

66778828

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



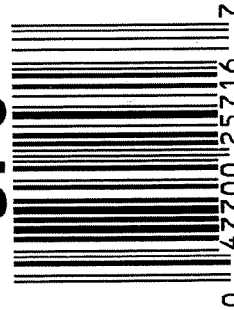
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6778828

UPC



GUN SERIAL #

G 6778828

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	S.P.D.
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	S.P.D.
460	CHECK HEADSPACE		8-20-08	S.P.D.
470	DIS-ASSEMBLE ACTION		8-20-08	S.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-21-08	KIT
475	DRILL AND TAP SIGHT HOLES	AUG 22 2008	8-21-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR B.H.	8-22-08	B.H.
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-29-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-29-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-29-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-22-08	S.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

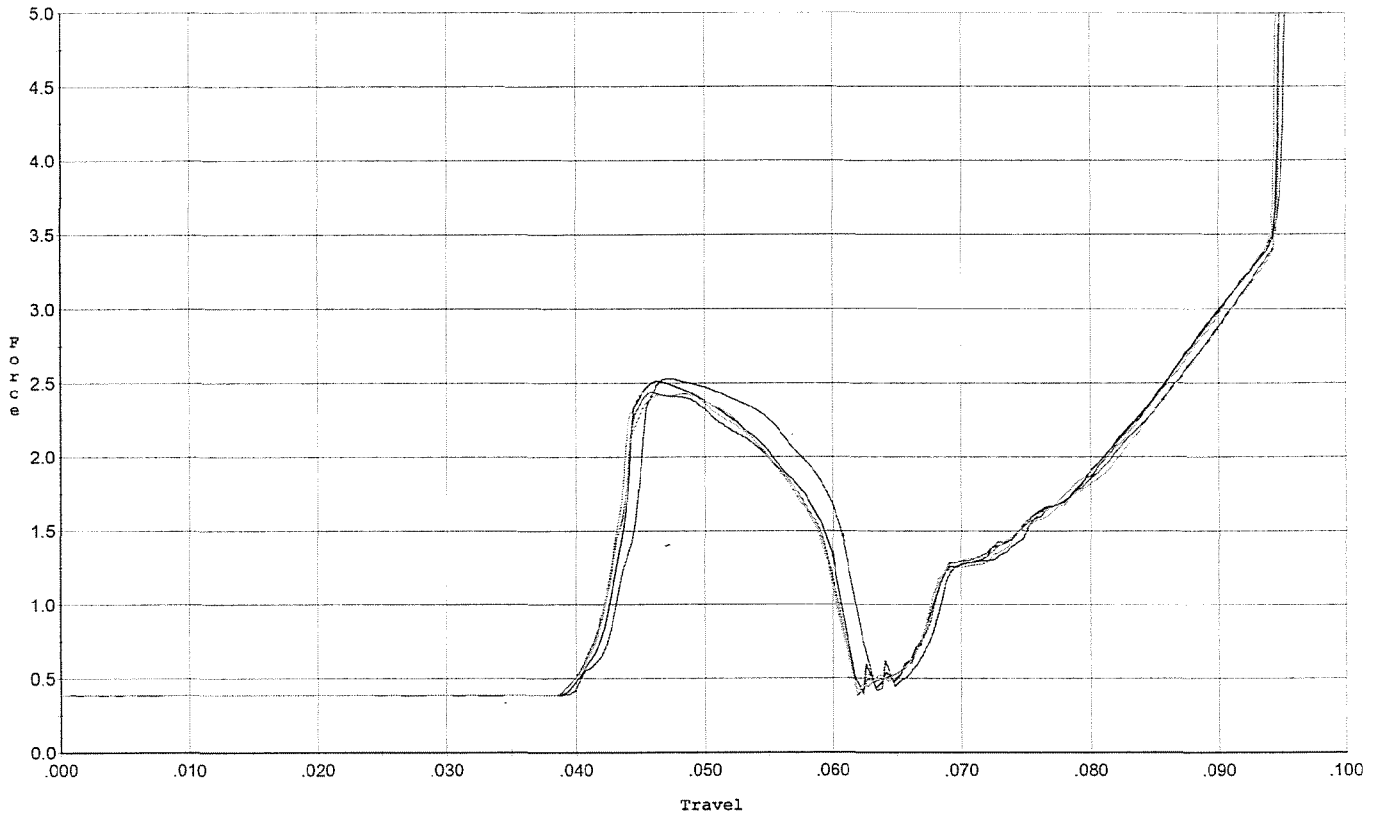
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-27-08	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	10-27-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-27-08	L. J.
	J) ASSEMBLE STOCK		10-22-08	L. J.
	K) ASSEMBLE SWIVEL STUDS		10-27-08	L. J.
	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	10-24-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	Ron
670	FINAL INSPECTION A) HEADSPACE		10-27-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.35</u> <u>2.33</u> <u>2.31</u> <u>2.29</u>	10-27-08	TC
	C) FUNCTION		10-27-08	L. J.
690	PACK		11-6-08	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



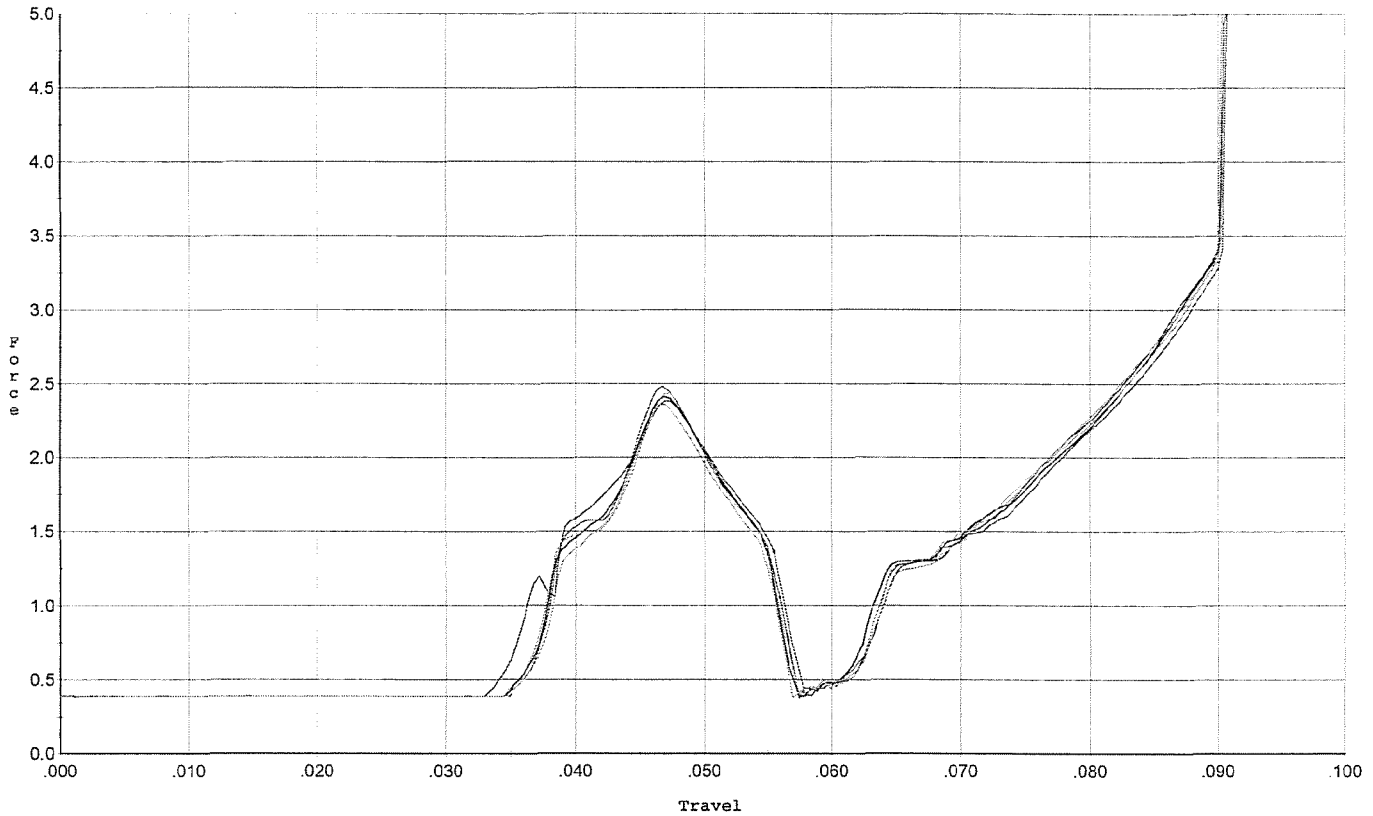
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.531	0.061	0.040	0.041	0.056		Set Trigger
2	2.515	0.060	0.041	0.041	0.053		Set Trigger
3	2.442	0.060	0.040	0.041	0.053		Set Trigger
4	2.429	0.061	0.041	0.041	0.054		Set Trigger
5	2.442	0.059	0.039	0.041	0.053		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



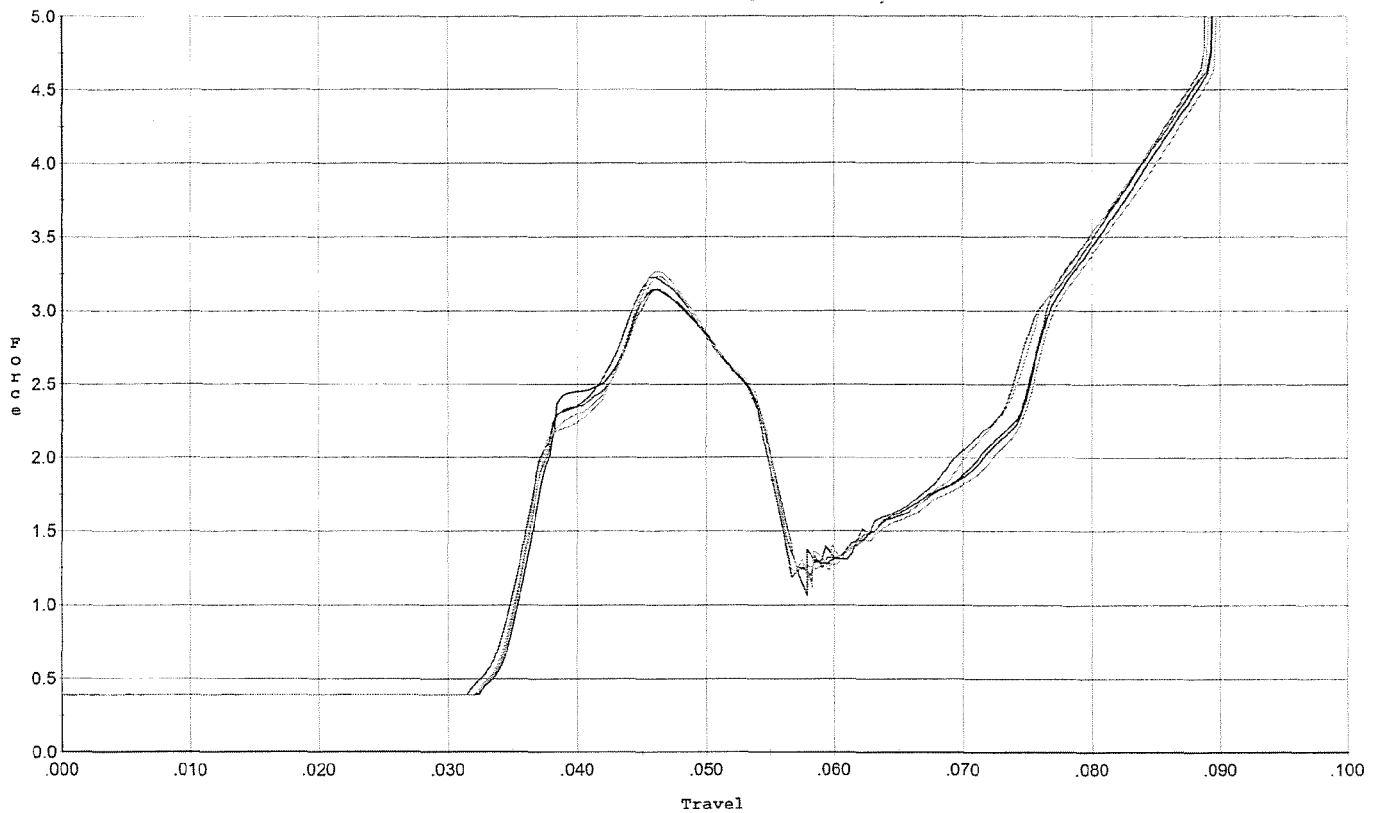
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.382	0.056	0.035	0.040	0.049		Set Trigger
2	2.415	0.055	0.036	0.041	0.047		Set Trigger
3	2.485	0.055	0.035	0.041	0.048		Set Trigger
4	2.436	0.055	0.037	0.041	0.046		Set Trigger
5	2.361	0.055	0.036	0.041	0.046		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



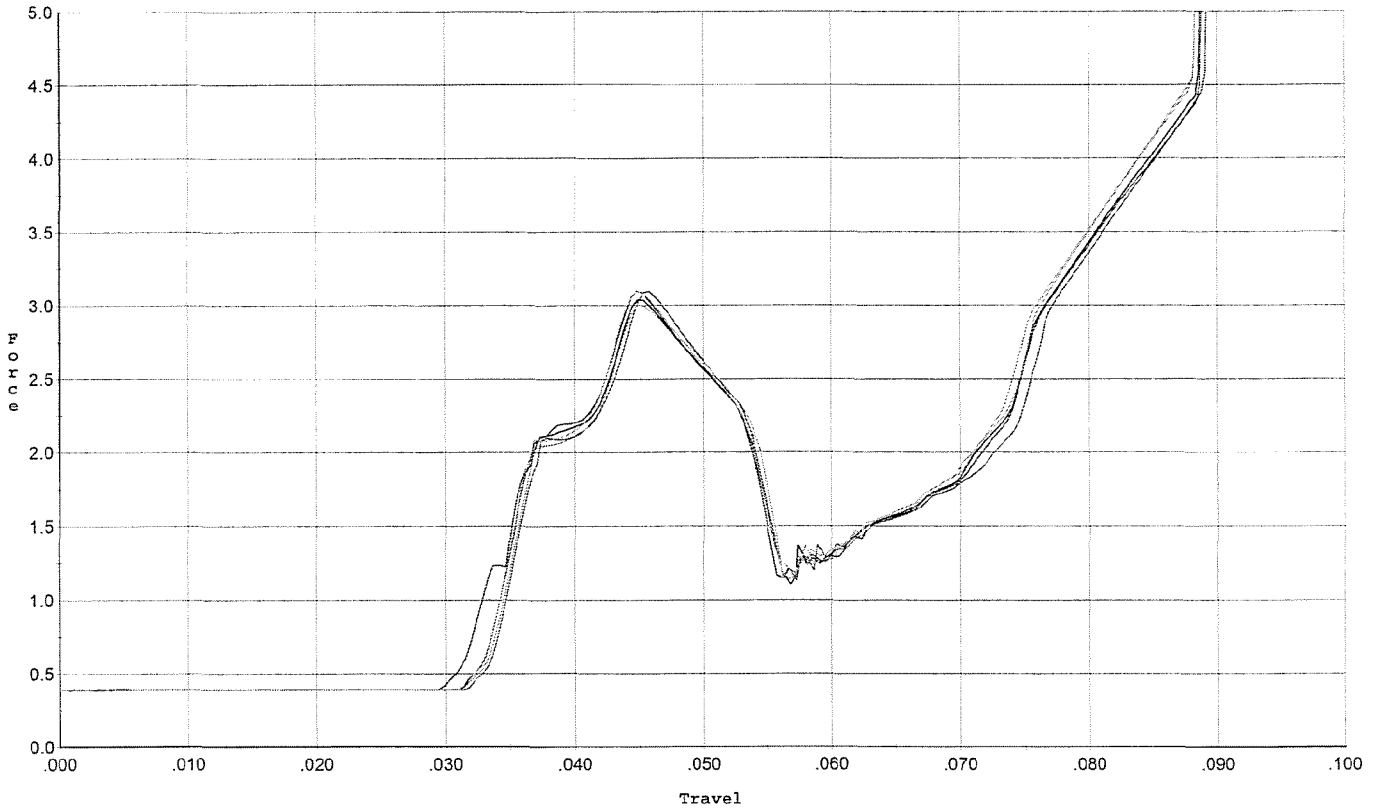
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.223	0.055	0.034	0.038	0.066		Set Trigger
2	3.142	0.055	0.033	0.038	0.064		Set Trigger
3	3.148	0.055	0.034	0.037	0.064		Set Trigger
4	3.270	0.055	0.034	0.038	0.064		Set Trigger
5	3.234	0.055	0.033	0.038	0.064		Set Trigger

A-3.20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



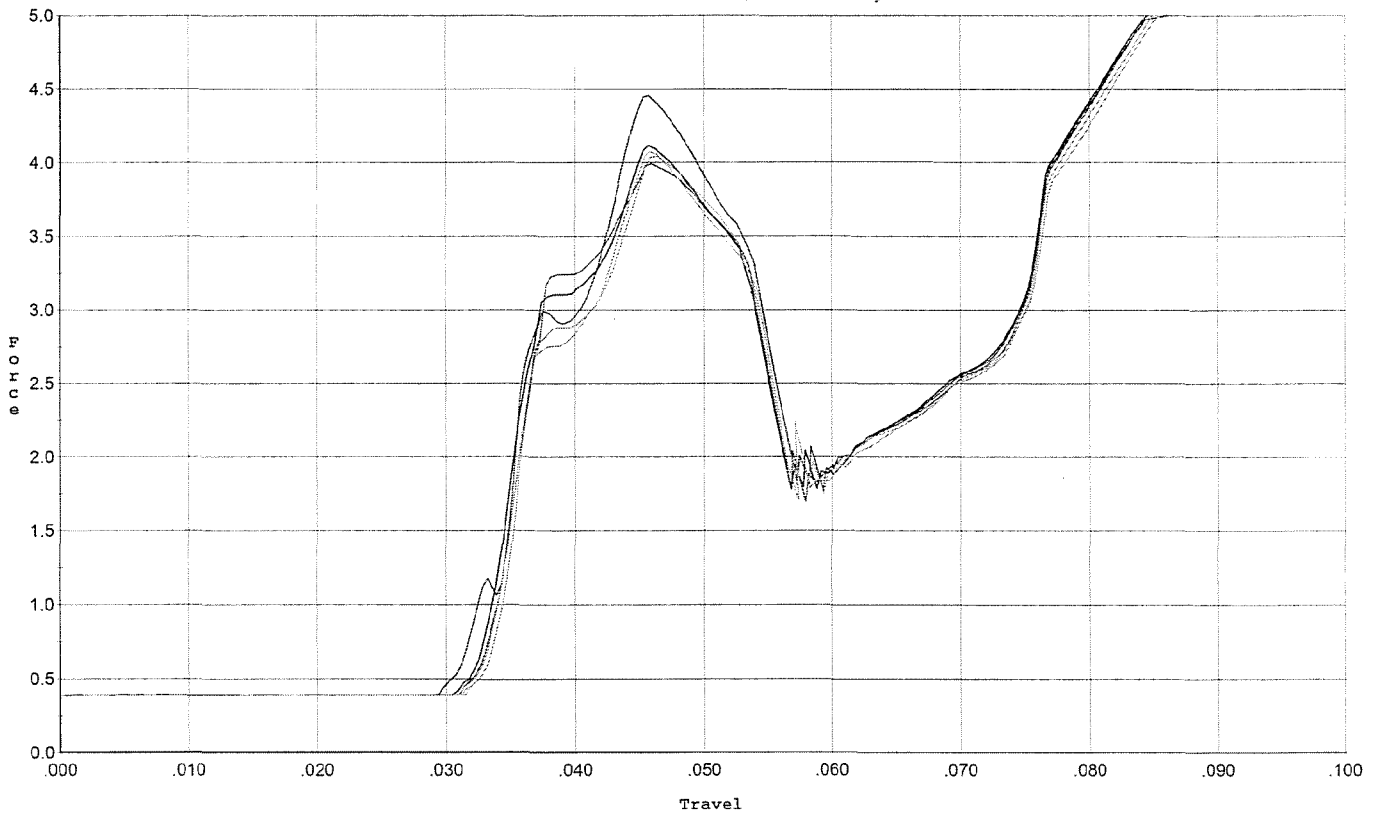
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.100	0.054	0.032	0.038	0.063		Set Trigger
2	3.039	0.054	0.032	0.038	0.061		Set Trigger
3	3.099	0.054	0.032	0.038	0.060		Set Trigger
4	3.097	0.054	0.033	0.038	0.061		Set Trigger
5	3.002	0.054	0.032	0.037	0.061		Set Trigger

A-3.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



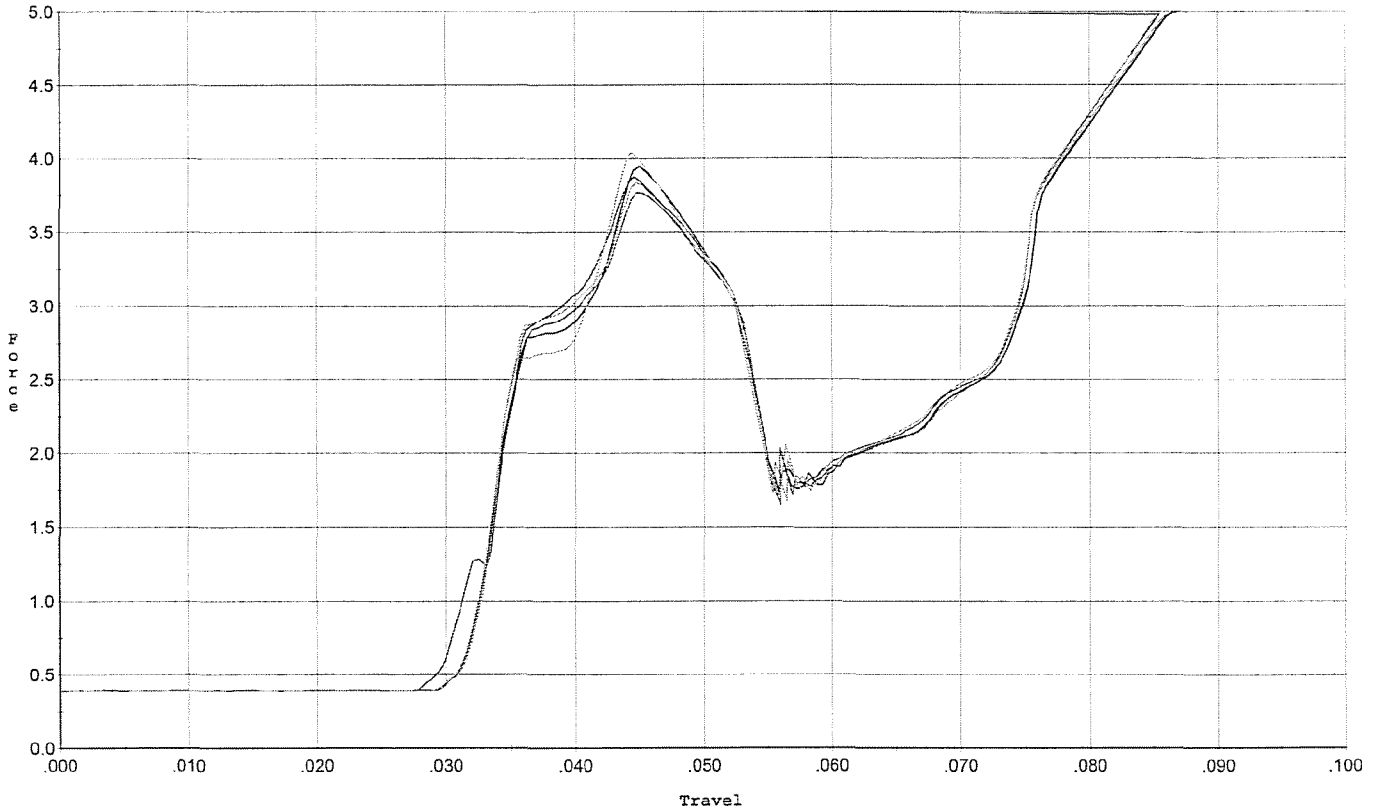
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.457	0.054	0.031	0.036	0.085		Set Trigger
2	4.117	0.054	0.031	0.036	0.081		Set Trigger
3	3.991	0.055	0.033	0.036	0.083		Set Trigger
4	4.073	0.054	0.033	0.036	0.079		Set Trigger
5	4.041	0.055	0.032	0.036	0.080		Set Trigger

A - 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



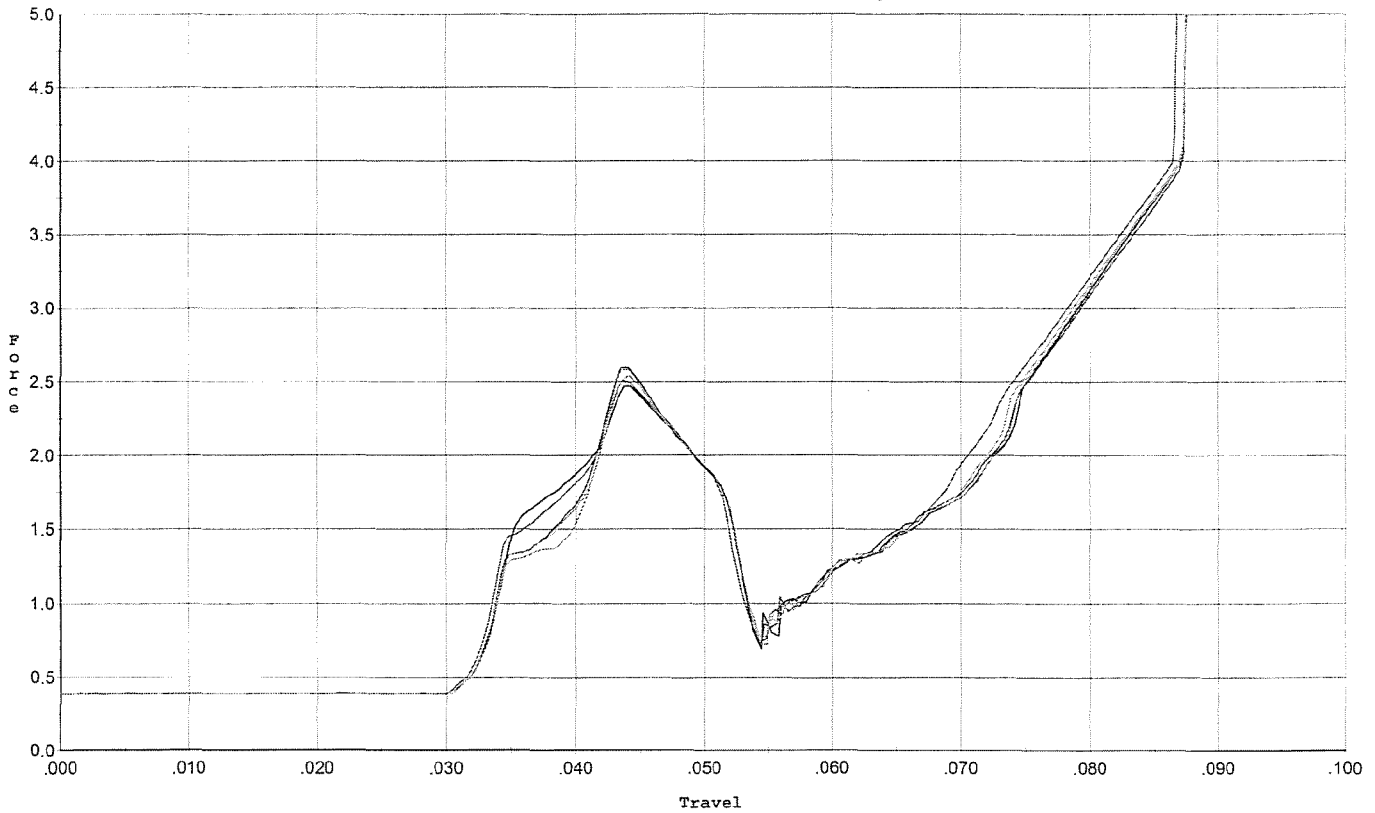
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.875	0.053	0.030	0.036	0.079		Set Trigger
2	3.947	0.053	0.031	0.036	0.077		Set Trigger
3	3.769	0.053	0.031	0.036	0.077		Set Trigger
4	4.039	0.053	0.032	0.036	0.077		Set Trigger
5	3.839	0.052	0.031	0.037	0.076		Set Trigger

A-3-89

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



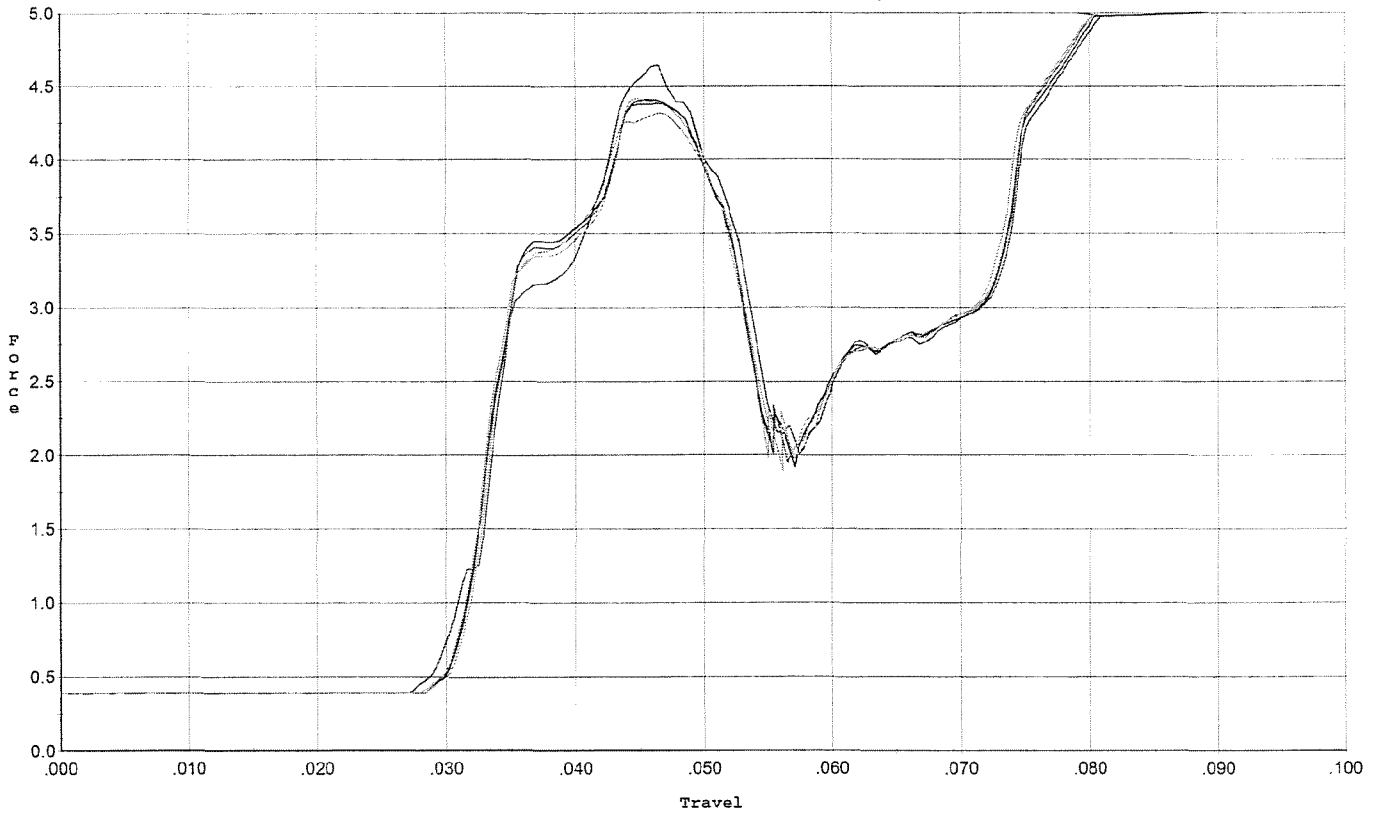
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.597	0.052	0.033	0.040	0.049		Set Trigger
2	2.470	0.052	0.033	0.040	0.049		Set Trigger
3	2.509	0.051	0.032	0.040	0.048		Set Trigger
4	2.541	0.052	0.033	0.040	0.048		Set Trigger
5	2.583	0.052	0.033	0.040	0.048		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lb. for taget & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.643	0.053	0.029	0.035	0.089		Set Trigger
2	4.407	0.052	0.031	0.035	0.087		Set Trigger
3	4.381	0.052	0.030	0.035	0.087		Set Trigger
4	4.414	0.052	0.031	0.035	0.086		Set Trigger
5	4.317	0.053	0.030	0.035	0.088		Set Trigger

A-41.43