

56794579

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



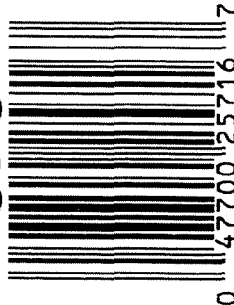
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

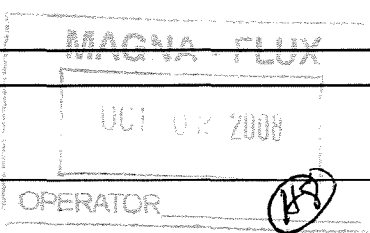
G6794579

UPC



GUN SERIAL #

66794579

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	RSN
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	(signature)
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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

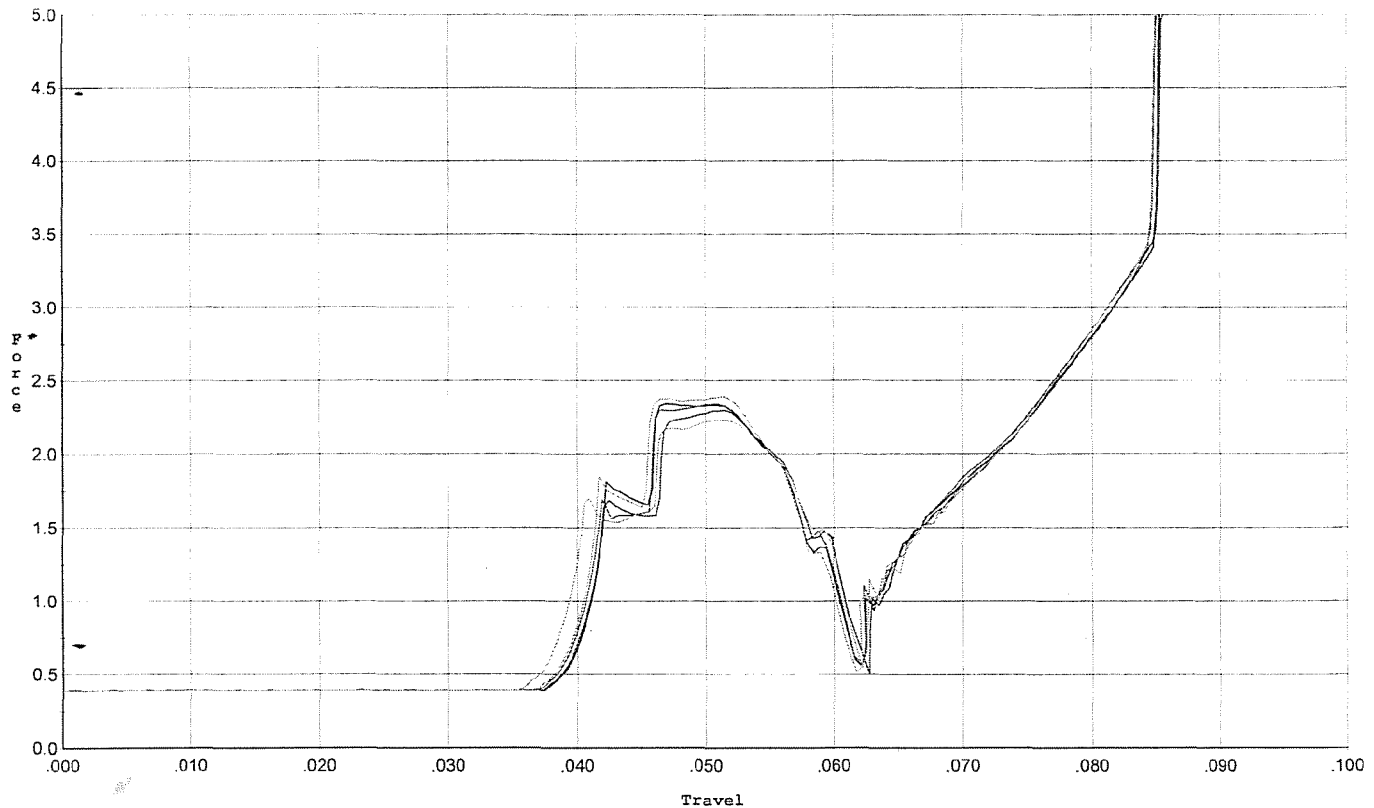
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>30</u> <u>30</u>	10-31-08	R. D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>55</u> <u>55</u> <u>50</u>	10-31-08	R. D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	10-31-08	R. D.
	J) ASSEMBLE STOCK		10-28-08	R. D.
	K) ASSEMBLE SWIVEL STUDS		10-31-08	R. D.
	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	10-29-08	R. D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-28-08	TAE
670	FINAL INSPECTION A) HEADSPACE		10-31-08	R. D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.36</u> <u>2.37</u> <u>2.32</u> <u>2.40</u>	10-30-08	R. D.
	C) FUNCTION		10-31-08	R. D.
690	PACK		10/31/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



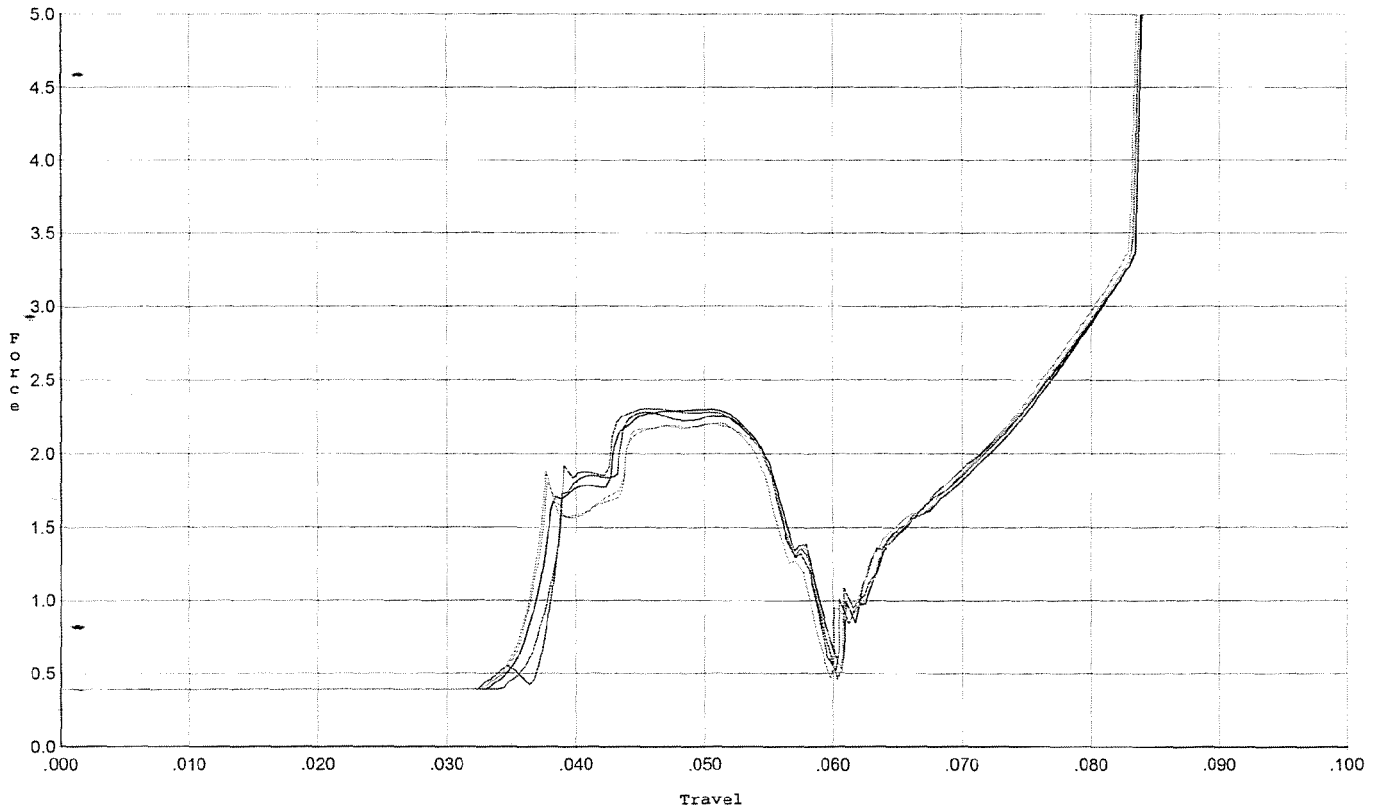
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.296	0.060	0.040	0.032	0.052		Set Trigger
2	2.348	0.060	0.040	0.032	0.053		Set Trigger
3	2.344	0.060	0.039	0.032	0.053		Set Trigger
4	2.230	0.060	0.038	0.032	0.054		Set Trigger
5	2.391	0.060	0.039	0.032	0.054		Set Trigger

A 2.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



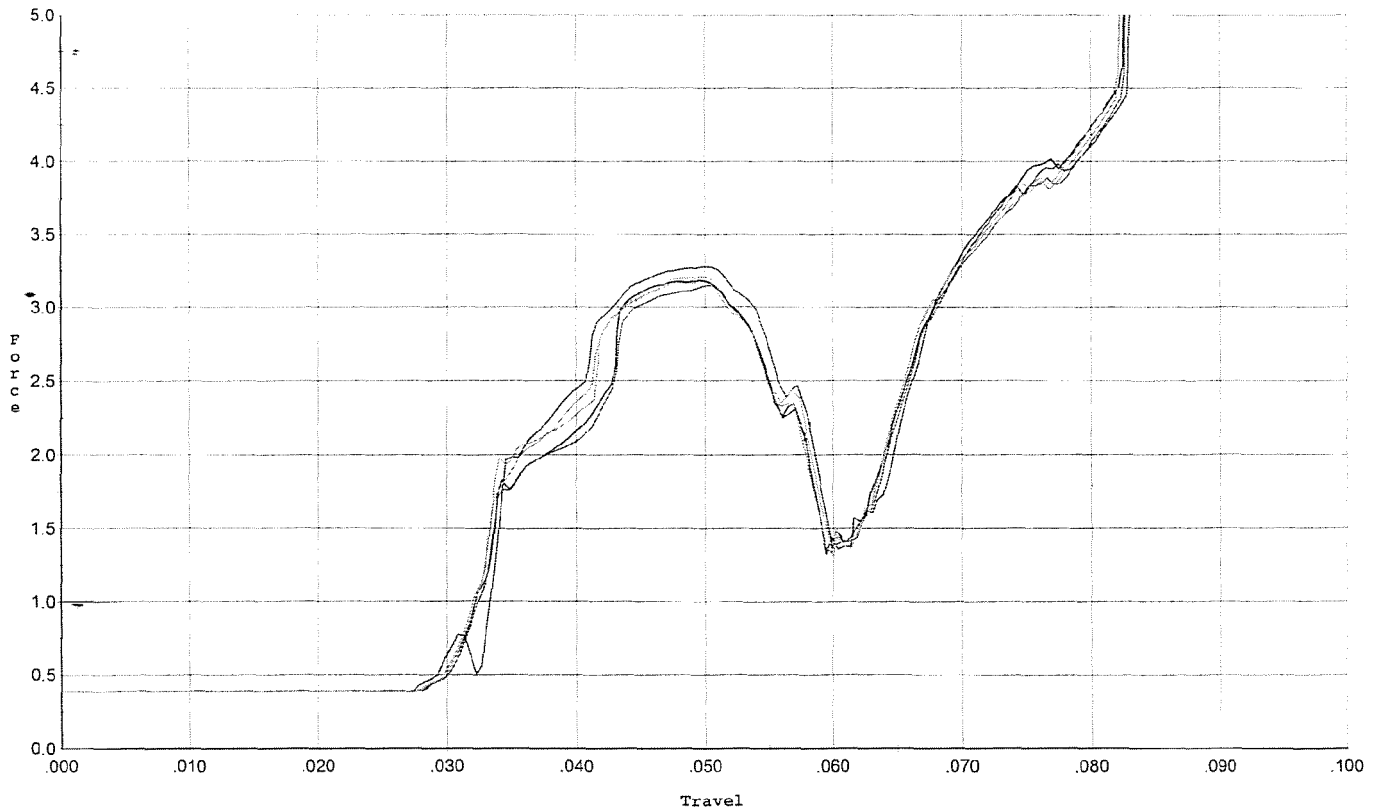
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.286	0.058	0.037	0.033	0.055		Set Trigger
2	2.299	0.058	0.036	0.033	0.056		Set Trigger
3	2.307	0.058	0.037	0.033	0.056		Set Trigger
4	2.204	0.058	0.035	0.033	0.055		Set Trigger
5	2.207	0.058	0.035	0.033	0.054		Set Trigger

A-2-26

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



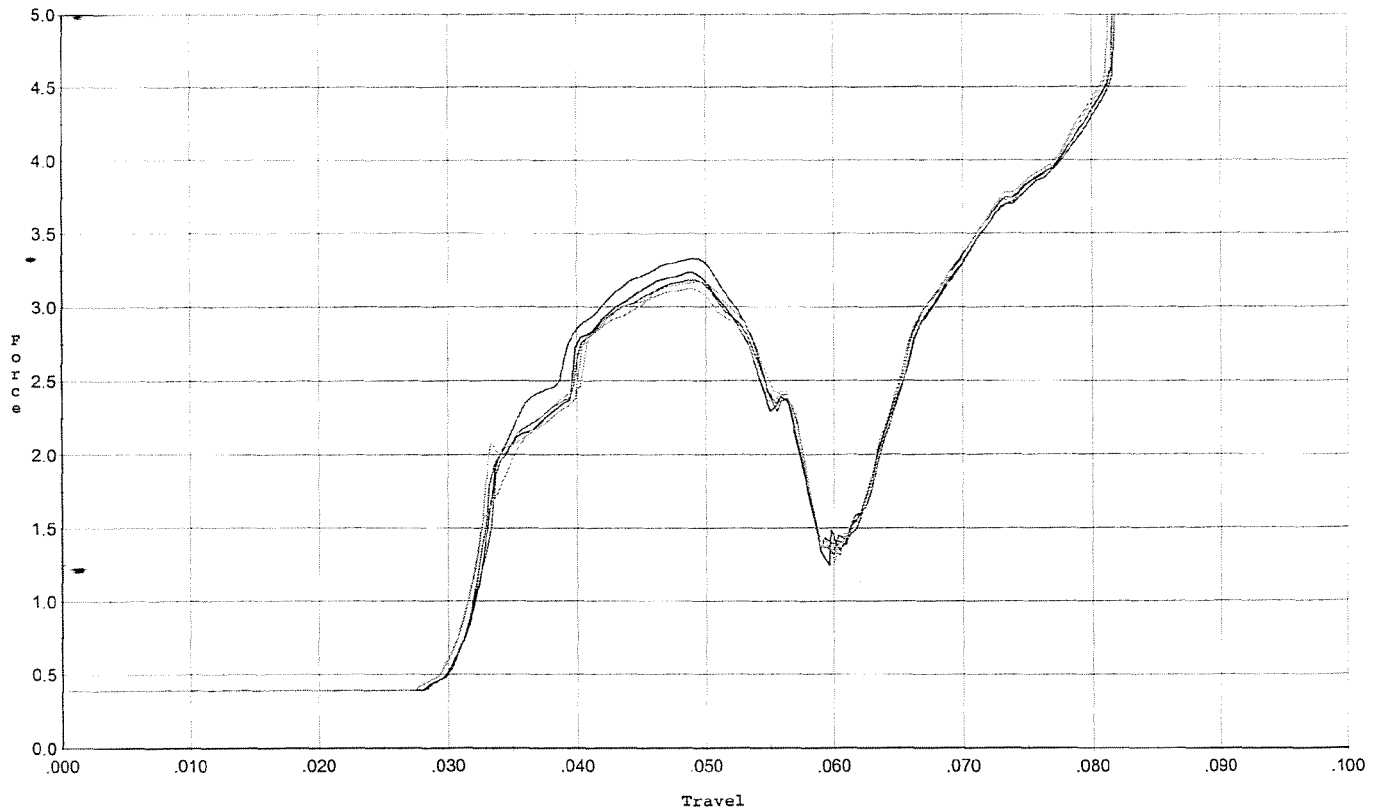
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.280	0.058	0.030	0.030	0.081		Set Trigger
2	3.185	0.058	0.031	0.031	0.077		Set Trigger
3	3.150	0.058	0.031	0.031	0.076		Set Trigger
4	3.210	0.057	0.030	0.030	0.079		Set Trigger
5	3.174	0.058	0.030	0.030	0.079		Set Trigger

A 3.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



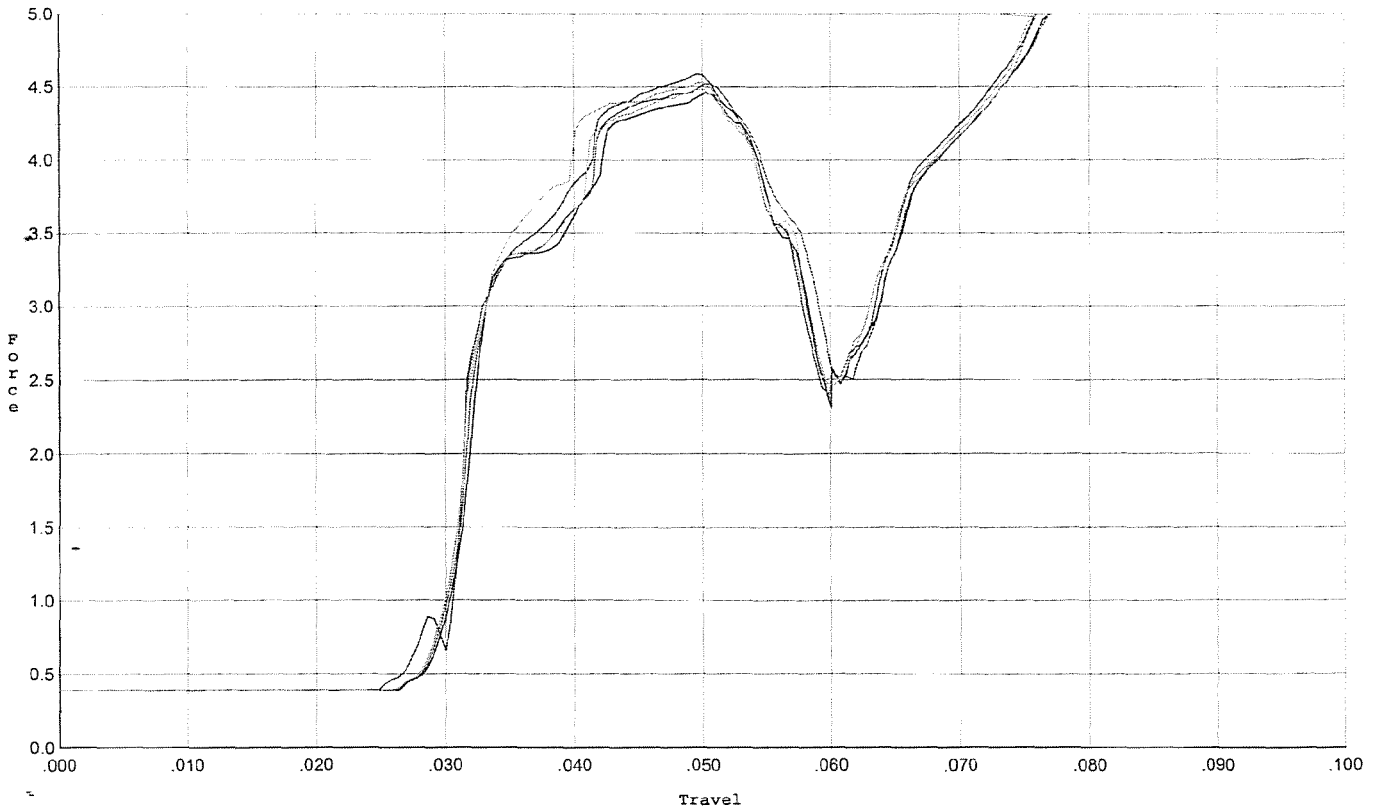
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.328	0.058	0.031	0.030	0.082		Set Trigger
2	3.232	0.056	0.030	0.031	0.078		Set Trigger
3	3.183	0.057	0.030	0.030	0.079		Set Trigger
4	3.172	0.057	0.030	0.030	0.079		Set Trigger
5	3.126	0.057	0.030	0.030	0.079		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



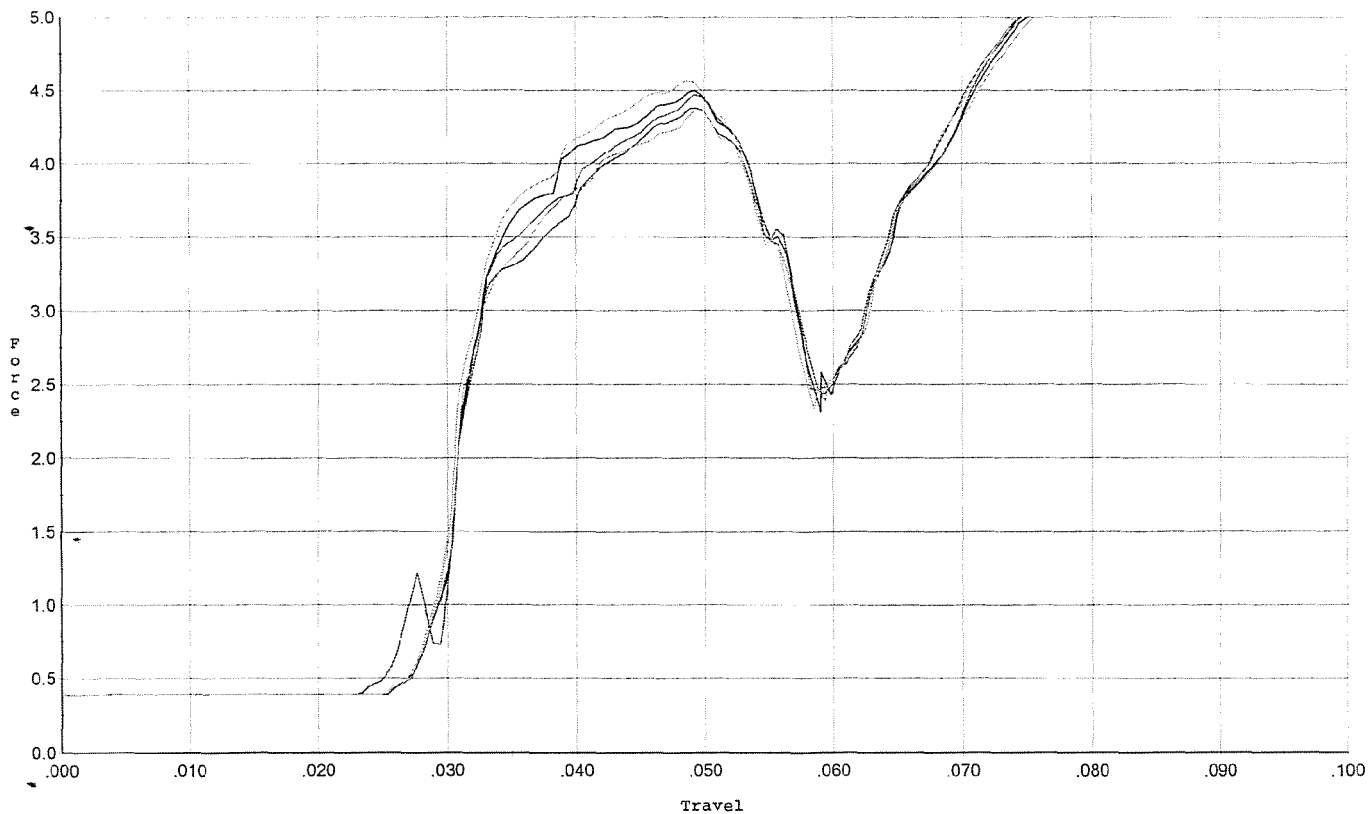
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.588	0.057	0.027	0.028	0.114		Set Trigger
2	4.458	0.057	0.029	0.028	0.112		Set Trigger
3	4.521	0.059	0.029	0.027	0.118		Set Trigger
4	4.485	0.057	0.029	0.027	0.114		Set Trigger
5	4.527	0.058	0.029	0.027	0.117		Set Trigger

A-4.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/22/2008

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



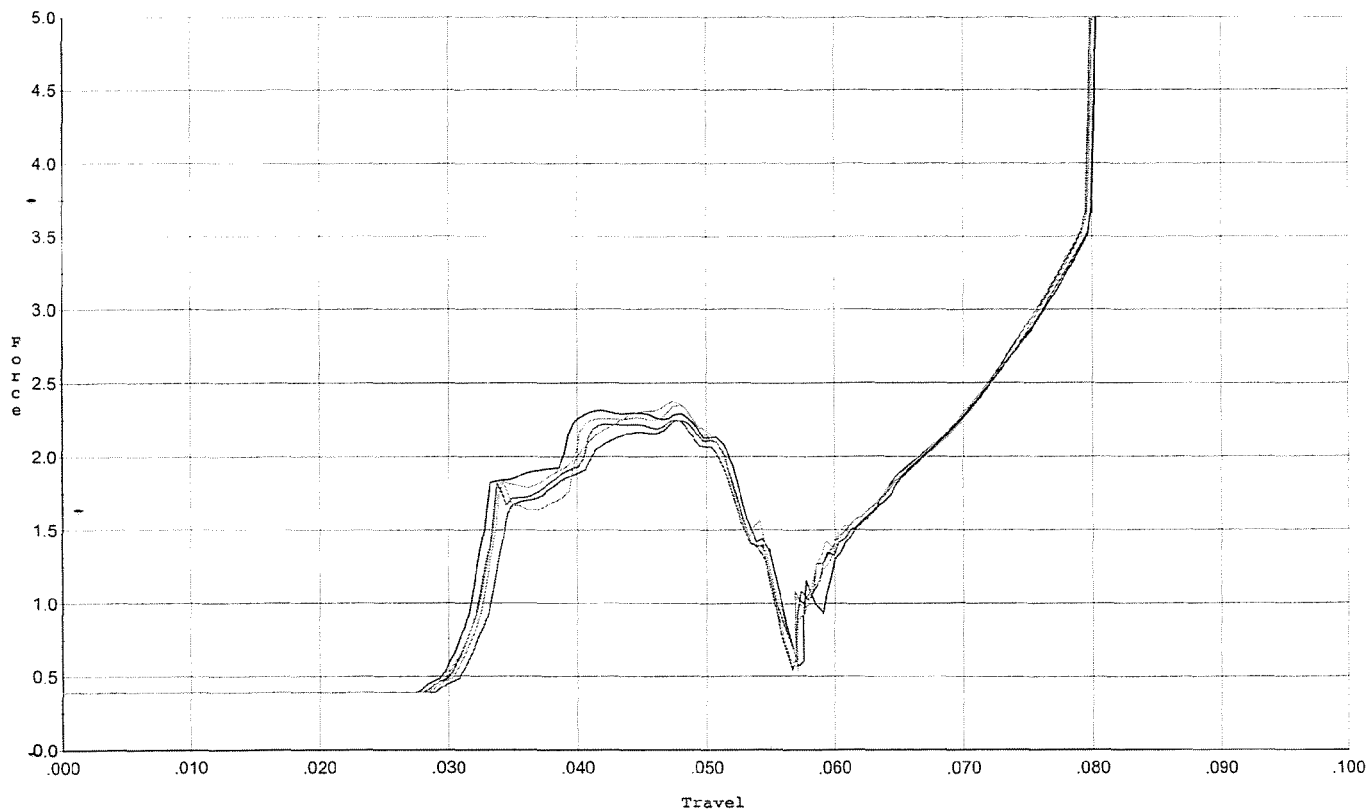
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.380	0.057	0.026	0.027	0.111		Set Trigger
2	4.500	0.056	0.028	0.028	0.114		Set Trigger
3	4.470	0.056	0.028	0.028	0.111		Set Trigger
4	4.566	0.056	0.028	0.028	0.114		Set Trigger
5	4.370	0.057	0.028	0.028	0.111		Set Trigger

A 4.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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



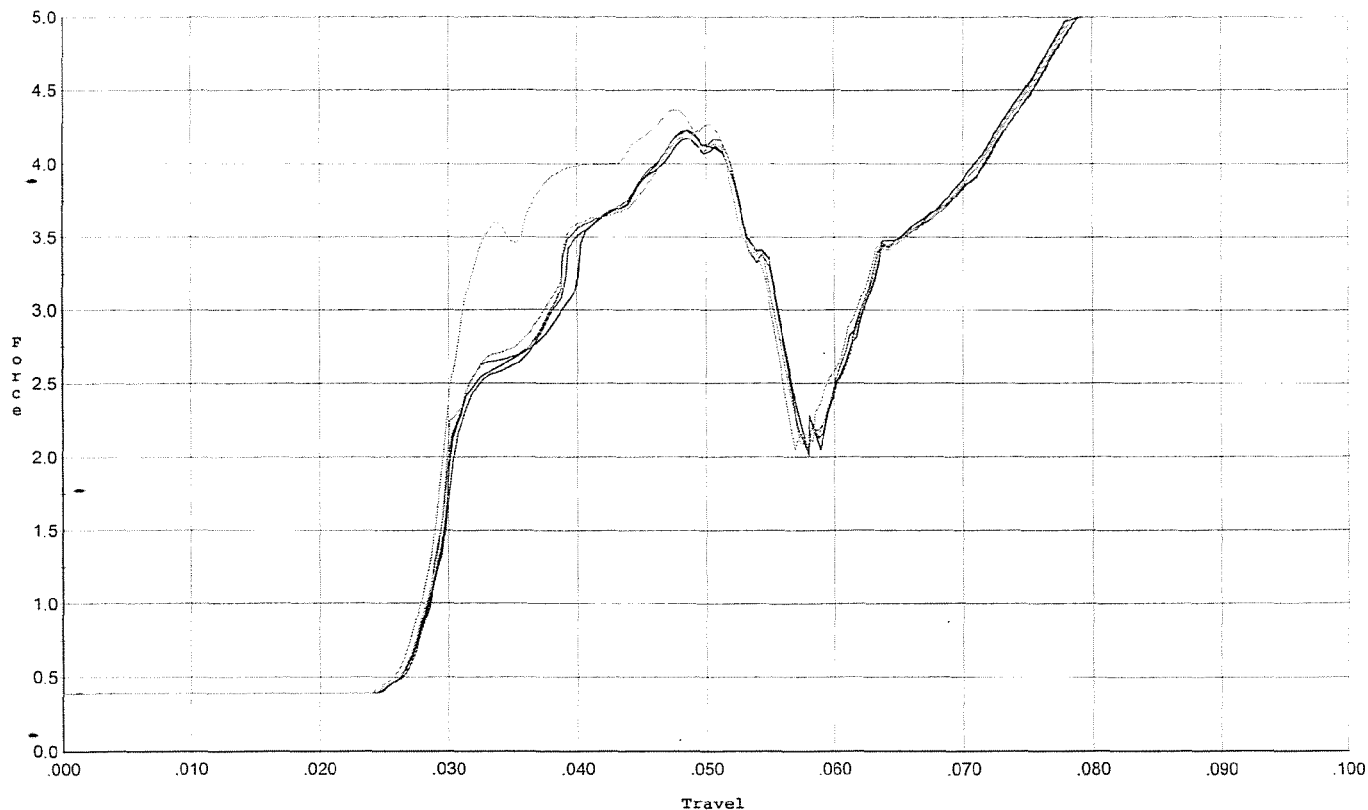
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.243	0.054	0.031	0.032	0.054		Set Trigger
2	2.312	0.055	0.030	0.032	0.059		Set Trigger
3	2.251	0.055	0.031	0.032	0.056		Set Trigger
4	2.354	0.054	0.031	0.032	0.057		Set Trigger
5	2.377	0.054	0.031	0.032	0.055		Set Trigger

A2-30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/22/2008

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	4.226	0.055	0.027	0.028	0.098		Set Trigger
2	4.170	0.055	0.027	0.028	0.098		Set Trigger
3	4.223	0.055	0.027	0.028	0.100		Set Trigger
4	4.365	0.055	0.026	0.028	0.108		Set Trigger
5	4.178	0.056	0.027	0.028	0.101		Set Trigger

A 4.23