

G-680 1488

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



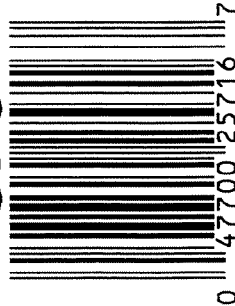
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801488

UPC



GUN SERIAL #

G 680 1488

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RTZ
480	MAGNAFLUX BBL ACTION		3/9/09	(D)
490	MAGNAFLUX BOLT			
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)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-27-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

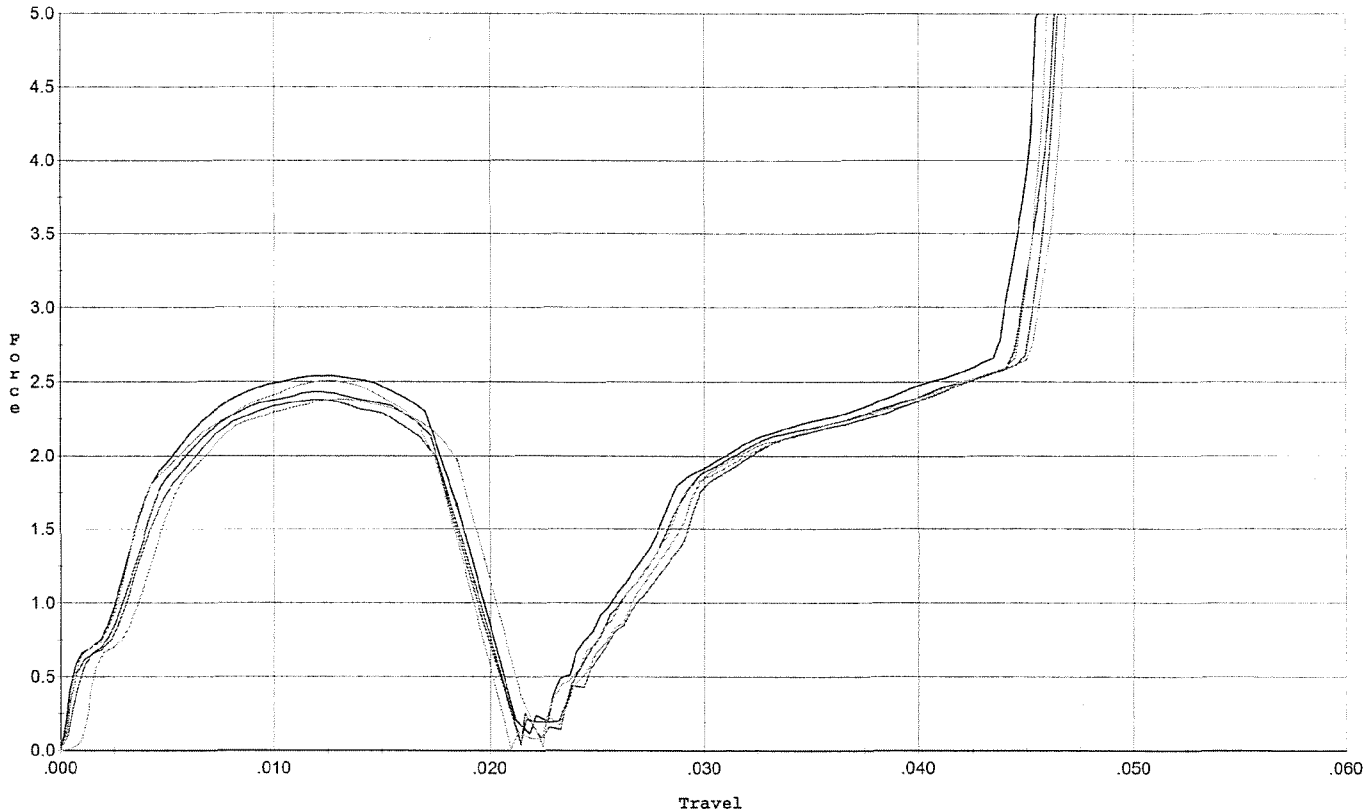
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	3-31-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-31-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	3-31-09	W/W
	J) ASSEMBLE STOCK		3-27-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-1-09	W/W
	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	3-30-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.54</u> <u>2.78</u> <u>2.60</u> <u>2.41</u>	3-31-09	W/W
	C) FUNCTION		3-31-09	W/W
690	PACK		5/29/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



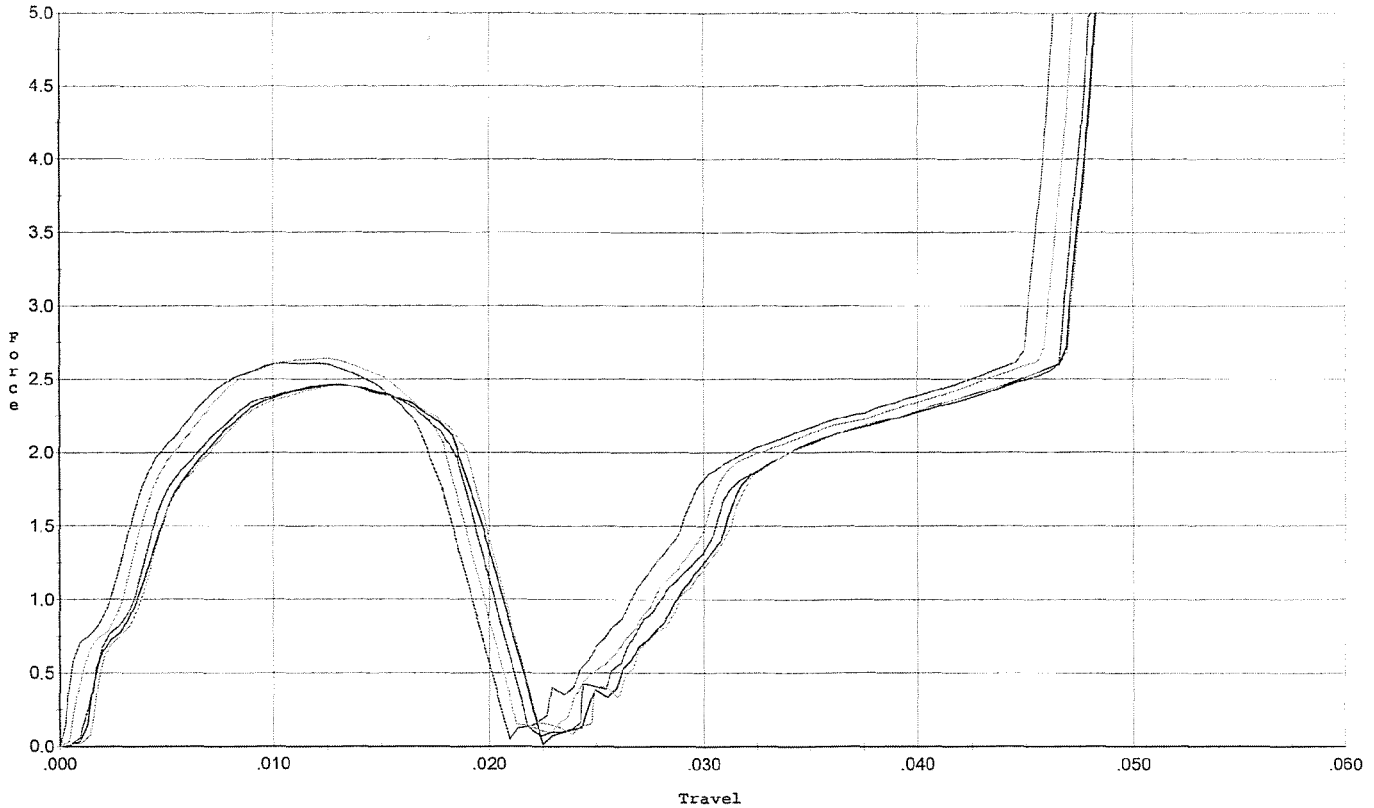
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.432	0.019	0.00	0.032	0.034		Set Trigger
2	2.539	0.018	0.00	0.031	0.035		Set Trigger
3	2.378	0.017	0.00	0.032	0.030		Set Trigger
4	2.508	0.018	0.00	0.032	0.032		Set Trigger
5	2.382	0.019	0.00	0.032	0.032		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



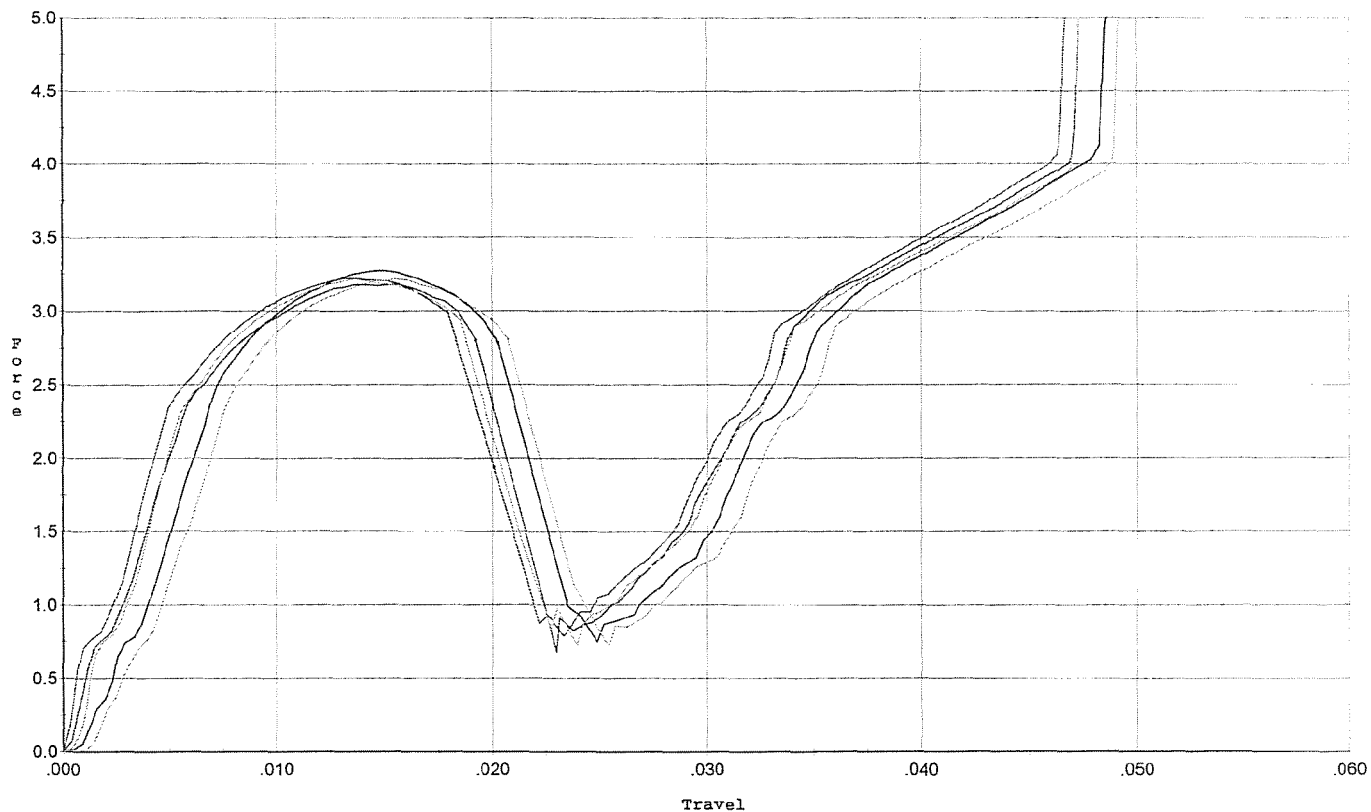
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.018	0.00	0.033	0.033		Set Trigger
2	2.466	0.020	0.00	0.033	0.034		Set Trigger
3	2.609	0.018	0.00	0.032	0.034		Set Trigger
4	2.455	0.019	0.00	0.033	0.033		Set Trigger
5	2.639	0.018	0.00	0.033	0.034		Set Trigger

A-252

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



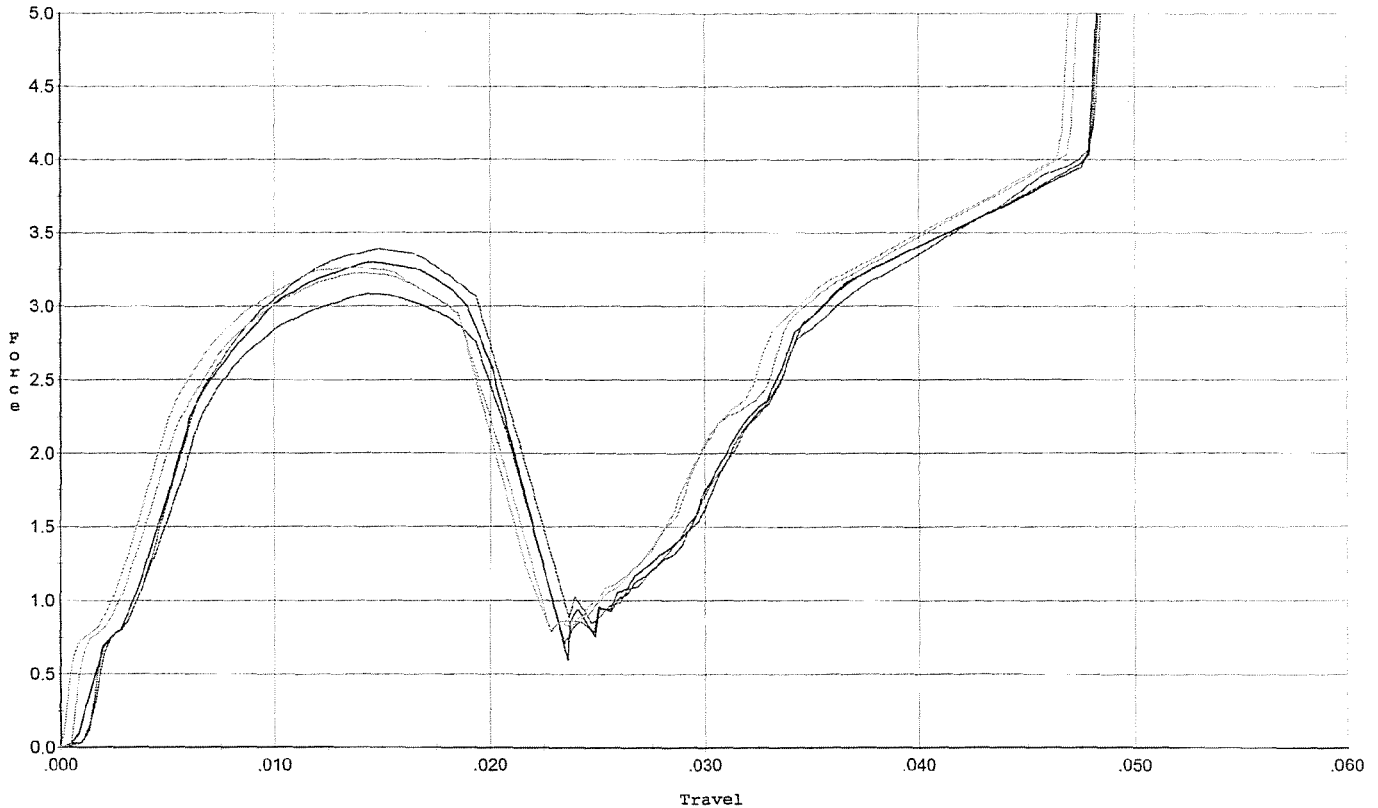
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.180	0.019	0.00	0.031	0.044		Set Trigger
2	3.272	0.020	0.00	0.031	0.045		Set Trigger
3	3.220	0.020	0.00	0.030	0.047		Set Trigger
4	3.218	0.021	0.00	0.032	0.044		Set Trigger
5	3.218	0.019	0.00	0.031	0.042		Set Trigger

A-3.22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



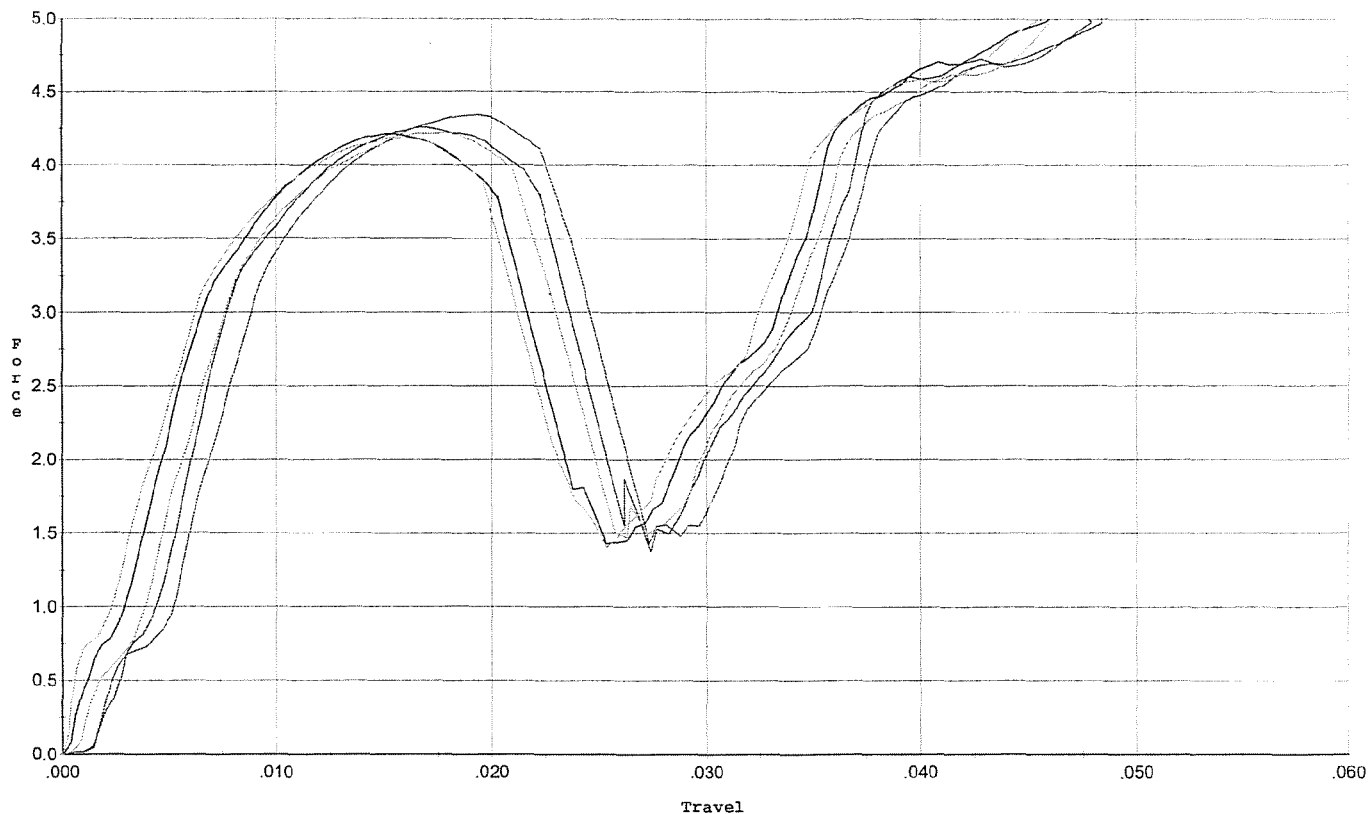
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.021	0.00	0.031	0.044		Set Trigger
2	3.299	0.020	0.00	0.031	0.045		Set Trigger
3	3.390	0.021	0.00	0.031	0.049		Set Trigger
4	3.261	0.019	0.00	0.030	0.043		Set Trigger
5	3.224	0.020	0.00	0.030	0.046		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



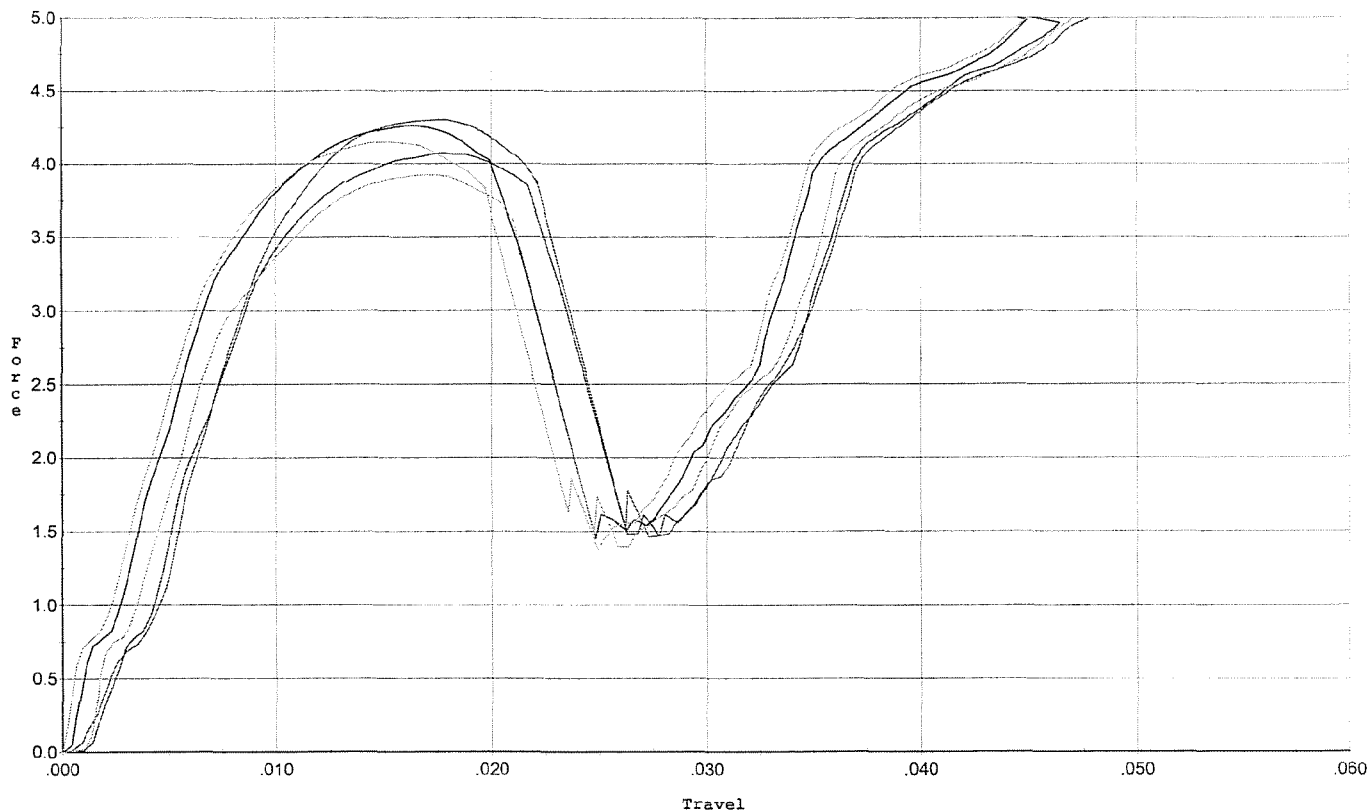
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.255	0.022	0.00	0.029	0.062		Set Trigger
2	4.212	0.020	0.00	0.029	0.058		Set Trigger
3	4.342	0.024	0.00	0.029	0.065		Set Trigger
4	4.194	0.020	0.00	0.028	0.057		Set Trigger
5	4.218	0.023	0.00	0.029	0.063		Set Trigger

A-4.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



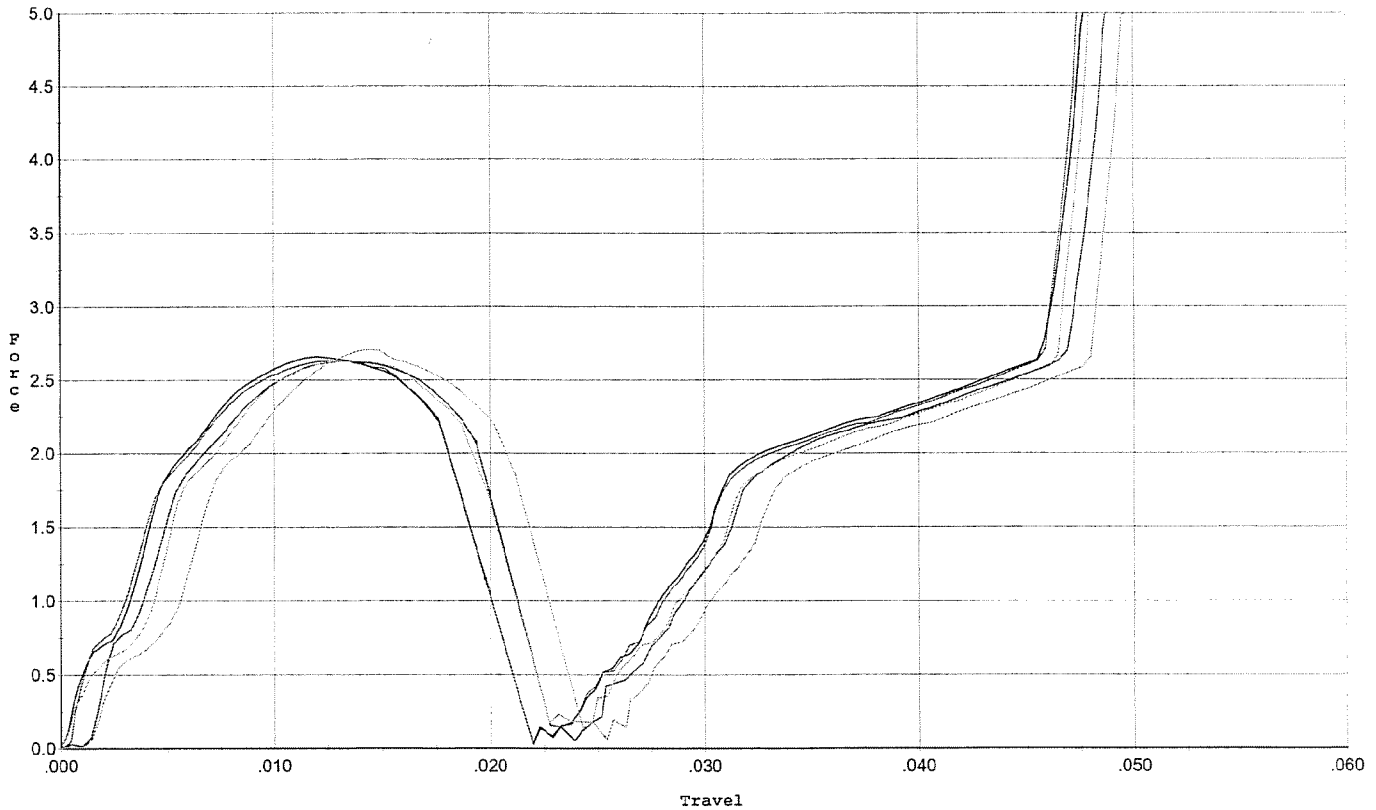
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.074	0.023	0.00	0.029	0.062		Set Trigger
2	4.261	0.021	0.00	0.028	0.062		Set Trigger
3	4.301	0.022	0.00	0.029	0.061		Set Trigger
4	4.151	0.020	0.00	0.029	0.057		Set Trigger
5	3.922	0.021	0.00	0.030	0.055		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



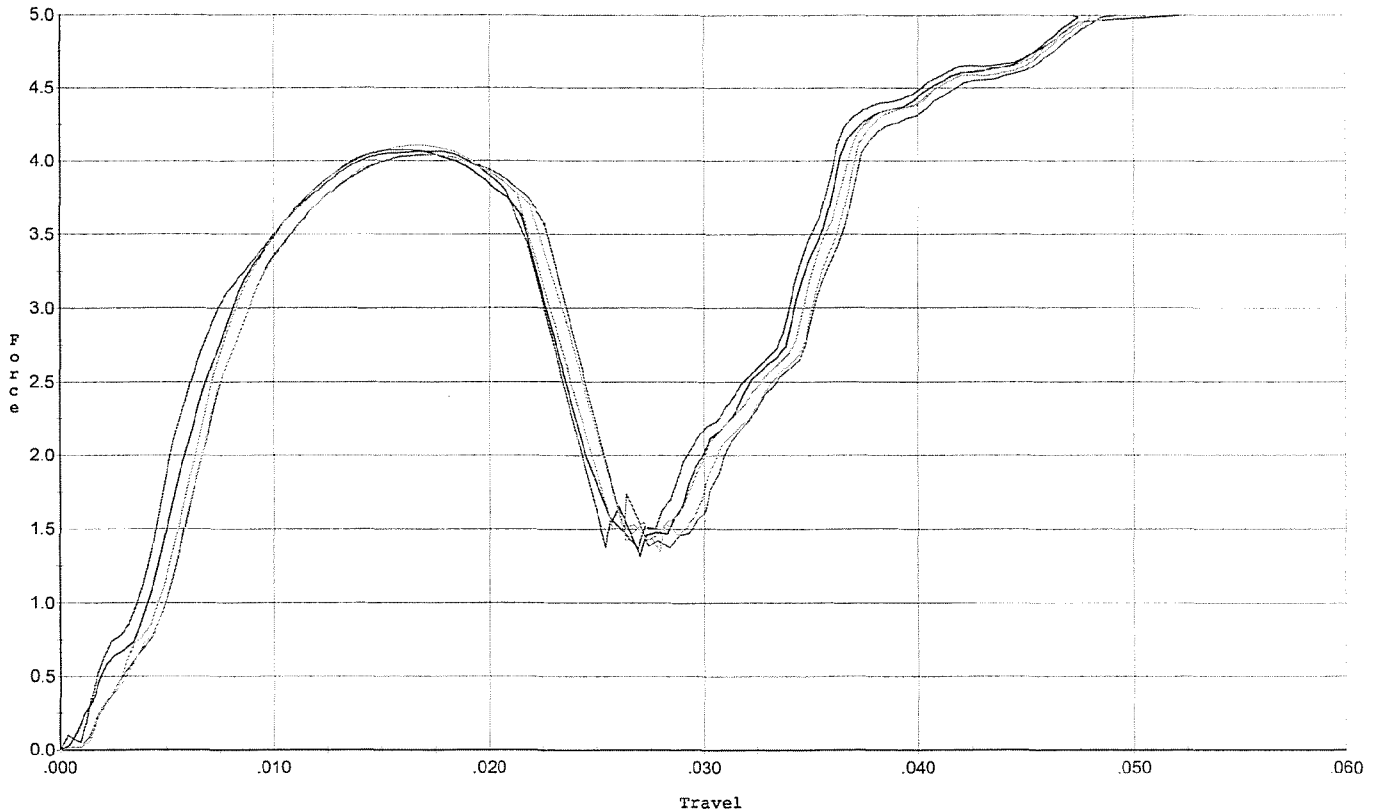
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.625	0.019	0.00	0.033	0.035		Set Trigger
2	2.658	0.020	0.00	0.033	0.037		Set Trigger
3	2.632	0.020	0.00	0.033	0.037		Set Trigger
4	2.628	0.020	0.00	0.033	0.036		Set Trigger
5	2.709	0.021	0.00	0.033	0.037		Set Trigger

A-2-65

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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	4.064	0.022	0.00	0.029	0.060		Set Trigger
2	4.073	0.021	0.00	0.030	0.058		Set Trigger
3	4.039	0.023	0.00	0.030	0.059		Set Trigger
4	4.043	0.024	0.00	0.030	0.061		Set Trigger
5	4.109	0.023	0.00	0.030	0.062		Set Trigger

A. 4.06