

66794578

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



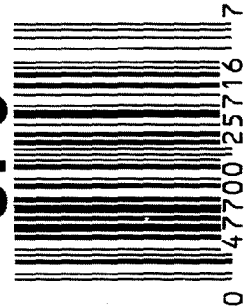
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794578

UPC



GUN SERIAL #

G 6794578

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SP
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SP
460	CHECK HEADSPACE		11-3-08	SP
470	DIS-ASSEMBLE ACTION		11-3-08	SP
472	SERIALIZE BOLT HANDLE		11-4-08	RT
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION		11/6/08	SP
490	MAGNAFLUX BOLT		11/3/08	SP
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/6/08	DS
542	APPLY COATINGS (BARREL ACTION)		11/5	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-18-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

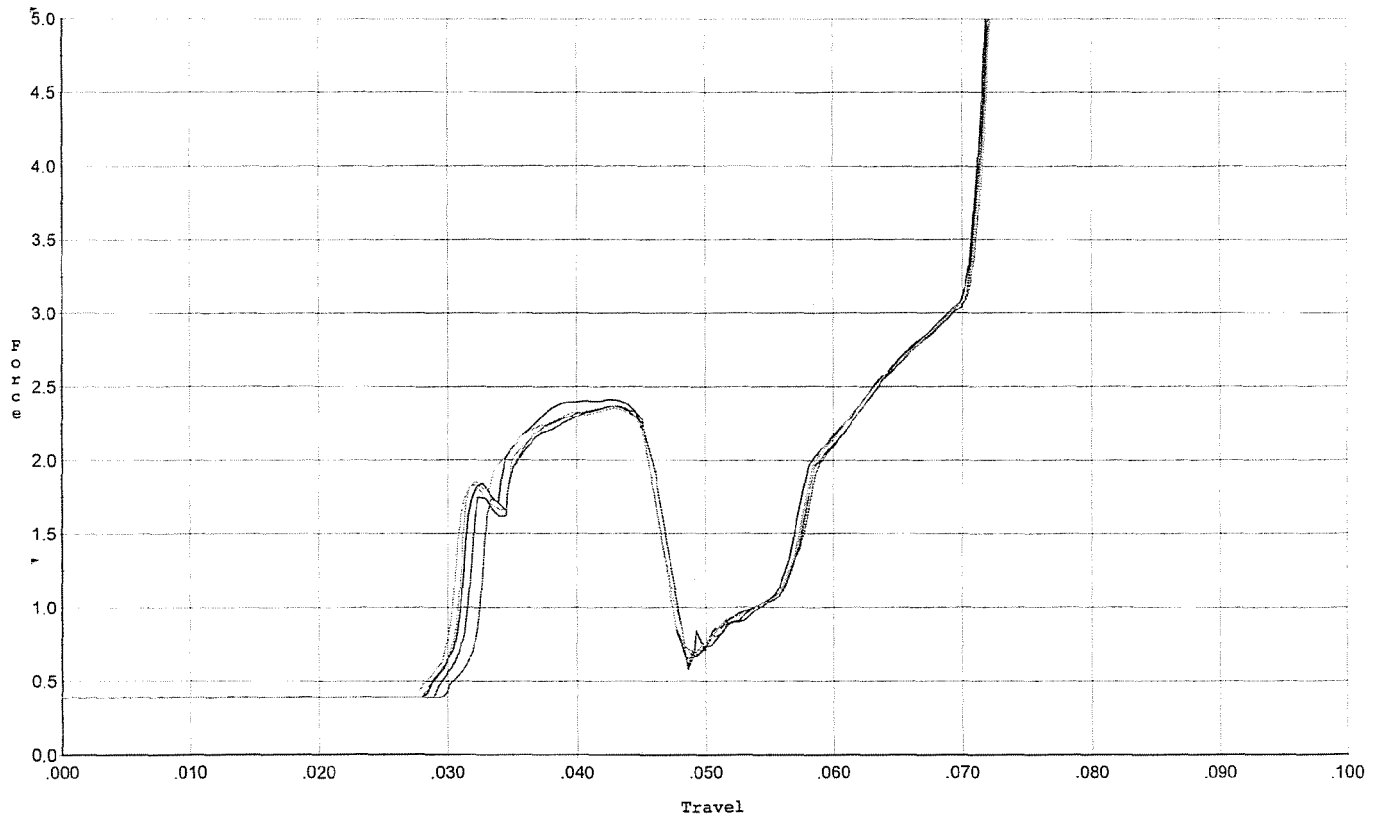
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	12-2-08	R.A.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>5.0</u> <u>5.0</u>	12-2-08	R.A.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-2-08	R.A.
	J) ASSEMBLE STOCK		11-18-08	R.A.
	K) ASSEMBLE SWIVEL STUDS		12-2-08	R.A.
	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	11-19-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	R.A.
670	FINAL INSPECTION A) HEADSPACE		12-2-08	R.A.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.73</u> <u>2.80</u> <u>2.77</u> <u>2.76</u> <u>2.70</u>	11-26-08	TC
	C) FUNCTION		12-2-08	R.A.
690	PACK		12-3-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



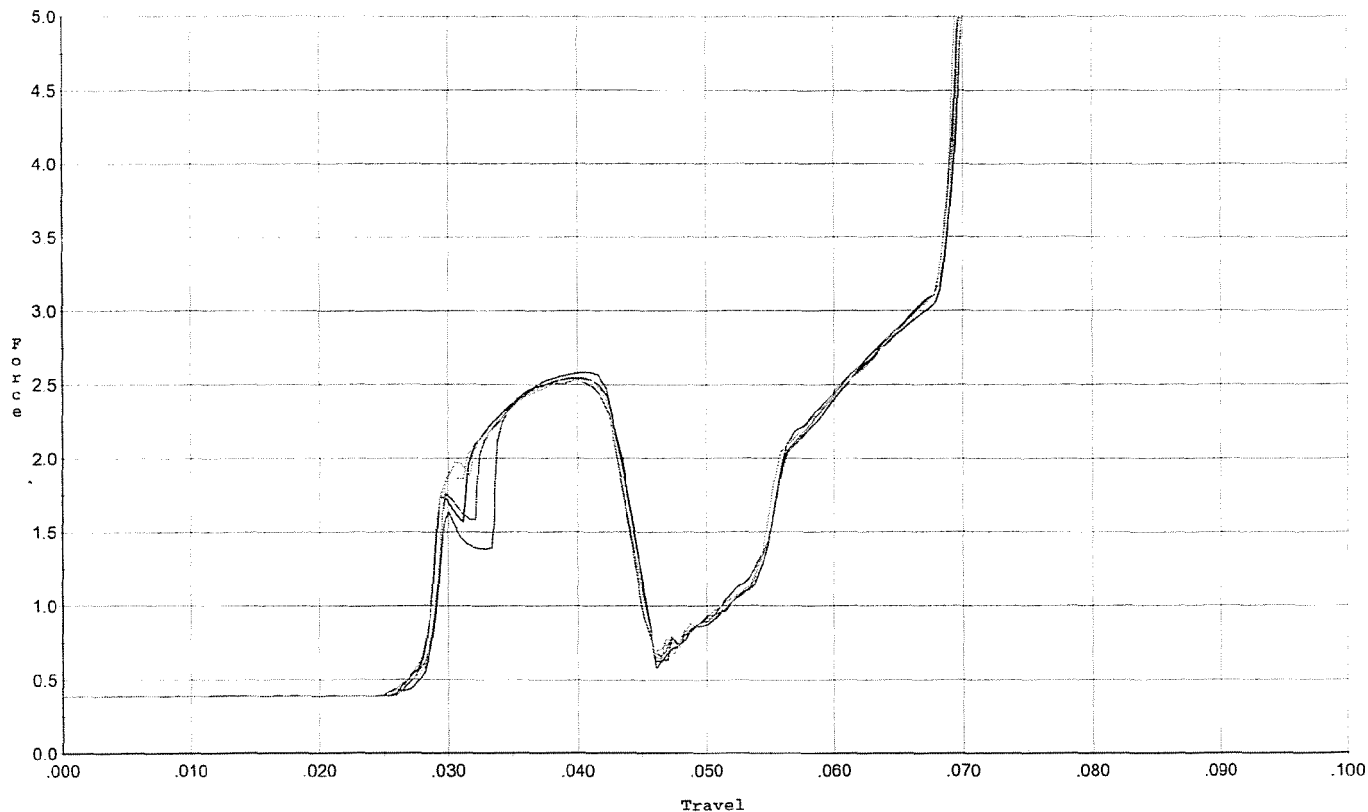
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.370	0.046	0.029	0.032	0.044		Set Trigger
2	2.410	0.045	0.029	0.031	0.044		Set Trigger
3	2.367	0.046	0.030	0.032	0.043		Set Trigger
4	2.369	0.045	0.028	0.031	0.045		Set Trigger
5	2.353	0.045	0.029	0.031	0.044		Set Trigger

A-237

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs after 50 cycles+/- 1.0 lbs



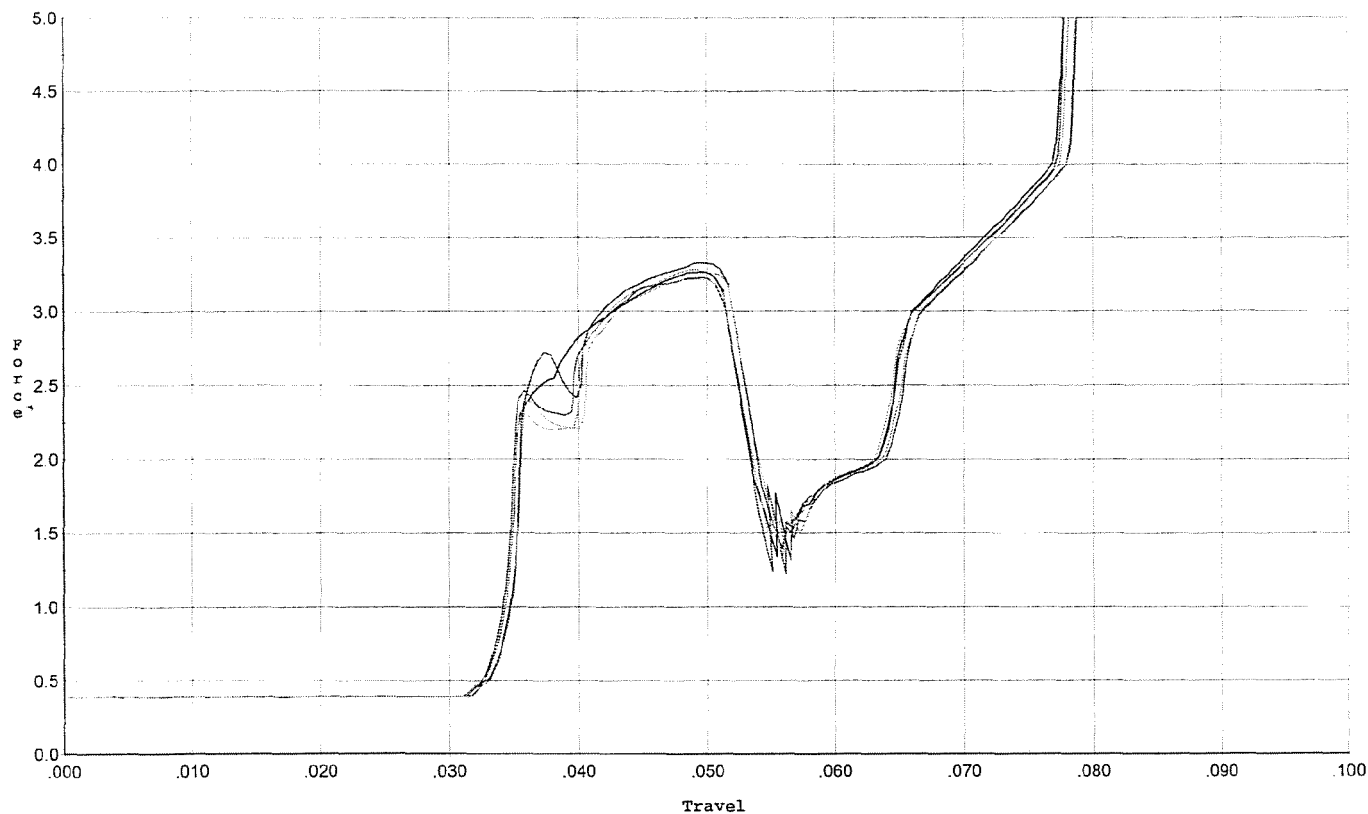
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.580	0.044	0.028	0.031	0.043		Set Trigger
2	2.542	0.043	0.028	0.031	0.045		Set Trigger
3	2.531	0.043	0.028	0.031	0.043		Set Trigger
4	2.528	0.042	0.028	0.031	0.044		Set Trigger
5	2.548	0.042	0.027	0.030	0.043		Set Trigger

A-254

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



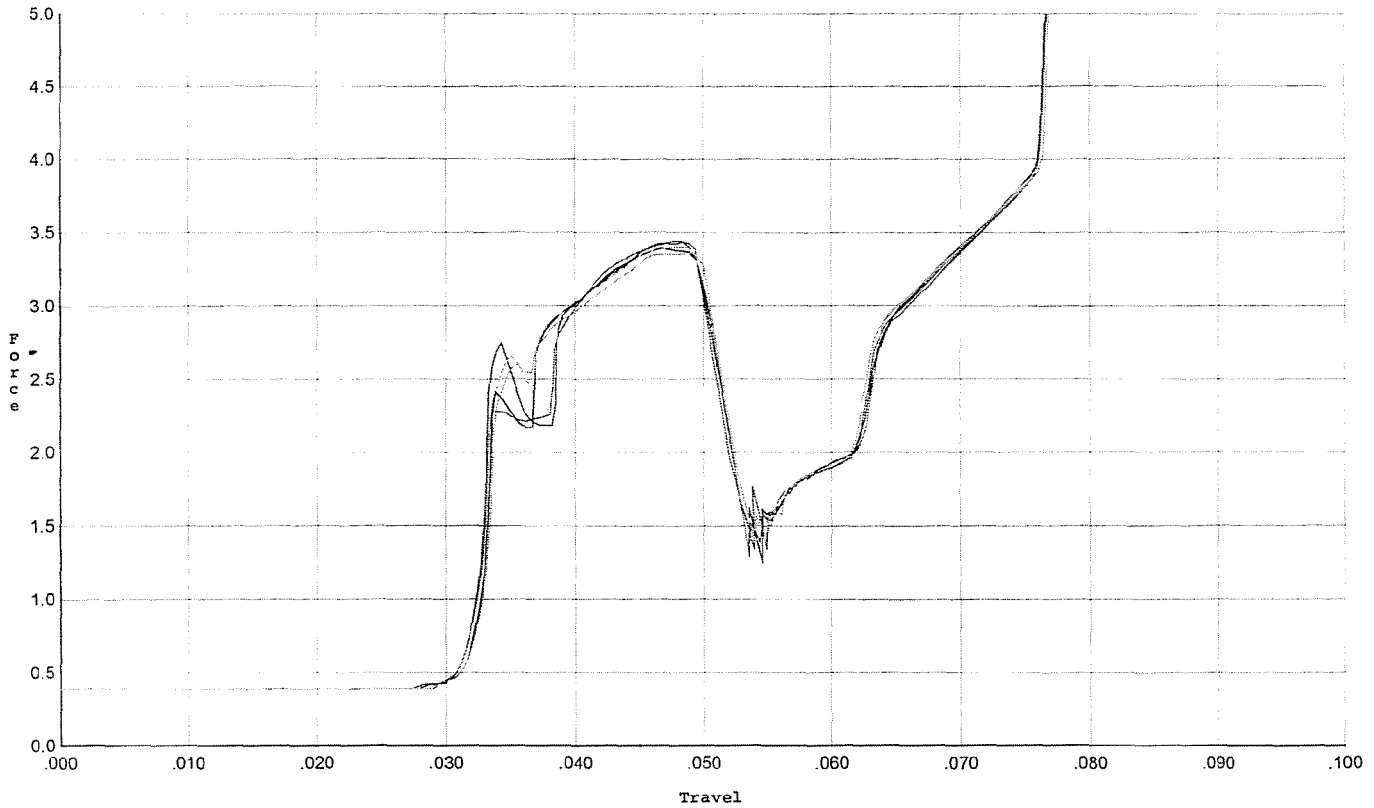
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.328	0.052	0.034	0.031	0.066		Set Trigger
2	3.265	0.051	0.033	0.031	0.065		Set Trigger
3	3.228	0.051	0.033	0.031	0.064		Set Trigger
4	3.216	0.051	0.033	0.031	0.063		Set Trigger
5	3.280	0.052	0.034	0.031	0.064		Set Trigger

A-3-26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



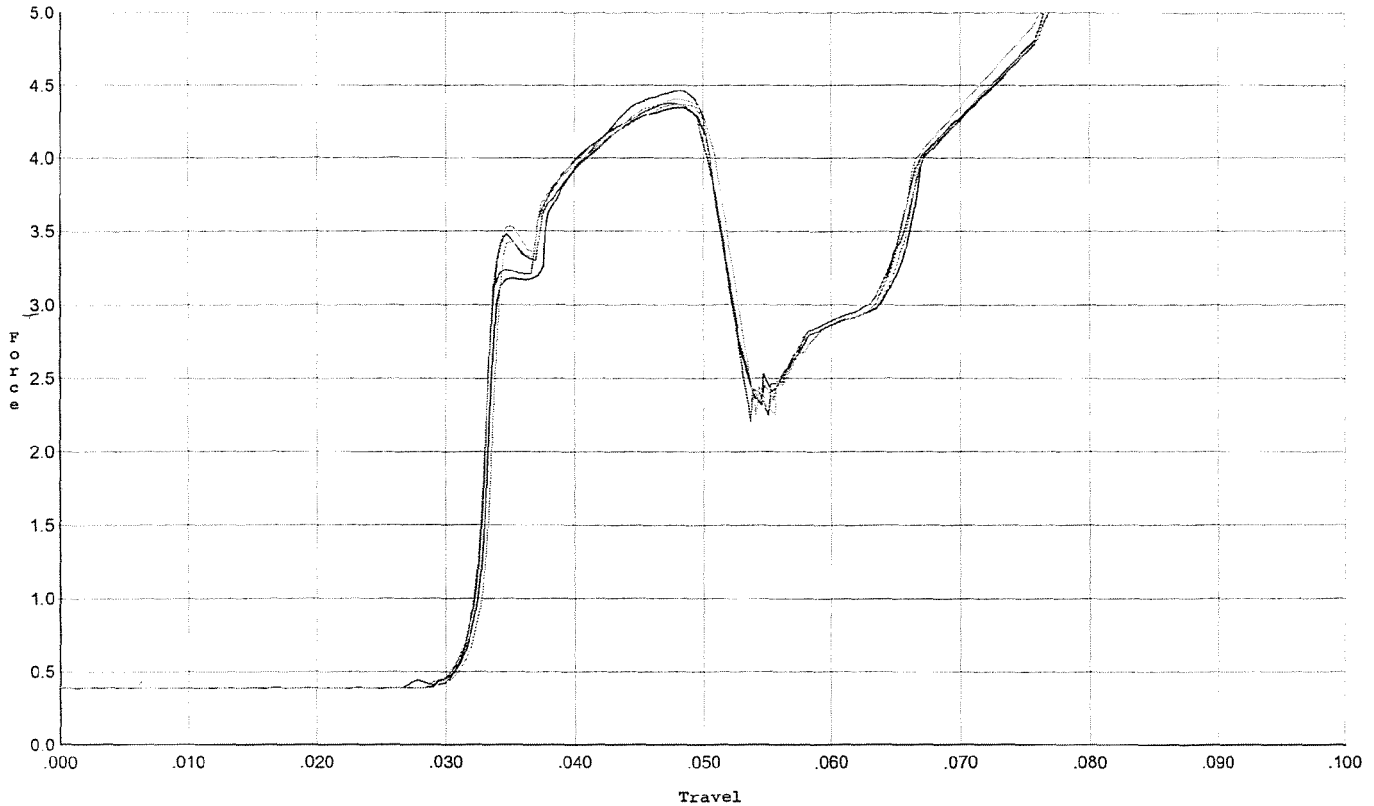
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.436	0.051	0.031	0.031	0.068		Set Trigger
2	3.392	0.051	0.032	0.031	0.067		Set Trigger
3	3.442	0.049	0.031	0.031	0.064		Set Trigger
4	3.398	0.050	0.031	0.031	0.068		Set Trigger
5	3.361	0.050	0.032	0.031	0.066		Set Trigger

A-3-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



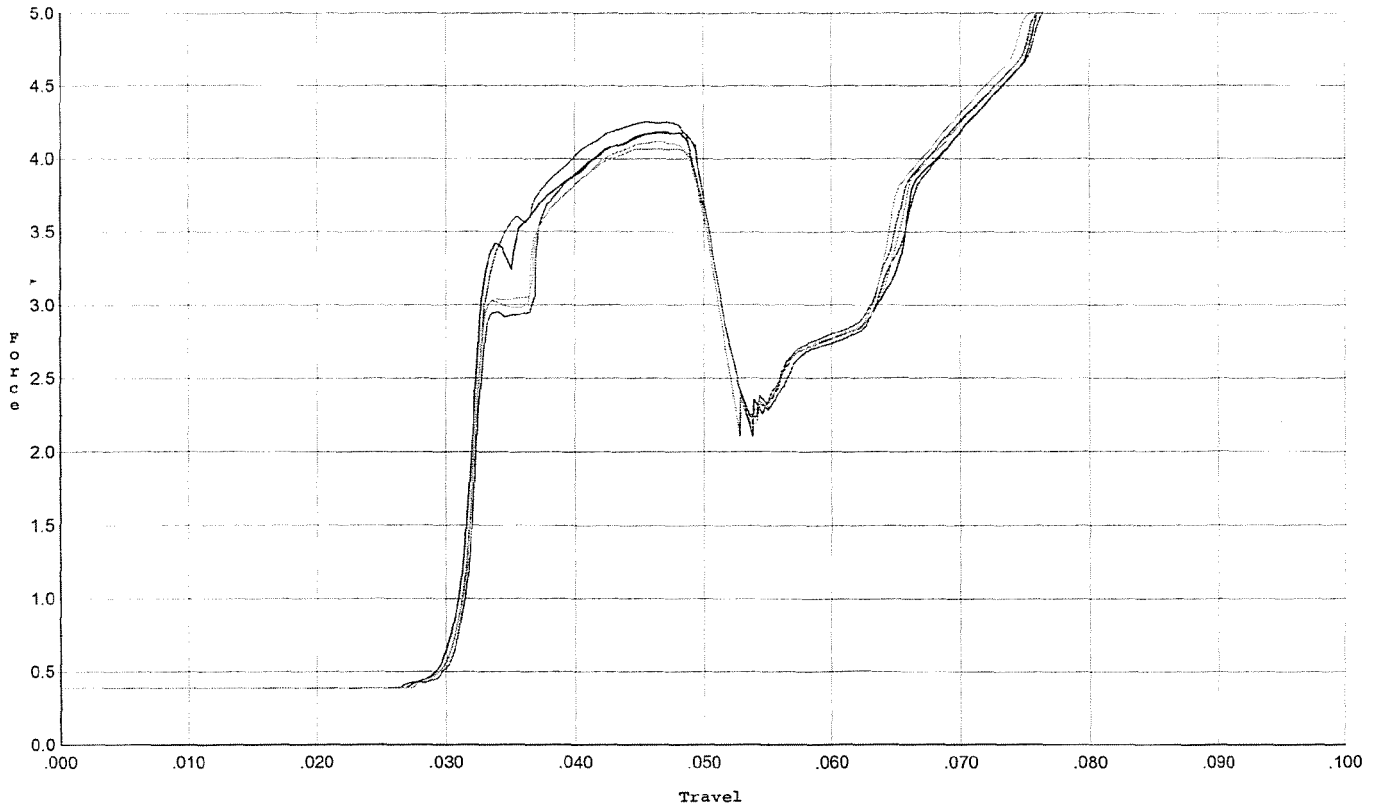
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.464	0.050	0.031	0.029	0.085		Set Trigger
2	4.347	0.050	0.031	0.030	0.083		Set Trigger
3	4.380	0.051	0.031	0.029	0.085		Set Trigger
4	4.405	0.051	0.032	0.029	0.086		Set Trigger
5	4.367	0.050	0.031	0.029	0.085		Set Trigger

A-4.39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



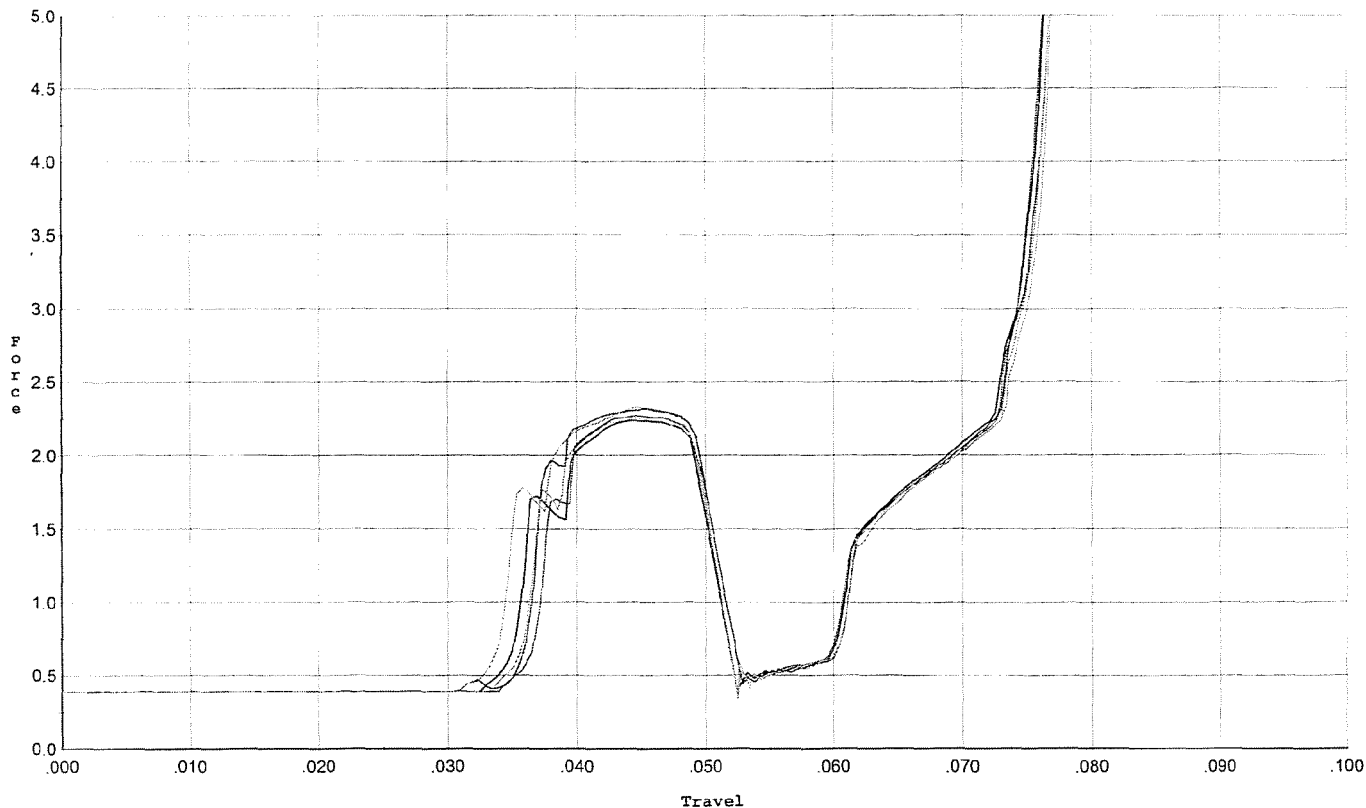
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.185	0.049	0.031	0.030	0.080		Set Trigger
2	4.175	0.050	0.030	0.029	0.084		Set Trigger
3	4.249	0.050	0.030	0.029	0.085		Set Trigger
4	4.118	0.050	0.030	0.030	0.081		Set Trigger
5	4.067	0.050	0.030	0.029	0.081		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



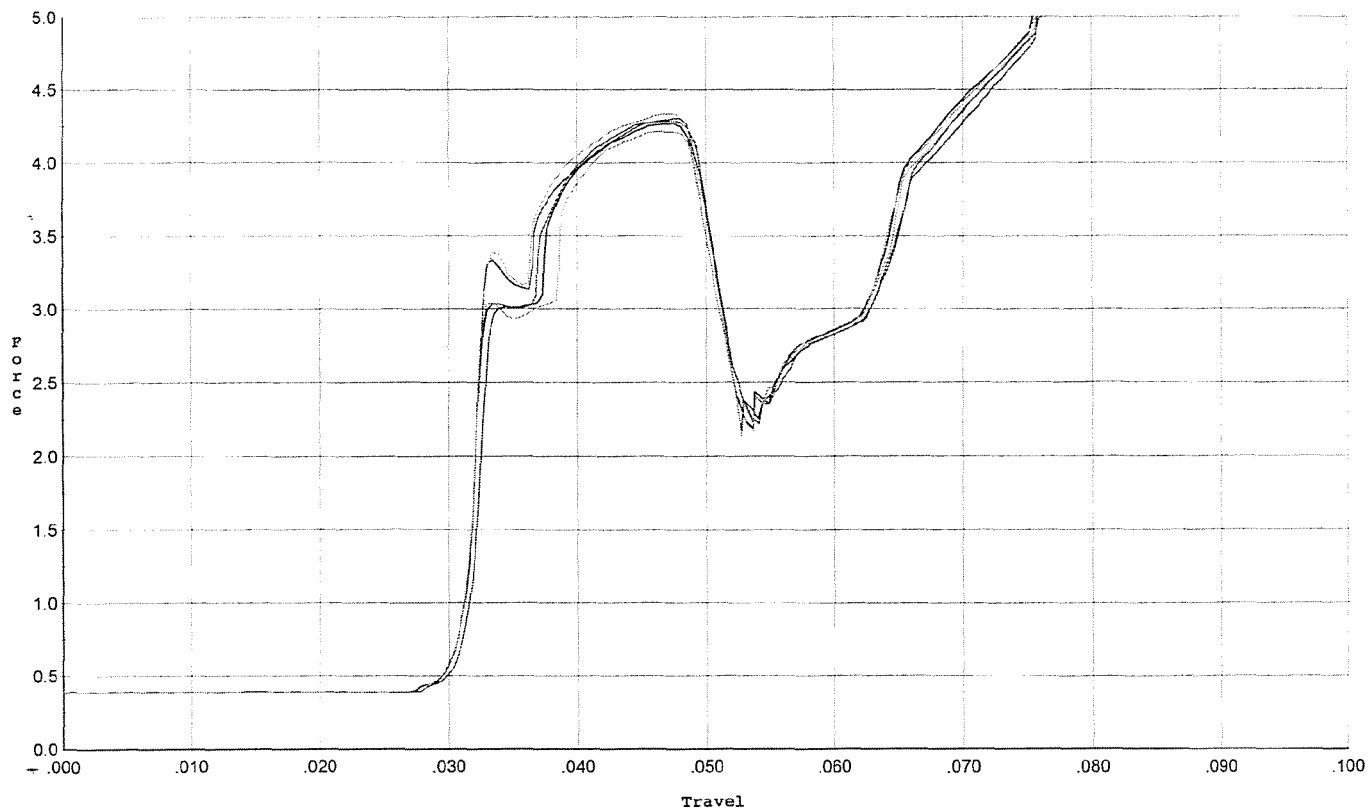
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.316	0.049	0.036	0.033	0.044		Set Trigger
2	2.236	0.050	0.035	0.033	0.044		Set Trigger
3	2.268	0.050	0.036	0.033	0.042		Set Trigger
4	2.254	0.050	0.036	0.033	0.043		Set Trigger
5	2.328	0.050	0.034	0.033	0.046		Set Trigger

A-2.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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	4.299	0.050	0.030	0.029	0.084		Set Trigger
2	4.269	0.049	0.030	0.029	0.080		Set Trigger
3	4.281	0.049	0.031	0.030	0.081		Set Trigger
4	4.336	0.050	0.030	0.029	0.085		Set Trigger
5	4.212	0.049	0.030	0.030	0.078		Set Trigger

A-4.27