

GG807797

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



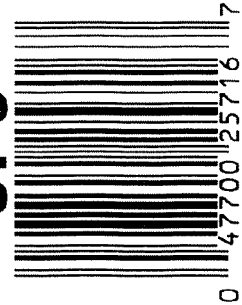
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807797

UPC



GUN SERIAL # G6807797

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		2-27-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	3/5/09	(A)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	mon
540	APPLY COATINGS (BARREL ACTION)		3/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-16-09	L. G.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

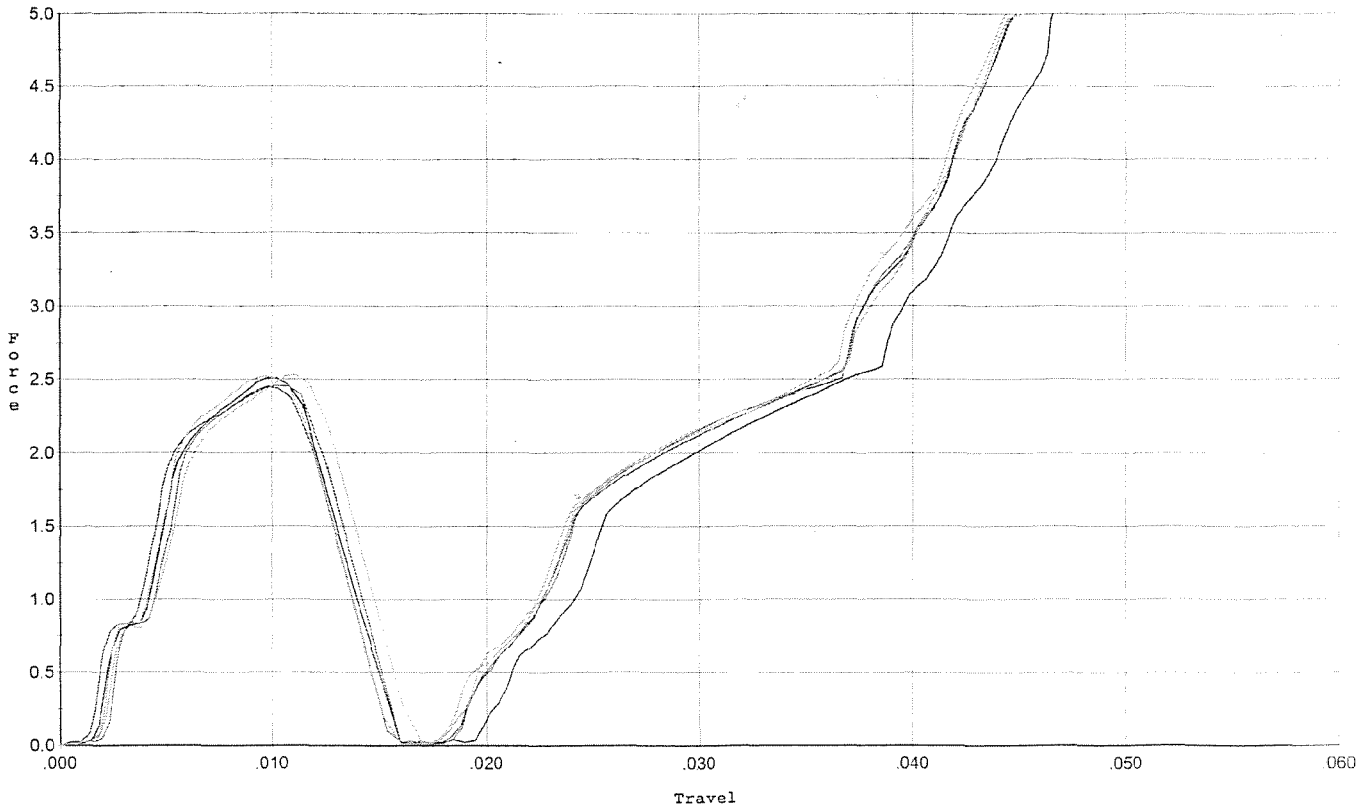
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	3-18-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2</u> <u>2.5</u>	3-18-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	3-18-09	NW
	J) ASSEMBLE STOCK		3-16-09	DS
	K) ASSEMBLE SWIVEL STUDS		3-19-09	NW
	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	3-17-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-18-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u> <u>2.24</u> <u>2.22</u> <u>2.22</u> <u>2.22</u>	3-18-09	TL
	C) FUNCTION		3-18-09	NW
690	PACK		3/19/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



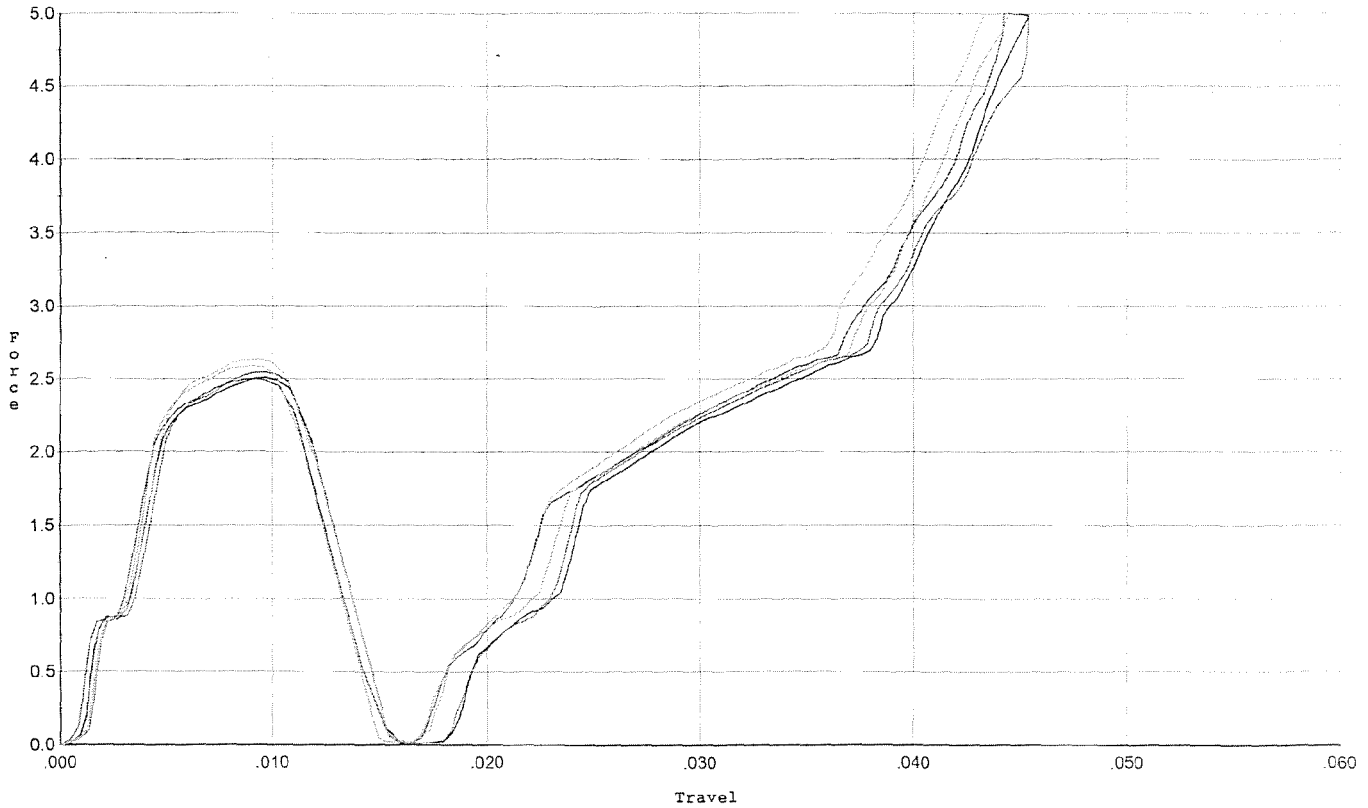
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.012	0.00	0.036	0.018		Set Trigger
2	2.510	0.011	0.00	0.038	0.017		Set Trigger
3	2.455	0.013	0.00	0.036	0.018		Set Trigger
4	2.529	0.013	0.00	0.035	0.019		Set Trigger
5	2.523	0.012	0.00	0.036	0.018		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



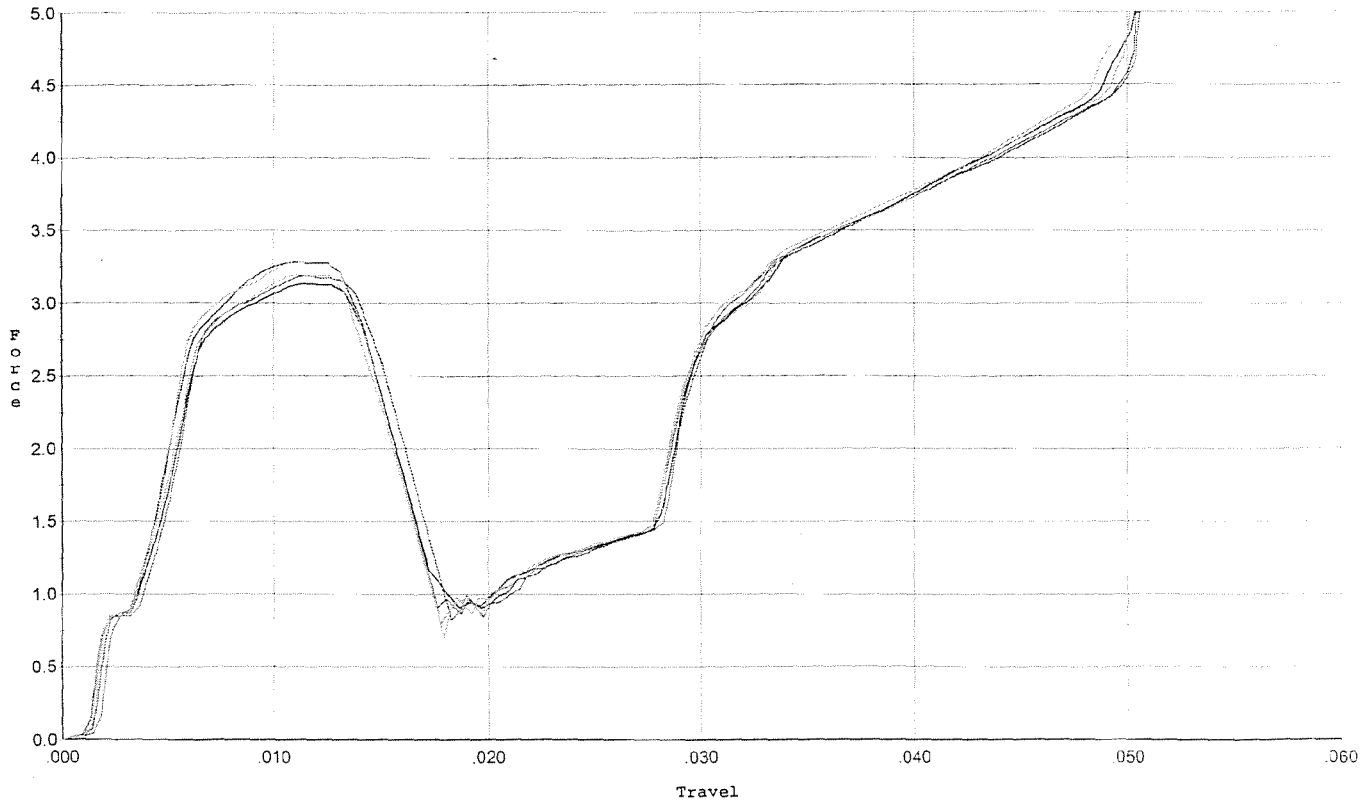
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.498	0.011	0.00	0.035	0.018		Set Trigger
2	2.507	0.012	0.00	0.037	0.019		Set Trigger
3	2.542	0.012	0.00	0.036	0.019		Set Trigger
4	2.628	0.012	0.00	0.034	0.020		Set Trigger
5	2.587	0.011	0.00	0.035	0.019		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



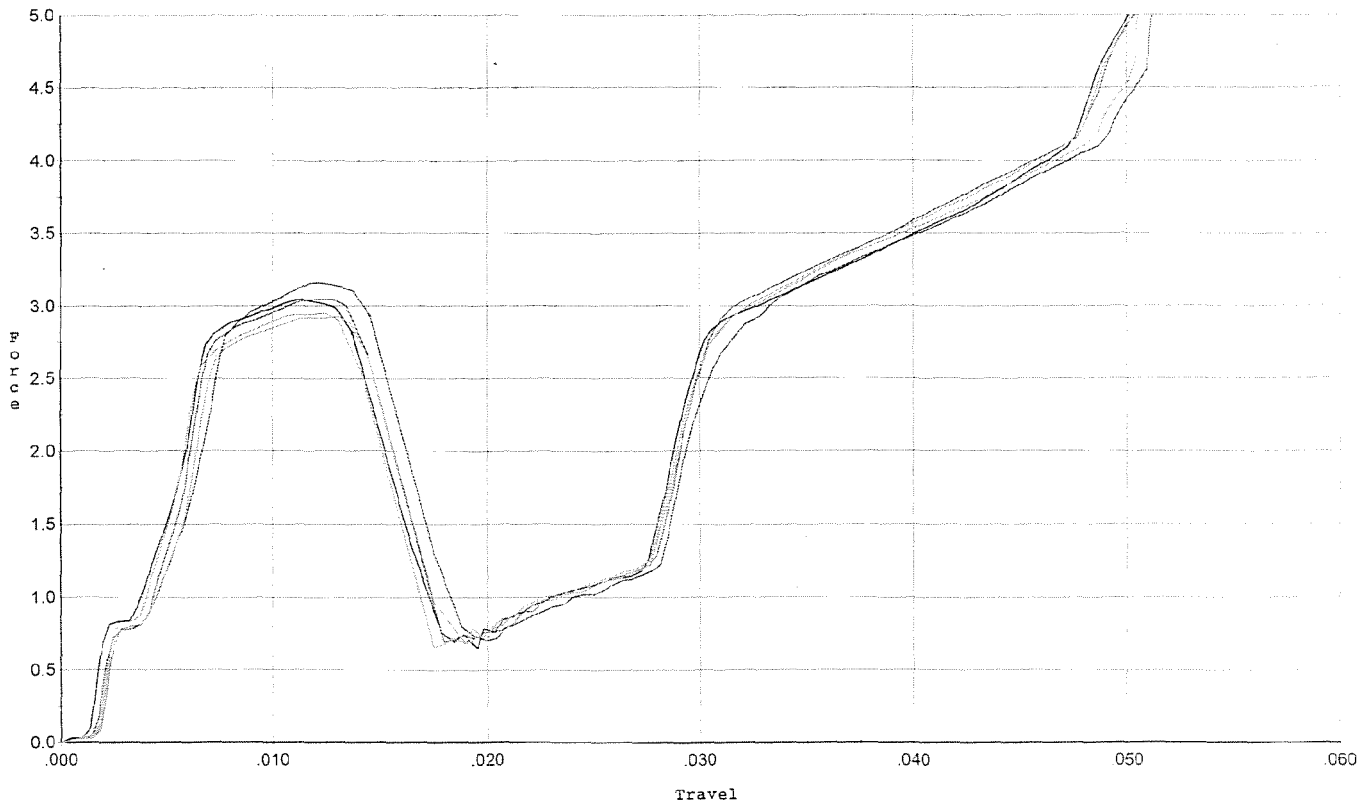
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.280	0.014	0.00	0.036	0.029		Set Trigger
2	3.133	0.014	0.00	0.036	0.028		Set Trigger
3	3.190	0.015	0.00	0.036	0.030		Set Trigger
4	3.194	0.015	0.00	0.036	0.030		Set Trigger
5	3.287	0.014	0.00	0.036	0.030		Set Trigger

A-3-21

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



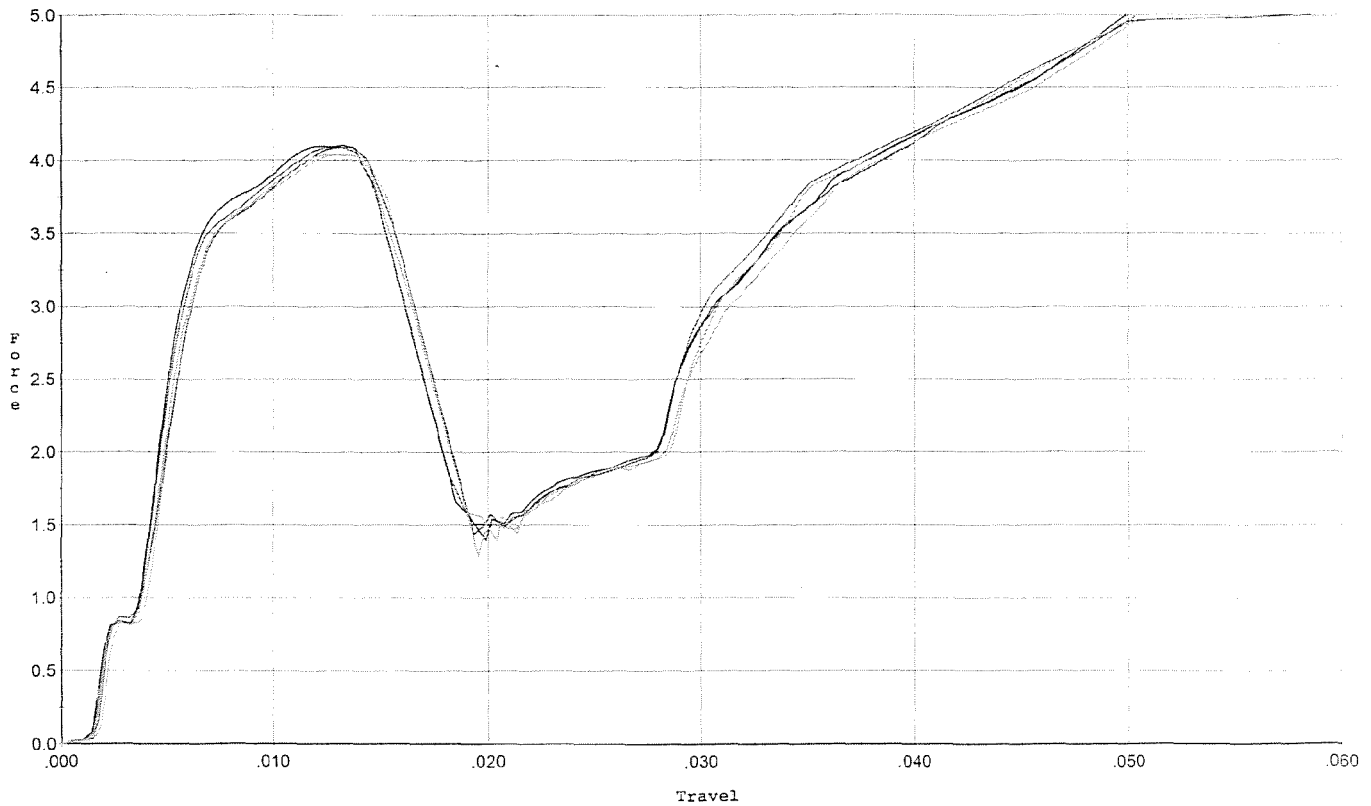
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.161	0.015	0.00	0.037	0.027		Set Trigger
2	3.046	0.014	0.00	0.037	0.026		Set Trigger
3	3.045	0.014	0.00	0.036	0.027		Set Trigger
4	2.928	0.014	0.00	0.037	0.026		Set Trigger
5	2.947	0.014	0.00	0.037	0.026		Set Trigger

A-3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



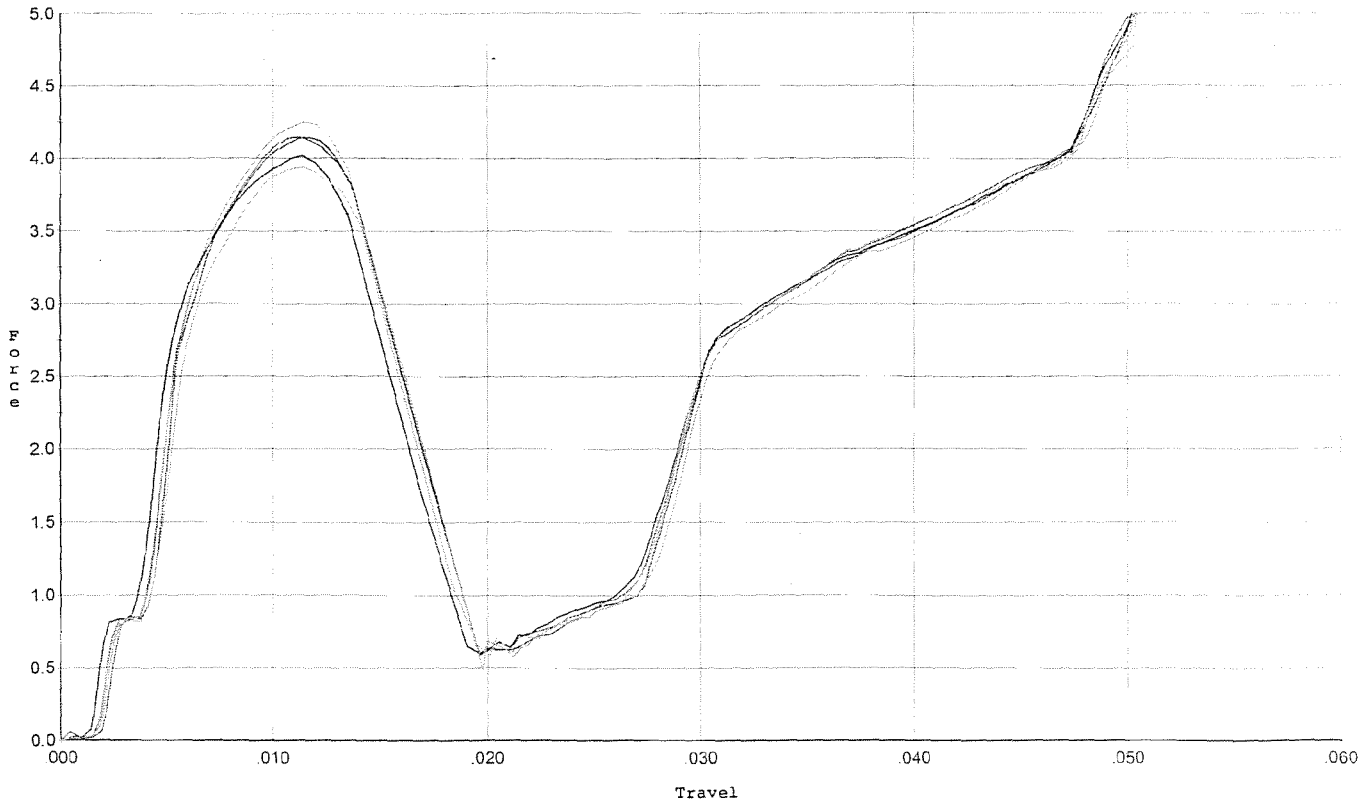
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.016	0.00	0.034	0.039		Set Trigger
2	4.101	0.015	0.00	0.034	0.038		Set Trigger
3	4.085	0.015	0.00	0.034	0.037		Set Trigger
4	4.035	0.015	0.00	0.034	0.038		Set Trigger
5	4.038	0.016	0.00	0.034	0.041		Set Trigger

A- 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



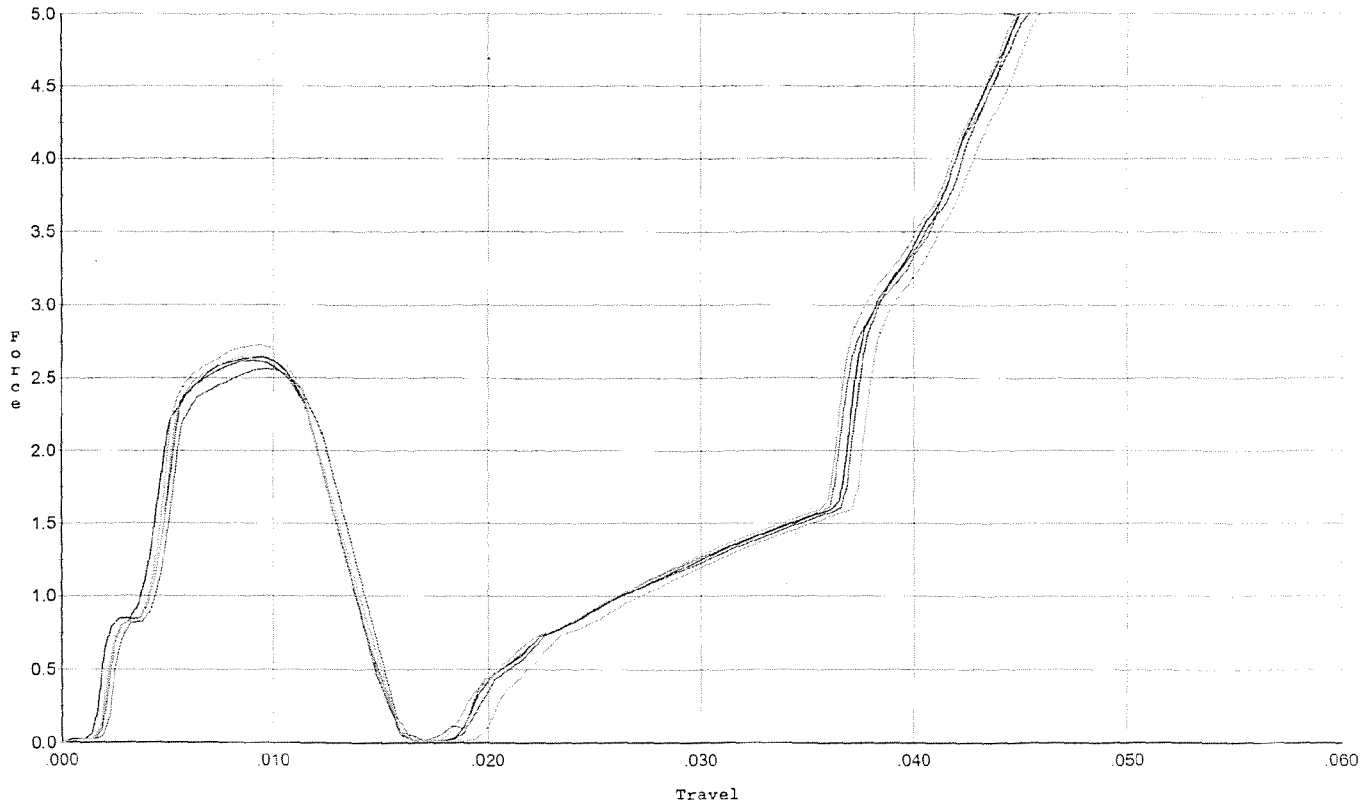
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.014	0.00	0.036	0.033		Set Trigger
2	4.016	0.013	0.00	0.036	0.033		Set Trigger
3	4.147	0.014	0.002	0.036	0.033		Set Trigger
4	3.937	0.014	0.00	0.036	0.033		Set Trigger
5	4.249	0.016	0.00	0.035	0.040		Set Trigger

A. 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



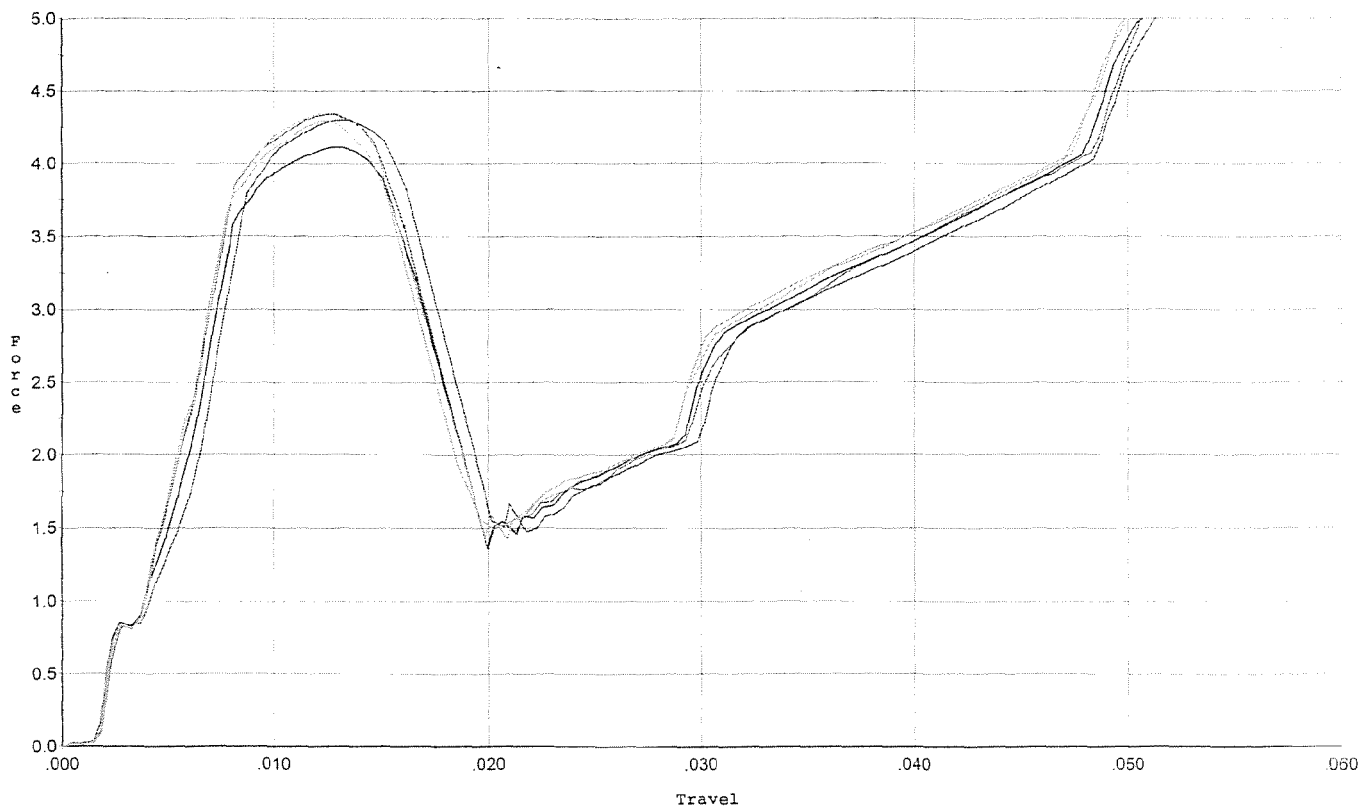
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.623	0.012	0.00	0.037	0.018		Set Trigger
2	2.646	0.011	0.00	0.037	0.019		Set Trigger
3	2.562	0.012	0.00	0.036	0.019		Set Trigger
4	2.730	0.011	0.00	0.038	0.018		Set Trigger
5	2.645	0.011	0.00	0.036	0.018		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

Model: M24
Serial No: Form #F005
Trigger: 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	4.296	0.016	0.00	0.034	0.040		Set Trigger
2	4.112	0.017	0.00	0.034	0.041		Set Trigger
3	4.336	0.016	0.00	0.034	0.041		Set Trigger
4	4.351	0.017	0.00	0.034	0.043		Set Trigger
5	4.299	0.015	0.00	0.034	0.038		Set Trigger

A. 4.27