

66801463

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

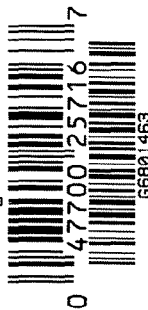
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



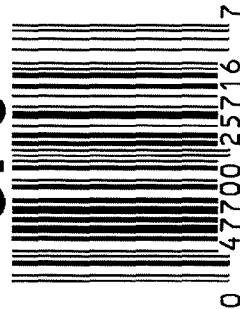
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801463

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801463

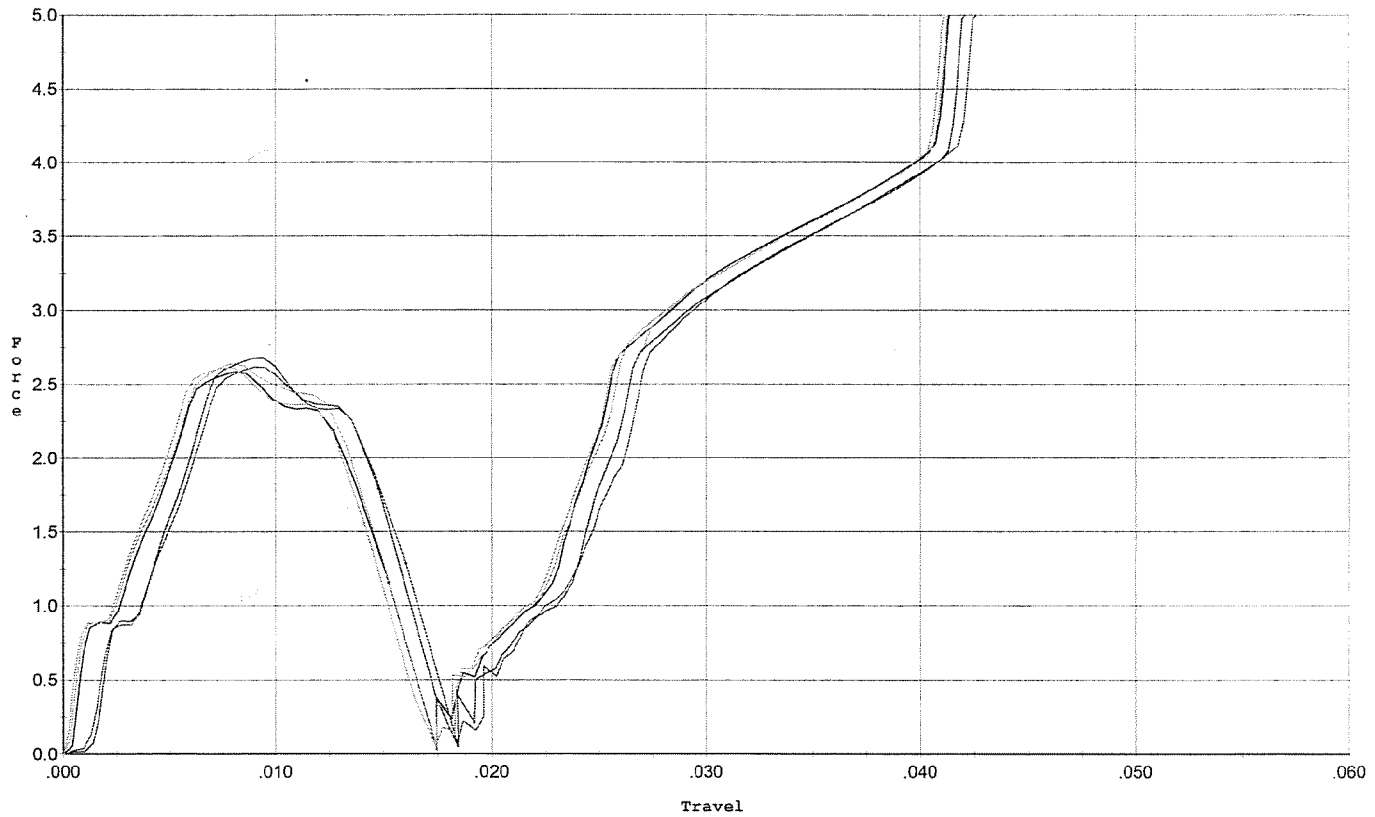
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR	3/9/09	SP
490	MAGNAFLUX BOLT		3/9/09	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)		3/8	
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		3-21-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP # OPERATION NAME			READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	3.0	2.8	2.8	3/23/09	RP		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	5.8	5.6	5.6	3/23/09	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.022	.022	.022	3/23/09	RP		
	J) ASSEMBLE STOCK					3/21/09	TL		
	K) ASSEMBLE SWIVEL STUDS					3/23/09	RP		
	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		3-23-09	TL		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					3-23-09	WW		
670	FINAL INSPECTION A) HEADSPACE					3/23/09	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.68	2.66	2.67	2.65	2.63	3-23-09	TL
	C) FUNCTION							3/23/09	RP
690	PACK							3/24/09	Fm

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



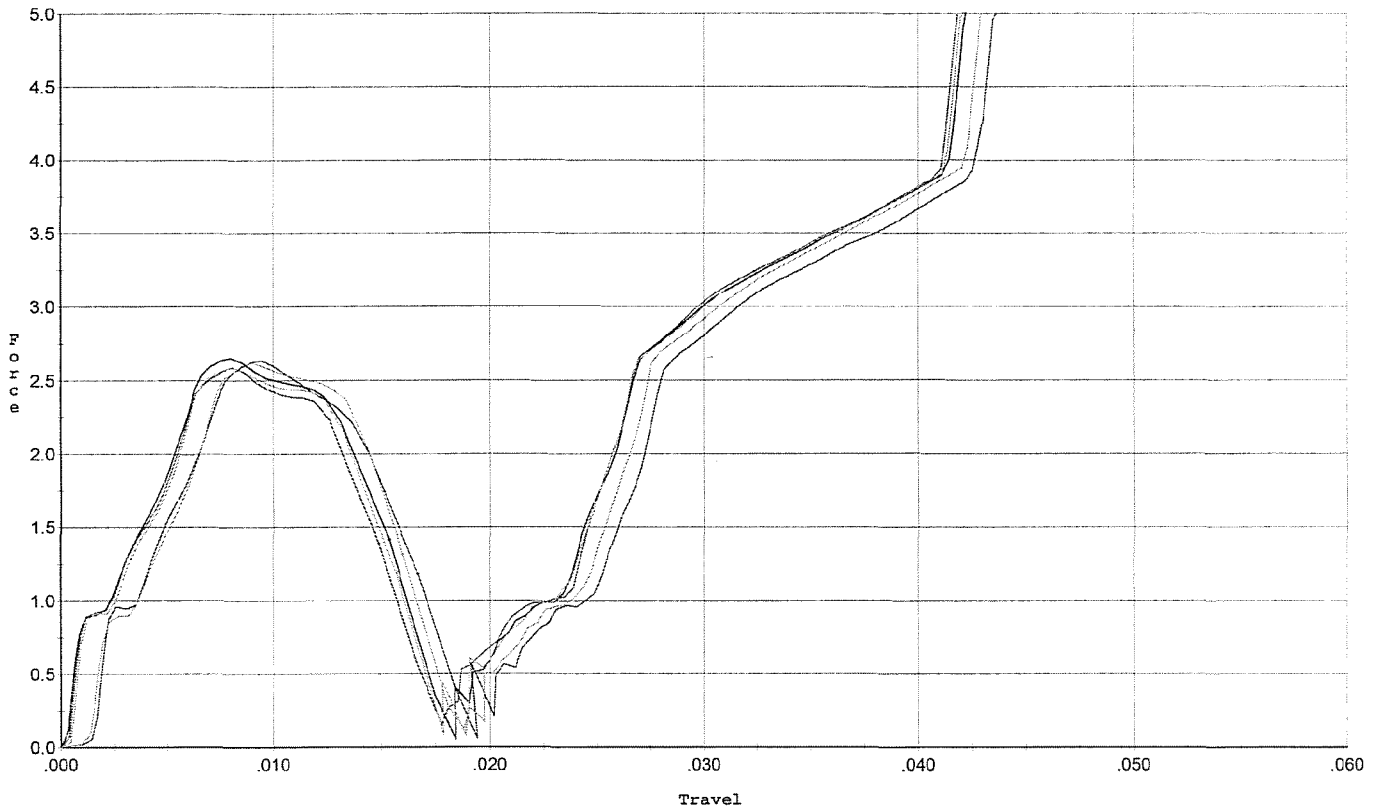
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.680	0.015	0.00	0.030	0.025		Set Trigger
2	2.586	0.015	0.00	0.029	0.026		Set Trigger
3	2.616	0.016	0.00	0.030	0.026		Set Trigger
4	2.610	0.014	0.00	0.030	0.025		Set Trigger
5	2.642	0.015	0.00	0.029	0.027		Set Trigger

A-2.62

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



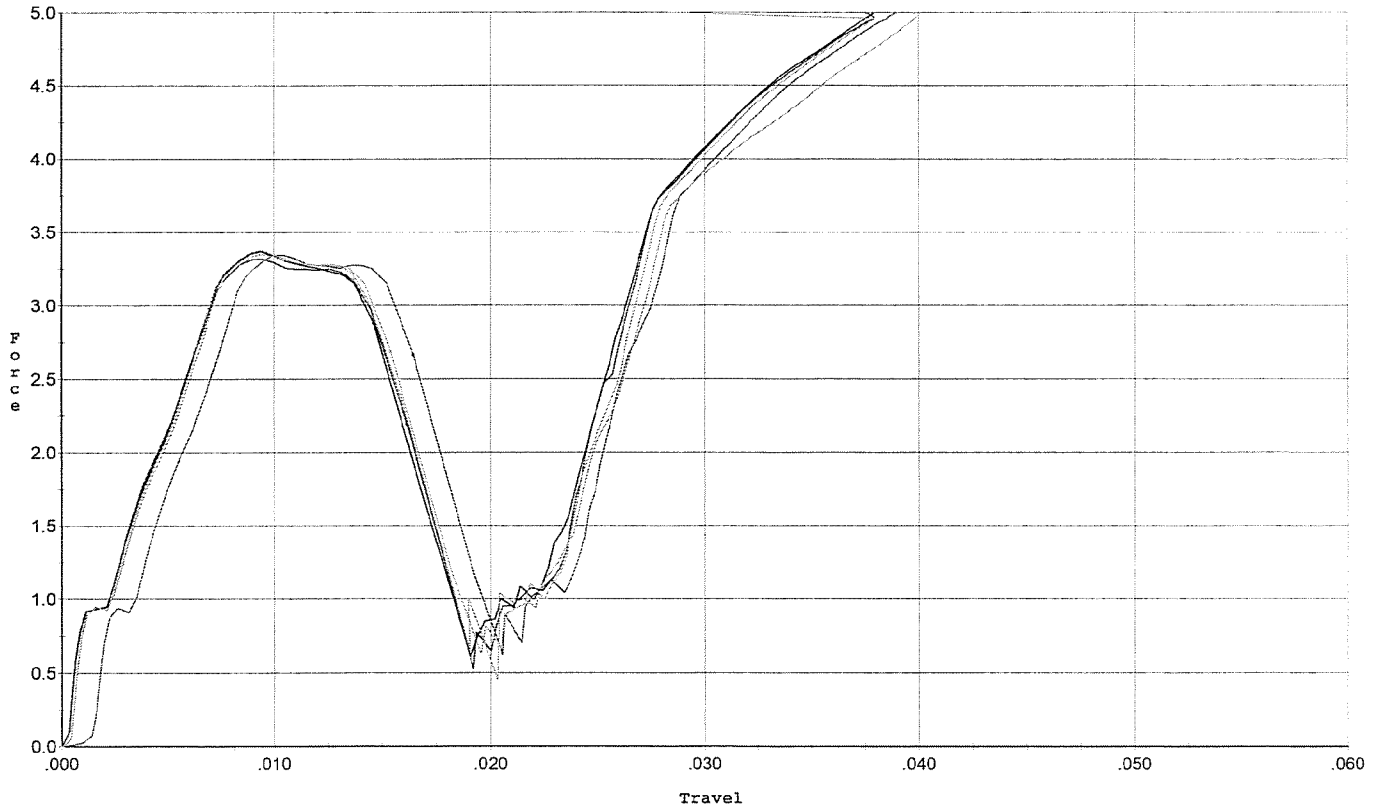
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.636	0.017	0.00	0.031	0.027		Set Trigger
2	2.653	0.015	0.00	0.030	0.027		Set Trigger
3	2.591	0.015	0.00	0.030	0.026		Set Trigger
4	2.586	0.016	0.00	0.030	0.027		Set Trigger
5	2.622	0.016	0.00	0.030	0.026		Set Trigger

A-2-61

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



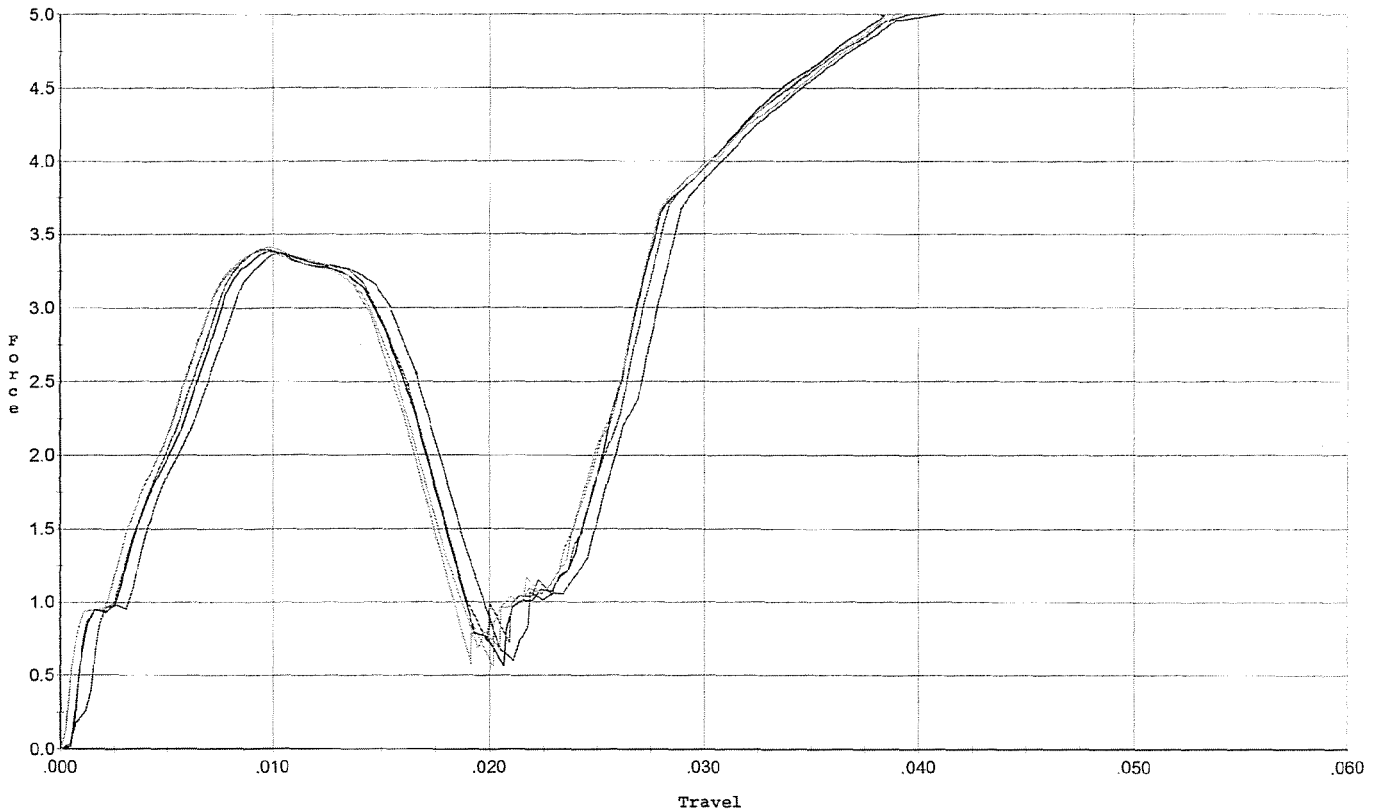
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.317	0.016	0.00	0.027	0.036		Set Trigger
2	3.369	0.015	0.00	0.027	0.033		Set Trigger
3	3.345	0.016	0.00	0.028	0.035		Set Trigger
4	3.351	0.015	0.00	0.027	0.035		Set Trigger
5	3.380	0.016	0.00	0.028	0.036		Set Trigger

A-3-35

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



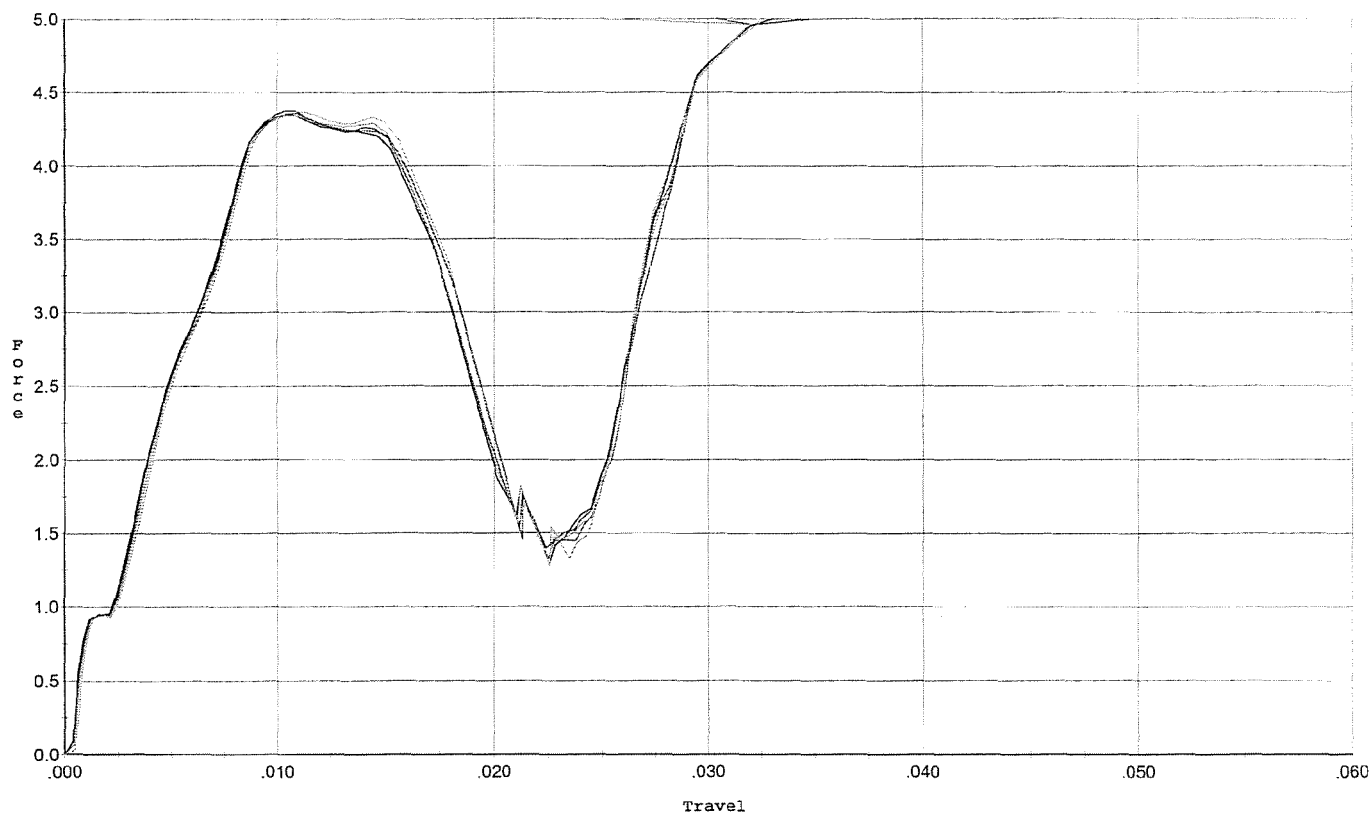
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.376	0.017	0.00	0.028	0.036		Set Trigger
2	3.390	0.016	0.00	0.027	0.036		Set Trigger
3	3.397	0.016	0.00	0.028	0.036		Set Trigger
4	3.412	0.016	0.00	0.027	0.036		Set Trigger
5	3.384	0.016	0.00	0.027	0.036		Set Trigger

A 3.39

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



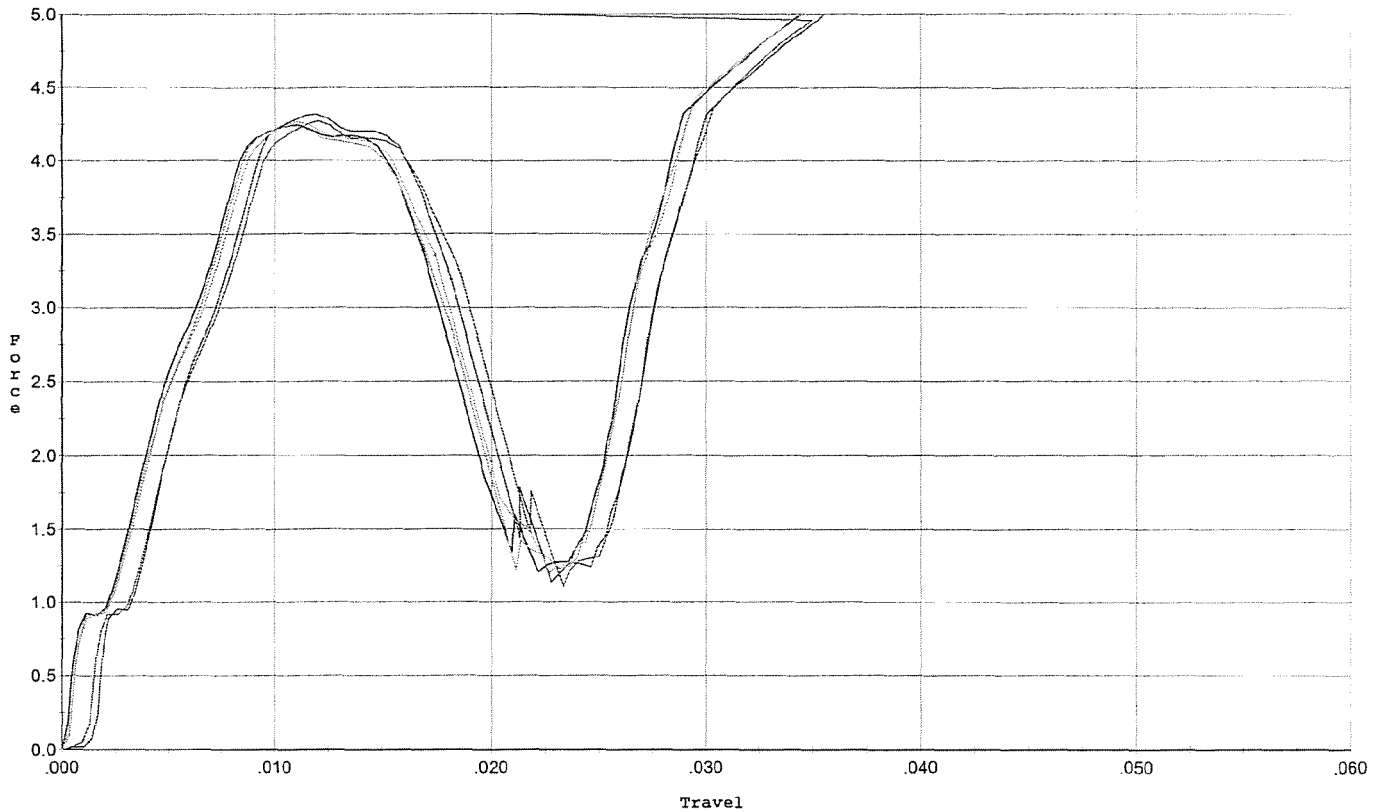
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.375	0.017	0.00	0.025	0.049		Set Trigger
2	4.355	0.017	0.00	0.026	0.049		Set Trigger
3	4.358	0.018	0.00	0.025	0.052		Set Trigger
4	4.371	0.018	0.00	0.025	0.051		Set Trigger
5	4.345	0.017	0.00	0.026	0.049		Set Trigger

A 4.36

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



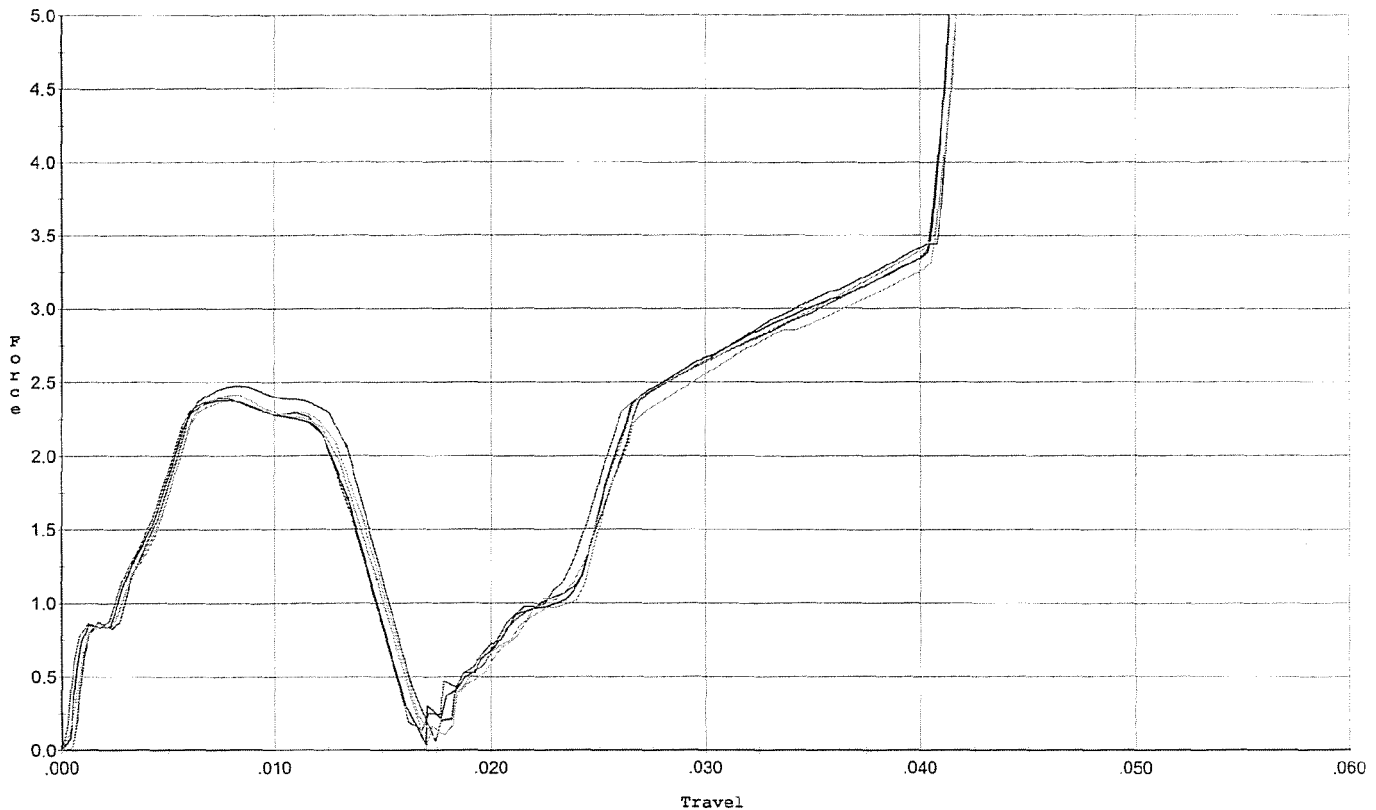
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.318	0.018	0.00	0.027	0.049		Set Trigger
2	4.246	0.017	0.00	0.026	0.047		Set Trigger
3	4.273	0.019	0.00	0.027	0.050		Set Trigger
4	4.267	0.017	0.00	0.026	0.048		Set Trigger
5	4.241	0.018	0.00	0.026	0.050		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: reset to 2.5 lbs +/- .50 lb for final test



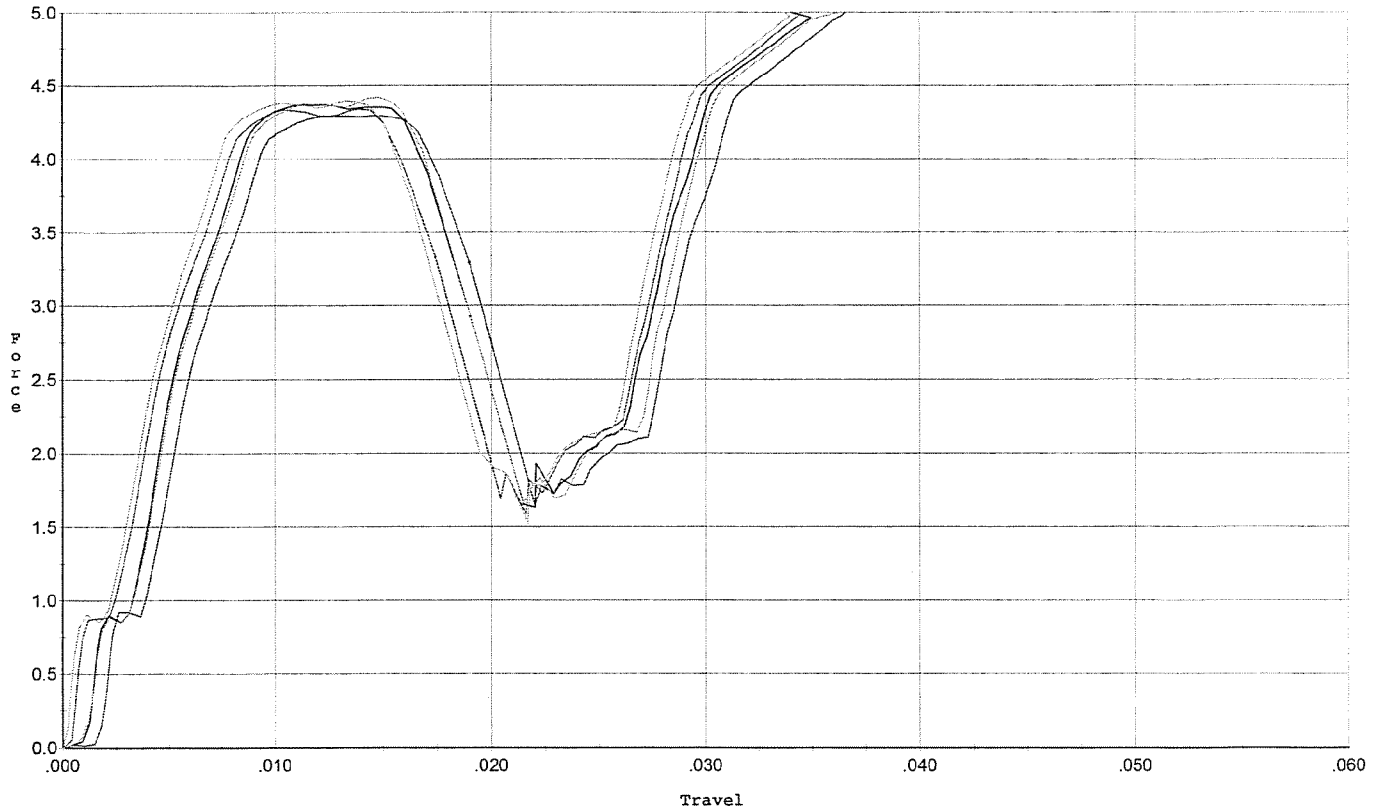
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.473	0.013	0.00	0.031	0.023		Set Trigger
2	2.380	0.013	0.003	0.031	0.022		Set Trigger
3	2.392	0.014	0.00	0.031	0.023		Set Trigger
4	2.374	0.014	0.00	0.031	0.023		Set Trigger
5	2.414	0.015	0.00	0.031	0.024		Set Trigger

A-2-40

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	4.292	0.019	0.004	0.024	0.052		Set Trigger
2	4.370	0.019	0.00	0.024	0.054		Set Trigger
3	4.338	0.017	0.002	0.023	0.051		Set Trigger
4	4.395	0.016	0.00	0.024	0.048		Set Trigger
5	4.418	0.019	0.00	0.024	0.054		Set Trigger

A-4.36