

667945-48

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



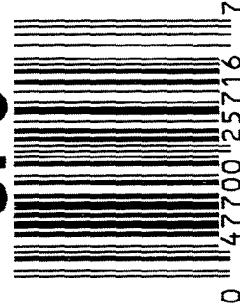
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794548

UPC



GUN SERIAL #

G 6794548

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SPD
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SPD
460	CHECK HEADSPACE		10-7-08	SPD
470	DIS-ASSEMBLE ACTION		10-7-08	SPD
472	SERIALIZE BOLT HANDLE		10-8-08	REN
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/11/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10 21	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-4-08	REN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

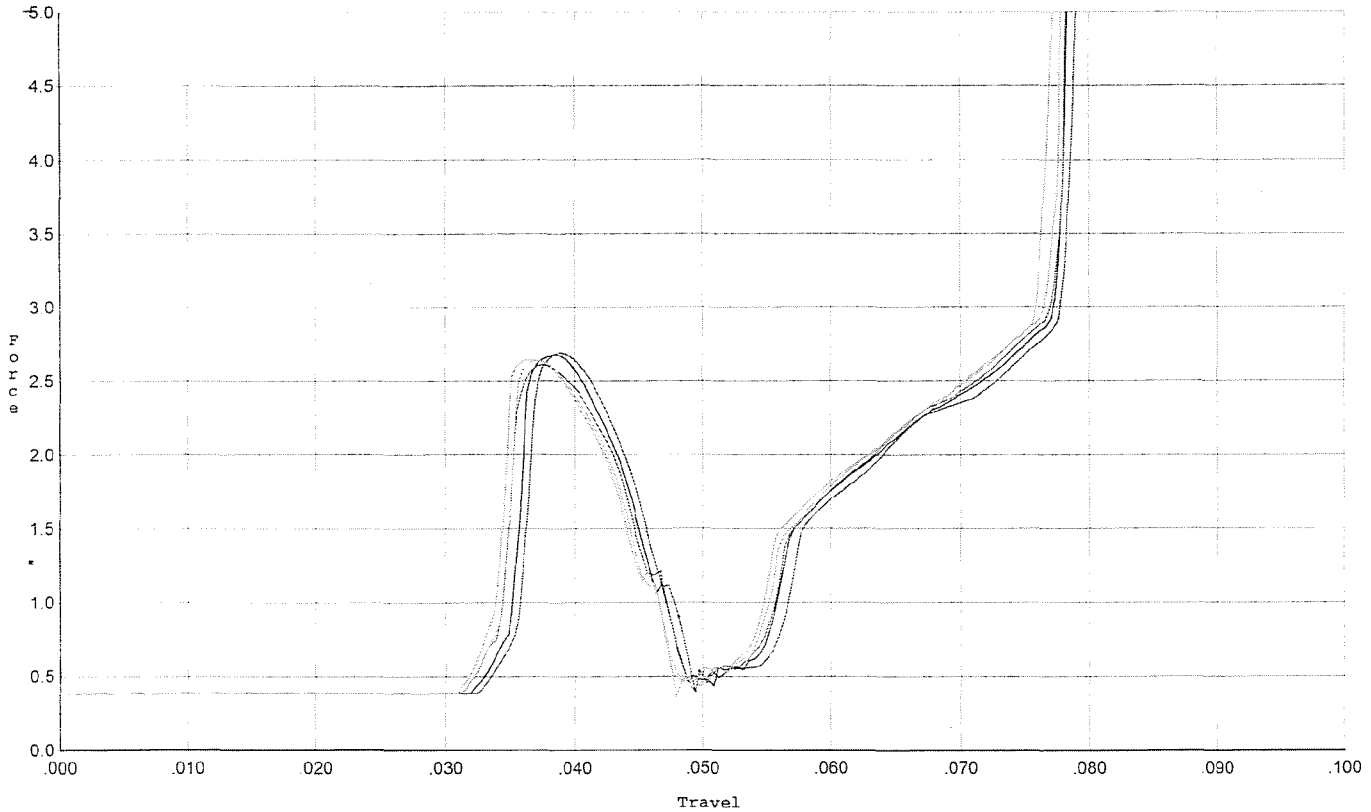
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>45</u> <u>4.5</u>	11-12-08	L. J.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	^{L. J.} 45 <u>6.0</u> <u>50</u> <u>50</u>	11-12-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-12-08	L. J.
	J) ASSEMBLE STOCK		11-4-08	R. N.
	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	11-5-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	R. N.
670	FINAL INSPECTION A) HEADSPACE		11-12-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.58</u> <u>2.62</u> <u>2.55</u> <u>2.57</u>	11-5-08	TC
	C) FUNCTION		11-12-08	L. J.
690	PACK		11/13/08	F. M.

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



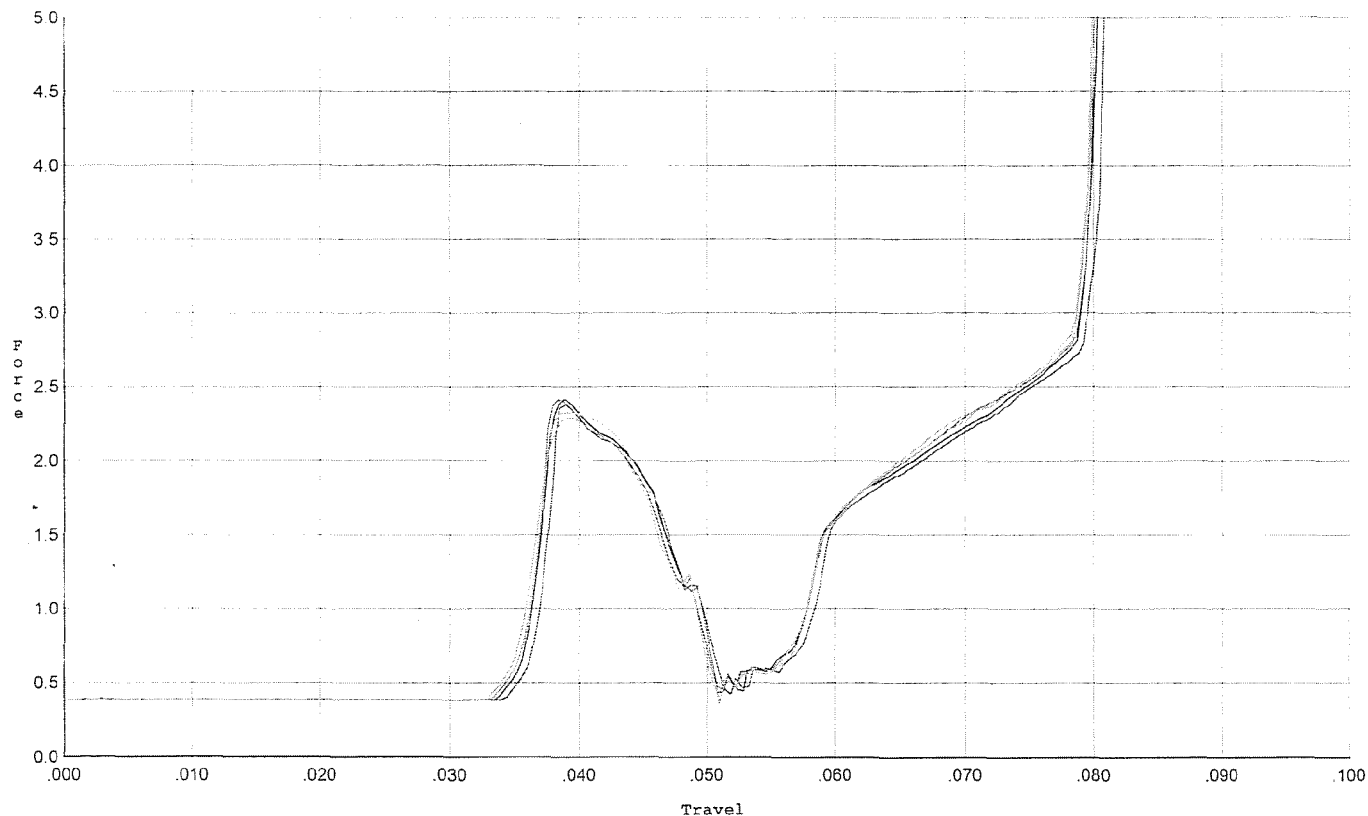
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.691	0.048	0.034	0.036	0.039		Set Trigger
2	2.679	0.047	0.034	0.036	0.039		Set Trigger
3	2.608	0.047	0.033	0.036	0.039		Set Trigger
4	2.639	0.046	0.032	0.036	0.038		Set Trigger
5	2.645	0.046	0.032	0.035	0.039		Set Trigger

7-2.65

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



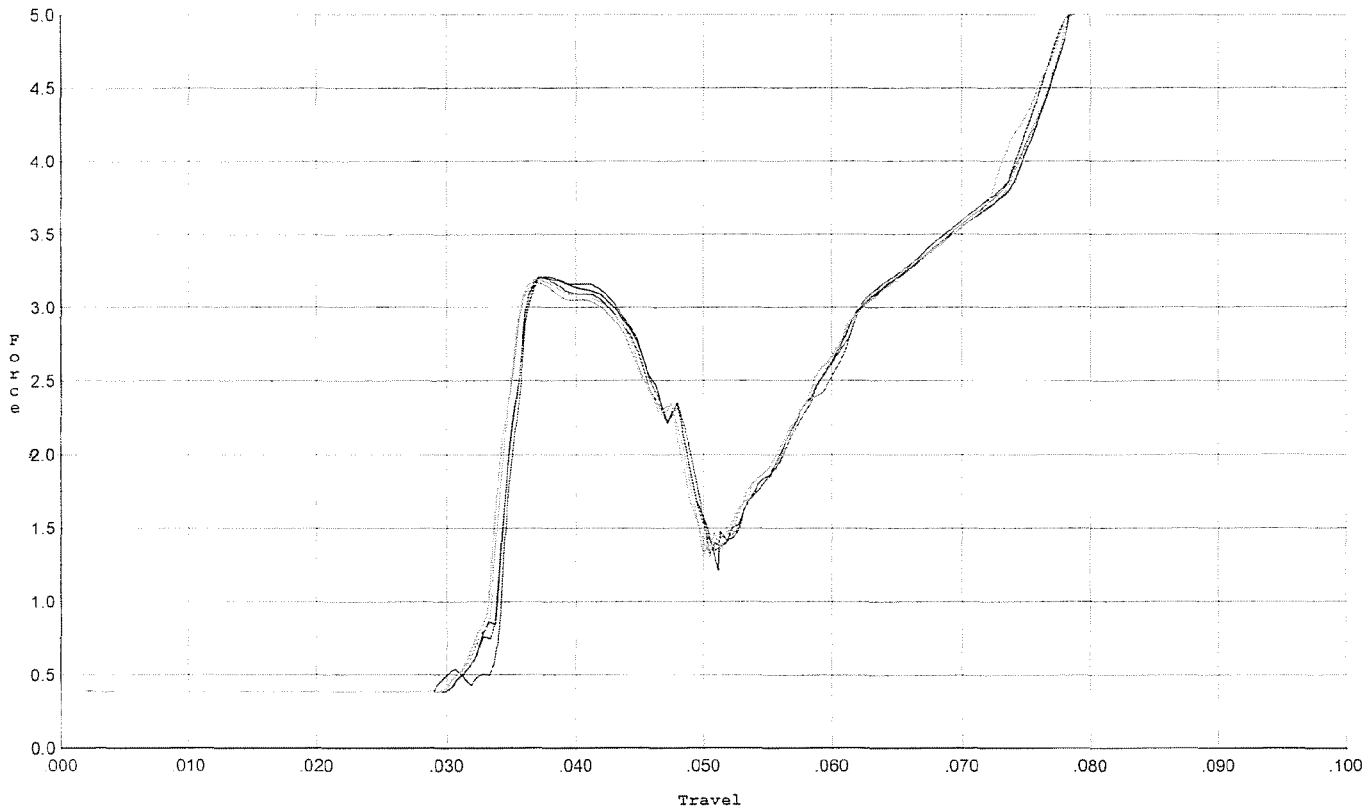
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.380	0.049	0.036	0.037	0.038		Set Trigger
2	2.415	0.049	0.035	0.037	0.039		Set Trigger
3	2.415	0.049	0.035	0.037	0.038		Set Trigger
4	2.326	0.049	0.035	0.037	0.039		Set Trigger
5	2.293	0.049	0.035	0.037	0.038		Set Trigger

A-236

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



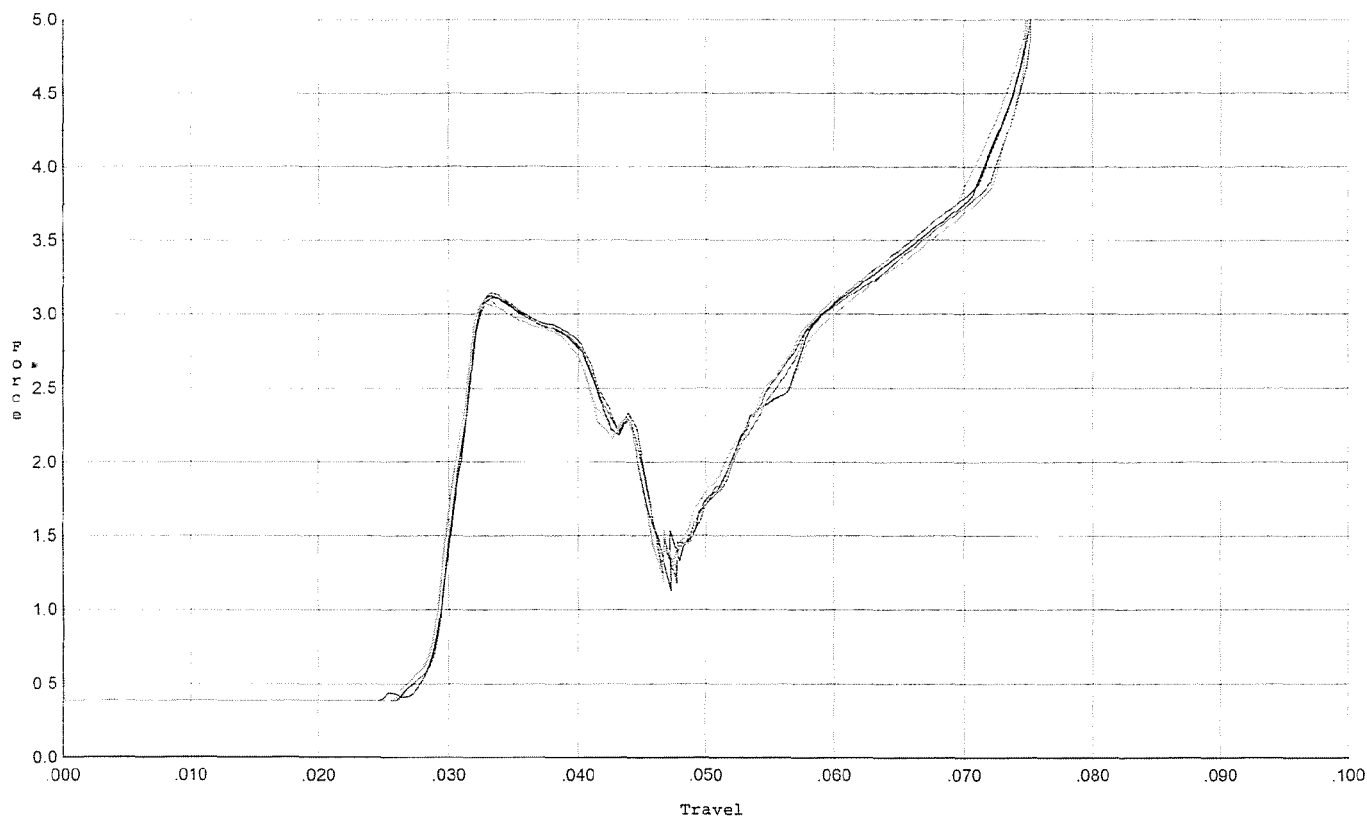
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.213	0.049	0.034	0.034	0.055		Set Trigger
2	3.204	0.048	0.032	0.034	0.054		Set Trigger
3	3.207	0.048	0.031	0.034	0.053		Set Trigger
4	3.188	0.048	0.030	0.034	0.055		Set Trigger
5	3.162	0.047	0.032	0.034	0.053		Set Trigger

A-3.19

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



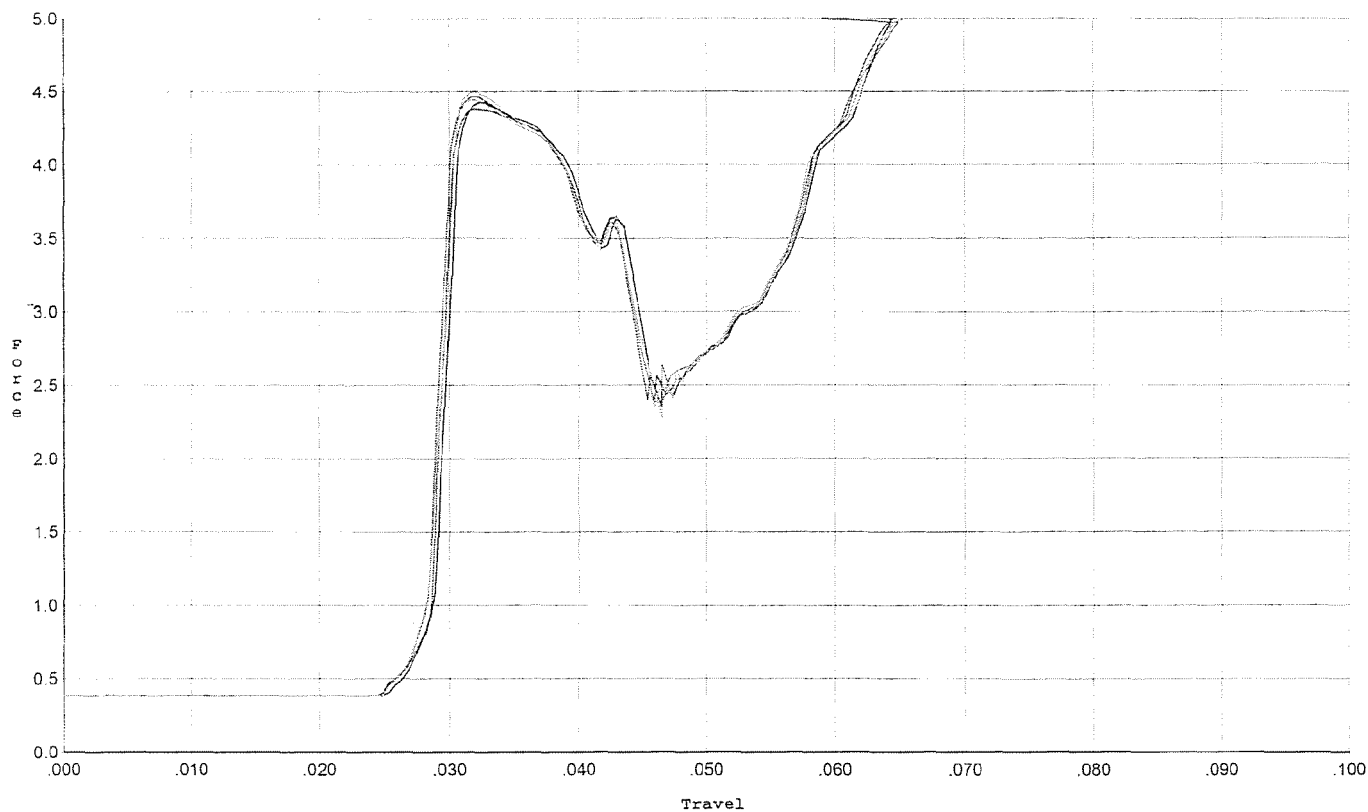
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.111	0.045	0.028	0.032	0.052		Set Trigger
2	3.126	0.044	0.029	0.032	0.051		Set Trigger
3	3.142	0.045	0.029	0.032	0.053		Set Trigger
4	3.072	0.044	0.026	0.032	0.051		Set Trigger
5	3.106	0.044	0.028	0.032	0.051		Set Trigger

A-3-11

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



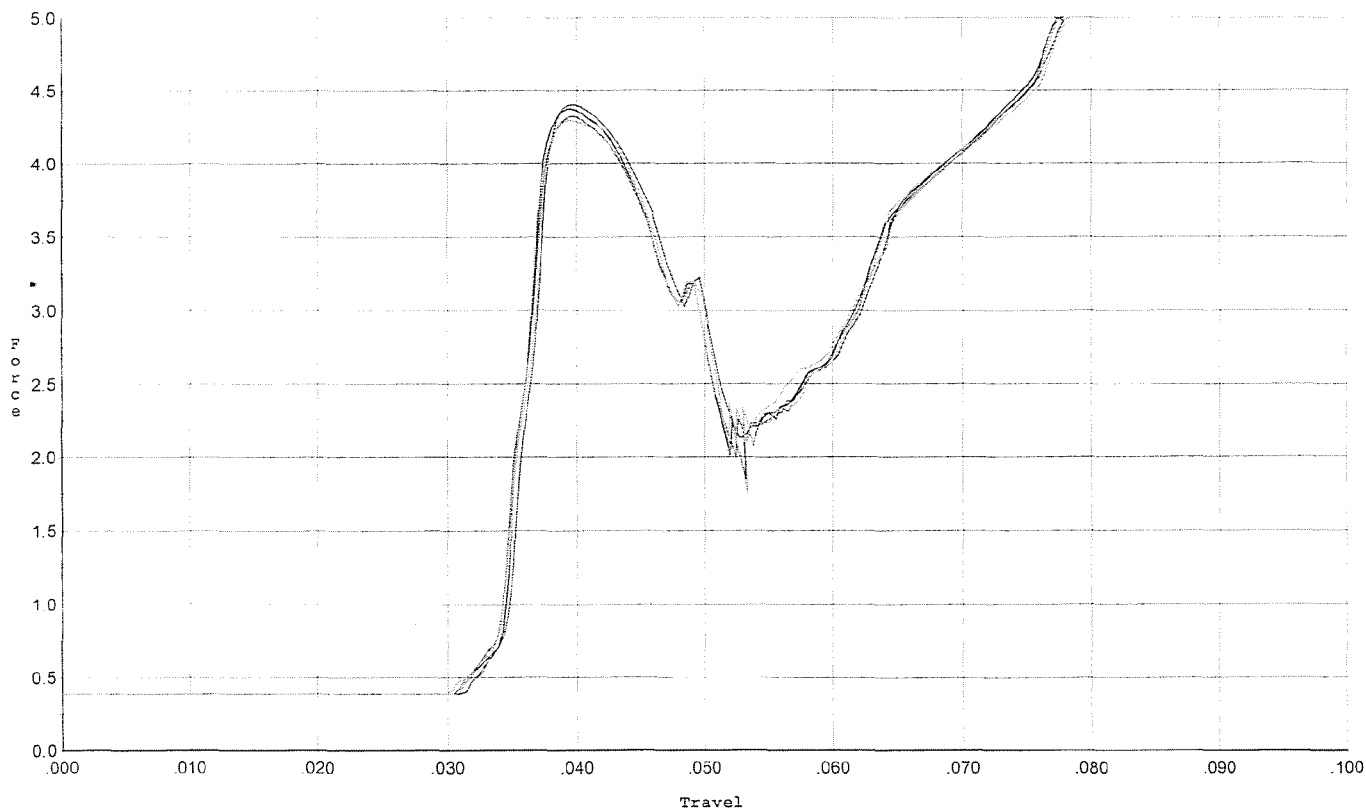
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.379	0.043	0.025	0.030	0.070		Set Trigger
2	4.423	0.044	0.027	0.030	0.071		Set Trigger
3	4.463	0.043	0.025	0.030	0.071		Set Trigger
4	4.493	0.043	0.025	0.030	0.070		Set Trigger
5	4.441	0.043	0.025	0.030	0.070		Set Trigger

A21.44

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 after 20 cycles+/- 1.0 lbs



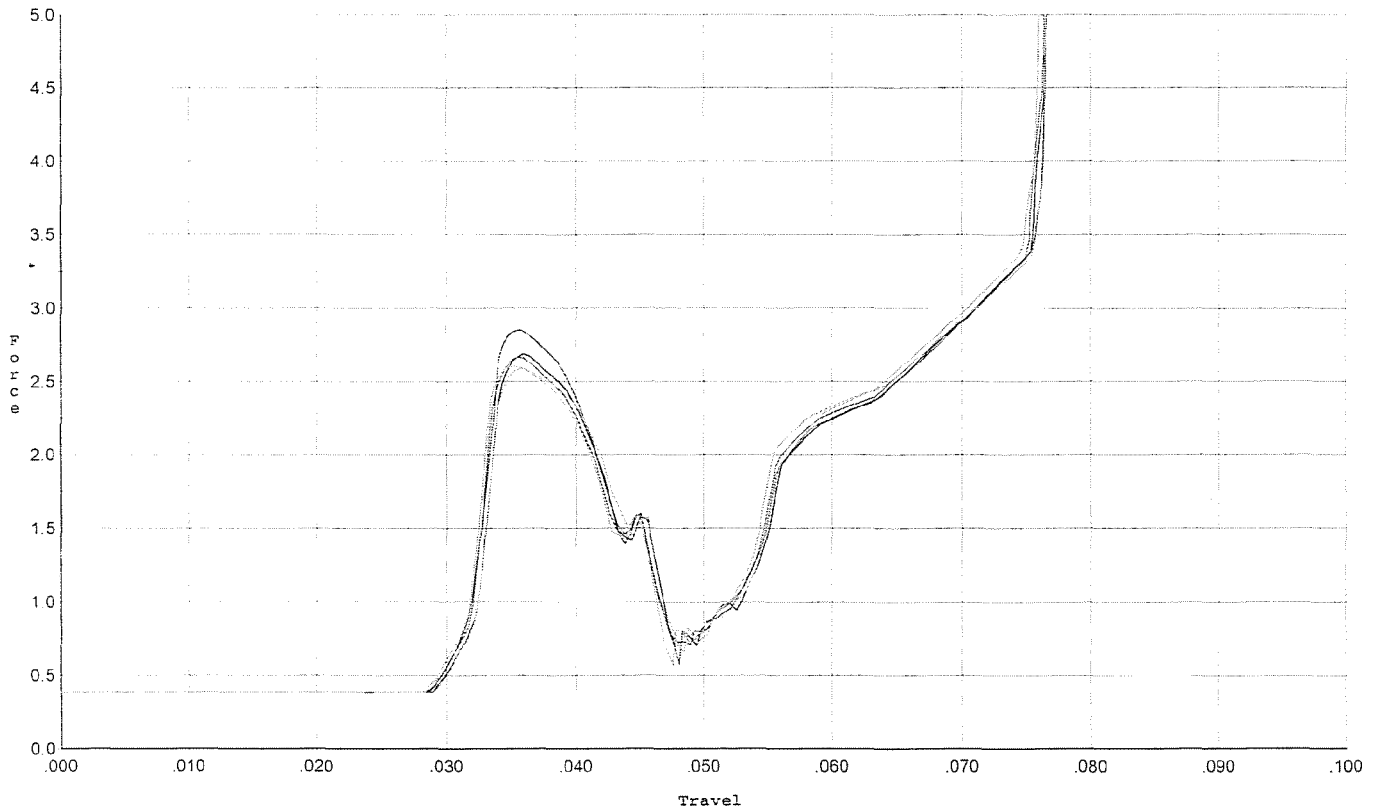
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.404	0.050	0.032	0.034	0.069		Set Trigger
2	4.377	0.049	0.031	0.034	0.069		Set Trigger
3	4.321	0.049	0.031	0.034	0.069		Set Trigger
4	4.333	0.050	0.031	0.034	0.070		Set Trigger
5	4.300	0.049	0.031	0.034	0.069		Set Trigger

A-4-34

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 lbs for final test



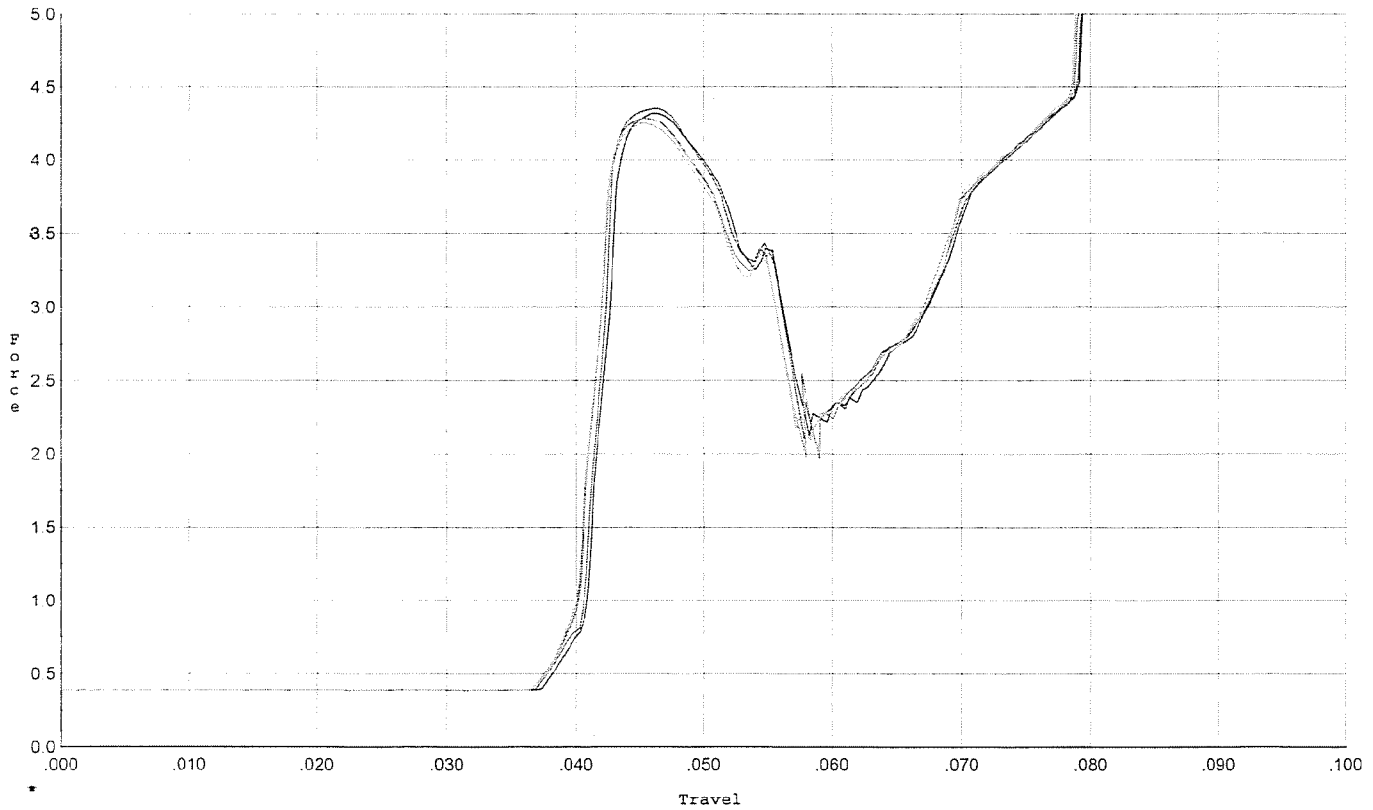
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.853	0.045	0.030	0.034	0.042		Set Trigger
2	2.690	0.046	0.029	0.034	0.041		Set Trigger
3	2.667	0.045	0.030	0.035	0.041		Set Trigger
4	2.585	0.046	0.031	0.034	0.041		Set Trigger
5	2.604	0.045	0.029	0.034	0.041		Set Trigger

A 2.68

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 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.350	0.055	0.037	0.028	0.074		Set Trigger
2	4.316	0.055	0.038	0.028	0.073		Set Trigger
3	4.282	0.055	0.037	0.028	0.073		Set Trigger
4	4.286	0.055	0.037	0.028	0.073		Set Trigger
5	4.251	0.055	0.038	0.028	0.072		Set Trigger

A-4-29