

GL794567

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



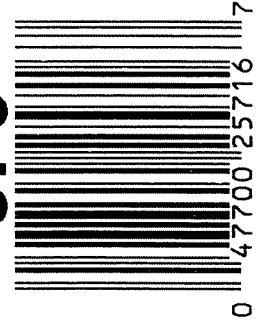
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794567

UPC



GUN SERIAL # G 6794567

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	10-8-08	Rsn
475	DRILL AND TAP SIGHT HOLES	2000	10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/11/08	
490	MAGNAFLUX BOLT		10/7/08	AR
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC		10/14/08	DS
542	APPLY COATINGS (BARREL ACTION)		10/15	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-15-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-15-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-15-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	Rsn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

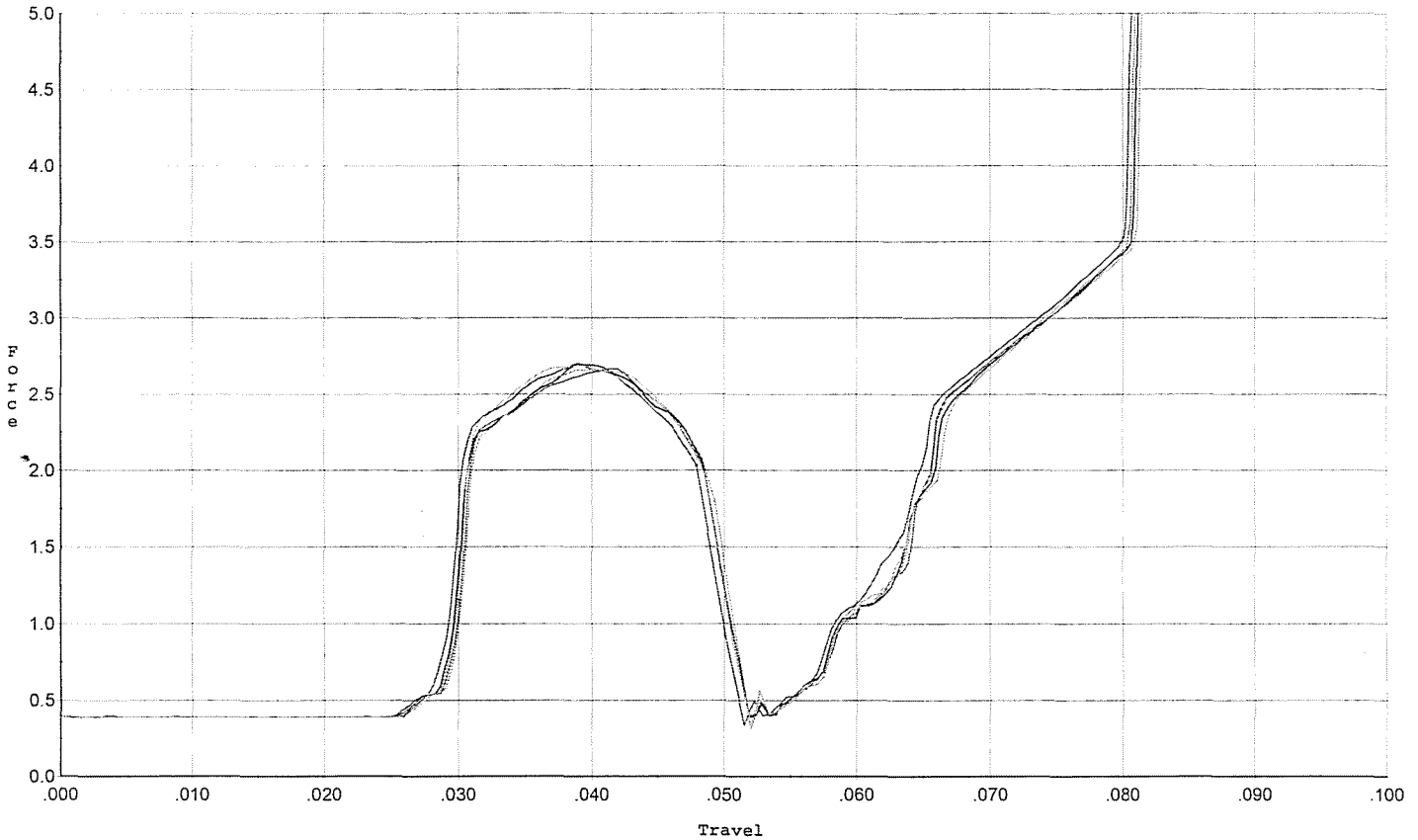
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2.5</u>	<u>3.0</u>	<u>3.5</u>	12-2-08	LN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u>	<u>4.5</u>	<u>4.5</u>	12-2-08	LN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	12-2-08	LN		
	J) ASSEMBLE STOCK					11-12-08	RSN		
	K) ASSEMBLE SWIVEL STUDS					12-2-08	LN		
	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		11-13-08	TL		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					11-13-08	JS		
670	FINAL INSPECTION A) HEADSPACE					12-2-08	LN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u>	<u>2.17</u>	<u>2.13</u>	<u>2.13</u>	<u>2.13</u>	11-20-08	TL
	C) FUNCTION					12-2-08	LN		
690	PACK					12-2-08	TL		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



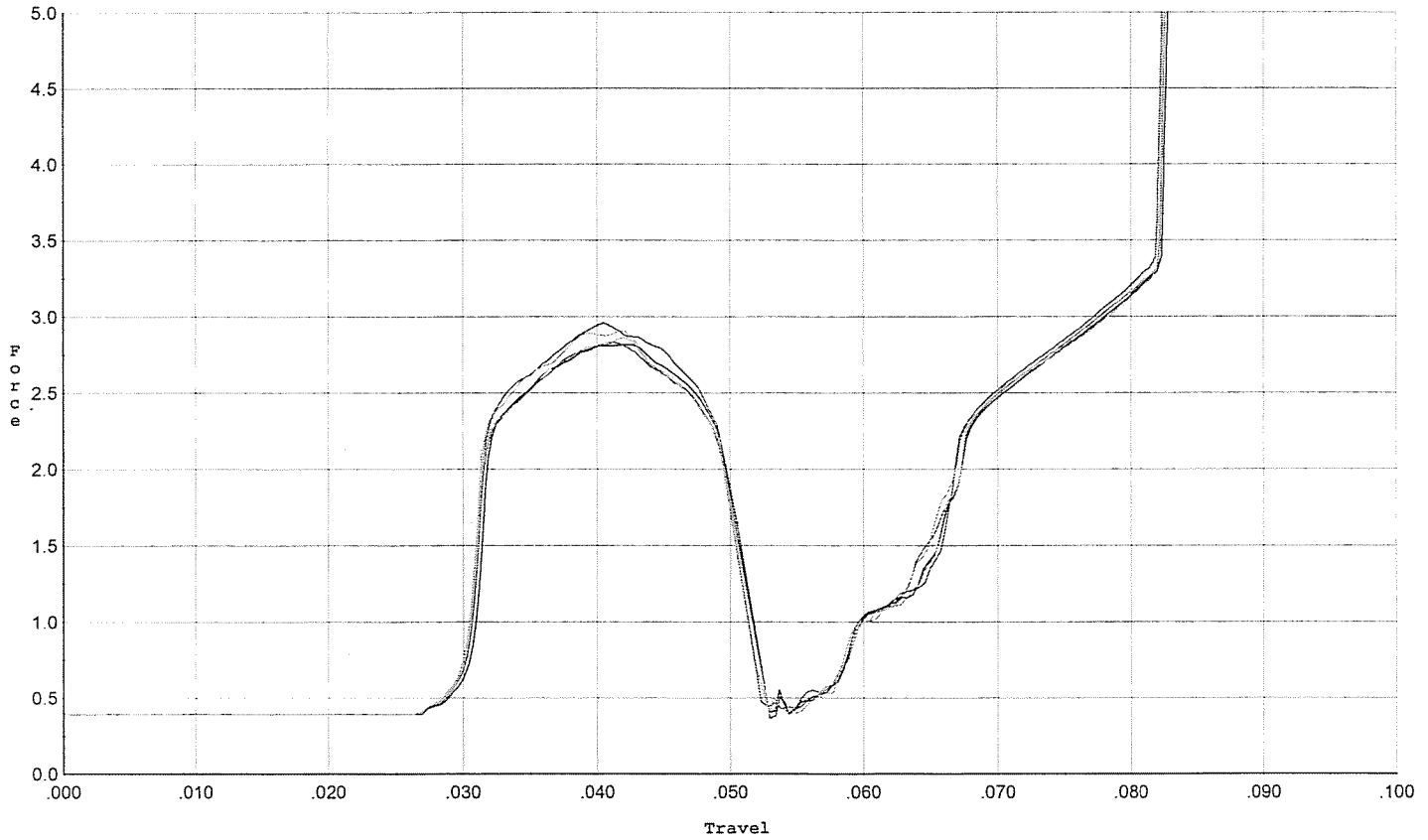
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.702	0.048	0.028	0.036	0.057		Set Trigger
2	2.699	0.048	0.029	0.036	0.058		Set Trigger
3	2.667	0.048	0.029	0.035	0.057		Set Trigger
4	2.688	0.048	0.029	0.035	0.058		Set Trigger
5	2.662	0.049	0.029	0.035	0.058		Set Trigger

A-2.68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



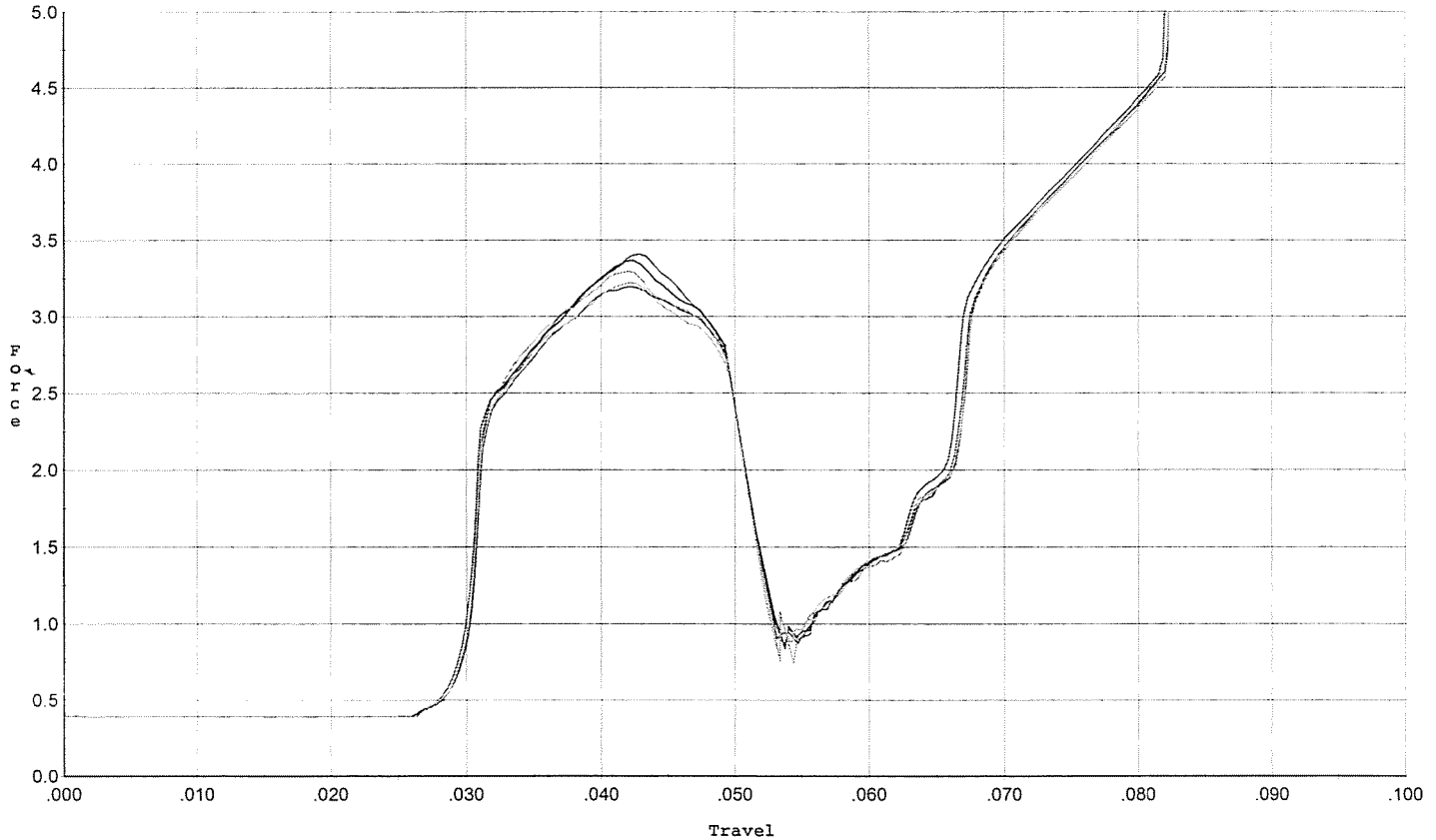
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.961	0.050	0.030	0.035	0.064		Set Trigger
2	2.815	0.051	0.030	0.036	0.062		Set Trigger
3	2.834	0.049	0.030	0.036	0.060		Set Trigger
4	2.864	0.049	0.030	0.036	0.060		Set Trigger
5	2.907	0.049	0.030	0.036	0.061		Set Trigger

A 287

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



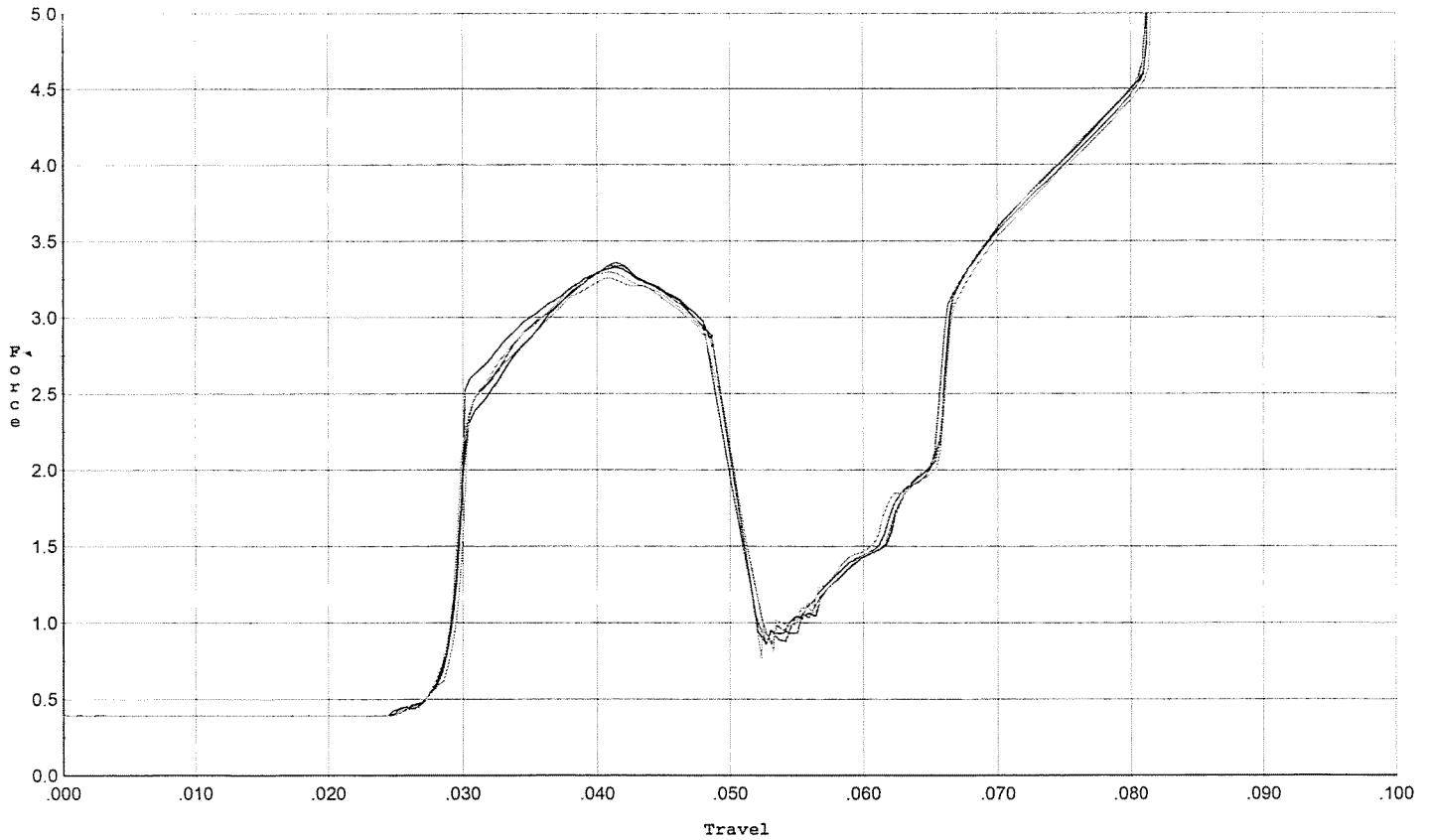
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.412	0.049	0.029	0.034	0.070		Set Trigger
2	3.369	0.049	0.029	0.034	0.069		Set Trigger
3	3.195	0.049	0.029	0.034	0.068		Set Trigger
4	3.221	0.049	0.029	0.034	0.068		Set Trigger
5	3.295	0.049	0.029	0.034	0.069		Set Trigger

A-3.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



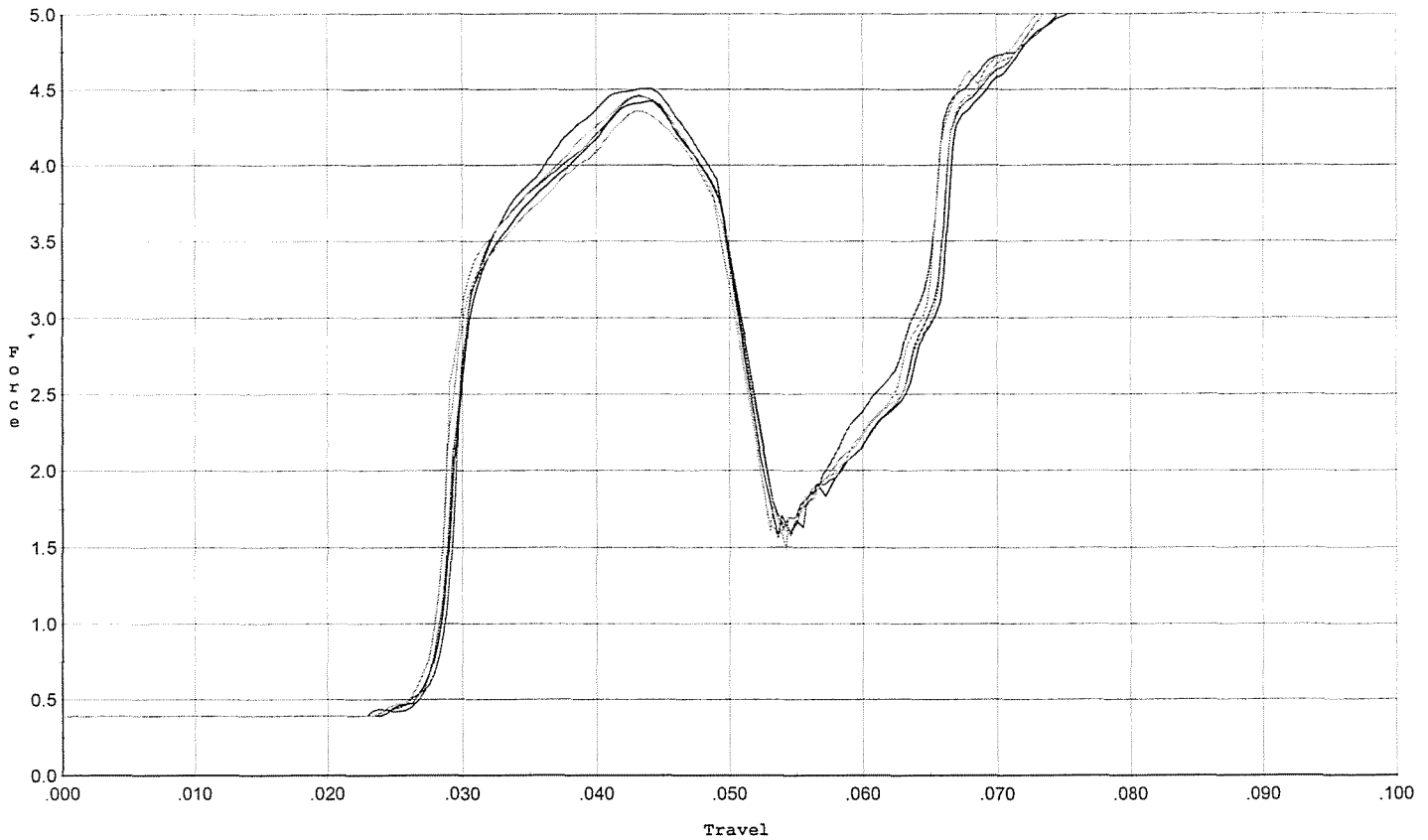
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.337	0.048	0.028	0.034	0.069		Set Trigger
2	3.327	0.049	0.028	0.034	0.070		Set Trigger
3	3.358	0.049	0.028	0.034	0.070		Set Trigger
4	3.295	0.049	0.029	0.034	0.070		Set Trigger
5	3.256	0.049	0.028	0.034	0.070		Set Trigger

173.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



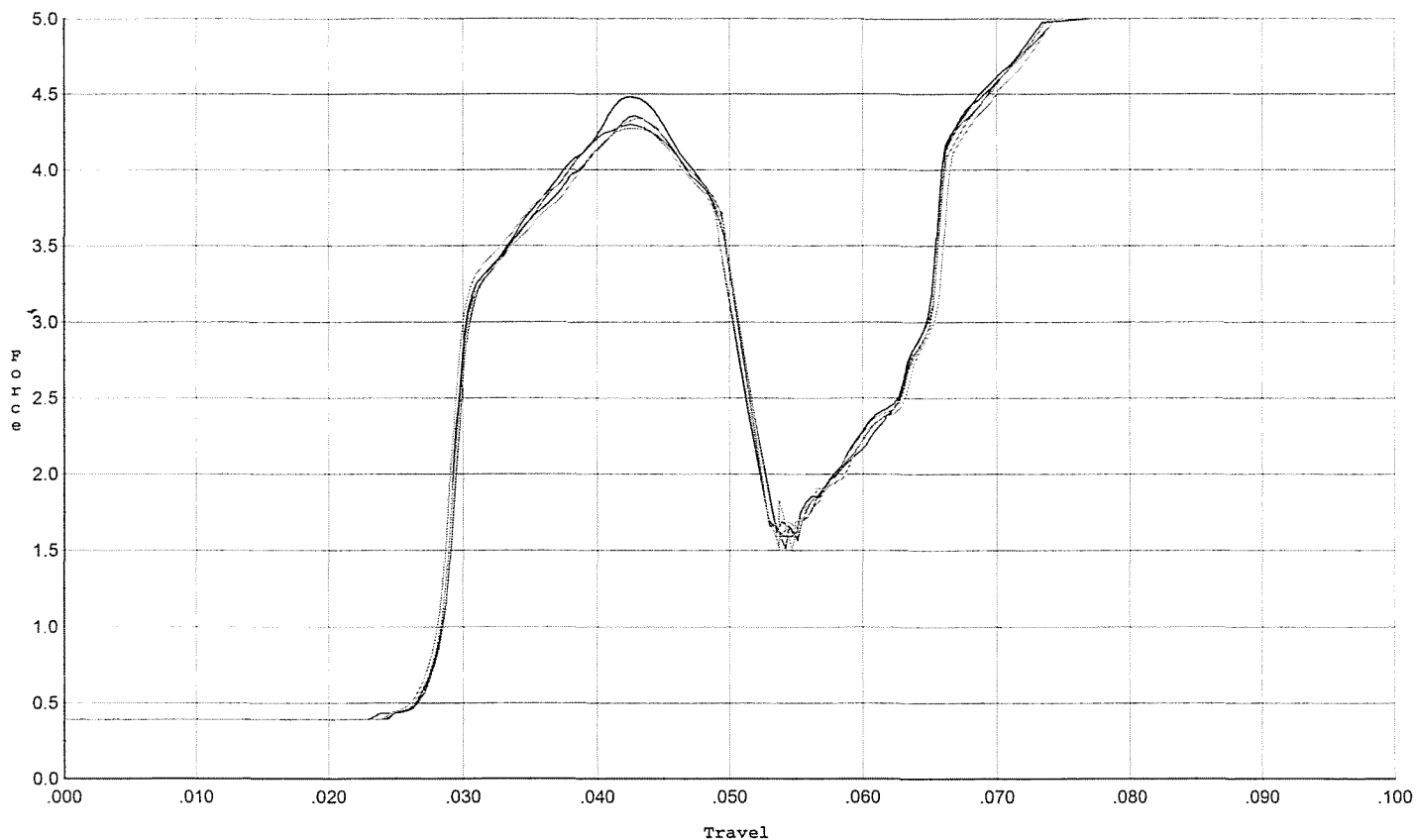
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.507	0.051	0.027	0.030	0.098		Set Trigger
2	4.421	0.049	0.027	0.031	0.092		Set Trigger
3	4.456	0.049	0.028	0.031	0.093		Set Trigger
4	4.463	0.050	0.027	0.031	0.095		Set Trigger
5	4.357	0.051	0.027	0.031	0.094		Set Trigger

A. 4.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



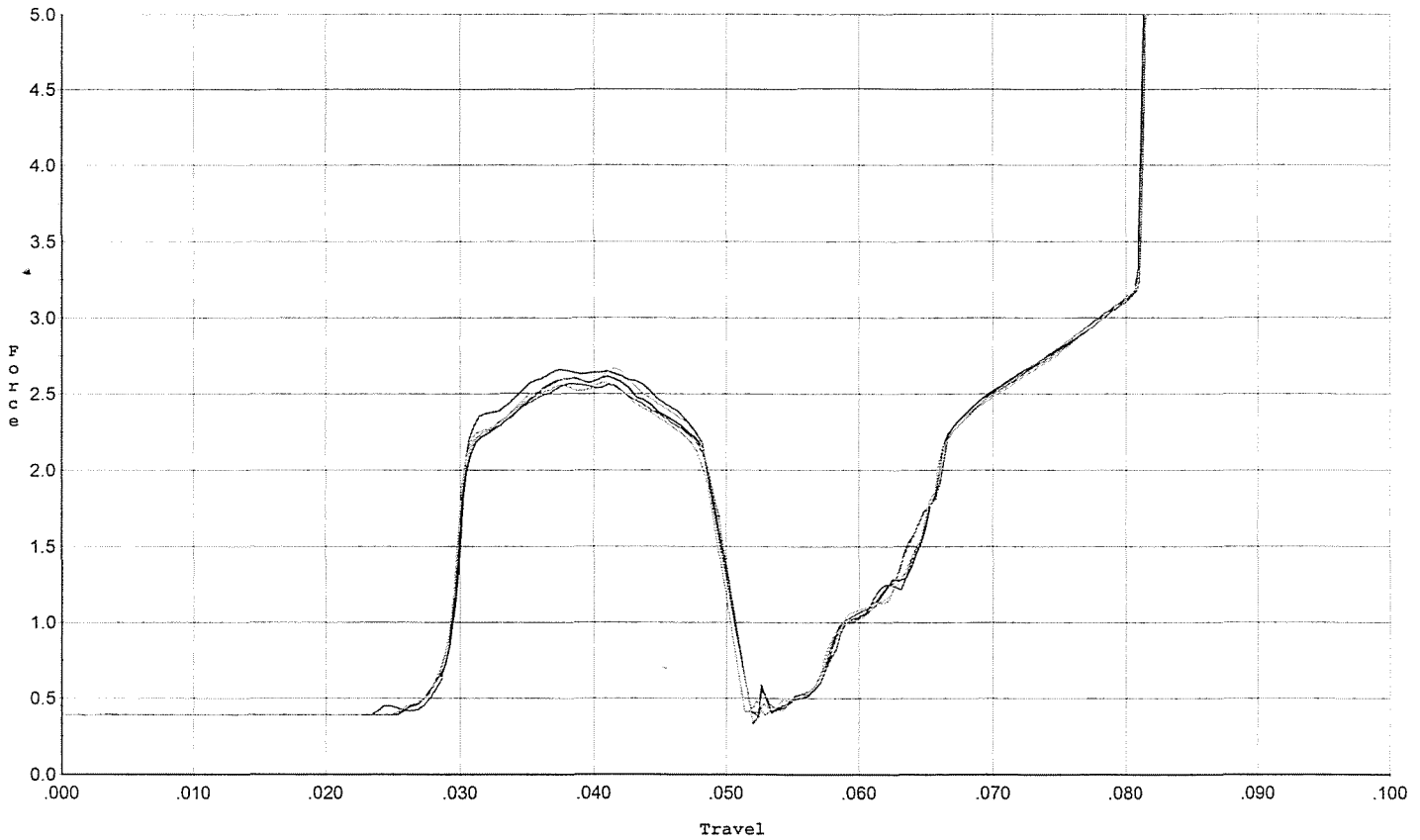
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.355	0.050	0.027	0.031	0.091		Set Trigger
2	4.478	0.049	0.027	0.031	0.090		Set Trigger
3	4.299	0.049	0.027	0.031	0.091		Set Trigger
4	4.340	0.049	0.027	0.031	0.091		Set Trigger
5	4.274	0.049	0.027	0.031	0.090		Set Trigger

A-4.34

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



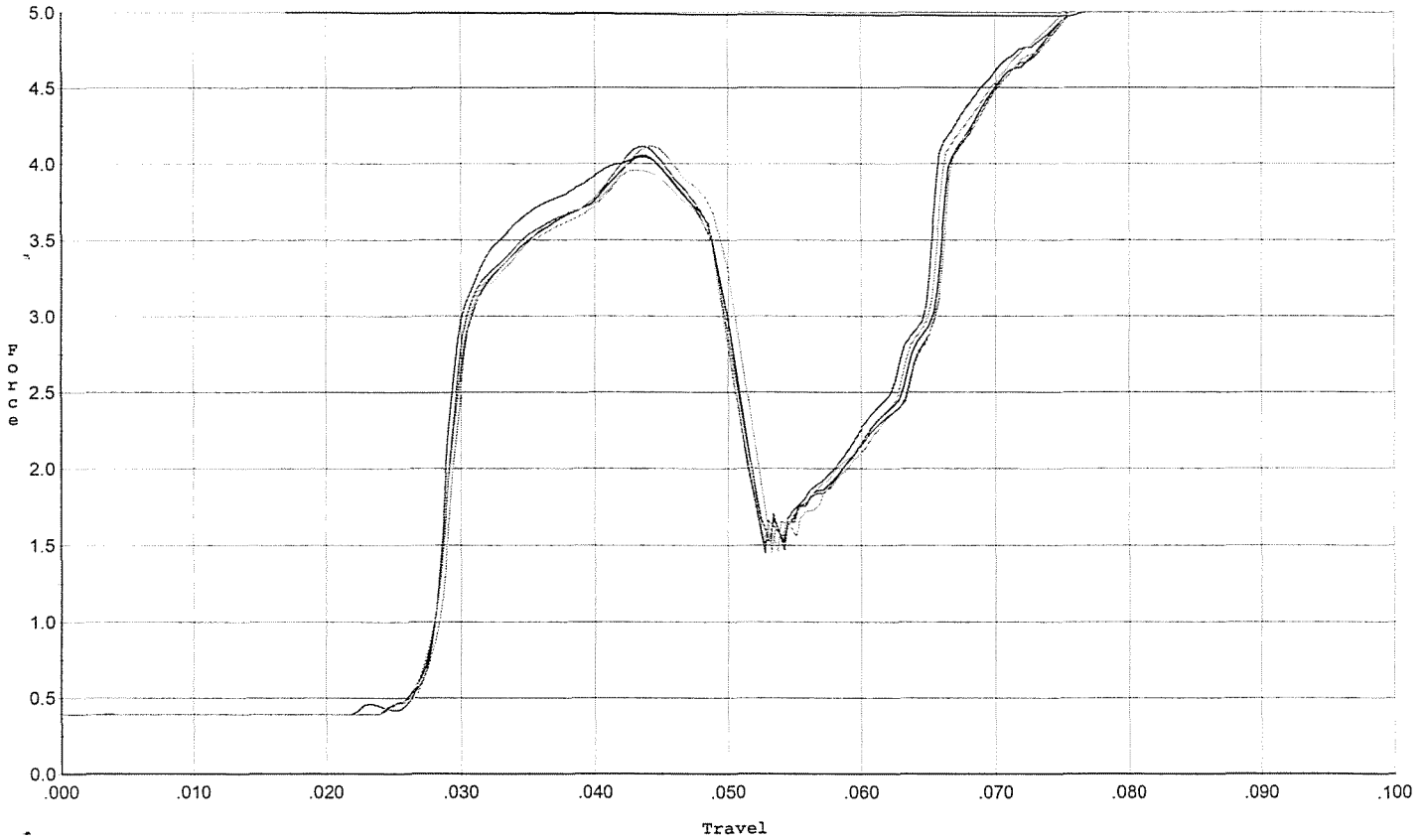
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.657	0.050	0.028	0.035	0.060		Set Trigger
2	2.615	0.049	0.029	0.035	0.059		Set Trigger
3	2.567	0.048	0.028	0.036	0.057		Set Trigger
4	2.669	0.050	0.028	0.035	0.060		Set Trigger
5	2.573	0.049	0.028	0.036	0.057		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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	4.055	0.049	0.027	0.031	0.086		Set Trigger
2	4.046	0.050	0.027	0.032	0.087		Set Trigger
3	4.112	0.049	0.027	0.032	0.085		Set Trigger
4	3.957	0.049	0.027	0.032	0.084		Set Trigger
5	4.115	0.050	0.027	0.031	0.088		Set Trigger

A-4.05