

66801375

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



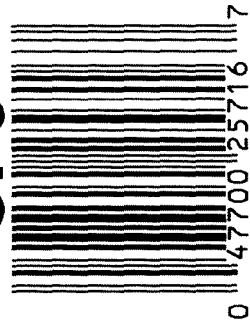
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801375

UPC



GUN SERIAL #

G 6801375

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-14-08	S.P.D.
430	ASSEMBLE TO STOCK		10-14-08	SP
440	PROOF		10-14-08	S.P.D.
460	CHECK HEADSPACE		10-14-08	S.P.D.
470	DIS-ASSEMBLE ACTION		10-14-08	S.P.D.
472	SERIALIZE BOLT HANDLE		10-15-08	RT
475	DRILL AND TAP SIGHT HOLES		10/15/08	SP
480	MAGNAFLUX BBL ACTION		10/11/08	(S)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/17/08	RT
520	GOFF BLAST BBL / REC		10/20/08	DG
542	APPLY COATINGS (BARREL ACTION)		10/22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-23-08	S.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

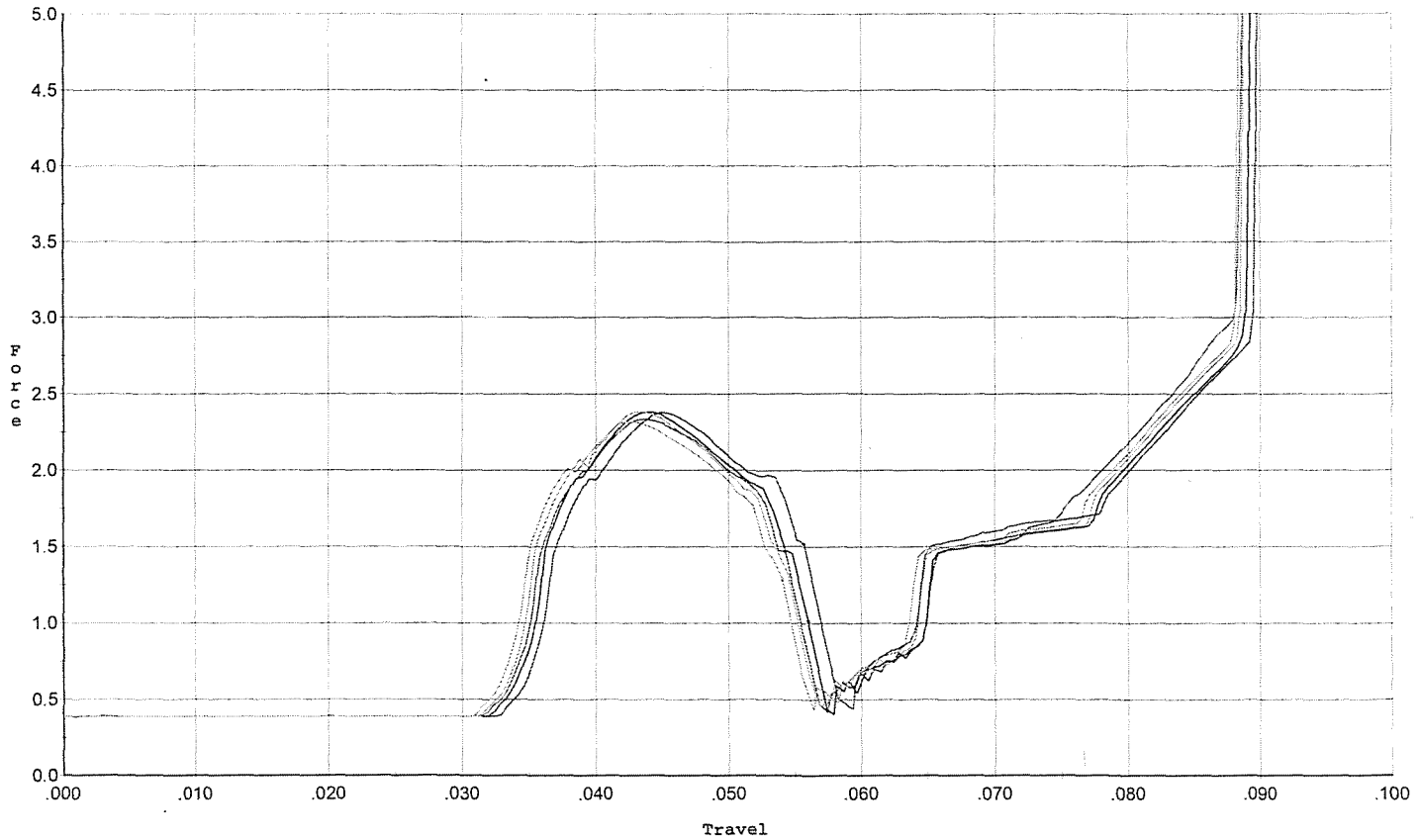
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0014551 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>45</u>	10-28-08	L N
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	10-28-08	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	10-28-08	L N
	J) ASSEMBLE STOCK		10-23-08	L N
	K) ASSEMBLE SWIVEL STUDS		10-28-08	L N
	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 FAIL PASS FAIL	10-27-08	FSU
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-27-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-28-08	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>267</u> <u>269</u> <u>261</u> <u>253</u> <u>251</u>	10-28-08	L N
	C) FUNCTION		10-28-08	L N
690	PACK		11/4/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



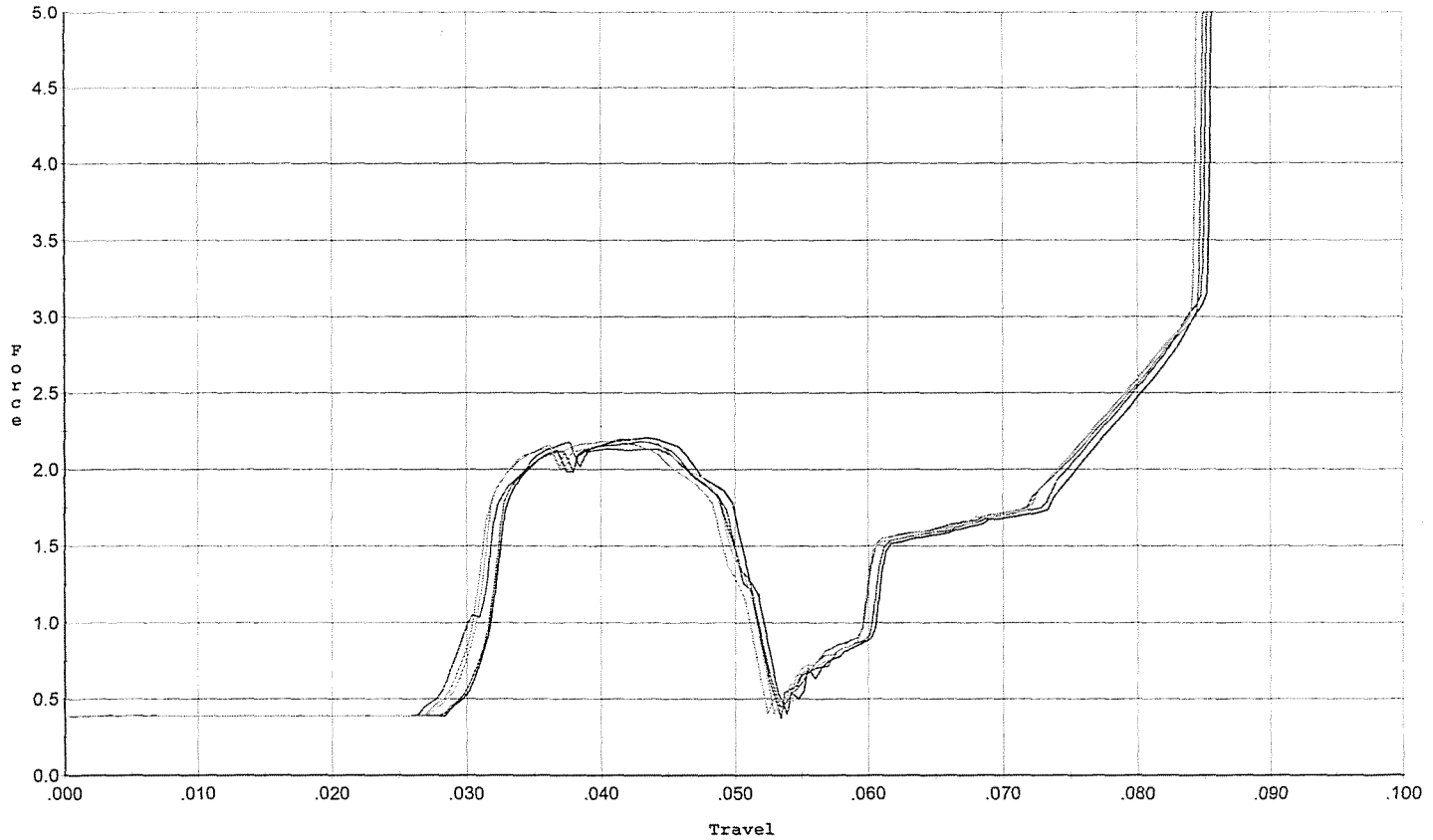
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.380	0.056	0.035	0.039	0.054		Set Trigger
2	2.381	0.056	0.034	0.039	0.055		Set Trigger
3	2.334	0.054	0.034	0.039	0.053		Set Trigger
4	2.386	0.055	0.034	0.039	0.054		Set Trigger
5	2.318	0.054	0.033	0.039	0.053		Set Trigger

A-236

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



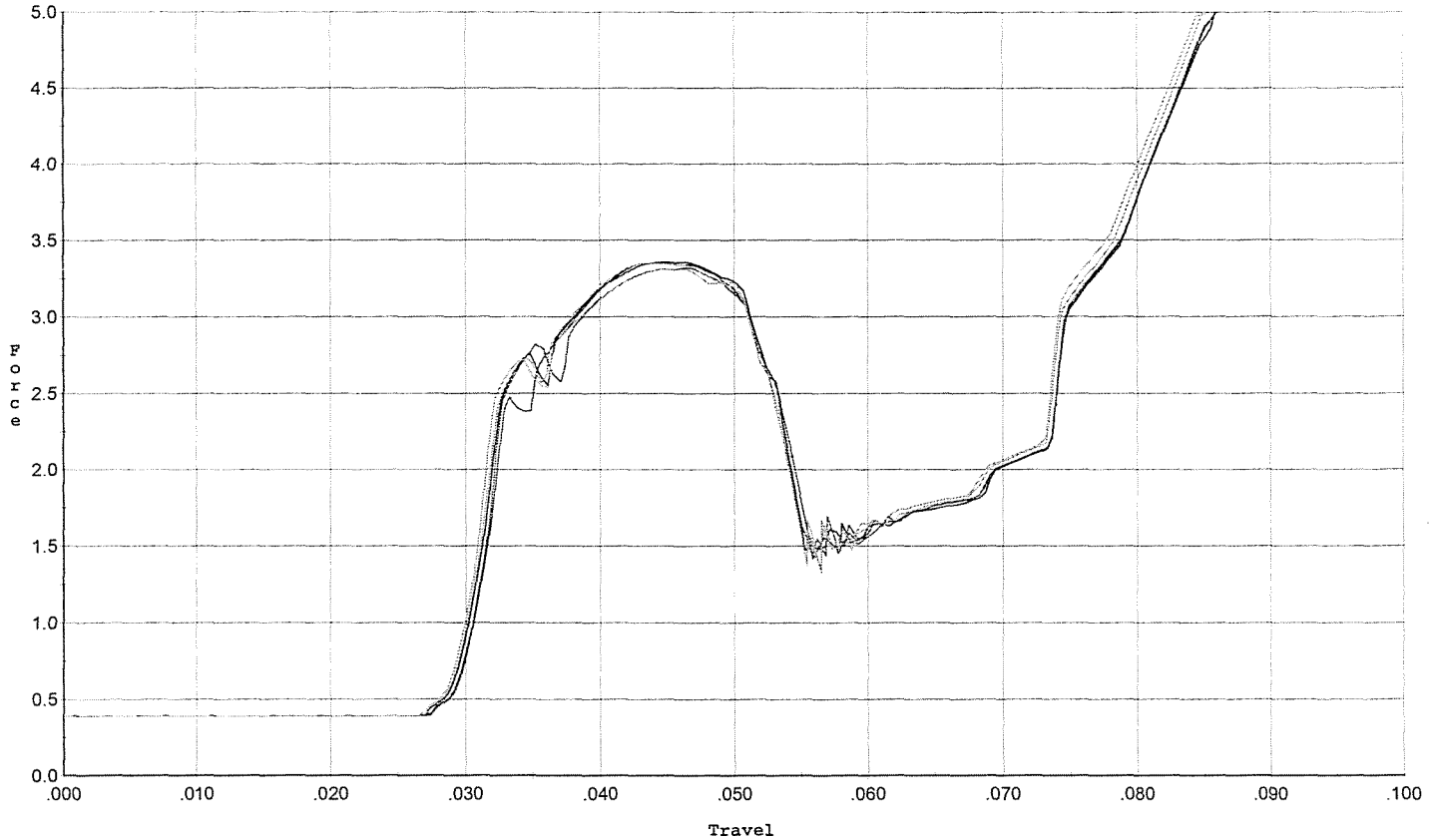
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.180	0.051	0.029	0.039	0.053		Set Trigger
2	2.204	0.052	0.031	0.038	0.052		Set Trigger
3	2.131	0.051	0.030	0.038	0.051		Set Trigger
4	2.200	0.051	0.029	0.038	0.053		Set Trigger
5	2.186	0.051	0.029	0.038	0.052		Set Trigger

A-2.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



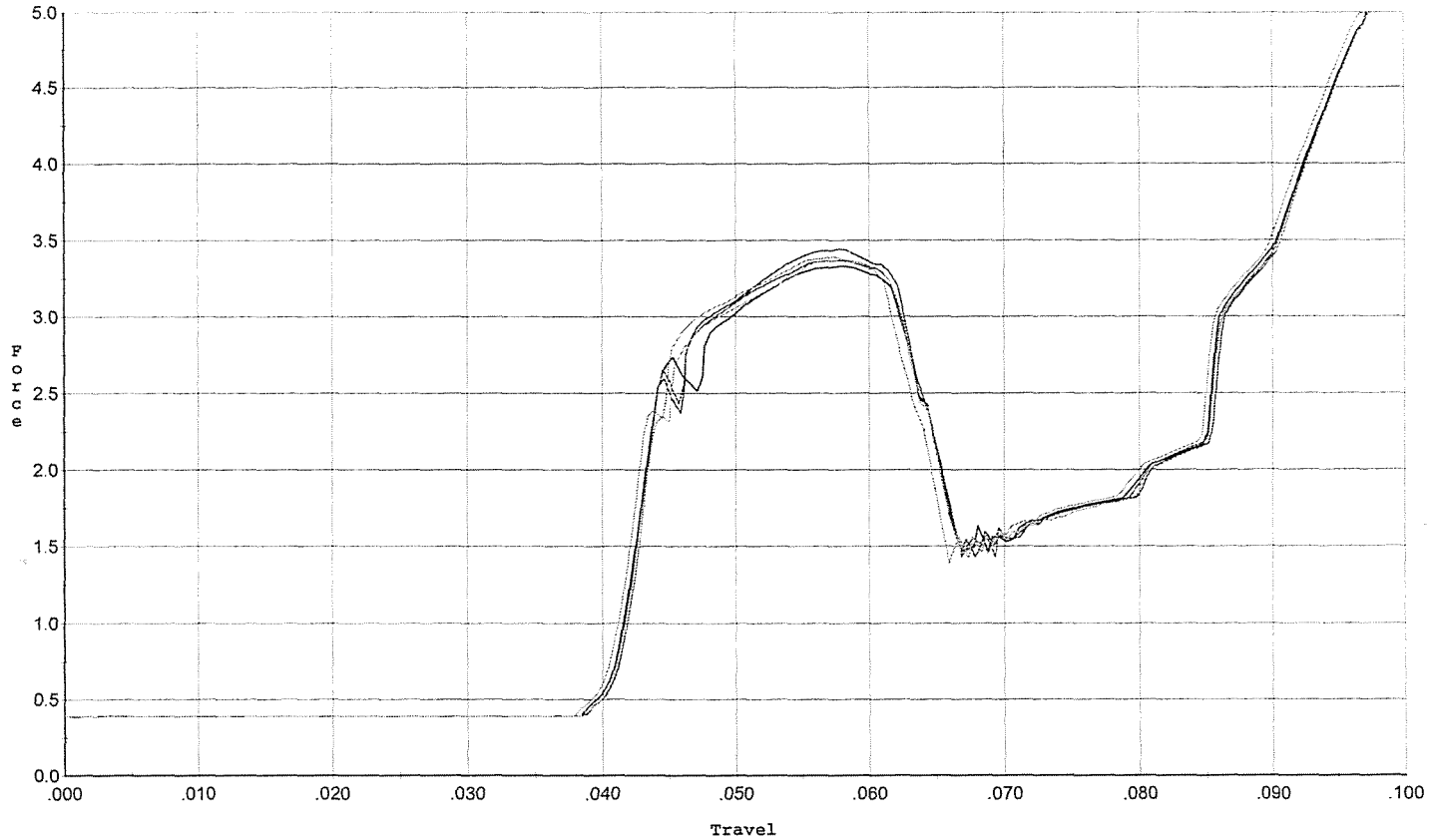
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.358	0.054	0.030	0.034	0.080		Set Trigger
2	3.358	0.053	0.029	0.034	0.079		Set Trigger
3	3.324	0.053	0.029	0.034	0.078		Set Trigger
4	3.312	0.053	0.029	0.034	0.080		Set Trigger
5	3.351	0.054	0.029	0.034	0.080		Set Trigger

A-3.34

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



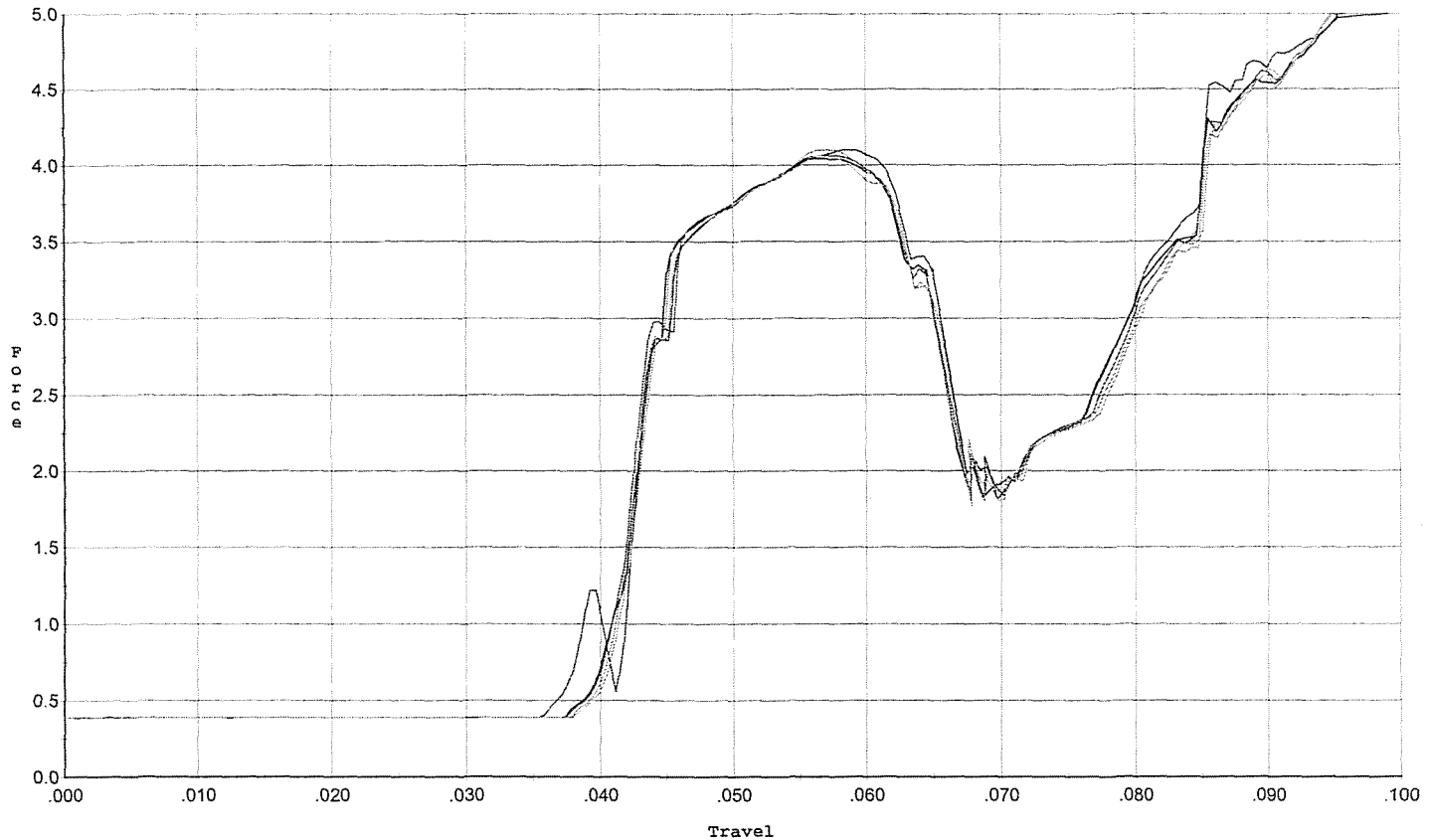
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.444	0.064	0.041	0.038	0.085		Set Trigger
2	3.332	0.064	0.041	0.038	0.083		Set Trigger
3	3.370	0.062	0.041	0.039	0.080		Set Trigger
4	3.373	0.064	0.041	0.038	0.083		Set Trigger
5	3.394	0.064	0.040	0.038	0.084		Set Trigger

A-3.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



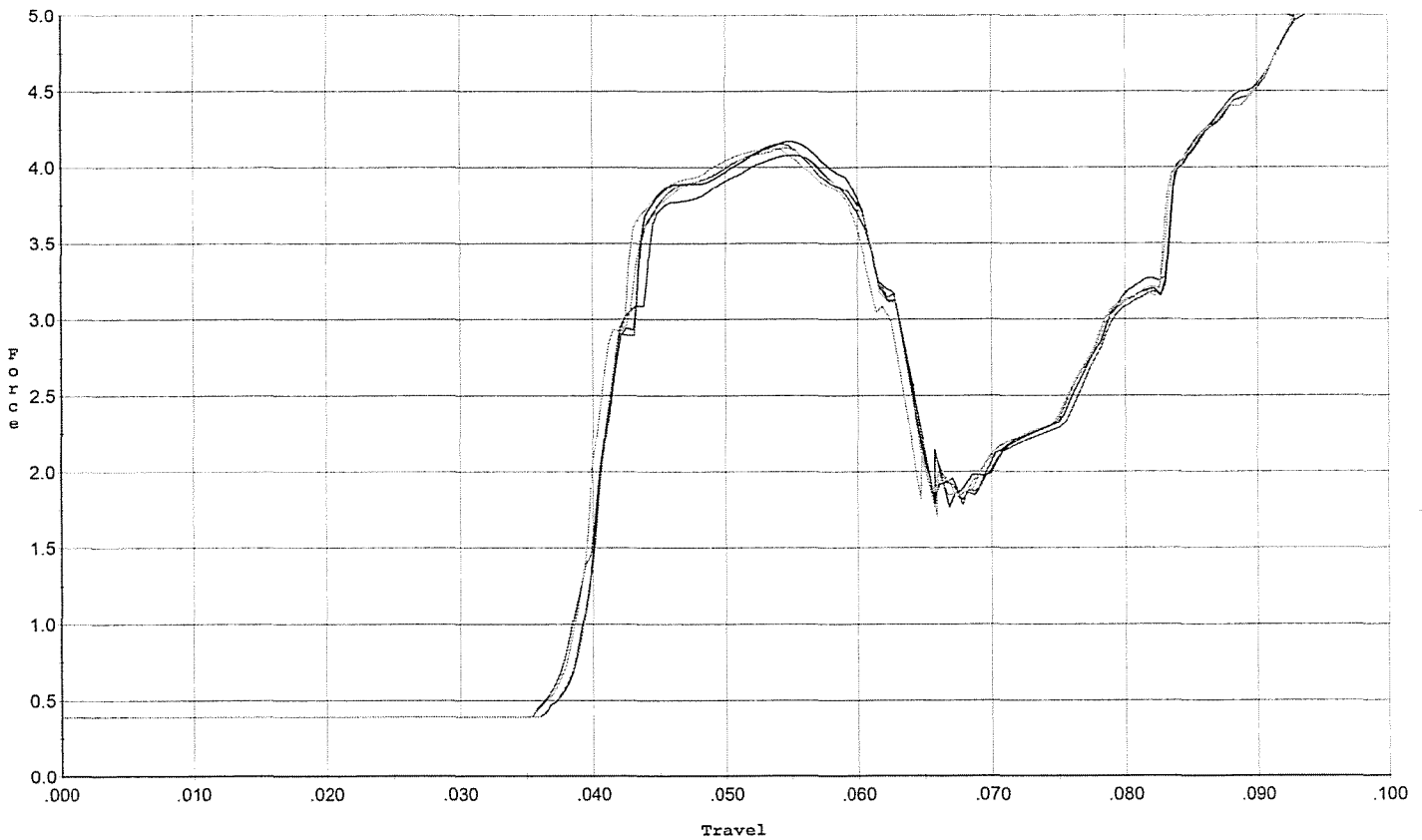
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.065	0.036	0.036	0.103		Set Trigger
2	4.045	0.064	0.040	0.036	0.100		Set Trigger
3	4.064	0.065	0.040	0.036	0.101		Set Trigger
4	4.061	0.065	0.040	0.036	0.101		Set Trigger
5	4.100	0.065	0.040	0.036	0.101		Set Trigger

A 4.07

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



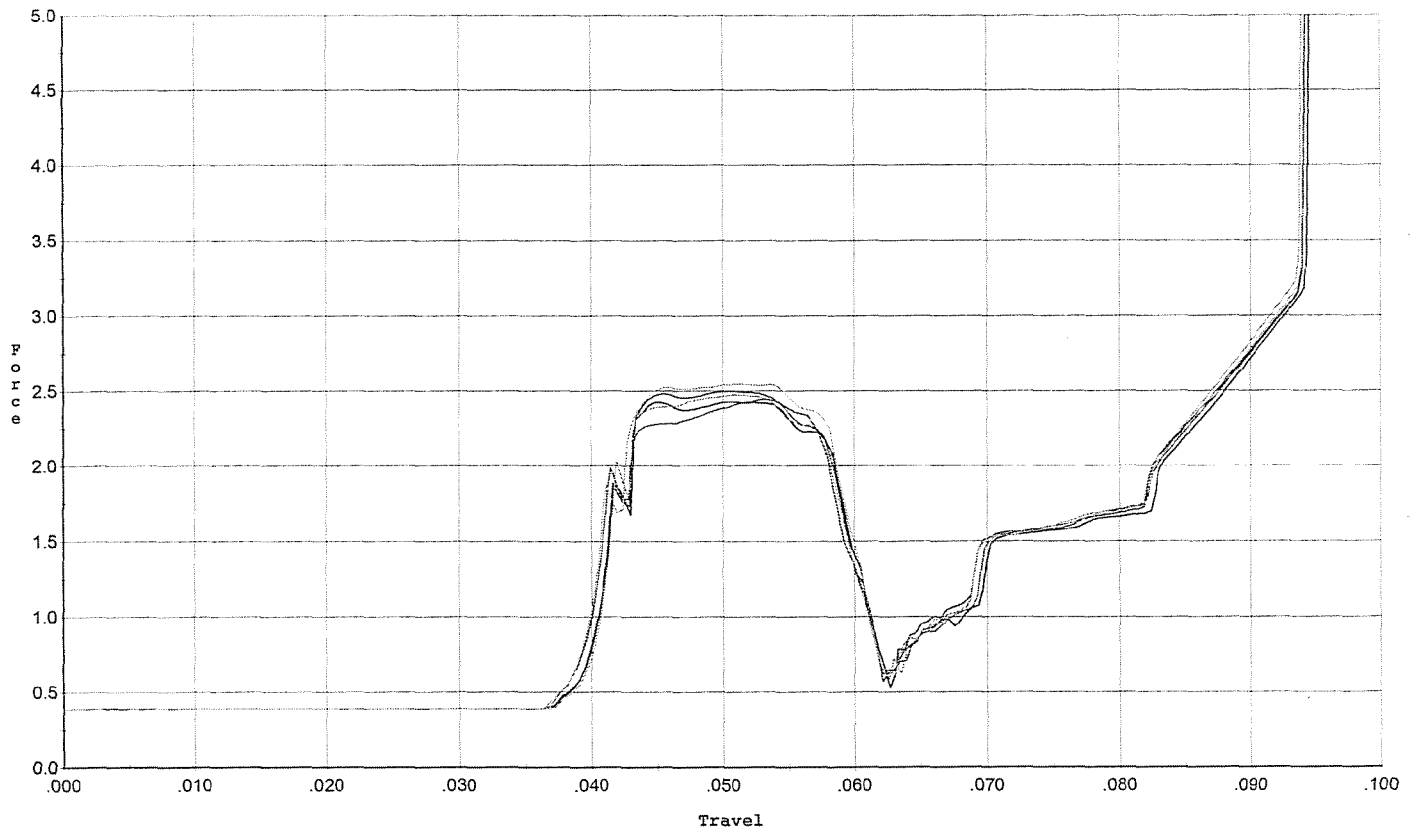
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.079	0.064	0.036	0.036	0.103		Set Trigger
2	4.169	0.063	0.037	0.037	0.101		Set Trigger
3	4.153	0.063	0.038	0.037	0.101		Set Trigger
4	4.126	0.063	0.038	0.036	0.101		Set Trigger
5	4.123	0.062	0.038	0.037	0.101		Set Trigger

A. 4.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



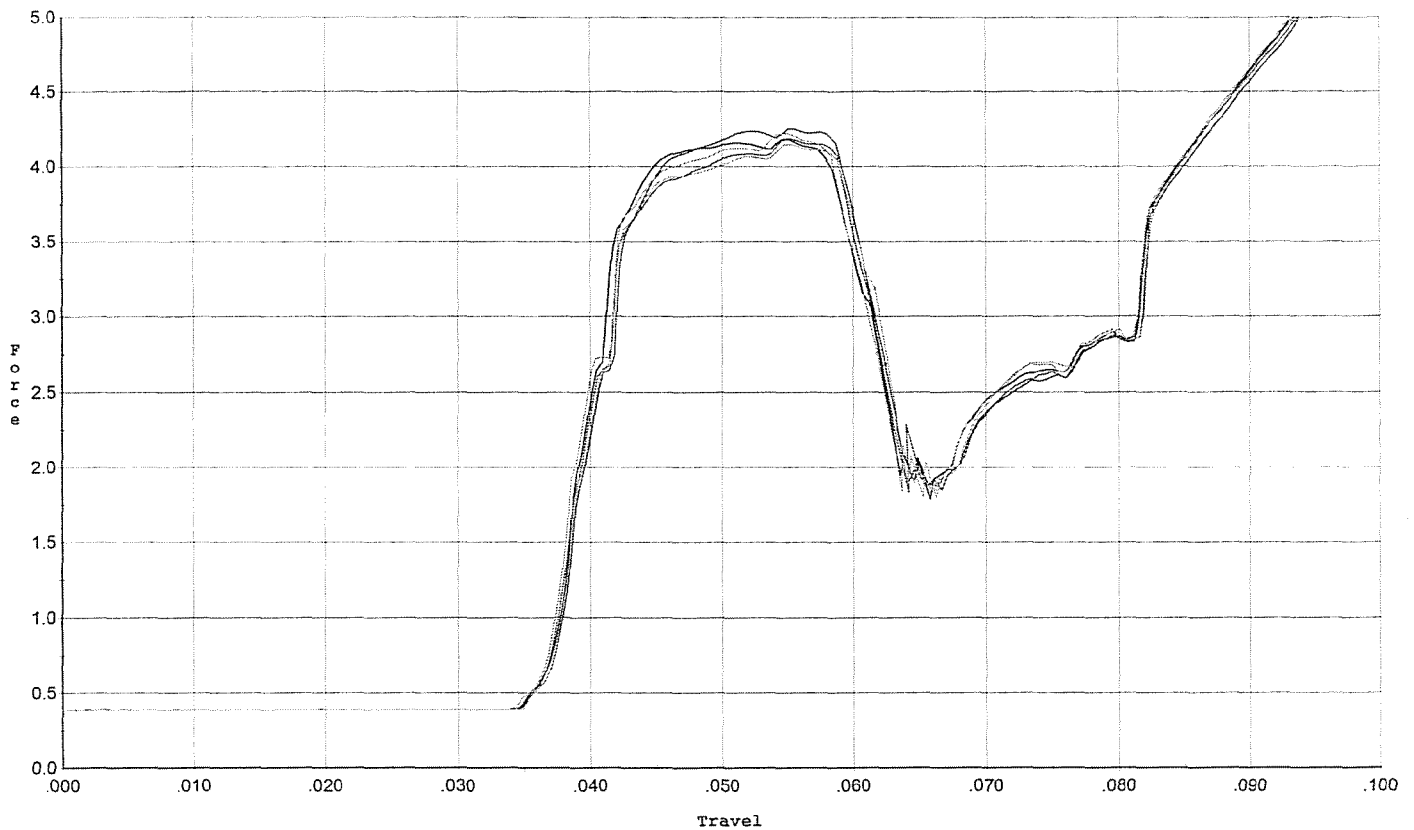
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.061	0.039	0.040	0.061		Set Trigger
2	2.427	0.058	0.040	0.041	0.057		Set Trigger
3	2.446	0.058	0.037	0.041	0.057		Set Trigger
4	2.545	0.060	0.039	0.040	0.063		Set Trigger
5	2.477	0.059	0.038	0.041	0.058		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

Model: M/24
Serial No: Form #F005
Trigger: set tot4.0 lbs. +/- 1.0 lbs for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.253	0.062	0.037	0.036	0.104		Set Trigger
2	4.183	0.061	0.035	0.036	0.102		Set Trigger
3	4.189	0.061	0.035	0.037	0.101		Set Trigger
4	4.150	0.062	0.035	0.036	0.102		Set Trigger
5	4.220	0.062	0.035	0.036	0.103		Set Trigger

A-4.19