

6680 7680

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



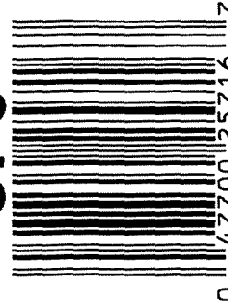
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807680

UPC



GUN SERIAL # G6807680

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SP
460	CHECK HEADSPACE		2-27-09	SP
470	DIS-ASSEMBLE ACTION		2-27-09	SP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION		3/5/09	SP
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-8-09	SP
520	GOFF BLAST BBL / REC		3/6	mm
540	APPLY COATINGS (BARREL ACTION)		3/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-13-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

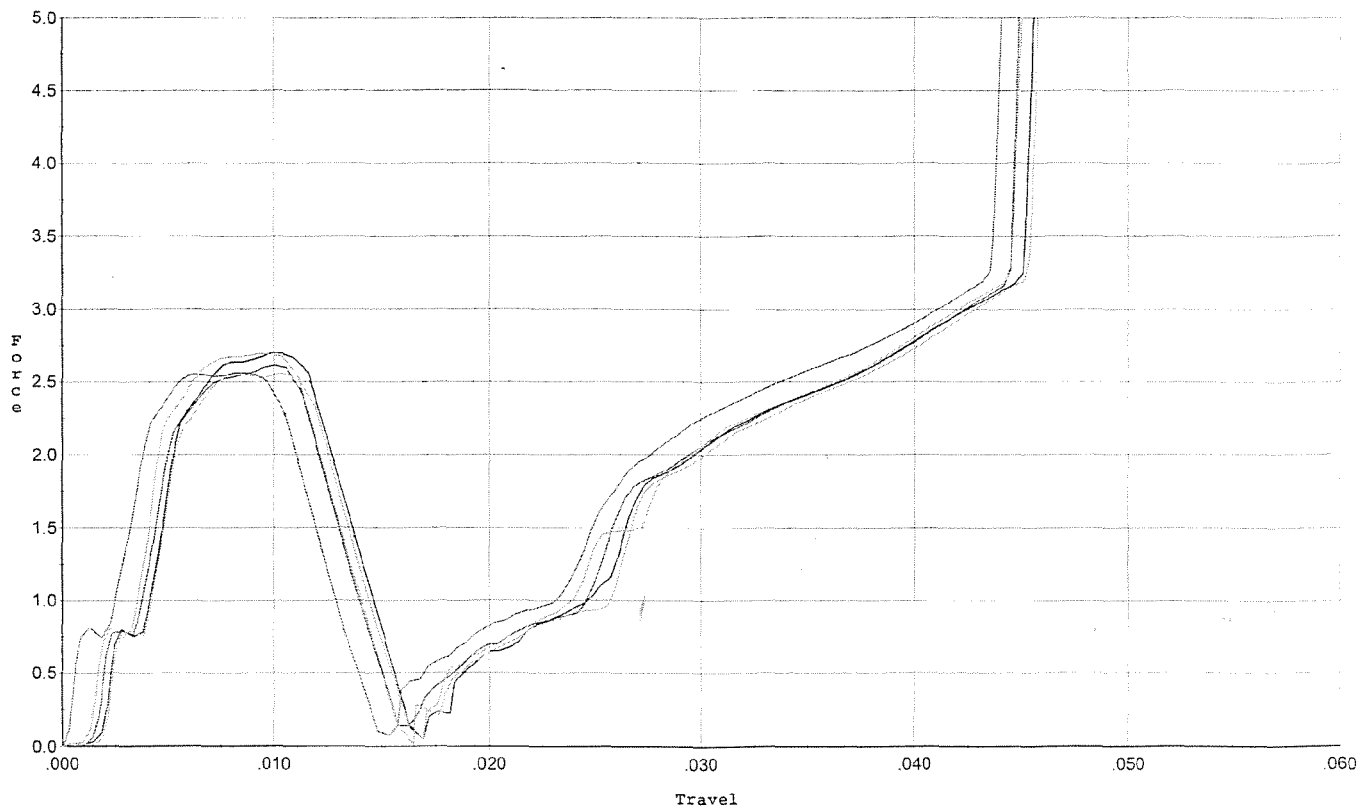
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	3-18-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-18-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	3-18-09	WW
	J) ASSEMBLE STOCK		3-13-09	WW
	K) ASSEMBLE SWIVEL STUDS		3-19-09	WW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	3-17-09	TC
650	TARGET	<u>PASS</u> FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	WW
670	FINAL INSPECTION A) HEADSPACE		3-18-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.69</u> <u>2.73</u> <u>2.65</u> <u>2.75</u>	3-18-09	TC
	C) FUNCTION		3-18-09	WW
690	PACK		3/19/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



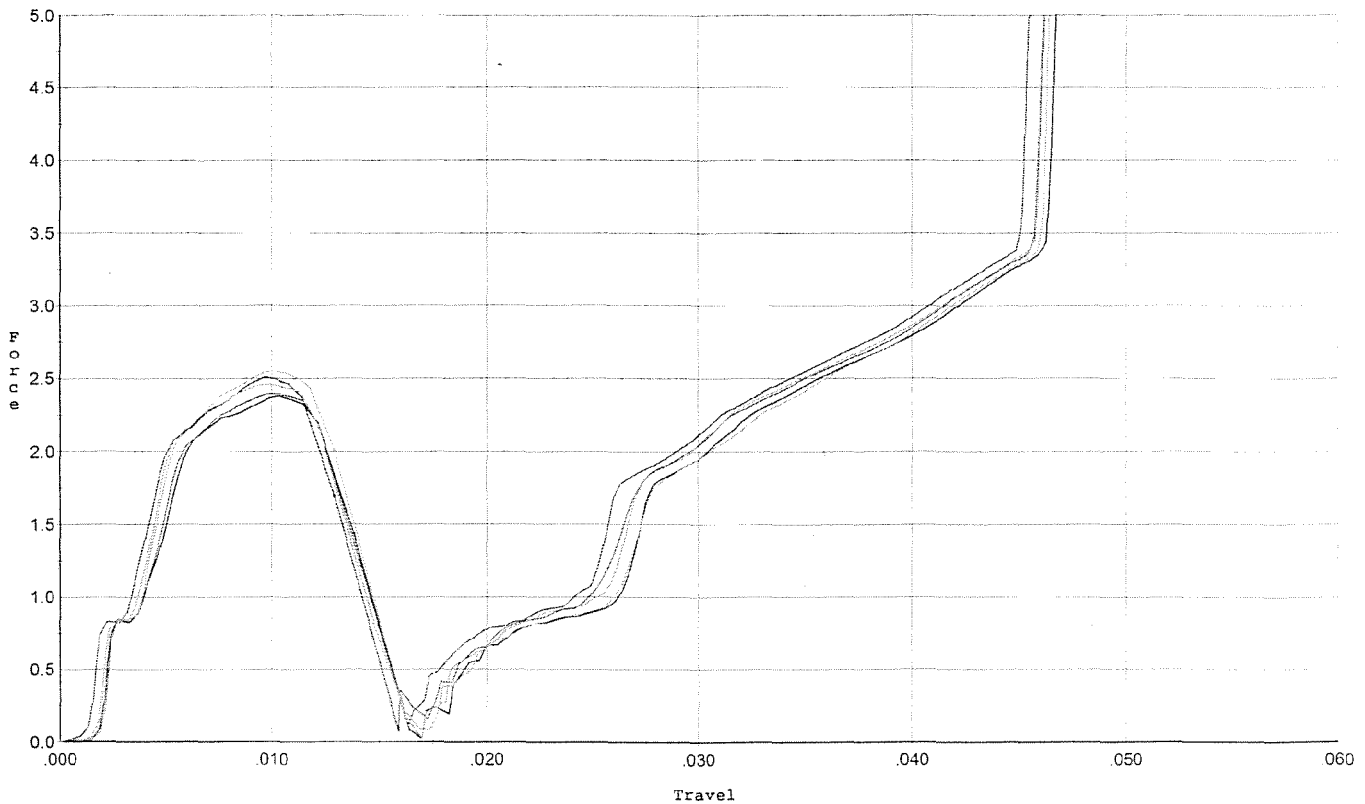
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.610	0.011	0.00	0.036	0.018		Set Trigger
2	2.701	0.014	0.00	0.035	0.022		Set Trigger
3	2.563	0.011	0.00	0.036	0.019		Set Trigger
4	2.557	0.012	0.002	0.036	0.019		Set Trigger
5	2.694	0.011	0.00	0.036	0.019		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



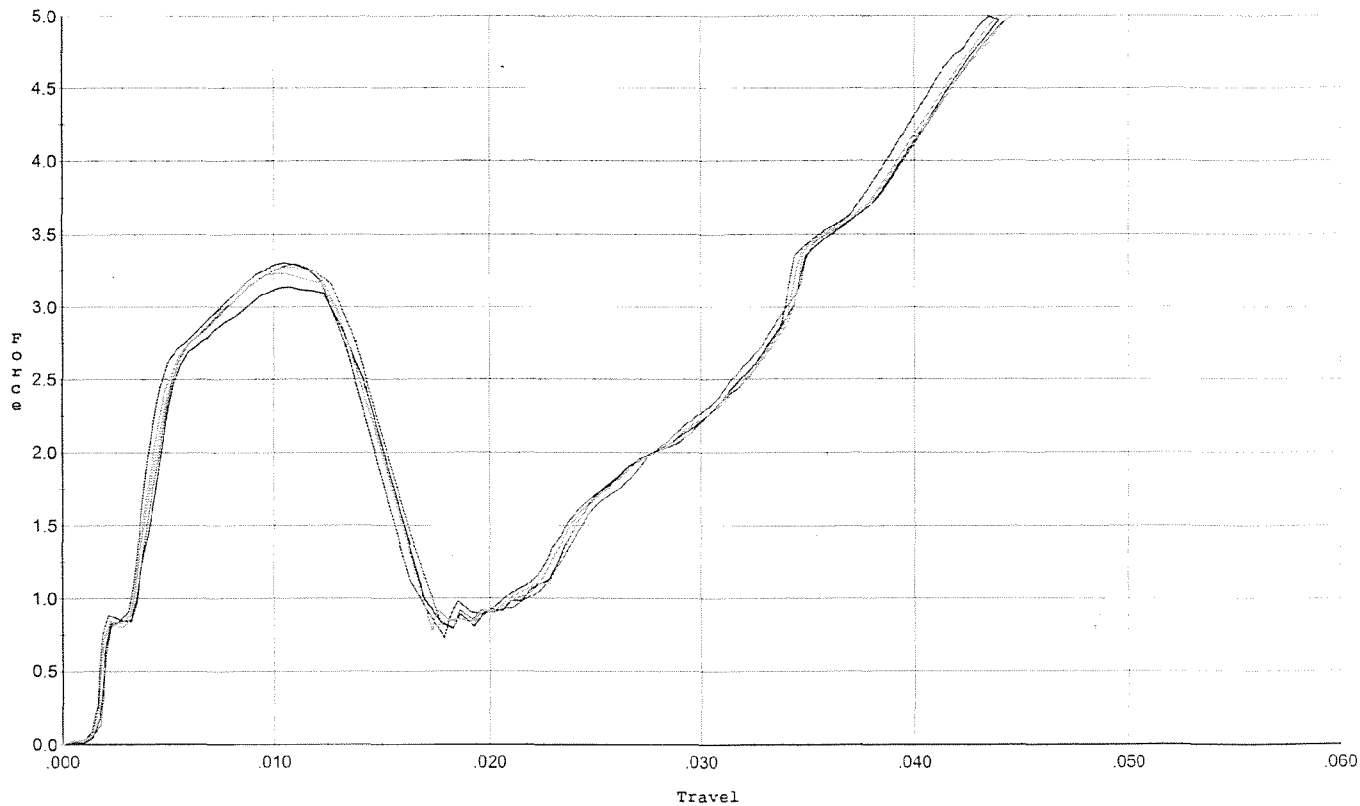
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.508	0.013	0.00	0.036	0.021		Set Trigger
2	2.379	0.014	0.002	0.037	0.020		Set Trigger
3	2.396	0.014	0.002	0.036	0.021		Set Trigger
4	2.547	0.013	0.002	0.036	0.020		Set Trigger
5	2.458	0.012	0.00	0.037	0.019		Set Trigger

A-2-45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



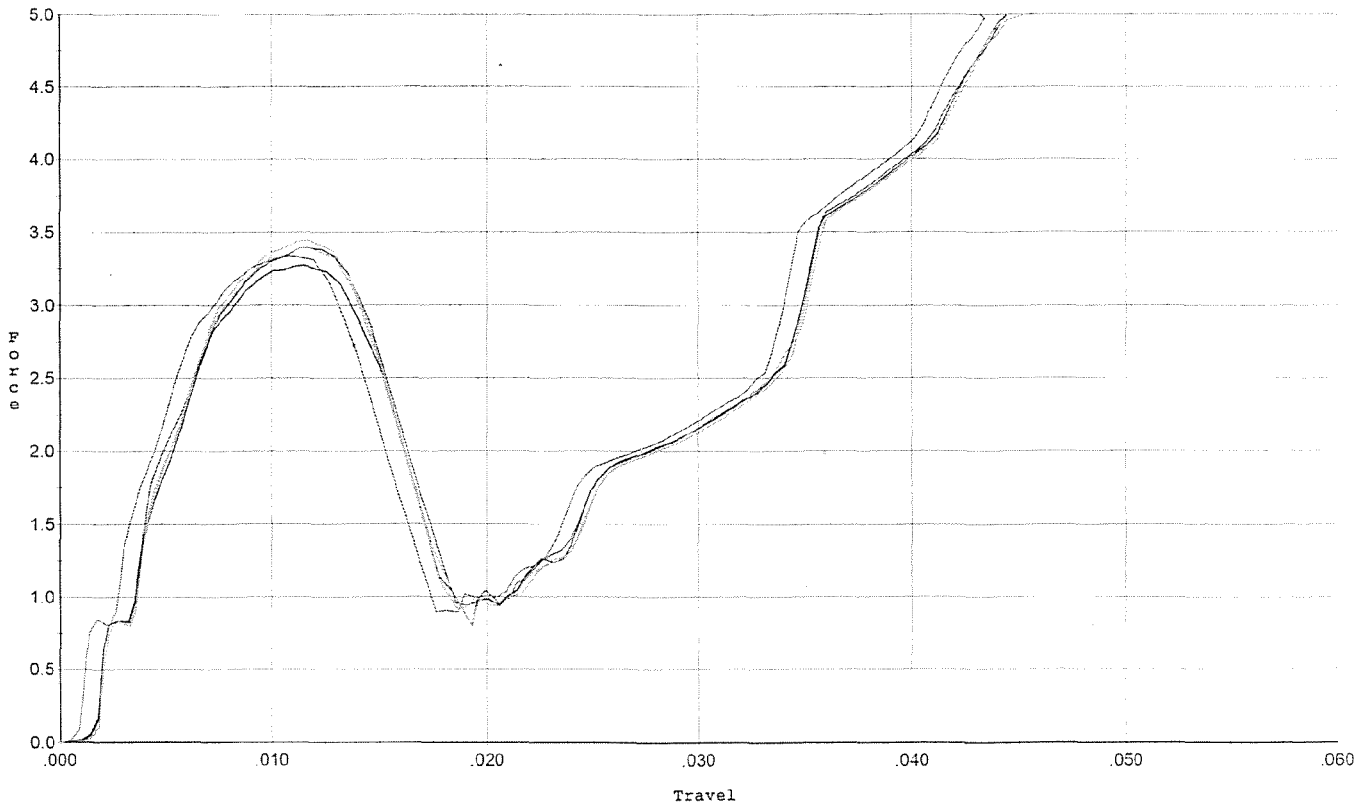
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.303	0.013	0.00	0.034	0.028		Set Trigger
2	3.136	0.014	0.00	0.034	0.029		Set Trigger
3	3.295	0.014	0.00	0.034	0.028		Set Trigger
4	3.229	0.015	0.00	0.034	0.030		Set Trigger
5	3.273	0.015	0.00	0.033	0.031		Set Trigger

A-3.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



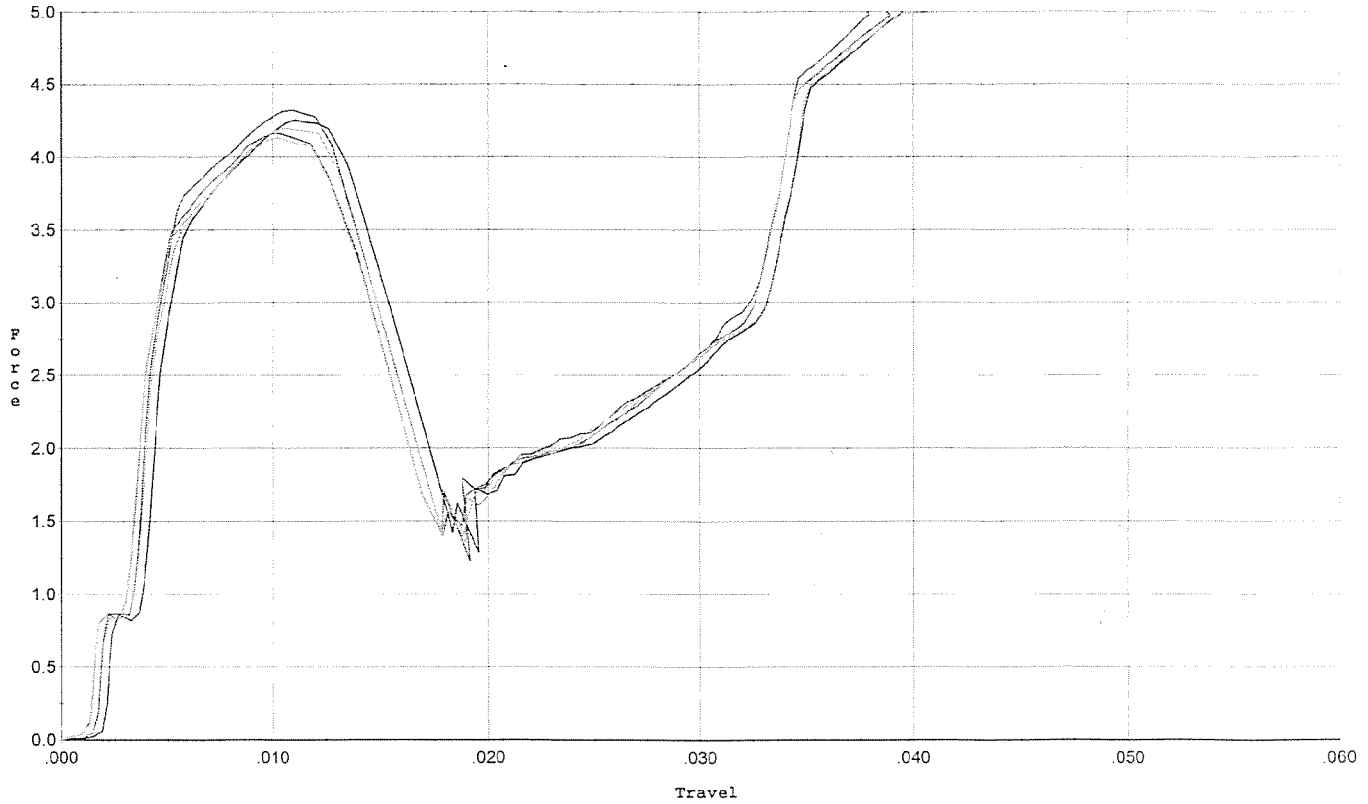
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.393	0.015	0.00	0.034	0.031		Set Trigger
2	3.275	0.015	0.00	0.034	0.031		Set Trigger
3	3.336	0.014	0.00	0.033	0.030		Set Trigger
4	3.445	0.015	0.00	0.034	0.031		Set Trigger
5	3.393	0.015	0.00	0.034	0.031		Set Trigger

A-3.36

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



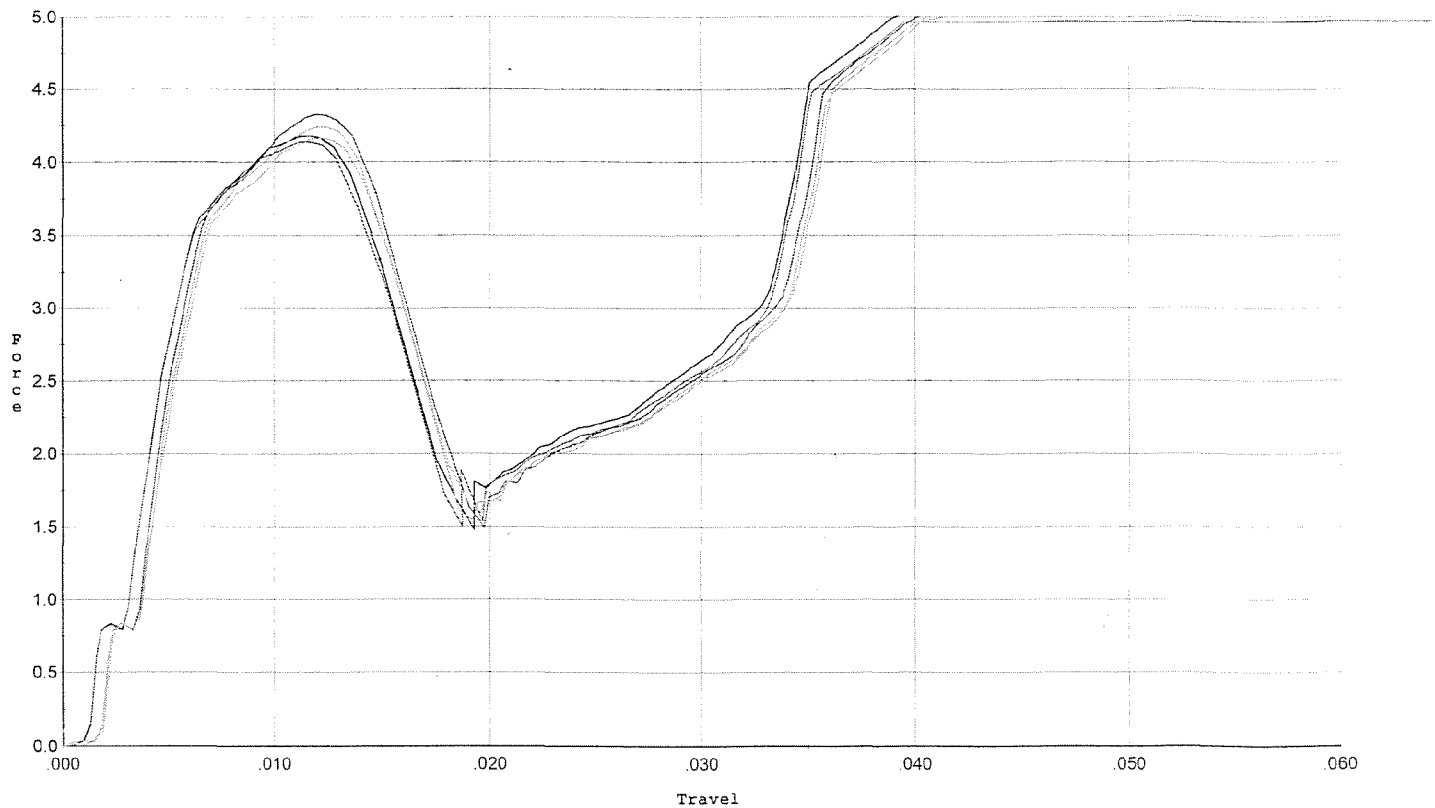
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.323	0.013	0.003	0.031	0.034		Set Trigger
2	4.256	0.016	0.00	0.031	0.040		Set Trigger
3	4.167	0.014	0.00	0.031	0.037		Set Trigger
4	4.134	0.014	0.00	0.031	0.037		Set Trigger
5	4.201	0.015	0.00	0.031	0.039		Set Trigger

A-4.21

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



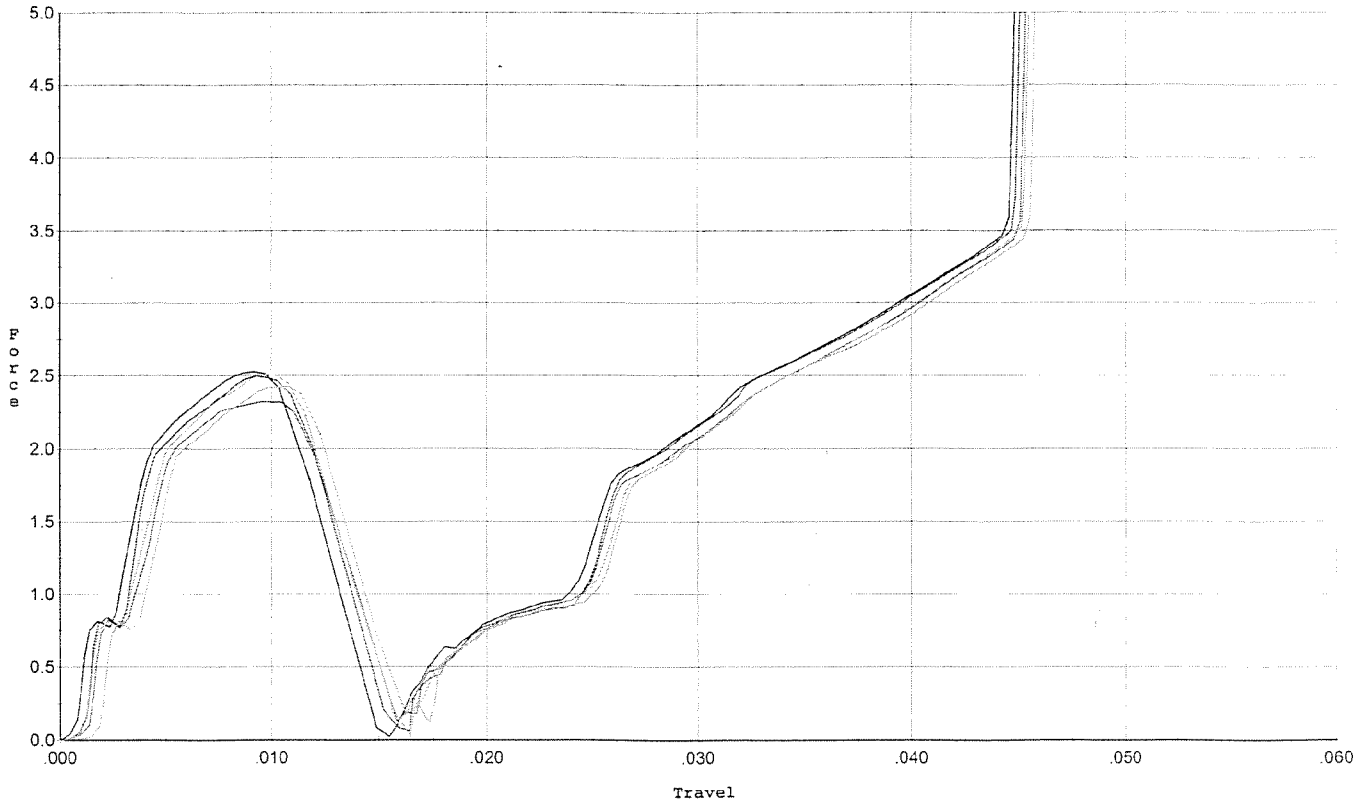
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.326	0.015	0.00	0.029	0.039		Set Trigger
2	4.178	0.015	0.00	0.029	0.039		Set Trigger
3	4.138	0.015	0.00	0.029	0.040		Set Trigger
4	4.162	0.015	0.00	0.029	0.039		Set Trigger
5	4.242	0.015	0.00	0.029	0.040		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



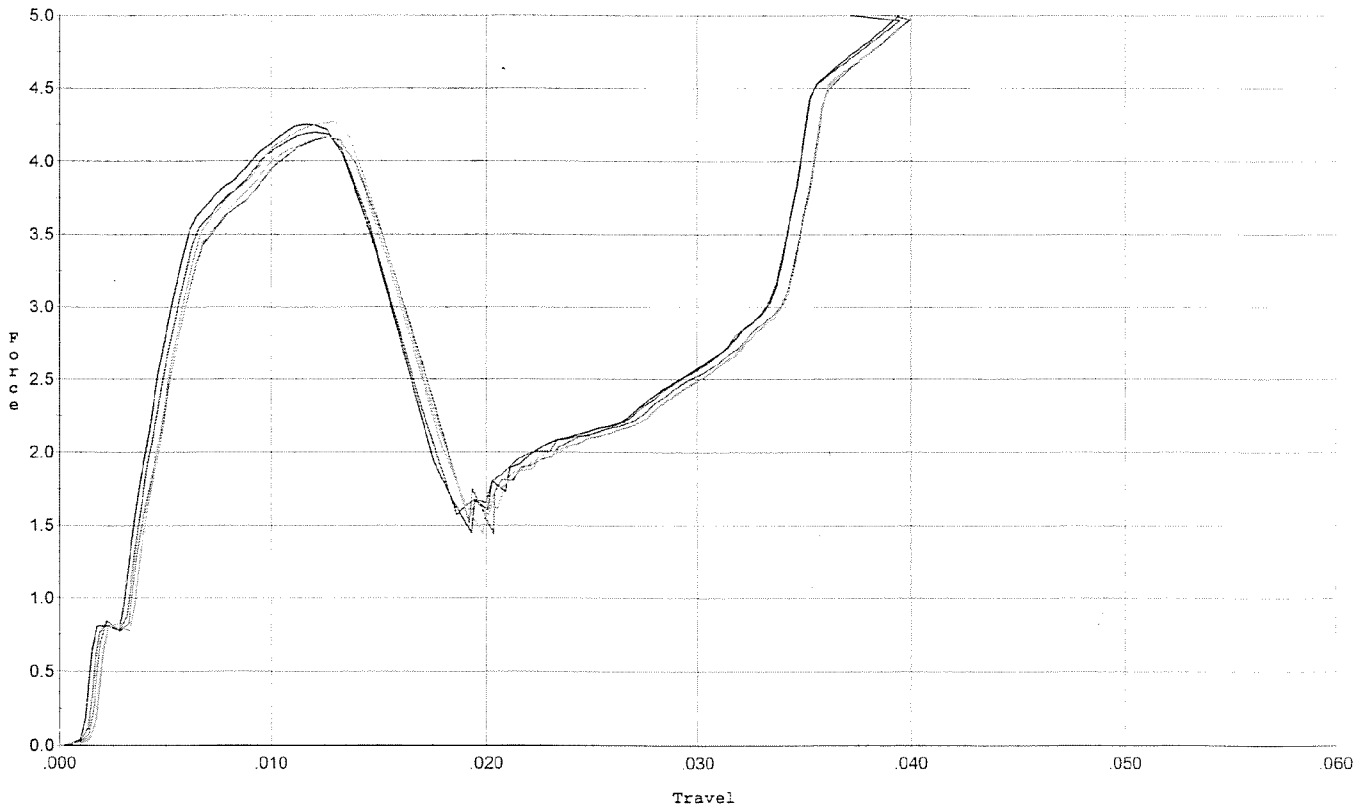
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.012	0.00	0.035	0.019		Set Trigger
2	2.526	0.012	0.00	0.036	0.019		Set Trigger
3	2.320	0.014	0.00	0.036	0.021		Set Trigger
4	2.507	0.012	0.00	0.036	0.018		Set Trigger
5	2.423	0.012	0.00	0.036	0.018		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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	4.198	0.015	0.00	0.028	0.038		Set Trigger
2	4.250	0.015	0.003	0.028	0.039		Set Trigger
3	4.165	0.017	0.00	0.028	0.043		Set Trigger
4	4.164	0.015	0.004	0.028	0.039		Set Trigger
5	4.272	0.015	0.00	0.028	0.039		Set Trigger

A-4.21