

56801474

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



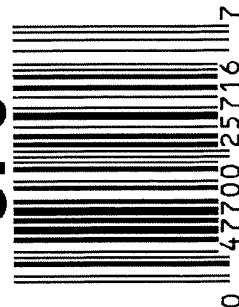
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801474

UPC



GUN SERIAL #

66801474

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	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES		2-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (P)	3/13/09	(P)
490	MAGNAFLUX BOLT		3/13/09	ML
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3-24	
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		3-26-09	R. N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

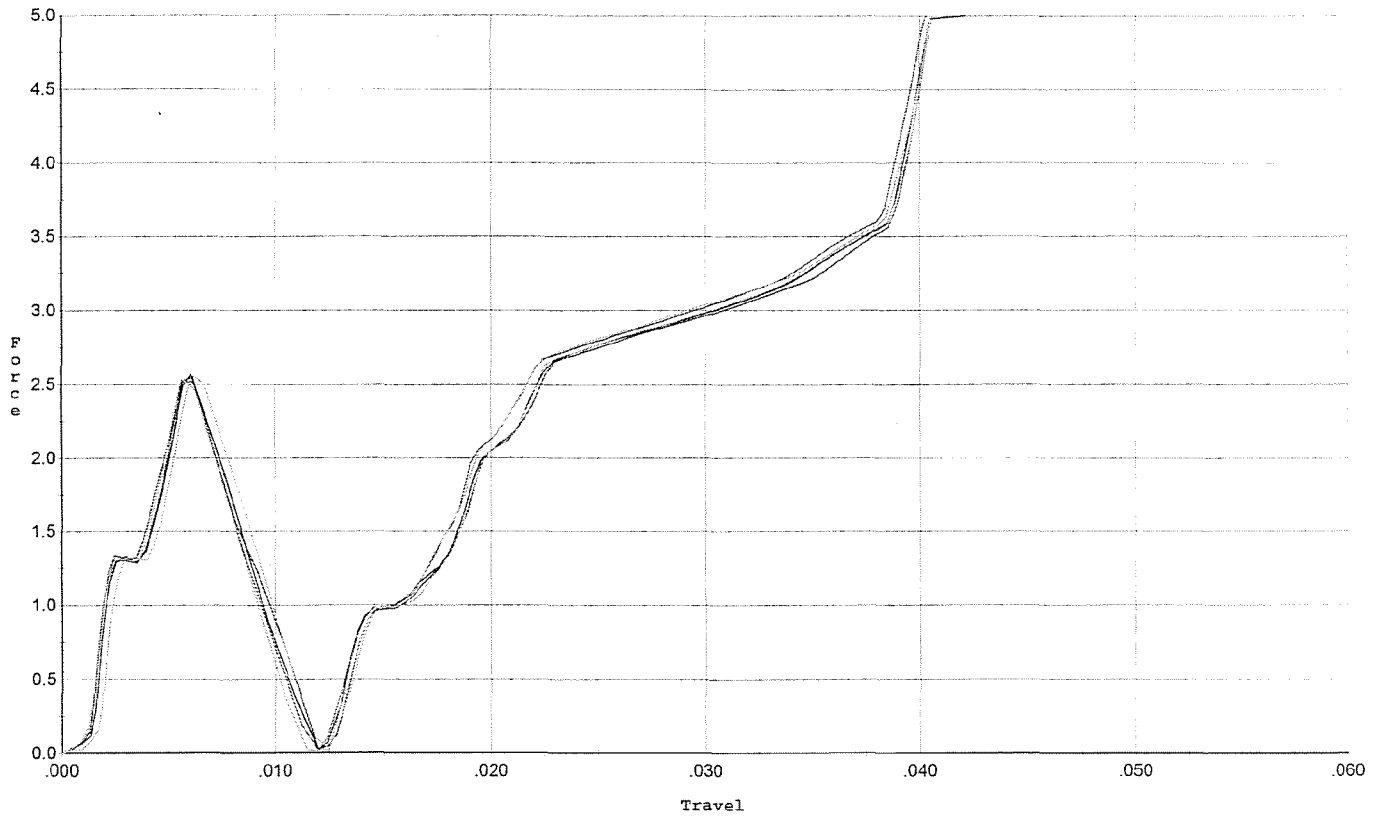
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.0</u>	3-30-09	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	3-30-09	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.033</u> <u>.033</u> <u>.033</u>	3-30-09	L N
	J) ASSEMBLE STOCK		3-26-09	L N
	K) ASSEMBLE SWIVEL STUDS		3-30-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-27-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	W N
670	FINAL INSPECTION A) HEADSPACE		3-30-09	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.41</u> <u>2.40</u> <u>2.37</u> <u>2.30</u> <u>2.32</u>	3-28-09	TL
	C) FUNCTION		3-30-09	L N
690	PACK		3/30/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



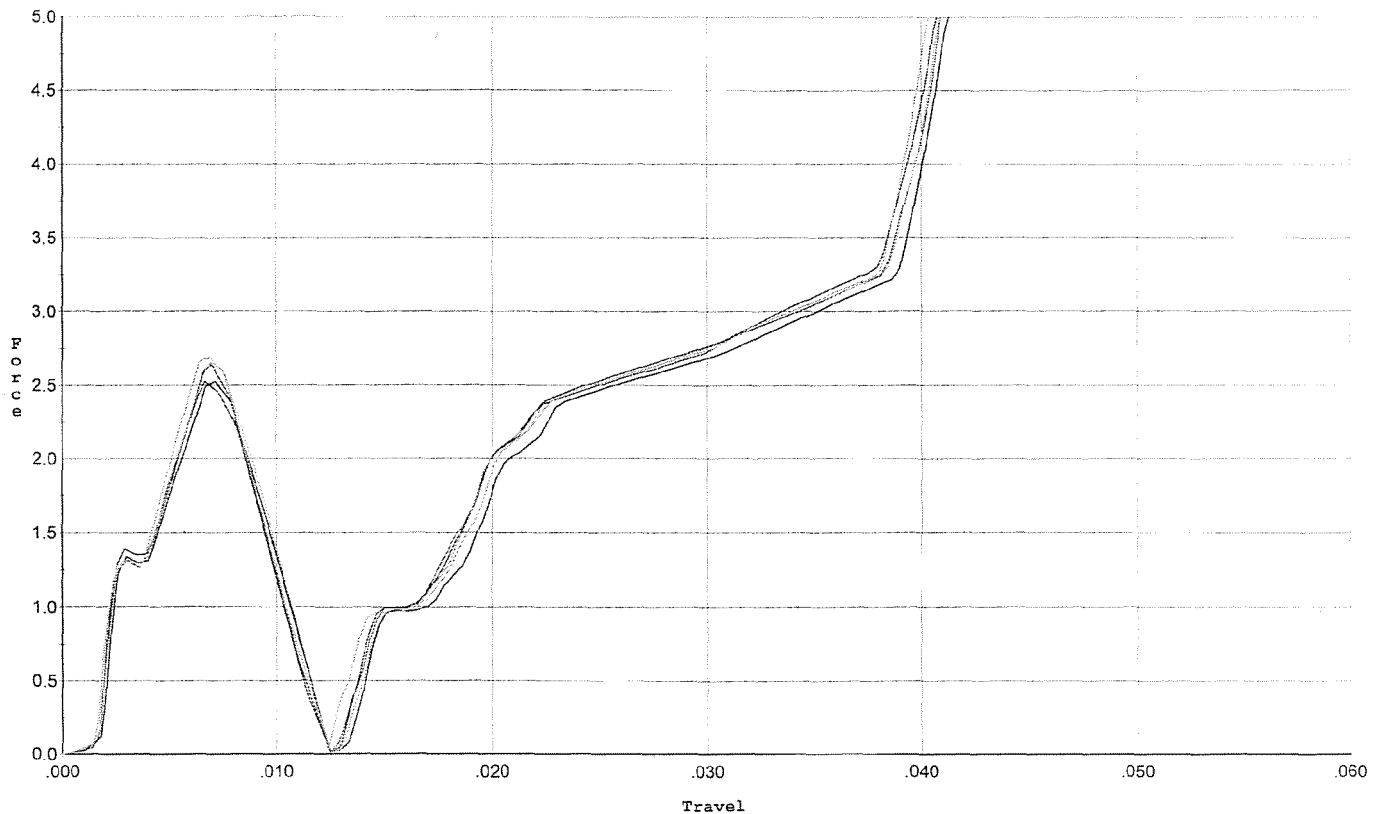
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.006	0.00	0.036	0.008		Set Trigger
2	2.572	0.008	0.00	0.035	0.010		Set Trigger
3	2.514	0.006	0.004	0.035	0.008		Set Trigger
4	2.566	0.008	0.004	0.035	0.011		Set Trigger
5	2.536	0.006	0.004	0.035	0.008		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



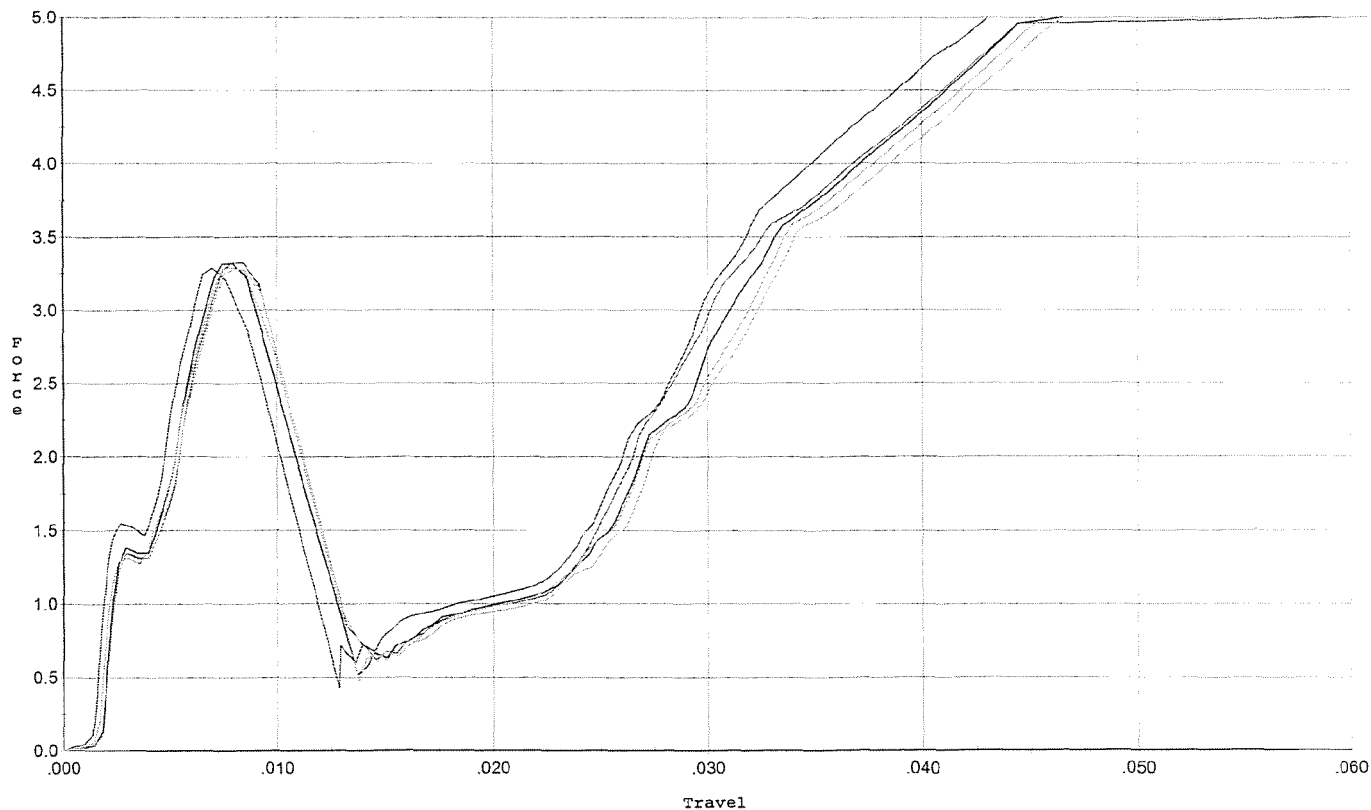
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.008	0.004	0.034	0.011		Set Trigger
2	2.525	0.010	0.00	0.035	0.013		Set Trigger
3	2.644	0.008	0.00	0.035	0.011		Set Trigger
4	2.659	0.009	0.00	0.034	0.013		Set Trigger
5	2.691	0.008	0.00	0.034	0.011		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



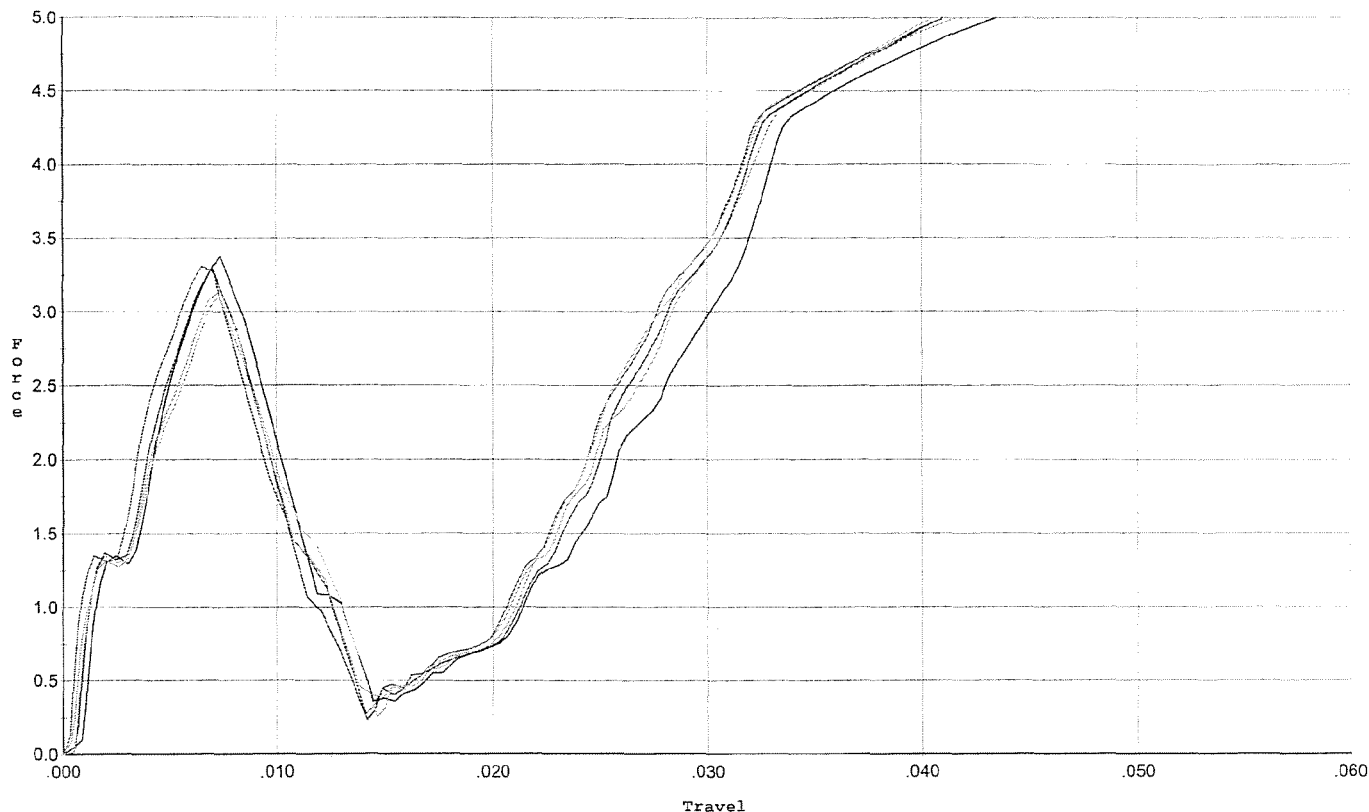
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.291	0.009	0.004	0.038	0.015		Set Trigger
2	3.320	0.009	0.004	0.039	0.015		Set Trigger
3	3.324	0.009	0.004	0.038	0.016		Set Trigger
4	3.282	0.009	0.00	0.039	0.016		Set Trigger
5	3.294	0.010	0.00	0.038	0.017		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



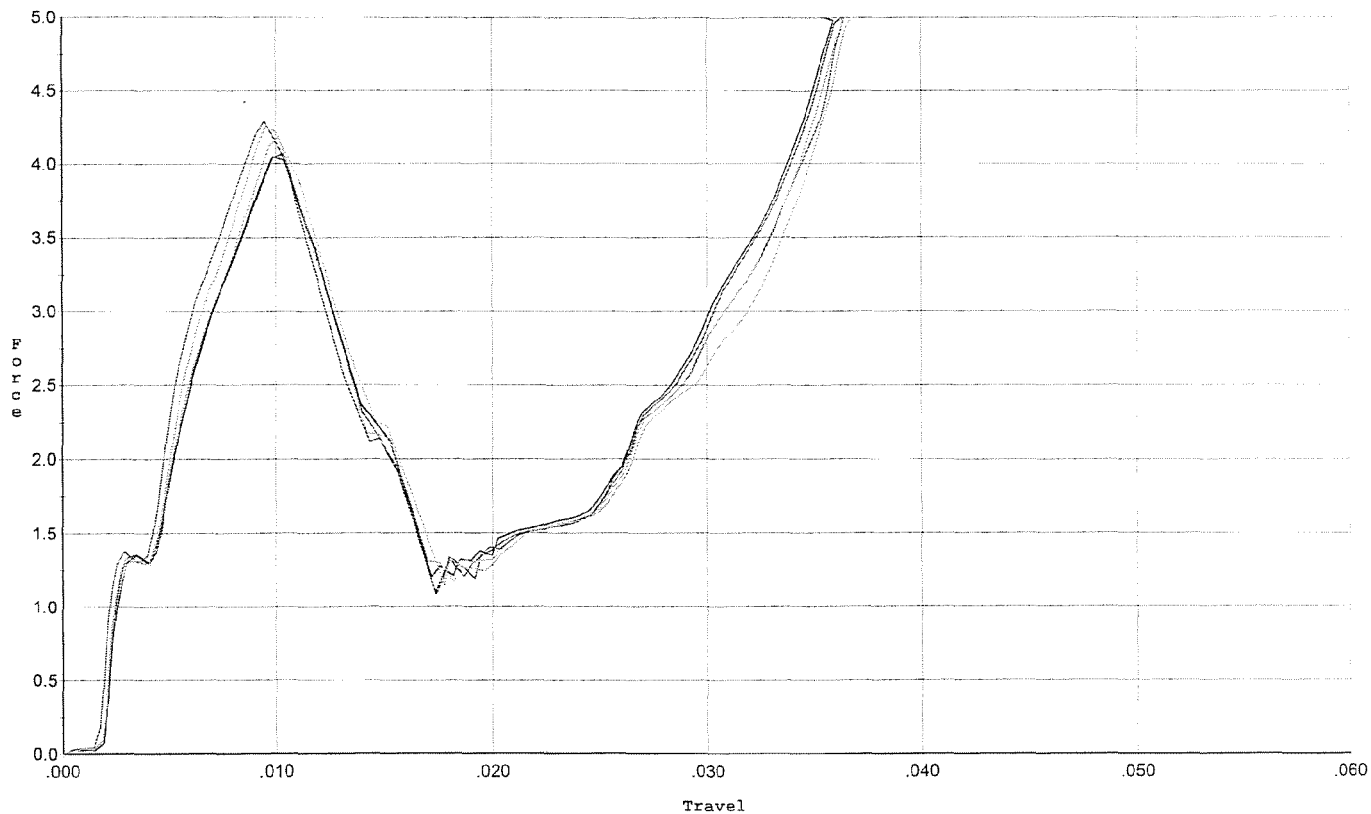
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.296	0.008	0.00	0.038	0.015		Set Trigger
2	3.380	0.009	0.00	0.038	0.016		Set Trigger
3	3.308	0.007	0.00	0.038	0.014		Set Trigger
4	3.112	0.008	0.00	0.037	0.014		Set Trigger
5	3.128	0.008	0.00	0.037	0.015		Set Trigger

A-3.24

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



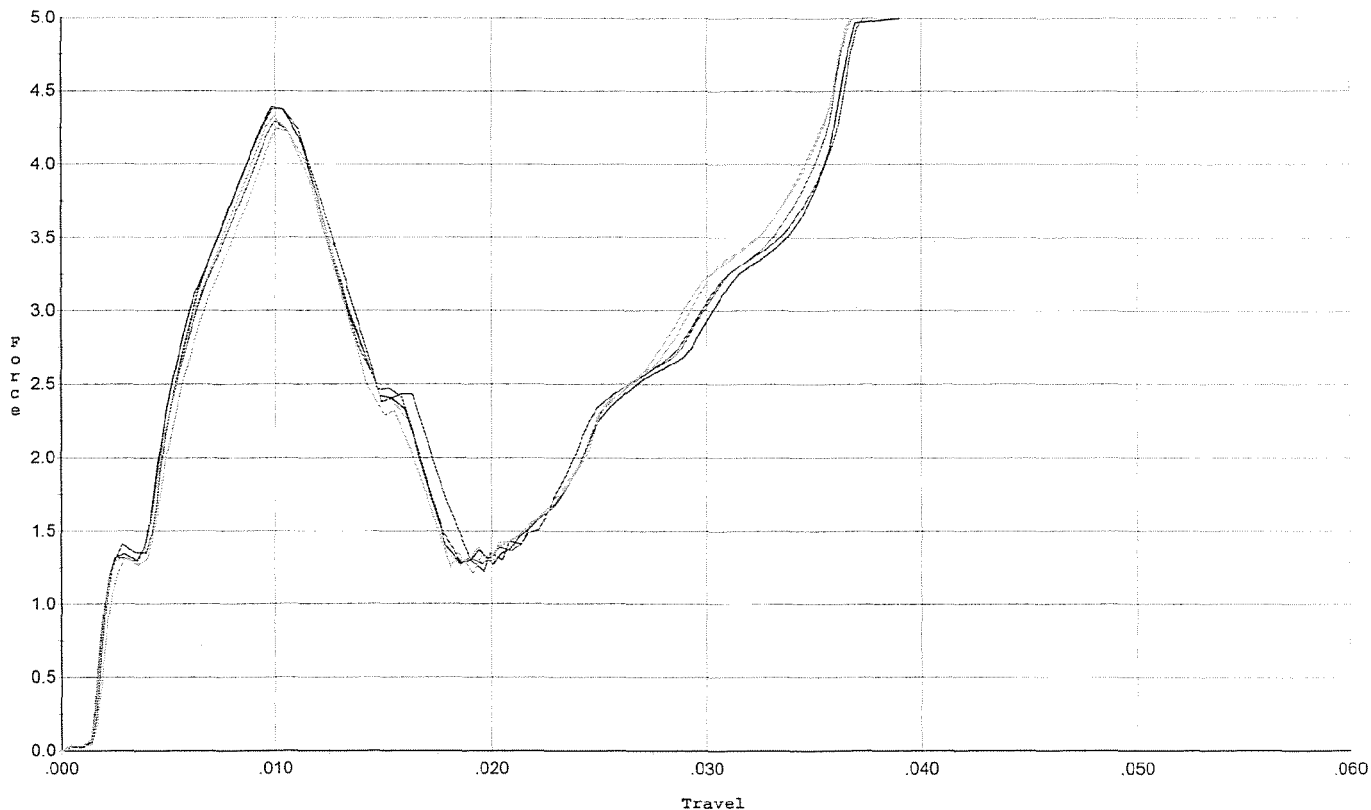
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.067	0.012	0.002	0.035	0.025		Set Trigger
2	4.048	0.012	0.00	0.034	0.025		Set Trigger
3	4.293	0.010	0.00	0.036	0.023		Set Trigger
4	4.255	0.012	0.004	0.035	0.026		Set Trigger
5	4.186	0.011	0.00	0.036	0.024		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



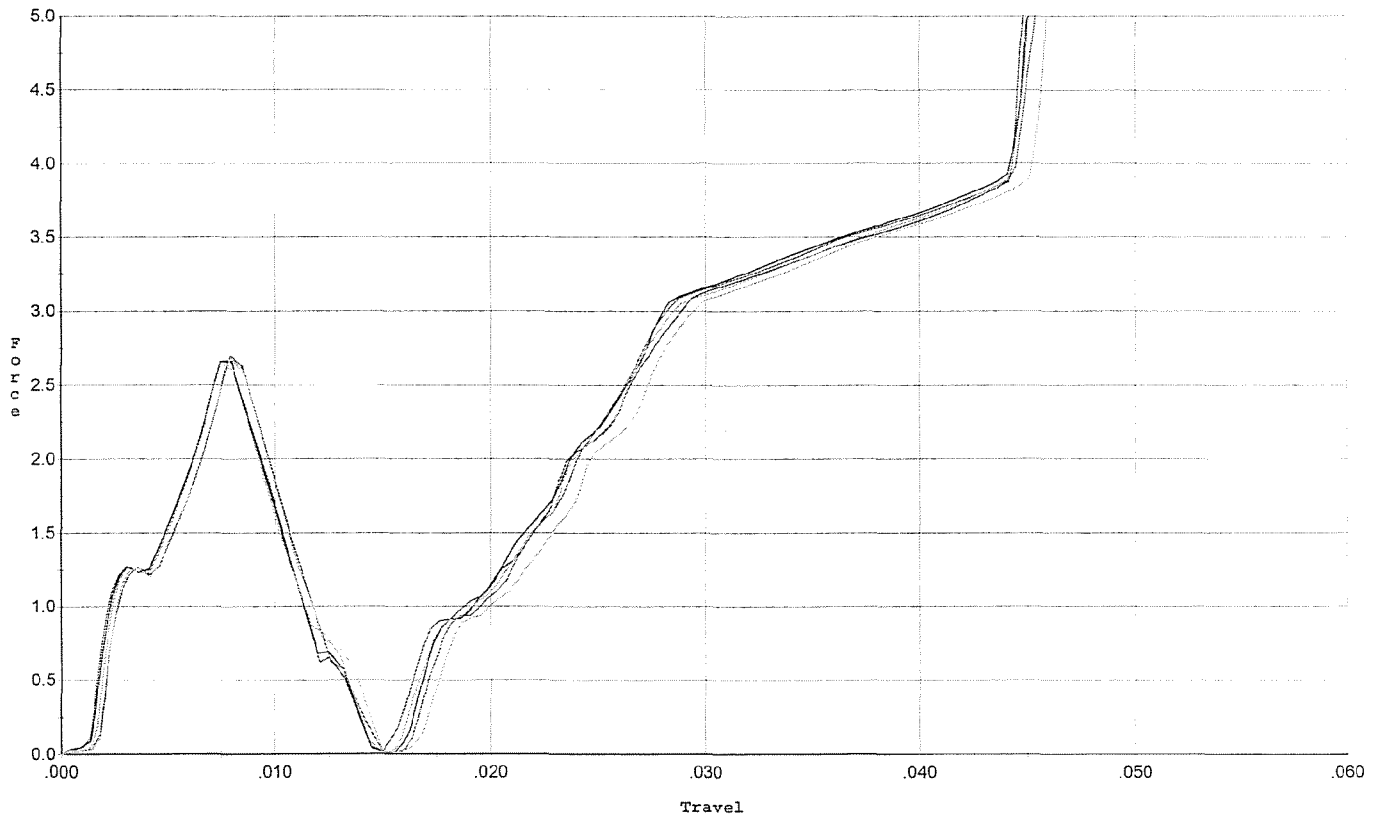
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.374	0.013	0.004	0.035	0.031		Set Trigger
2	4.393	0.011	0.00	0.035	0.027		Set Trigger
3	4.293	0.012	0.004	0.034	0.027		Set Trigger
4	4.329	0.012	0.00	0.034	0.027		Set Trigger
5	4.246	0.011	0.00	0.034	0.026		Set Trigger

A-4.32

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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	2.661	0.010	0.00	0.037	0.014		Set Trigger
2	2.663	0.010	0.00	0.037	0.014		Set Trigger
3	2.697	0.009	0.00	0.037	0.011		Set Trigger
4	2.685	0.009	0.00	0.038	0.011		Set Trigger
5	2.651	0.008	0.004	0.038	0.011		Set Trigger

A-2-67