

56794571

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



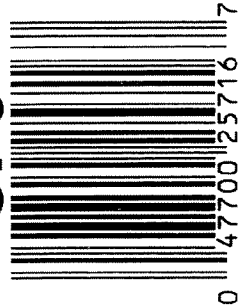
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794571

UPC



GUN SERIAL #

G 6794571

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	MAGNA - FLUX OCT 1 2008 OPERATOR 	10-1-08	REN
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10-8	
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		10-28-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

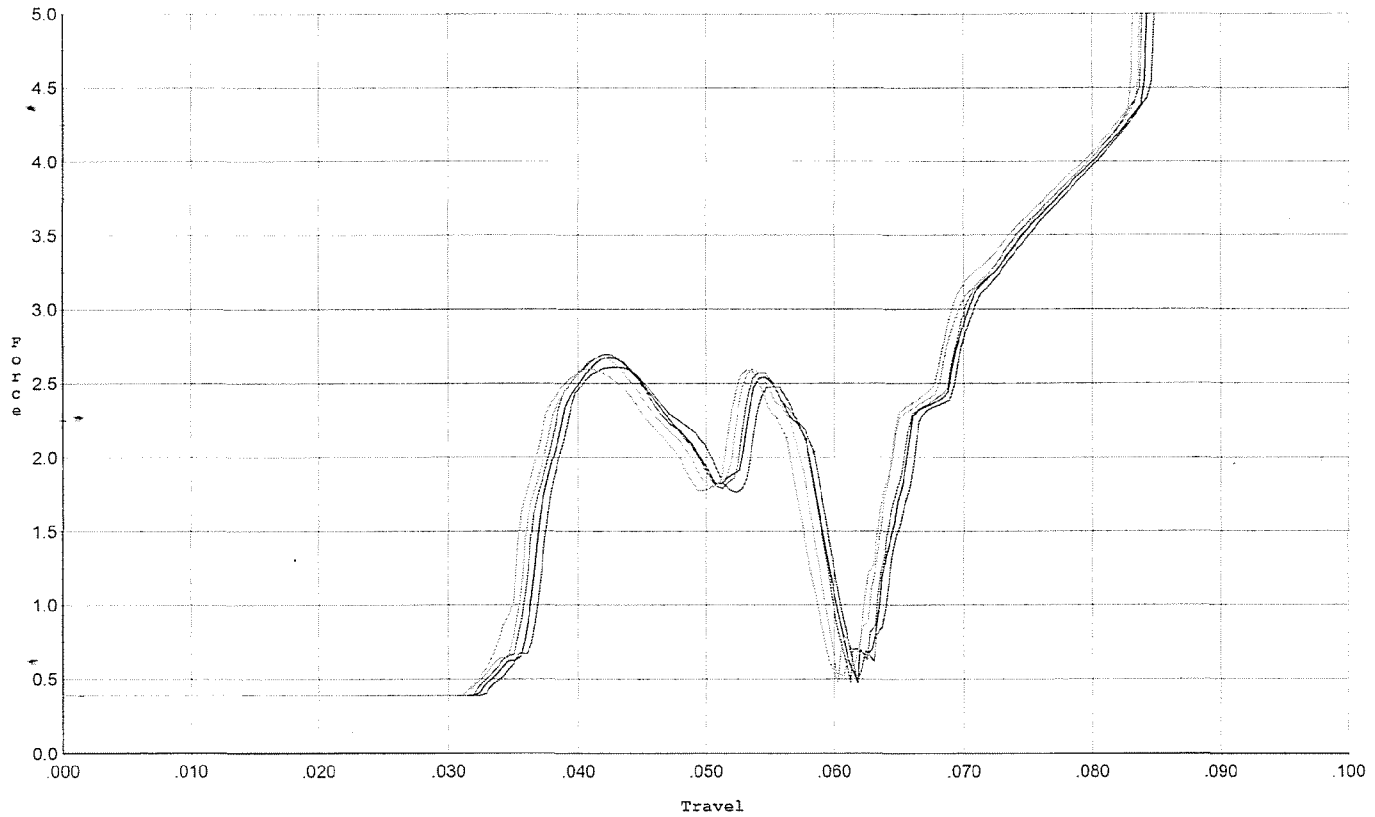
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>3°</u> <u>3°</u>	11-13-08	RN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5.0</u> <u>5°</u>	11-13-08	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-13-08	RN
	J) ASSEMBLE STOCK		10-28-08	RSW
	K) ASSEMBLE SWIVEL STUDS		11-13-08	RN
	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	11-12-08 10-30-08	TC Rm
	MALFUNCTION BAC	CORRECTION <u>BAC</u> ^{POA}	11-12-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-13-08	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.25</u> <u>2.22</u> <u>2.24</u> <u>2.25</u>	11-3-08	TC
	C) FUNCTION		11-13-08	RN
690	PACK		11/13/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



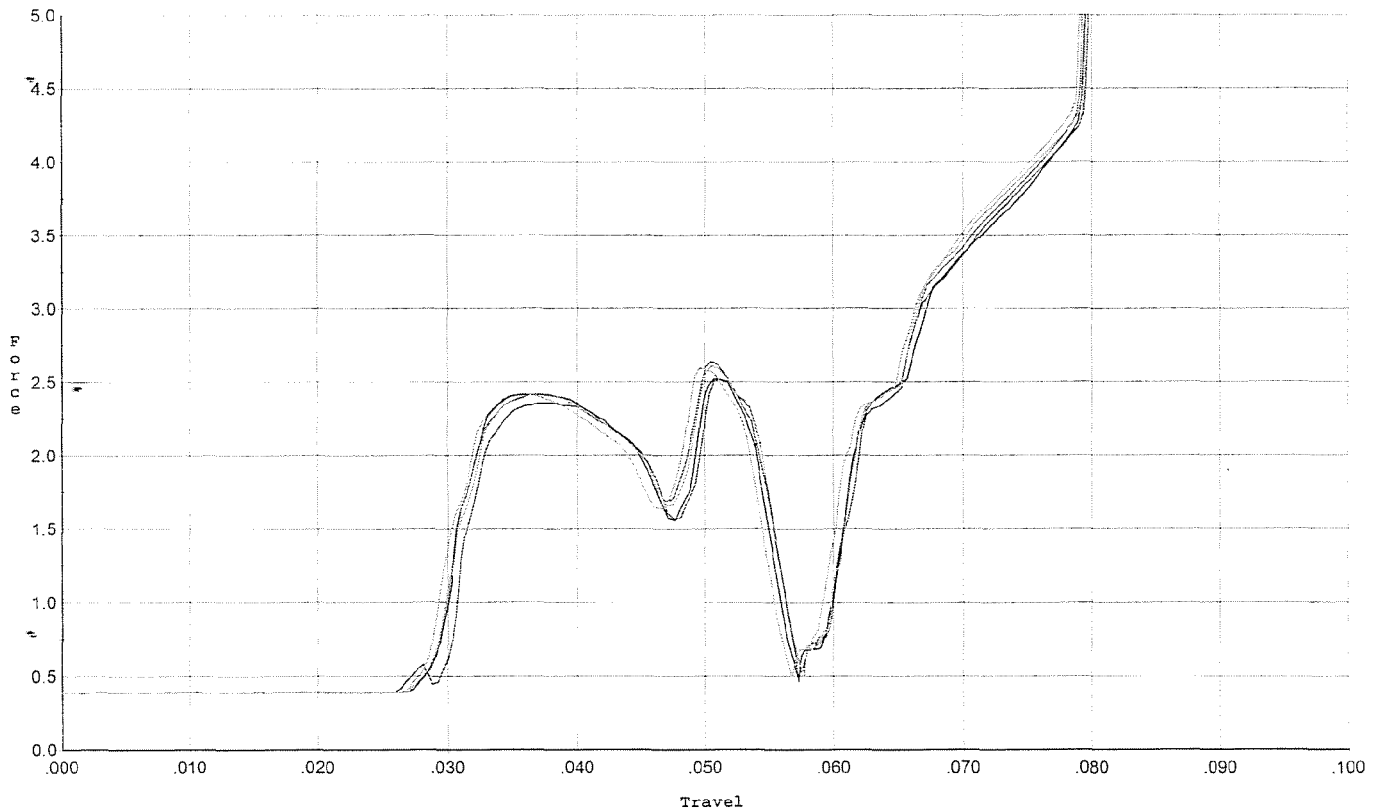
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.058	0.035	0.032	0.064		Set Trigger
2	2.677	0.058	0.036	0.032	0.064		Set Trigger
3	2.695	0.058	0.035	0.032	0.065		Set Trigger
4	2.680	0.058	0.035	0.032	0.065		Set Trigger
5	2.597	0.056	0.033	0.033	0.063		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



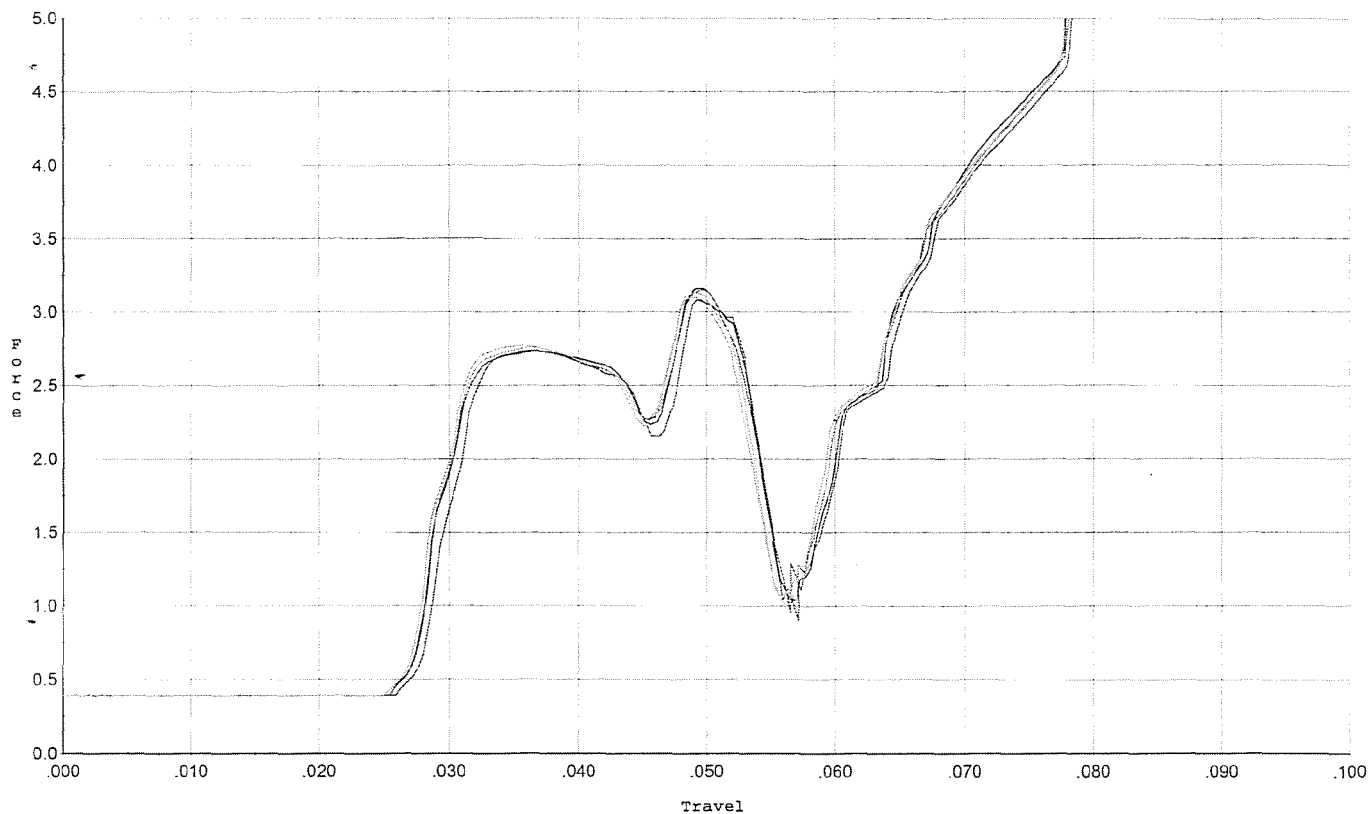
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.055	0.030	0.031	0.063		Set Trigger
2	2.522	0.054	0.028	0.031	0.063		Set Trigger
3	2.641	0.054	0.029	0.030	0.066		Set Trigger
4	2.612	0.054	0.029	0.030	0.065		Set Trigger
5	2.596	0.053	0.029	0.030	0.063		Set Trigger

A-2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



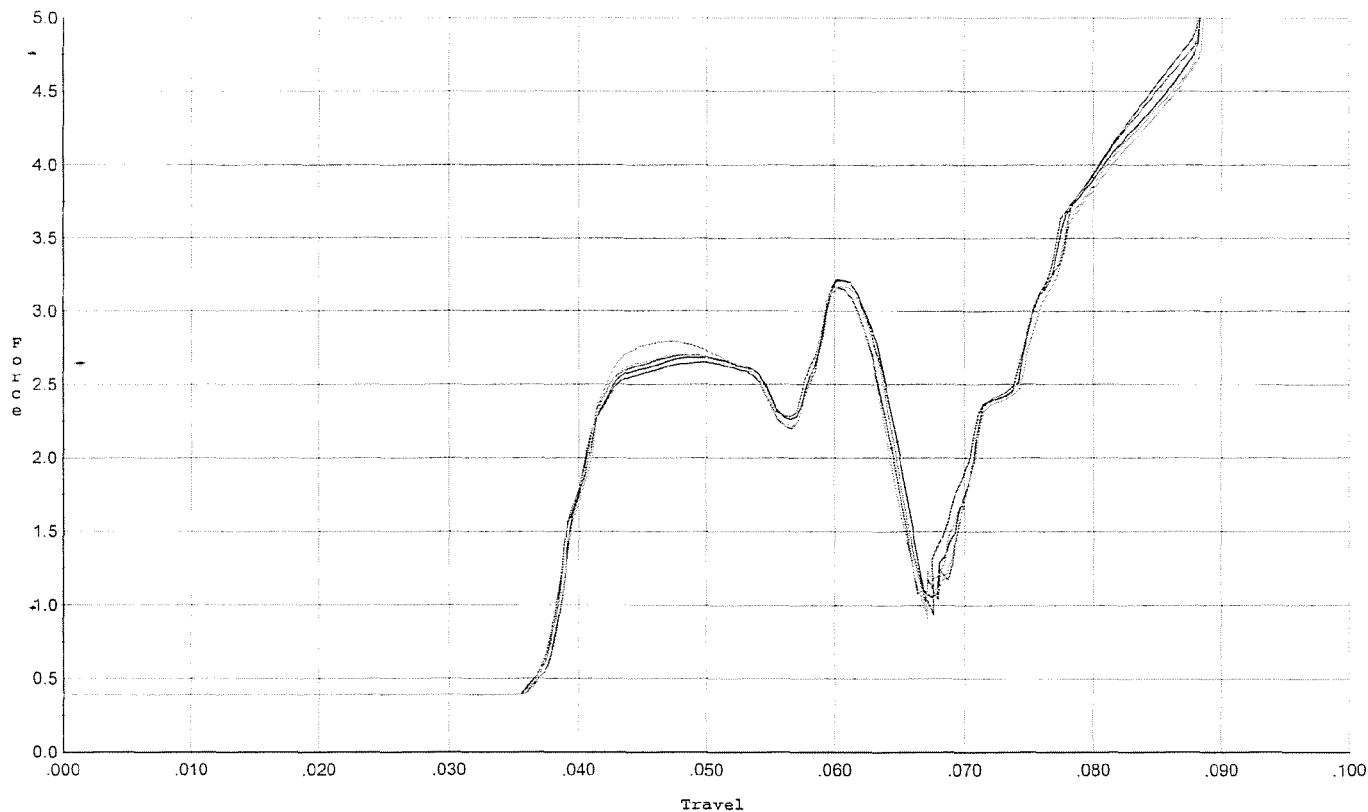
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.083	0.053	0.028	0.029	0.074		Set Trigger
2	3.161	0.053	0.026	0.029	0.076		Set Trigger
3	3.155	0.053	0.027	0.029	0.076		Set Trigger
4	3.128	0.053	0.027	0.029	0.075		Set Trigger
5	3.101	0.053	0.027	0.029	0.076		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



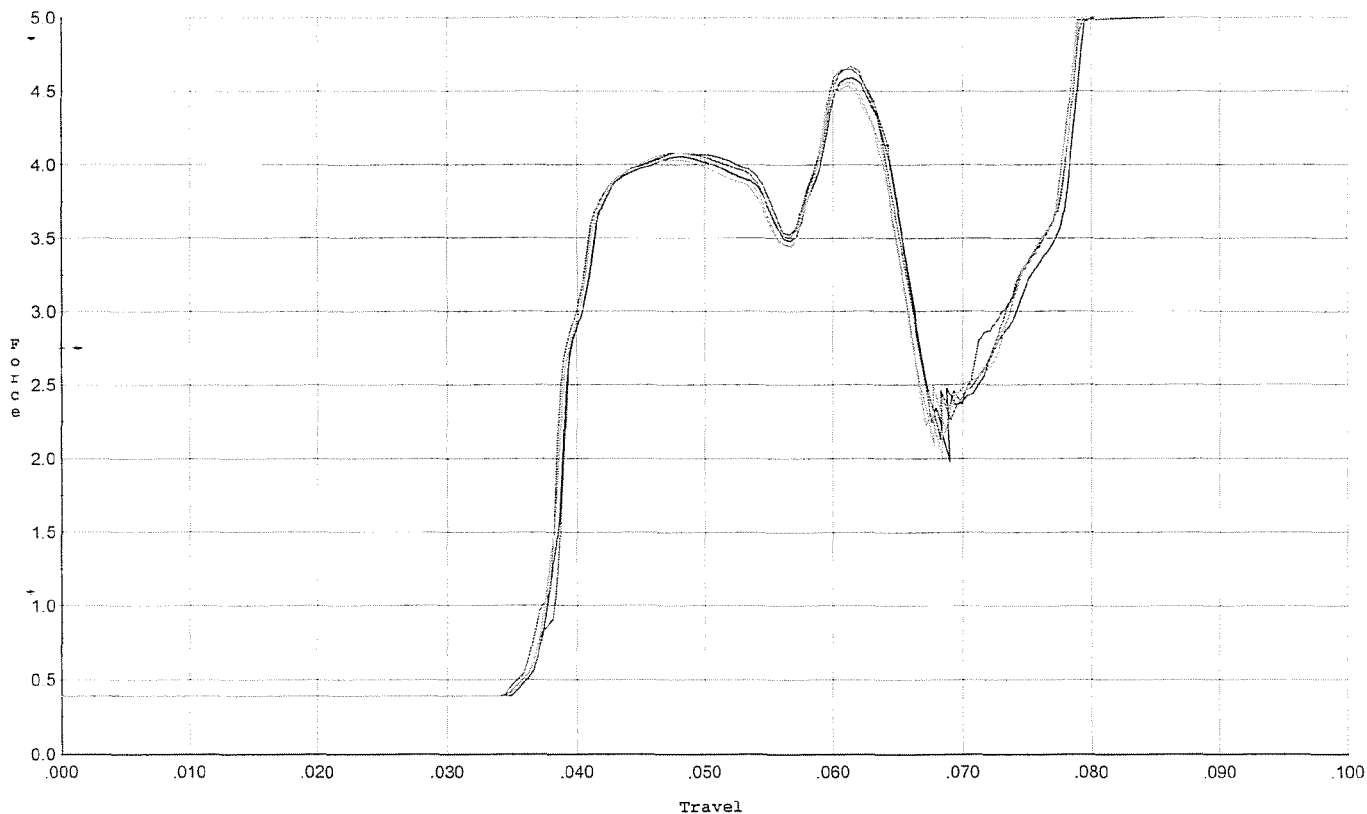
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.163	0.064	0.037	0.030	0.080		Set Trigger
2	3.209	0.065	0.036	0.029	0.082		Set Trigger
3	3.220	0.063	0.037	0.030	0.081		Set Trigger
4	3.172	0.064	0.038	0.030	0.080		Set Trigger
5	3.152	0.063	0.036	0.030	0.079		Set Trigger

A 3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



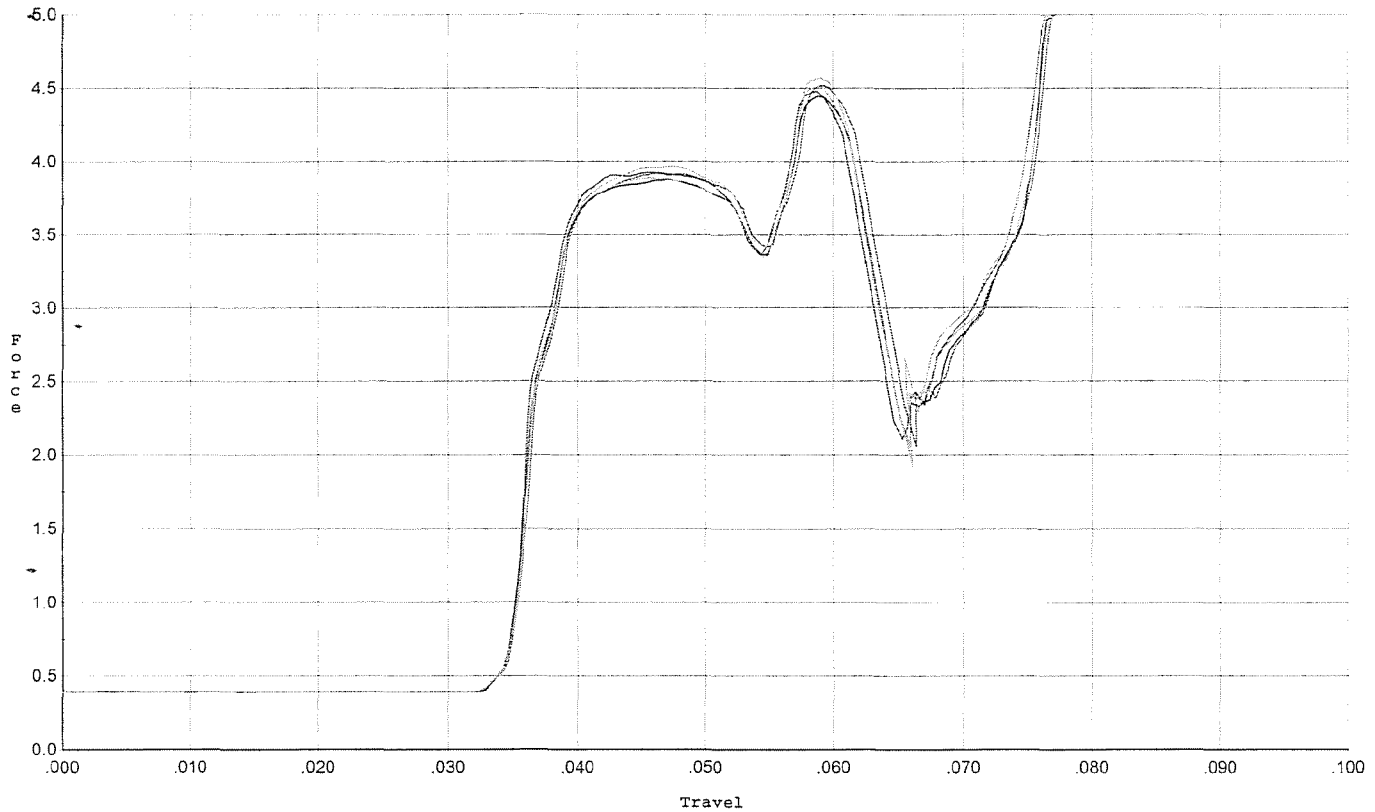
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.650	0.064	0.037	0.026	0.119		Set Trigger
2	4.590	0.064	0.037	0.027	0.118		Set Trigger
3	4.669	0.065	0.036	0.026	0.122		Set Trigger
4	4.536	0.064	0.037	0.027	0.117		Set Trigger
5	4.562	0.064	0.037	0.027	0.117		Set Trigger

A-4.60

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



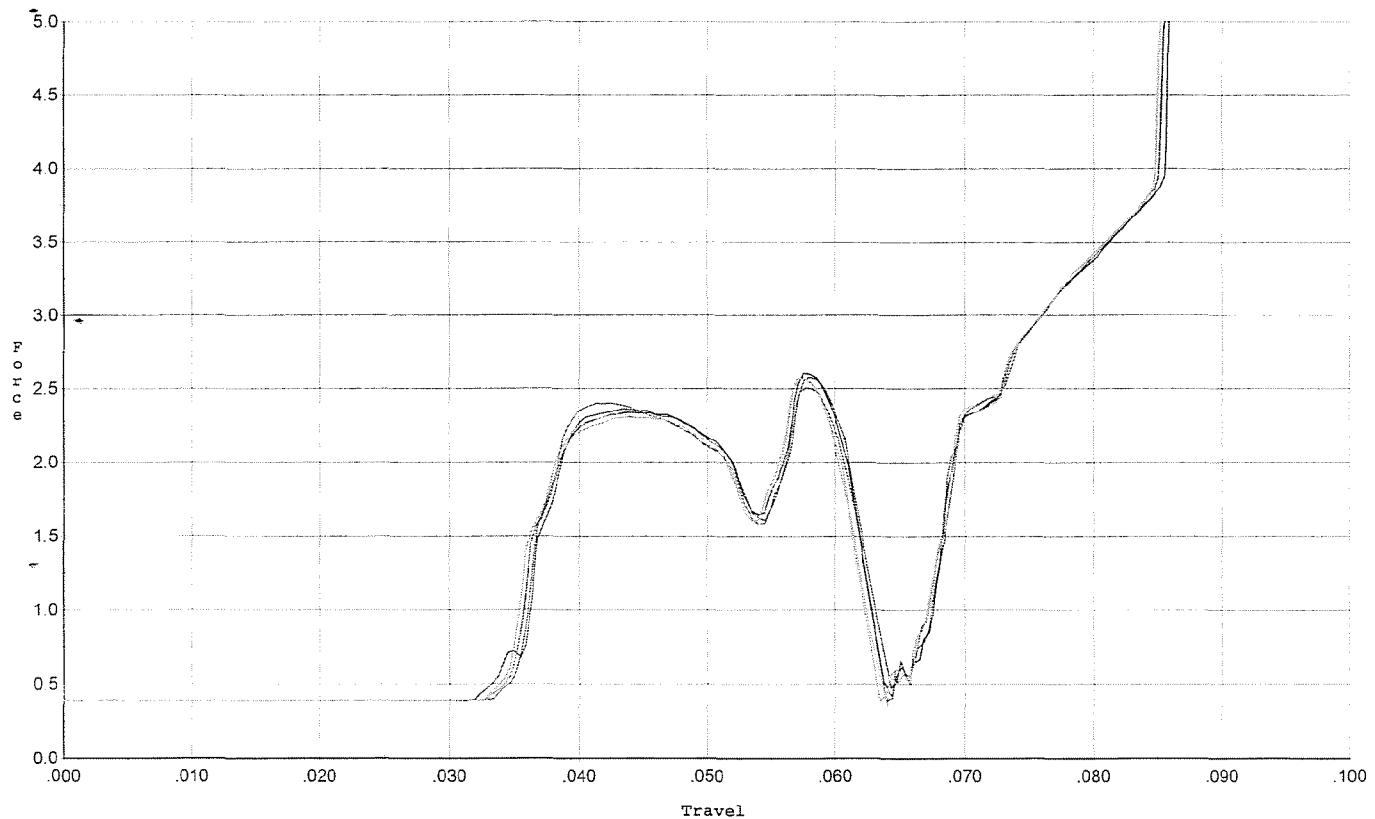
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.481	0.062	0.035	0.027	0.115		Set Trigger
2	4.449	0.063	0.035	0.027	0.116		Set Trigger
3	4.520	0.064	0.035	0.026	0.118		Set Trigger
4	4.572	0.063	0.035	0.027	0.117		Set Trigger
5	4.511	0.061	0.035	0.027	0.112		Set Trigger

A-4.50

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



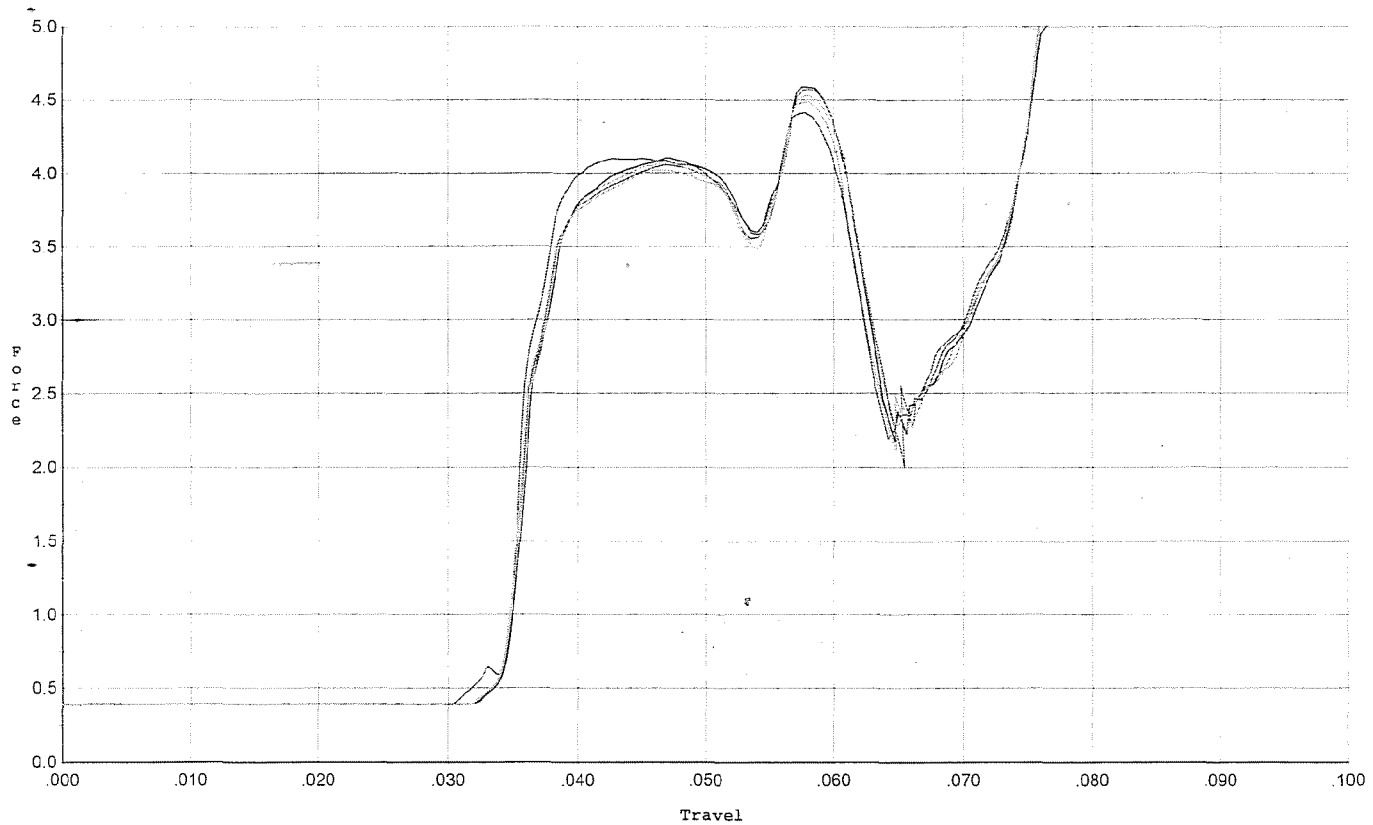
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.578	0.061	0.034	0.030	0.068		Set Trigger
2	2.604	0.061	0.035	0.031	0.069		Set Trigger
3	2.505	0.061	0.035	0.031	0.068		Set Trigger
4	2.572	0.060	0.035	0.031	0.067		Set Trigger
5	2.572	0.061	0.035	0.031	0.068		Set Trigger

A-2.56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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	4.415	0.061	0.033	0.026	0.115		Set Trigger
2	4.590	0.061	0.034	0.027	0.115		Set Trigger
3	4.572	0.061	0.034	0.026	0.114		Set Trigger
4	4.528	0.061	0.034	0.026	0.114		Set Trigger
5	4.488	0.060	0.034	0.027	0.112		Set Trigger

A-4.51