

95801894

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



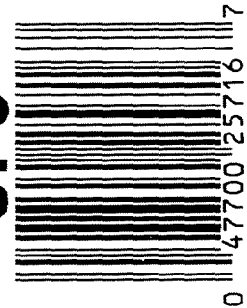
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6810336

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6810336

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RTZ
475	DRILL AND TAP SIGHT HOLES	MAR 10 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (11)	3/13/09	(10)
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

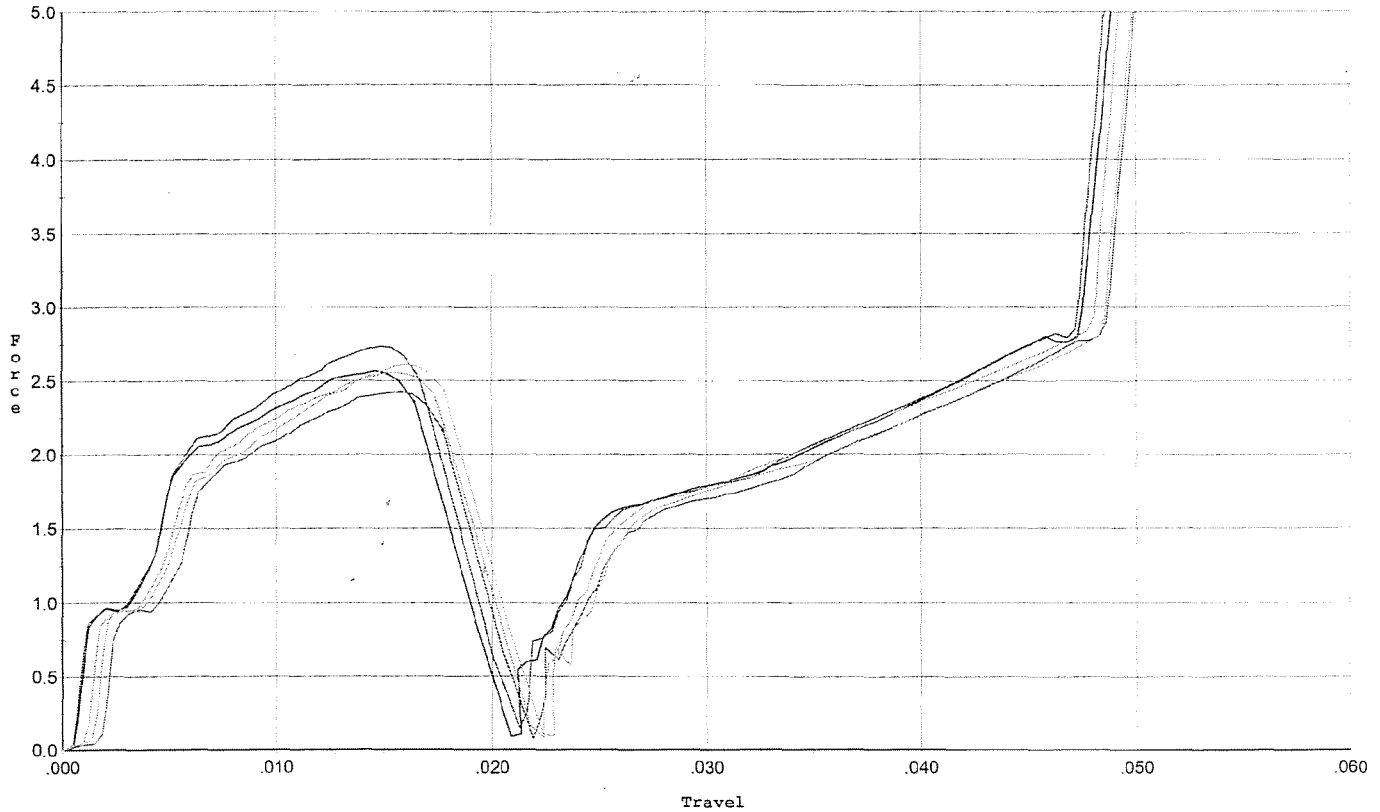
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	3-30-09	LN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	3-30-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.023</u>	3-30-09	LN
	J) ASSEMBLE STOCK		3-25-09	LN
	K) ASSEMBLE SWIVEL STUDS		3-30-09	LN
	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	3-27-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	LN
670	FINAL INSPECTION A) HEADSPACE		3-30-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.39</u> <u>2.45</u> <u>2.45</u> <u>2.42</u>	3-30-09	TC
	C) FUNCTION		3-30-09	LN
690	PACK		3/31/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



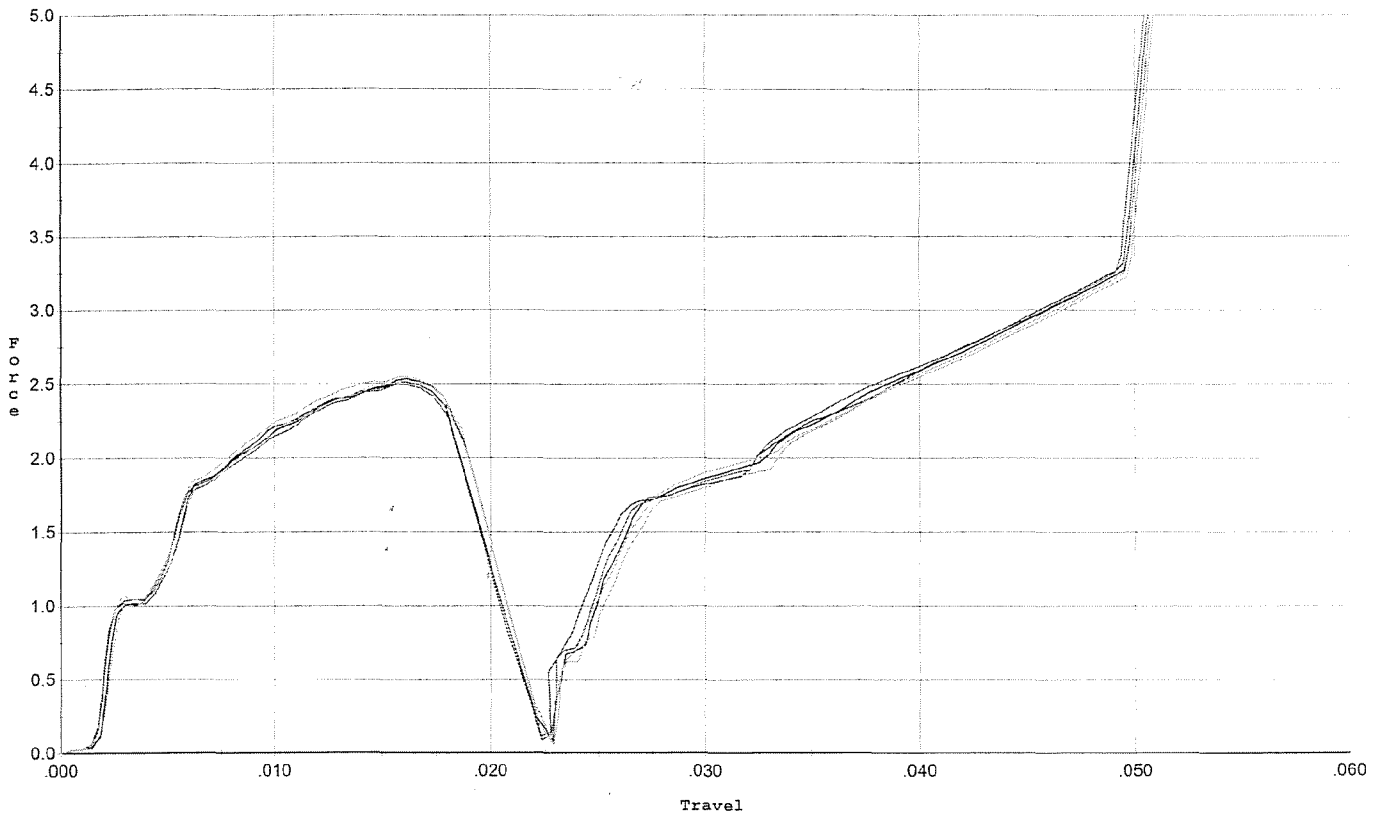
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.736	0.017	0.00	0.035	0.031		Set Trigger
2	2.565	0.016	0.00	0.035	0.029		Set Trigger
3	2.426	0.018	0.00	0.036	0.028		Set Trigger
4	2.611	0.018	0.00	0.035	0.031		Set Trigger
5	2.556	0.019	0.00	0.034	0.034		Set Trigger

A-257

Trigger Profile [lbs,inch]

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

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



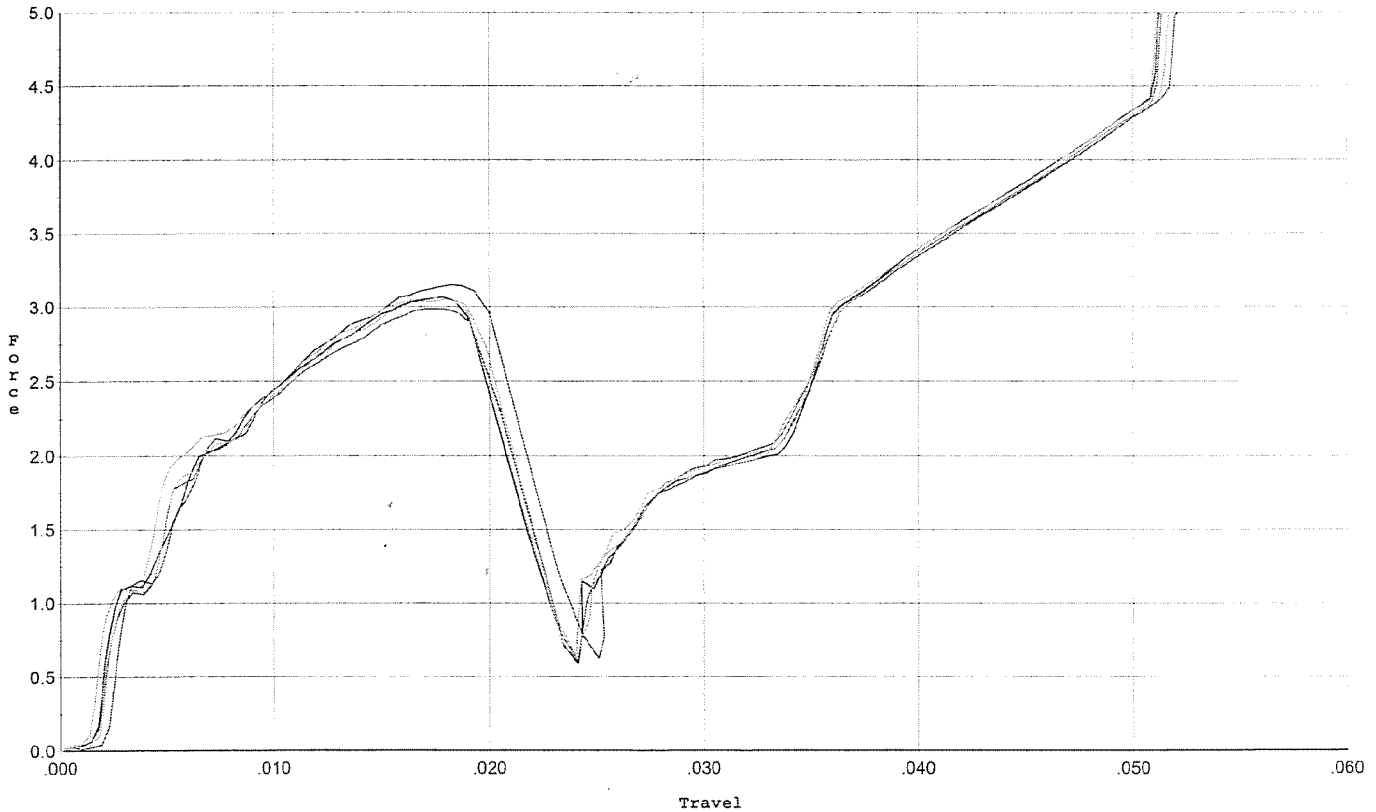
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.511	0.018	0.00	0.036	0.031		Set Trigger
2	2.536	0.019	0.00	0.035	0.032		Set Trigger
3	2.497	0.018	0.00	0.035	0.030		Set Trigger
4	2.553	0.019	0.00	0.035	0.033		Set Trigger
5	2.520	0.019	0.004	0.035	0.032		Set Trigger

A-2-52

Trigger Profile [lbs,inch]

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

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



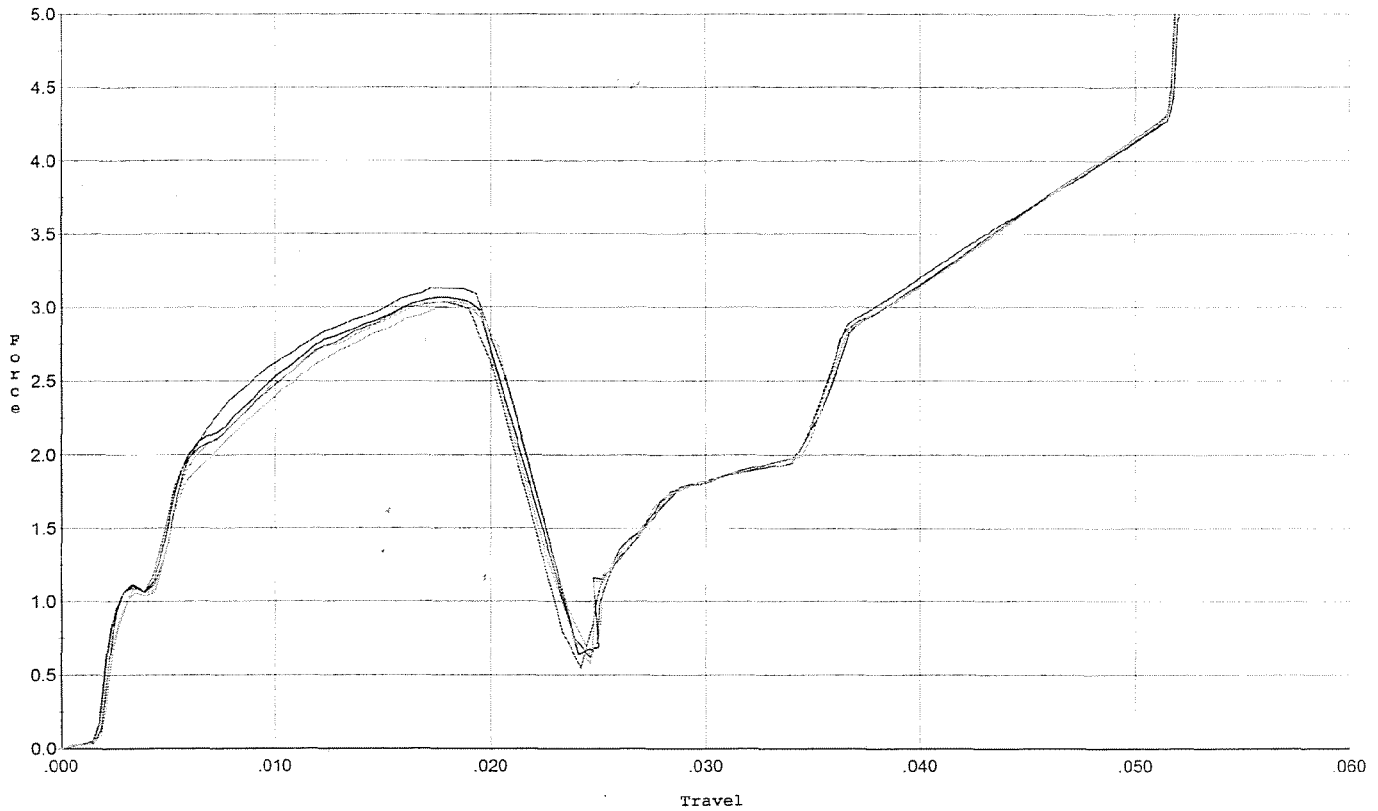
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.147	0.020	0.00	0.034	0.040		Set Trigger
2	3.066	0.019	0.00	0.034	0.038		Set Trigger
3	2.985	0.020	0.00	0.034	0.040		Set Trigger
4	3.049	0.020	0.00	0.034	0.040		Set Trigger
5	3.061	0.019	0.00	0.034	0.039		Set Trigger

A-3.06

Trigger Profile [lbs,inch]

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

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



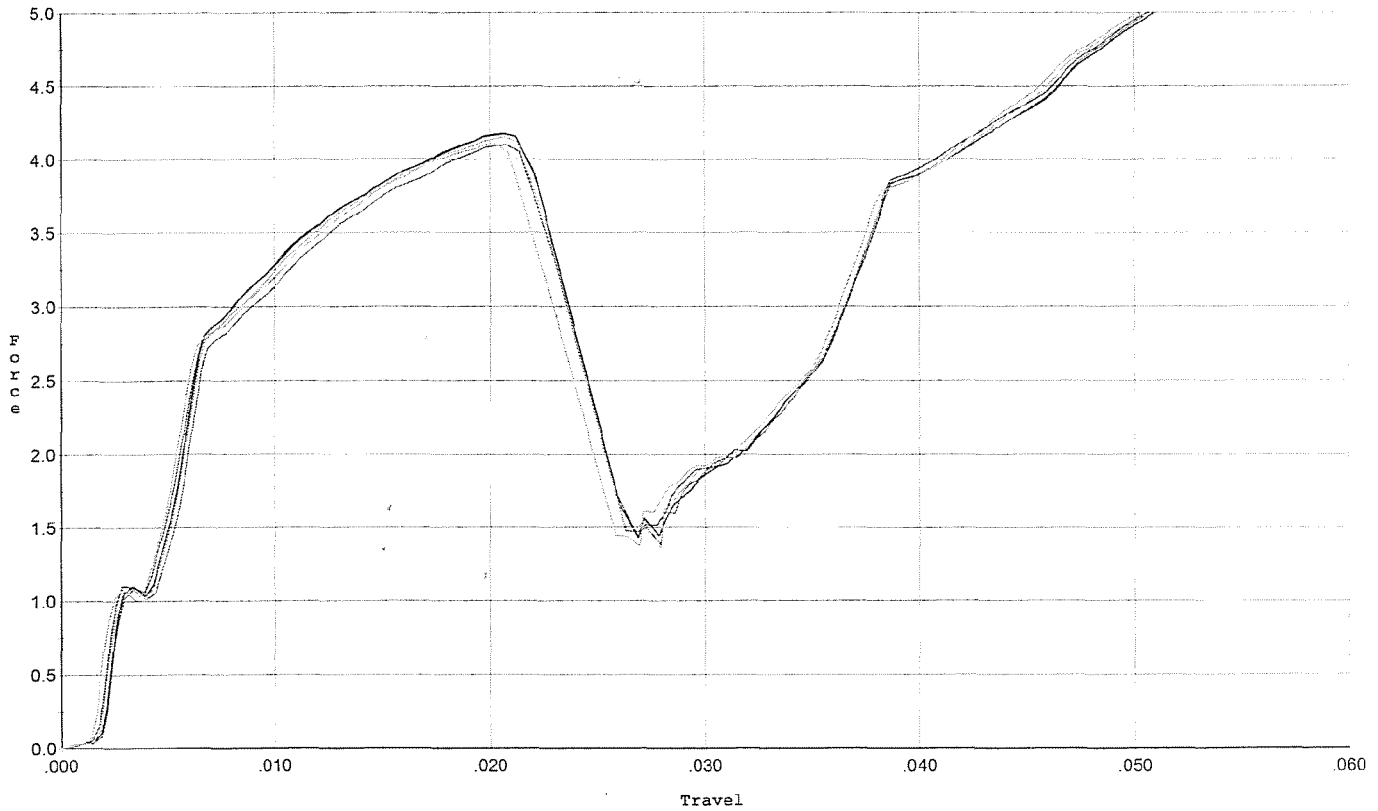
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.131	0.021	0.00	0.034	0.043		Set Trigger
2	3.069	0.022	0.00	0.034	0.044		Set Trigger
3	3.033	0.020	0.00	0.034	0.040		Set Trigger
4	3.042	0.020	0.00	0.035	0.039		Set Trigger
5	2.998	0.020	0.00	0.034	0.040		Set Trigger

A-3.05

Trigger Profile [lbs,inch]

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

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



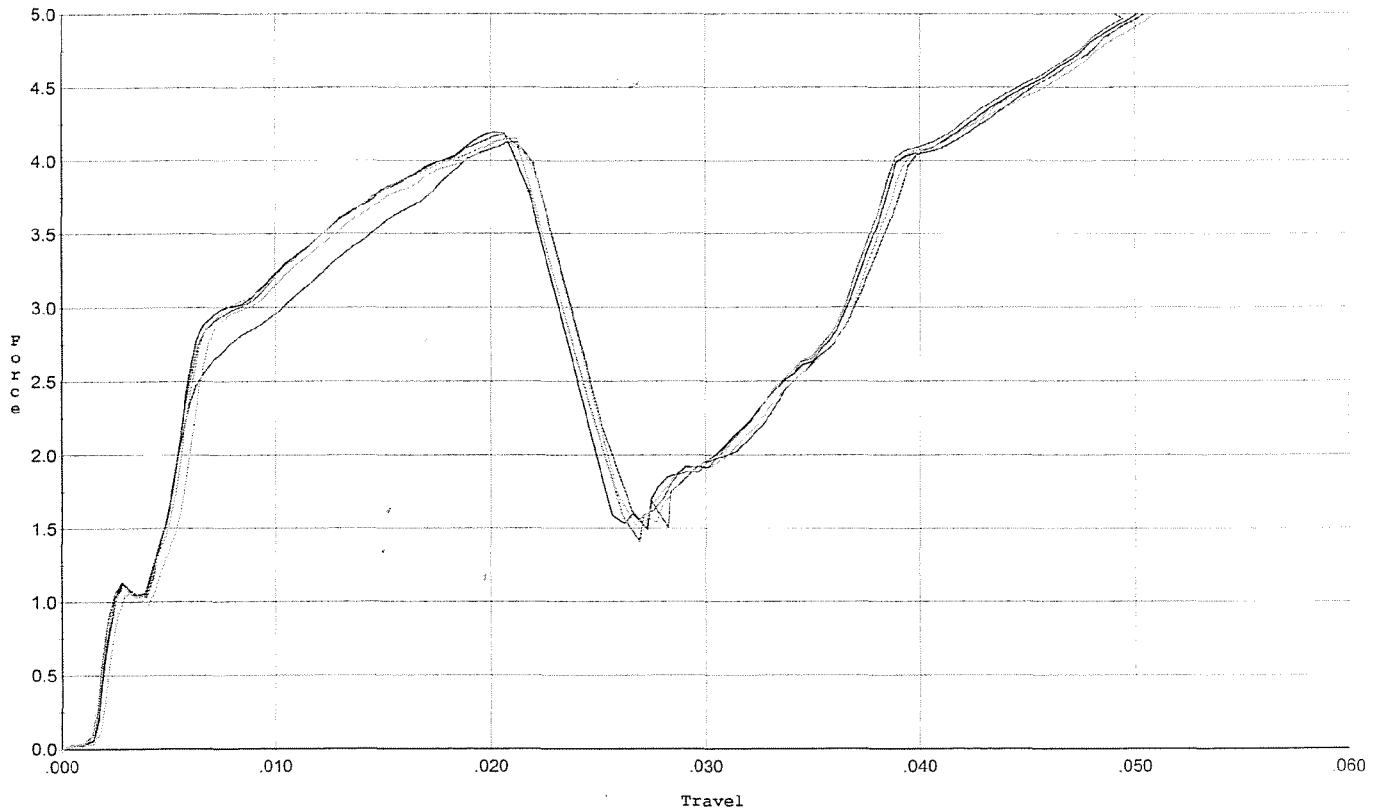
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.171	0.022	0.004	0.032	0.060		Set Trigger
2	4.174	0.022	0.00	0.032	0.060		Set Trigger
3	4.097	0.023	0.00	0.032	0.060		Set Trigger
4	4.155	0.023	0.00	0.031	0.060		Set Trigger
5	4.107	0.023	0.00	0.032	0.062		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

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

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



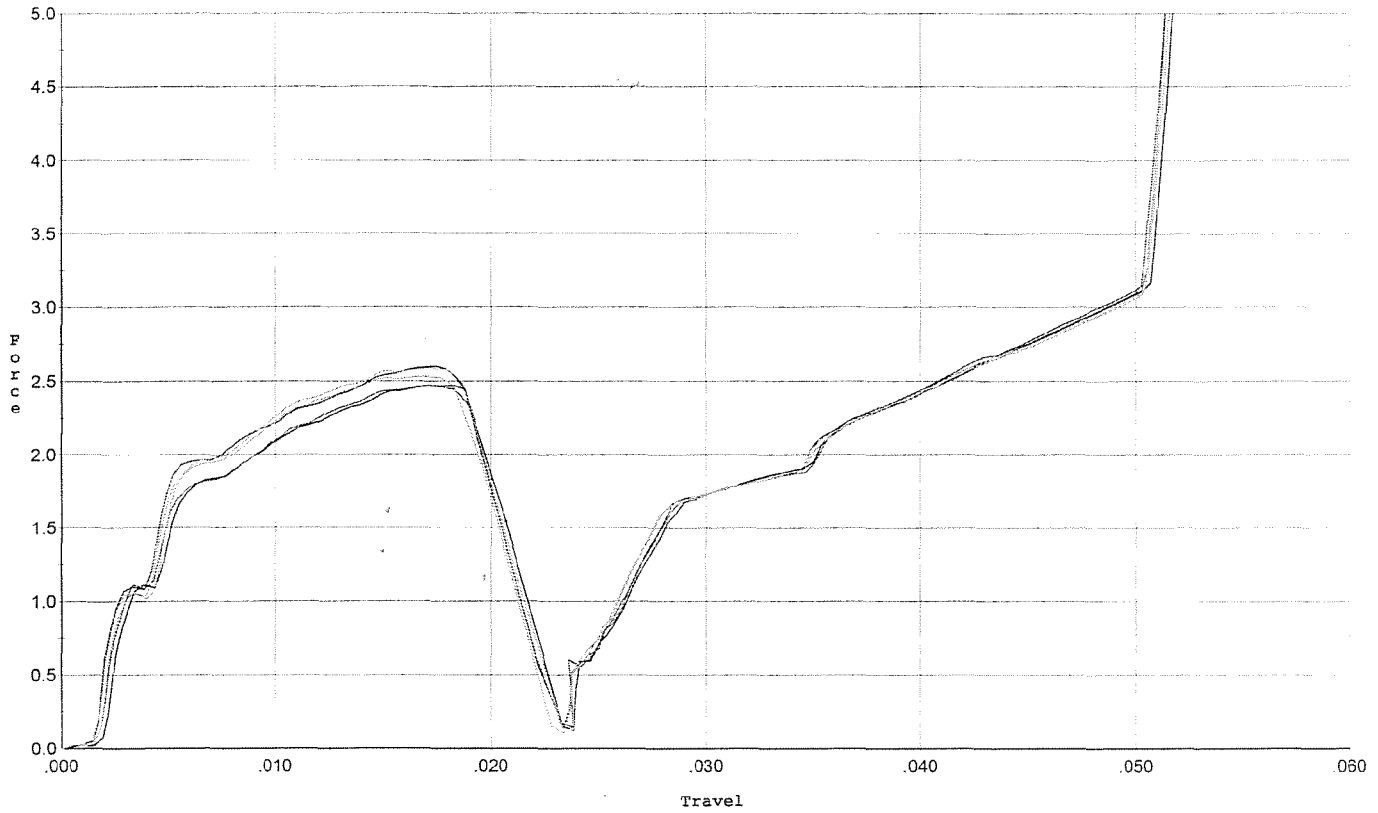
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.127	0.022	0.004	0.032	0.057		Set Trigger
2	4.194	0.022	0.004	0.032	0.059		Set Trigger
3	4.176	0.021	0.00	0.032	0.057		Set Trigger
4	4.152	0.022	0.002	0.032	0.058		Set Trigger
5	4.145	0.021	0.00	0.032	0.057		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

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

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



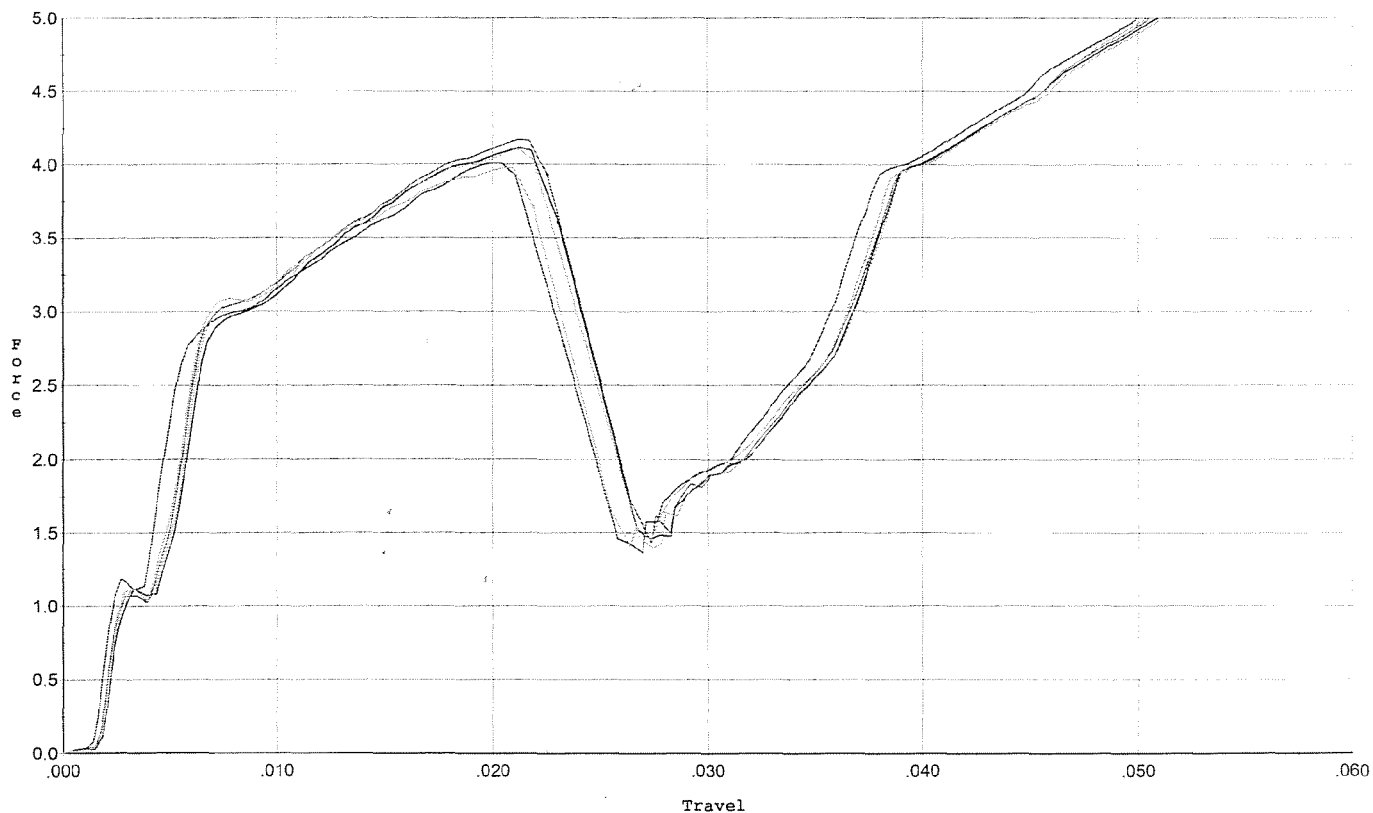
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.596	0.019	0.00	0.036	0.034		Set Trigger
2	2.472	0.021	0.002	0.035	0.035		Set Trigger
3	2.467	0.019	0.00	0.036	0.032		Set Trigger
4	2.588	0.019	0.002	0.036	0.033		Set Trigger
5	2.529	0.020	0.00	0.036	0.035		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

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

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	4.011	0.023	0.00	0.031	0.062		Set Trigger
2	4.115	0.023	0.00	0.031	0.061		Set Trigger
3	4.168	0.023	0.00	0.032	0.061		Set Trigger
4	4.099	0.024	0.00	0.031	0.065		Set Trigger
5	3.976	0.022	0.00	0.032	0.058		Set Trigger

A-4.07