

56778946

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



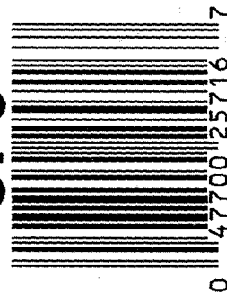
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6778946

UPC



GUN SERIAL #

G6778946

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	SP
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	SP
460	CHECK HEADSPACE		8-20-08	SP
470	DIS-ASSEMBLE ACTION		8-20-08	SP
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	BN
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/23/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-28-	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-16-08	BN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

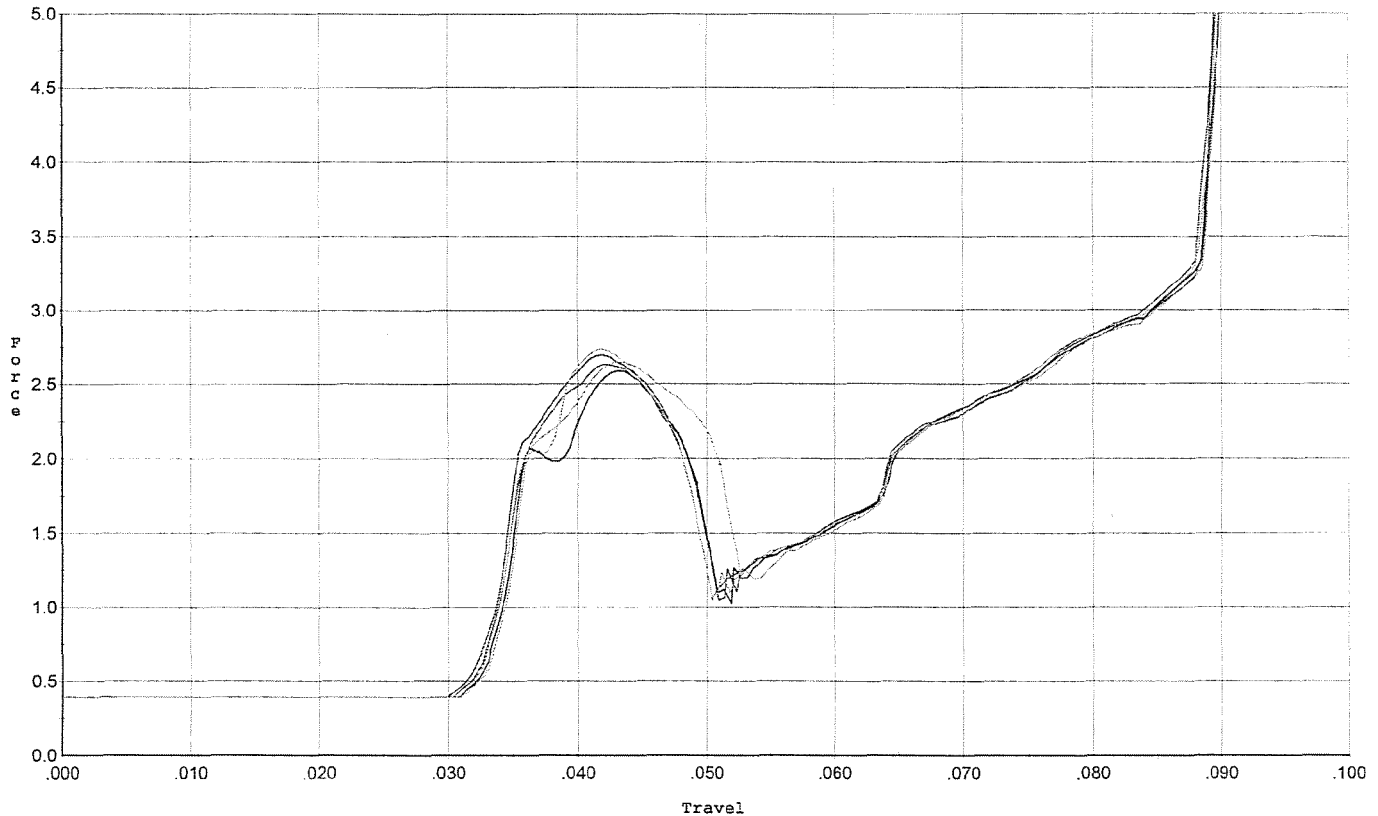
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>5.0</u>	10-27-08	RJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	10-27-08	RJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	10-27-08	RJ
	J) ASSEMBLE STOCK		10-16-08	RJ
	K) ASSEMBLE SWIVEL STUDS		10-27-08	RJ
	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	PASS FAIL PASS FAIL	10-23-08	RJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-27-08	RJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>243</u> <u>246</u> <u>240</u> <u>242</u> <u>247</u>	10-27-08	RJ
	C) FUNCTION		10-27-08	RJ
690	PACK		11/7/08	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



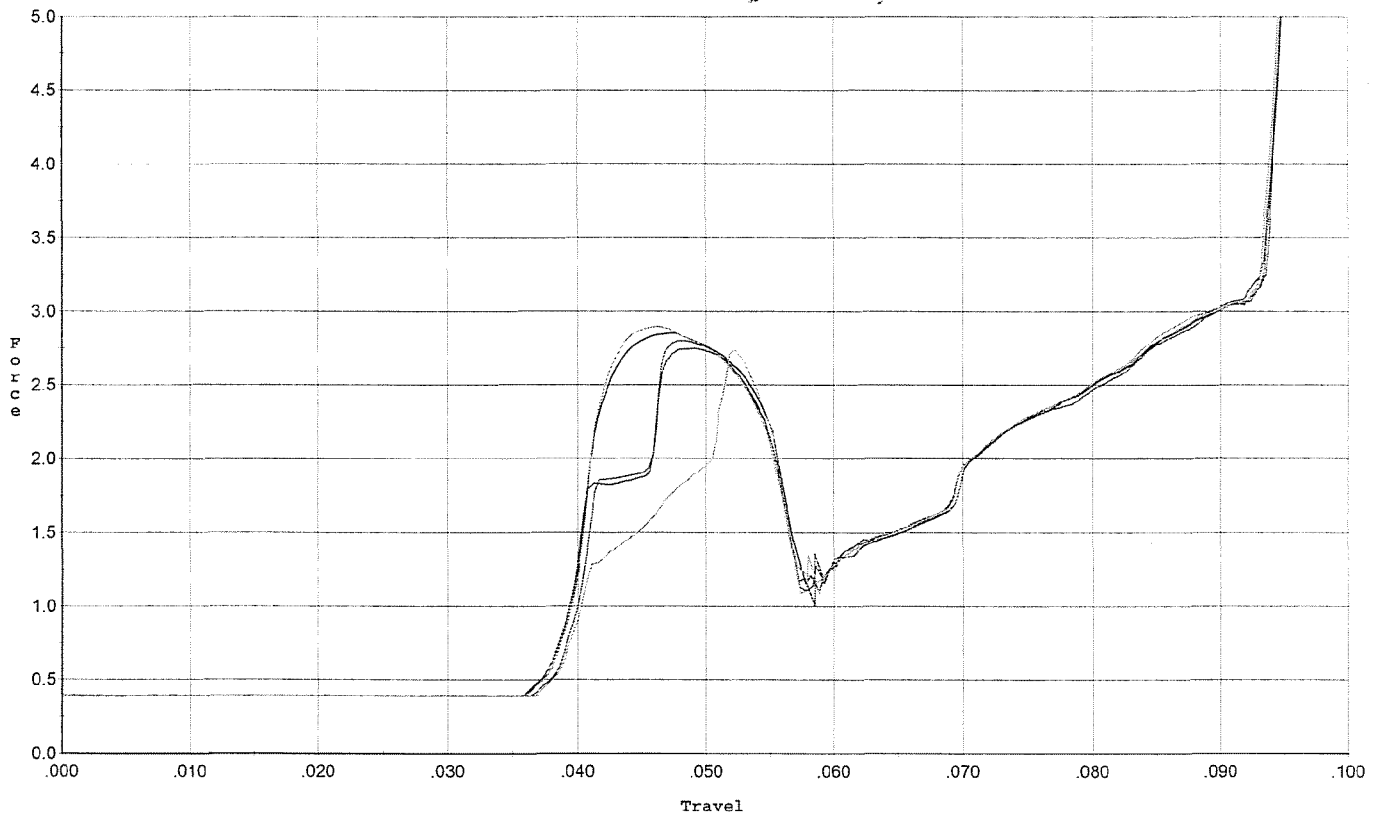
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.697	0.049	0.032	0.043	0.050		Set Trigger
2	2.591	0.049	0.033	0.044	0.047		Set Trigger
3	2.634	0.049	0.032	0.044	0.048		Set Trigger
4	2.739	0.049	0.033	0.044	0.047		Set Trigger
5	2.649	0.051	0.033	0.042	0.054		Set Trigger

A-2.66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 20 cycles +/- .50 lbs.



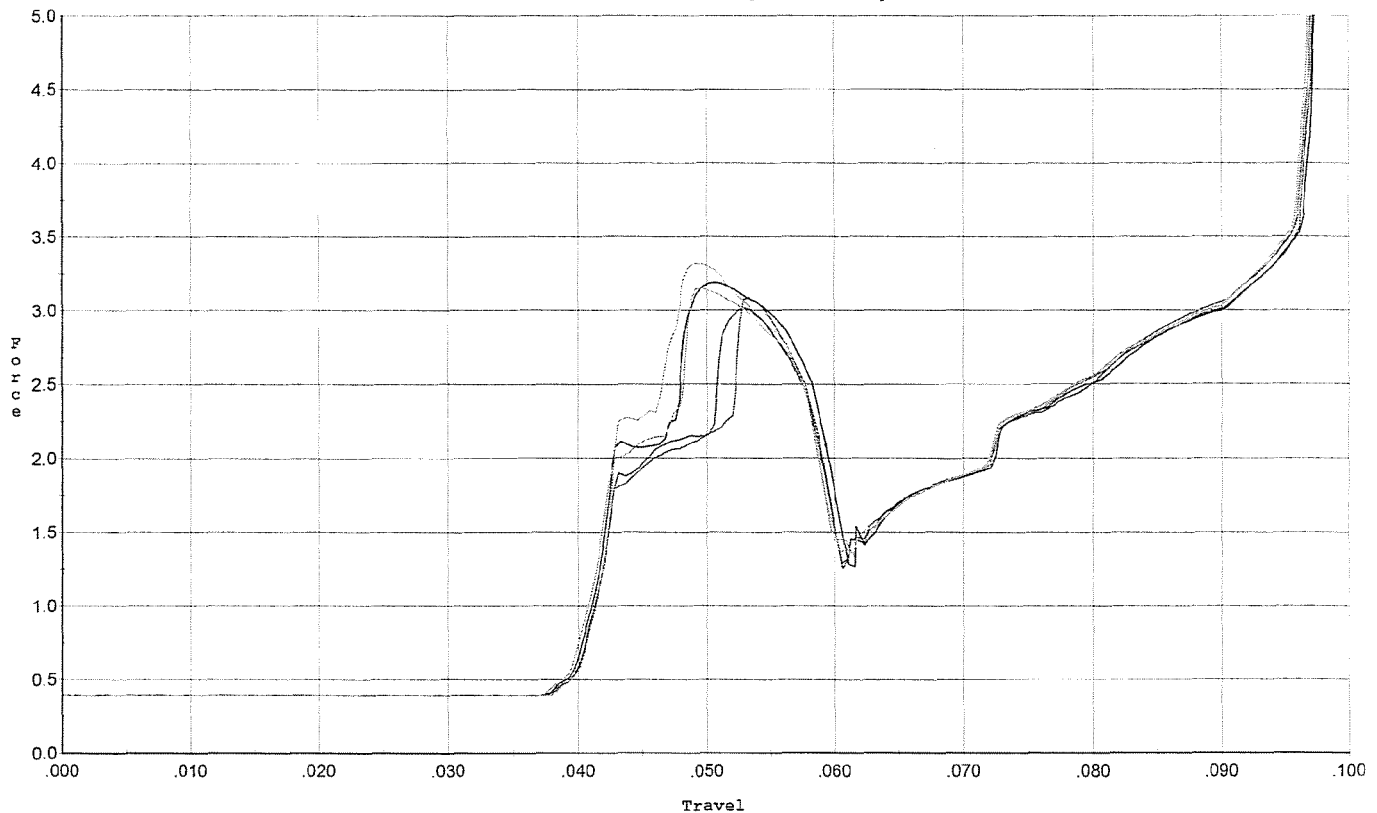
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.747	0.055	0.038	0.043	0.053		Set Trigger
2	2.853	0.055	0.038	0.042	0.057		Set Trigger
3	2.799	0.055	0.039	0.043	0.052		Set Trigger
4	2.896	0.056	0.038	0.042	0.057		Set Trigger
5	2.736	0.055	0.039	0.043	0.046		Set Trigger

A-280

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



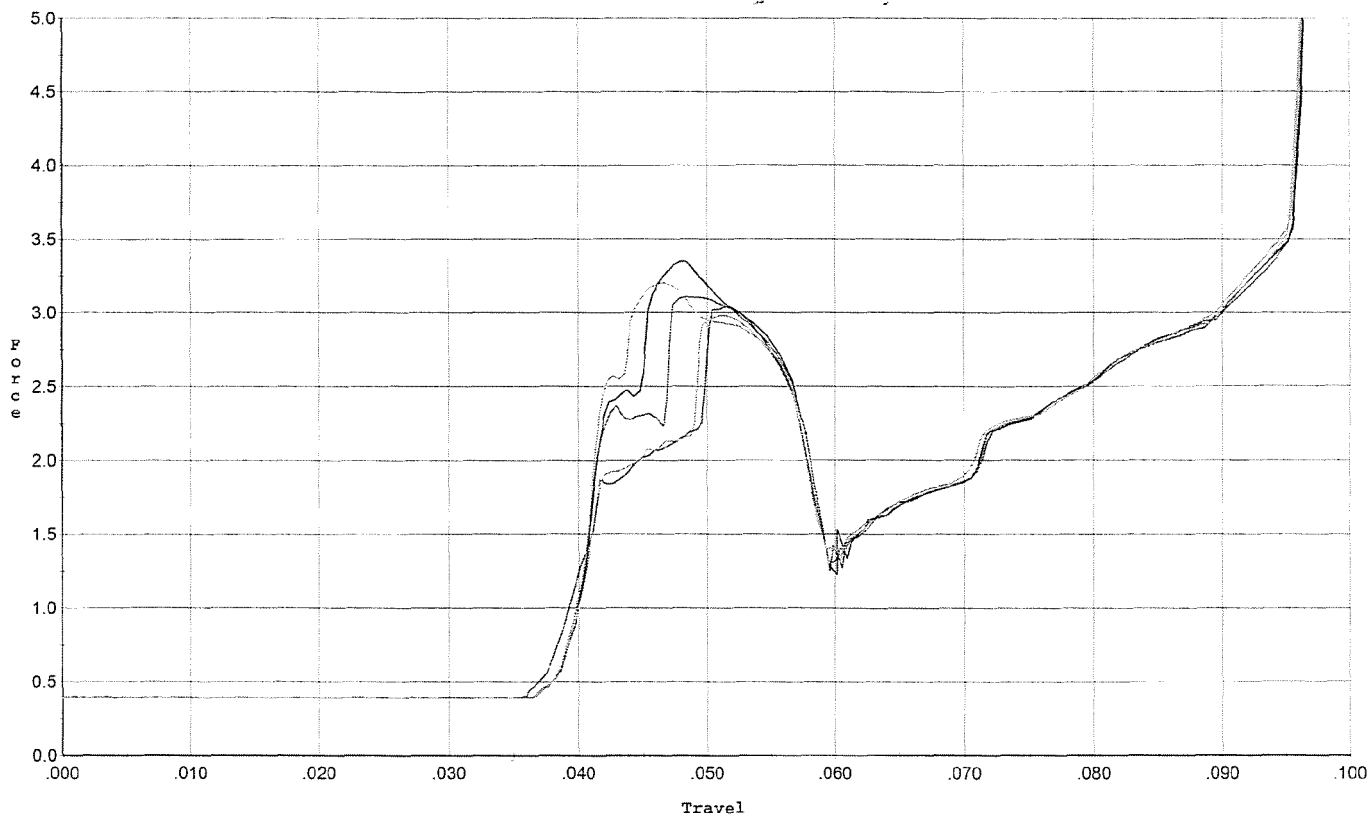
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.015	0.059	0.040	0.043	0.058		Set Trigger
2	3.188	0.059	0.040	0.042	0.064		Set Trigger
3	3.086	0.059	0.040	0.042	0.057		Set Trigger
4	3.317	0.058	0.040	0.042	0.062		Set Trigger
5	3.150	0.058	0.040	0.042	0.061		Set Trigger

A - 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



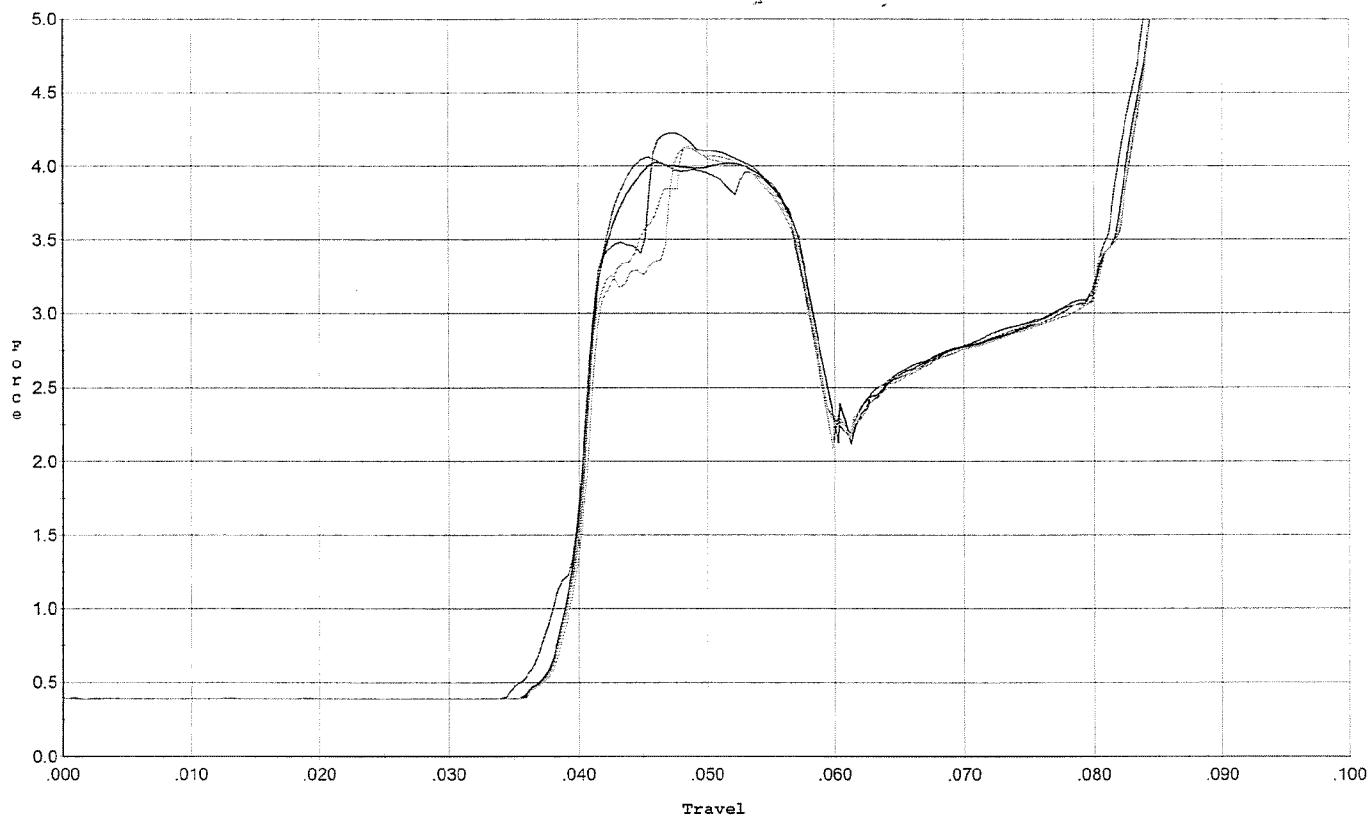
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.039	0.058	0.038	0.042	0.059		Set Trigger
2	3.350	0.058	0.039	0.042	0.065		Set Trigger
3	3.109	0.058	0.039	0.042	0.063		Set Trigger
4	3.204	0.057	0.039	0.042	0.064		Set Trigger
5	2.980	0.057	0.039	0.043	0.057		Set Trigger

A. 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



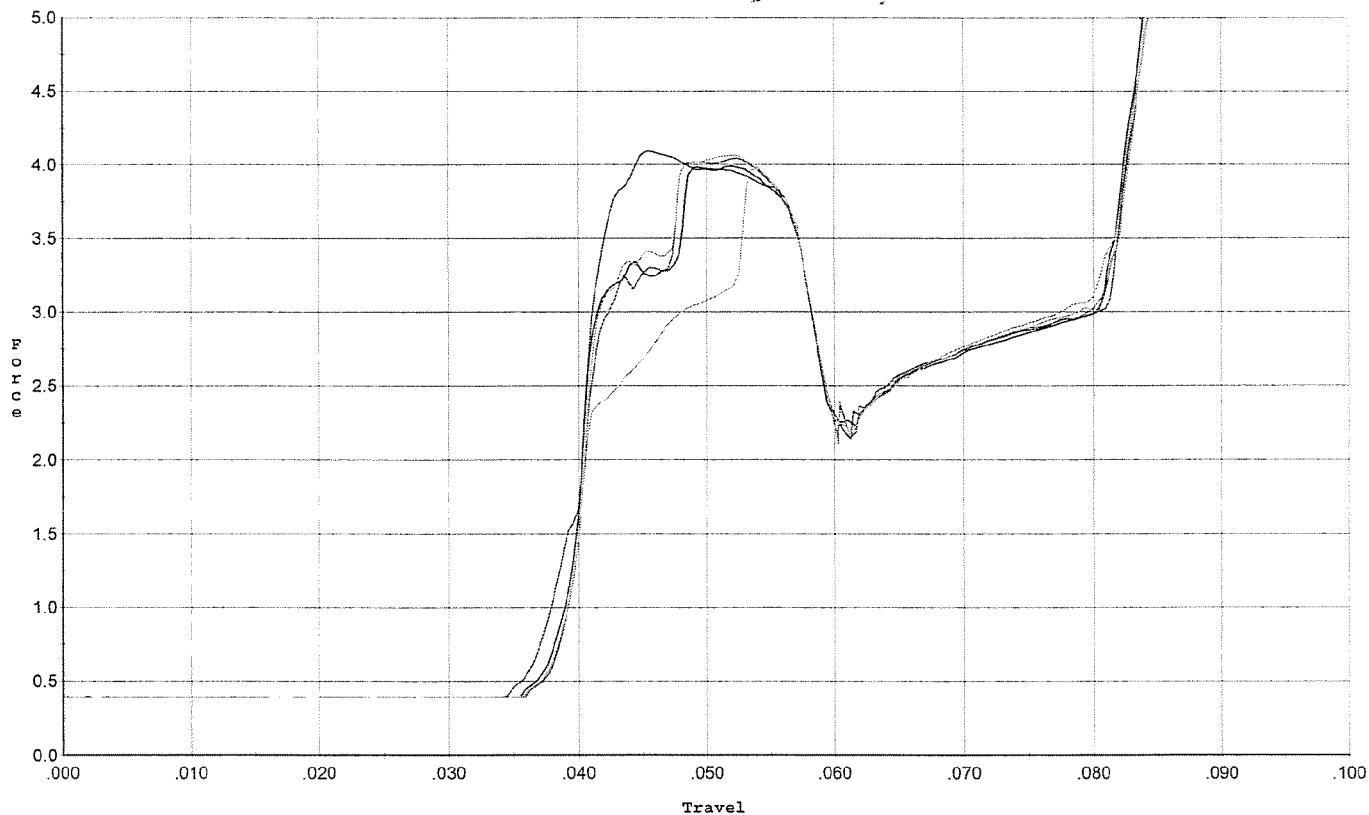
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.225	0.058	0.037	0.032	0.086		Set Trigger
2	4.024	0.057	0.038	0.032	0.084		Set Trigger
3	4.060	0.057	0.038	0.032	0.084		Set Trigger
4	4.138	0.057	0.038	0.032	0.082		Set Trigger
5	4.120	0.058	0.038	0.032	0.082		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



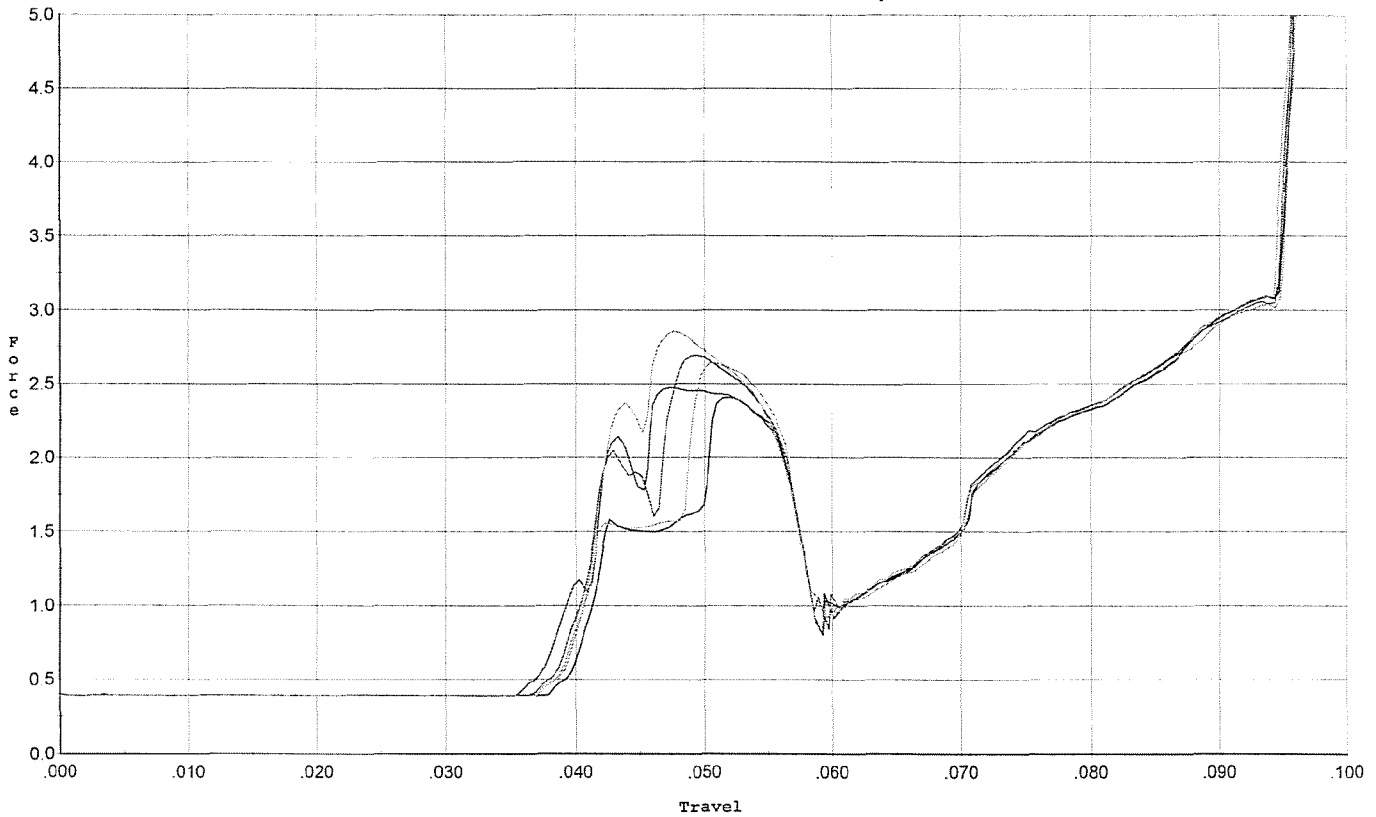
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.057	0.037	0.031	0.086		Set Trigger
2	3.990	0.057	0.038	0.031	0.081		Set Trigger
3	4.043	0.057	0.038	0.032	0.080		Set Trigger
4	4.061	0.057	0.038	0.032	0.081		Set Trigger
5	3.968	0.057	0.038	0.032	0.073		Set Trigger

A- 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



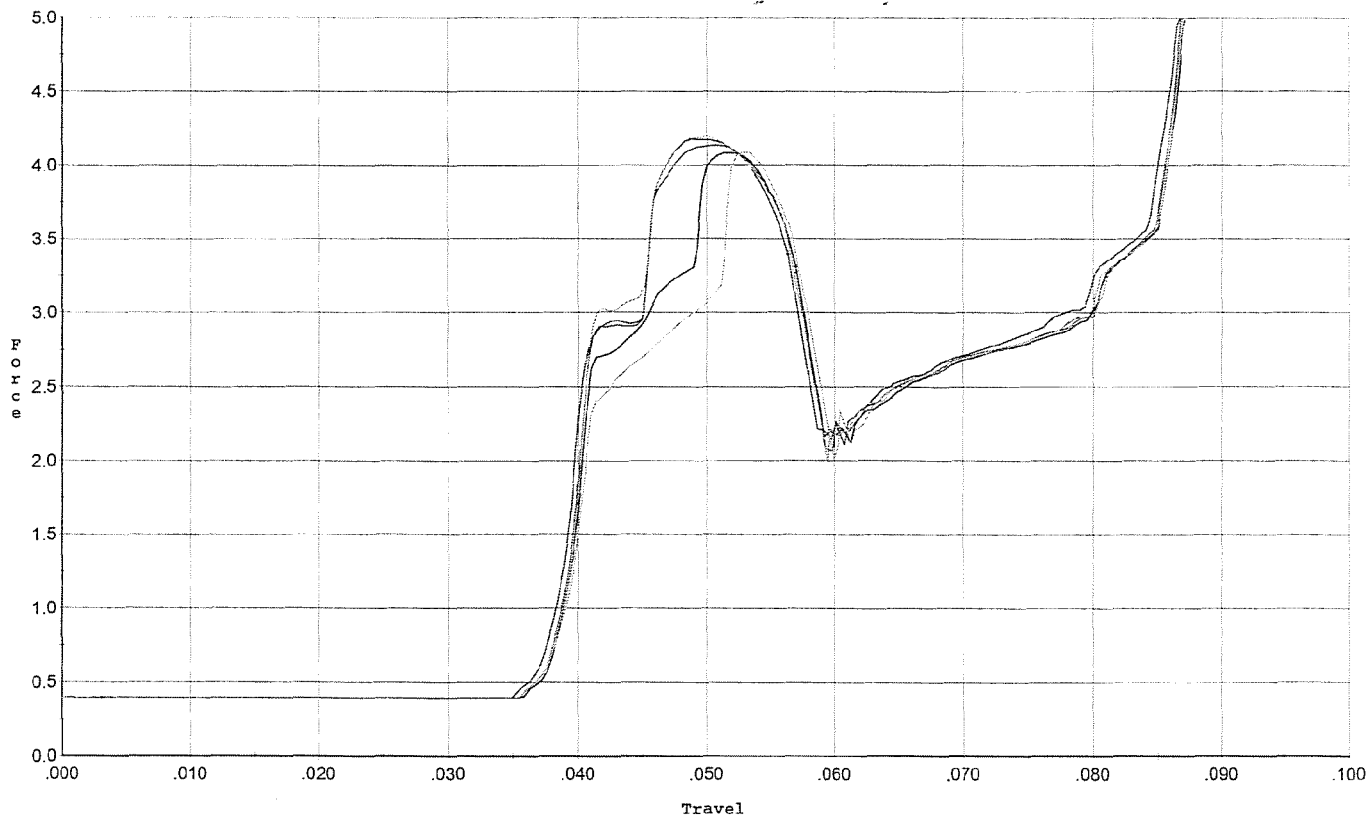
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.472	0.057	0.038	0.043	0.053		Set Trigger
2	2.412	0.057	0.040	0.044	0.046		Set Trigger
3	2.692	0.057	0.039	0.043	0.053		Set Trigger
4	2.640	0.057	0.039	0.044	0.049		Set Trigger
5	2.855	0.056	0.039	0.043	0.055		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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	4.177	0.056	0.037	0.035	0.080		Set Trigger
2	4.086	0.057	0.038	0.035	0.077		Set Trigger
3	4.139	0.057	0.038	0.035	0.081		Set Trigger
4	4.088	0.058	0.038	0.035	0.075		Set Trigger
5	4.195	0.057	0.038	0.035	0.082		Set Trigger

A-4.13