

8946 0894

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



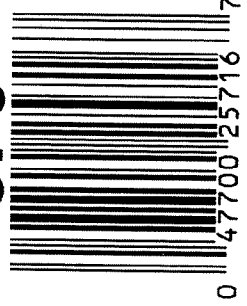
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807768

UPC



GUN SERIAL #

66807768
~~66794478~~ RP

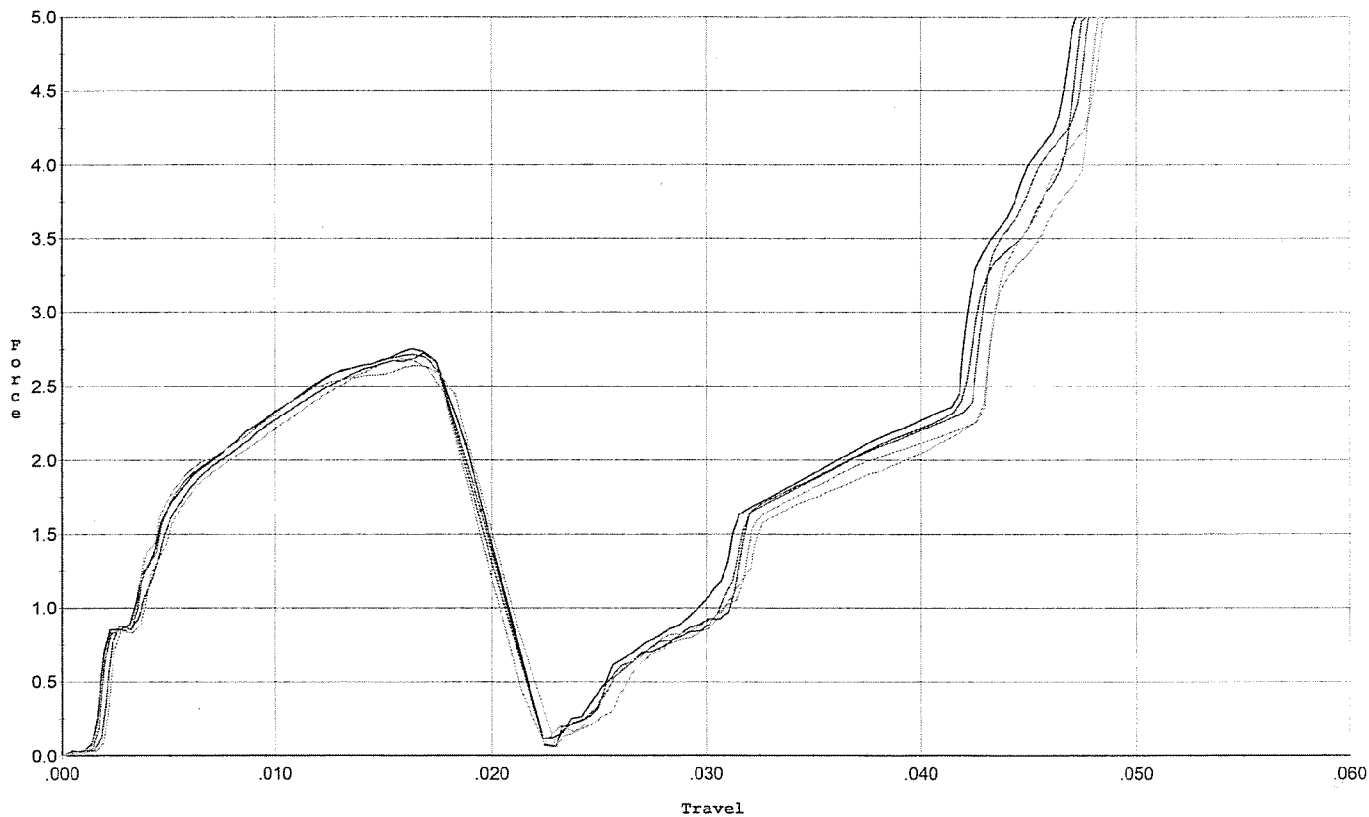
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAG VA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	3/5/09	(H)
490	MAGNAFLUX BOLT		3/5/09	RP
500	ROLLMARK CALIBER		3/5/09	RP
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	RP
540	APPLY COATINGS (BARREL ACTION)		3/11	RP
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		3-16-09	RP
	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>4.5</u> <u>5</u> <u>5</u>	3-20-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.022</u>	3-20-09	WV
	J) ASSEMBLE STOCK		3-16-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	WV
	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	PASS FAIL PASS FAIL	3-18-09	RP
	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	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.82</u> <u>2.80</u> <u>2.79</u> <u>2.82</u> <u>2.83</u>	3-19-09	TL
	C) FUNCTION		3-20-09	WV
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



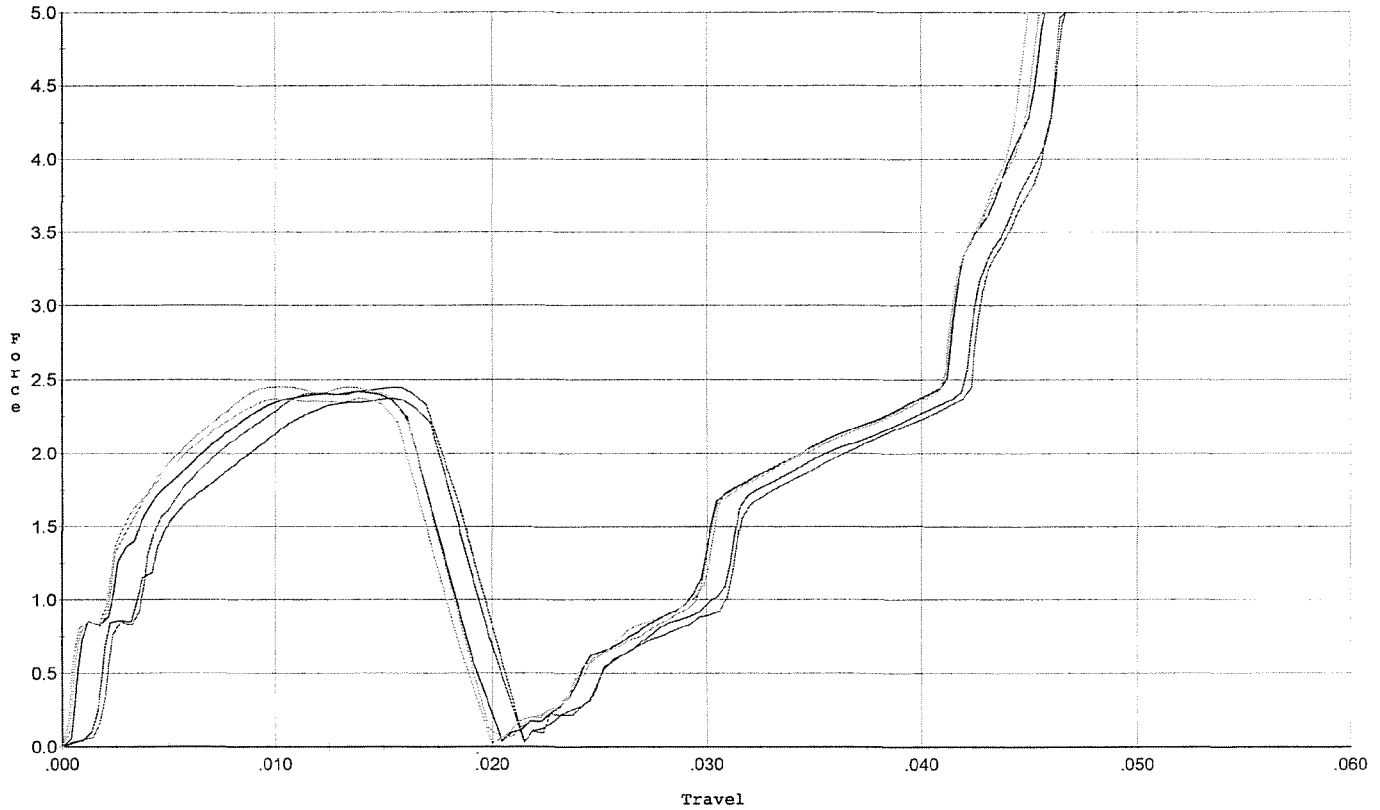
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.725	0.019	0.00	0.033	0.035		Set Trigger
2	2.754	0.019	0.00	0.032	0.035		Set Trigger
3	2.716	0.018	0.00	0.034	0.032		Set Trigger
4	2.639	0.018	0.00	0.034	0.032		Set Trigger
5	2.685	0.018	0.00	0.034	0.032		Set Trigger

A-2-70

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



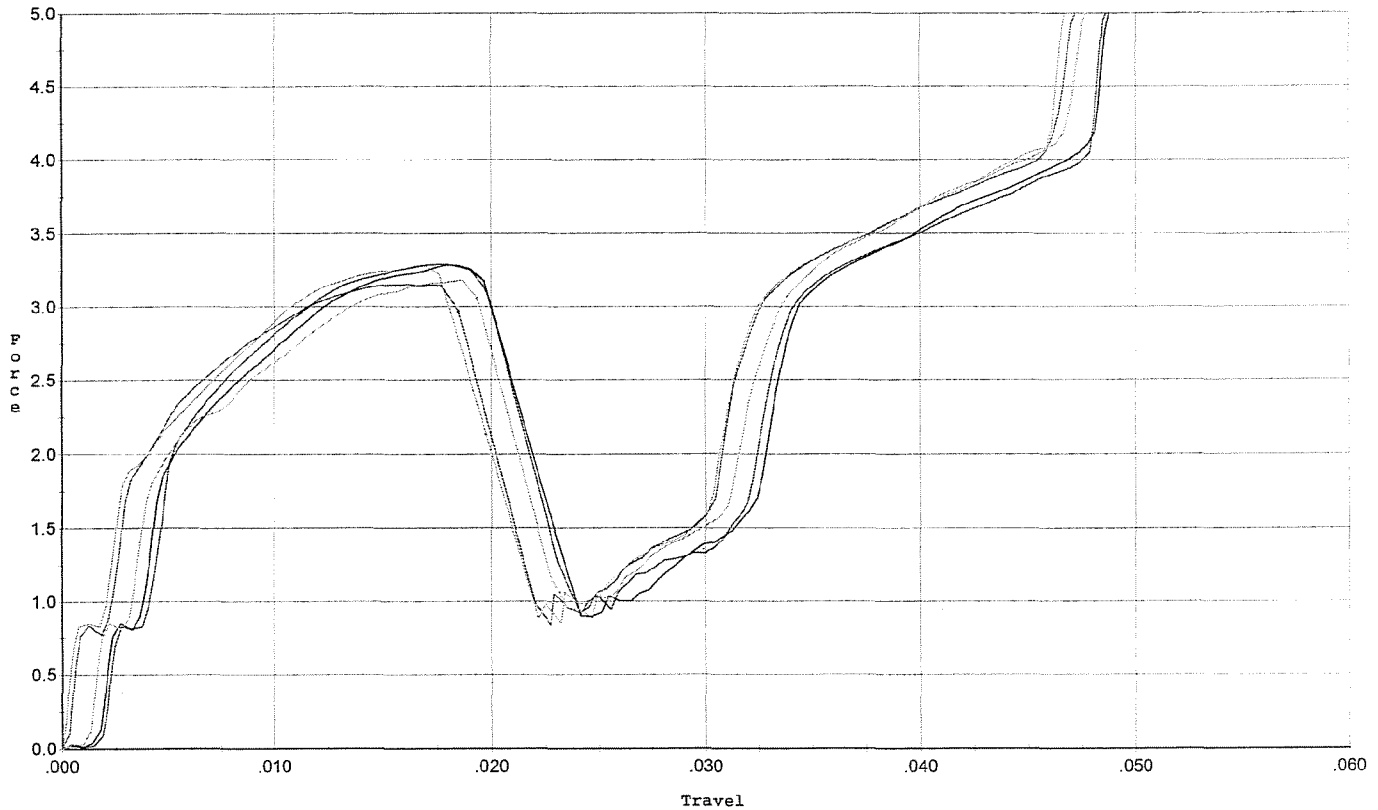
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.377	0.017	0.00	0.034	0.028		Set Trigger
2	2.420	0.016	0.00	0.034	0.029		Set Trigger
3	2.446	0.019	0.00	0.033	0.031		Set Trigger
4	2.380	0.016	0.00	0.033	0.028		Set Trigger
5	2.453	0.016	0.00	0.033	0.030		Set Trigger

A-2-41

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 lbs ini +/- .75 lb



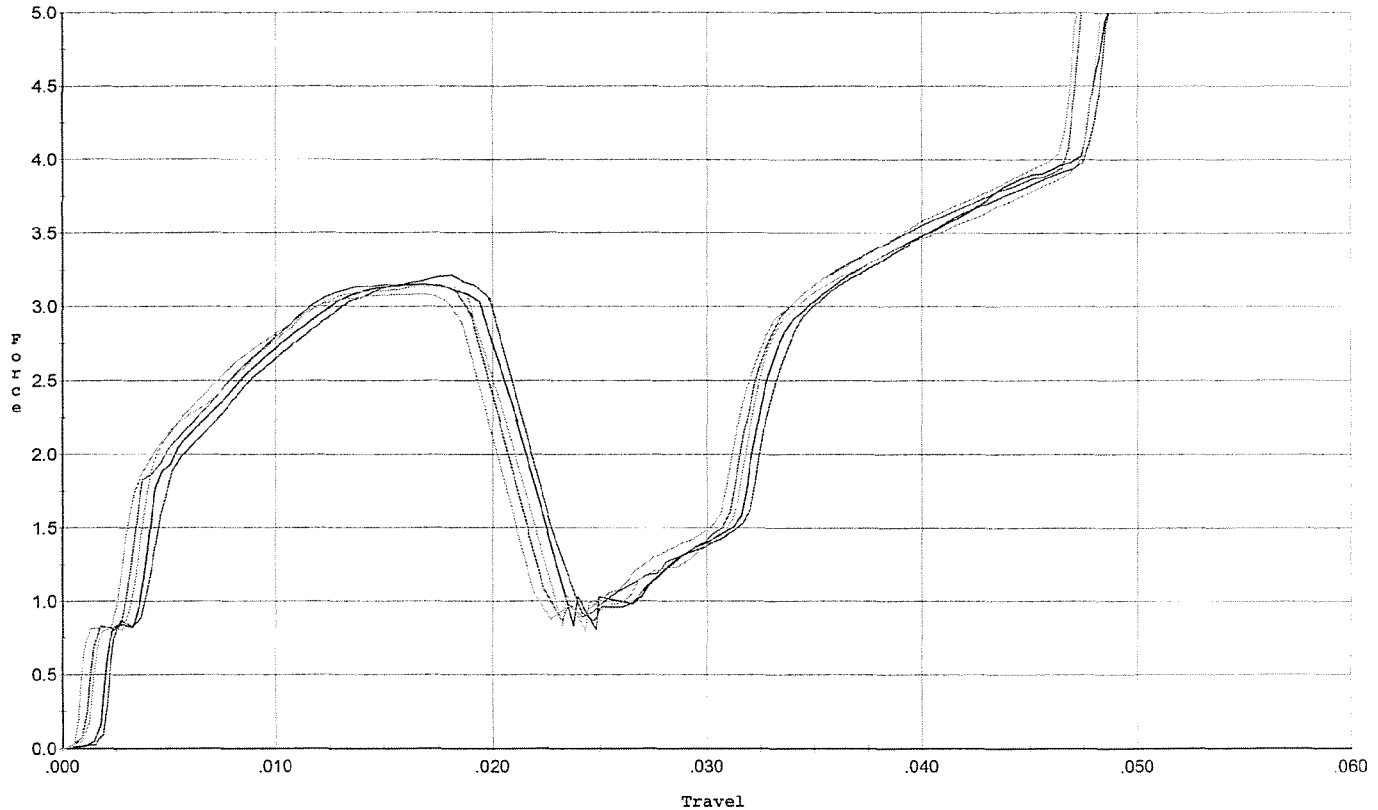
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.290	0.020	0.00	0.032	0.044		Set Trigger
2	3.288	0.020	0.00	0.032	0.043		Set Trigger
3	3.154	0.018	0.00	0.031	0.042		Set Trigger
4	3.181	0.019	0.00	0.031	0.042		Set Trigger
5	3.282	0.020	0.00	0.031	0.046		Set Trigger

A-3.23

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 lbs after 20 cycles +/- .75 lb



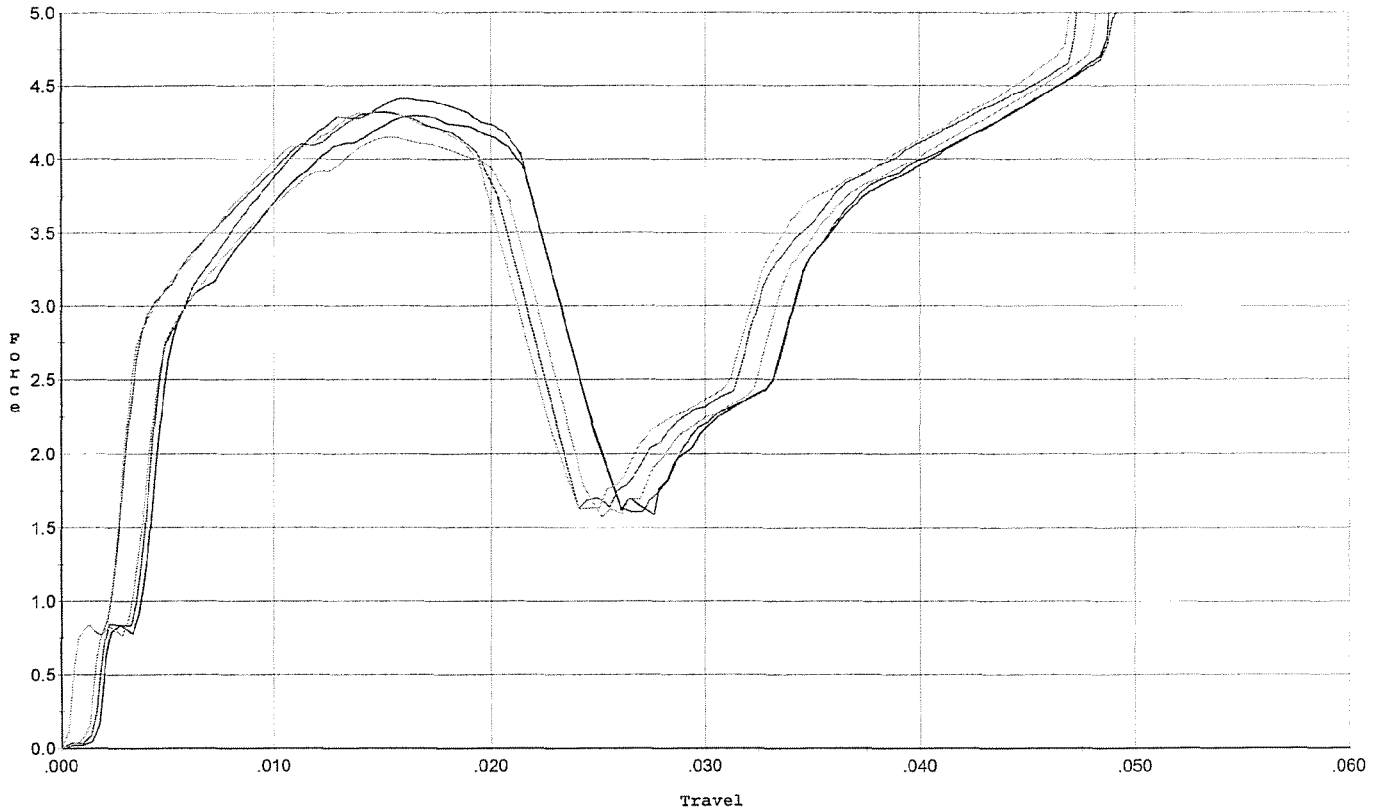
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.212	0.020	0.00	0.032	0.042		Set Trigger
2	3.151	0.021	0.00	0.032	0.046		Set Trigger
3	3.154	0.019	0.00	0.031	0.042		Set Trigger
4	3.136	0.021	0.00	0.032	0.046		Set Trigger
5	3.086	0.019	0.003	0.031	0.042		Set Trigger

A-3.14

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 lb ini +/- 1.0 lb



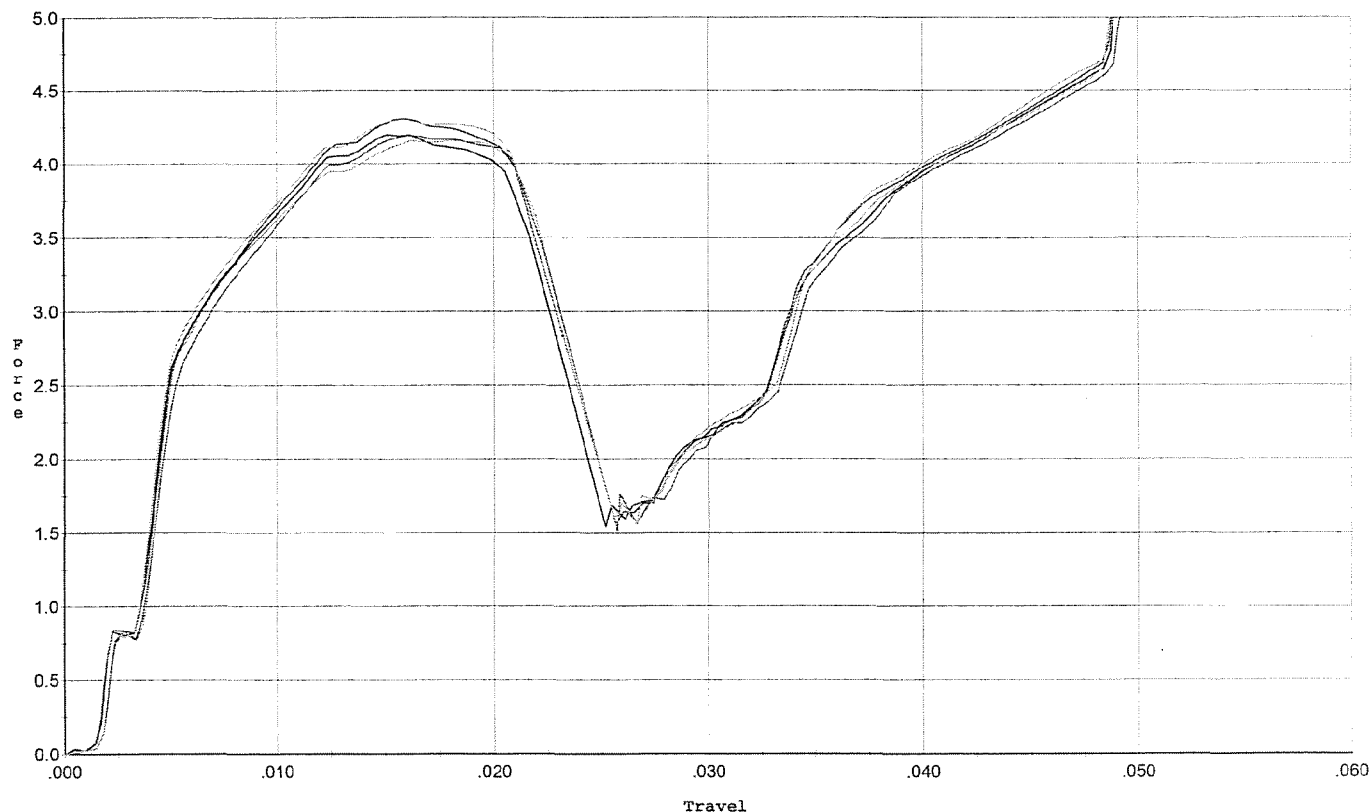
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.412	0.021	0.003	0.029	0.065		Set Trigger
2	4.296	0.022	0.00	0.028	0.063		Set Trigger
3	4.320	0.020	0.00	0.028	0.063		Set Trigger
4	4.326	0.019	0.00	0.028	0.060		Set Trigger
5	4.149	0.021	0.00	0.028	0.060		Set Trigger

A-4.30

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 lb after 20 cycles+/- 1.0 lb



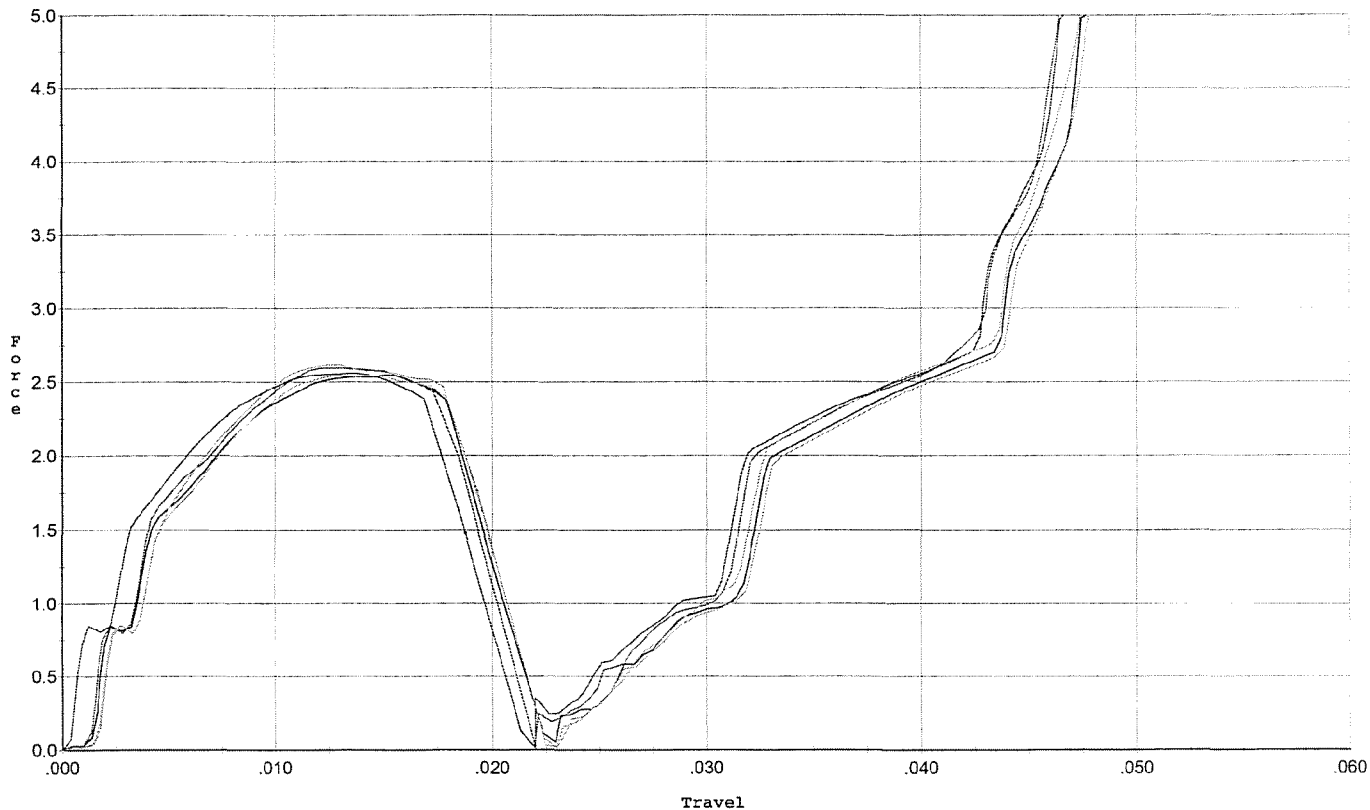
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.307	0.023	0.004	0.028	0.067		Set Trigger
2	4.197	0.022	0.00	0.028	0.062		Set Trigger
3	4.191	0.022	0.00	0.029	0.063		Set Trigger
4	4.303	0.023	0.00	0.028	0.068		Set Trigger
5	4.158	0.022	0.00	0.029	0.063		Set Trigger

A-4.23

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



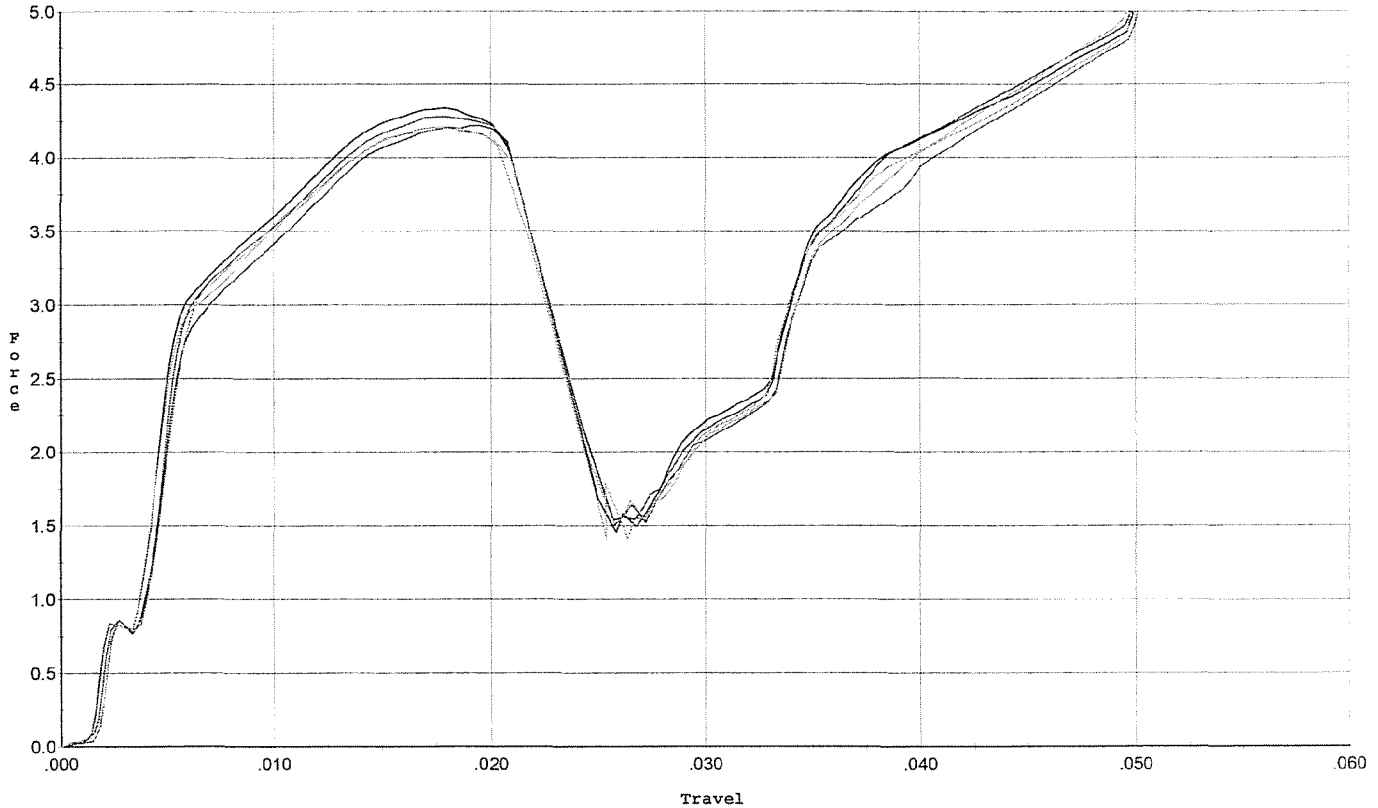
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.559	0.019	0.00	0.032	0.035		Set Trigger
2	2.548	0.018	0.00	0.033	0.032		Set Trigger
3	2.596	0.019	0.00	0.033	0.034		Set Trigger
4	2.542	0.019	0.00	0.033	0.034		Set Trigger
5	2.615	0.020	0.00	0.033	0.035		Set Trigger

A-2-57

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 +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.217	0.021	0.00	0.029	0.058		Set Trigger
2	4.336	0.021	0.004	0.030	0.060		Set Trigger
3	4.275	0.021	0.00	0.030	0.059		Set Trigger
4	4.209	0.022	0.004	0.029	0.061		Set Trigger
5	4.199	0.021	0.00	0.029	0.059		Set Trigger

A-4.24