

66807770

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



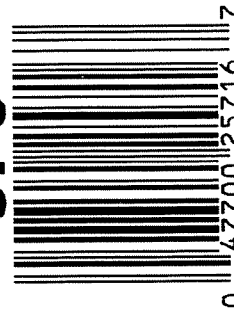
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807770

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

66807770

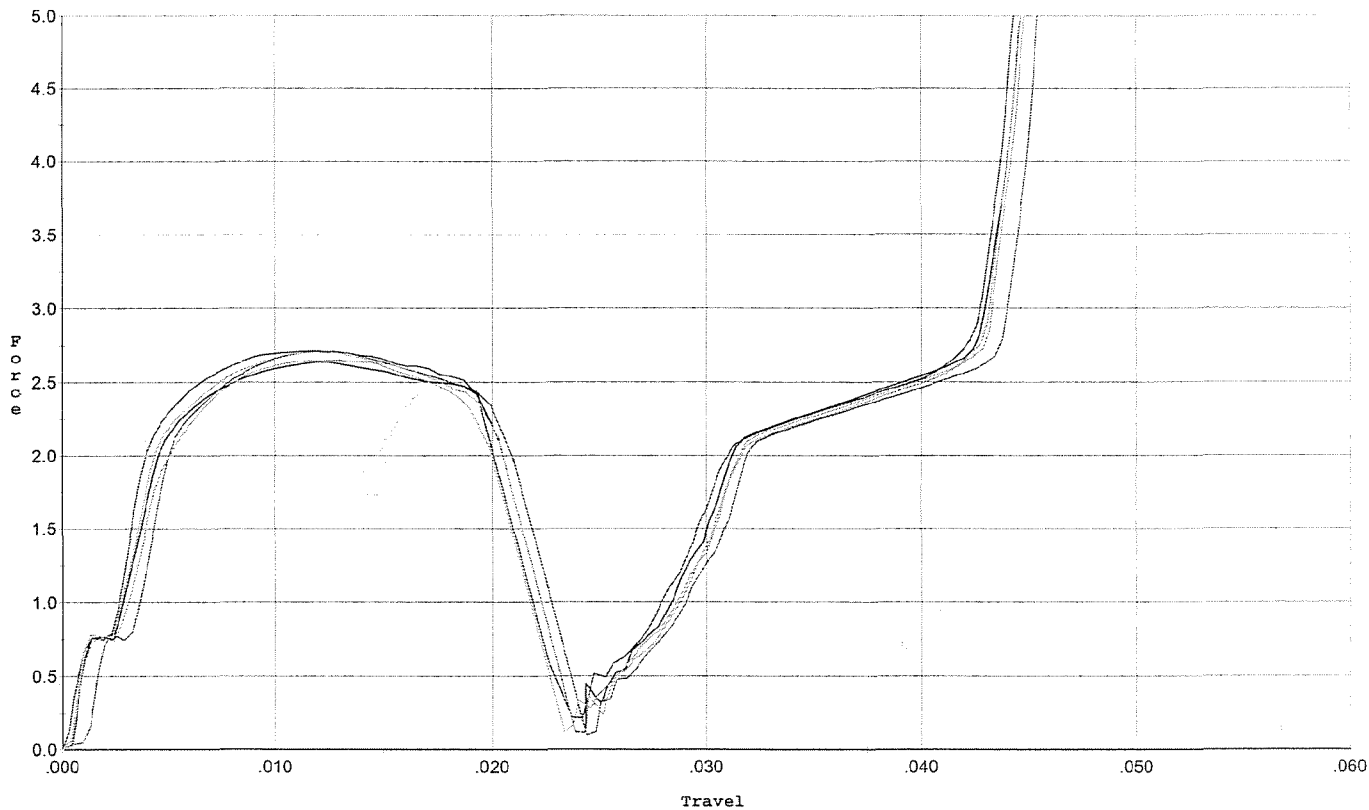
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	RT
460	CHECK HEADSPACE		3-6-09	RT
470	DIS-ASSEMBLE ACTION		3-6-09	P.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES	March 10 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	3-13-09	RT
490	MAGNAFLUX BOLT		3-13-09	RT
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		3-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	RT
	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	<u>4.0</u> <u>4.0</u> <u>4.0</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>.023</u> <u>.023</u> <u>.024</u>	3-30-09	L.N.
	J) ASSEMBLE STOCK		3-25-09	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	3-26-09	7/2
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-30-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.71</u> <u>2.65</u> <u>2.66</u> <u>2.65</u>	3-26-09	TL
	C) FUNCTION		3-30-09	L.N.
690	PACK		3/31/09	Fm

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



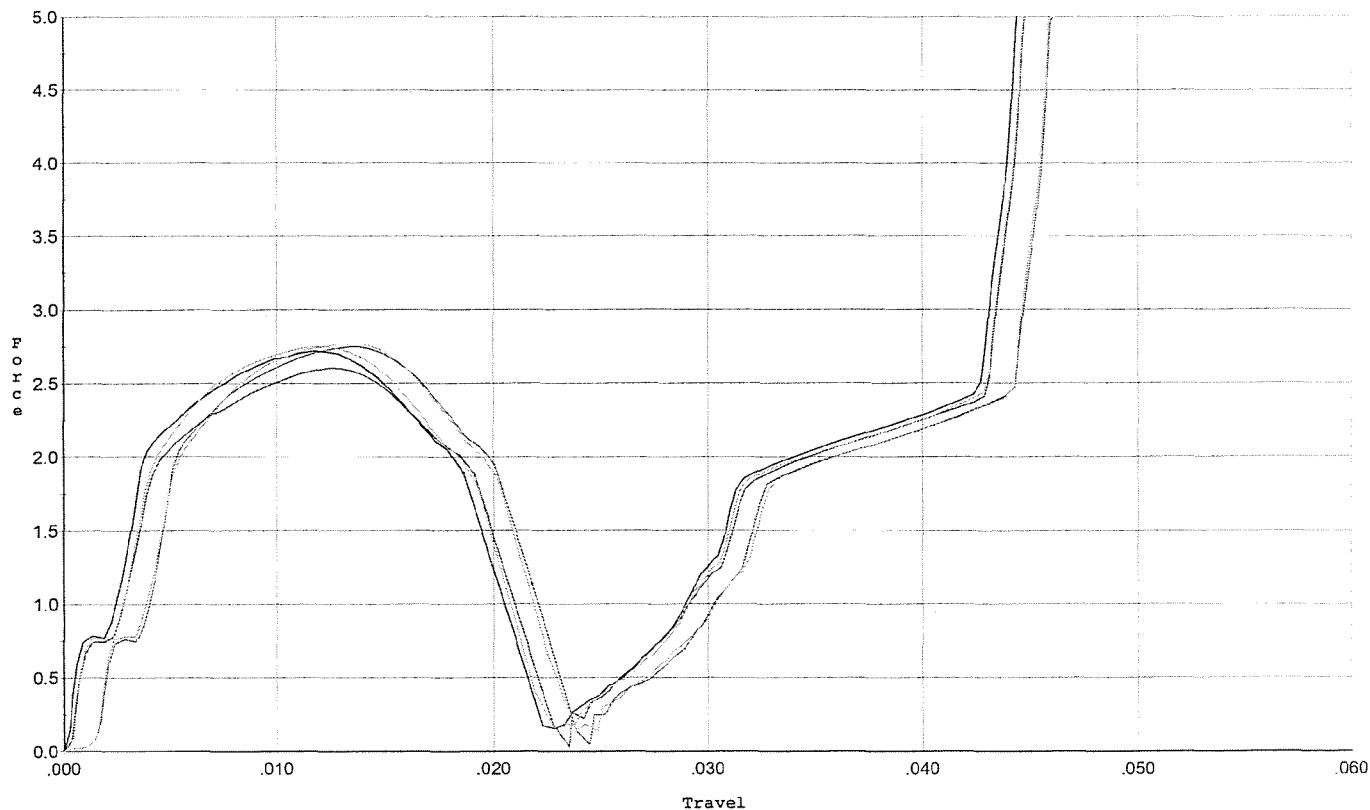
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.712	0.019	0.00	0.029	0.041		Set Trigger
2	2.637	0.020	0.003	0.029	0.041		Set Trigger
3	2.702	0.021	0.00	0.029	0.042		Set Trigger
4	2.710	0.020	0.003	0.030	0.040		Set Trigger
5	2.649	0.020	0.00	0.029	0.040		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



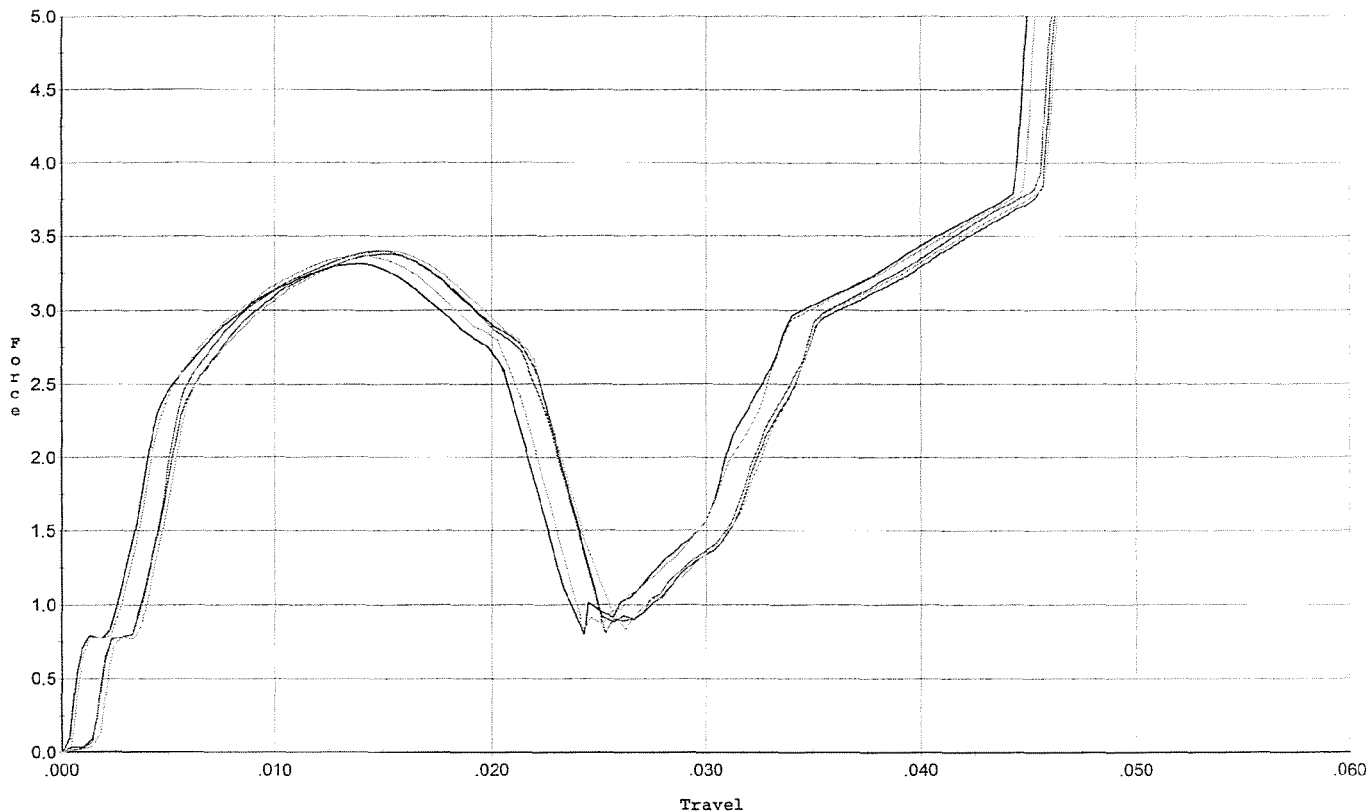
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.603	0.019	0.00	0.031	0.036		Set Trigger
2	2.719	0.019	0.00	0.030	0.037		Set Trigger
3	2.748	0.022	0.00	0.031	0.041		Set Trigger
4	2.747	0.019	0.00	0.031	0.038		Set Trigger
5	2.766	0.020	0.00	0.031	0.038		Set Trigger

A-2-71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



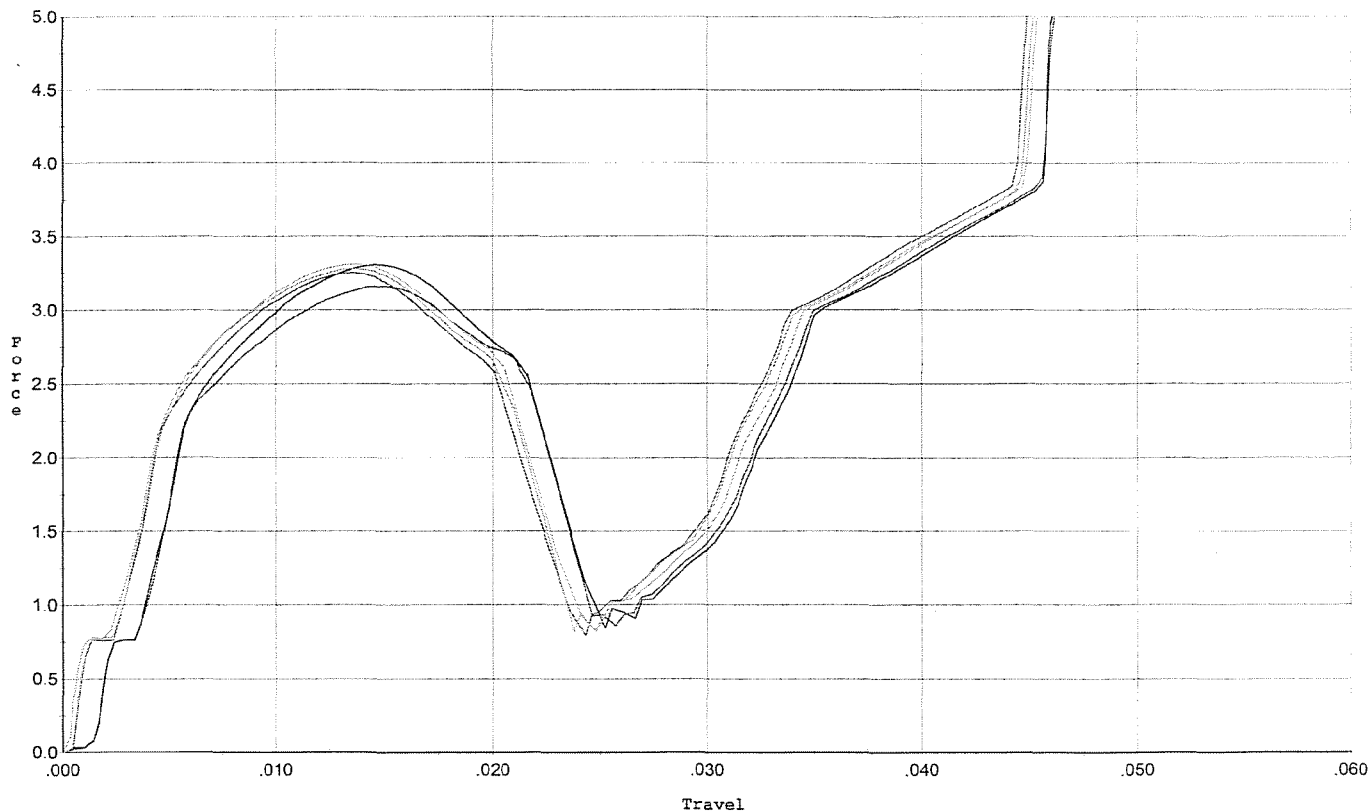
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.381	0.022	0.00	0.028	0.052		Set Trigger
2	3.312	0.021	0.00	0.028	0.049		Set Trigger
3	3.402	0.023	0.00	0.028	0.053		Set Trigger
4	3.404	0.022	0.00	0.028	0.051		Set Trigger
5	3.369	0.021	0.00	0.028	0.052		Set Trigger

A-3-37

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



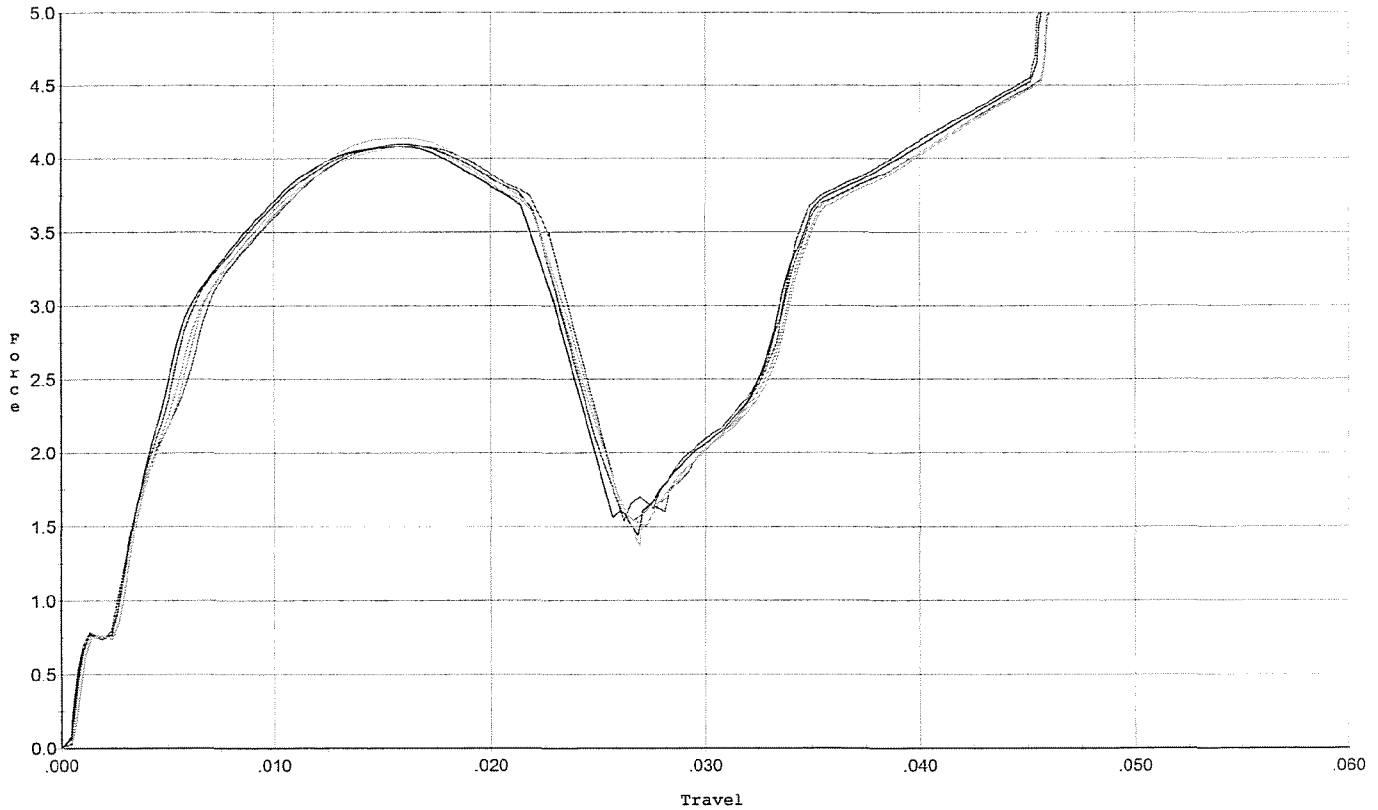
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.159	0.022	0.00	0.029	0.048		Set Trigger
2	3.307	0.022	0.00	0.029	0.049		Set Trigger
3	3.252	0.020	0.003	0.028	0.046		Set Trigger
4	3.309	0.021	0.00	0.029	0.048		Set Trigger
5	3.279	0.021	0.00	0.028	0.049		Set Trigger

A-3-26

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



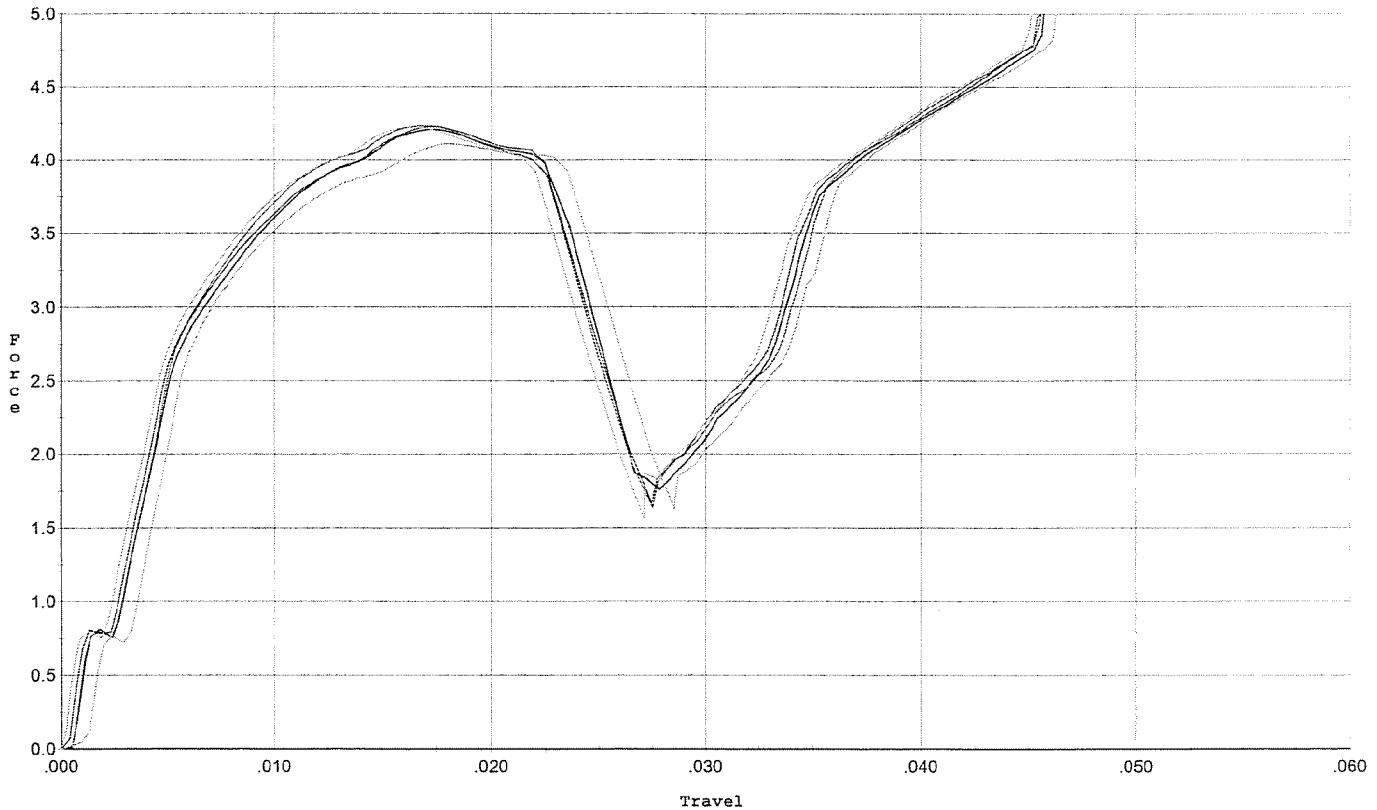
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.097	0.022	0.00	0.025	0.064		Set Trigger
2	4.080	0.023	0.00	0.026	0.066		Set Trigger
3	4.090	0.023	0.003	0.022	0.065		Set Trigger
4	4.083	0.022	0.00	0.024	0.063		Set Trigger
5	4.142	0.024	0.00	0.024	0.068		Set Trigger

A. 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



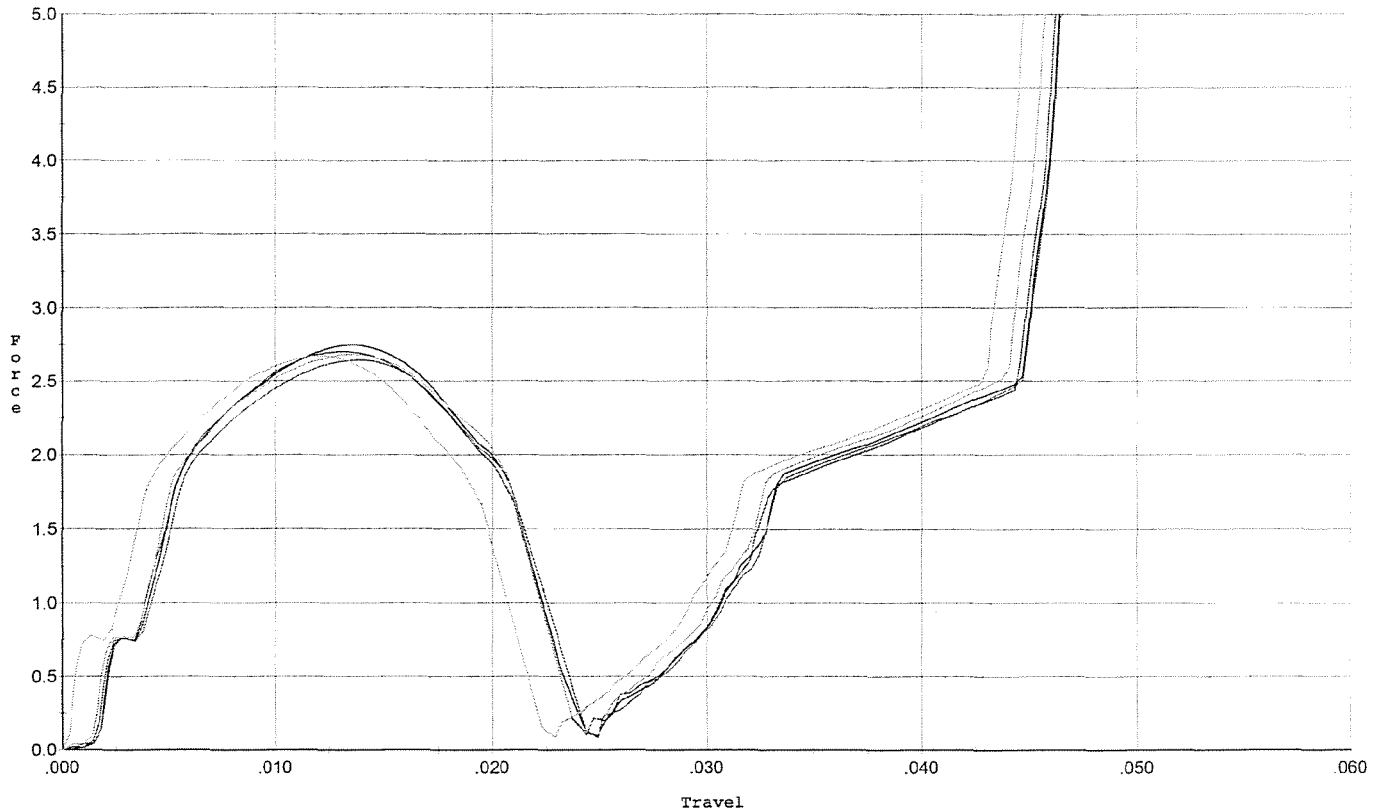
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.227	0.022	0.00	0.020	0.067		Set Trigger
2	4.207	0.024	0.00	0.020	0.070		Set Trigger
3	4.234	0.023	0.00	0.021	0.067		Set Trigger
4	4.224	0.022	0.00	0.021	0.067		Set Trigger
5	4.109	0.024	0.00	0.020	0.068		Set Trigger

A. 4.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



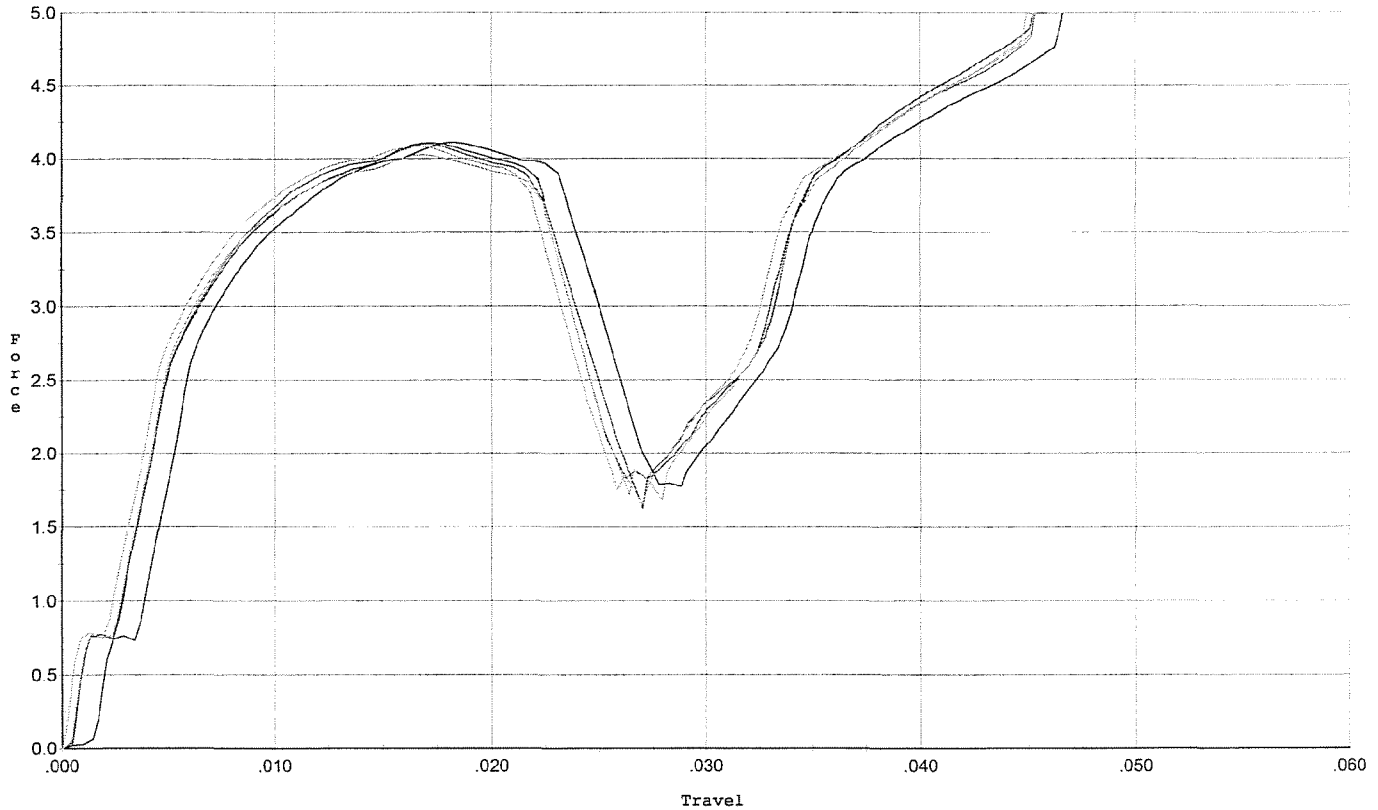
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.699	0.021	0.00	0.031	0.039		Set Trigger
2	2.745	0.021	0.00	0.031	0.039		Set Trigger
3	2.644	0.022	0.00	0.031	0.040		Set Trigger
4	2.669	0.019	0.00	0.031	0.038		Set Trigger
5	2.682	0.021	0.004	0.030	0.039		Set Trigger

A-2068

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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	4.109	0.022	0.00	0.021	0.065		Set Trigger
2	4.111	0.025	0.00	0.021	0.070		Set Trigger
3	4.099	0.022	0.003	0.021	0.065		Set Trigger
4	4.086	0.022	0.00	0.021	0.065		Set Trigger
5	4.027	0.022	0.00	0.021	0.065		Set Trigger

A-4.08