

96801346

Oxford

NO. 752 1/3
100%

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



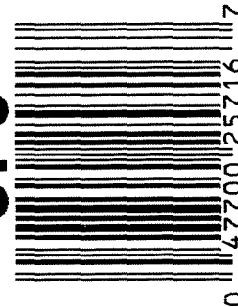
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801346

UPC



GUN SERIAL # G 6801346

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/13/09	
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	ST
542	APPLY COATINGS (BARREL ACTION)		3-25-09	✓
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

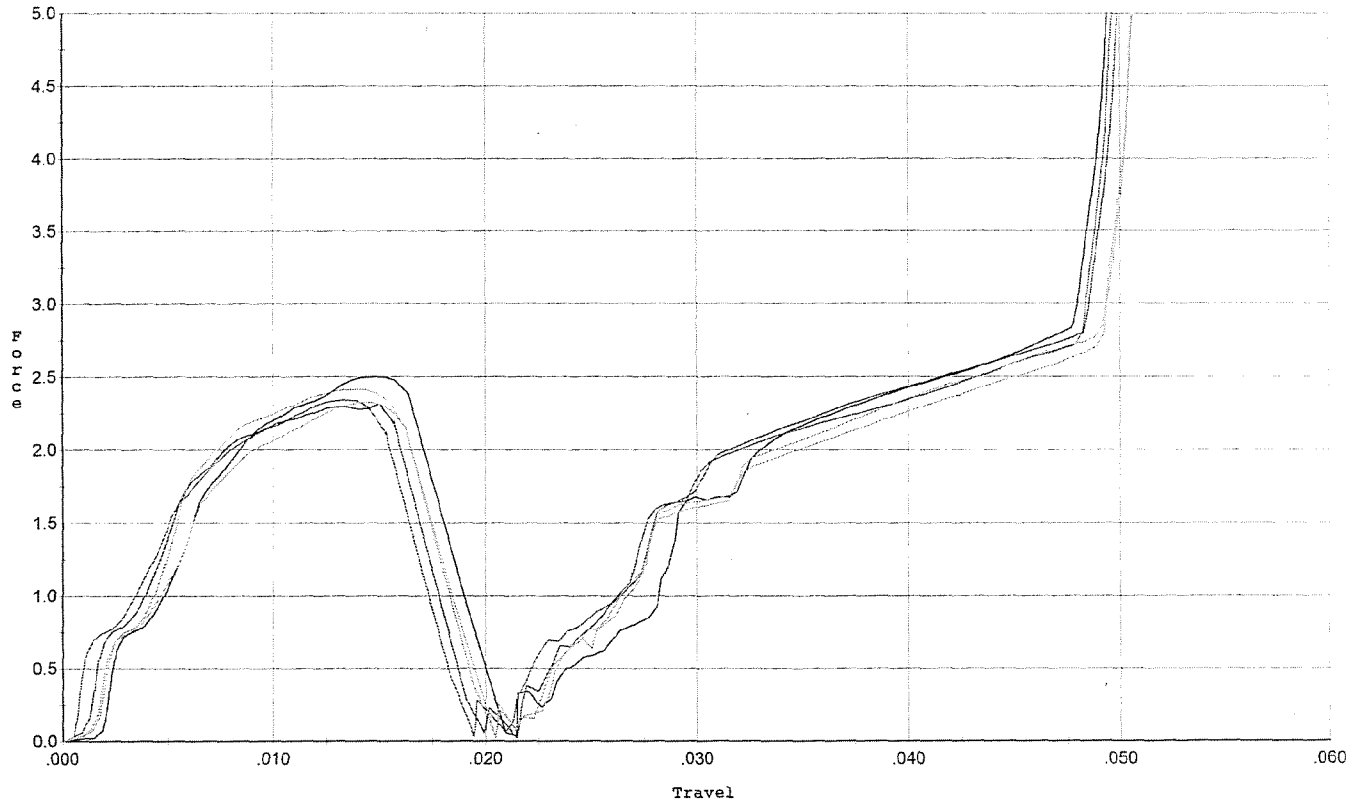
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	3-30-09	LH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	3-30-09	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-30-09	LH
	J) ASSEMBLE STOCK		3-25-09	LH
	K) ASSEMBLE SWIVEL STUDS		3-30-09	LH
	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	WA
670	FINAL INSPECTION A) HEADSPACE		3-30-09	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.38</u> <u>2.43</u> <u>2.46</u> <u>2.37</u>	3-30-09	TC
	C) FUNCTION		3-30-09	LH
690	PACK		4/13/09	Fm

F004 REV 5/2006

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



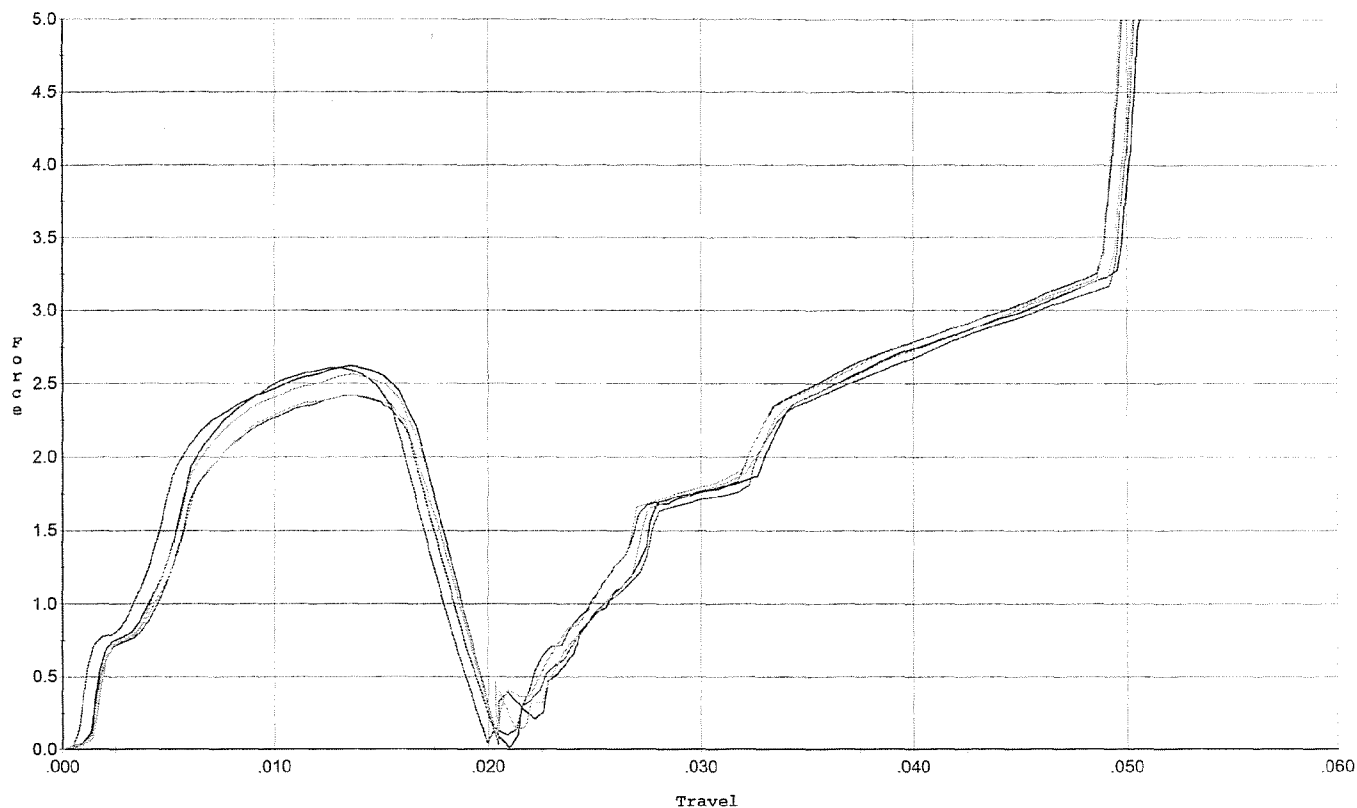
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.315	0.016	0.00	0.037	0.025		Set Trigger
2	2.500	0.016	0.00	0.036	0.026		Set Trigger
3	2.342	0.015	0.00	0.038	0.024		Set Trigger
4	2.326	0.016	0.00	0.038	0.024		Set Trigger
5	2.414	0.016	0.00	0.038	0.026		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: 2.5 lbs after 20 cycles +/- .50 lb



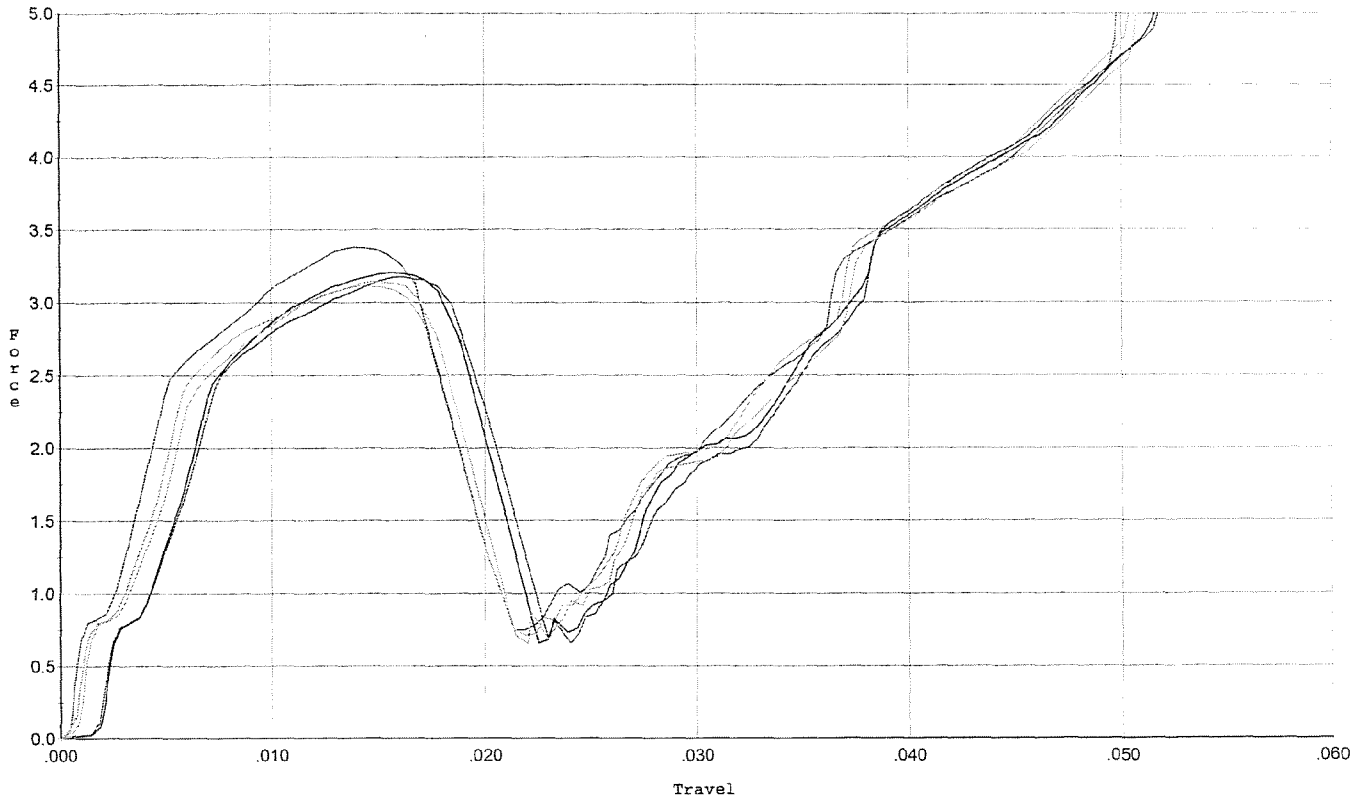
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.608	0.015	0.00	0.037	0.028		Set Trigger
2	2.621	0.017	0.00	0.037	0.029		Set Trigger
3	2.420	0.016	0.00	0.037	0.026		Set Trigger
4	2.561	0.017	0.00	0.036	0.029		Set Trigger
5	2.417	0.018	0.00	0.036	0.028		Set Trigger

A-2-52

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



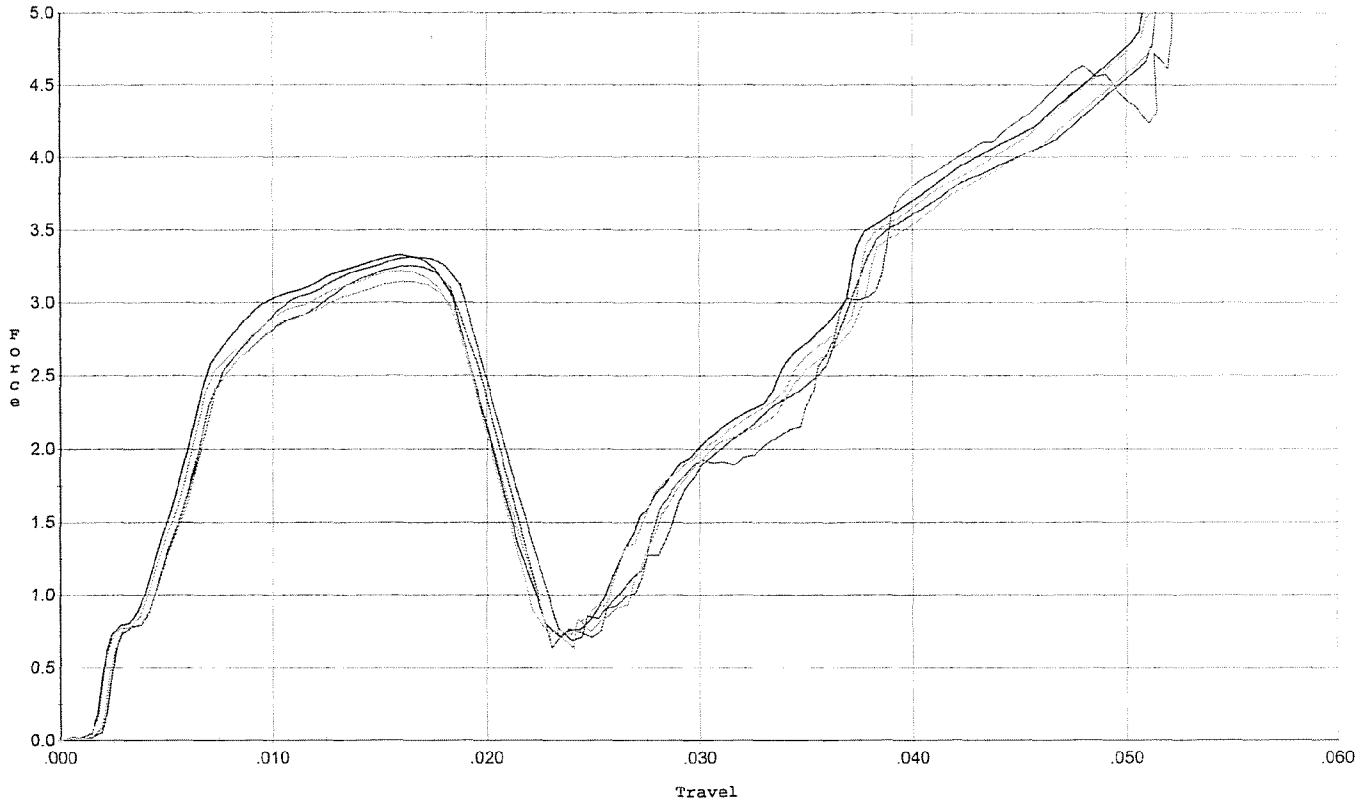
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.176	0.020	0.00	0.034	0.041		Set Trigger
2	3.208	0.019	0.00	0.035	0.039		Set Trigger
3	3.381	0.017	0.00	0.034	0.039		Set Trigger
4	3.145	0.018	0.00	0.035	0.038		Set Trigger
5	3.117	0.017	0.00	0.034	0.037		Set Trigger

A-3-20

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



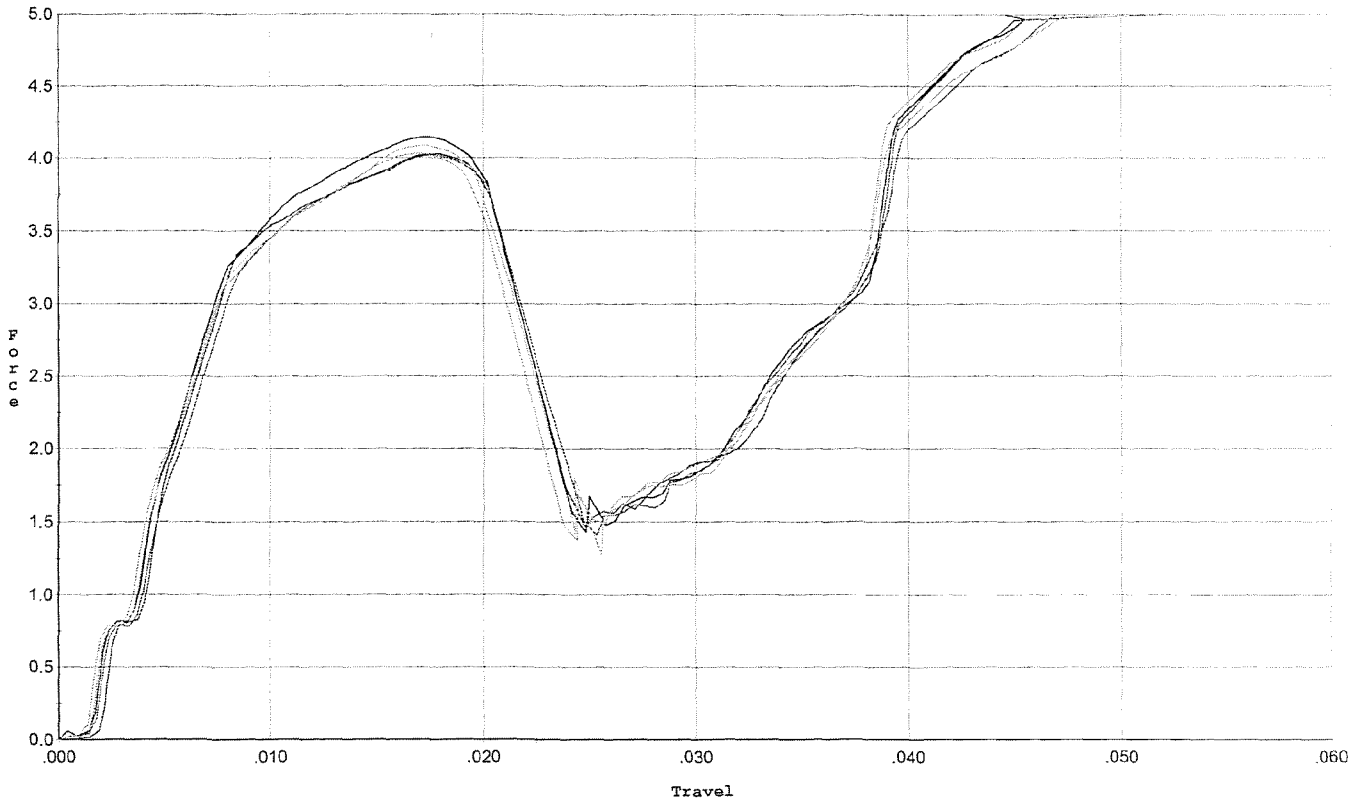
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.315	0.019	0.00	0.034	0.040		Set Trigger
2	3.329	0.018	0.00	0.034	0.040		Set Trigger
3	3.255	0.020	0.002	0.035	0.041		Set Trigger
4	3.220	0.019	0.00	0.034	0.039		Set Trigger
5	3.147	0.019	0.002	0.034	0.038		Set Trigger

A-3-25

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



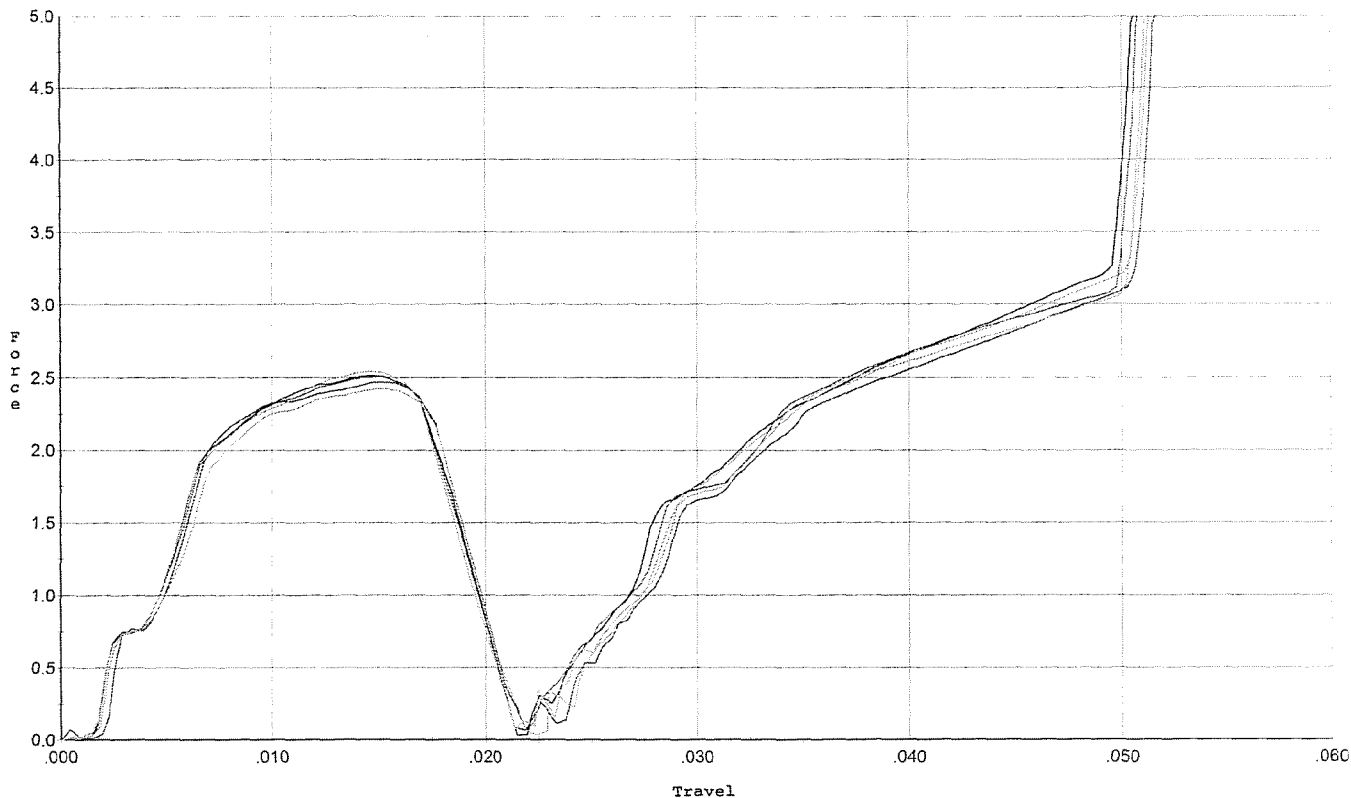
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.030	0.020	0.00	0.032	0.053		Set Trigger
2	4.142	0.020	0.00	0.032	0.055		Set Trigger
3	4.016	0.020	0.00	0.032	0.053		Set Trigger
4	4.087	0.021	0.00	0.032	0.057		Set Trigger
5	4.029	0.020	0.00	0.032	0.053		Set Trigger

A. 4.06

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



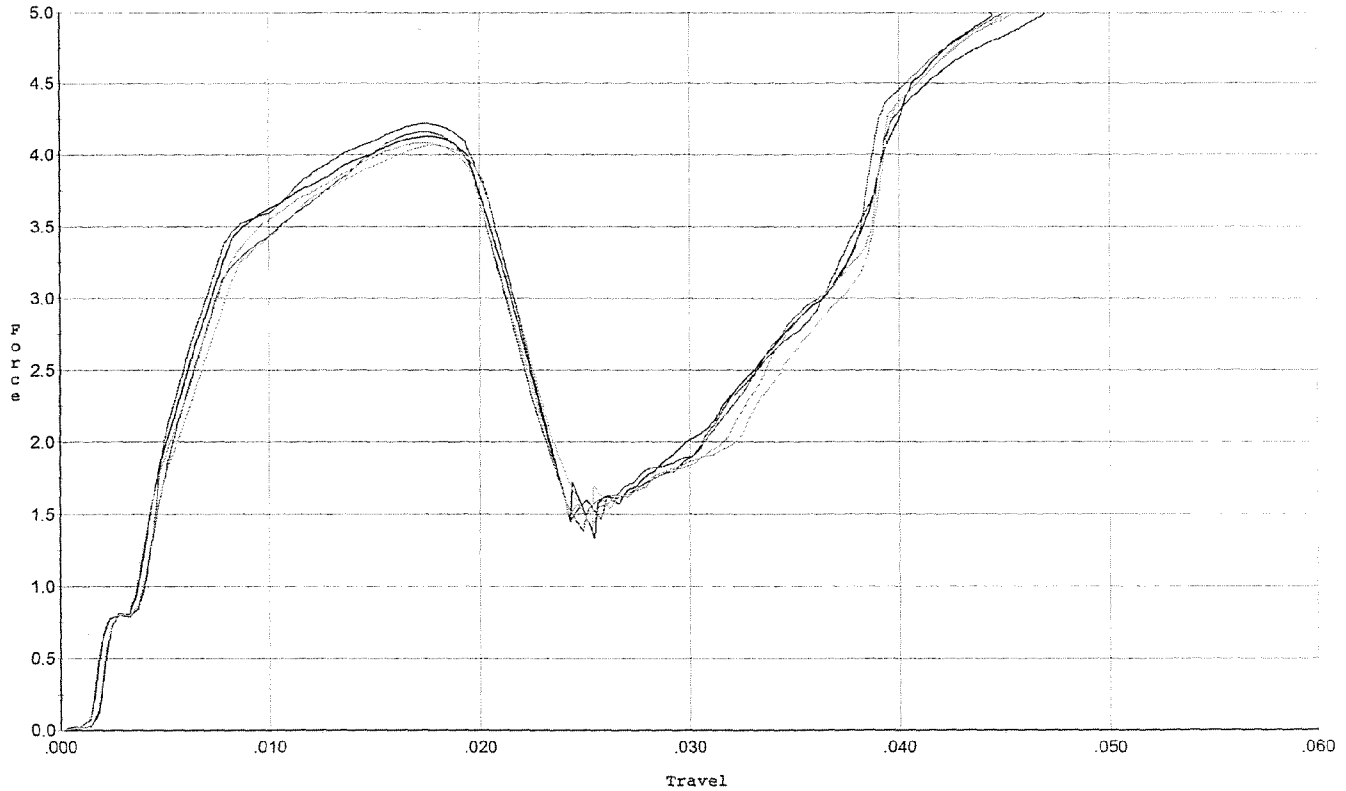
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.469	0.018	0.002	0.036	0.029		Set Trigger
2	2.516	0.018	0.00	0.035	0.030		Set Trigger
3	2.503	0.019	0.00	0.036	0.031		Set Trigger
4	2.545	0.017	0.00	0.037	0.028		Set Trigger
5	2.422	0.018	0.00	0.036	0.028		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: 4.0 lbs +/- 1.0 lb for vtarget & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.217	0.020	0.00	0.032	0.056		Set Trigger
2	4.128	0.021	0.00	0.032	0.058		Set Trigger
3	4.158	0.020	0.00	0.032	0.051		Set Trigger
4	4.069	0.020	0.00	0.033	0.053		Set Trigger
5	4.082	0.020	0.00	0.033	0.052		Set Trigger

A-4.13