

G6778942

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



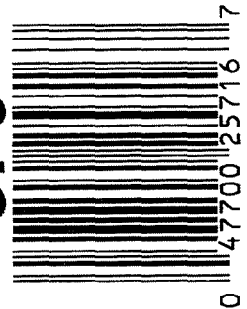
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6778942

UPC



GUN SERIAL #

G 6778942

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	SPD
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	SPD
460	CHECK HEADSPACE		8-20-08	SPD
470	DIS-ASSEMBLE ACTION		8-20-08	SPD
472	SERIALIZE BOLT HANDLE		8-21-08	RT
475	DRILL AND TAP SIGHT HOLES		8-21-08	SP
480	MAGNAFLUX BBL ACTION		8-22-08	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25	~
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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

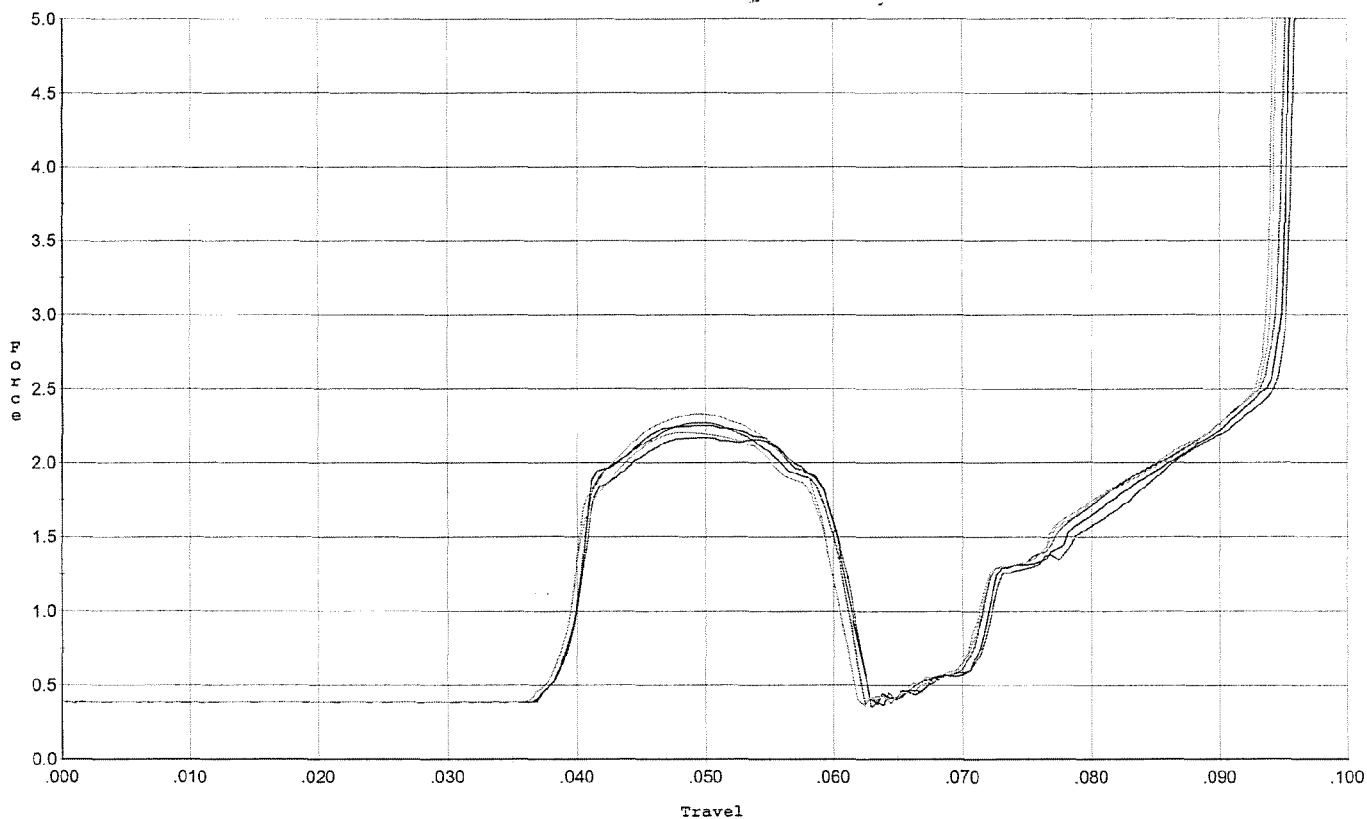
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>4.0</u>	10-29-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>5.0</u> <u>5.0</u>	10-29-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-29-08	LJ
	J) ASSEMBLE STOCK		10-22-08	LJ
	K) ASSEMBLE SWIVEL STUDS		10-24-08	LJ
	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	FSN
670	FINAL INSPECTION A) HEADSPACE		10-29-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.71</u> <u>2.77</u> <u>2.63</u> <u>2.67</u>	10-28-08	TC
	C) FUNCTION		10-29-08	LJ
690	PACK		11/3/08	FM

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.



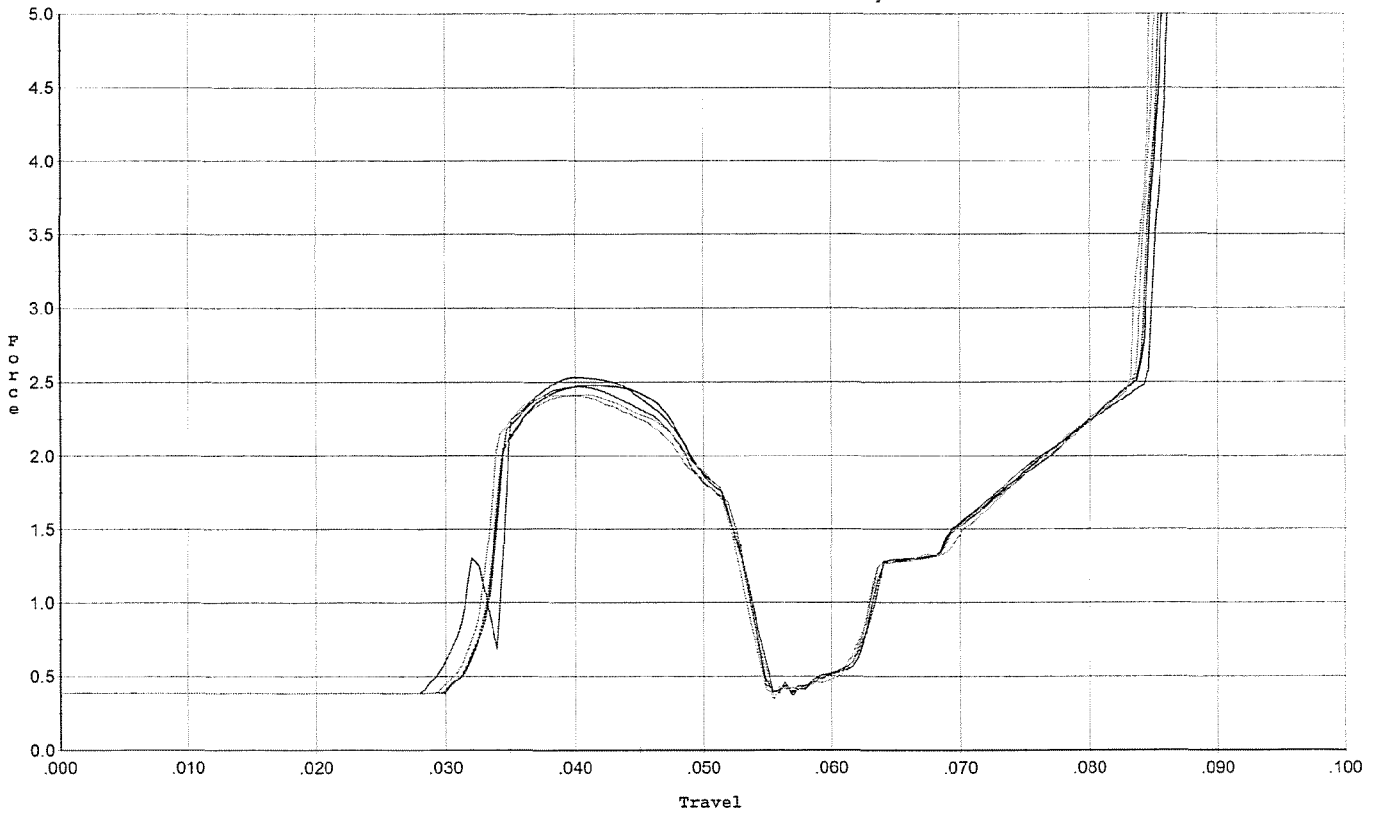
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.166	0.061	0.037	0.041	0.058		Set Trigger
2	2.253	0.060	0.039	0.040	0.058		Set Trigger
3	2.270	0.060	0.039	0.040	0.057		Set Trigger
4	2.204	0.060	0.038	0.040	0.056		Set Trigger
5	2.331	0.059	0.038	0.040	0.057		Set Trigger

A-2.24

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.



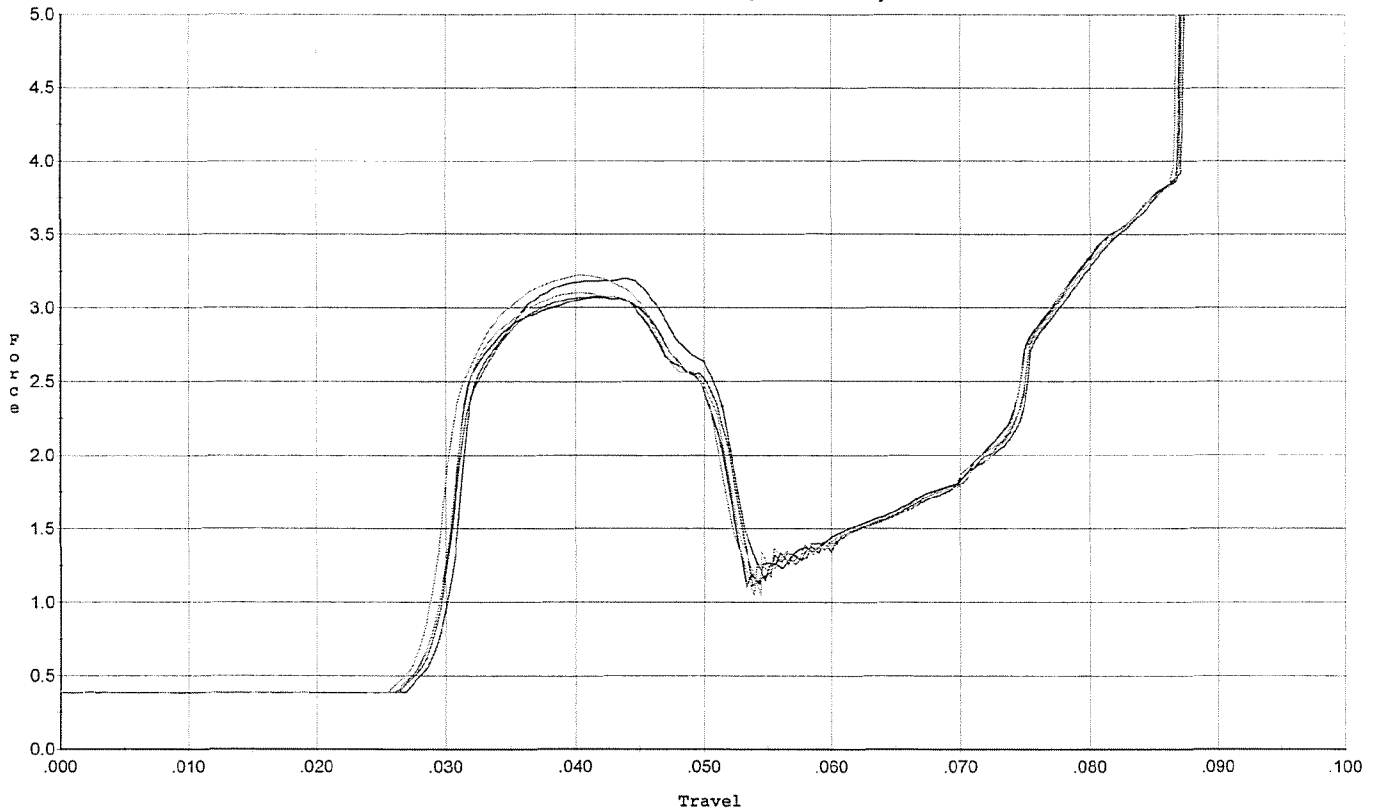
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.532	0.053	0.030	0.037	0.057		Set Trigger
2	2.477	0.053	0.032	0.037	0.056		Set Trigger
3	2.469	0.053	0.032	0.036	0.056		Set Trigger
4	2.416	0.053	0.032	0.036	0.055		Set Trigger
5	2.411	0.052	0.031	0.036	0.055		Set Trigger

A-2.46

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.



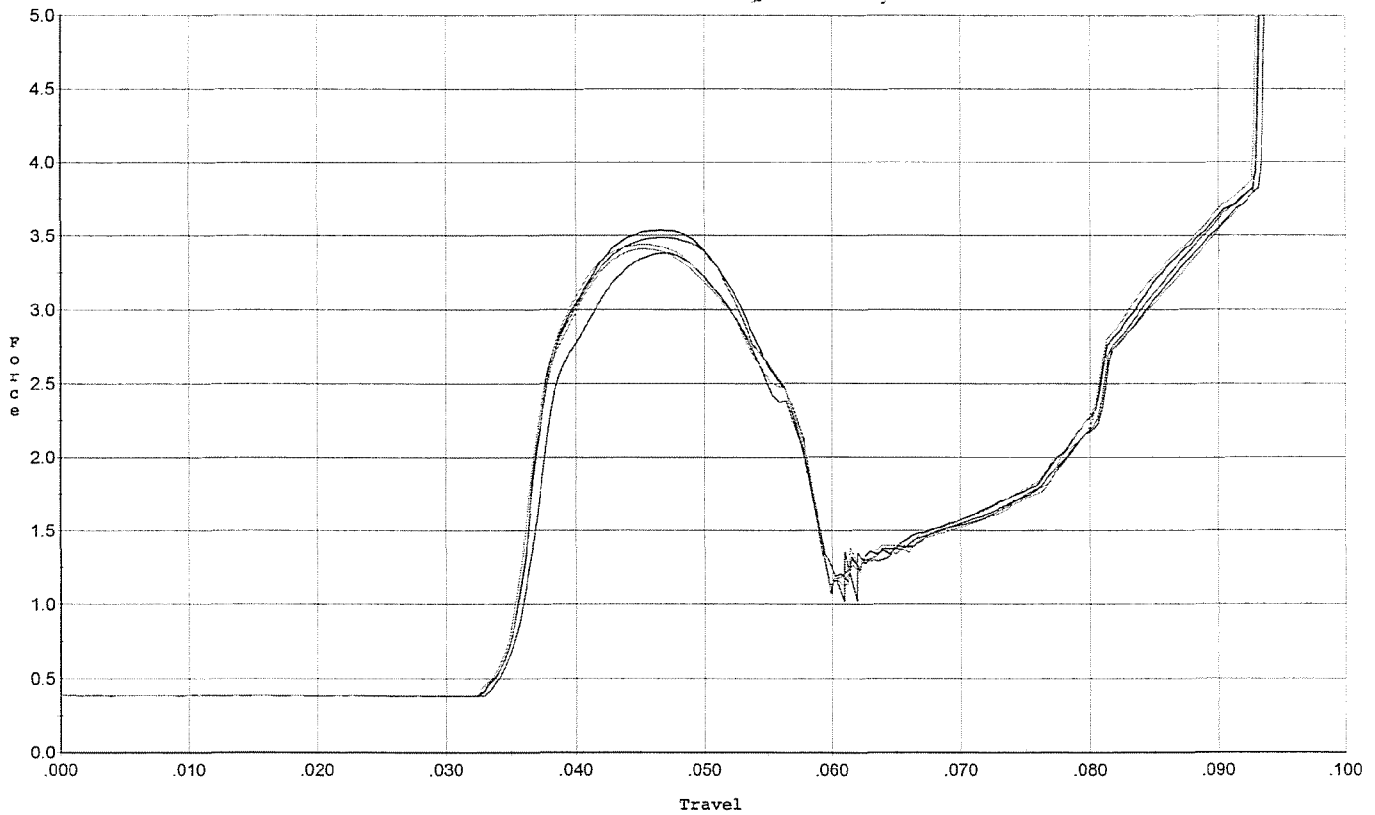
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.197	0.051	0.029	0.037	0.072		Set Trigger
2	3.069	0.051	0.028	0.037	0.071		Set Trigger
3	3.079	0.052	0.029	0.037	0.072		Set Trigger
4	3.102	0.051	0.027	0.037	0.071		Set Trigger
5	3.220	0.050	0.028	0.038	0.072		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

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

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



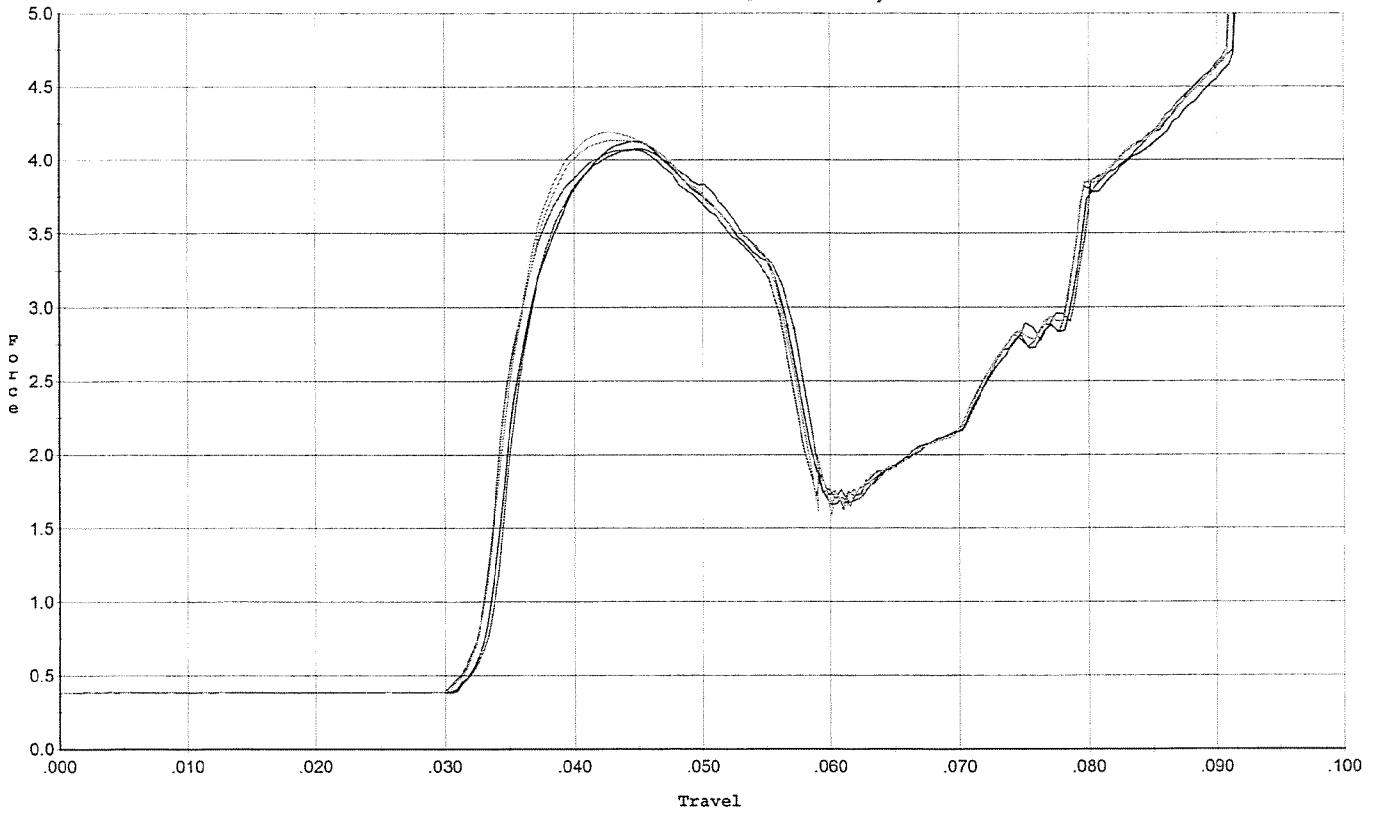
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.382	0.058	0.034	0.039	0.076		Set Trigger
2	3.539	0.058	0.033	0.038	0.081		Set Trigger
3	3.486	0.058	0.035	0.038	0.080		Set Trigger
4	3.439	0.058	0.034	0.038	0.080		Set Trigger
5	3.412	0.058	0.033	0.038	0.079		Set Trigger

A-3.45

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 lbs.



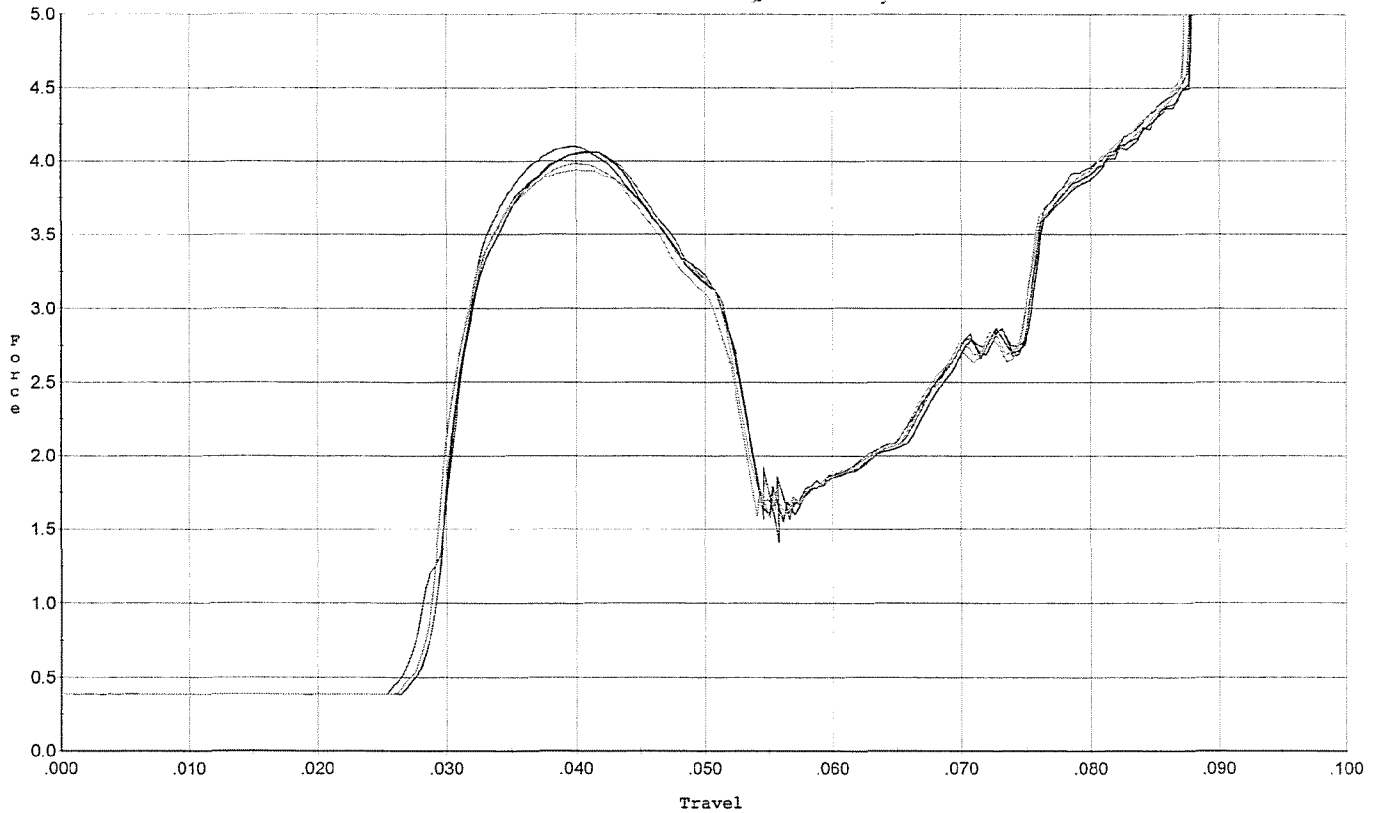
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.072	0.057	0.033	0.036	0.095		Set Trigger
2	4.128	0.057	0.032	0.036	0.094		Set Trigger
3	4.069	0.056	0.032	0.036	0.094		Set Trigger
4	4.134	0.057	0.032	0.035	0.097		Set Trigger
5	4.193	0.057	0.032	0.035	0.098		Set Trigger

A-4.11

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 lbs.



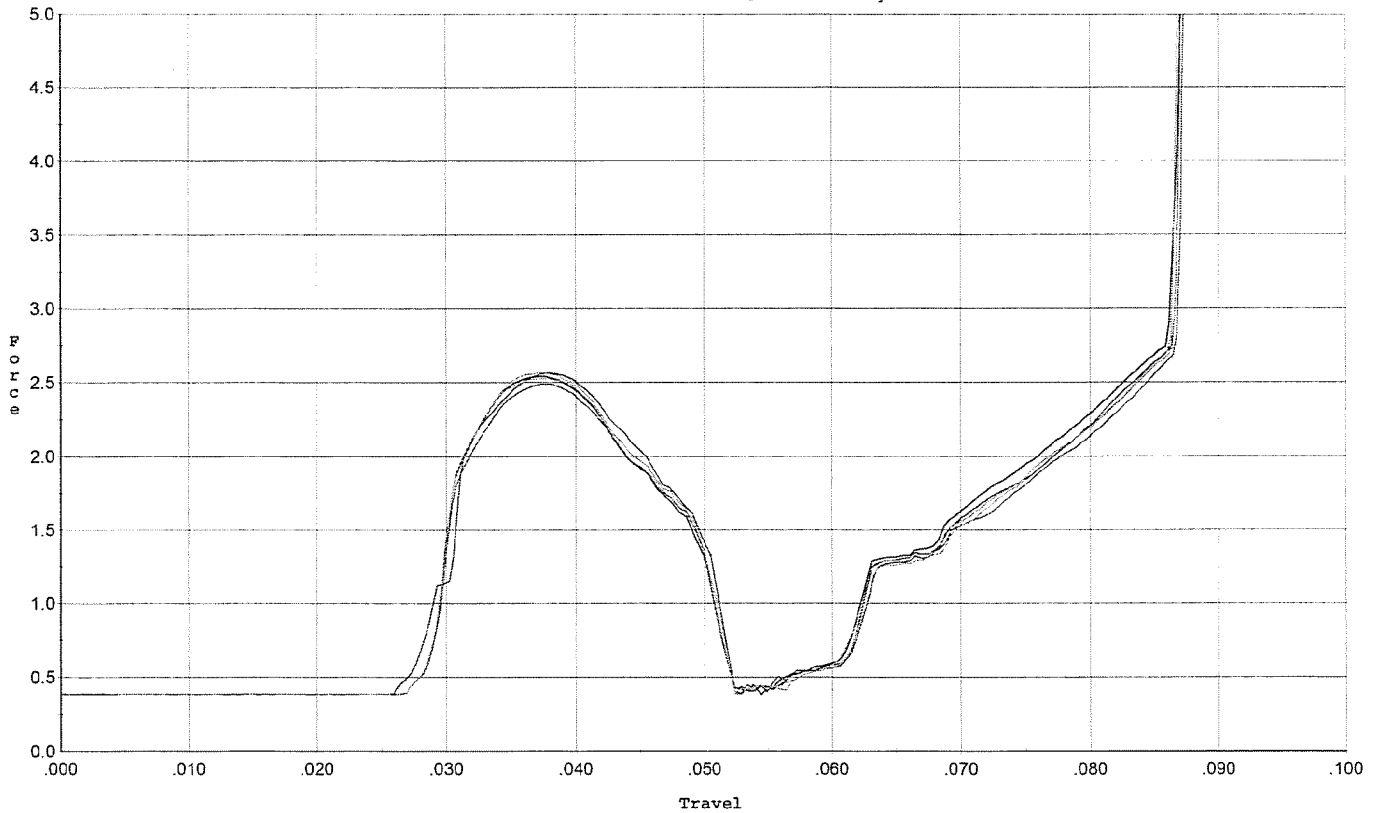
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.100	0.053	0.027	0.035	0.093		Set Trigger
2	4.062	0.052	0.028	0.035	0.091		Set Trigger
3	4.060	0.052	0.028	0.035	0.092		Set Trigger
4	3.937	0.052	0.028	0.035	0.090		Set Trigger
5	3.980	0.052	0.028	0.035	0.090		Set Trigger

A-4.02

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



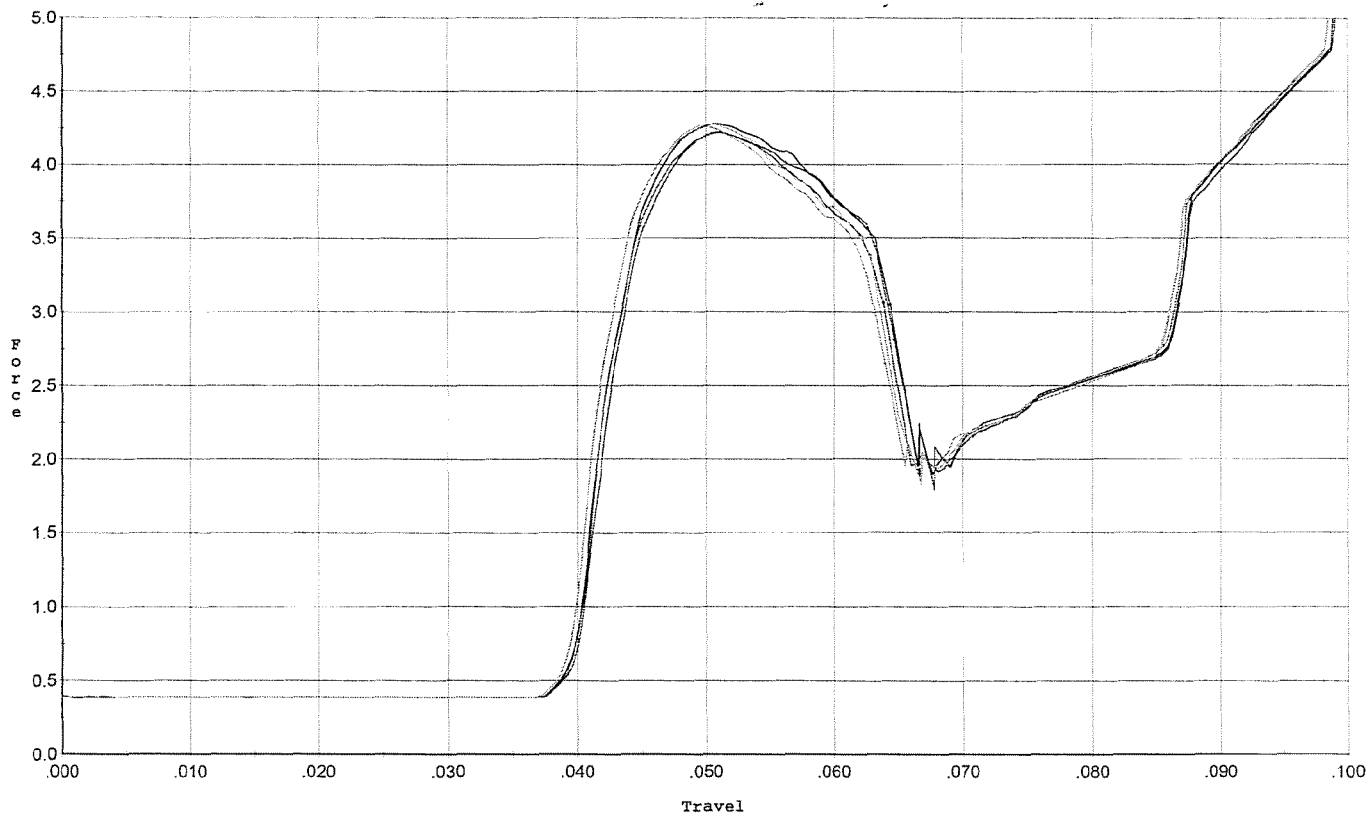
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.050	0.026	0.040	0.056		Set Trigger
2	2.542	0.050	0.029	0.041	0.055		Set Trigger
3	2.488	0.050	0.027	0.042	0.054		Set Trigger
4	2.566	0.051	0.027	0.040	0.056		Set Trigger
5	2.526	0.050	0.027	0.041	0.055		Set Trigger

A-2.53

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 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.223	0.065	0.040	0.039	0.104		Set Trigger
2	4.277	0.064	0.039	0.039	0.105		Set Trigger
3	4.219	0.064	0.040	0.039	0.102		Set Trigger
4	4.277	0.063	0.039	0.039	0.102		Set Trigger
5	4.257	0.064	0.039	0.039	0.103		Set Trigger

A-4.25