

66794628

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



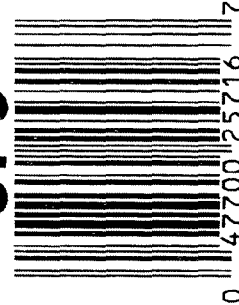
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794628

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794628

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD.
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD.
460	CHECK HEADSPACE		9-30-08	SPD.
470	DIS-ASSEMBLE ACTION		9-30-08	SPD.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-1-08	PSN
475	DRILL AND TAP SIGHT HOLES	2008	10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (KB)	10/7/08	(KB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DO
542	APPLY COATINGS (BARREL ACTION)		10-5	
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	PSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

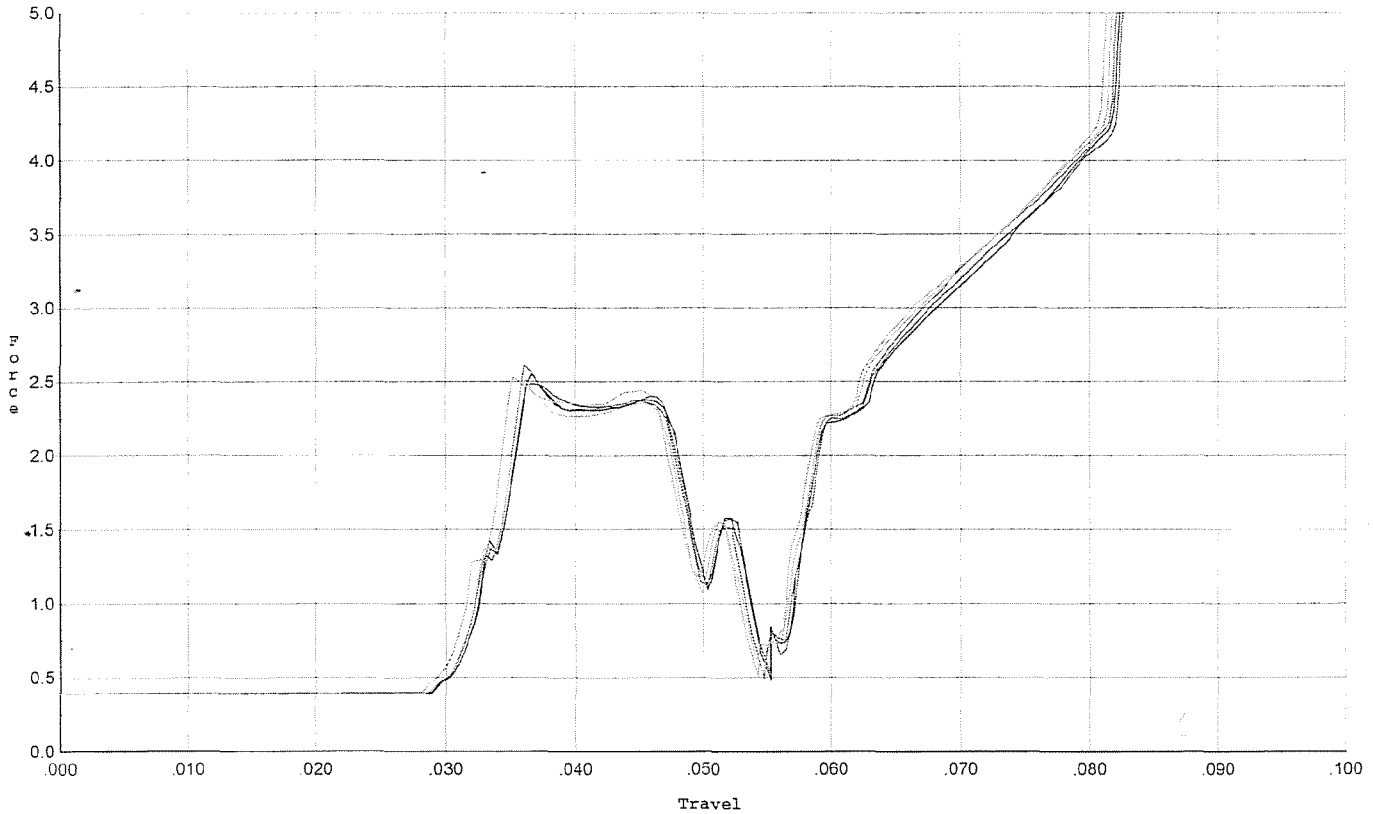
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>39</u> <u>39</u> <u>35</u>	11-11-08	R D
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>50</u>	11-11-08	R D
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-11-08	R D
	J) ASSEMBLE STOCK		10-29-08	Rsw
	K) ASSEMBLE SWIVEL STUDS		11-11-08	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> FAIL <u>PASS</u> FAIL	10-30-08	Rsw
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-11-08	R D
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.31</u> <u>2.29</u> <u>2.33</u> <u>2.37</u>	11/5/08	Fm
	C) FUNCTION		11-11-08	R D
690	PACK		11/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



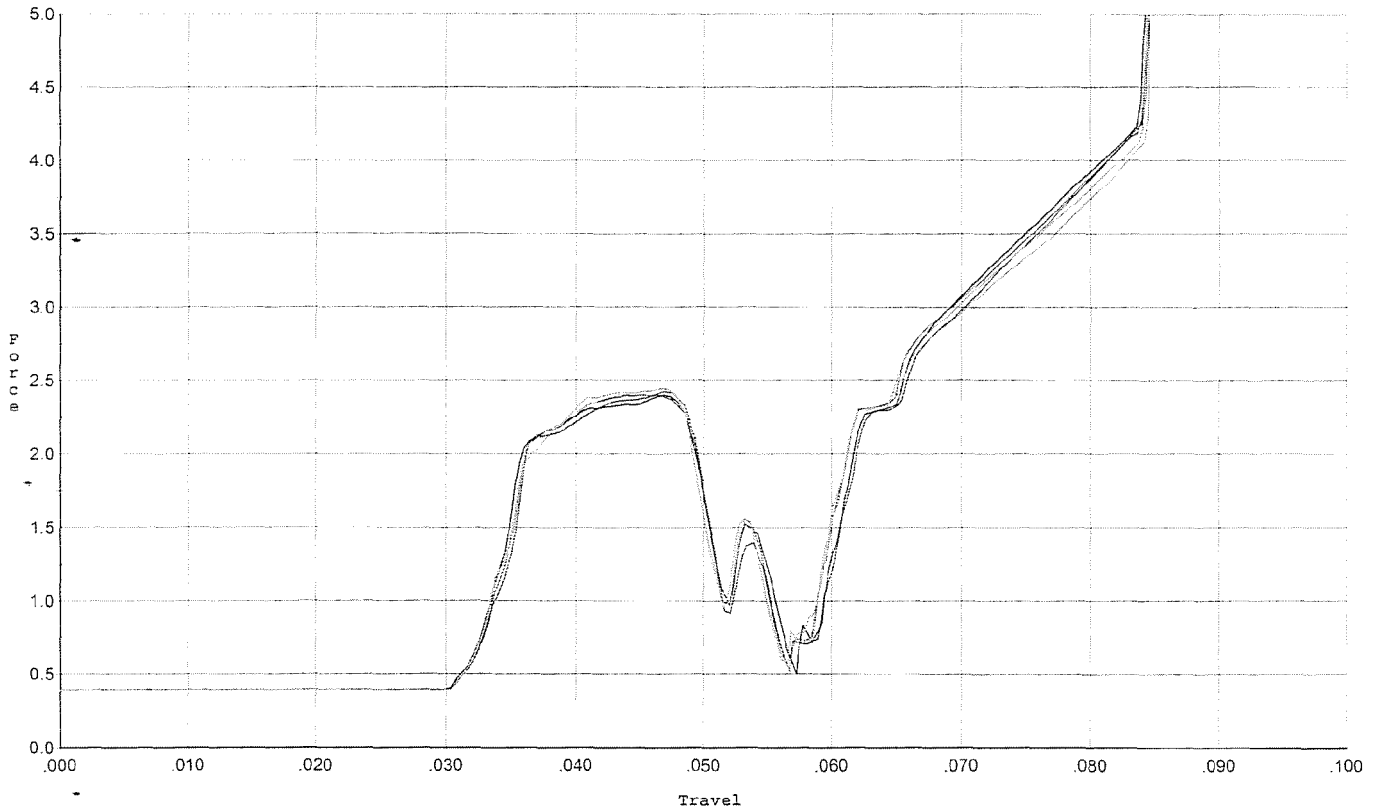
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.486	0.053	0.031	0.035	0.054		Set Trigger
2	2.553	0.048	0.031	0.037	0.048		Set Trigger
3	2.614	0.052	0.031	0.034	0.053		Set Trigger
4	2.507	0.047	0.031	0.037	0.047		Set Trigger
5	2.528	0.052	0.030	0.034	0.054		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



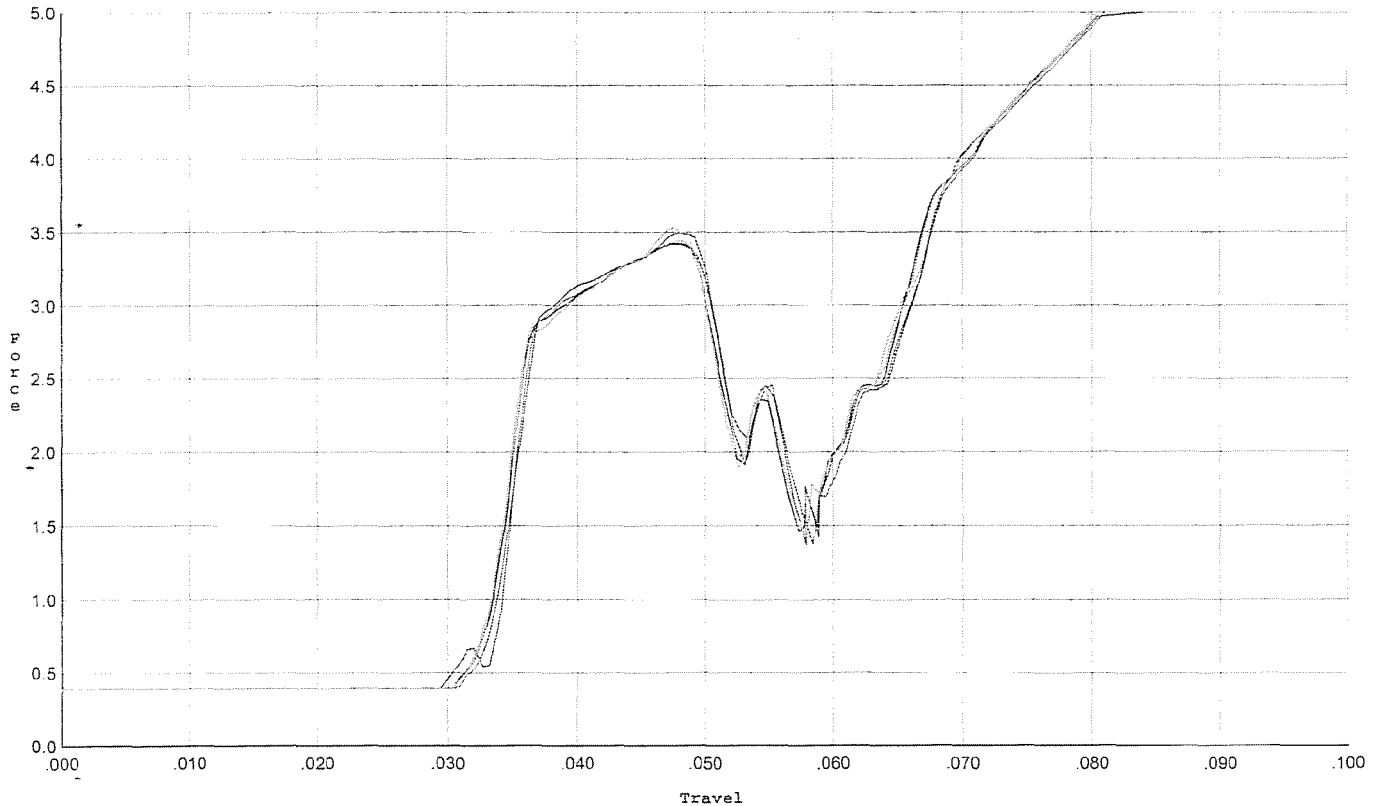
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.399	0.049	0.032	0.039	0.048		Set Trigger
2	2.400	0.050	0.031	0.038	0.049		Set Trigger
3	2.423	0.049	0.032	0.038	0.049		Set Trigger
4	2.445	0.049	0.031	0.039	0.048		Set Trigger
5	2.451	0.049	0.031	0.039	0.048		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



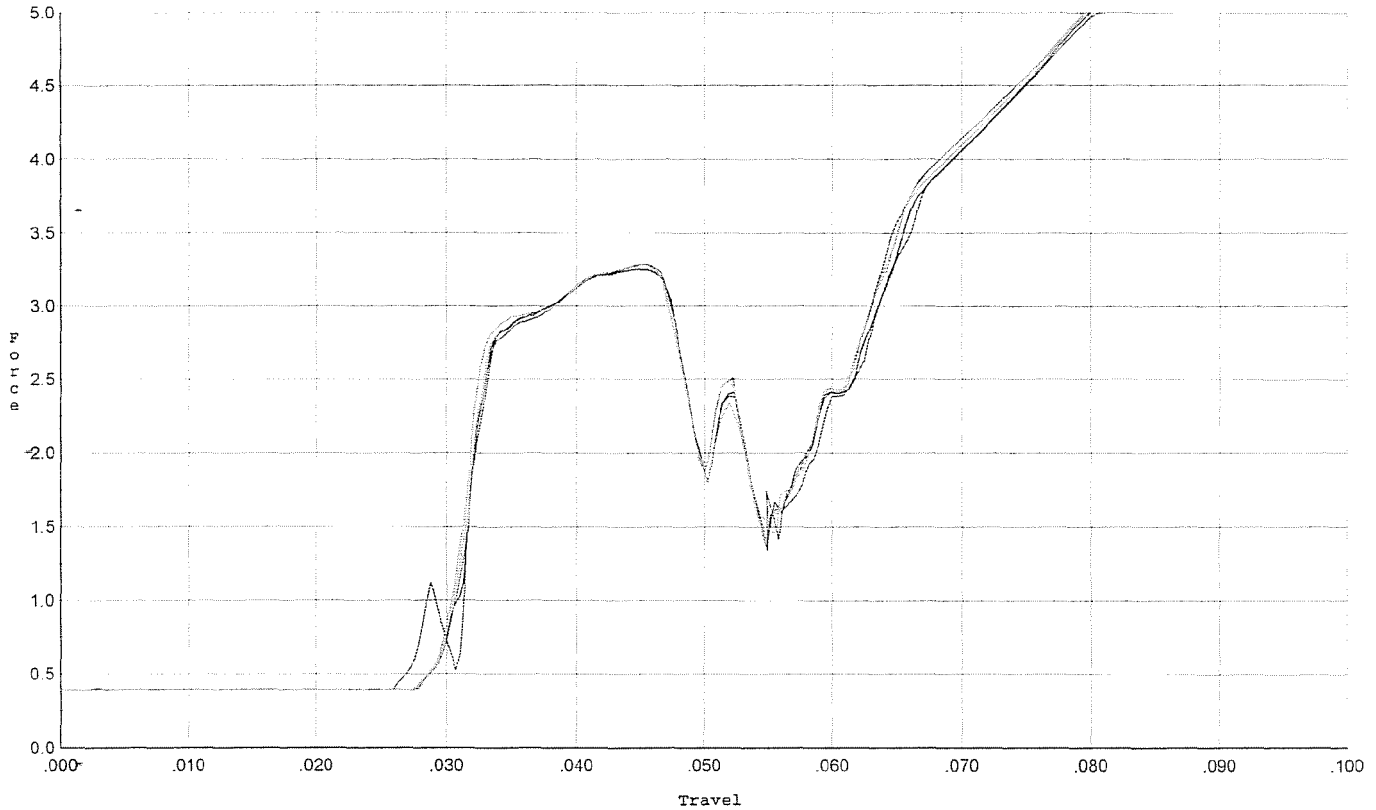
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.425	0.050	0.031	0.036	0.065		Set Trigger
2	3.422	0.049	0.031	0.036	0.064		Set Trigger
3	3.487	0.050	0.031	0.036	0.065		Set Trigger
4	3.531	0.049	0.032	0.036	0.064		Set Trigger
5	3.443	0.050	0.031	0.036	0.064		Set Trigger

A-3-46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



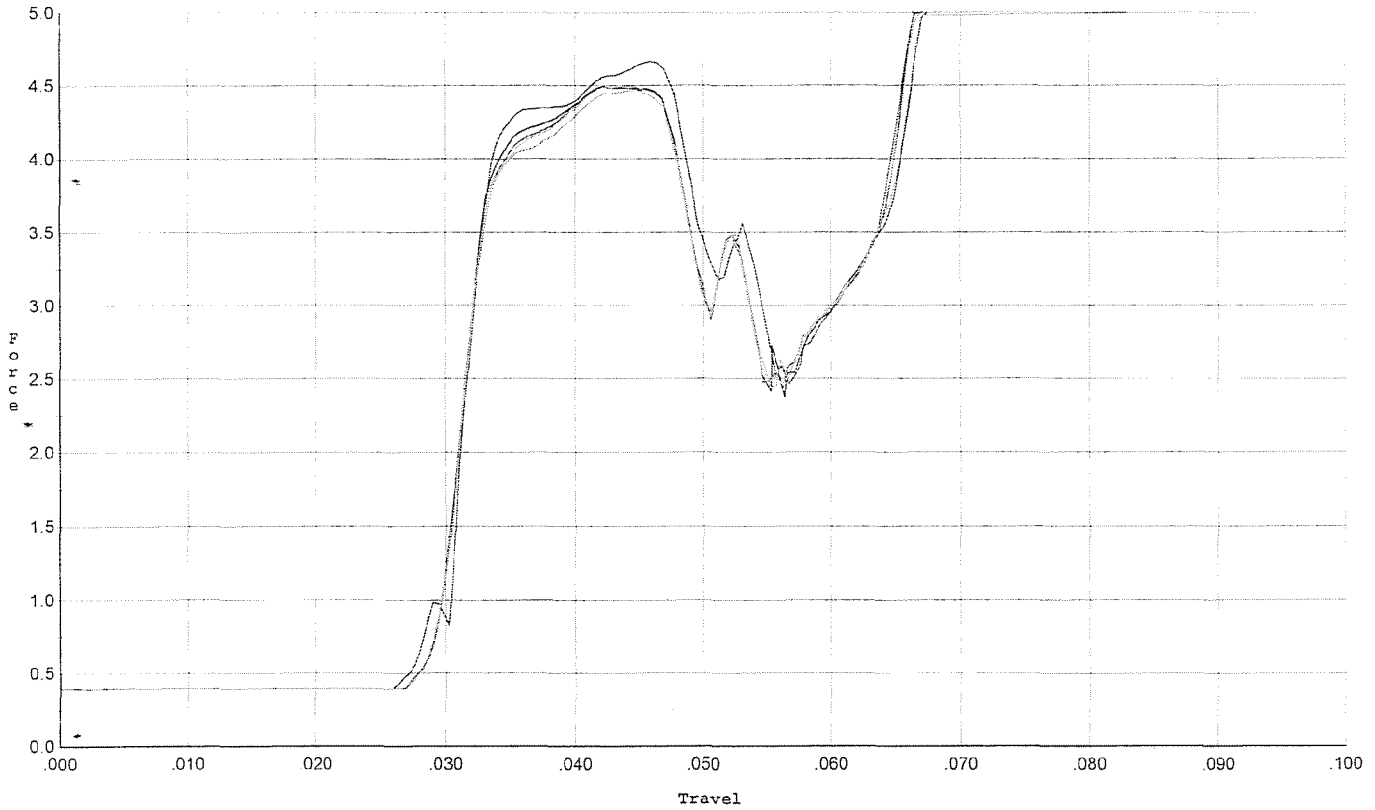
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.253	0.047	0.028	0.035	0.063		Set Trigger
2	3.289	0.047	0.030	0.035	0.063		Set Trigger
3	3.283	0.052	0.028	0.032	0.072		Set Trigger
4	3.286	0.052	0.028	0.032	0.073		Set Trigger
5	3.291	0.048	0.029	0.035	0.064		Set Trigger

4.328

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



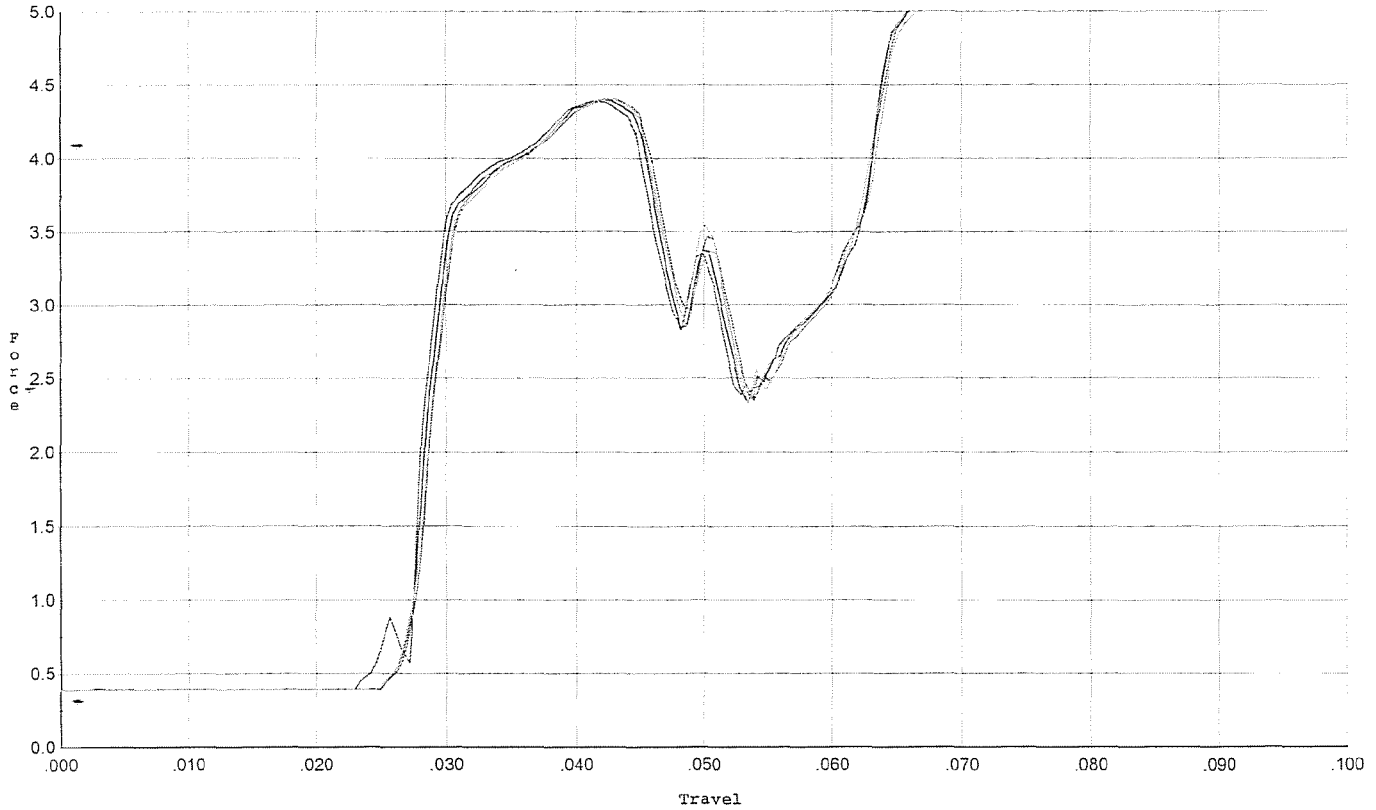
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.664	0.048	0.028	0.031	0.089		Set Trigger
2	4.494	0.053	0.029	0.028	0.101		Set Trigger
3	4.492	0.048	0.029	0.031	0.086		Set Trigger
4	4.495	0.053	0.029	0.028	0.100		Set Trigger
5	4.469	0.048	0.029	0.031	0.085		Set Trigger

A-452

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



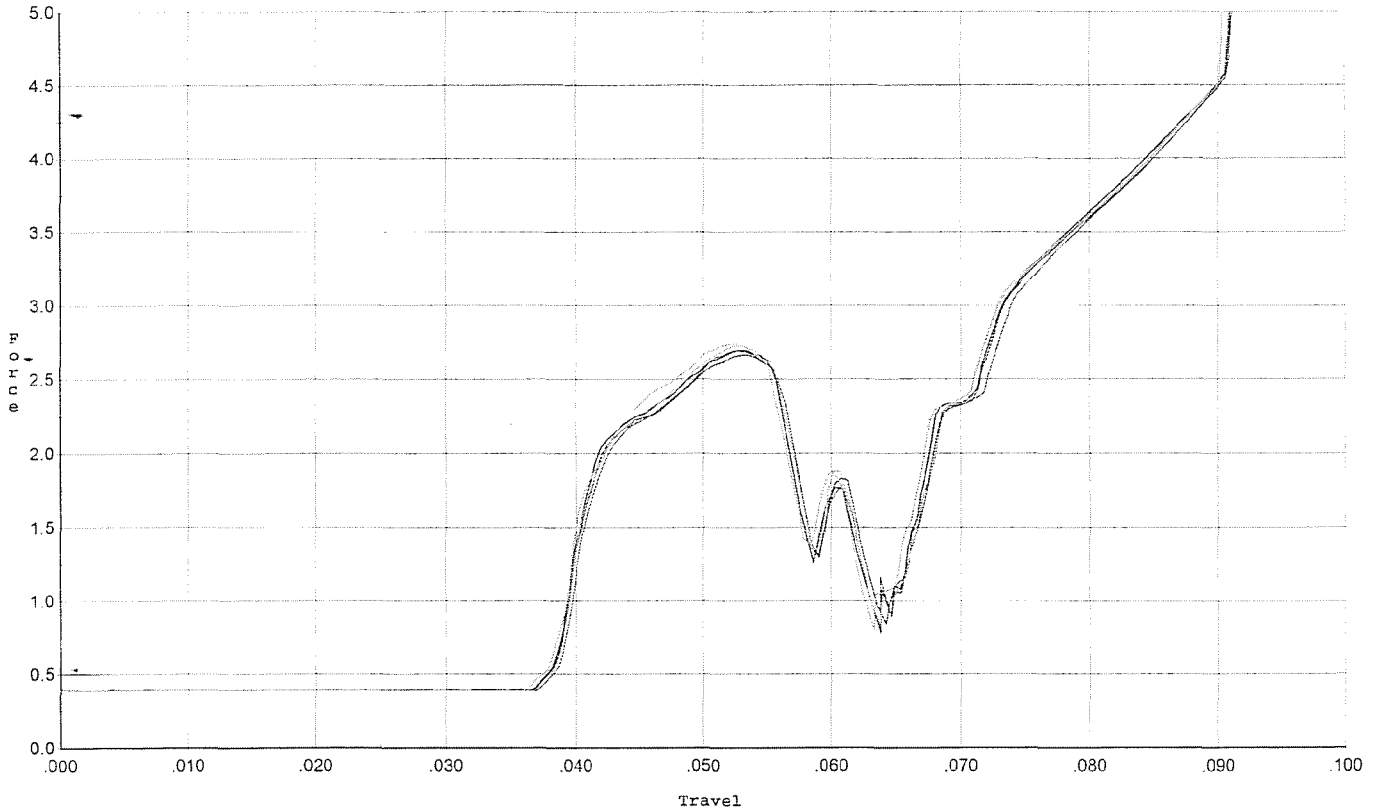
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.390	0.045	0.025	0.030	0.081		Set Trigger
2	4.399	0.045	0.027	0.030	0.082		Set Trigger
3	4.407	0.046	0.027	0.030	0.084		Set Trigger
4	4.402	0.051	0.027	0.028	0.098		Set Trigger
5	4.408	0.051	0.025	0.028	0.098		Set Trigger

A 4.40

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



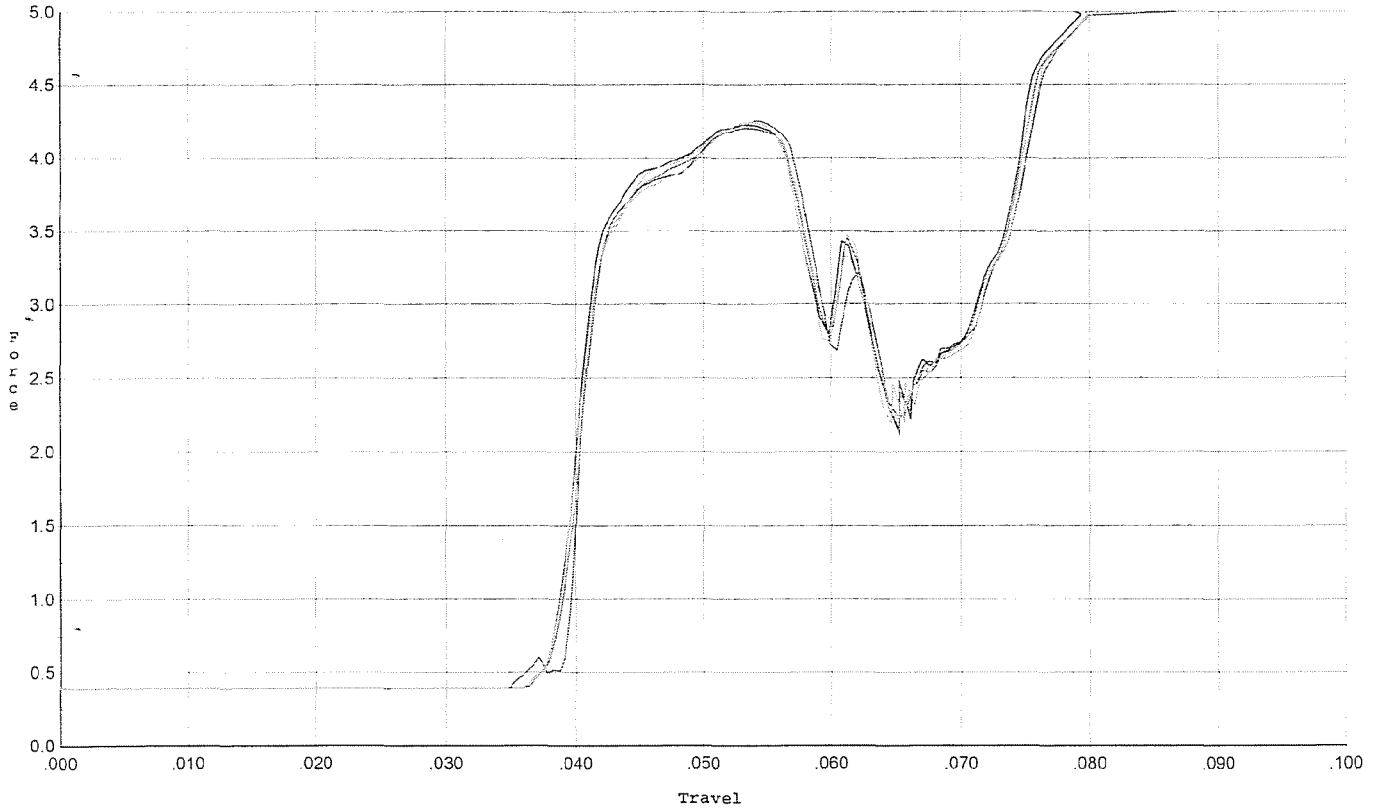
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.665	0.056	0.037	0.039	0.056		Set Trigger
2	2.694	0.056	0.039	0.039	0.055		Set Trigger
3	2.691	0.056	0.039	0.039	0.056		Set Trigger
4	2.728	0.057	0.039	0.039	0.057		Set Trigger
5	2.741	0.061	0.038	0.036	0.064		Set Trigger

A 2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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	4.250	0.058	0.039	0.036	0.088		Set Trigger
2	4.225	0.056	0.038	0.037	0.085		Set Trigger
3	4.201	0.062	0.038	0.032	0.099		Set Trigger
4	4.244	0.062	0.038	0.032	0.099		Set Trigger
5	4.236	0.057	0.038	0.036	0.086		Set Trigger

A-423