

G 680 1489

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



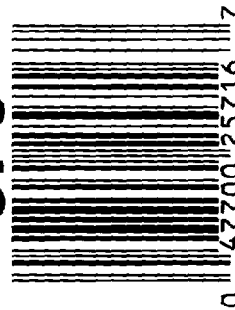
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801489

UPC



GUN SERIAL #

G 6801489

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	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	RIC
480	MAGNAFLUX BBL ACTION	(P)	3/9/09	(P)
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	RL
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

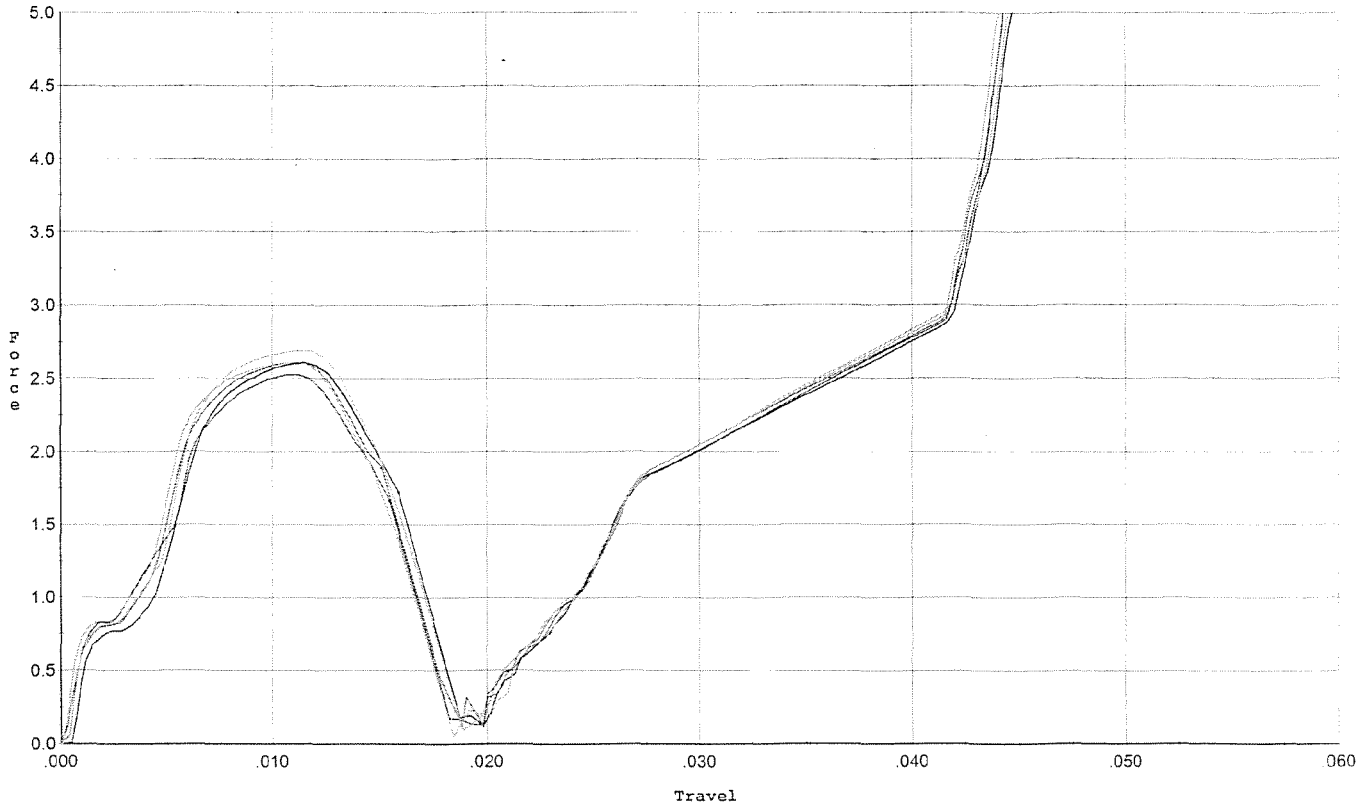
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0015895 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>7</u>	3-23-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>4</u>	3-23-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.082</u> <u>.082</u> <u>.023</u>	3-23-09	W/W
	J) ASSEMBLE STOCK		3-20-09	A.D.
	K) ASSEMBLE SWIVEL STUDS		3-23-09	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	PASS PASS FAIL FAIL	3-23-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	W/W
670	FINAL INSPECTION A) HEADSPACE		3-23-09	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.67</u> <u>2.69</u> <u>2.58</u> <u>2.57</u>	TL	3-23-09
	C) FUNCTION		3-23-09	W/W
690	PACK		3/25/09	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



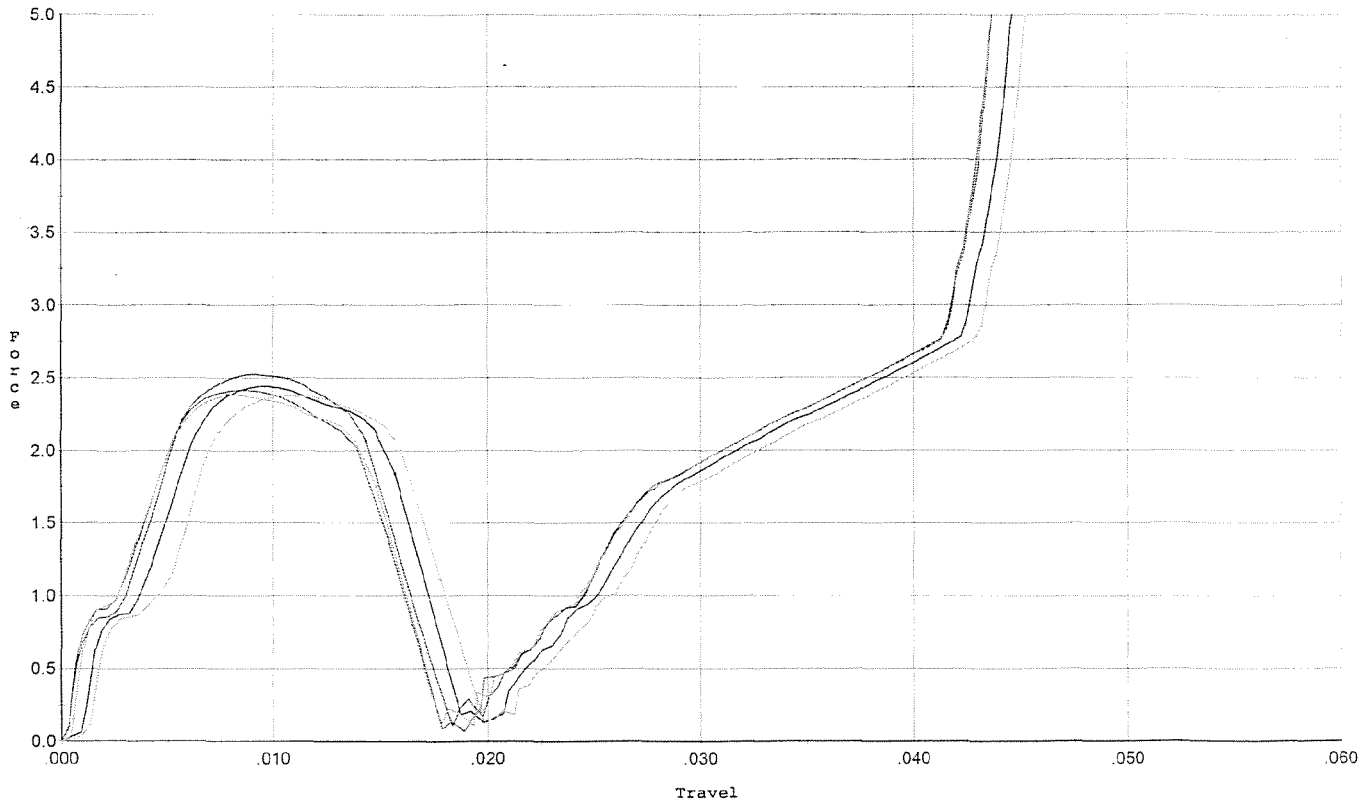
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.527	0.015	0.00	0.033	0.026		Set Trigger
2	2.604	0.016	0.00	0.033	0.027		Set Trigger
3	2.611	0.015	0.00	0.033	0.026		Set Trigger
4	2.691	0.017	0.00	0.033	0.029		Set Trigger
5	2.610	0.016	0.00	0.033	0.028		Set Trigger

A-2.60

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



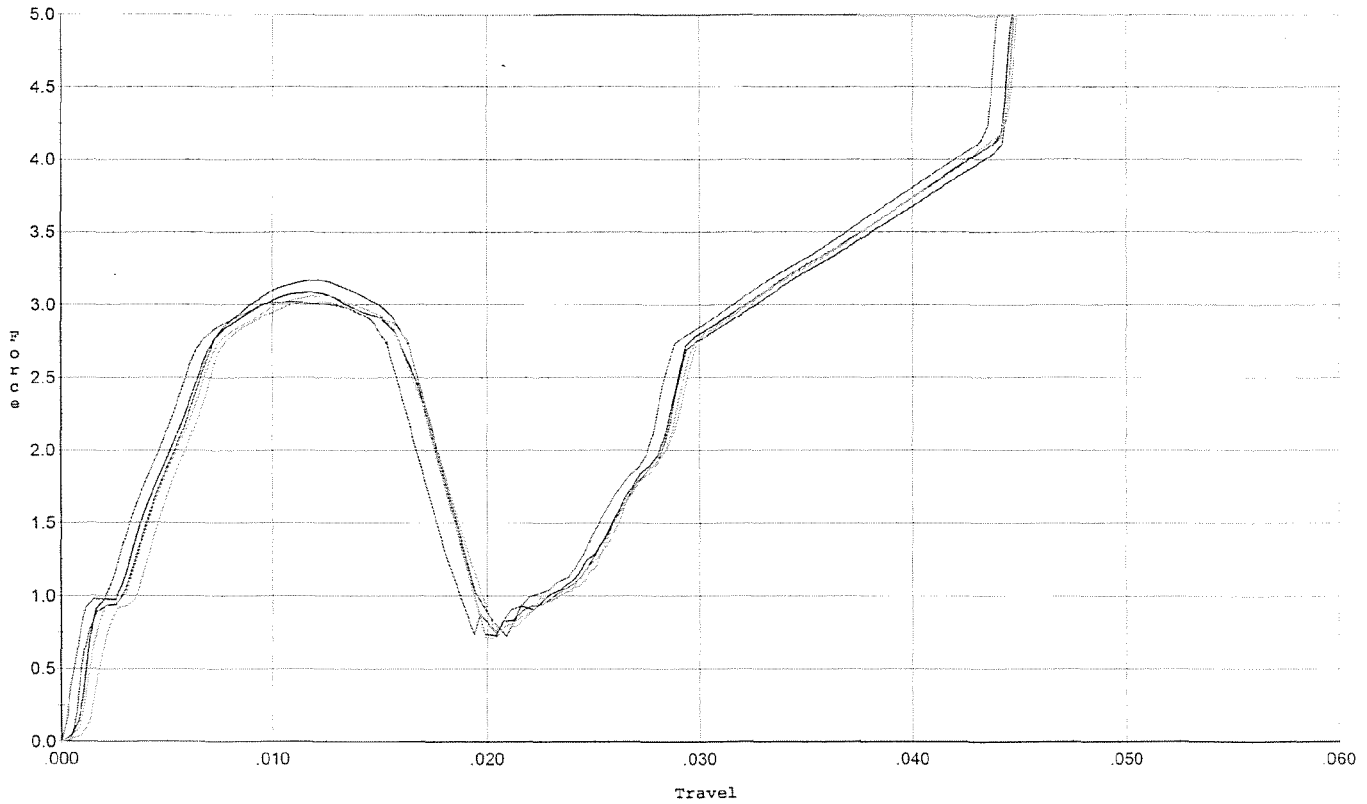
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.014	0.00	0.033	0.025		Set Trigger
2	2.441	0.016	0.00	0.033	0.026		Set Trigger
3	2.417	0.015	0.00	0.033	0.026		Set Trigger
4	2.378	0.018	0.00	0.032	0.028		Set Trigger
5	2.383	0.015	0.00	0.033	0.025		Set Trigger

A-2-42

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



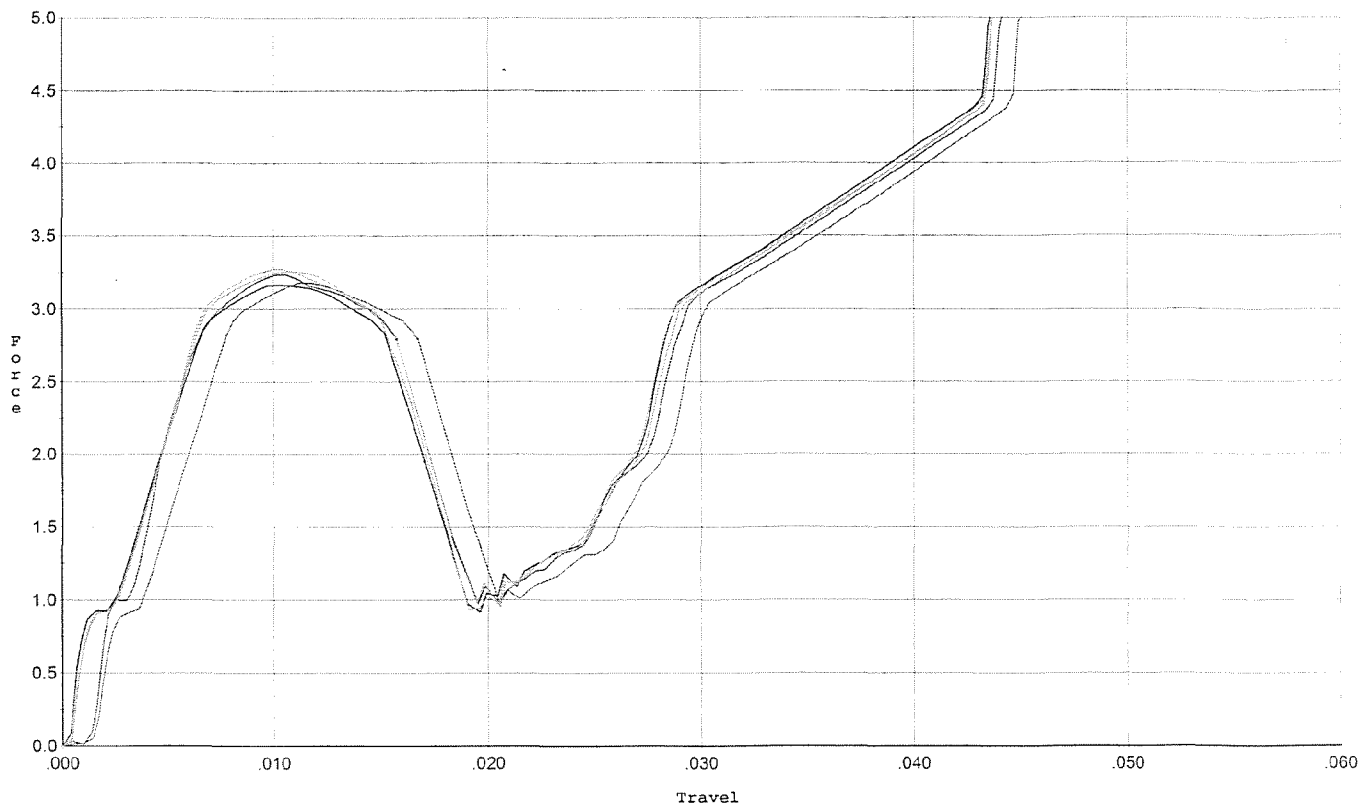
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.171	0.016	0.00	0.030	0.035		Set Trigger
2	3.085	0.017	0.00	0.030	0.036		Set Trigger
3	3.018	0.015	0.00	0.030	0.033		Set Trigger
4	3.063	0.017	0.00	0.030	0.035		Set Trigger
5	3.020	0.016	0.00	0.030	0.033		Set Trigger

A-3.07

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



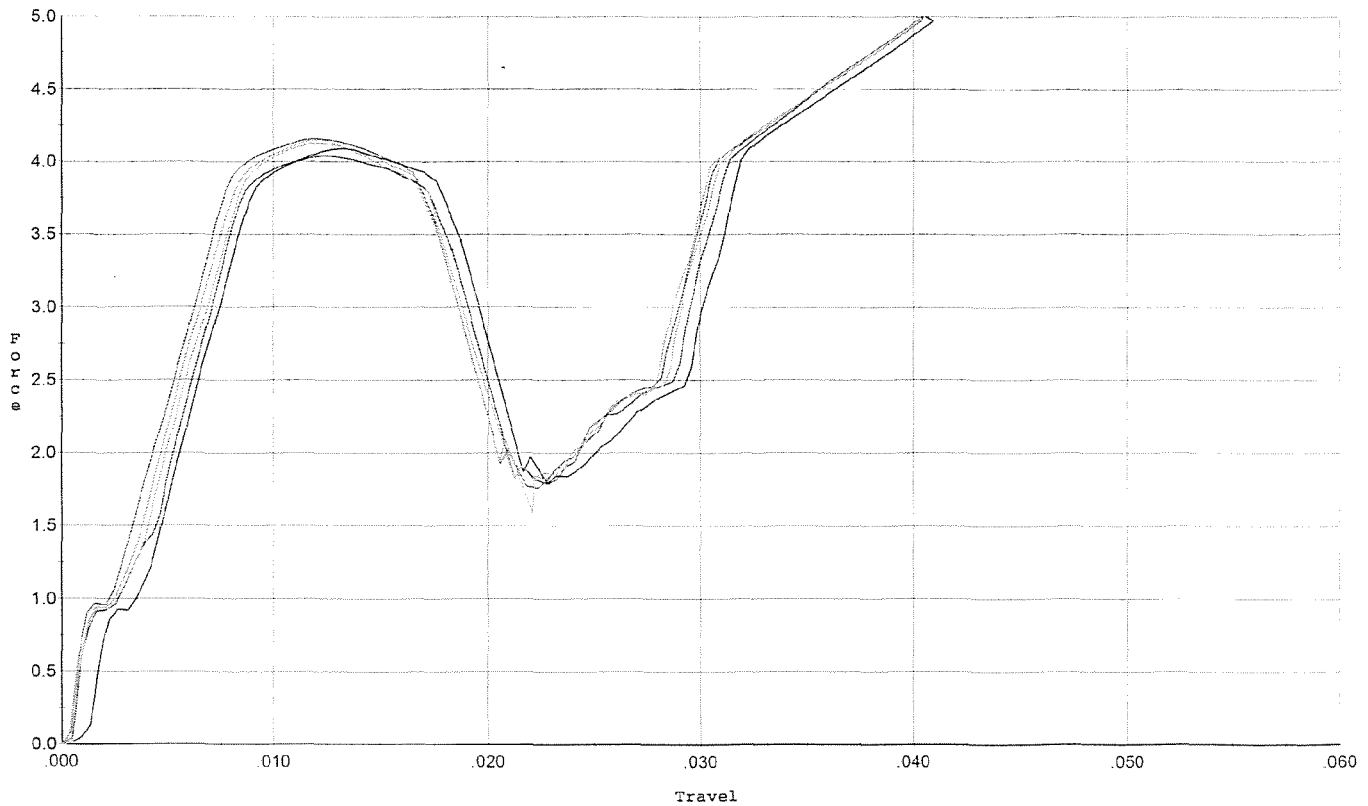
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.236	0.016	0.00	0.029	0.034		Set Trigger
2	3.164	0.017	0.00	0.029	0.037		Set Trigger
3	3.179	0.017	0.00	0.030	0.035		Set Trigger
4	3.273	0.016	0.00	0.029	0.037		Set Trigger
5	3.255	0.016	0.00	0.029	0.035		Set Trigger

A-3.22

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



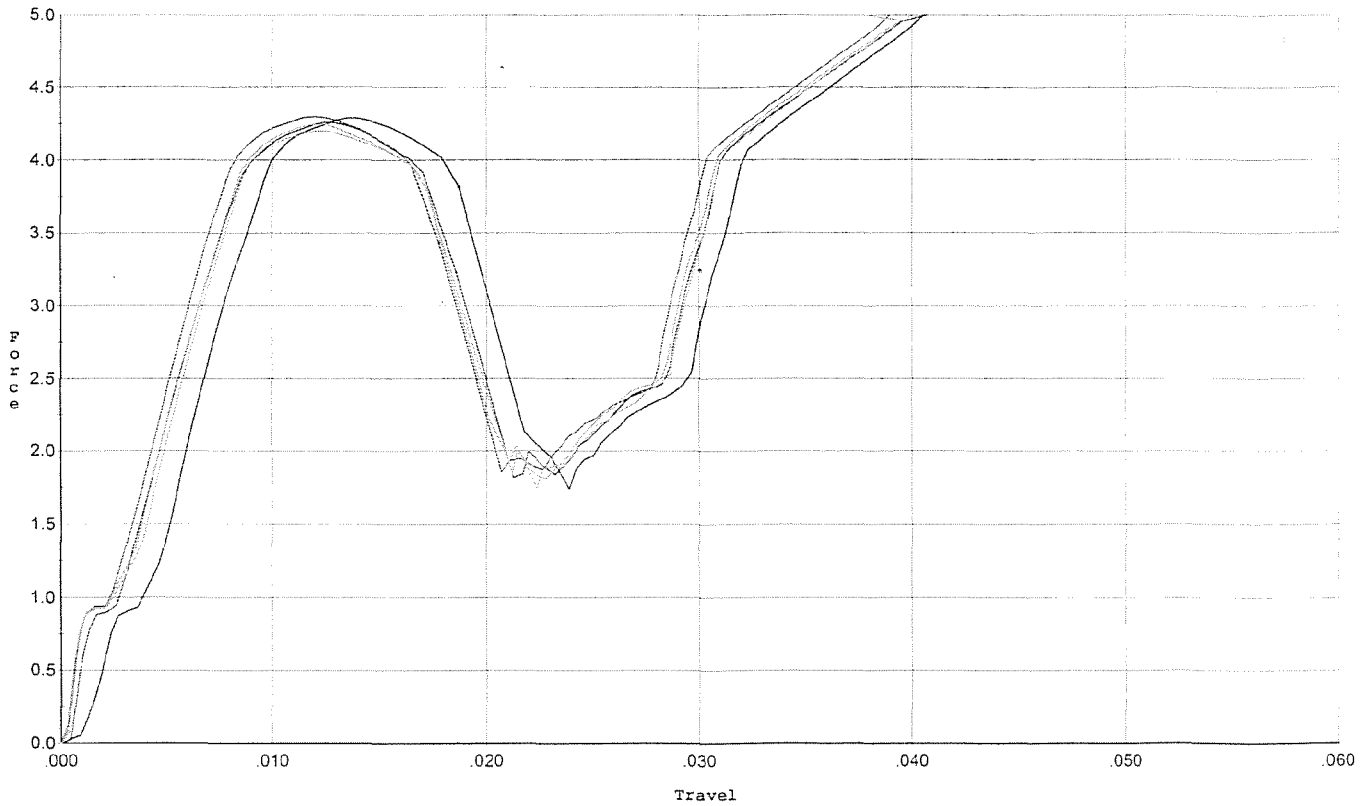
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.042	0.018	0.00	0.027	0.049		Set Trigger
2	4.092	0.019	0.00	0.027	0.049		Set Trigger
3	4.158	0.018	0.00	0.027	0.049		Set Trigger
4	4.128	0.017	0.00	0.028	0.047		Set Trigger
5	4.153	0.018	0.00	0.027	0.048		Set Trigger

A-4.11

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



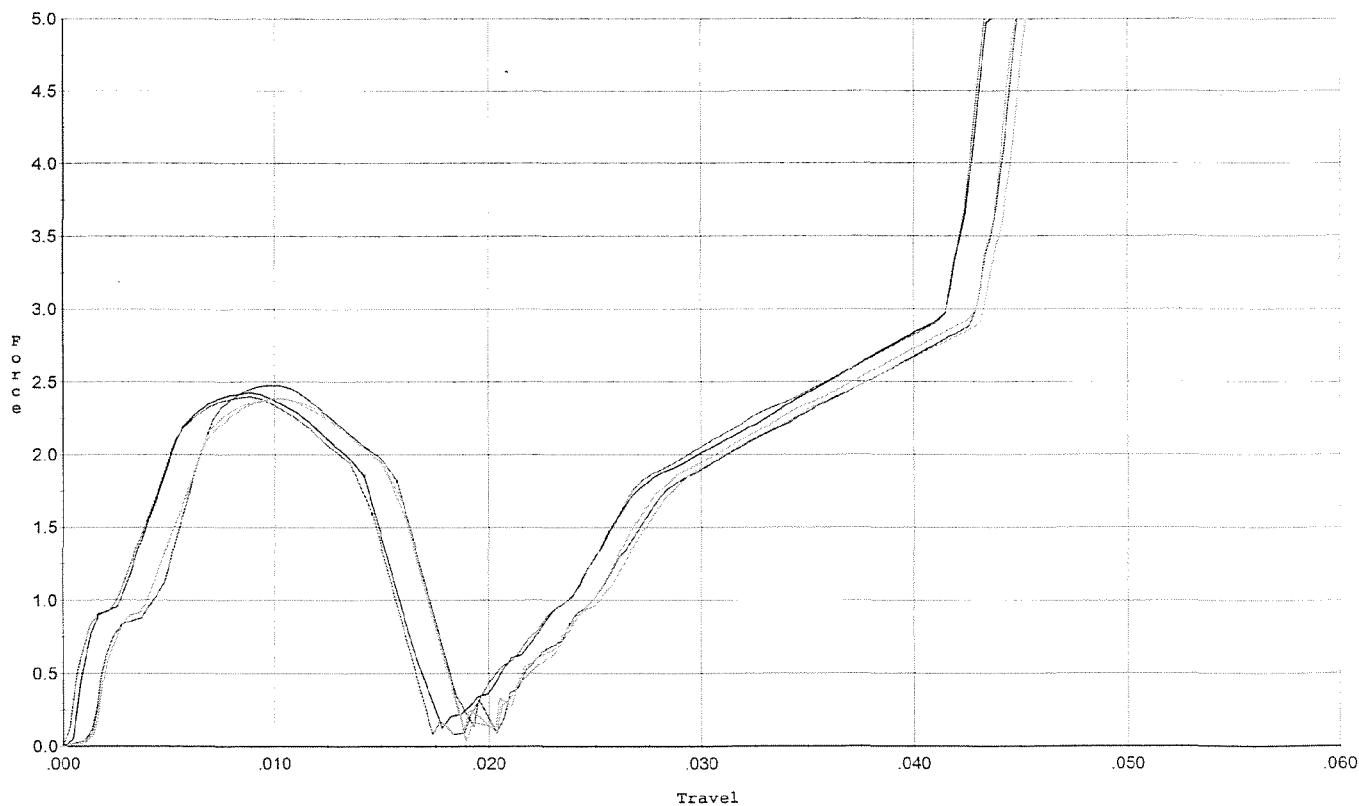
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.259	0.019	0.00	0.027	0.052		Set Trigger
2	4.290	0.019	0.00	0.027	0.050		Set Trigger
3	4.298	0.018	0.00	0.027	0.051		Set Trigger
4	4.198	0.017	0.00	0.028	0.047		Set Trigger
5	4.245	0.017	0.00	0.028	0.048		Set Trigger

A. 4.25

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



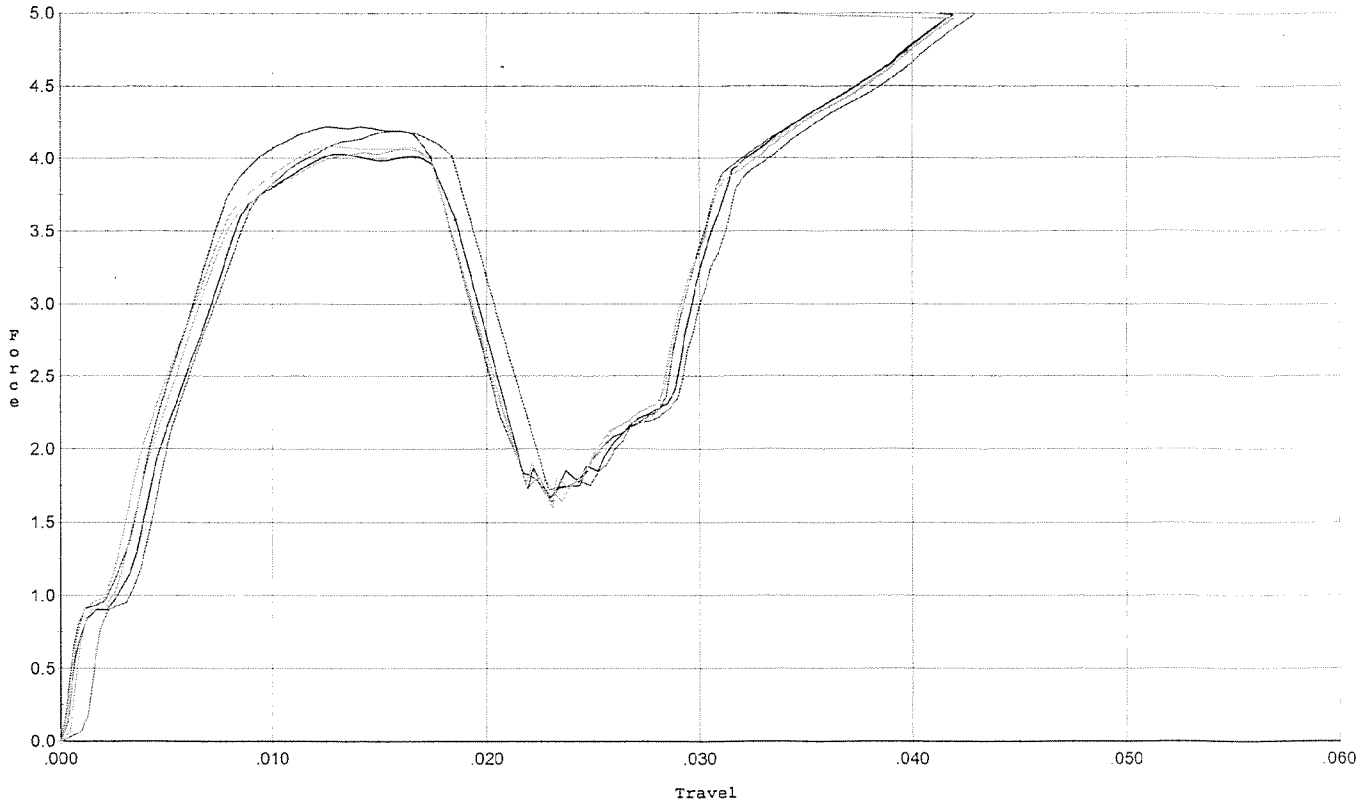
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.016	0.00	0.033	0.025		Set Trigger
2	2.426	0.014	0.00	0.033	0.024		Set Trigger
3	2.401	0.015	0.00	0.033	0.025		Set Trigger
4	2.393	0.016	0.00	0.033	0.025		Set Trigger
5	2.385	0.016	0.00	0.033	0.025		Set Trigger

A-2-41

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	4.219	0.017	0.00	0.028	0.050		Set Trigger
2	4.028	0.019	0.00	0.027	0.051		Set Trigger
3	4.187	0.018	0.00	0.028	0.050		Set Trigger
4	4.081	0.017	0.00	0.028	0.049		Set Trigger
5	4.064	0.017	0.00	0.028	0.048		Set Trigger

A-4.11