

56794649

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



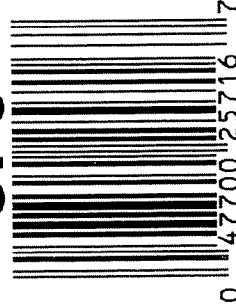
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794649

UPC



GUN SERIAL #

G 6794649

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD.
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD.
460	CHECK HEADSPACE		10-27-08	SPD.
470	DIS-ASSEMBLE ACTION		10-27-08	SPD.
472	SERIALIZE BOLT HANDLE		10-28-08	PSH
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/29/08	MR
490	MAGNAFLUX BOLT		10/27/08	MR
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		11-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-4-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-4-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-4-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	SPD.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

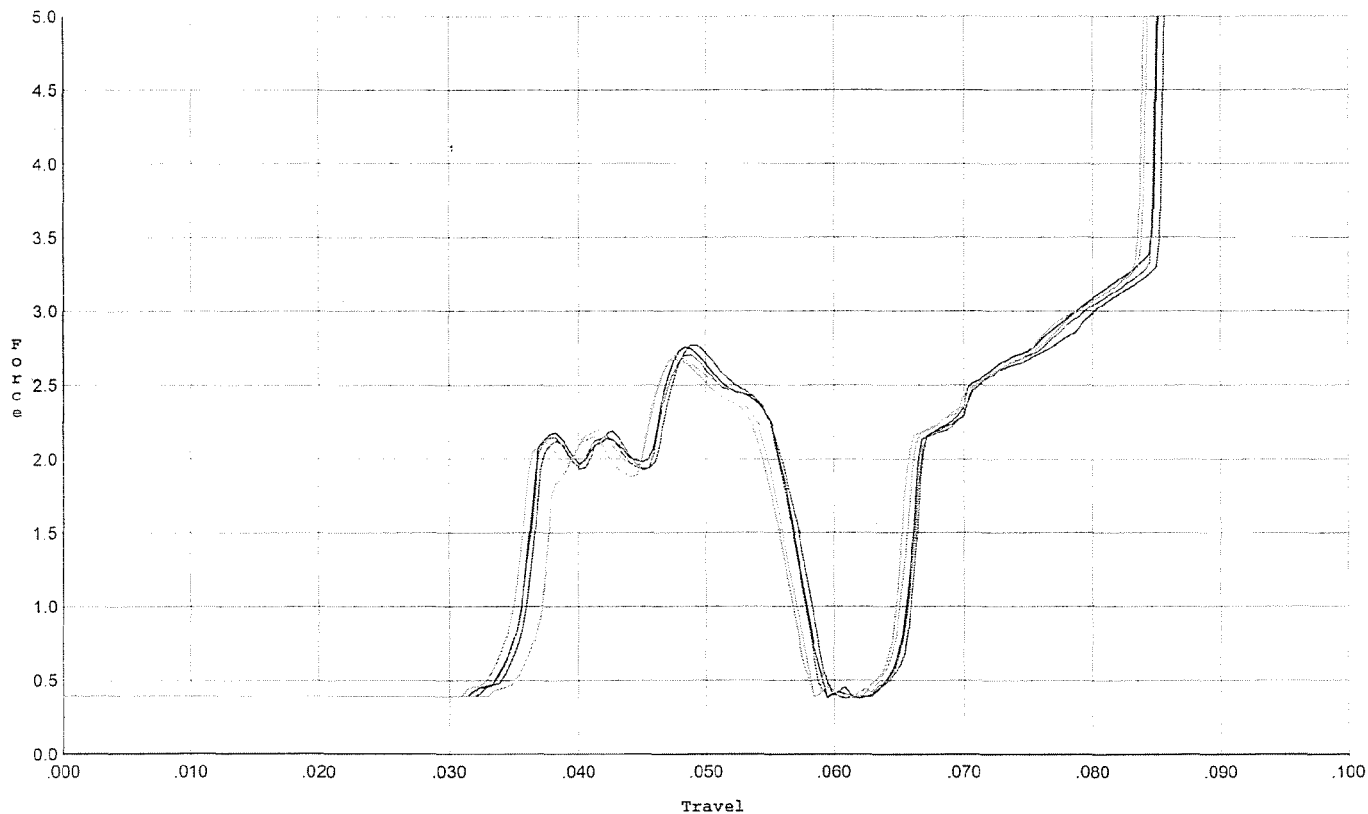
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>4.5</u> <u>4</u>	11-17-08	TC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	11-17-08	TC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.026</u> <u>.025</u>	11-17-08	TC
	J) ASSEMBLE STOCK		11-10-08	PPD
	K) ASSEMBLE SWIVEL STUDS		11-17-08	TC
	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	11-11-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-11-08	JS
670	FINAL INSPECTION A) HEADSPACE		11-17-08	TC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.35</u> <u>2.26</u> <u>2.22</u> <u>2.23</u>	11-17-08	TC
	C) FUNCTION		11-17-08	TC
690	PACK		12-1-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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



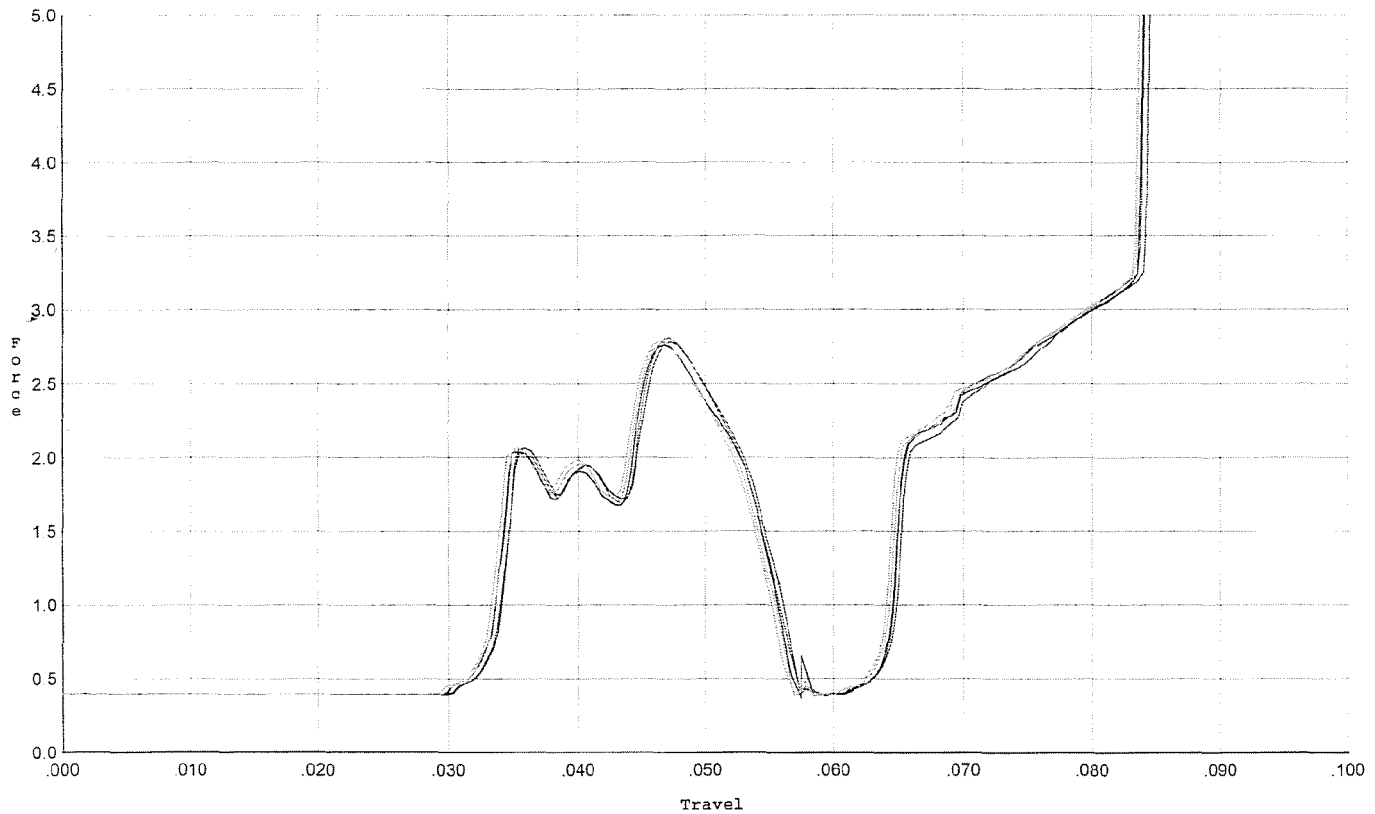
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.770	0.057	0.035	0.035	0.061		Set Trigger
2	2.755	0.056	0.034	0.035	0.061		Set Trigger
3	2.701	0.057	0.034	0.035	0.061		Set Trigger
4	2.707	0.055	0.033	0.035	0.059		Set Trigger
5	2.674	0.056	0.036	0.035	0.056		Set Trigger

A-2.72

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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



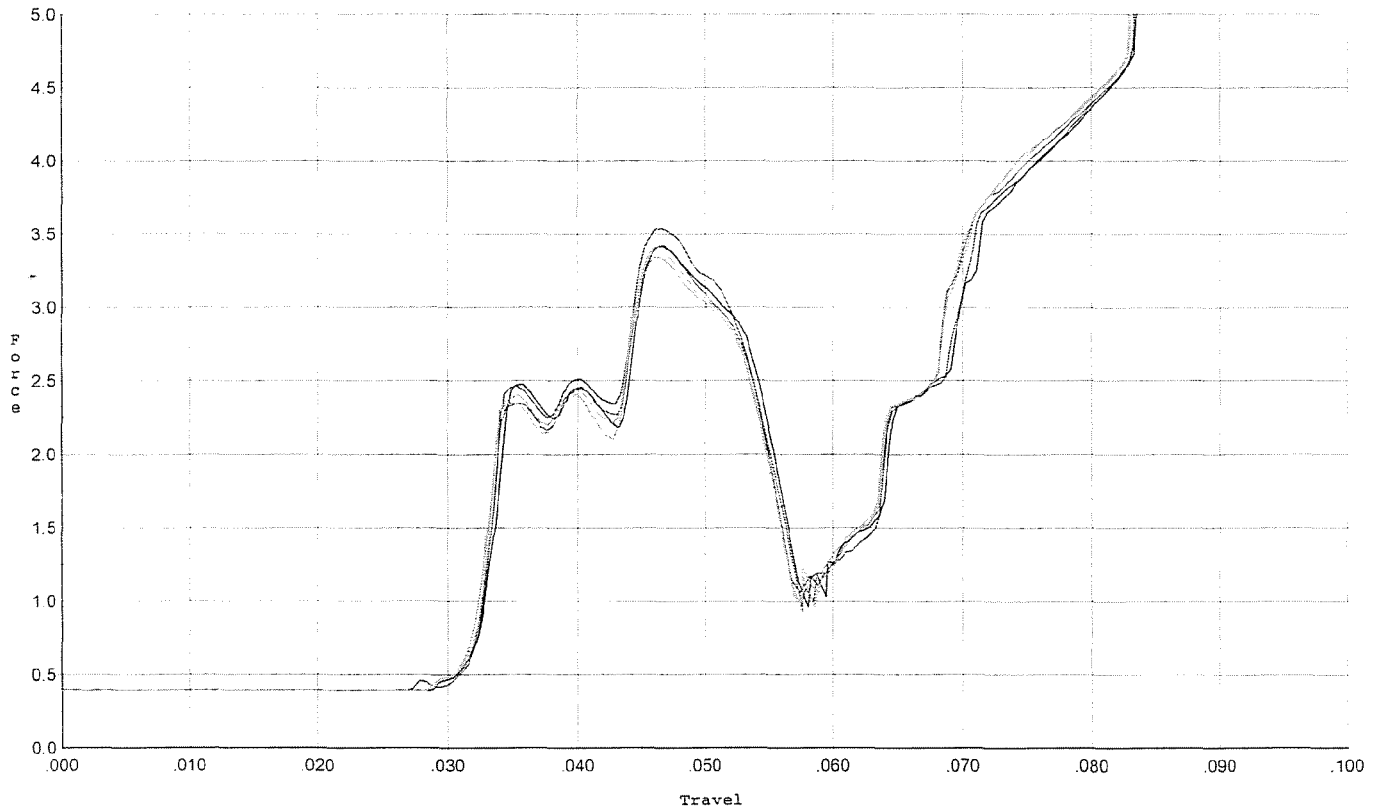
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.788	0.056	0.033	0.034	0.058		Set Trigger
2	2.762	0.055	0.033	0.034	0.057		Set Trigger
3	2.810	0.055	0.033	0.035	0.057		Set Trigger
4	2.791	0.055	0.032	0.034	0.058		Set Trigger
5	2.782	0.055	0.033	0.034	0.058		Set Trigger

A-2-75

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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



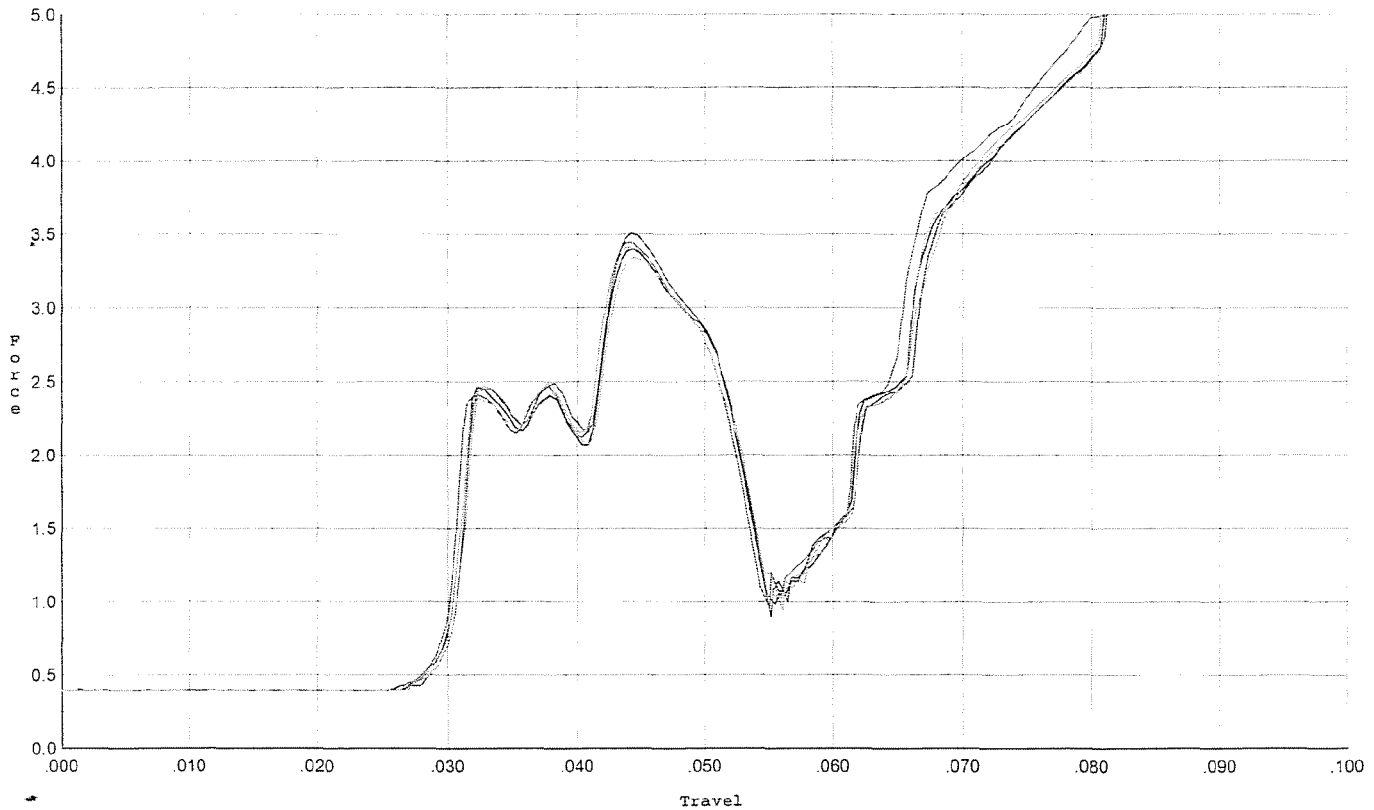
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.538	0.055	0.032	0.033	0.073		Set Trigger
2	3.420	0.056	0.032	0.033	0.073		Set Trigger
3	3.412	0.056	0.032	0.033	0.073		Set Trigger
4	3.416	0.055	0.032	0.033	0.072		Set Trigger
5	3.345	0.055	0.031	0.033	0.071		Set Trigger

3.42

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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



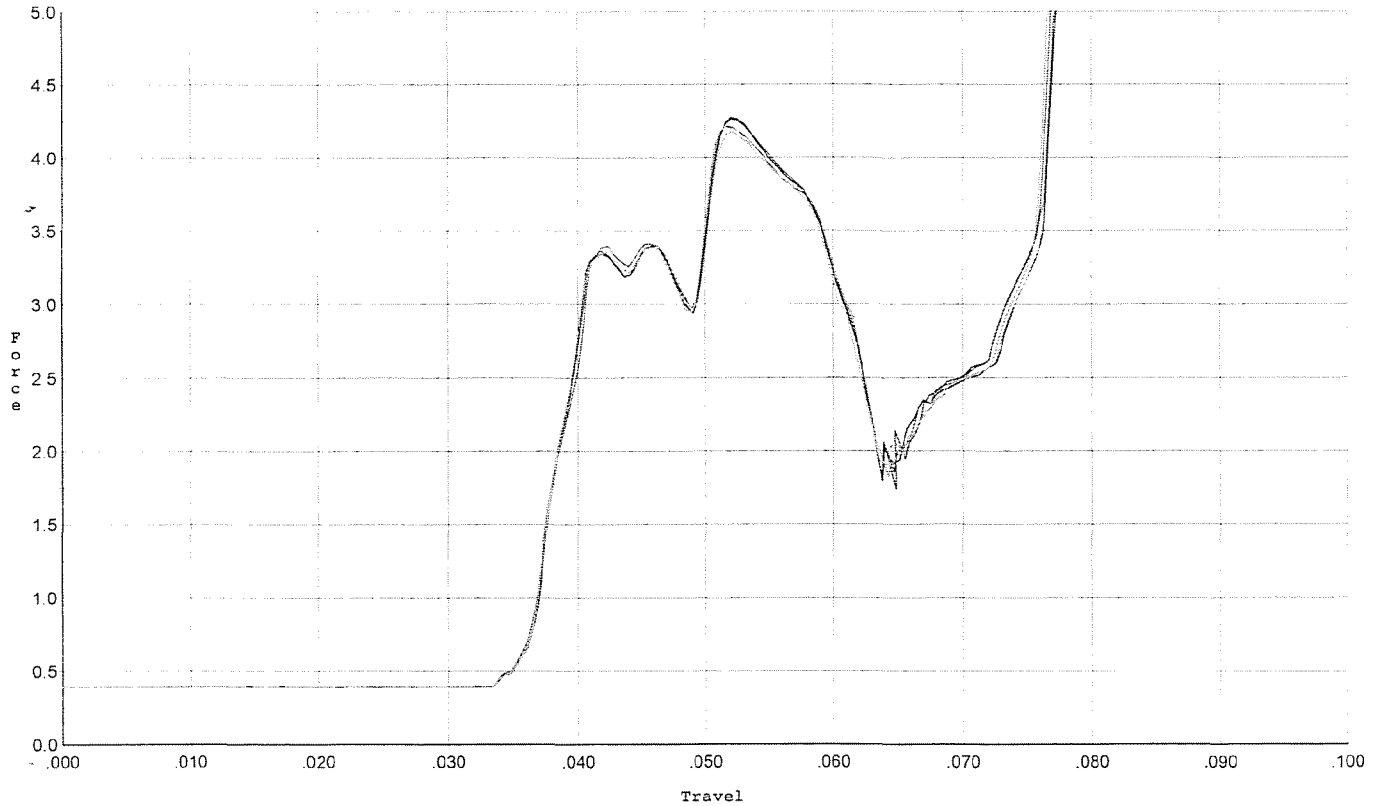
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.508	0.054	0.030	0.032	0.072		Set Trigger
2	3.398	0.053	0.029	0.031	0.071		Set Trigger
3	3.441	0.052	0.029	0.031	0.070		Set Trigger
4	3.410	0.053	0.030	0.031	0.071		Set Trigger
5	3.343	0.053	0.030	0.032	0.070		Set Trigger

A-3.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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



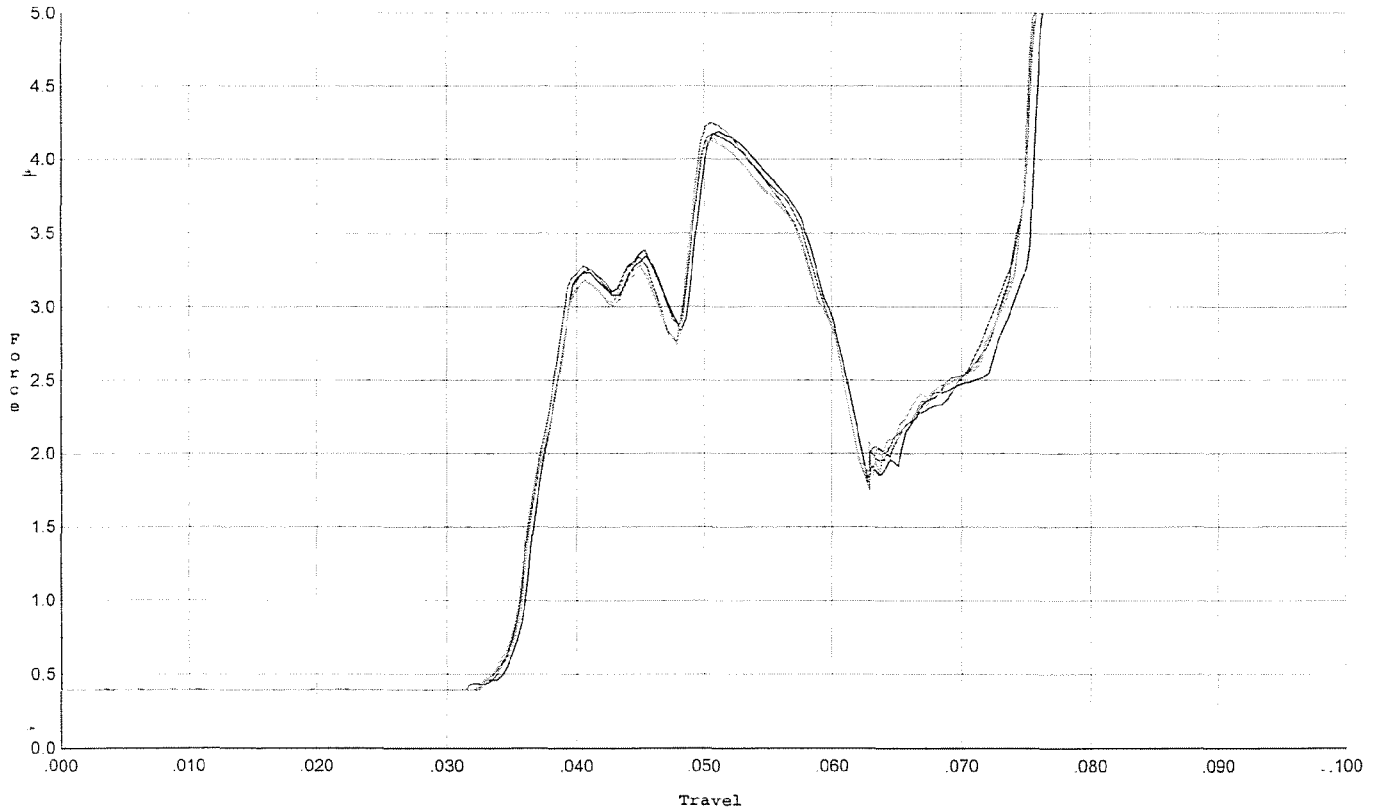
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.275	0.062	0.036	0.032	0.098		Set Trigger
2	4.266	0.062	0.036	0.032	0.098		Set Trigger
3	4.211	0.062	0.034	0.031	0.098		Set Trigger
4	4.220	0.062	0.034	0.031	0.098		Set Trigger
5	4.175	0.062	0.036	0.032	0.097		Set Trigger

A-4.72

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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



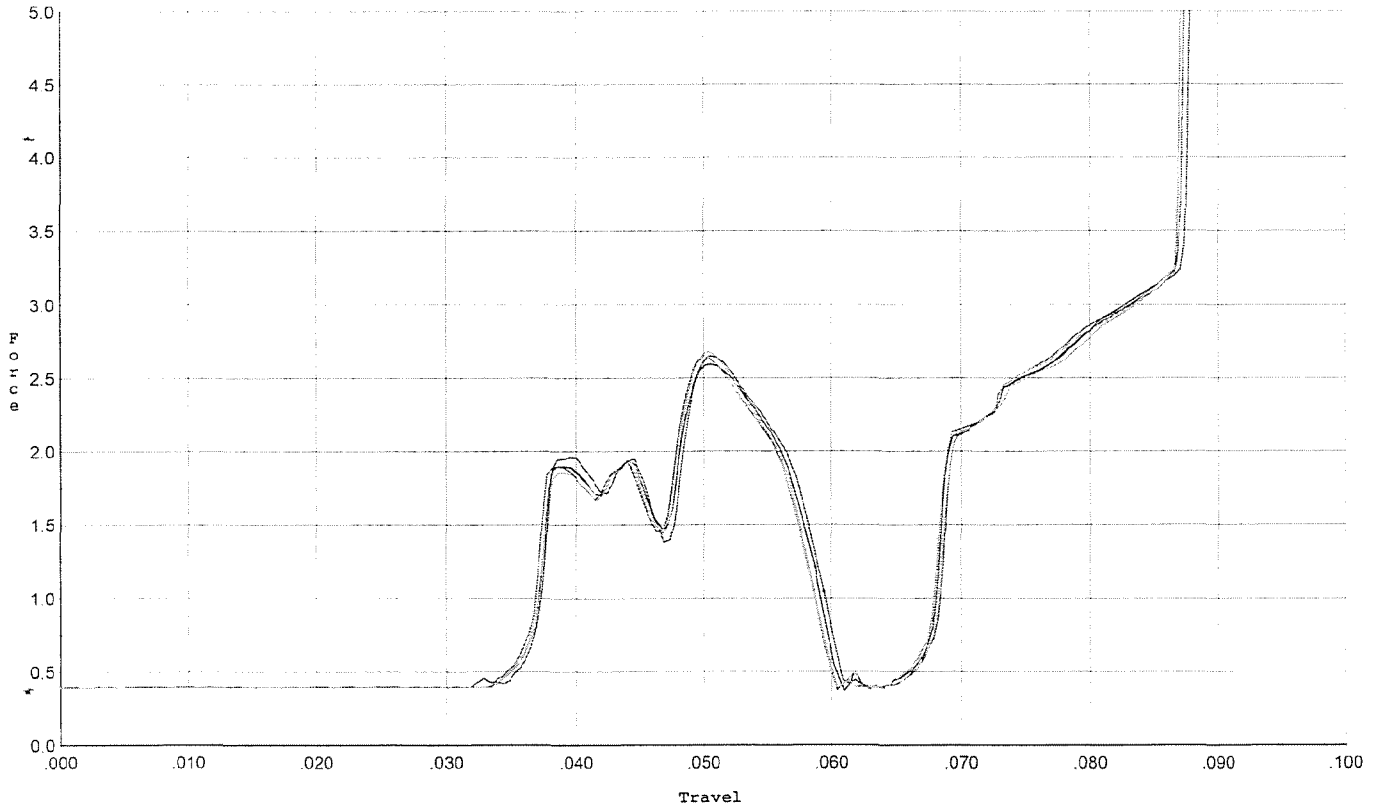
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.178	0.060	0.034	0.032	0.095		Set Trigger
2	4.189	0.061	0.035	0.032	0.096		Set Trigger
3	4.247	0.060	0.035	0.031	0.095		Set Trigger
4	4.143	0.060	0.035	0.032	0.093		Set Trigger
5	4.126	0.060	0.034	0.031	0.094		Set Trigger

A-4-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/13/2008

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



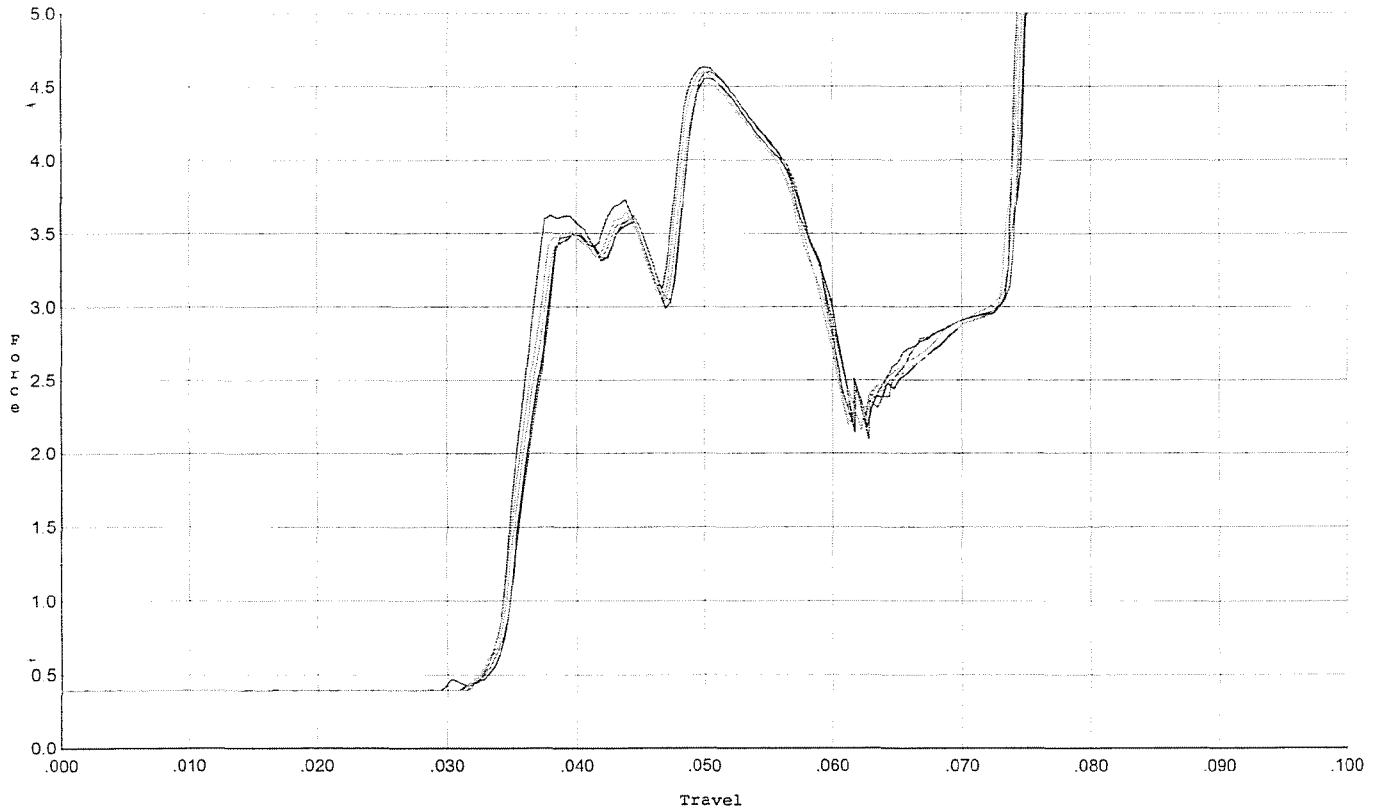
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.649	0.059	0.036	0.036	0.058		Set Trigger
2	2.596	0.059	0.036	0.036	0.057		Set Trigger
3	2.648	0.058	0.036	0.036	0.057		Set Trigger
4	2.647	0.058	0.036	0.036	0.056		Set Trigger
5	2.680	0.058	0.036	0.036	0.056		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/13/2008

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	4.631	0.059	0.033	0.019	0.105		Set Trigger
2	4.551	0.060	0.034	0.020	0.103		Set Trigger
3	4.601	0.060	0.034	0.019	0.104		Set Trigger
4	4.596	0.060	0.033	0.019	0.104		Set Trigger
5	4.518	0.059	0.032	0.020	0.102		Set Trigger

A-4.57