

6680 7804

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



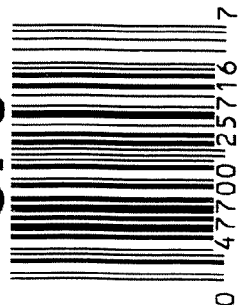
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807804

UPC



GUN SERIAL # 66807804

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		2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
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	MTW
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

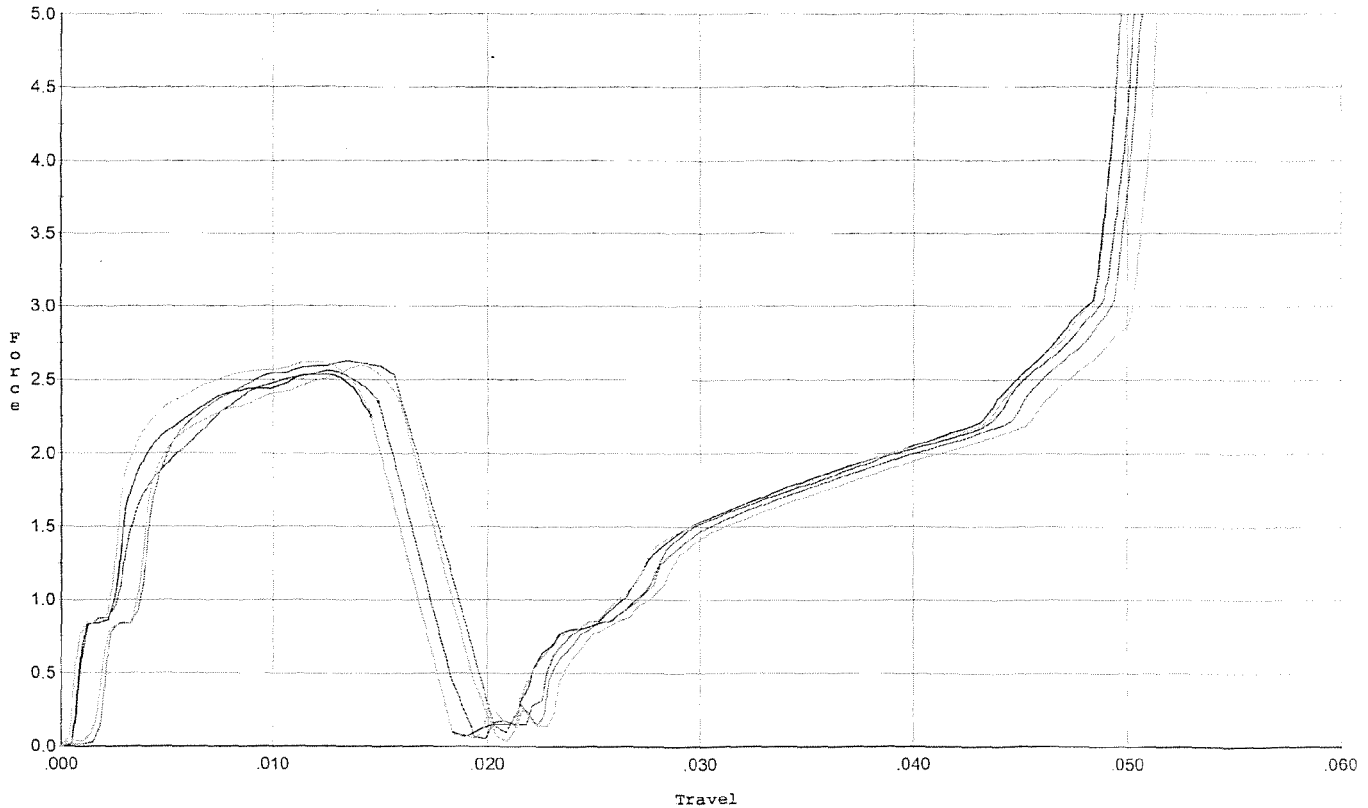
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>45</u> <u>65</u> <u>6</u>	3-19-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3.5</u>	3-19-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-19-09	WV
	J) ASSEMBLE STOCK		3-16-09	JS
	K) ASSEMBLE SWIVEL STUDS		3-19-09	WV
	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	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-19-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.67</u> <u>2.72</u> <u>2.65</u> <u>2.64</u>	3-18-09	TC
	C) FUNCTION		3-19-09	WV
690	PACK		3/22/09	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



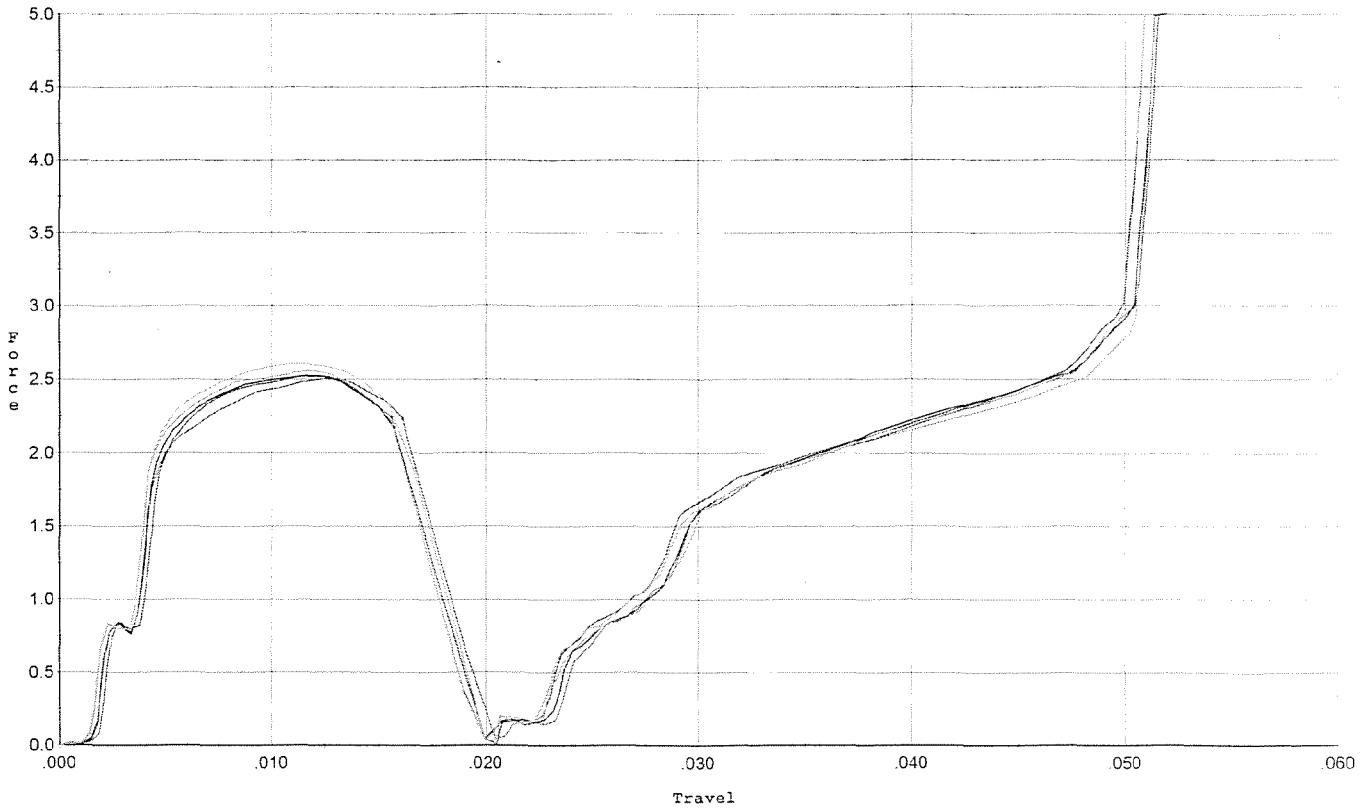
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.563	0.015	0.00	0.039	0.027		Set Trigger
2	2.534	0.015	0.00	0.038	0.027		Set Trigger
3	2.628	0.018	0.00	0.038	0.032		Set Trigger
4	2.624	0.014	0.00	0.038	0.028		Set Trigger
5	2.597	0.016	0.00	0.039	0.028		Set Trigger

A-2.58

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



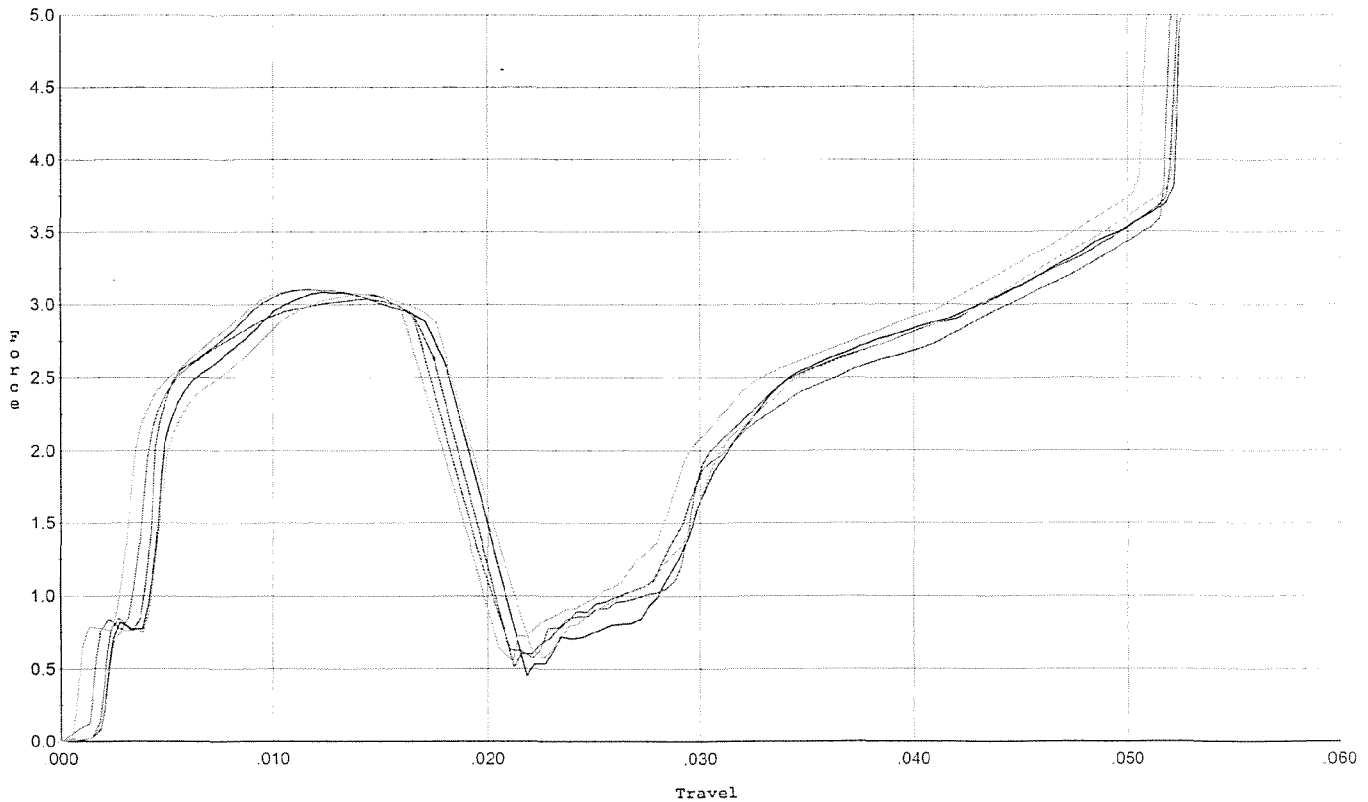
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.016	0.00	0.038	0.027		Set Trigger
2	2.523	0.016	0.00	0.039	0.028		Set Trigger
3	2.506	0.016	0.00	0.039	0.028		Set Trigger
4	2.606	0.017	0.004	0.038	0.031		Set Trigger
5	2.553	0.016	0.004	0.039	0.028		Set Trigger

A-2-54

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



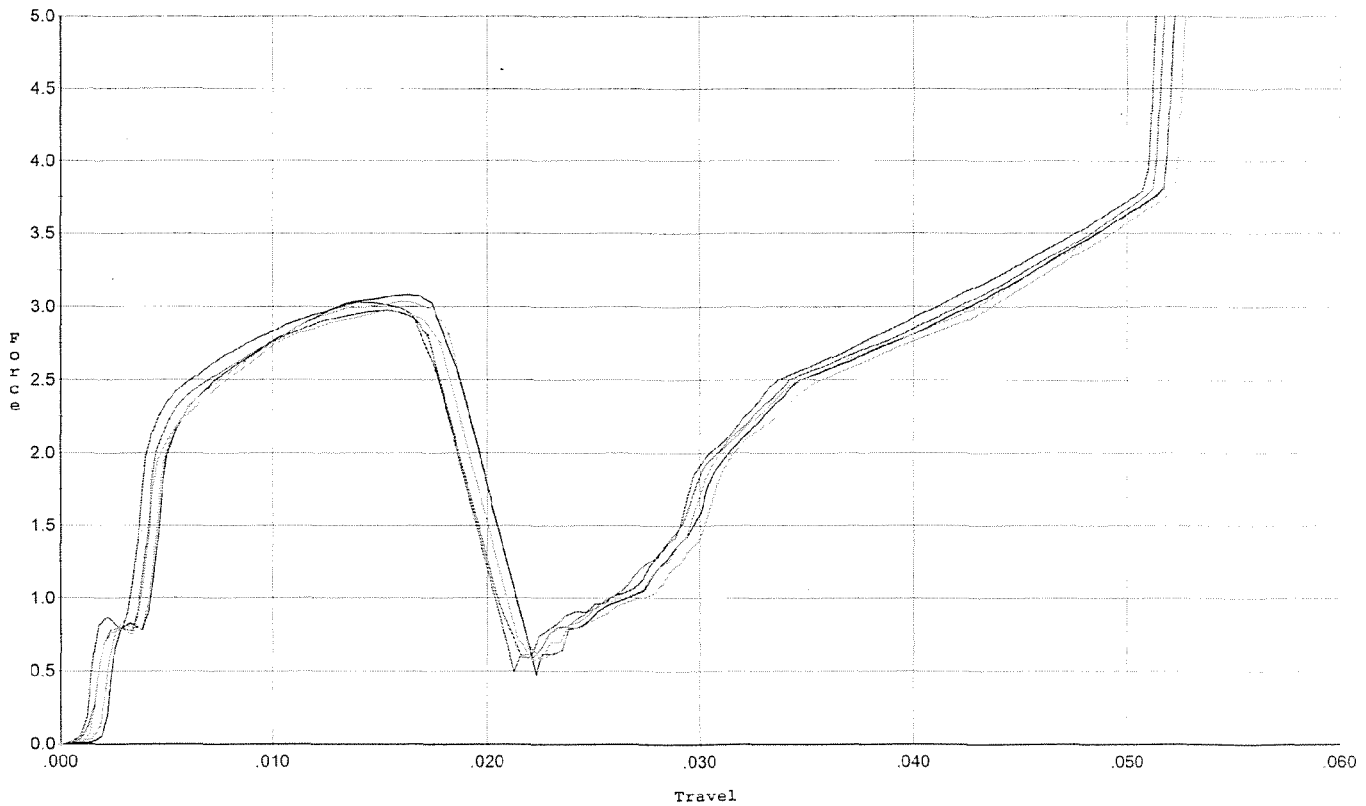
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.018	0.00	0.036	0.037		Set Trigger
2	3.084	0.018	0.004	0.036	0.038		Set Trigger
3	3.034	0.017	0.00	0.037	0.036		Set Trigger
4	3.073	0.018	0.002	0.037	0.036		Set Trigger
5	3.104	0.018	0.003	0.035	0.040		Set Trigger

A.3.07

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



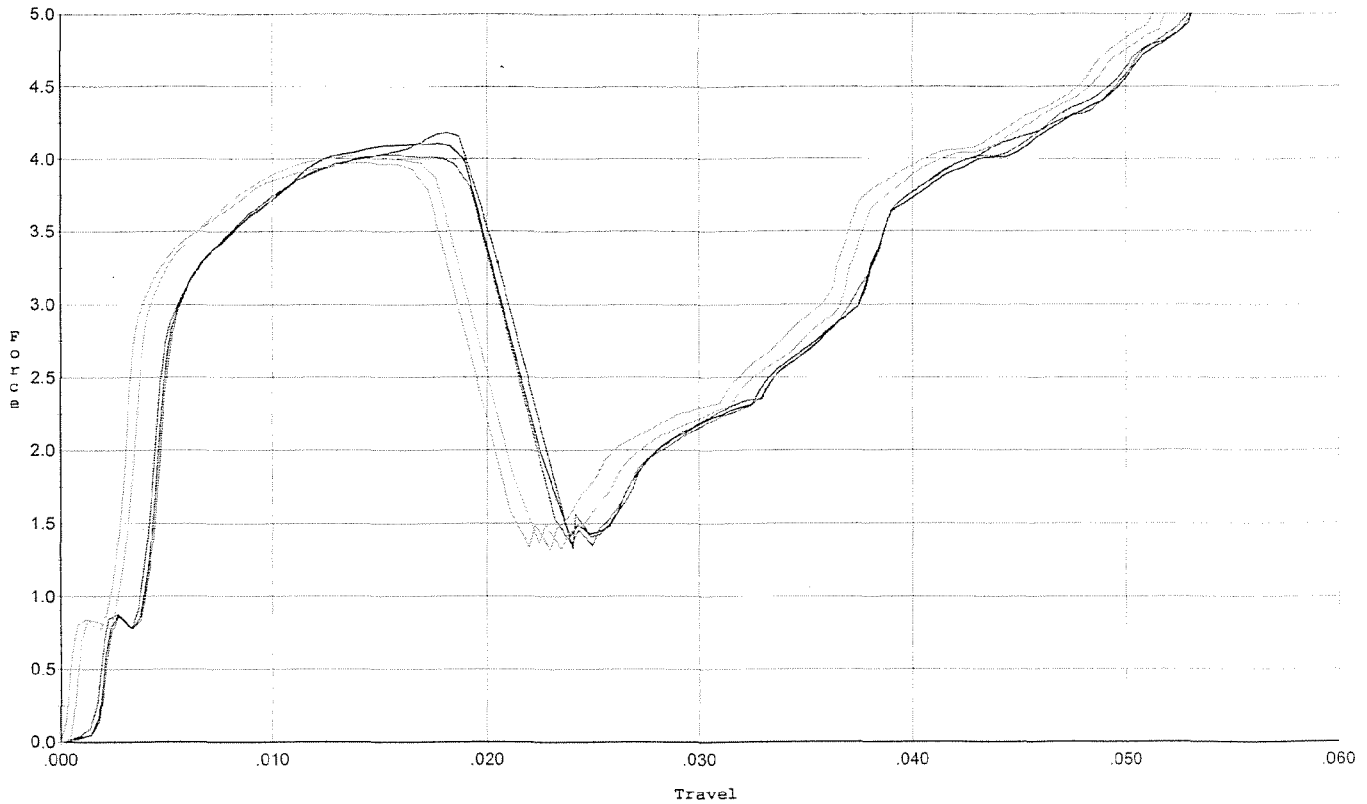
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.029	0.018	0.00	0.036	0.038		Set Trigger
2	3.082	0.019	0.002	0.036	0.038		Set Trigger
3	2.974	0.017	0.00	0.036	0.036		Set Trigger
4	2.967	0.018	0.00	0.036	0.036		Set Trigger
5	3.035	0.018	0.004	0.036	0.038		Set Trigger

A-3.01

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



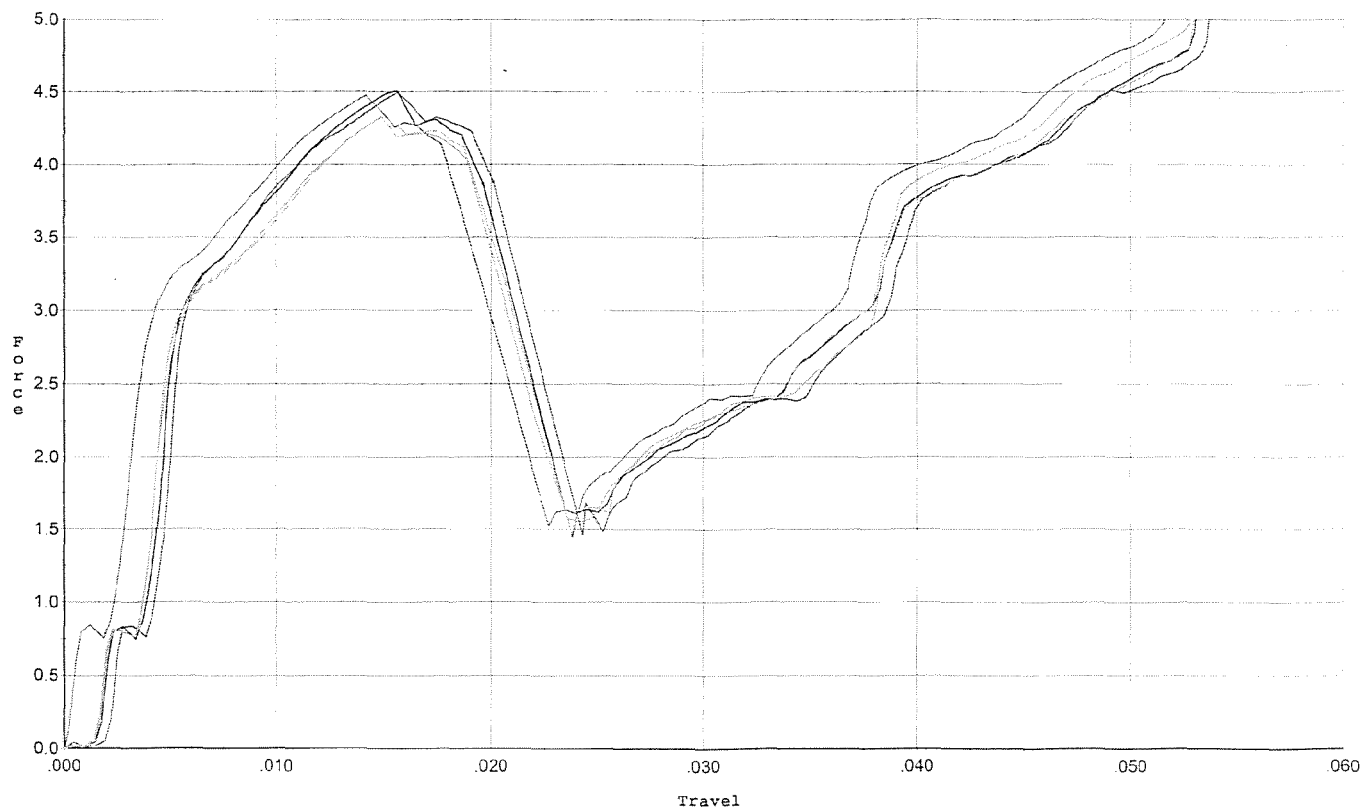
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.183	0.020	0.00	0.034	0.058		Set Trigger
2	4.108	0.019	0.00	0.034	0.053		Set Trigger
3	4.028	0.019	0.00	0.034	0.053		Set Trigger
4	4.020	0.018	0.003	0.034	0.051		Set Trigger
5	3.974	0.017	0.00	0.034	0.050		Set Trigger

A-4.06

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



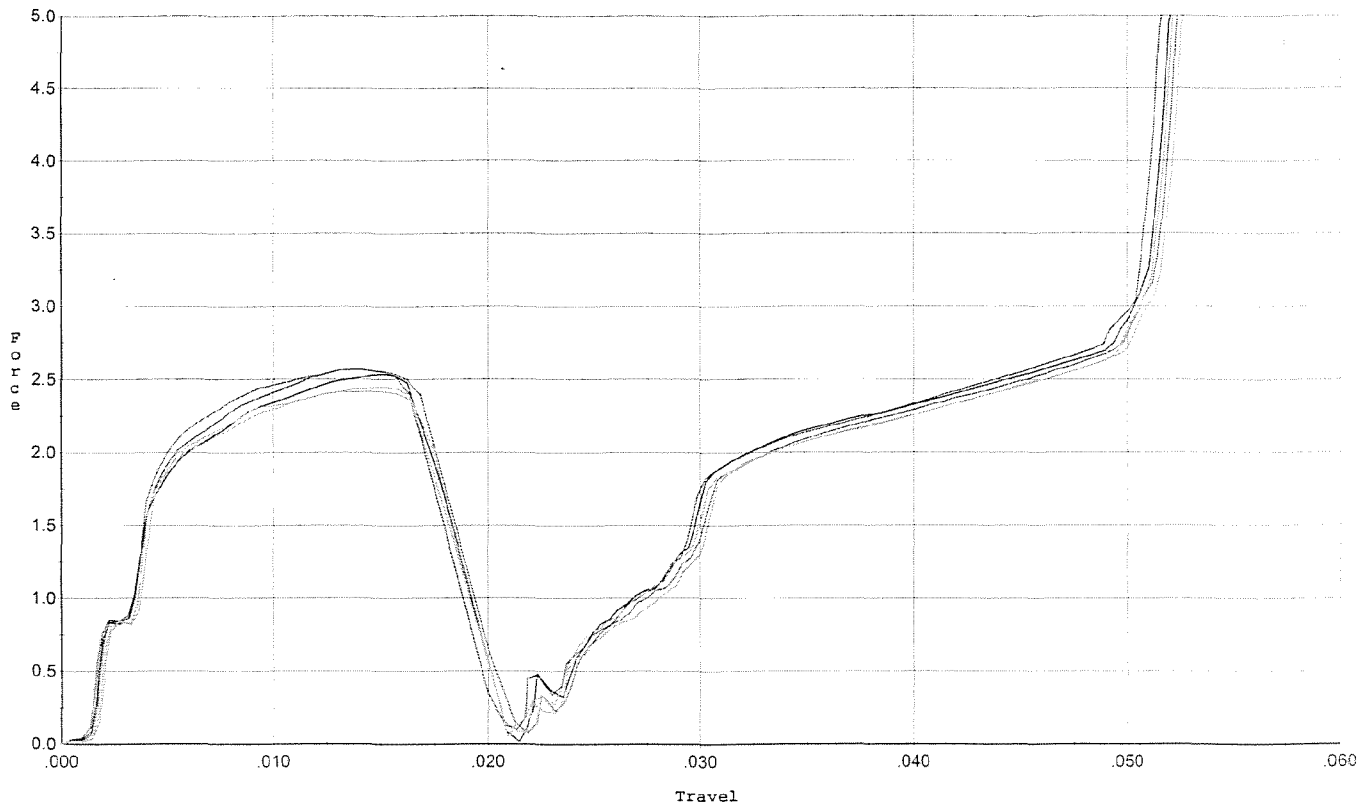
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.493	0.020	0.00	0.034	0.058		Set Trigger
2	4.506	0.020	0.00	0.034	0.057		Set Trigger
3	4.476	0.020	0.00	0.033	0.061		Set Trigger
4	4.334	0.021	0.004	0.033	0.058		Set Trigger
5	4.328	0.019	0.004	0.034	0.053		Set Trigger

A.4.42

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



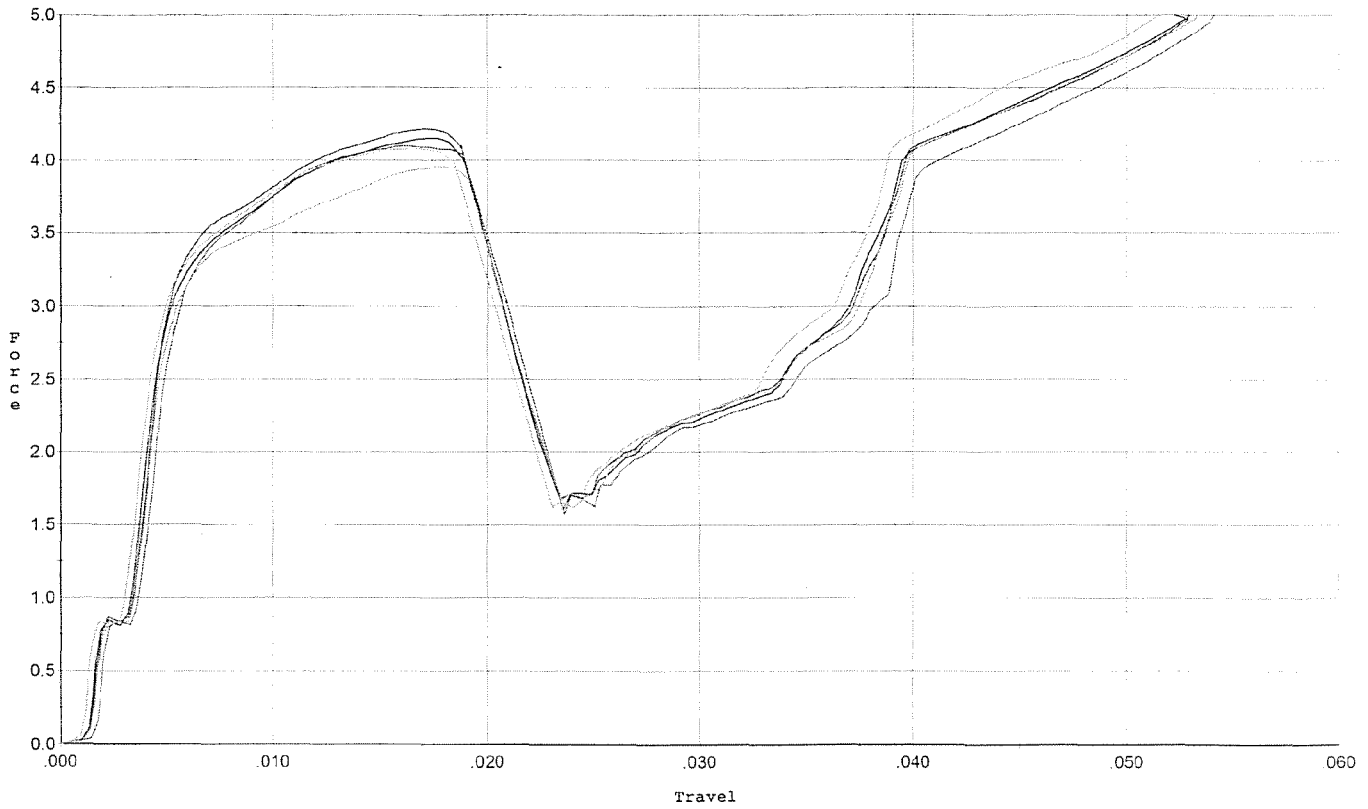
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.568	0.016	0.00	0.038	0.030		Set Trigger
2	2.532	0.018	0.00	0.038	0.031		Set Trigger
3	2.569	0.017	0.00	0.038	0.031		Set Trigger
4	2.447	0.017	0.00	0.038	0.030		Set Trigger
5	2.419	0.018	0.00	0.039	0.031		Set Trigger

A-2.50

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	4.218	0.019	0.00	0.034	0.054		Set Trigger
2	4.150	0.019	0.00	0.034	0.054		Set Trigger
3	4.097	0.021	0.00	0.035	0.058		Set Trigger
4	4.079	0.018	0.003	0.034	0.053		Set Trigger
5	3.955	0.019	0.00	0.034	0.052		Set Trigger

A. 4.10