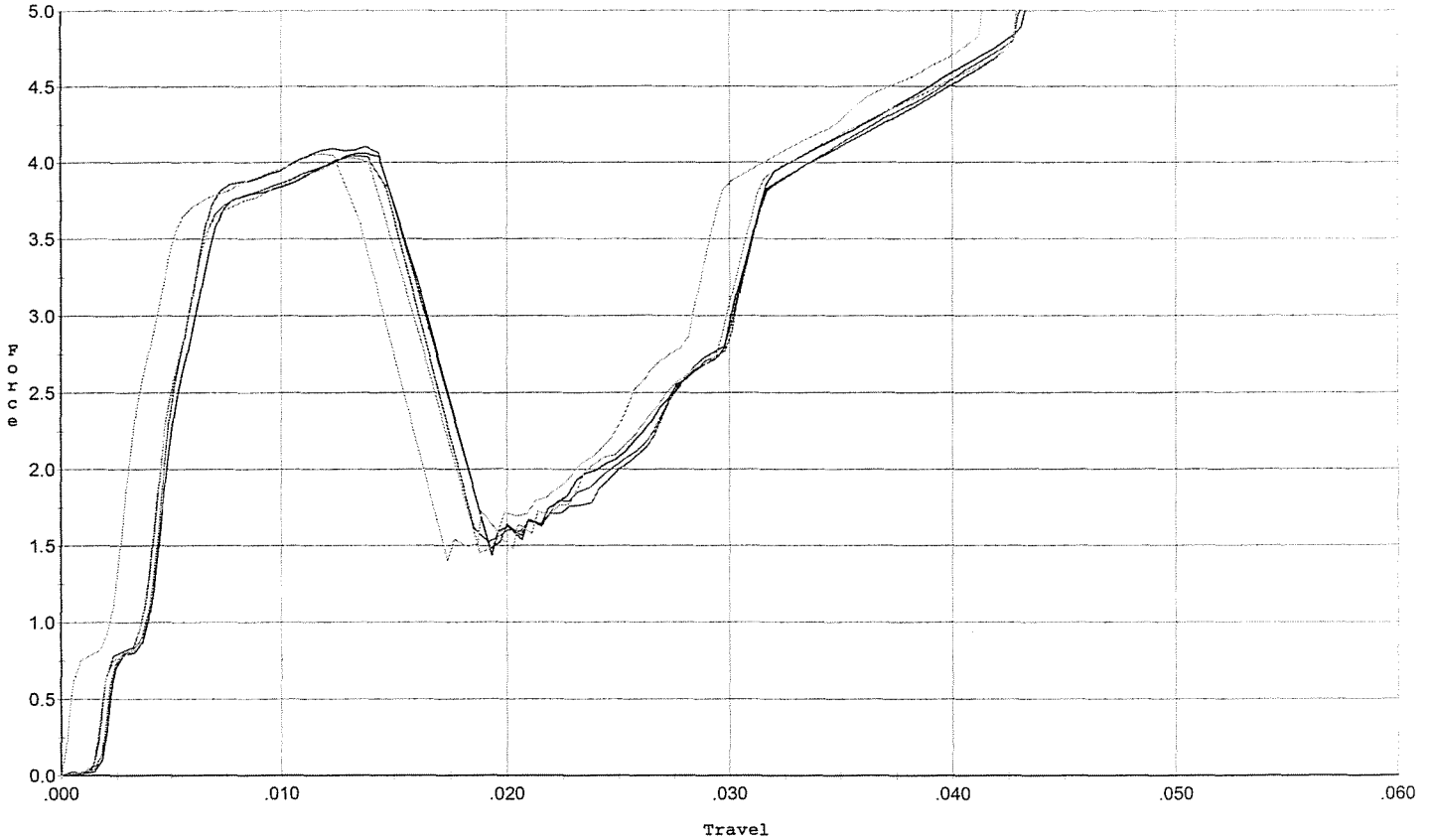
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.015	0.00	0.028	0.037		Set Trigger
2	4.149	0.017	0.00	0.028	0.042		Set Trigger
3	4.054	0.017	0.00	0.028	0.041		Set Trigger
4	4.050	0.013	0.00	0.028	0.036		Set Trigger
5	4.025	0.015	0.002	0.028	0.036		Set Trigger

A. 4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



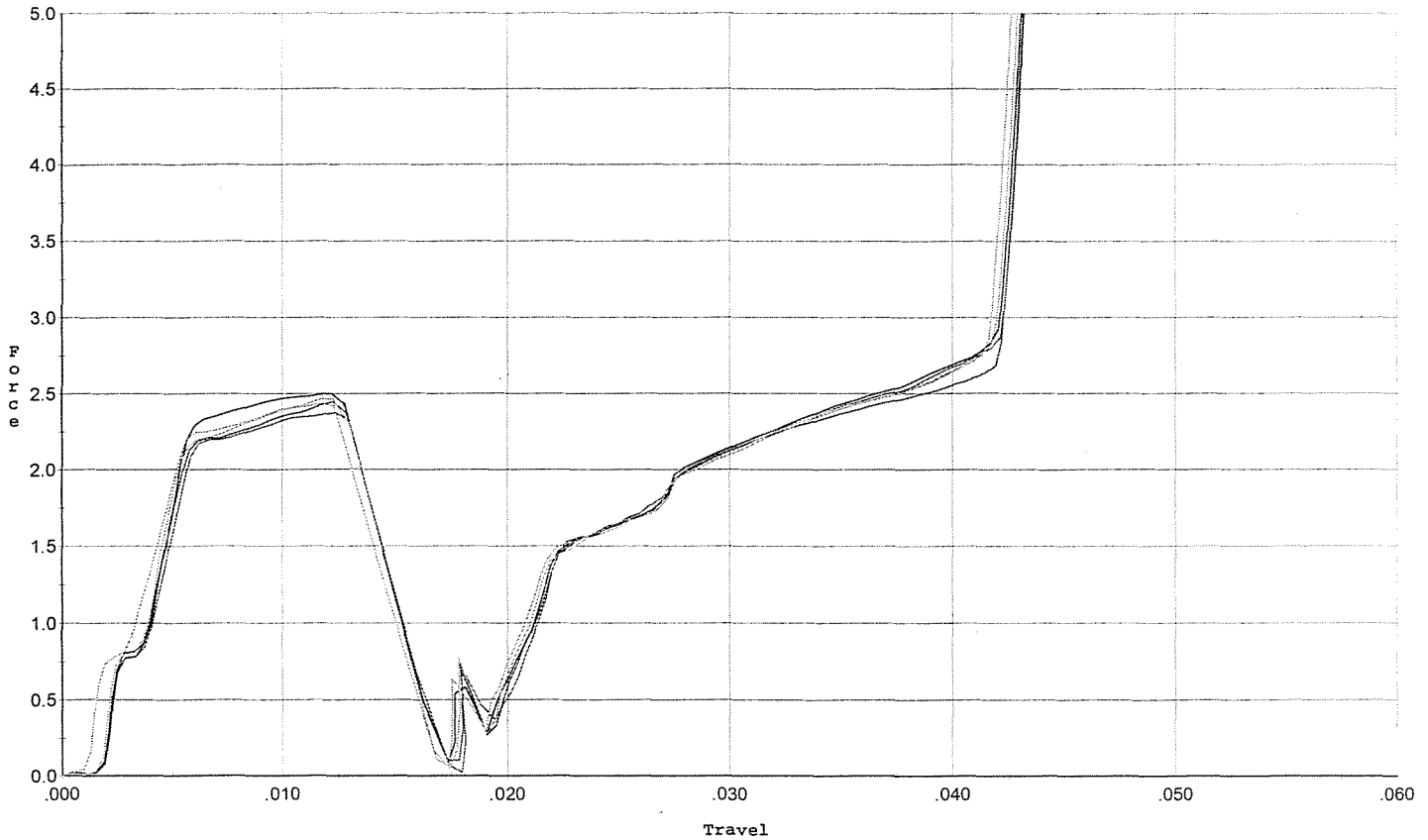
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.103	0.017	0.00	0.028	0.043		Set Trigger
2	4.056	0.016	0.00	0.028	0.041		Set Trigger
3	4.042	0.015	0.00	0.028	0.037		Set Trigger
4	4.056	0.014	0.00	0.028	0.037		Set Trigger
5	4.027	0.016	0.00	0.028	0.041		Set Trigger

A. 4.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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	2.447	0.013	0.00	0.033	0.020		Set Trigger
2	2.503	0.013	0.00	0.033	0.021		Set Trigger
3	2.374	0.013	0.002	0.033	0.020		Set Trigger
4	2.466	0.013	0.00	0.033	0.021		Set Trigger
5	2.436	0.012	0.00	0.033	0.020		Set Trigger

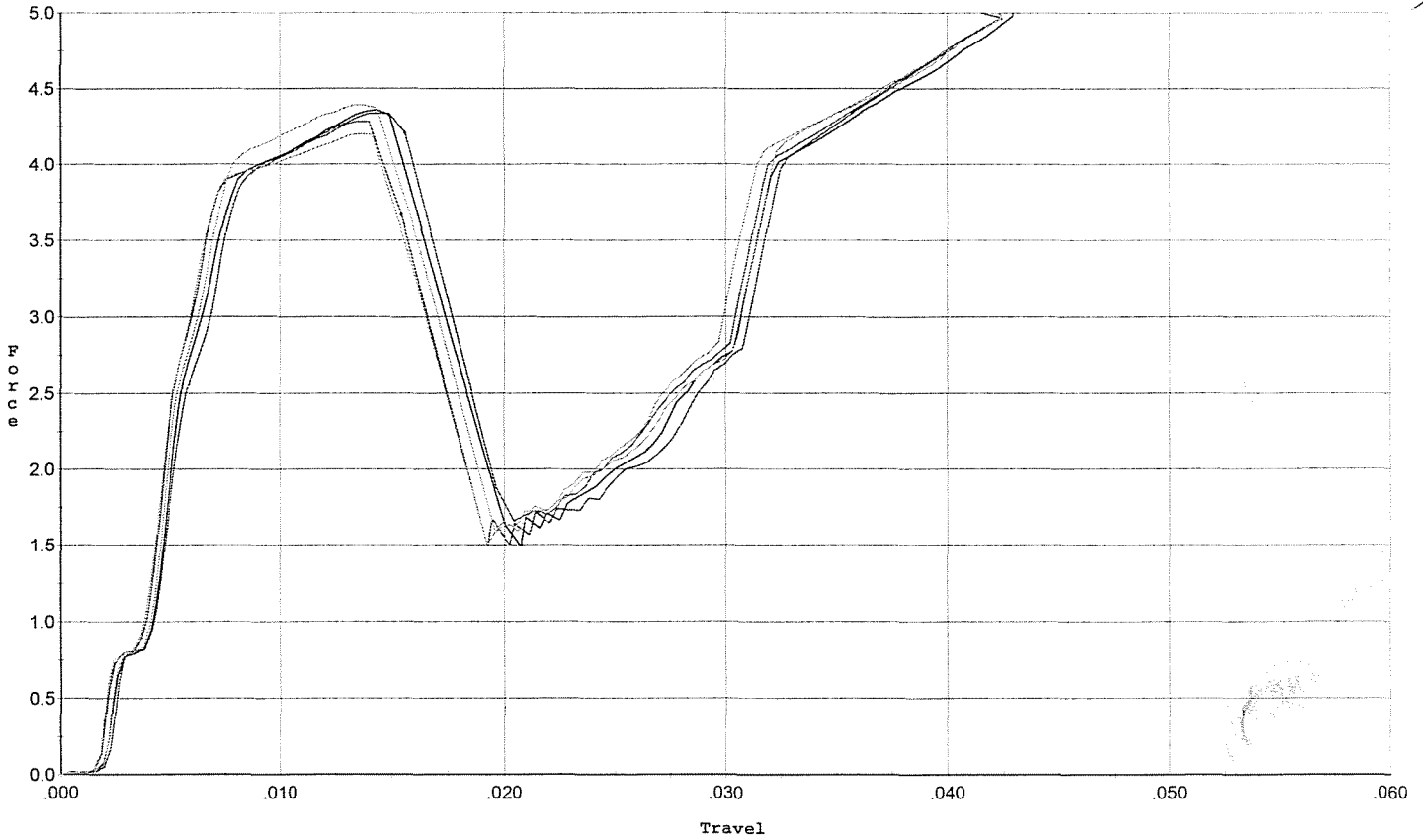
A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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

For target +
accuracy
(cmj)



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.337	0.016	0.00	0.028	0.041		Set Trigger
2	4.358	0.015	0.002	0.028	0.039		Set Trigger
3	4.282	0.015	0.00	0.028	0.040		Set Trigger
4	4.390	0.016	0.002	0.028	0.043		Set Trigger
5	4.199	0.016	0.00	0.028	0.042		Set Trigger

A. 4.31