

66794537

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



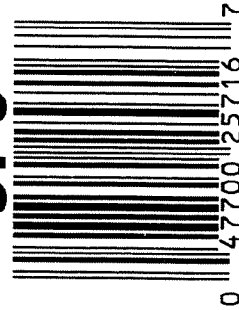
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794537

UPC



GUN SERIAL #

G 6794537

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	MAGNA - FLUX OCT 28 2008 OPERATOR (A)	10-28-08	RSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/29/08	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10 30	
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

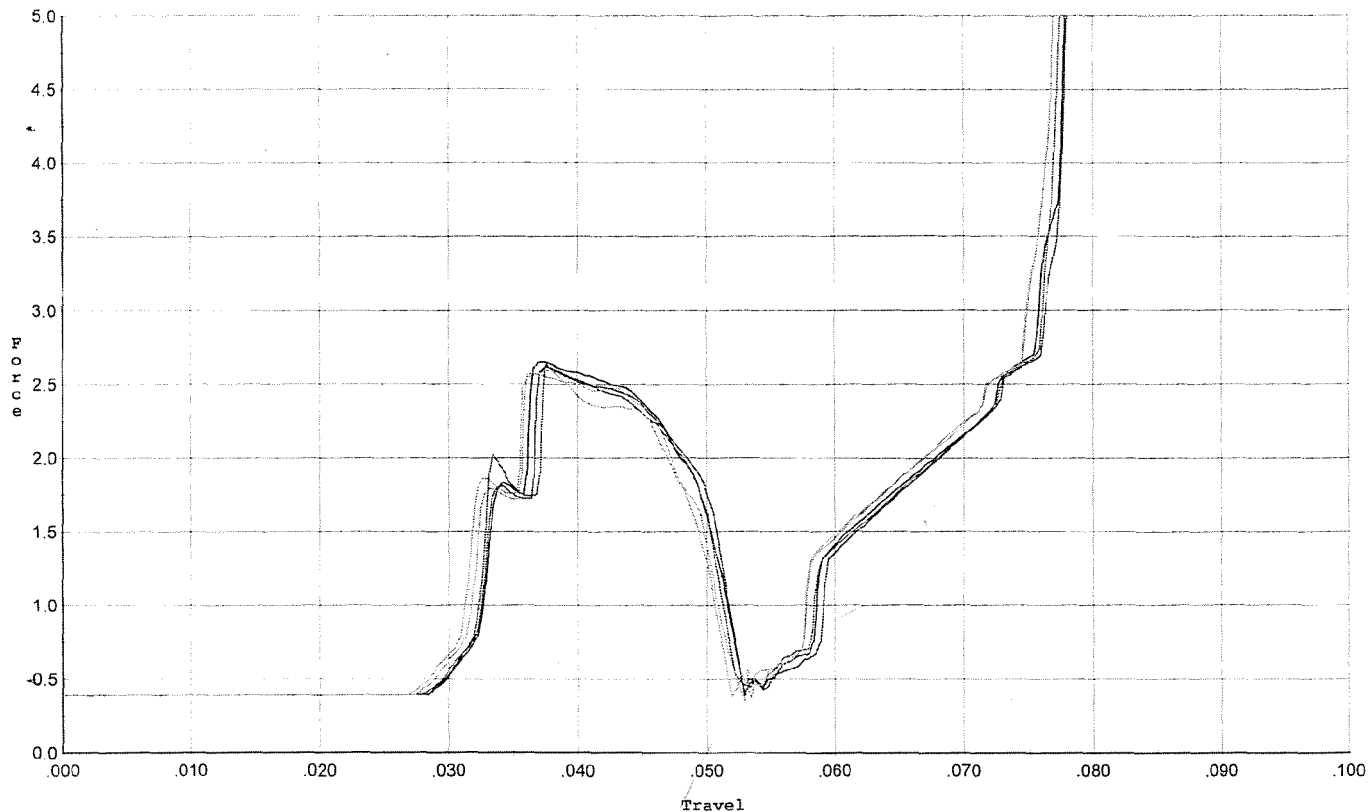
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	4° 4° 4°	11-12-08	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	5° 5.0 5.0	11-12-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	.023 .023 .023	11-12-08	L. J.
	J) ASSEMBLE STOCK		11-5-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		11-12-08	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	PASS FAIL PASS FAIL	11-6-08	L. J.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-6-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-12-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.19 2.21 2.28 2.23 2.32	11-6-08	TC
	C) FUNCTION		11-12-08	L. J.
690	PACK		11/13/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



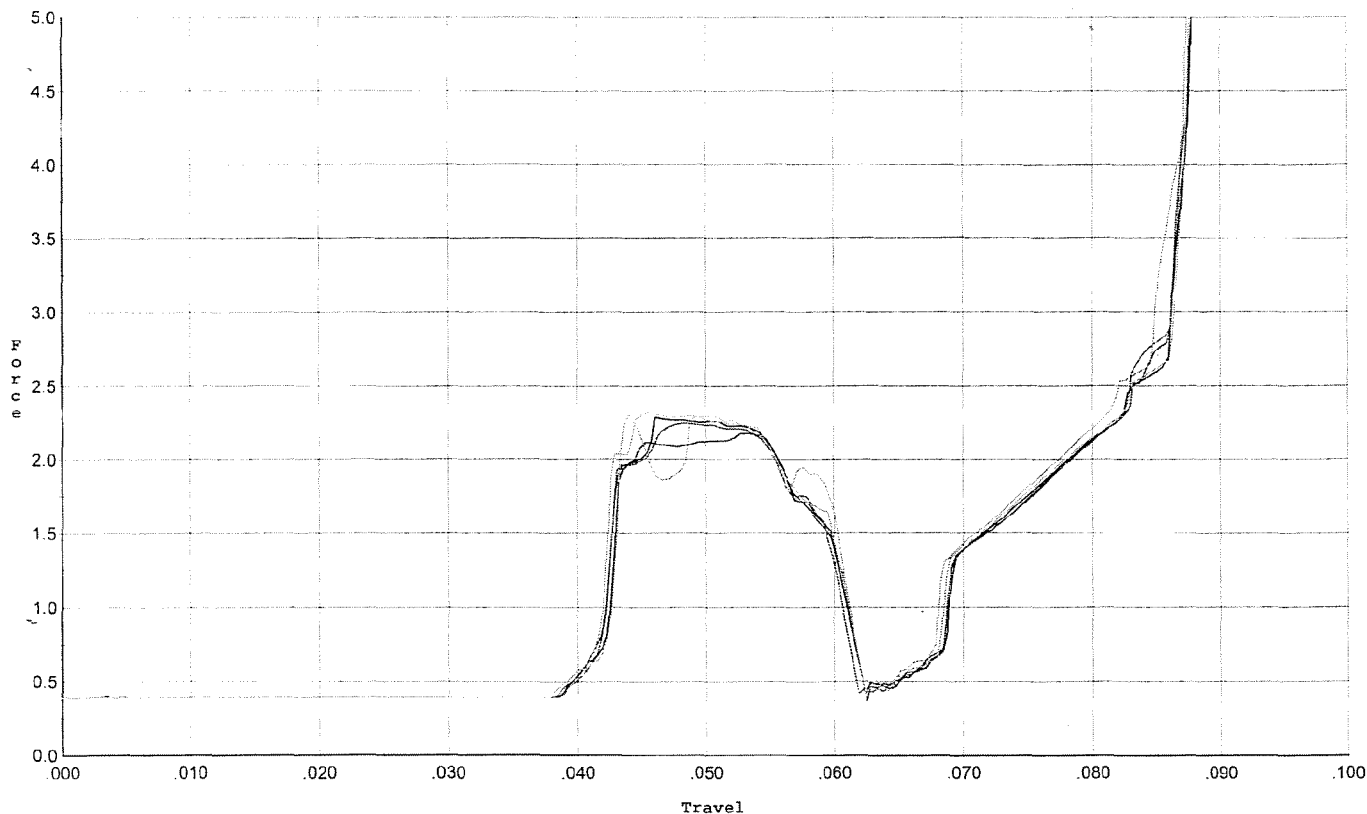
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.051	0.031	0.033	0.053		Set Trigger
2	2.652	0.051	0.032	0.033	0.054		Set Trigger
3	2.634	0.050	0.032	0.033	0.052		Set Trigger
4	2.575	0.050	0.031	0.032	0.052		Set Trigger
5	2.596	0.050	0.031	0.032	0.053		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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



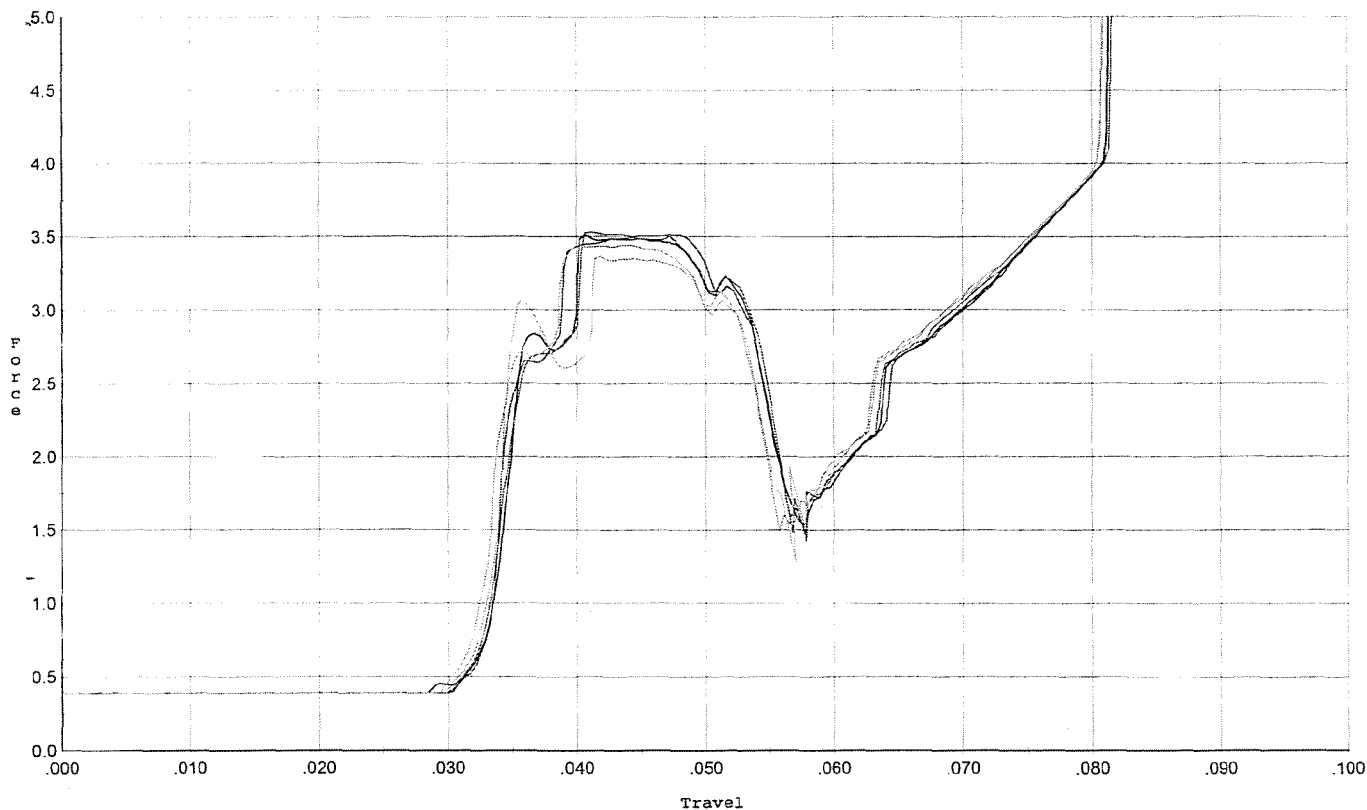
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.177	0.061	0.041	0.034	0.053		Set Trigger
2	2.288	0.061	0.041	0.034	0.054		Set Trigger
3	2.247	0.060	0.042	0.035	0.053		Set Trigger
4	2.311	0.060	0.042	0.034	0.053		Set Trigger
5	2.324	0.061	0.041	0.034	0.055		Set Trigger

A-2-26

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



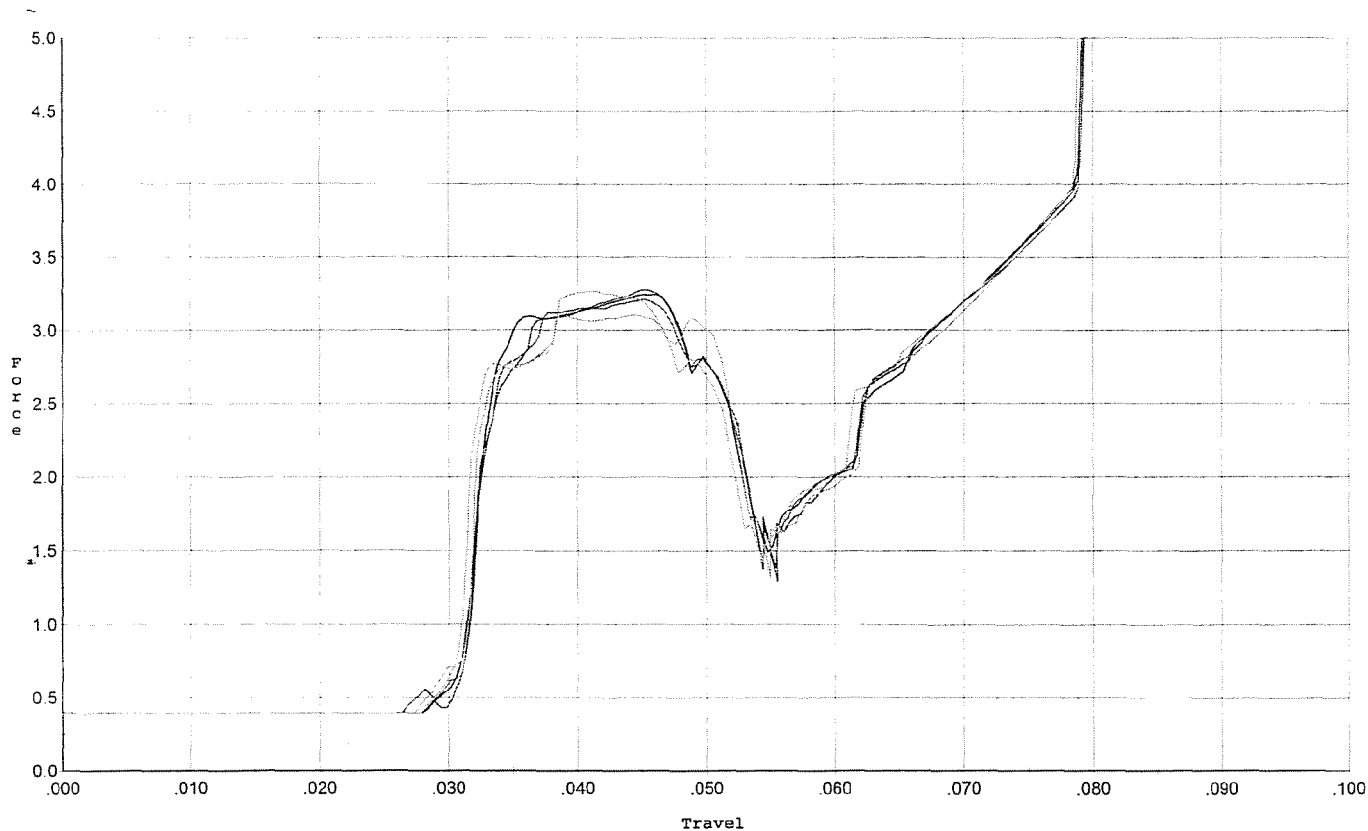
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.513	0.055	0.032	0.032	0.080		Set Trigger
2	3.515	0.054	0.032	0.032	0.076		Set Trigger
3	3.533	0.054	0.031	0.032	0.078		Set Trigger
4	3.366	0.053	0.030	0.032	0.074		Set Trigger
5	3.441	0.054	0.030	0.032	0.077		Set Trigger

A-3.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



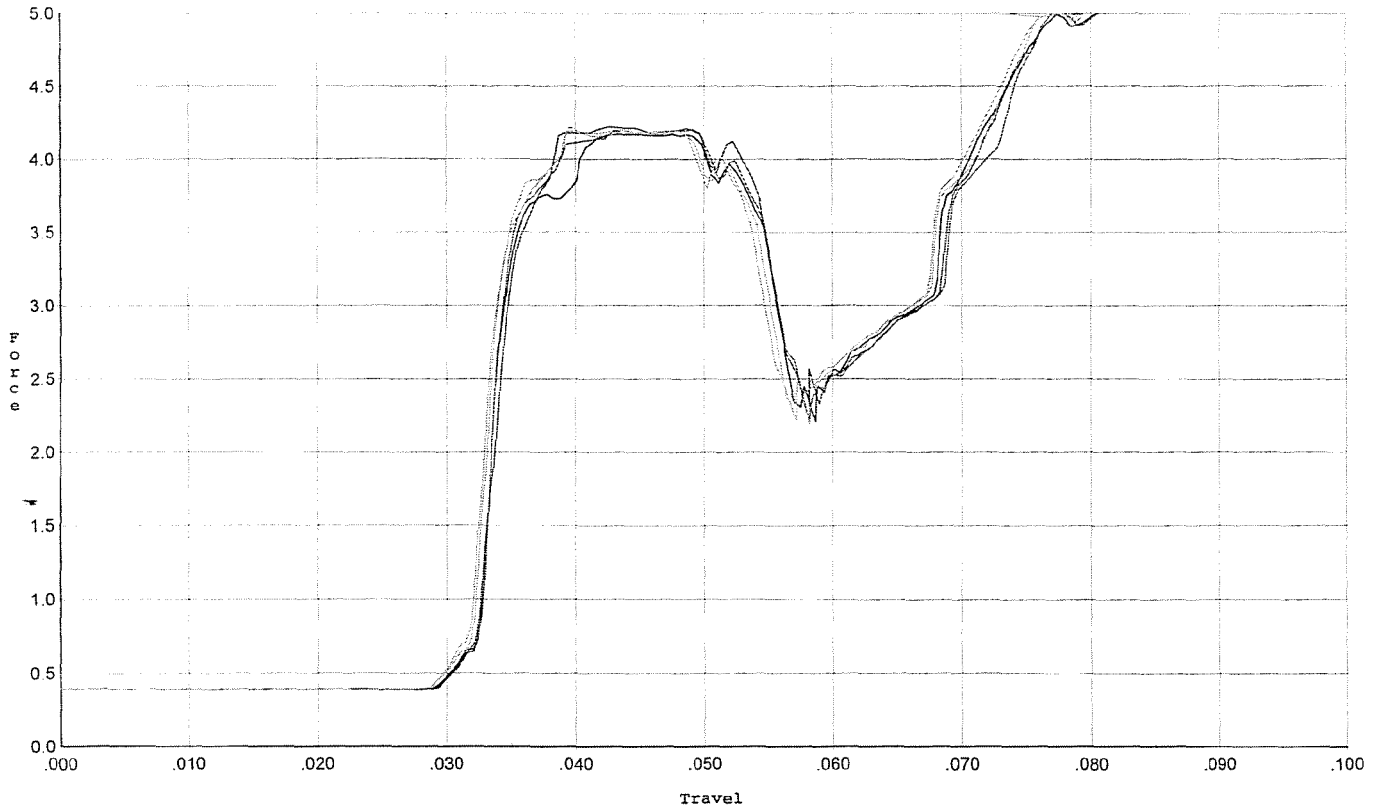
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.277	0.053	0.027	0.032	0.073		Set Trigger
2	3.245	0.052	0.031	0.032	0.072		Set Trigger
3	3.214	0.052	0.031	0.032	0.073		Set Trigger
4	3.121	0.051	0.028	0.031	0.070		Set Trigger
5	3.267	0.051	0.028	0.032	0.072		Set Trigger

A-3.22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



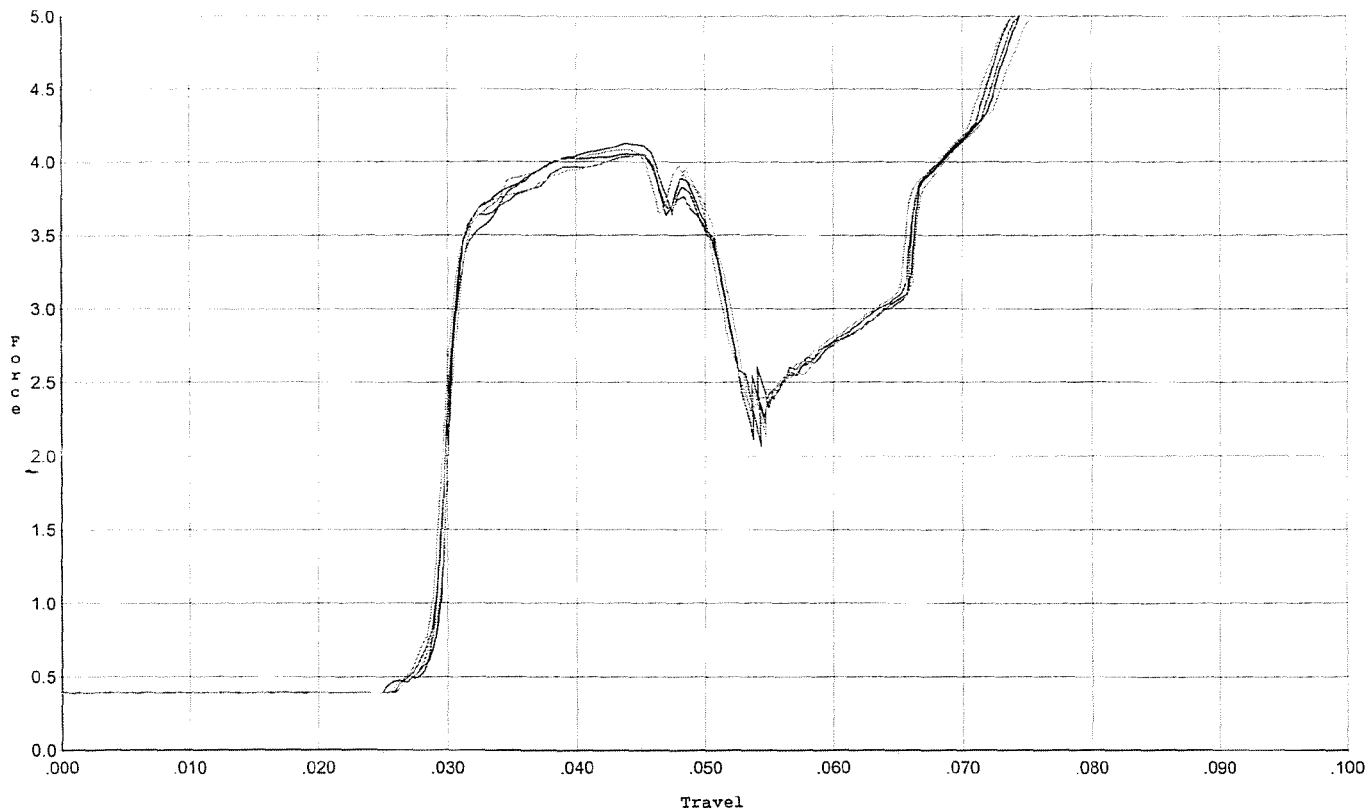
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.223	0.054	0.031	0.031	0.098		Set Trigger
2	4.168	0.055	0.031	0.031	0.097		Set Trigger
3	4.204	0.055	0.032	0.031	0.098		Set Trigger
4	4.196	0.054	0.029	0.031	0.098		Set Trigger
5	4.218	0.054	0.031	0.031	0.096		Set Trigger

A420

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schuils 10/31/2008

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



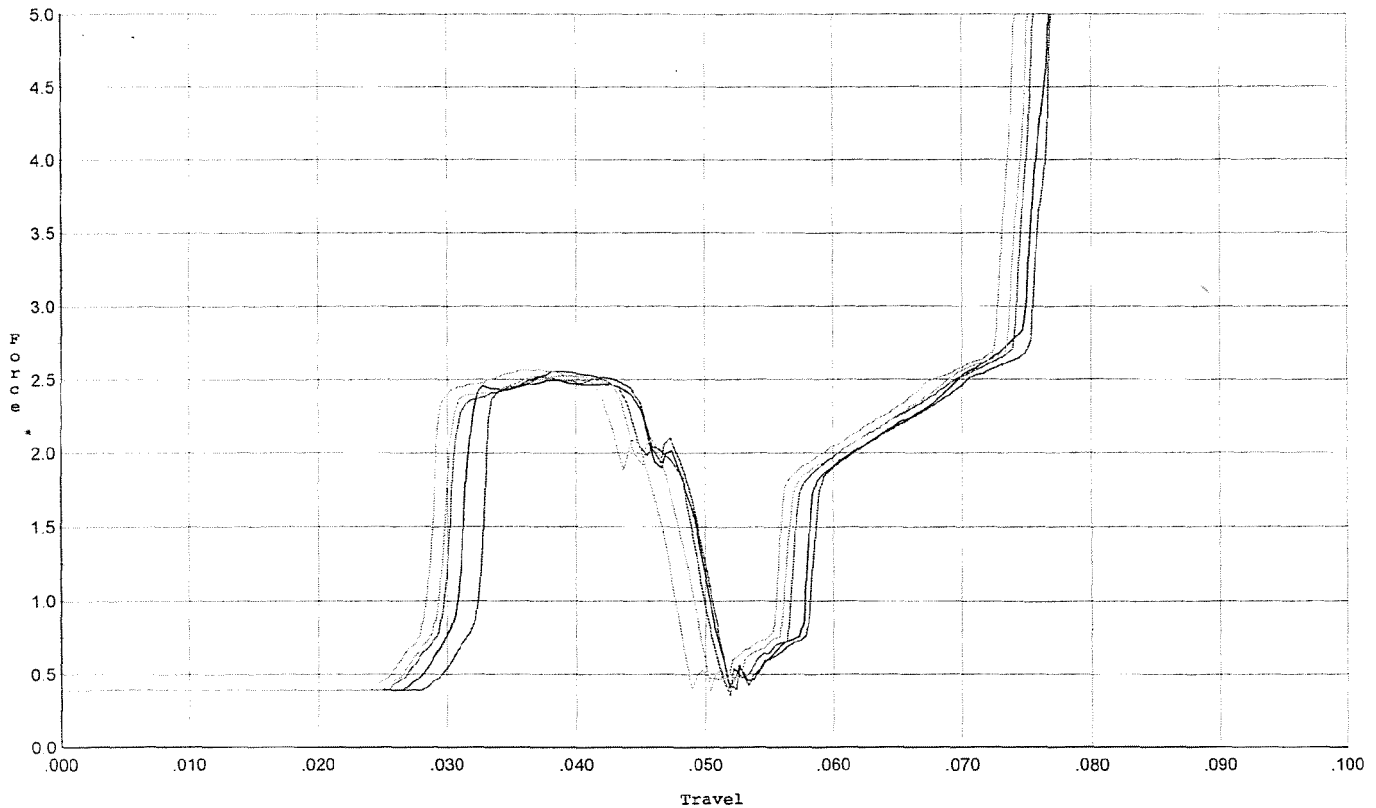
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.126	0.051	0.029	0.030	0.093		Set Trigger
2	4.054	0.051	0.029	0.030	0.093		Set Trigger
3	4.051	0.051	0.028	0.030	0.092		Set Trigger
4	4.044	0.052	0.028	0.030	0.094		Set Trigger
5	4.080	0.050	0.028	0.029	0.092		Set Trigger

A-4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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

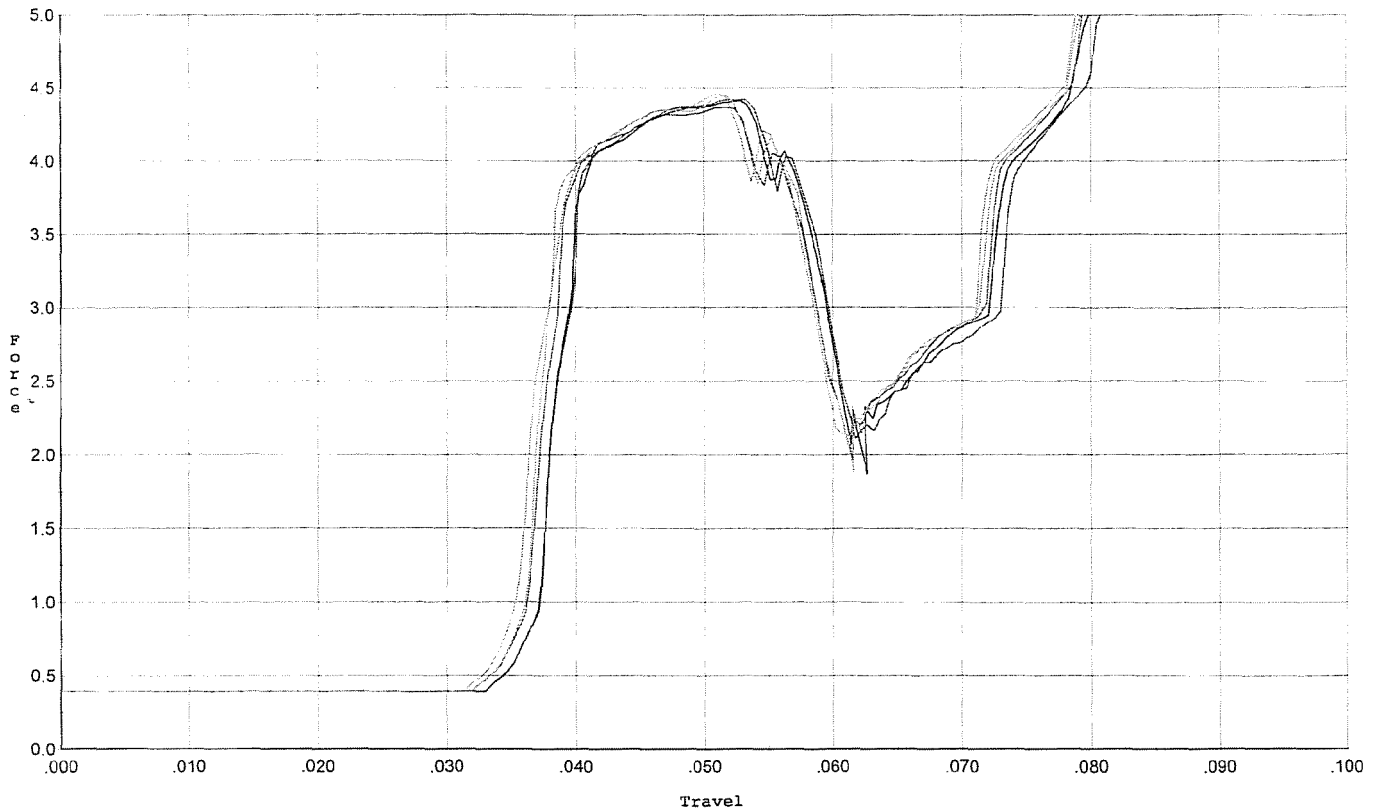


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.557	0.050	0.031	0.033	0.054		Set Trigger
2	2.496	0.049	0.029	0.032	0.054		Set Trigger
3	2.518	0.048	0.027	0.031	0.055		Set Trigger
4	2.524	0.049	0.027	0.031	0.055		Set Trigger
5	2.572	0.047	0.026	0.032	0.054		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008
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	4.417	0.059	0.036	0.027	0.101		Set Trigger
2	4.409	0.059	0.036	0.027	0.102		Set Trigger
3	4.366	0.058	0.035	0.027	0.099		Set Trigger
4	4.444	0.057	0.035	0.027	0.101		Set Trigger
5	4.458	0.058	0.034	0.026	0.104		Set Trigger

A4.41