

66801338

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



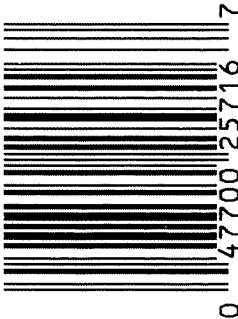
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801338

UPC



GUN SERIAL # G 6801338

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	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RTZ
472	SERIALIZE BOLT HANDLE		3-6-09	RTZ
480	MAGNAFLUX BBL ACTION	(A)	3/9/09	(A)
490	MAGNAFLUX BOLT		3/9/09	RT
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3/11	RT
540	APPLY COATINGS (BARREL ACTION)		5-20	
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

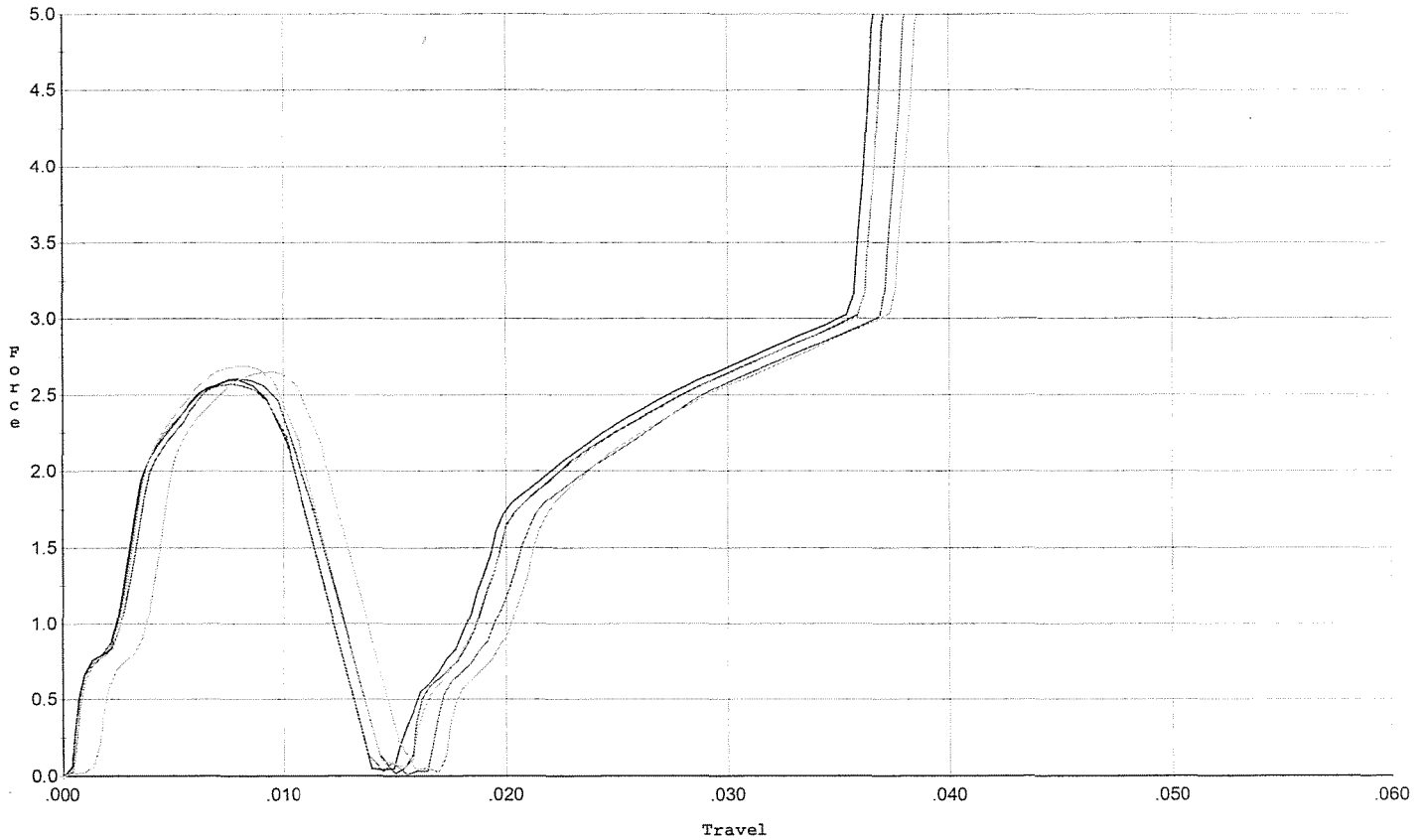
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0014108 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>7</u> <u>7</u>	3-25-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-25-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	3-25-09	NW
	J) ASSEMBLE STOCK		3-28-09	TL
	K) ASSEMBLE SWIVEL STUDS		3-27-09	TL
	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 PASS FAIL FAIL	3-24-09	TK
	MALFUNCTION	CORRECTION	n/a	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-25-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.27</u> <u>2.37</u> <u>2.43</u> <u>2.37</u>	3-24-09	TL
	C) FUNCTION		3-25-09	NW
690	PACK		3-28-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



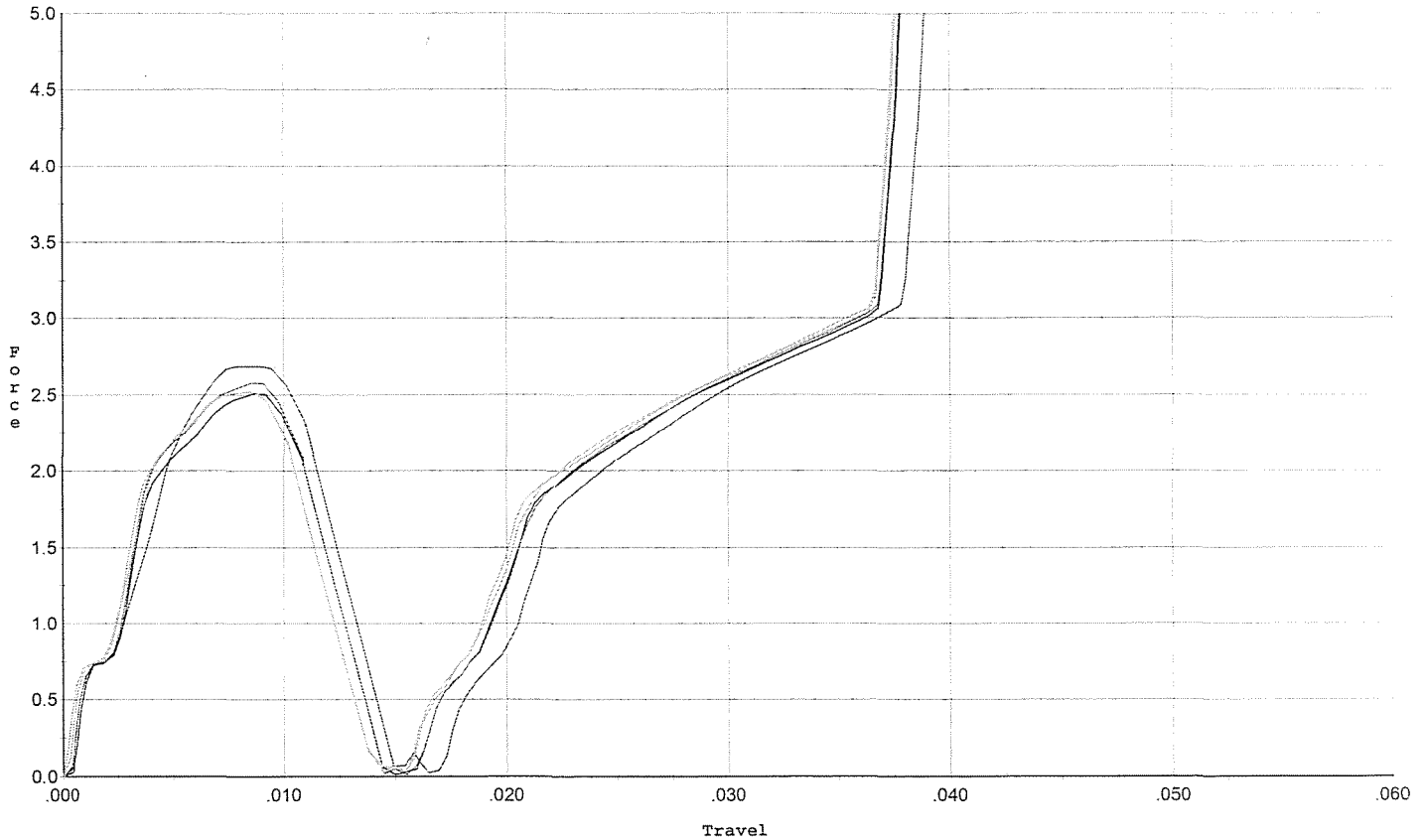
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.605	0.011	0.00	0.029	0.019		Set Trigger
2	2.595	0.010	0.00	0.029	0.018		Set Trigger
3	2.573	0.010	0.00	0.030	0.017		Set Trigger
4	2.691	0.011	0.00	0.029	0.019		Set Trigger
5	2.652	0.012	0.00	0.030	0.019		Set Trigger

A. 2.62

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



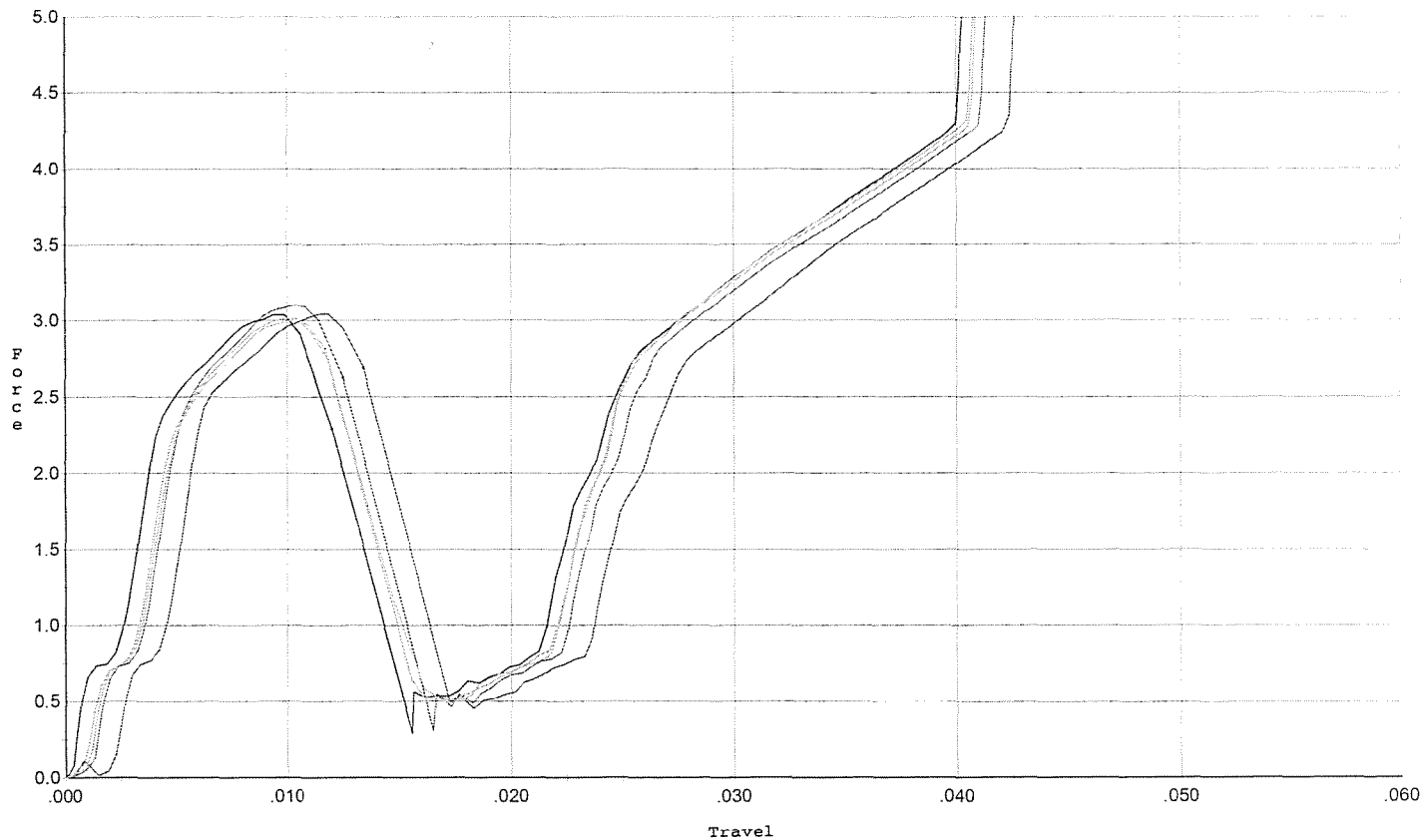
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.688	0.011	0.00	0.030	0.019		Set Trigger
2	2.507	0.011	0.00	0.030	0.018		Set Trigger
3	2.580	0.011	0.00	0.030	0.018		Set Trigger
4	2.528	0.010	0.00	0.030	0.017		Set Trigger
5	2.517	0.010	0.00	0.030	0.017		Set Trigger

A-2-56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



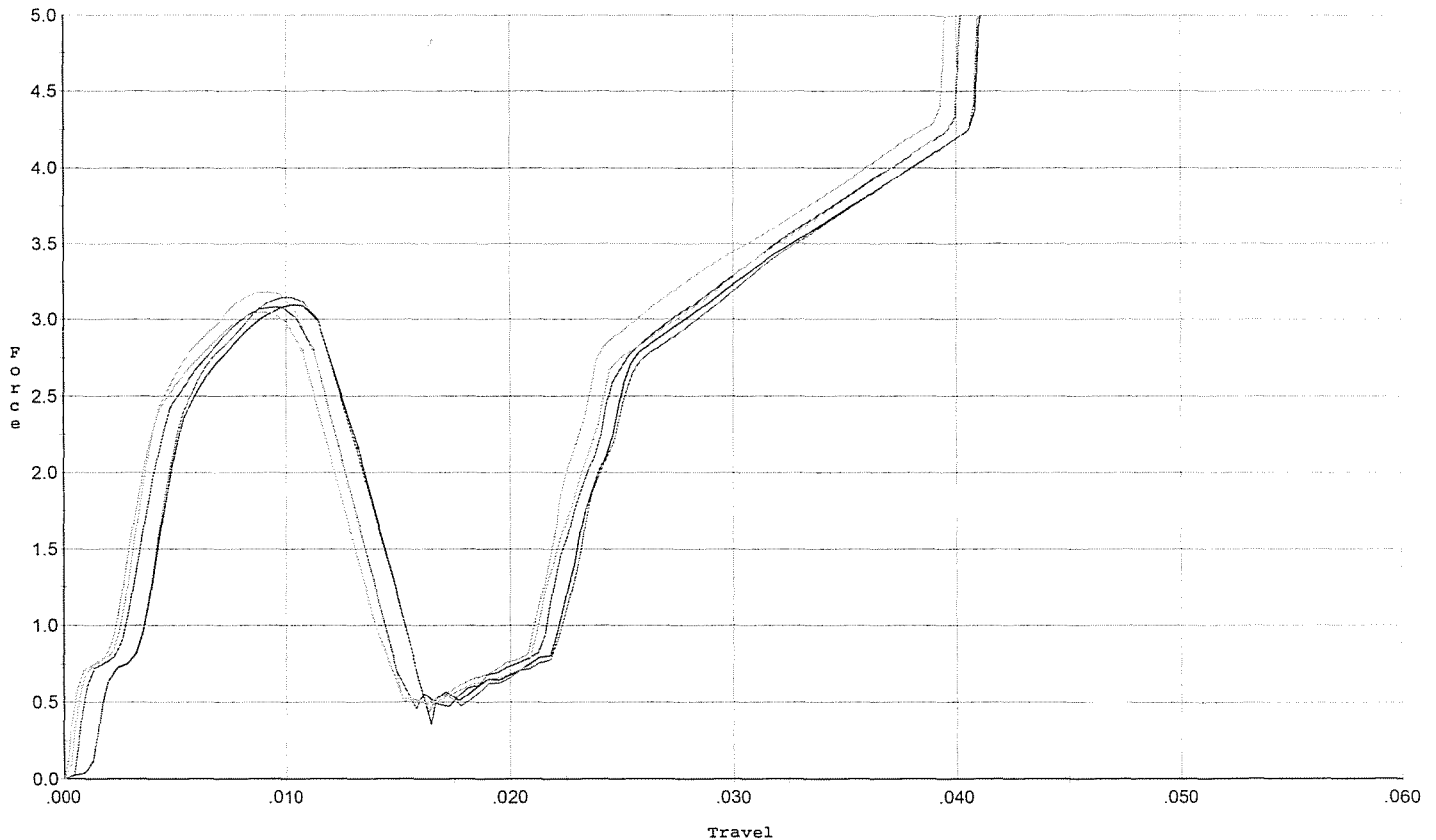
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.013	0.00	0.030	0.024		Set Trigger
2	3.036	0.012	0.00	0.030	0.024		Set Trigger
3	3.100	0.013	0.00	0.030	0.024		Set Trigger
4	3.004	0.012	0.00	0.030	0.022		Set Trigger
5	3.013	0.012	0.00	0.030	0.022		Set Trigger

A-3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



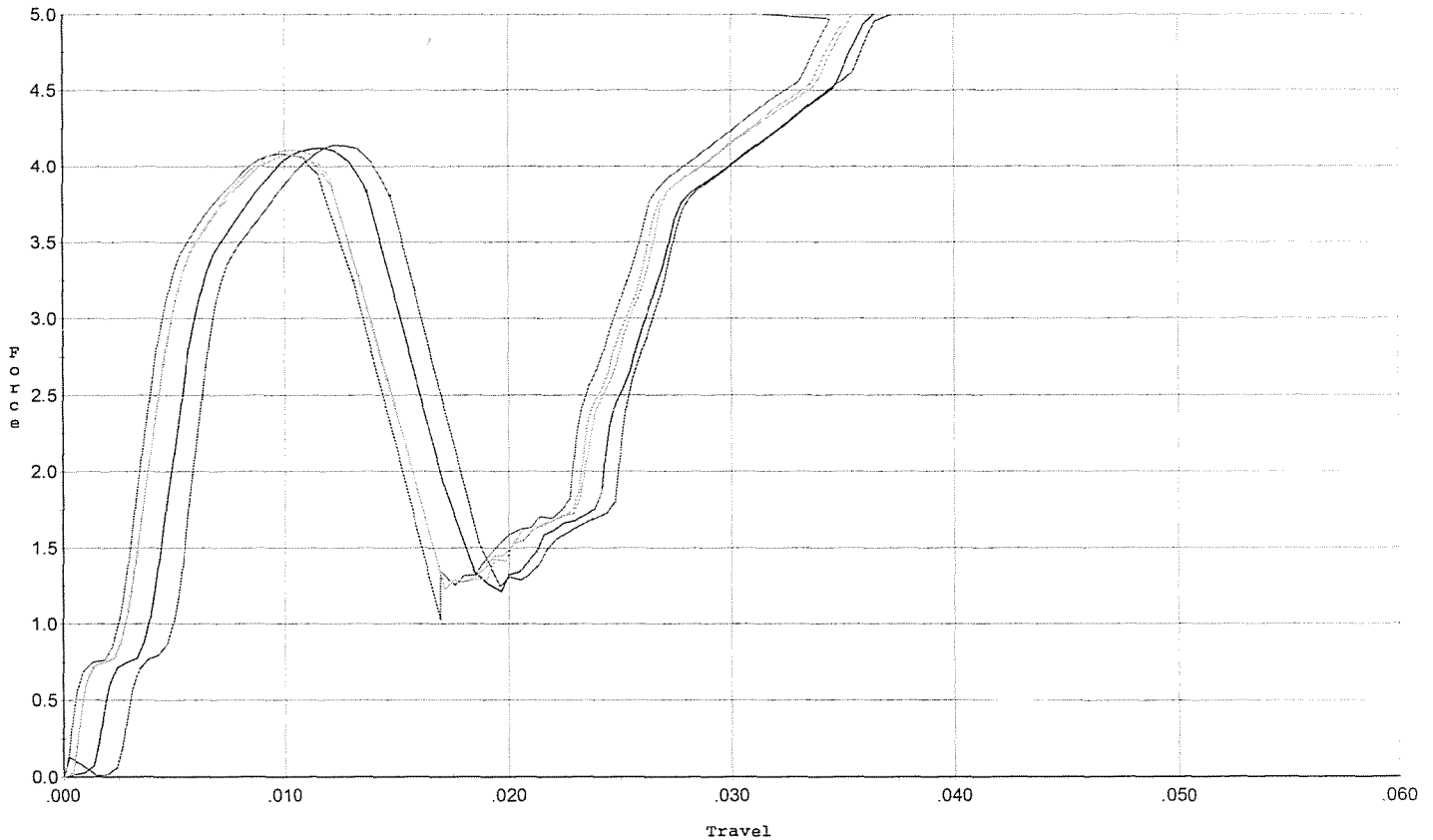
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.078	0.011	0.00	0.030	0.022		Set Trigger
2	3.096	0.013	0.00	0.030	0.025		Set Trigger
3	3.147	0.014	0.00	0.029	0.025		Set Trigger
4	3.181	0.011	0.00	0.030	0.023		Set Trigger
5	3.046	0.011	0.00	0.029	0.021		Set Trigger

A.3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



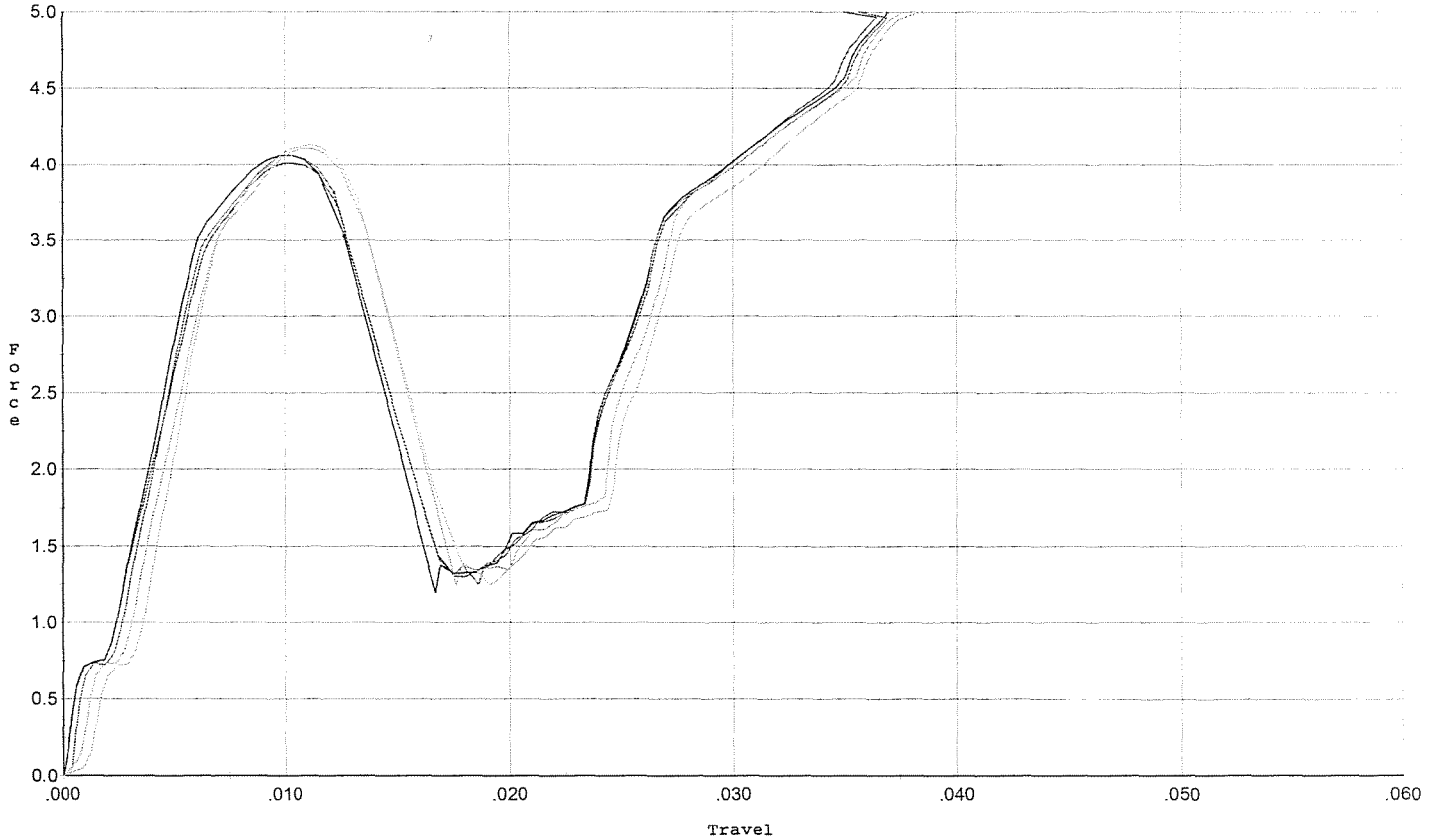
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.139	0.015	0.003	0.027	0.034		Set Trigger
2	4.123	0.014	0.00	0.027	0.033		Set Trigger
3	4.084	0.013	0.00	0.026	0.034		Set Trigger
4	4.079	0.015	0.00	0.026	0.037		Set Trigger
5	4.108	0.014	0.00	0.027	0.036		Set Trigger

A-4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



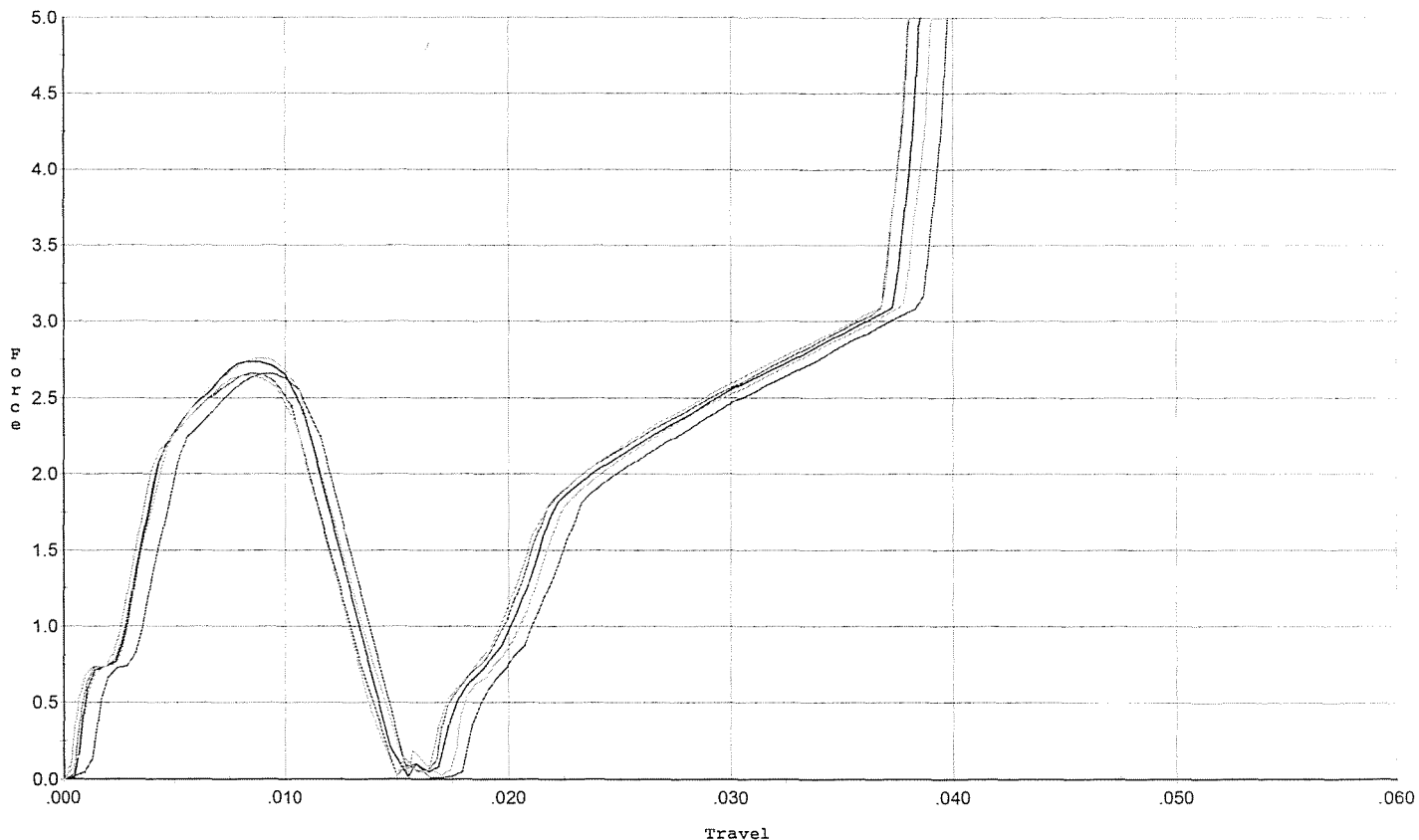
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.012	0.012	0.00	0.027	0.031		Set Trigger
2	4.061	0.013	0.00	0.027	0.032		Set Trigger
3	4.062	0.012	0.00	0.027	0.030		Set Trigger
4	4.131	0.013	0.00	0.027	0.032		Set Trigger
5	4.108	0.013	0.00	0.027	0.033		Set Trigger

A-4.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



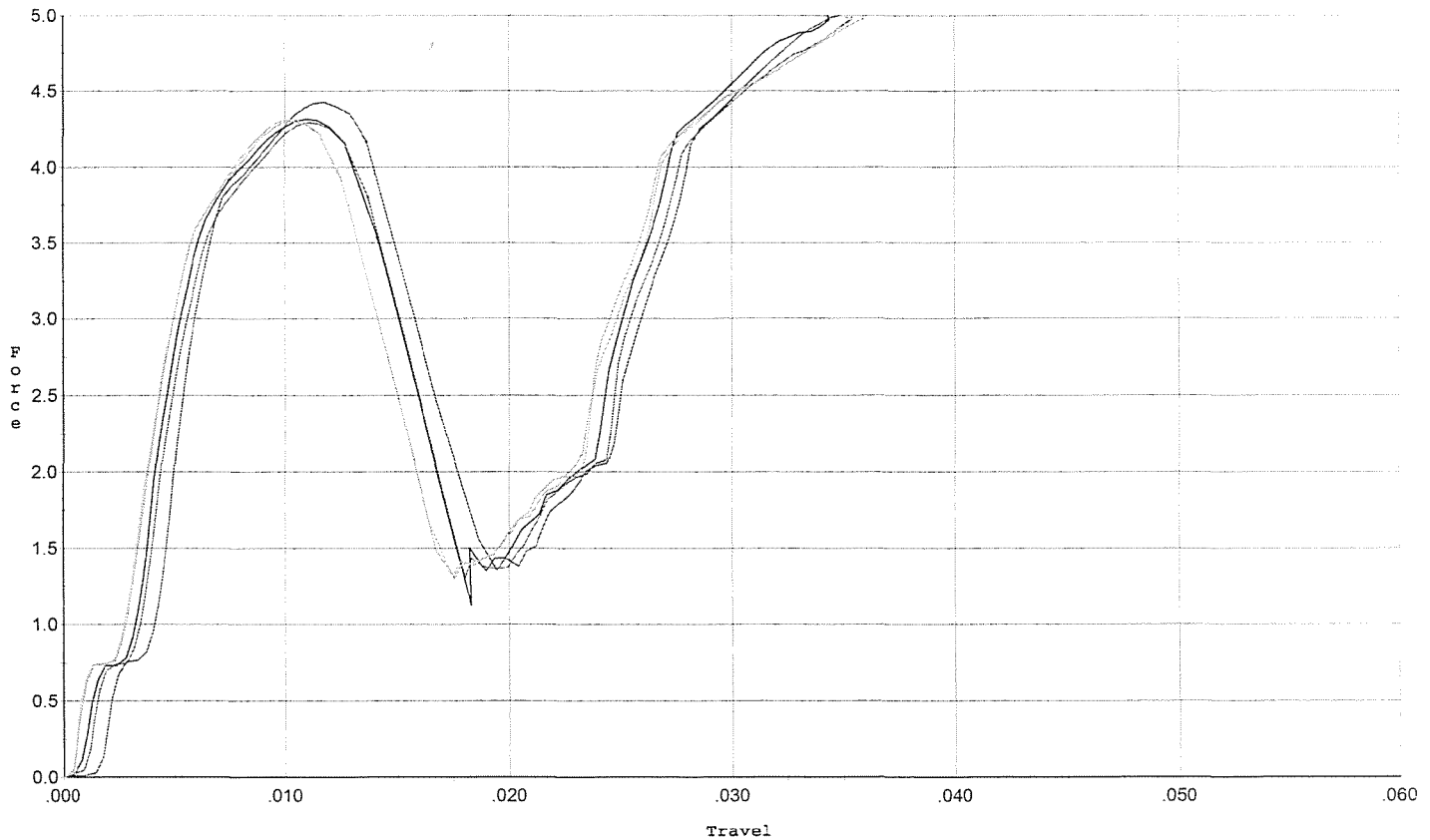
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.657	0.012	0.00	0.031	0.019		Set Trigger
2	2.737	0.011	0.00	0.030	0.019		Set Trigger
3	2.661	0.010	0.00	0.030	0.018		Set Trigger
4	2.761	0.011	0.00	0.031	0.019		Set Trigger
5	2.646	0.010	0.00	0.030	0.018		Set Trigger

A-2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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	4.427	0.014	0.00	0.027	0.035		Set Trigger
2	4.315	0.014	0.00	0.026	0.037		Set Trigger
3	4.293	0.014	0.00	0.027	0.035		Set Trigger
4	4.311	0.013	0.00	0.026	0.033		Set Trigger
5	4.298	0.013	0.00	0.026	0.033		Set Trigger

A-4-32