

66801351

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



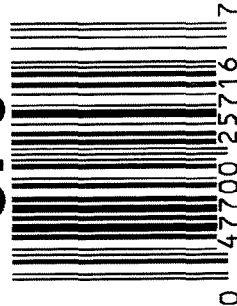
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801351

UPC



GUN SERIAL #

G 6801351

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	KTZ
480	MAGNAFLUX BBL ACTION	(B)	3/9/09	(B)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-20-09	KTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

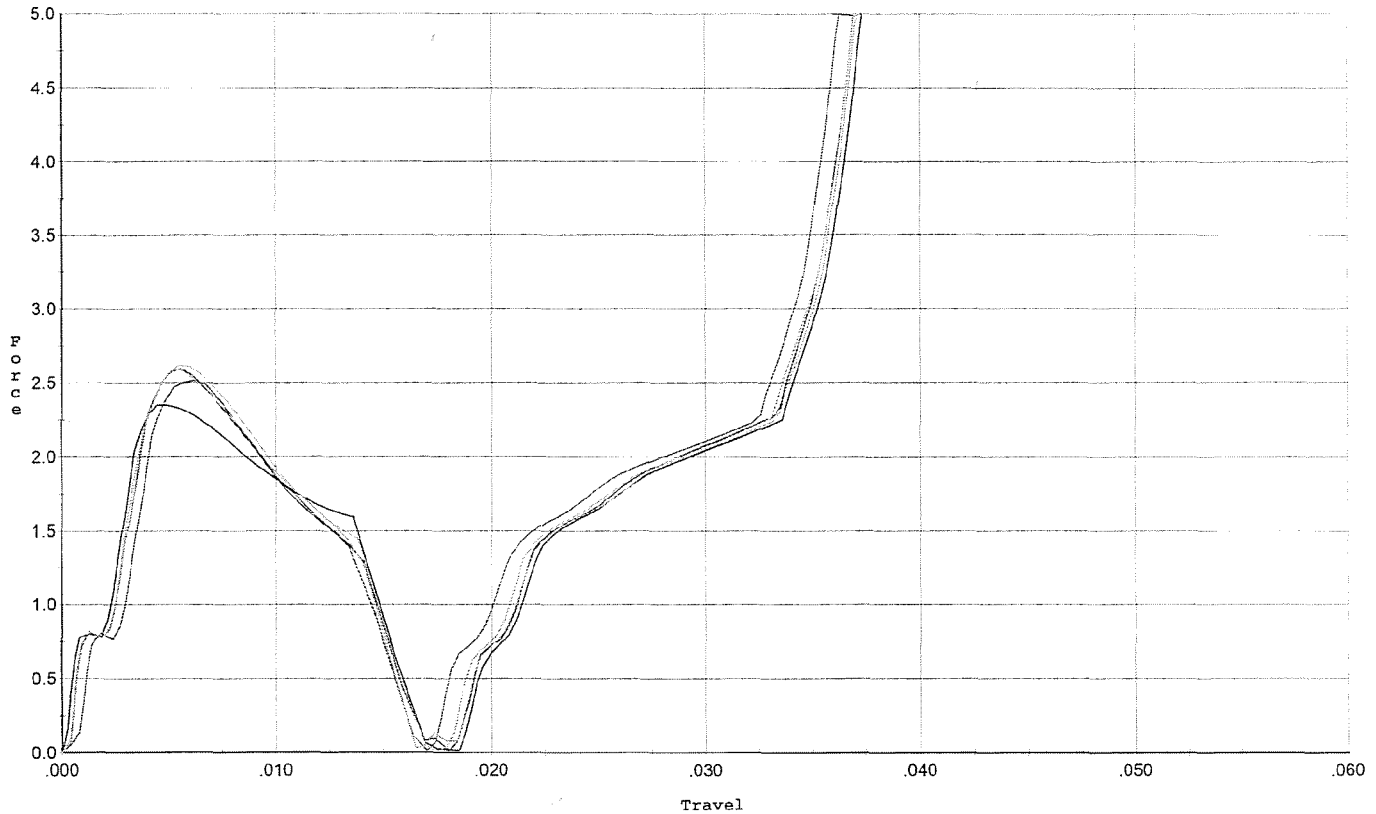
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6</u> <u>6</u>	3-23-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3.5</u> <u>3.5</u>	3-23-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.022</u> <u>.022</u>	3-23-09	WV
	J) ASSEMBLE STOCK		3-23-09	RT
	K) ASSEMBLE SWIVEL STUDS		3-23-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-23-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-23-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.73</u> <u>2.71</u> <u>2.60</u> <u>2.65</u>	3-23-09	TL
	C) FUNCTION		3-23-09	WV
690	PACK		3/23/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



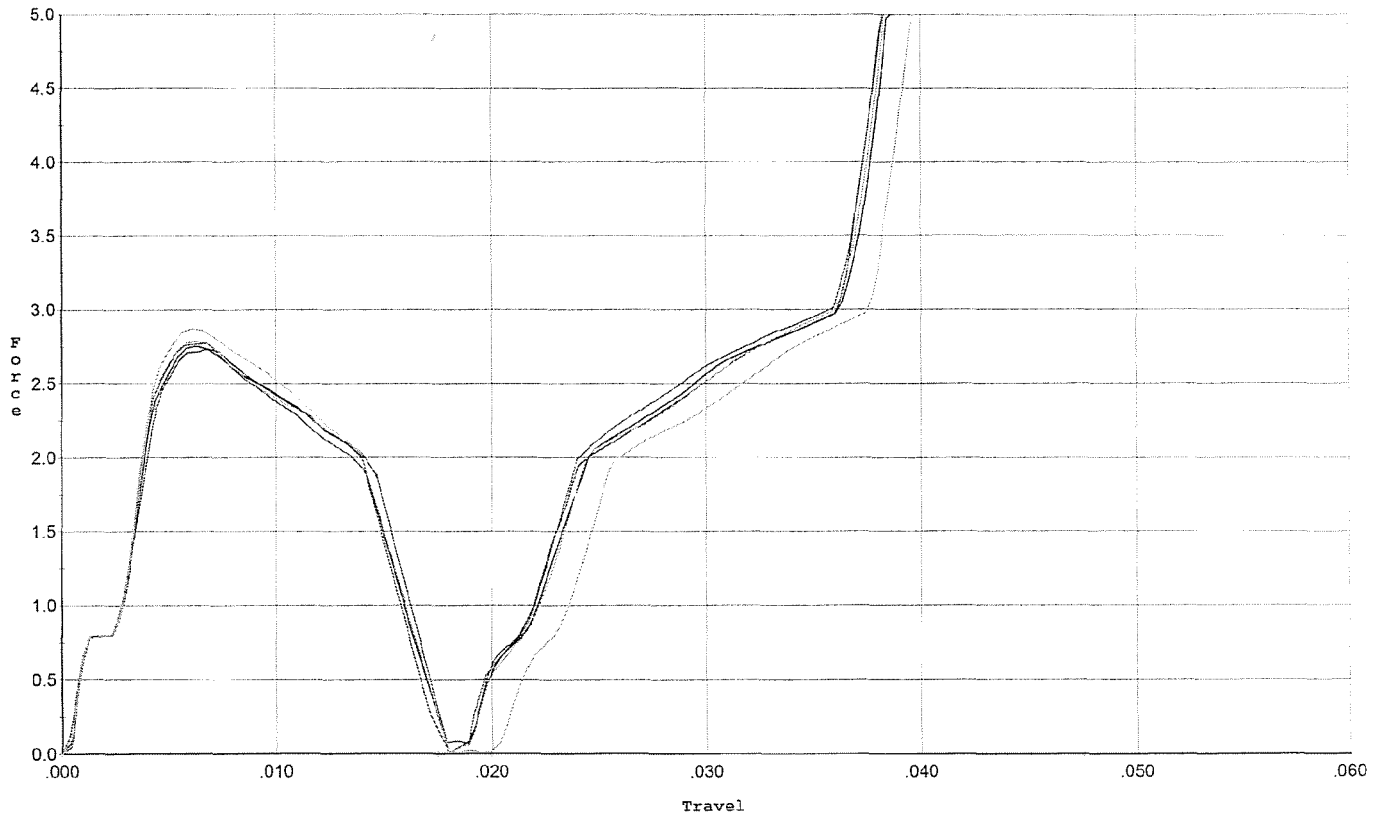
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.014	0.00	0.028	0.022		Set Trigger
2	2.348	0.014	0.00	0.029	0.022		Set Trigger
3	2.593	0.015	0.00	0.028	0.023		Set Trigger
4	2.589	0.014	0.00	0.028	0.023		Set Trigger
5	2.620	0.014	0.00	0.028	0.023		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



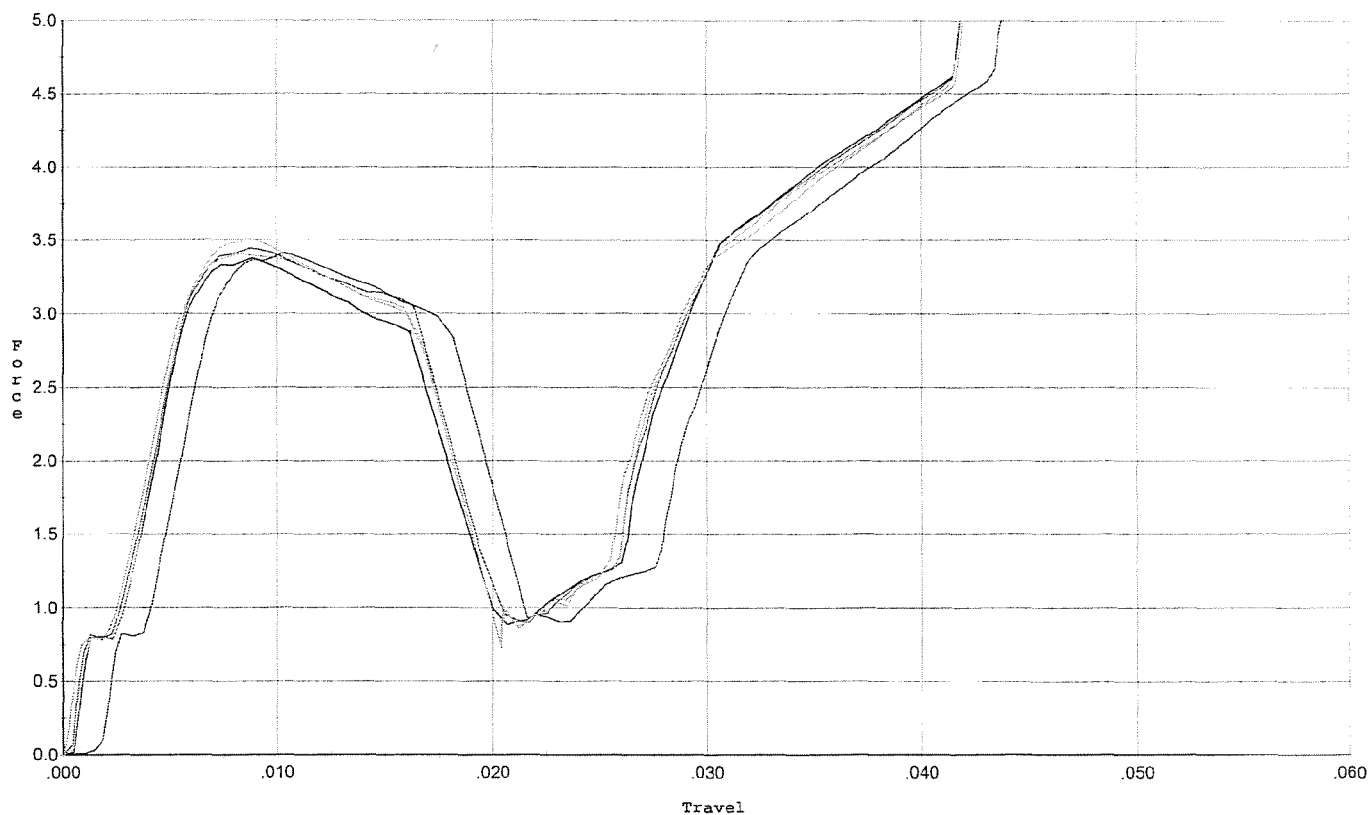
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.734	0.015	0.00	0.028	0.027		Set Trigger
2	2.753	0.014	0.003	0.028	0.026		Set Trigger
3	2.773	0.014	0.00	0.028	0.026		Set Trigger
4	2.868	0.016	0.00	0.029	0.030		Set Trigger
5	2.782	0.016	0.00	0.028	0.029		Set Trigger

A-2-78

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



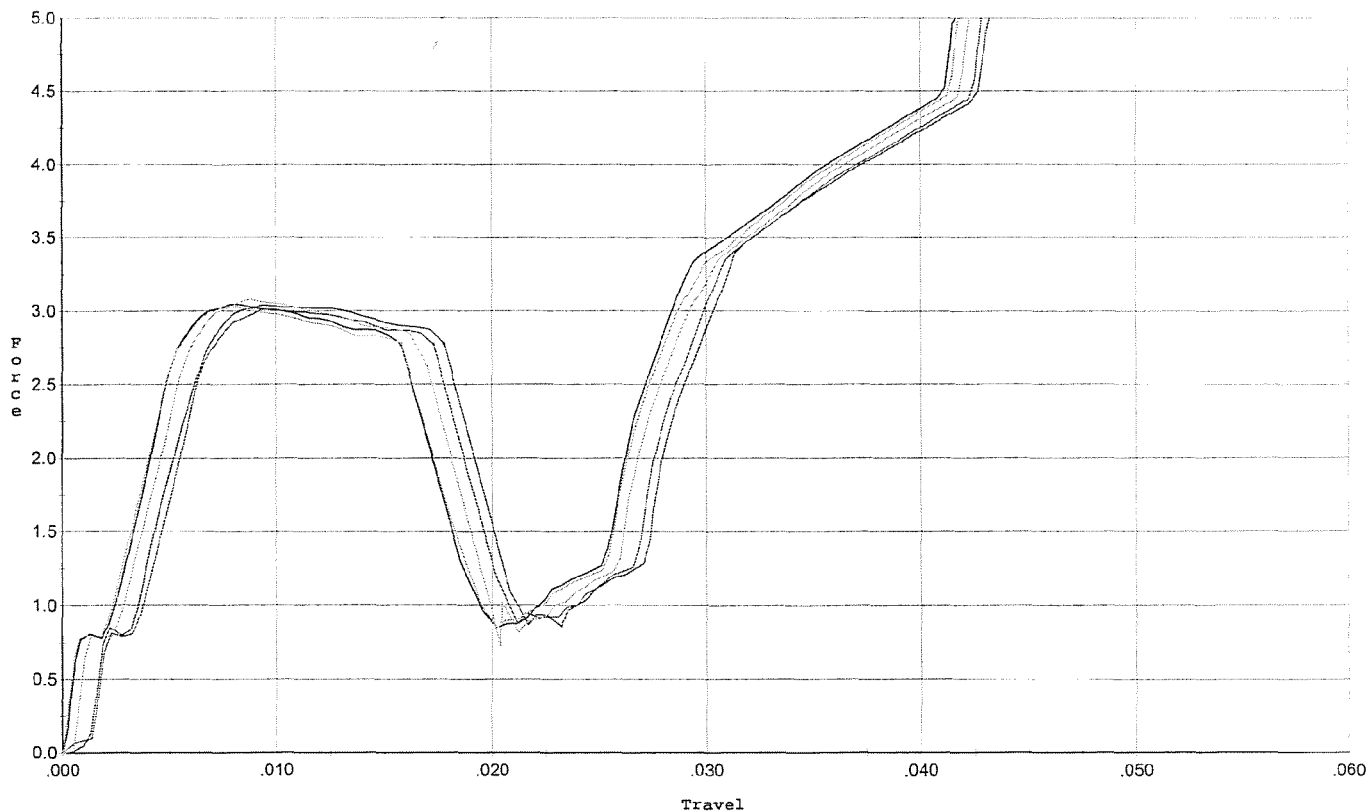
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.413	0.018	0.00	0.028	0.041		Set Trigger
2	3.377	0.016	0.00	0.028	0.037		Set Trigger
3	3.445	0.016	0.00	0.027	0.039		Set Trigger
4	3.512	0.017	0.003	0.027	0.040		Set Trigger
5	3.407	0.017	0.00	0.027	0.040		Set Trigger

A-3-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



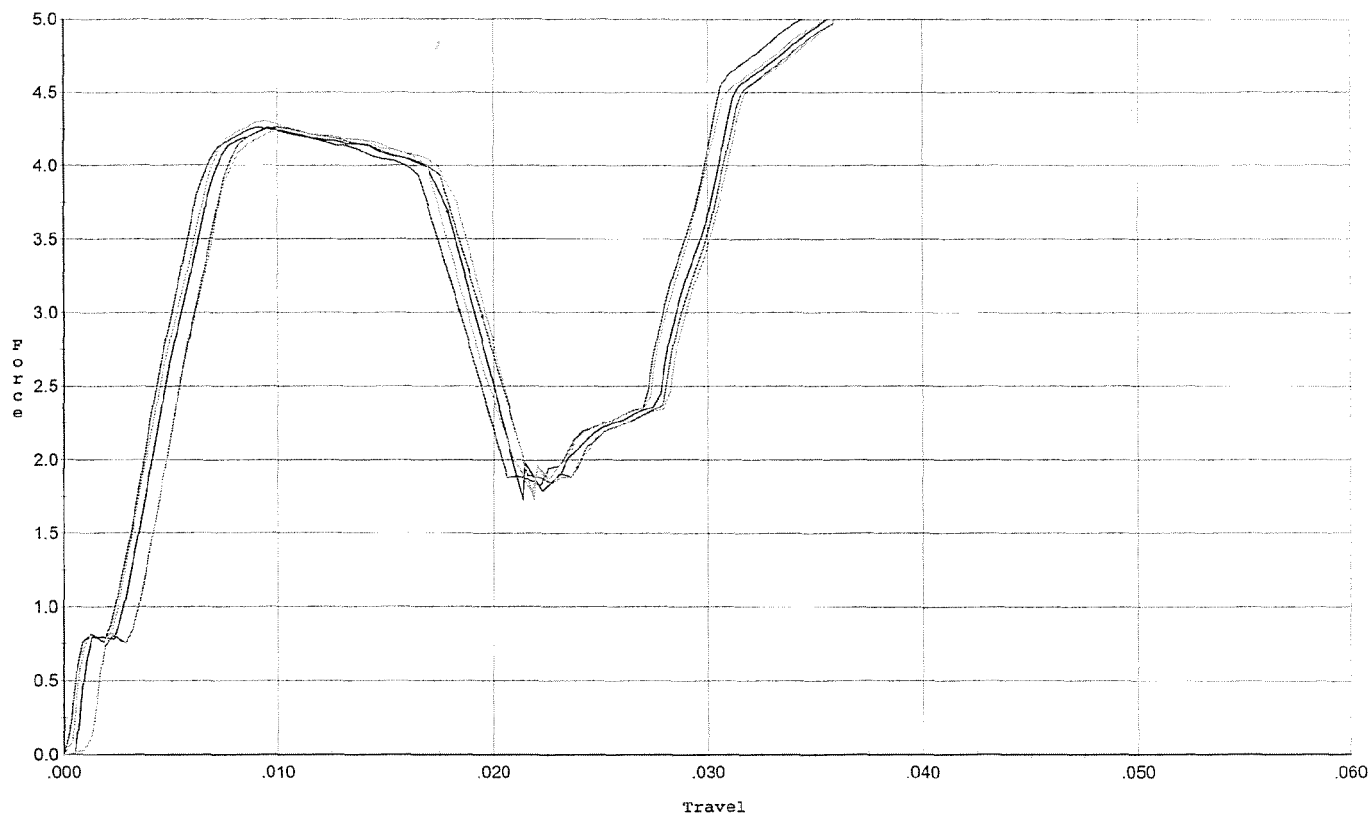
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.039	0.018	0.00	0.028	0.038		Set Trigger
2	3.045	0.016	0.00	0.027	0.035		Set Trigger
3	3.015	0.017	0.00	0.028	0.036		Set Trigger
4	3.082	0.017	0.003	0.027	0.037		Set Trigger
5	3.030	0.016	0.00	0.028	0.035		Set Trigger

A-3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



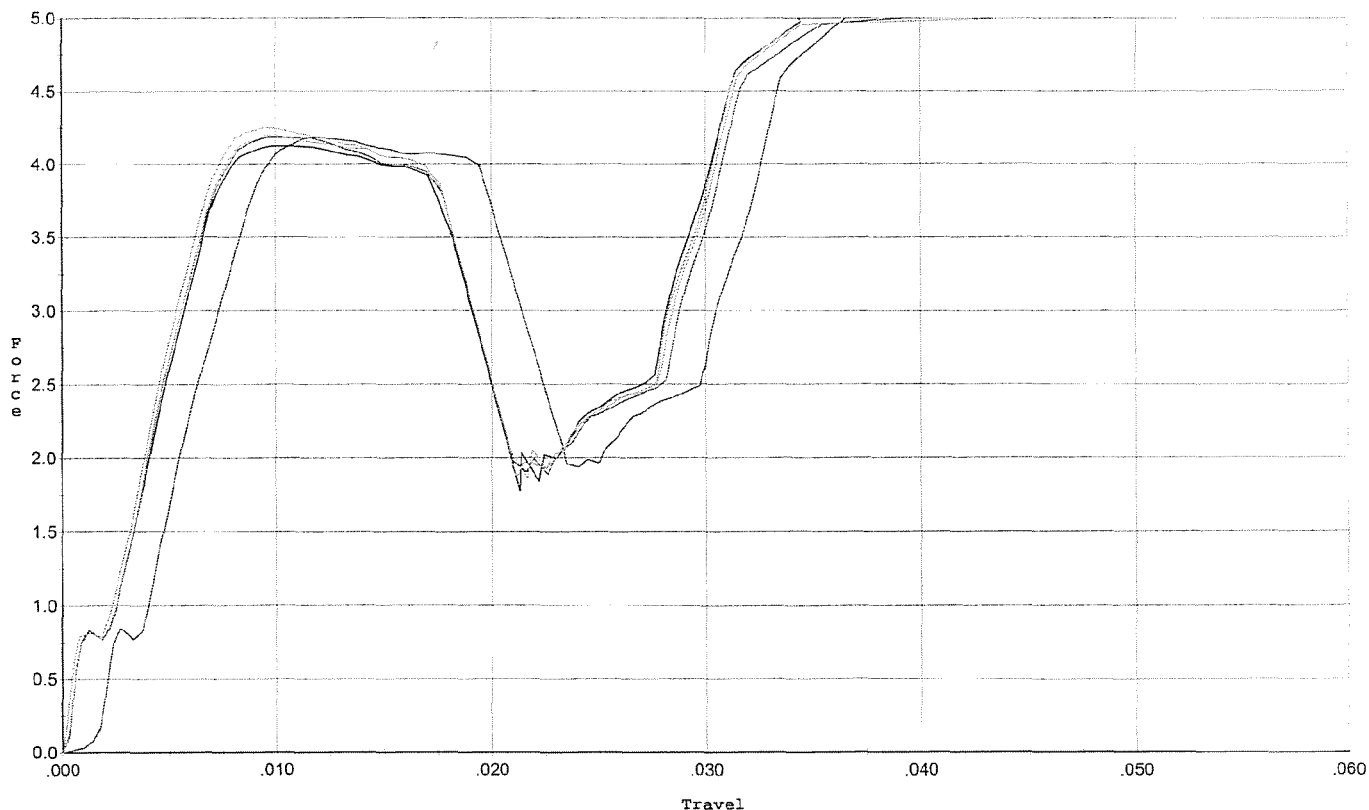
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.260	0.018	0.00	0.025	0.054		Set Trigger
2	4.258	0.018	0.003	0.025	0.052		Set Trigger
3	4.261	0.019	0.00	0.025	0.055		Set Trigger
4	4.307	0.017	0.00	0.025	0.050		Set Trigger
5	4.246	0.018	0.00	0.025	0.052		Set Trigger

A. 4.26

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



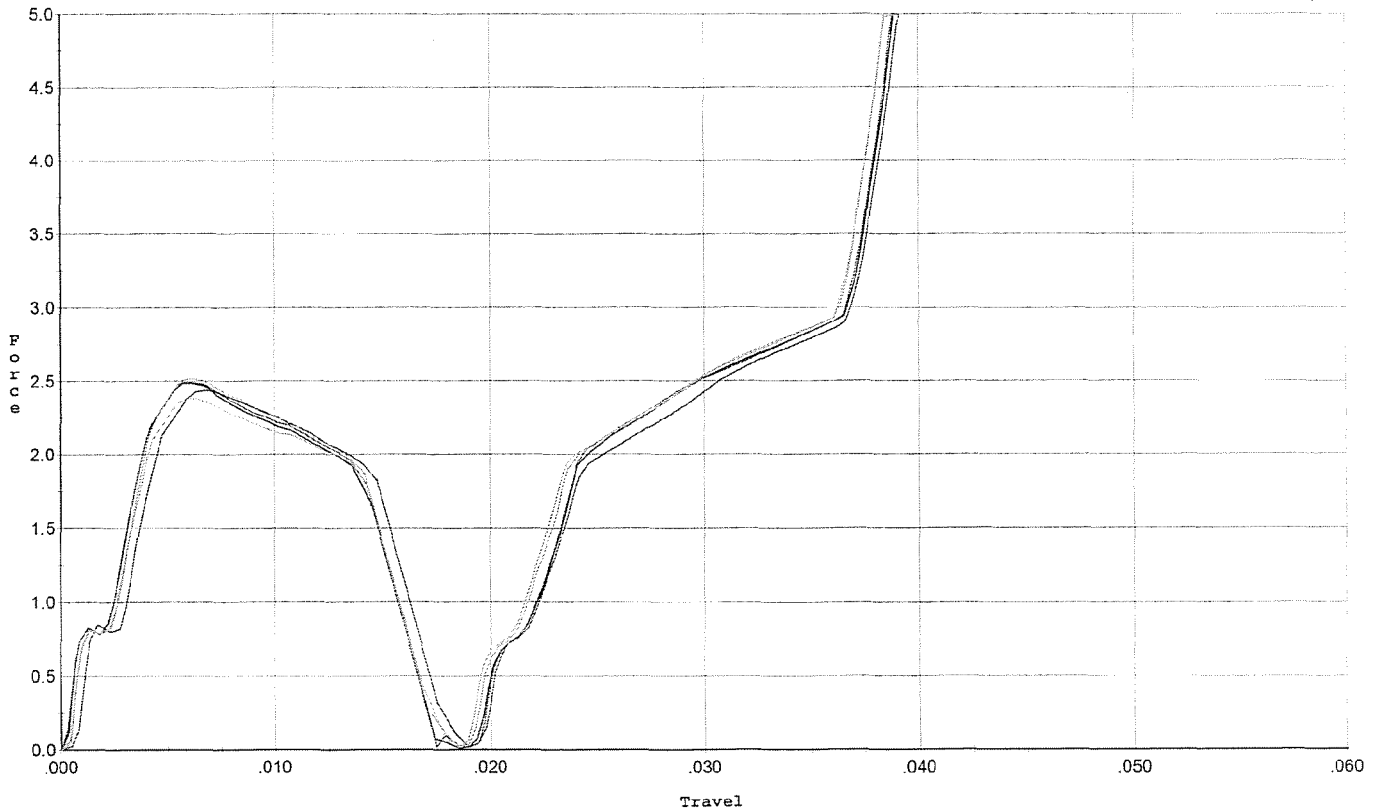
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.184	0.019	0.00	0.025	0.053		Set Trigger
2	4.122	0.018	0.00	0.025	0.052		Set Trigger
3	4.186	0.018	0.00	0.025	0.051		Set Trigger
4	4.200	0.018	0.00	0.025	0.051		Set Trigger
5	4.253	0.018	0.00	0.025	0.052		Set Trigger

A. 4.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



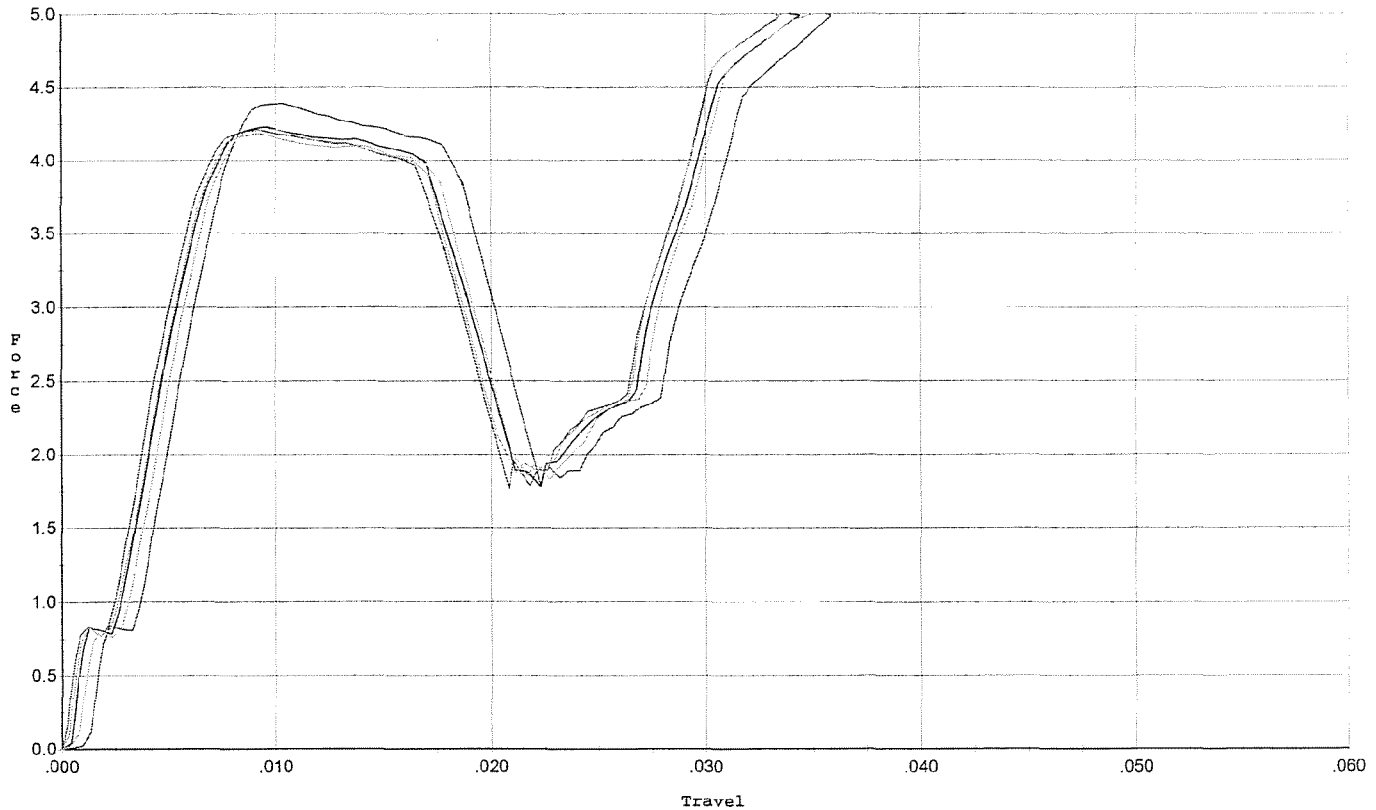
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.438	0.015	0.00	0.028	0.025		Set Trigger
2	2.485	0.014	0.00	0.028	0.025		Set Trigger
3	2.491	0.014	0.00	0.028	0.025		Set Trigger
4	2.382	0.014	0.00	0.028	0.024		Set Trigger
5	2.515	0.014	0.00	0.028	0.025		Set Trigger

A. 2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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	4.389	0.019	0.004	0.024	0.054		Set Trigger
2	4.230	0.019	0.003	0.024	0.055		Set Trigger
3	4.211	0.018	0.00	0.024	0.052		Set Trigger
4	4.217	0.018	0.00	0.025	0.050		Set Trigger
5	4.184	0.017	0.00	0.024	0.049		Set Trigger

A-4-24