

G679 4549

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



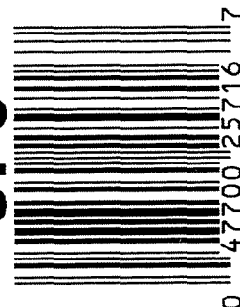
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794549

UPC



GUN SERIAL #

G 6794549

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD.
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD.
460	CHECK HEADSPACE		9-30-08	SPD.
470	DIS-ASSEMBLE ACTION		9-30-08	SPD.
472	SERIALIZE BOLT HANDLE		10-1-08	BSN
475	DRILL AND TAP SIGHT HOLES	MAGNA-FLUX 2008	10-1-08	SP
480	MAGNAFLUX BBL ACTION	ⓐ	10-2-08	ⓐ
490	MAGNAFLUX BOLT	OPERATOR	9/30/08	TC
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10-8	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-13-08	SPD.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

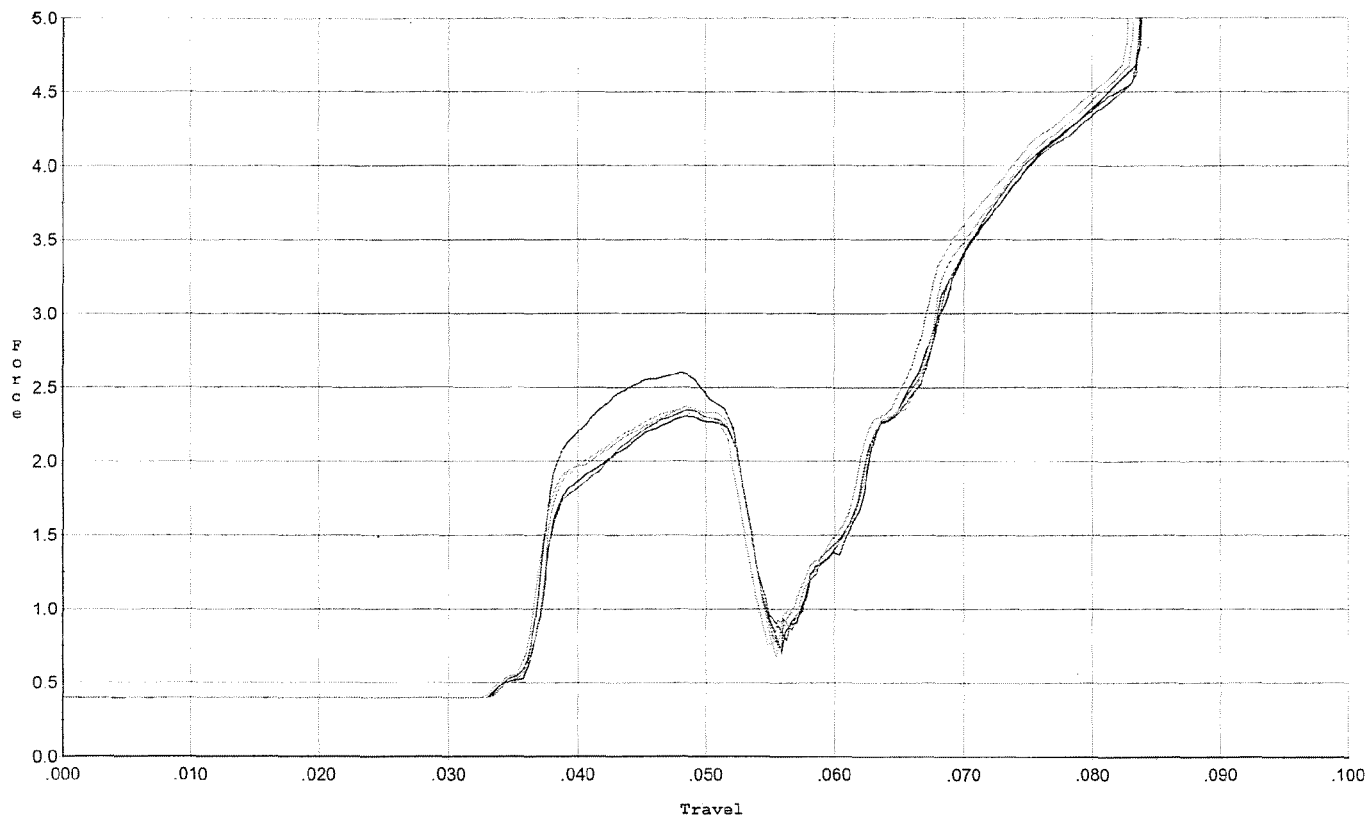
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>3.0</u> <u>3.0</u>	12-2-08	L. N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	12-2-08	L. N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	12-2-08	L. N
	J) ASSEMBLE STOCK		11-13-08	L. P. N
	K) ASSEMBLE SWIVEL STUDS		12-2-08	L. N
	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	11-14-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-14-08	L. N
670	FINAL INSPECTION A) HEADSPACE		12-2-08	L. N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.50</u> <u>2.51</u> <u>2.54</u> <u>2.49</u>	11-20-08	TC
	C) FUNCTION		12-2-08	L. N
690	PACK		3/17/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/062008

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



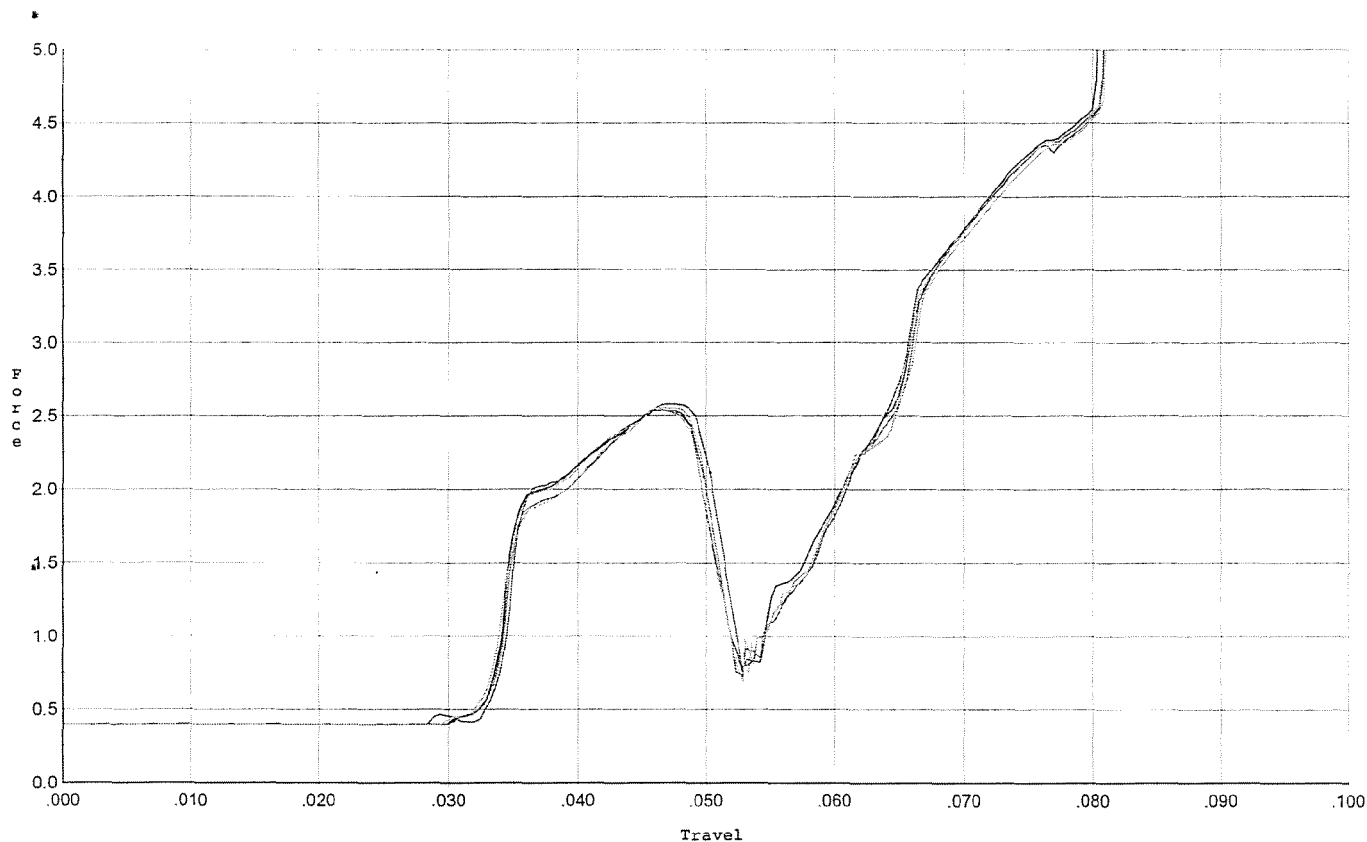
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.052	0.036	0.037	0.052		Set Trigger
2	2.307	0.052	0.036	0.037	0.048		Set Trigger
3	2.345	0.052	0.036	0.037	0.048		Set Trigger
4	2.369	0.052	0.036	0.036	0.049		Set Trigger
5	2.345	0.052	0.036	0.036	0.048		Set Trigger

A-239

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



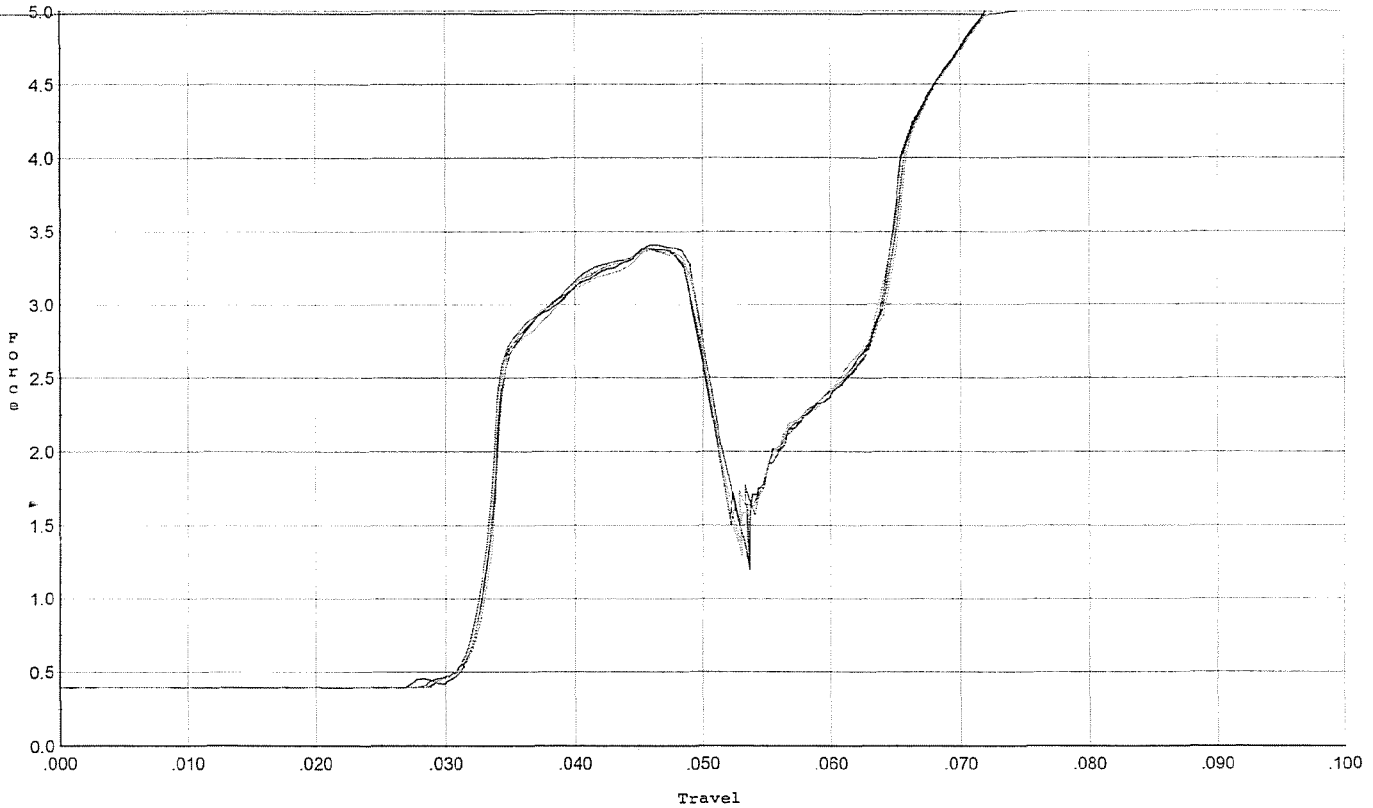
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.581	0.050	0.033	0.035	0.051		Set Trigger
2	2.537	0.049	0.033	0.035	0.048		Set Trigger
3	2.553	0.050	0.033	0.035	0.049		Set Trigger
4	2.554	0.051	0.033	0.035	0.050		Set Trigger
5	2.558	0.050	0.033	0.035	0.049		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/062008

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



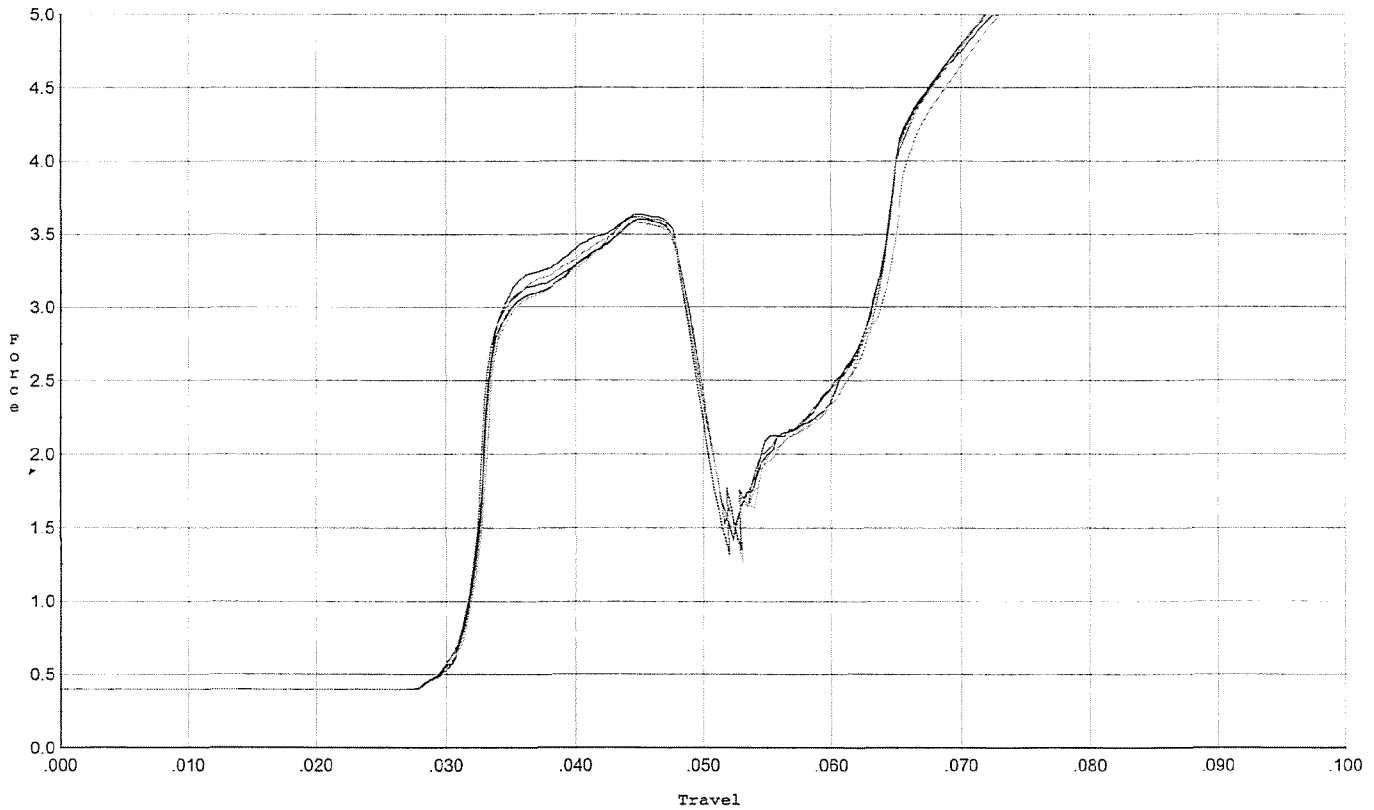
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.409	0.049	0.032	0.034	0.065		Set Trigger
2	3.374	0.050	0.032	0.033	0.066		Set Trigger
3	3.382	0.050	0.032	0.033	0.066		Set Trigger
4	3.372	0.049	0.032	0.034	0.065		Set Trigger
5	3.374	0.049	0.032	0.034	0.065		Set Trigger

A 3-38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/062008

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



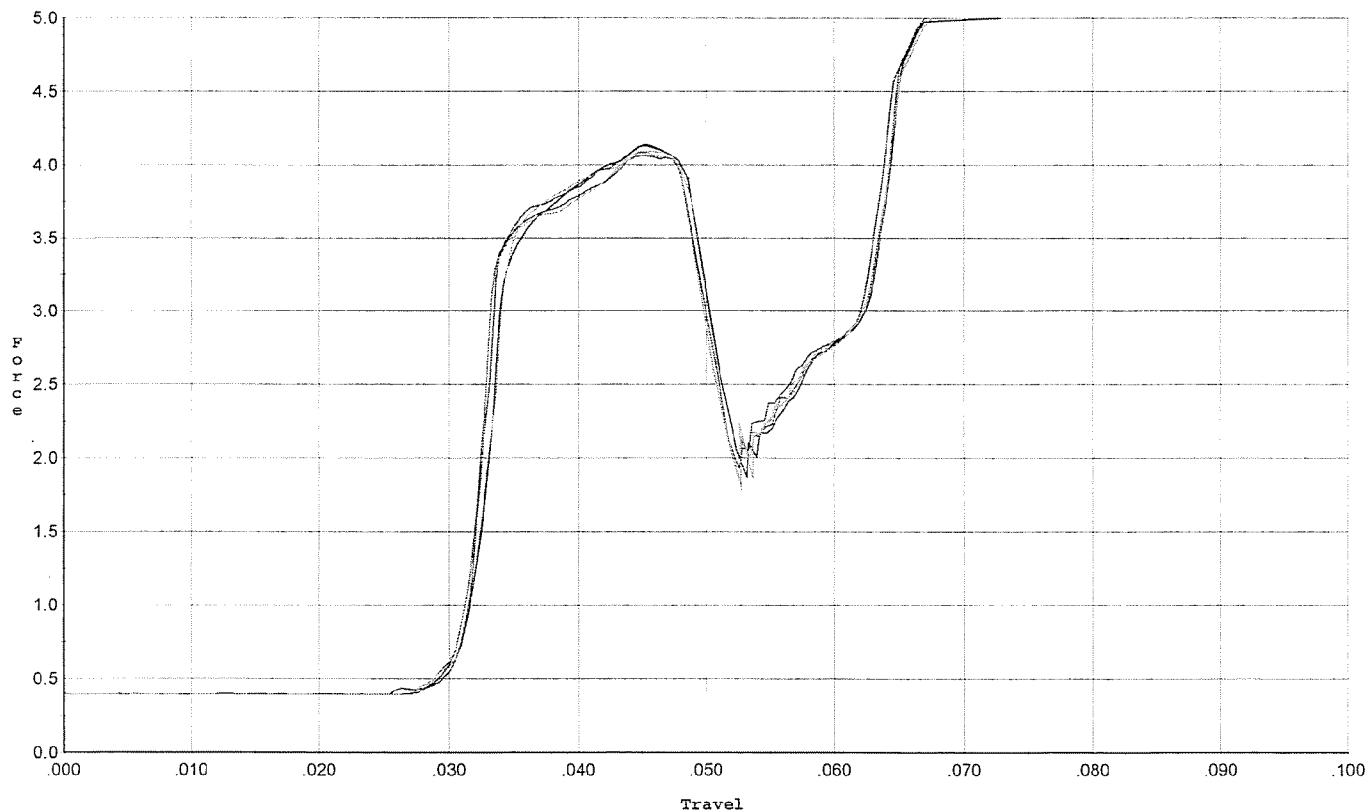
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.635	0.049	0.031	0.033	0.070		Set Trigger
2	3.604	0.048	0.031	0.033	0.066		Set Trigger
3	3.622	0.048	0.031	0.033	0.067		Set Trigger
4	3.585	0.048	0.030	0.033	0.066		Set Trigger
5	3.585	0.049	0.030	0.033	0.069		Set Trigger

A-3.60

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



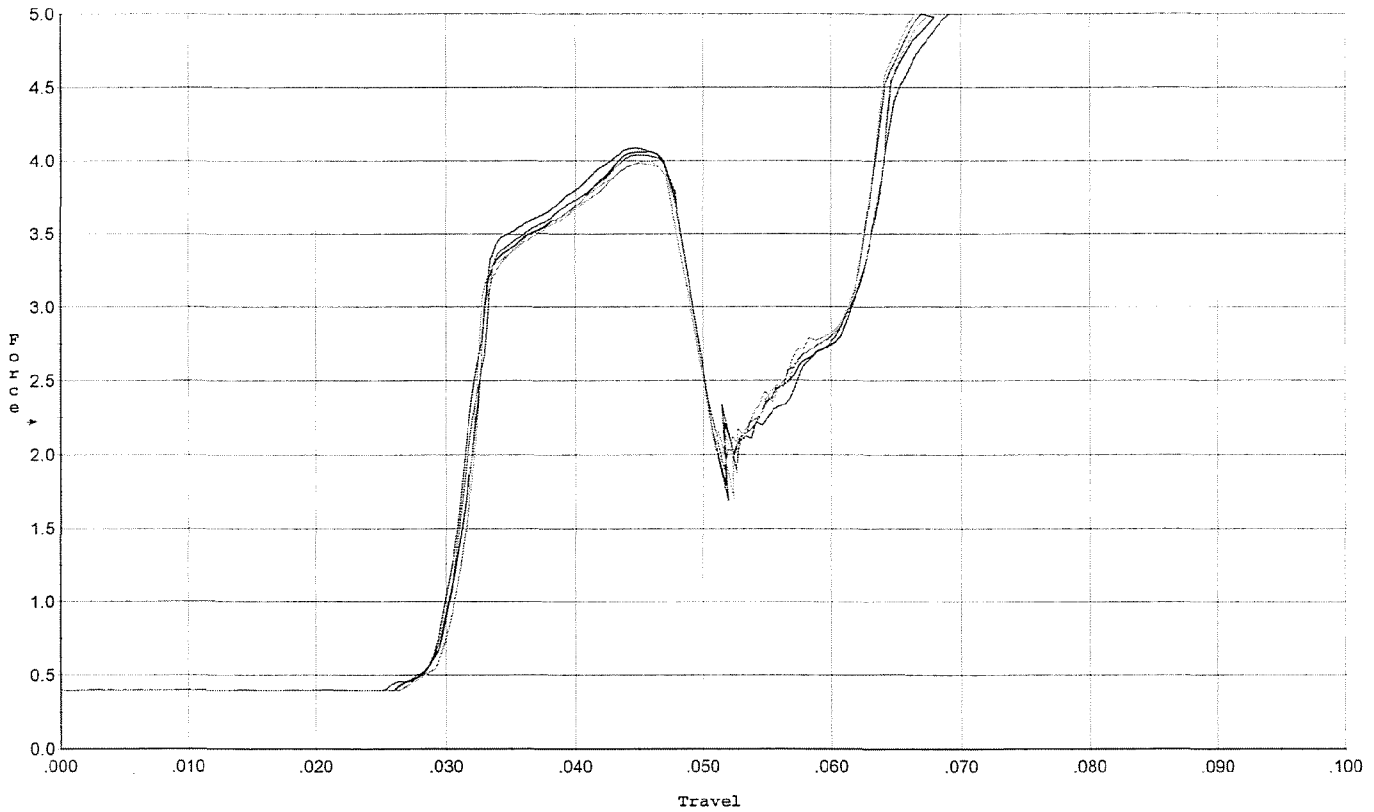
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.048	0.031	0.031	0.076		Set Trigger
2	4.140	0.049	0.031	0.031	0.077		Set Trigger
3	4.064	0.048	0.030	0.031	0.076		Set Trigger
4	4.093	0.048	0.030	0.032	0.076		Set Trigger
5	4.082	0.049	0.031	0.031	0.077		Set Trigger

A-4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/062008

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



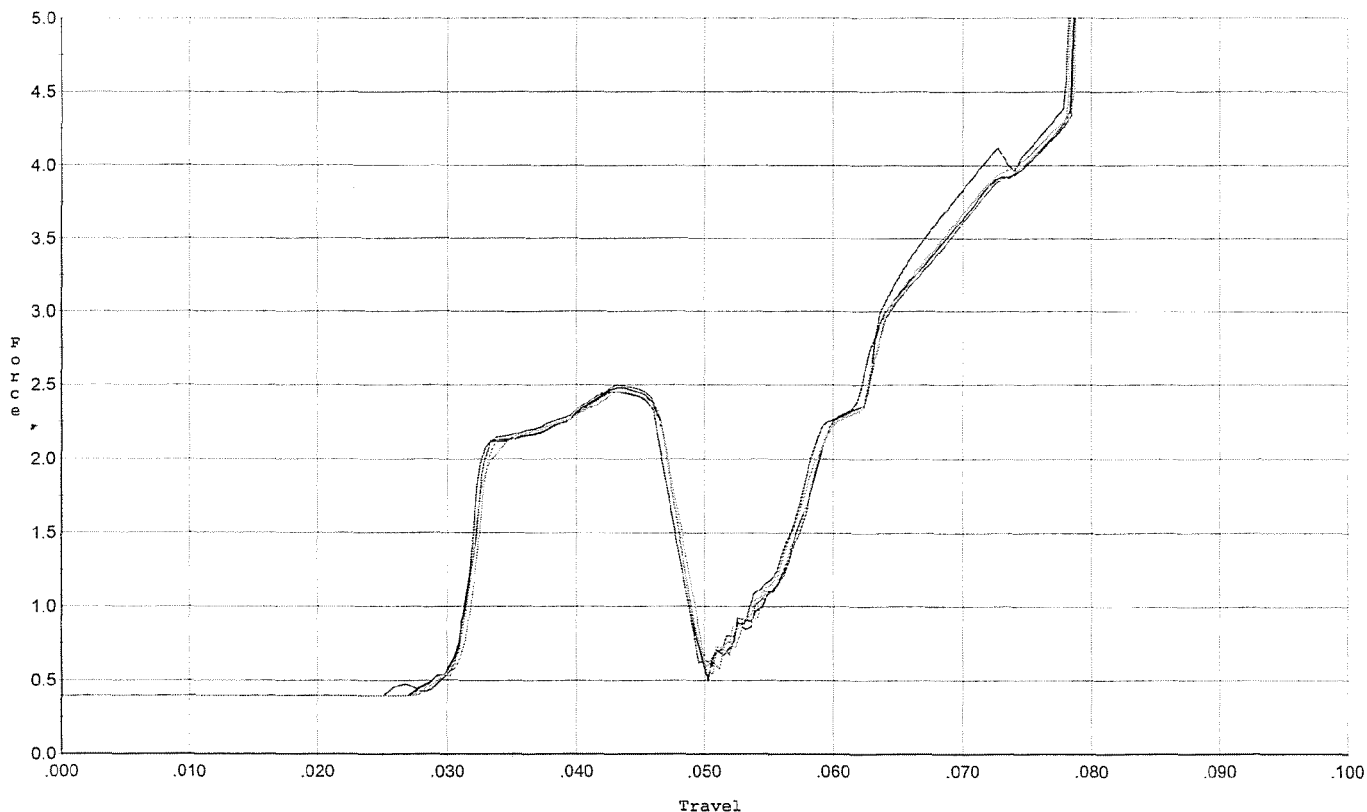
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.091	0.048	0.029	0.031	0.077		Set Trigger
2	4.062	0.048	0.029	0.032	0.075		Set Trigger
3	4.040	0.048	0.029	0.032	0.076		Set Trigger
4	3.983	0.048	0.030	0.032	0.075		Set Trigger
5	3.998	0.049	0.030	0.031	0.076		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/062008

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



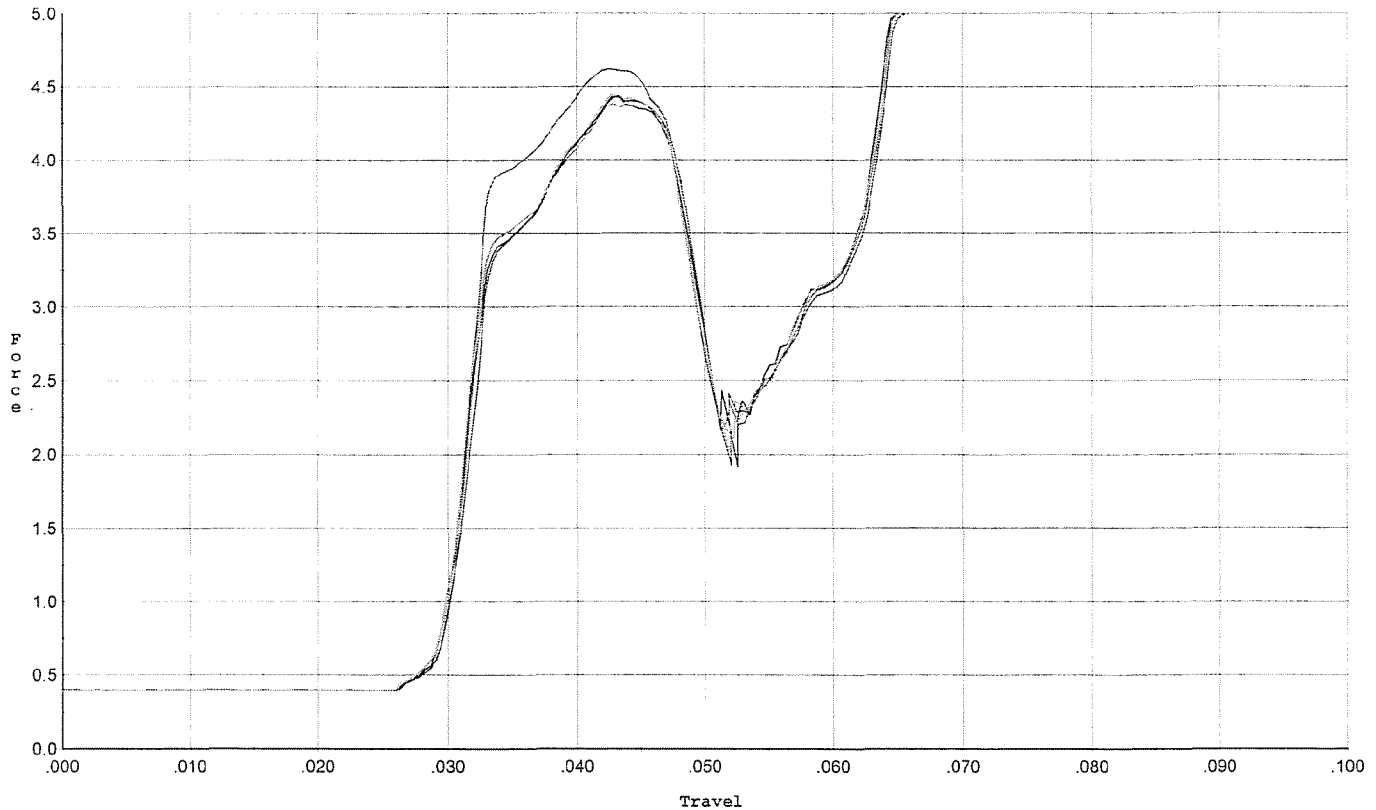
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.455	0.046	0.031	0.035	0.047		Set Trigger
2	2.482	0.047	0.030	0.035	0.048		Set Trigger
3	2.501	0.047	0.031	0.035	0.048		Set Trigger
4	2.453	0.047	0.031	0.035	0.047		Set Trigger
5	2.458	0.048	0.031	0.035	0.049		Set Trigger

A-2-47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/062008

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	4.439	0.047	0.029	0.030	0.079		Set Trigger
2	4.431	0.049	0.029	0.029	0.083		Set Trigger
3	4.618	0.048	0.029	0.029	0.086		Set Trigger
4	4.448	0.047	0.029	0.030	0.080		Set Trigger
5	4.394	0.047	0.029	0.030	0.079		Set Trigger

A-4.46