

66794526

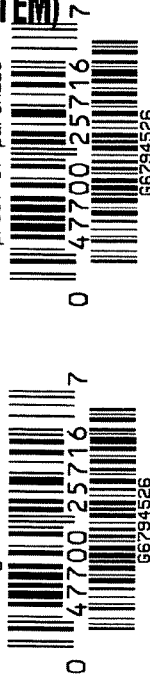
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

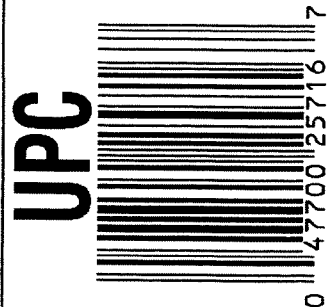
proof of purchase

owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794526



GUN SERIAL #

G 6794526

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE		10-28-08	SP
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	MAGNA - FLUX 2008 OPERATOR	10/29/08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		1030	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11/3/08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/3/08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/3/08	SP
	D) OIL FIRING PIN ASSEMBLY		11-5-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

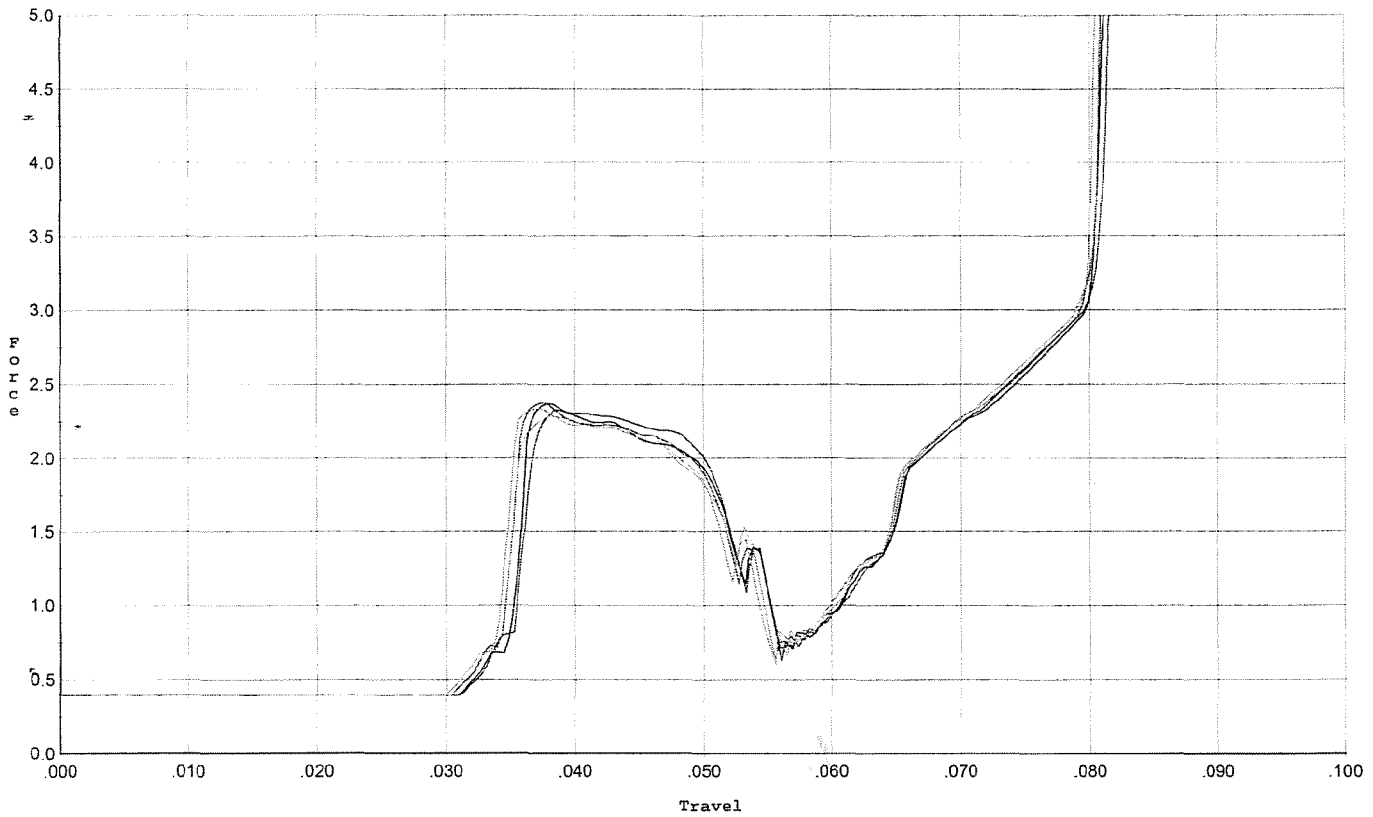
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	11-12-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.5</u> <u>5.5</u> <u>5.0</u>	11-12-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-12-08	LJ
	J) ASSEMBLE STOCK		11-5-08	L.P.N.
	K) ASSEMBLE SWIVEL STUDS		11-12-08	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	11-6-08	LJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-6-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-12-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.57</u> <u>2.60</u> <u>2.53</u> <u>2.59</u>	11-8-08	TC
	C) FUNCTION		11-12-08	LJ
690	PACK		11/14/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



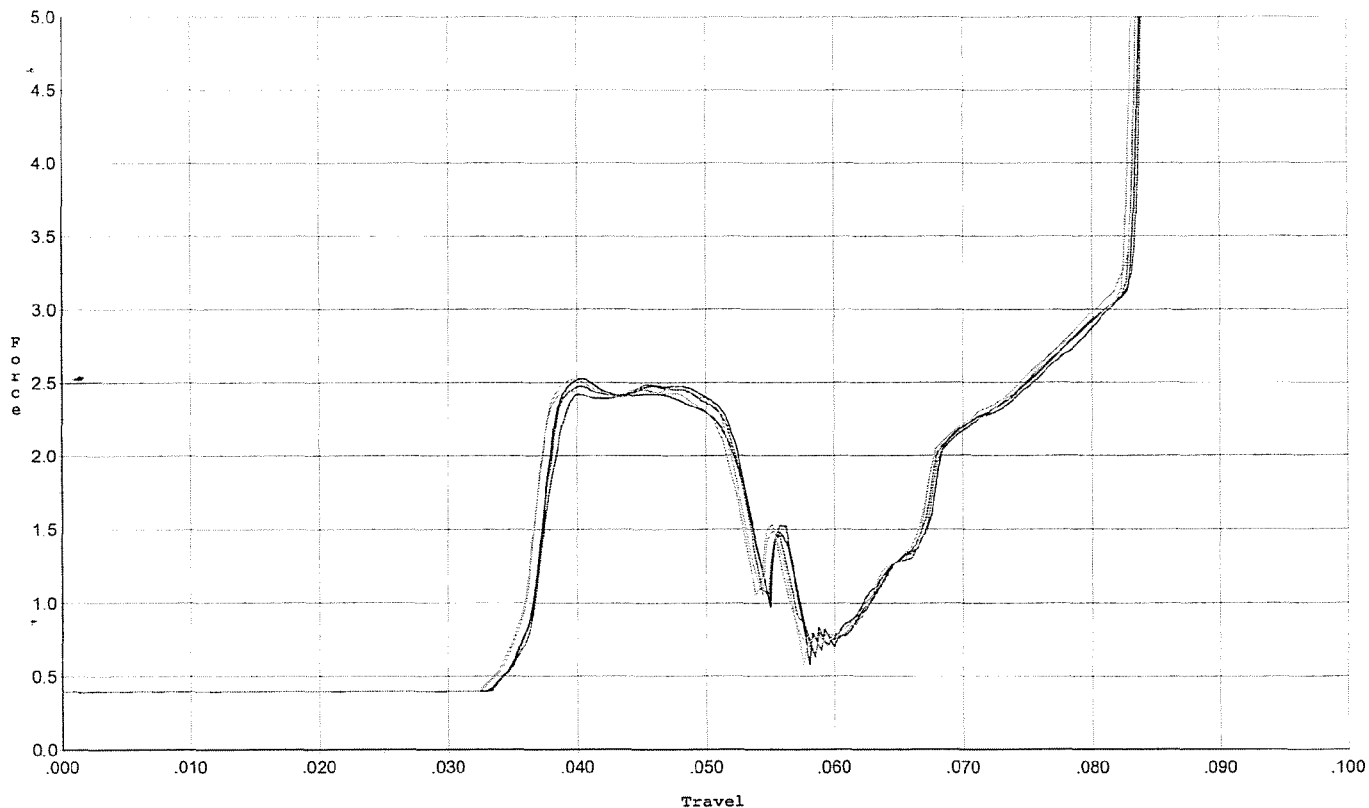
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.328	0.054	0.033	0.033	0.053		Set Trigger
2	2.372	0.054	0.033	0.033	0.053		Set Trigger
3	2.374	0.054	0.033	0.033	0.053		Set Trigger
4	2.286	0.054	0.033	0.033	0.053		Set Trigger
5	2.333	0.053	0.032	0.033	0.053		Set Trigger

A-2.33

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



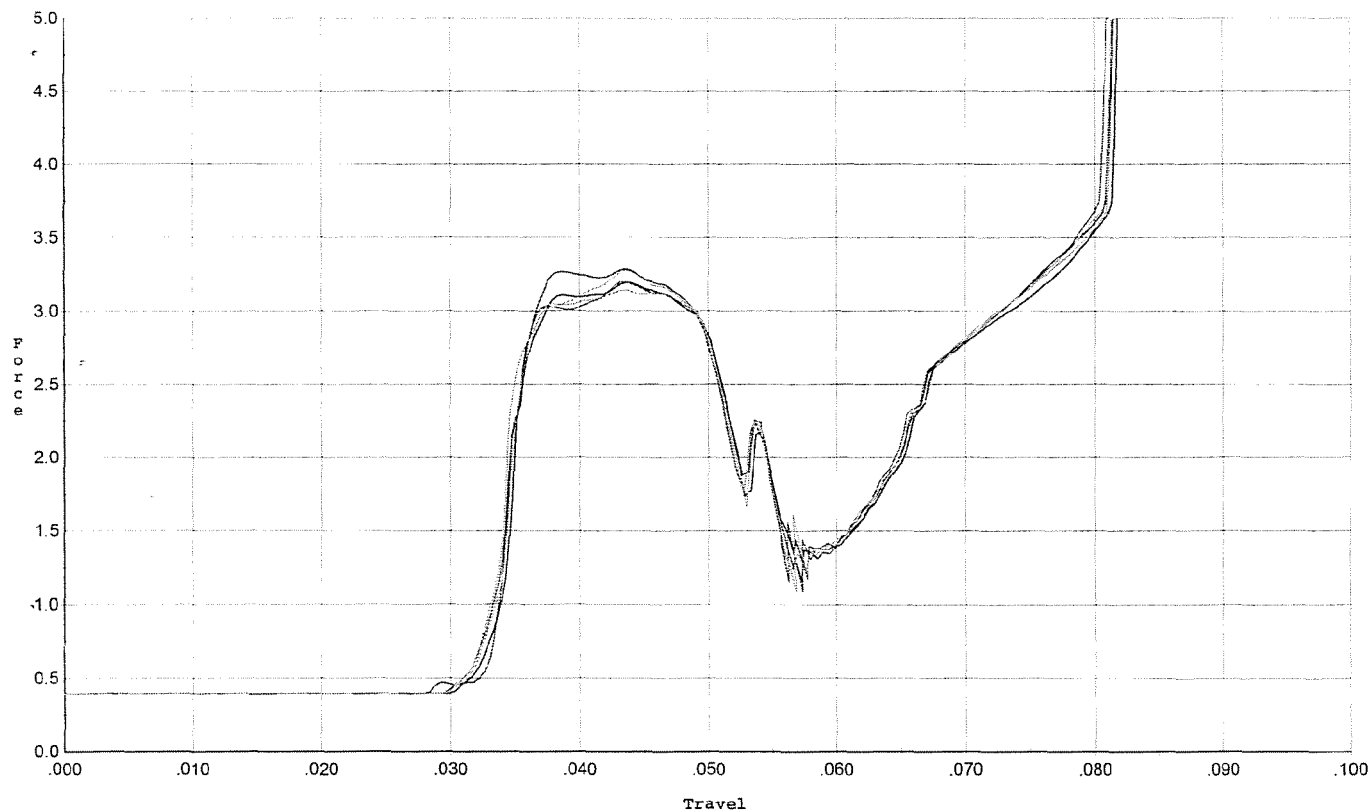
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.421	0.056	0.036	0.034	0.056		Set Trigger
2	2.526	0.056	0.035	0.034	0.058		Set Trigger
3	2.488	0.053	0.035	0.036	0.052		Set Trigger
4	2.522	0.052	0.035	0.036	0.053		Set Trigger
5	2.465	0.052	0.034	0.036	0.053		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



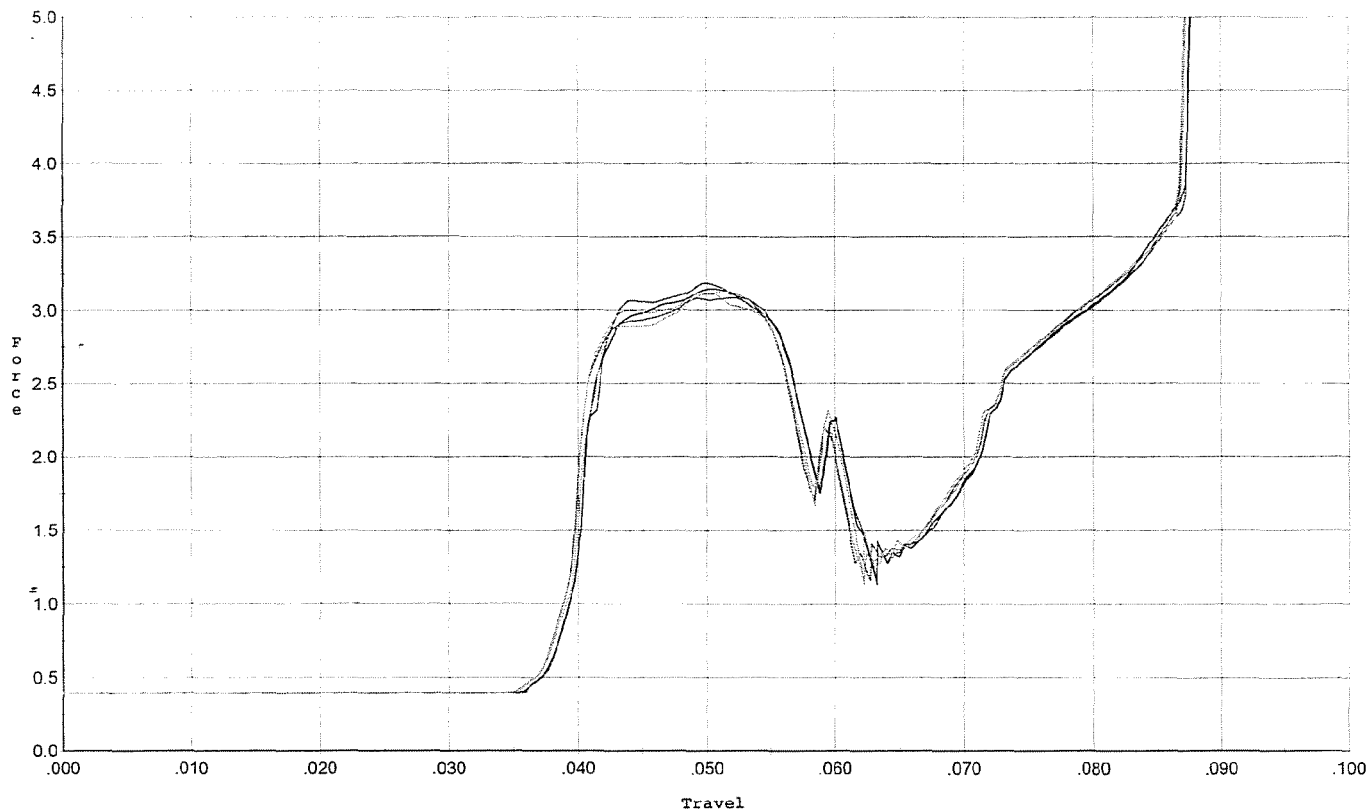
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.285	0.054	0.033	0.033	0.072		Set Trigger
2	3.195	0.051	0.033	0.034	0.065		Set Trigger
3	3.197	0.054	0.032	0.032	0.071		Set Trigger
4	3.277	0.054	0.032	0.032	0.071		Set Trigger
5	3.143	0.054	0.032	0.032	0.072		Set Trigger

A-3.21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



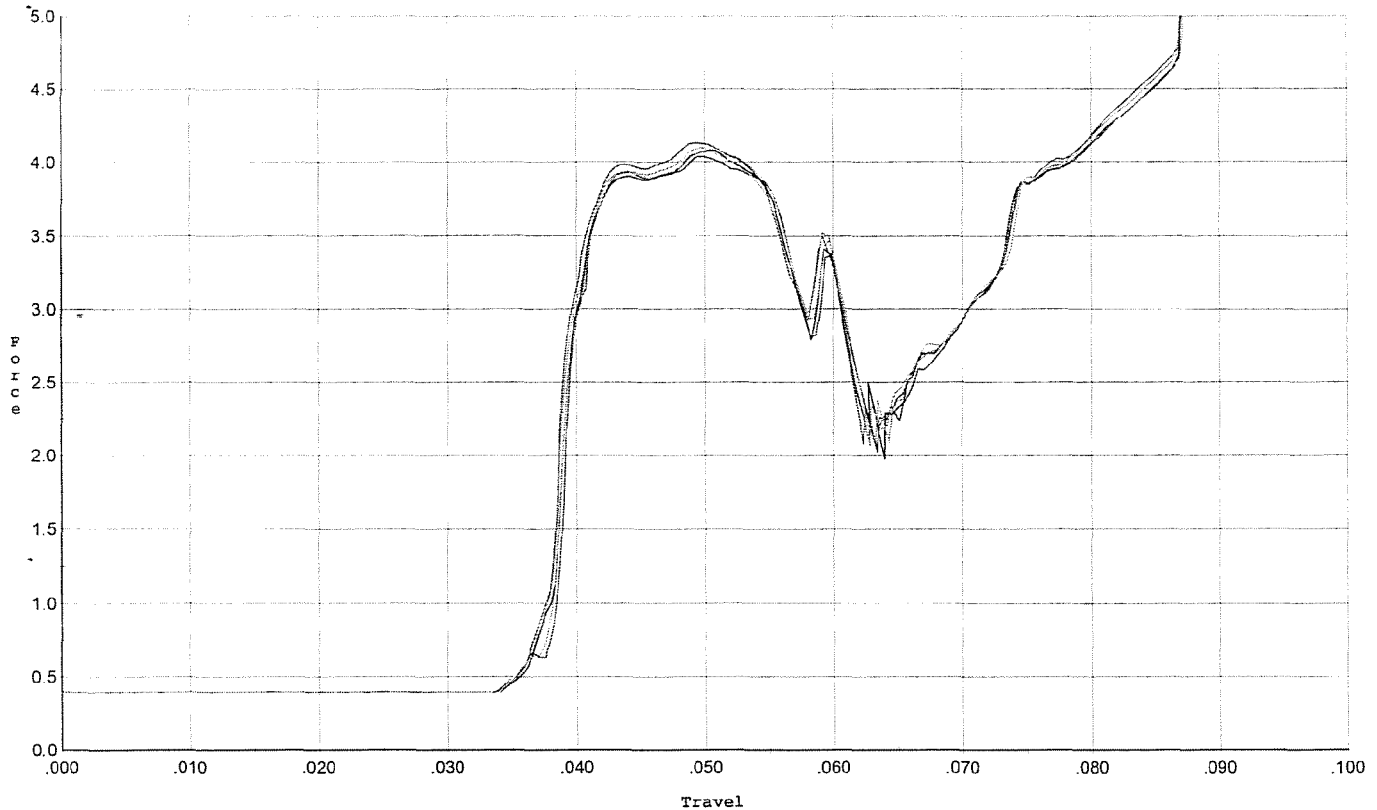
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.182	0.060	0.038	0.033	0.073		Set Trigger
2	3.144	0.060	0.038	0.033	0.073		Set Trigger
3	3.085	0.060	0.038	0.033	0.072		Set Trigger
4	3.127	0.060	0.038	0.033	0.073		Set Trigger
5	3.115	0.060	0.038	0.033	0.073		Set Trigger

A3.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



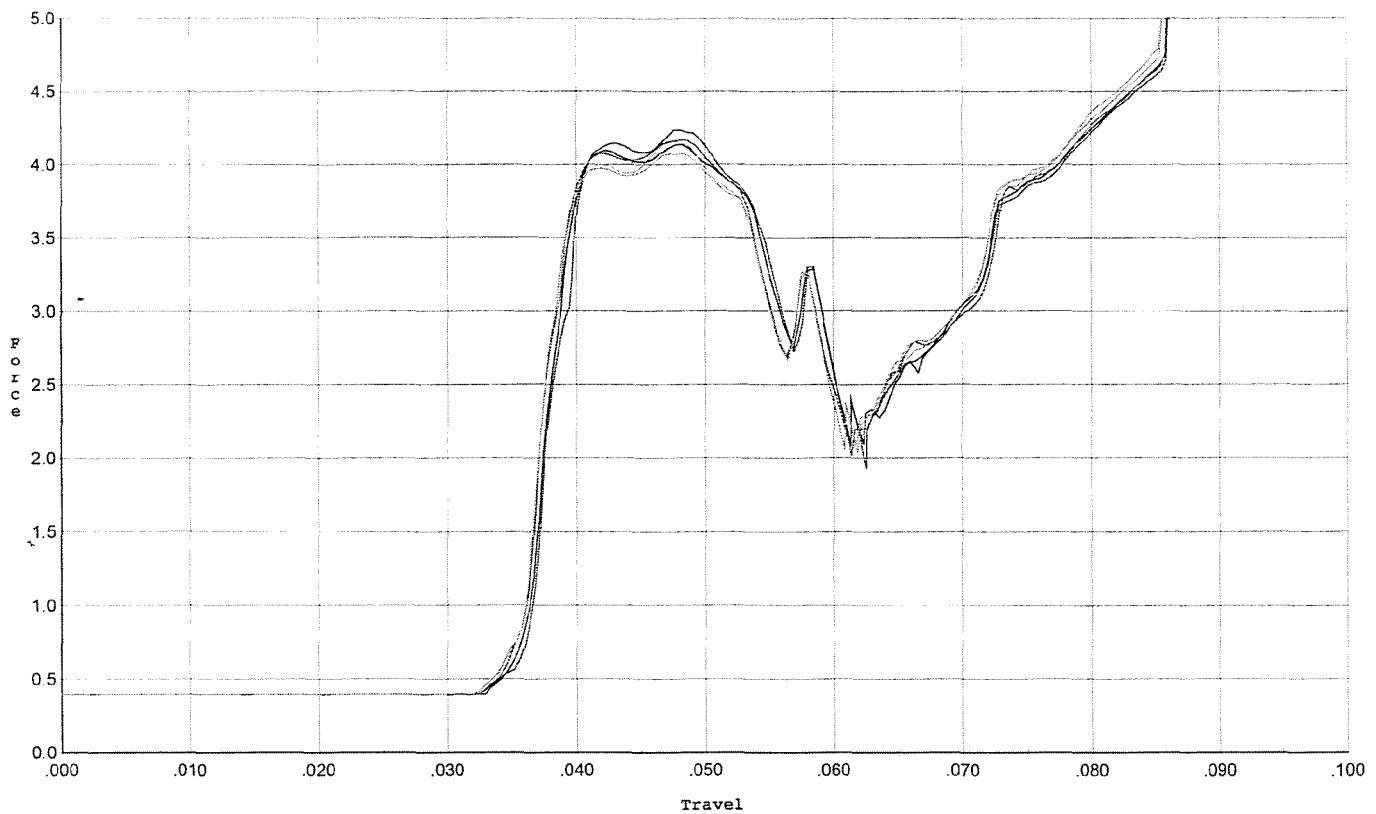
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.038	0.060	0.036	0.031	0.095		Set Trigger
2	4.074	0.060	0.037	0.031	0.095		Set Trigger
3	4.132	0.060	0.036	0.031	0.097		Set Trigger
4	4.085	0.061	0.038	0.031	0.098		Set Trigger
5	4.096	0.060	0.036	0.031	0.096		Set Trigger

A 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



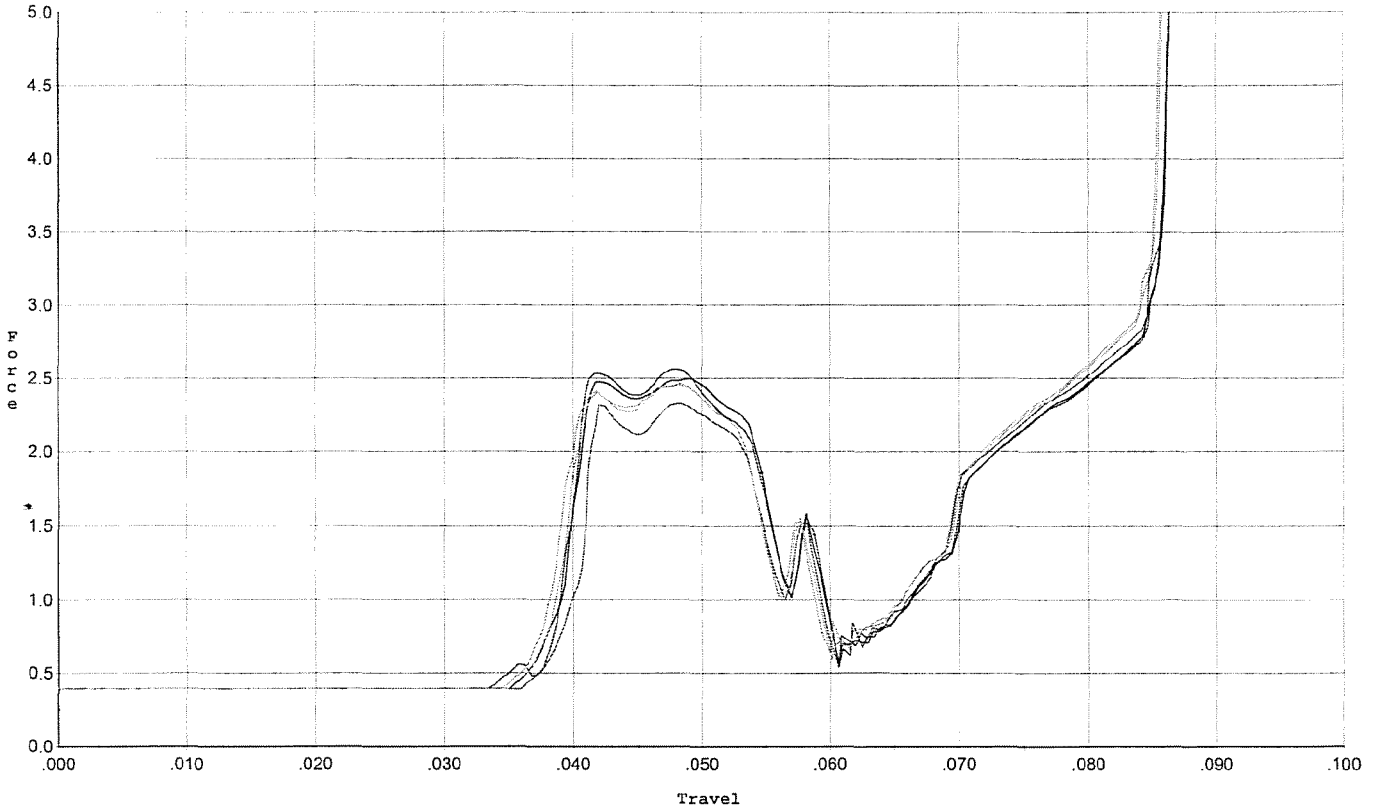
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.234	0.059	0.036	0.031	0.095		Set Trigger
2	4.134	0.058	0.035	0.031	0.095		Set Trigger
3	4.166	0.058	0.035	0.032	0.094		Set Trigger
4	4.155	0.058	0.035	0.031	0.094		Set Trigger
5 *	4.074	0.058	0.035	0.031	0.094		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



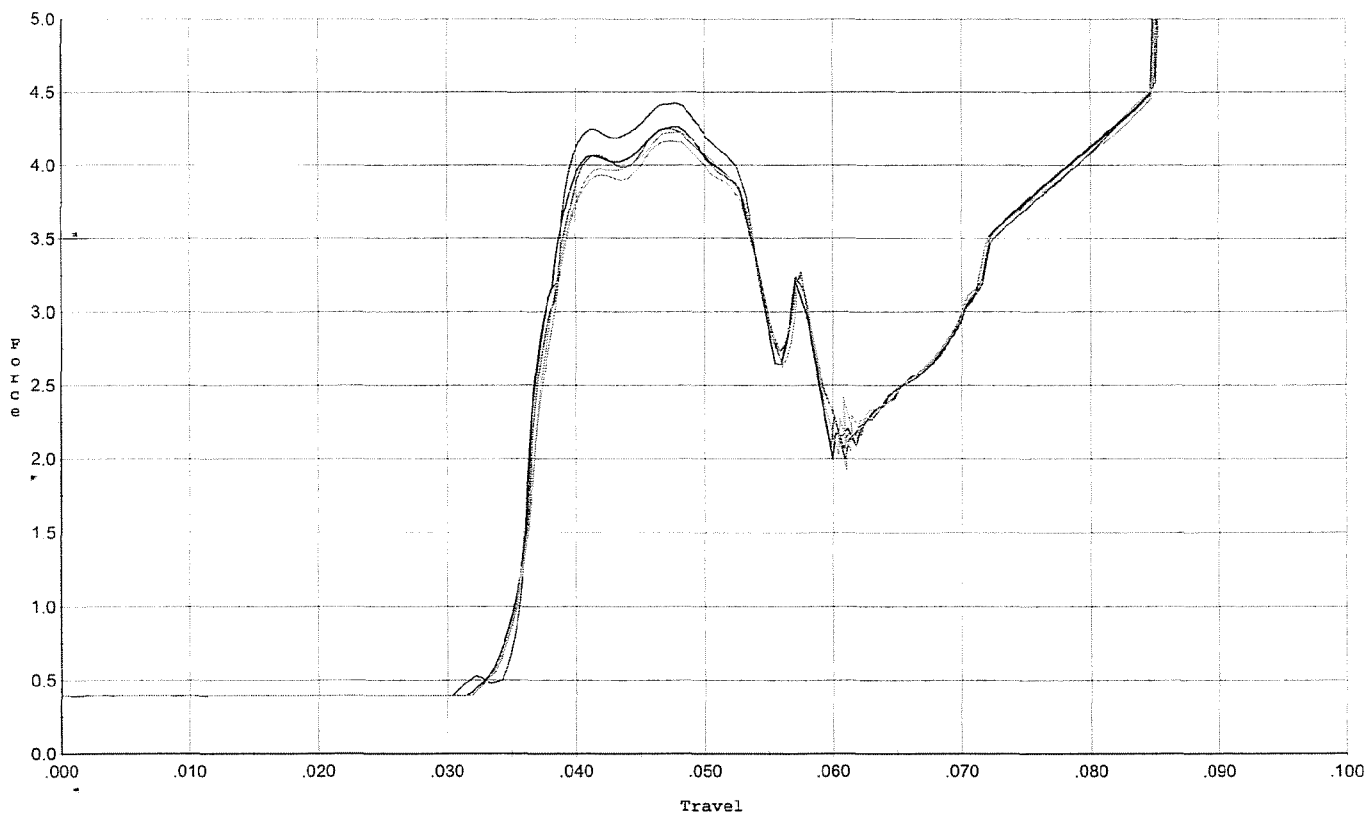
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.561	0.059	0.038	0.034	0.058		Set Trigger
2	2.498	0.055	0.037	0.037	0.052		Set Trigger
3	2.324	0.058	0.038	0.035	0.052		Set Trigger
4	2.448	0.059	0.037	0.034	0.056		Set Trigger
5	2.464	0.058	0.037	0.035	0.056		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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	4.425	0.058	0.035	0.032	0.098		Set Trigger
2	4.261	0.058	0.034	0.031	0.096		Set Trigger
3	4.248	0.058	0.034	0.032	0.095		Set Trigger
4	4.221	0.058	0.034	0.031	0.094		Set Trigger
5	4.162	0.058	0.034	0.031	0.093		Set Trigger

A-4.26