

66845318

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



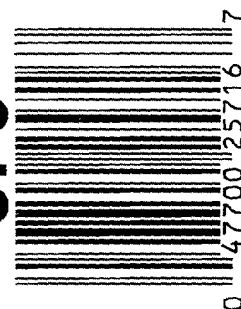
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6845318

UPC



GUN SERIAL # 66845318

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
472	SERIALIZE BOLT HANDLE		3-18-09	RT
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	①	3/20/09	①
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-20-09	24
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

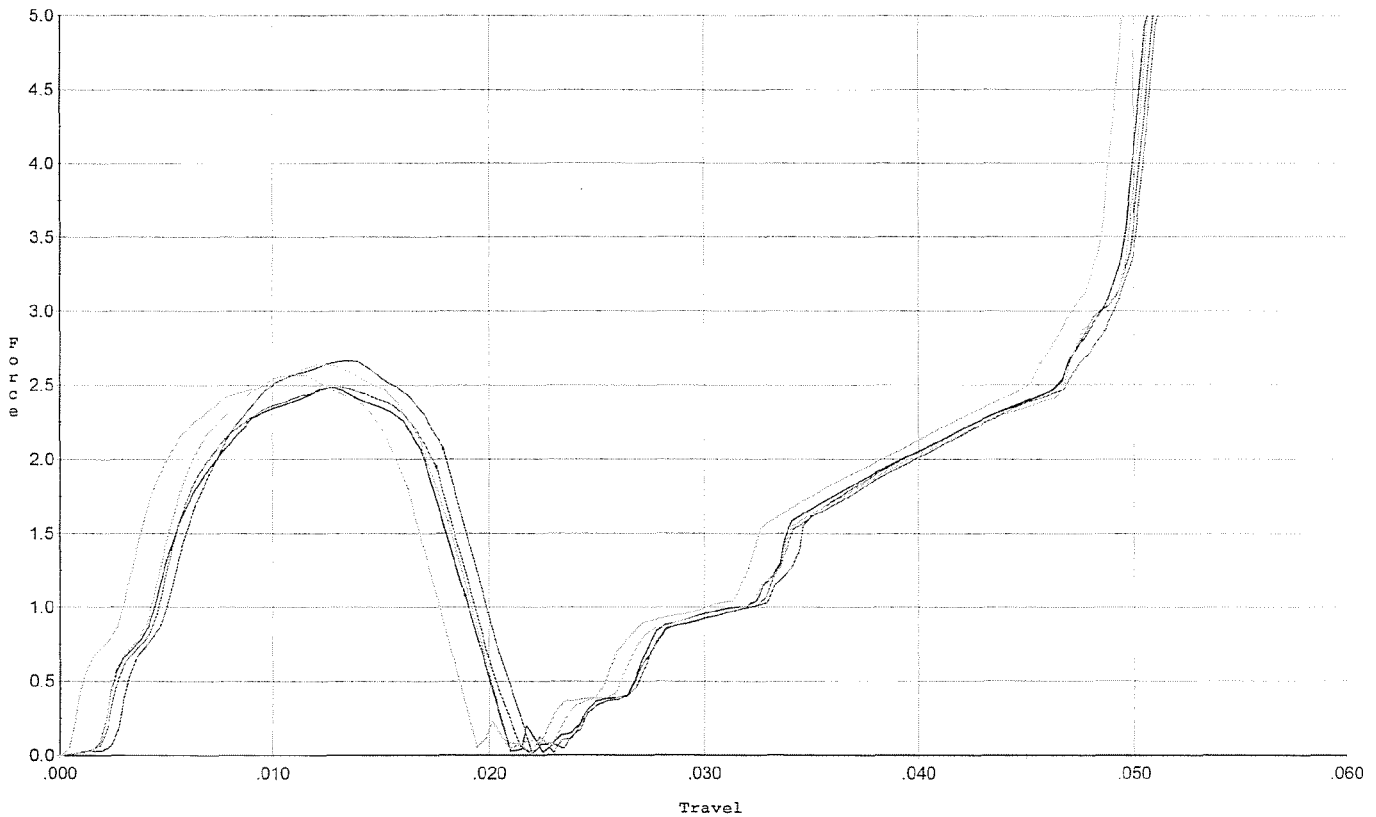
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>24</u> <u>24</u> <u>25</u>	4/28/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>38</u> <u>38</u> <u>38</u>	4/28/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4/28/09	RP
	J) ASSEMBLE STOCK		4-28-09	LW
	K) ASSEMBLE SWIVEL STUDS		4/28/09	RP
	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	4-21-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-21-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE		4/28/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.50</u> <u>2.32</u> <u>2.32</u> <u>2.44</u>	4-22-09	WV
	C) FUNCTION		4/28/09	RP
690	PACK		5/29/09	Fuy

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



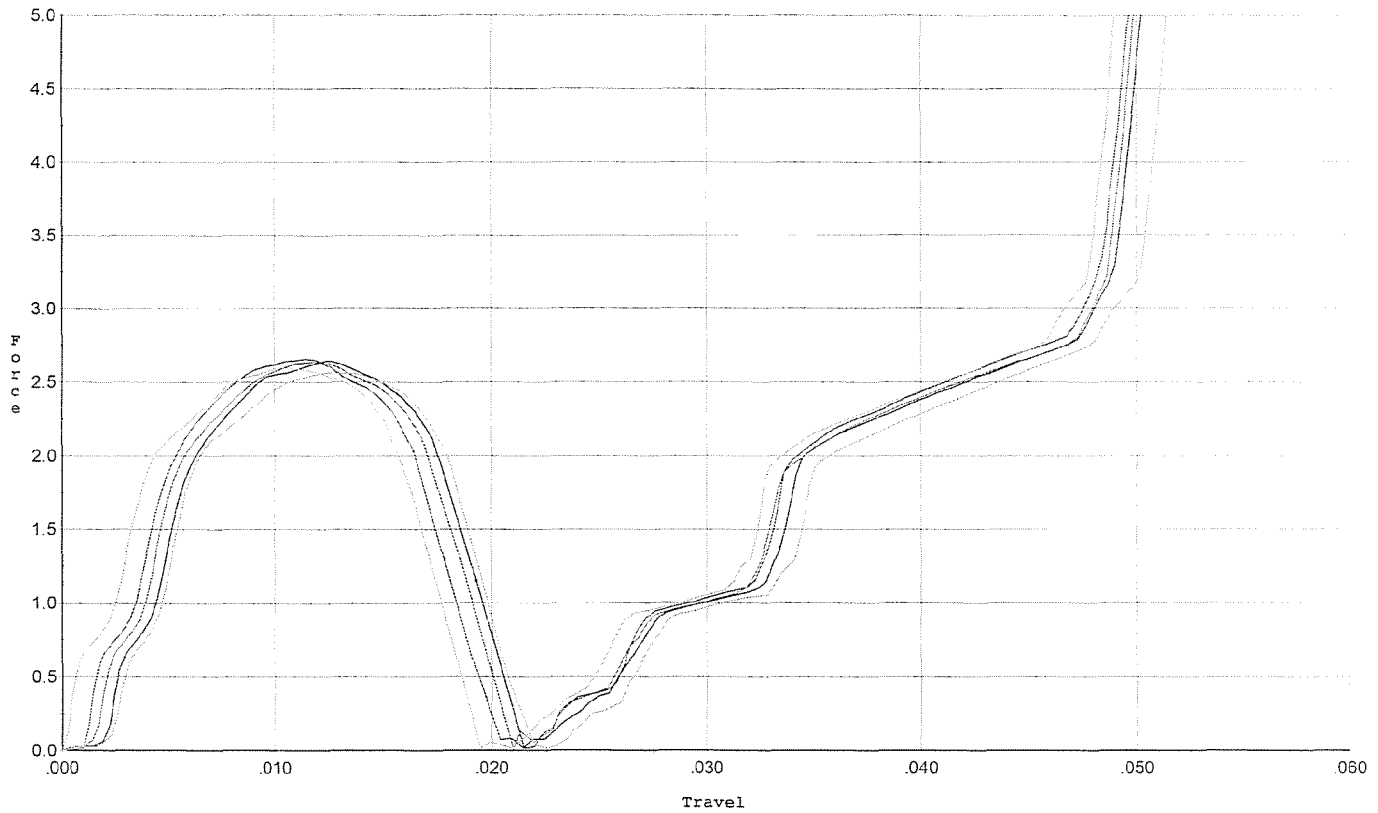
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.662	0.018	0.00	0.037	0.030		Set Trigger
2	2.488	0.019	0.00	0.037	0.030		Set Trigger
3	2.488	0.018	0.00	0.038	0.029		Set Trigger
4	2.638	0.018	0.00	0.037	0.031		Set Trigger
5	2.567	0.016	0.00	0.038	0.029		Set Trigger

A-2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



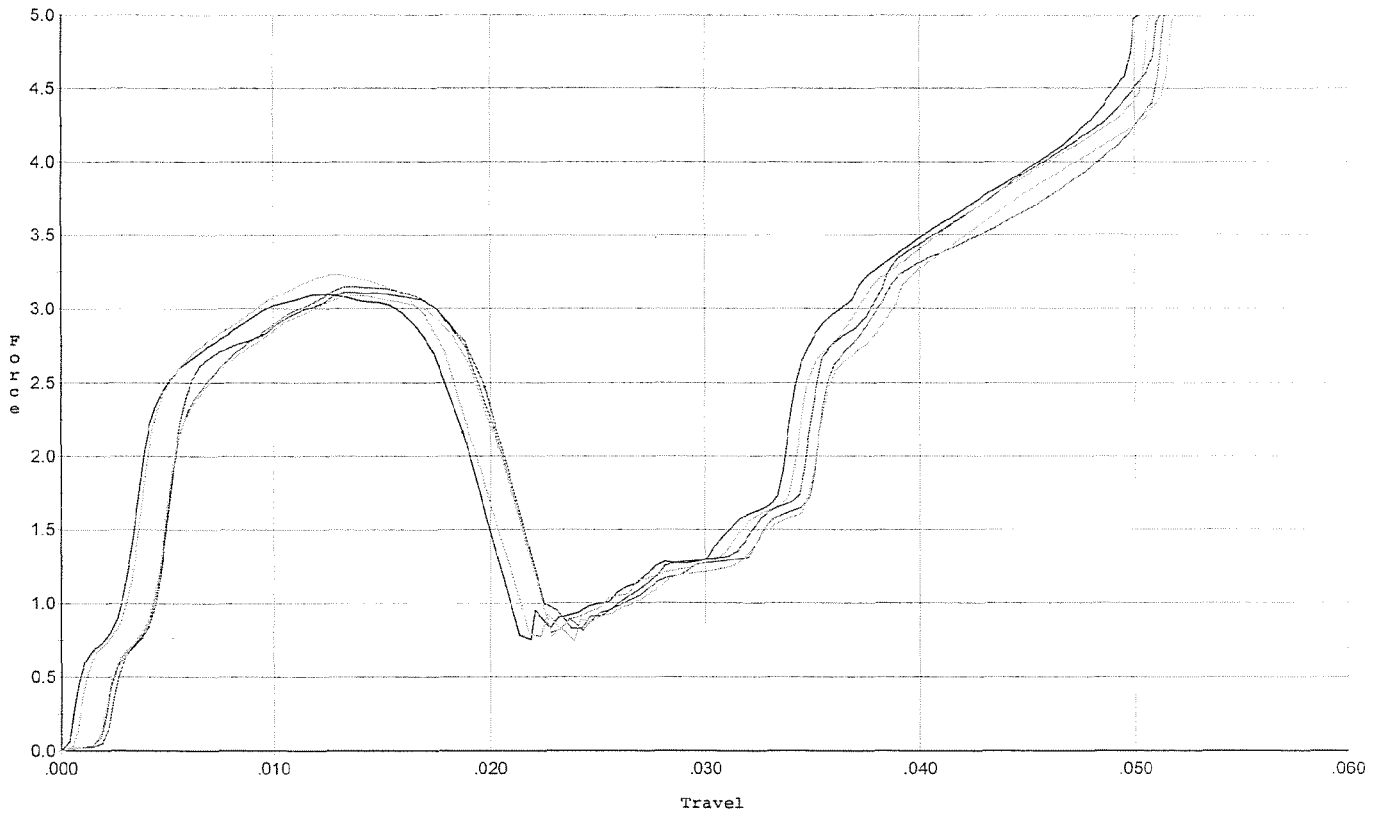
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.657	0.016	0.00	0.037	0.030		Set Trigger
2	2.645	0.019	0.00	0.036	0.033		Set Trigger
3	2.637	0.019	0.00	0.036	0.033		Set Trigger
4	2.598	0.016	0.00	0.037	0.031		Set Trigger
5	2.566	0.018	0.002	0.037	0.030		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



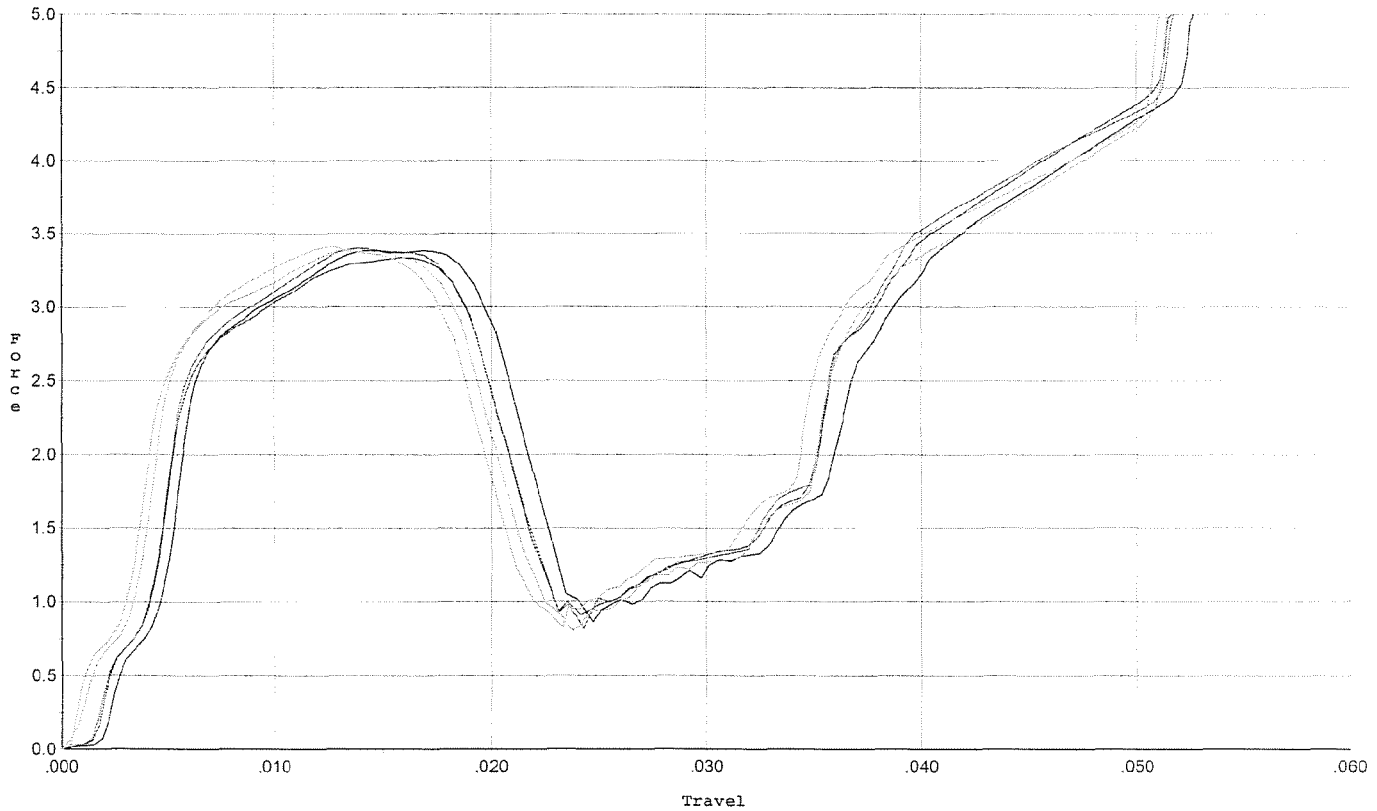
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.110	0.020	0.00	0.035	0.042		Set Trigger
2	3.098	0.019	0.00	0.034	0.042		Set Trigger
3	3.150	0.020	0.00	0.035	0.042		Set Trigger
4	3.089	0.020	0.00	0.035	0.042		Set Trigger
5	3.231	0.020	0.00	0.035	0.045		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



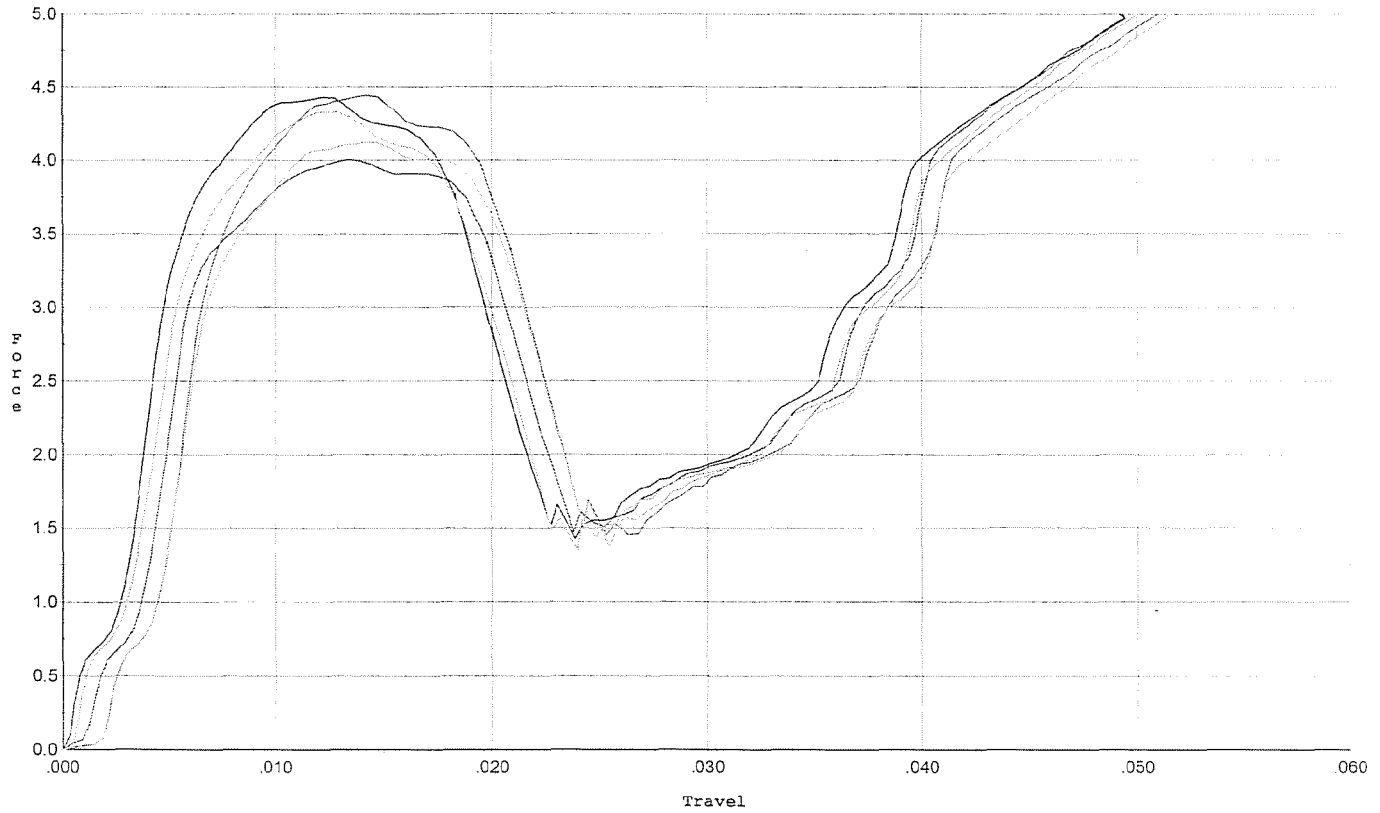
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.338	0.019	0.00	0.035	0.043		Set Trigger
2	3.385	0.020	0.002	0.035	0.046		Set Trigger
3	3.404	0.019	0.00	0.035	0.044		Set Trigger
4	3.415	0.018	0.00	0.035	0.044		Set Trigger
5	3.383	0.019	0.00	0.035	0.044		Set Trigger

A-338

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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



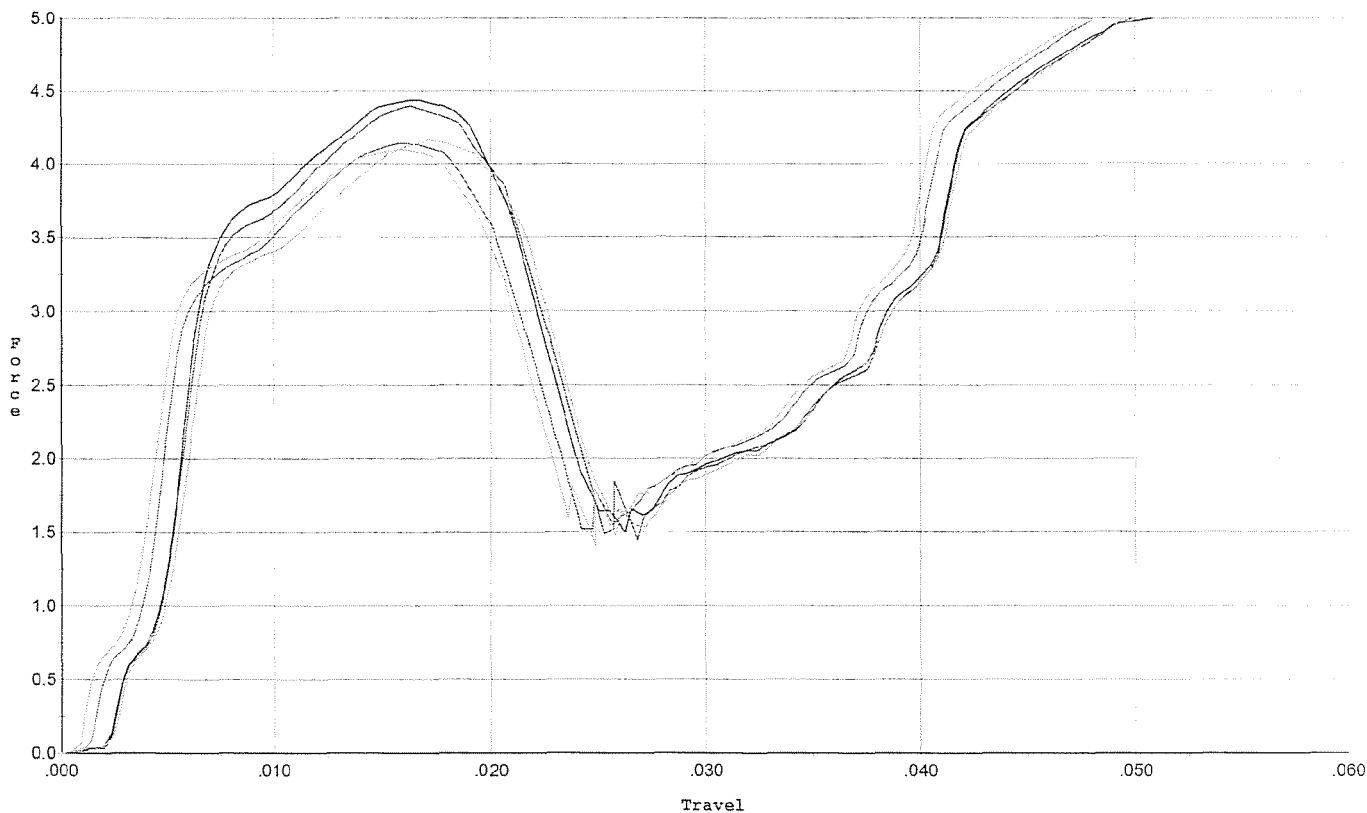
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.005	0.020	0.00	0.033	0.054		Set Trigger
2	4.431	0.018	0.00	0.033	0.056		Set Trigger
3	4.443	0.021	0.00	0.033	0.059		Set Trigger
4	4.126	0.021	0.00	0.033	0.057		Set Trigger
5	4.331	0.020	0.00	0.033	0.058		Set Trigger

A-4-26

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



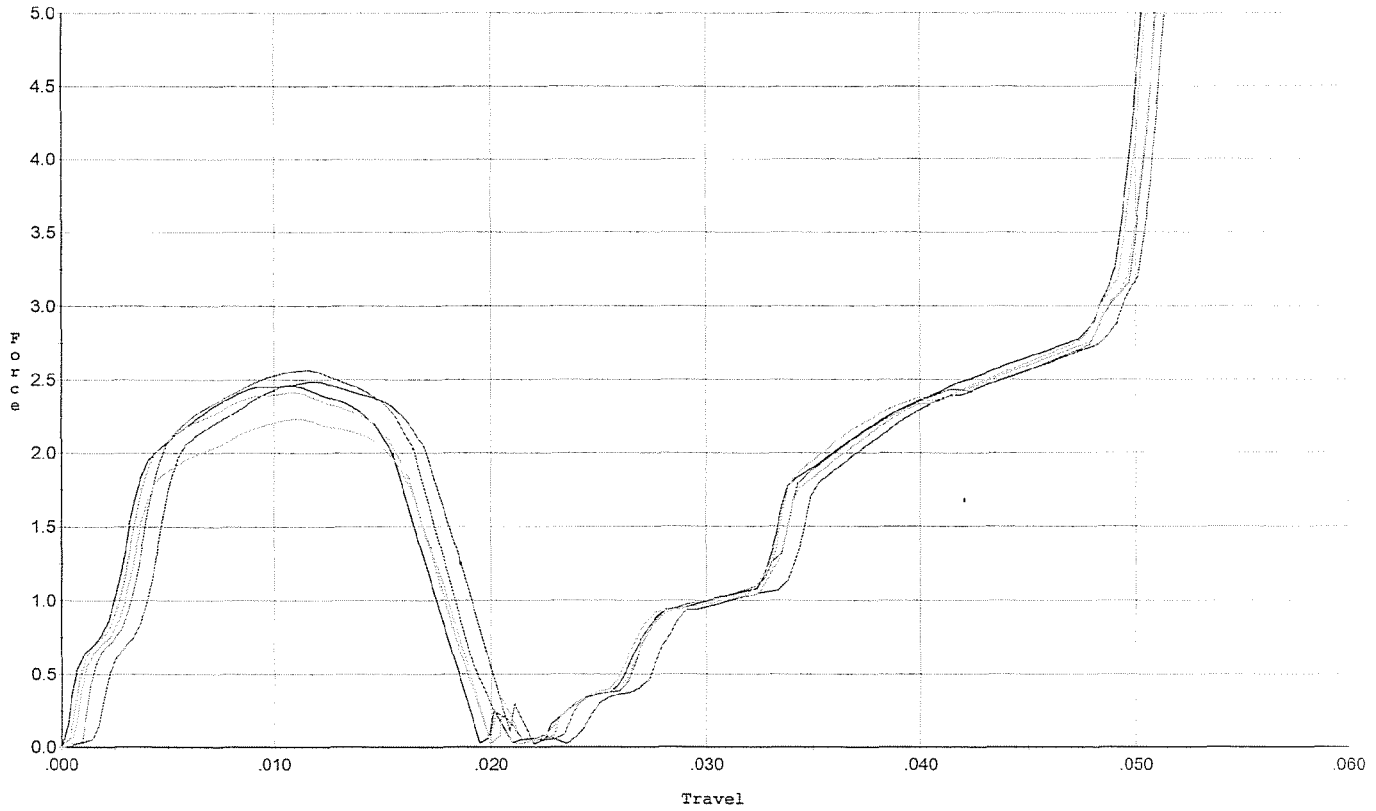
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.400	0.023	0.002	0.032	0.063		Set Trigger
2	4.437	0.021	0.00	0.033	0.059		Set Trigger
3	4.139	0.022	0.00	0.033	0.059		Set Trigger
4	4.099	0.021	0.00	0.033	0.057		Set Trigger
5	4.166	0.022	0.00	0.033	0.057		Set Trigger

A-424

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/13/2009

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



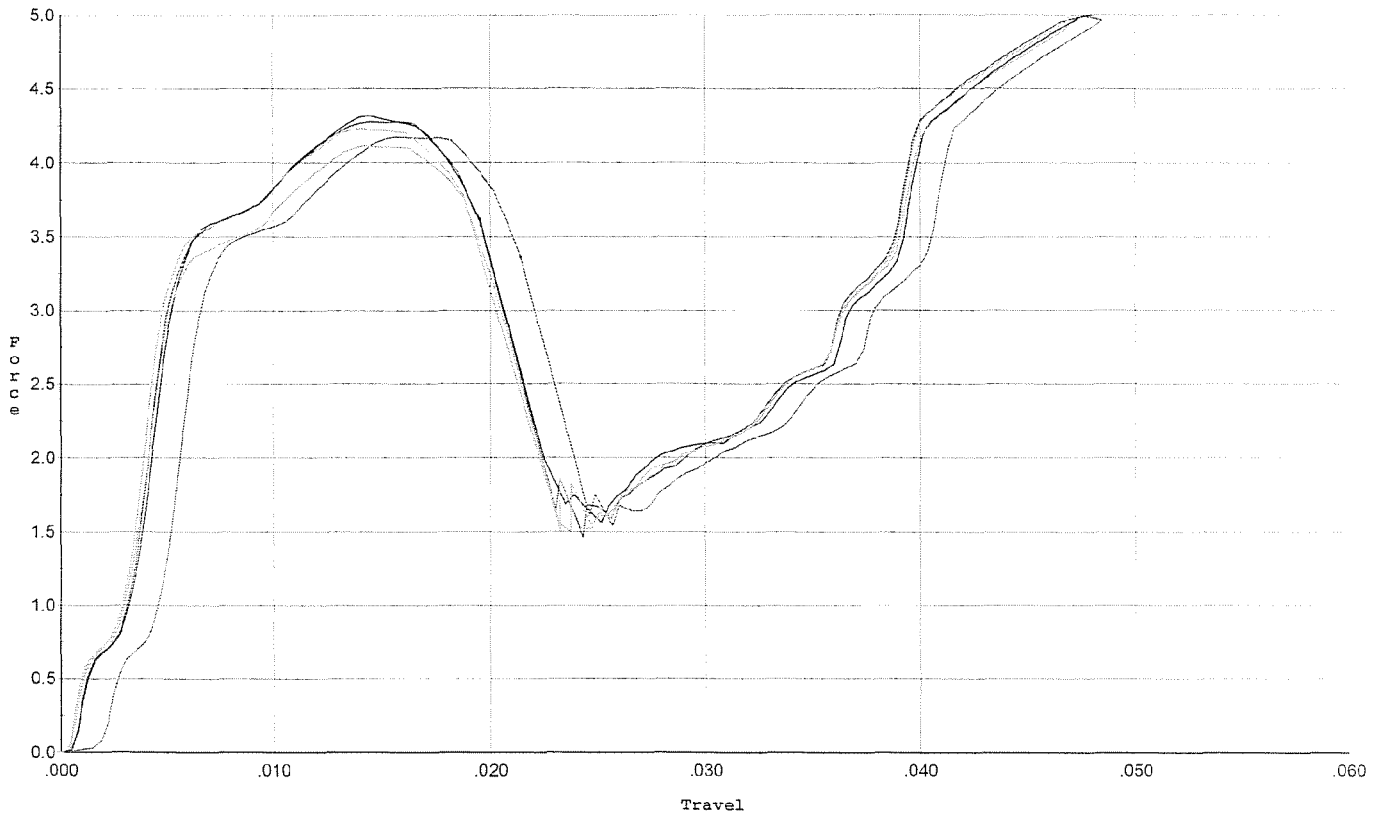
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.019	0.00	0.037	0.031		Set Trigger
2	2.465	0.015	0.00	0.038	0.028		Set Trigger
3	2.568	0.016	0.00	0.038	0.030		Set Trigger
4	2.234	0.018	0.00	0.038	0.029		Set Trigger
5	2.415	0.016	0.00	0.039	0.029		Set Trigger

A.2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/13/2009

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	4.277	0.020	0.00	0.032	0.057		Set Trigger
2	4.319	0.019	0.00	0.033	0.057		Set Trigger
3	4.174	0.021	0.00	0.033	0.058		Set Trigger
4	4.231	0.019	0.00	0.033	0.055		Set Trigger
5	4.115	0.020	0.00	0.033	0.057		Set Trigger

A-4-22