

66794656

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTUCTION BOOK 3518

proof of purchase



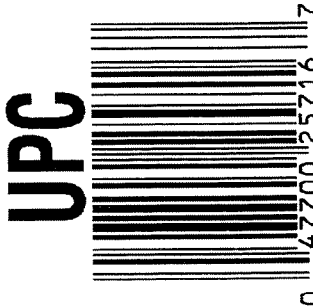
owner registration sticker



BM FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794656



GUN SERIAL # G 6794656

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SPD
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SPD
460	CHECK HEADSPACE		11-3-08	SPD
470	DIS-ASSEMBLE ACTION		11-3-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	11-4-08	KTC
475	DRILL AND TAP SIGHT HOLES	2008	11-4-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	11/6/08	RT
490	MAGNAFLUX BOLT		11/3/08	RT
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/15	C
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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

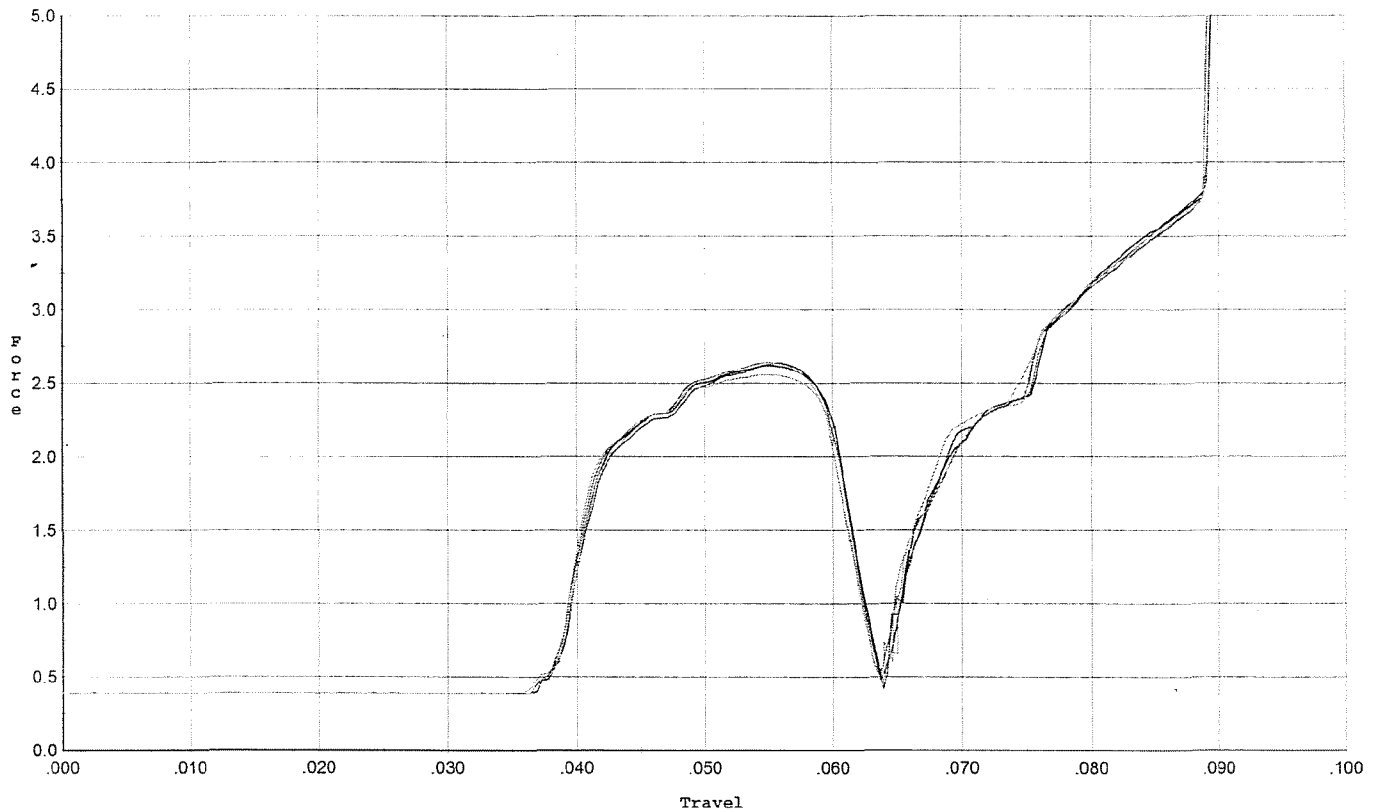
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>49</u> <u>40</u> <u>30</u>	11-20-08	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>60</u> <u>60</u>	11-20-08	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-20-08	L N
	J) ASSEMBLE STOCK		11-18-08	L N
	K) ASSEMBLE SWIVEL STUDS		11-20-08	L N
	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	L N
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	TL
670	FINAL INSPECTION A) HEADSPACE		11-20-08	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.41</u> <u>2.47</u> <u>2.47</u> <u>2.46</u>	11-20-08	TL
	C) FUNCTION		11-20-08	L N
690	PACK		12-2-08	TL

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: 2.5 lbs ini +/- .50 lbs



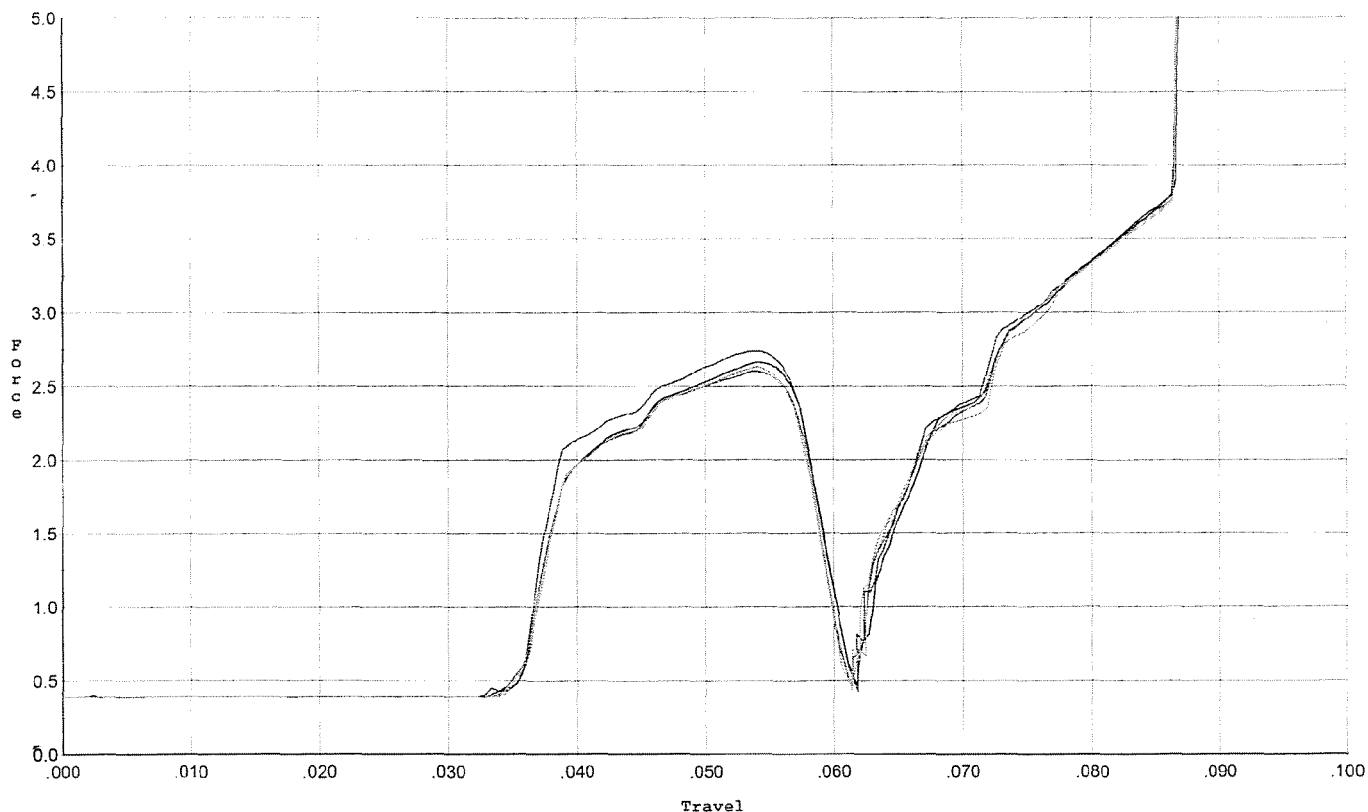
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.632	0.060	0.037	0.035	0.064		Set Trigger
2	2.615	0.060	0.037	0.035	0.064		Set Trigger
3	2.639	0.061	0.038	0.035	0.066		Set Trigger
4	2.636	0.060	0.037	0.035	0.063		Set Trigger
5	2.559	0.060	0.039	0.035	0.065		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

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

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



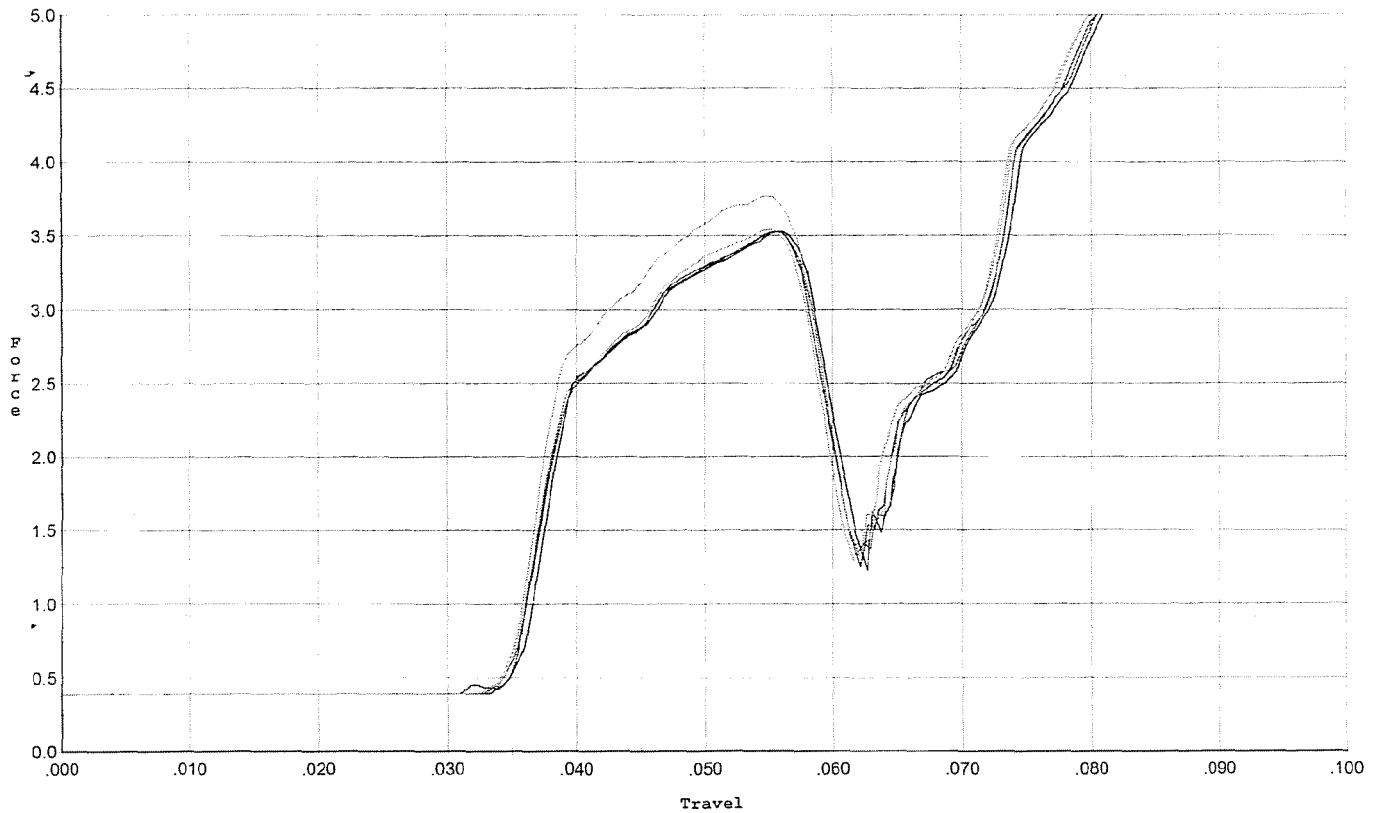
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.738	0.059	0.036	0.034	0.067		Set Trigger
2	2.661	0.057	0.036	0.035	0.063		Set Trigger
3	2.599	0.058	0.036	0.035	0.063		Set Trigger
4	2.609	0.058	0.036	0.035	0.063		Set Trigger
5	2.628	0.058	0.035	0.035	0.063		Set Trigger

A 2.64

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



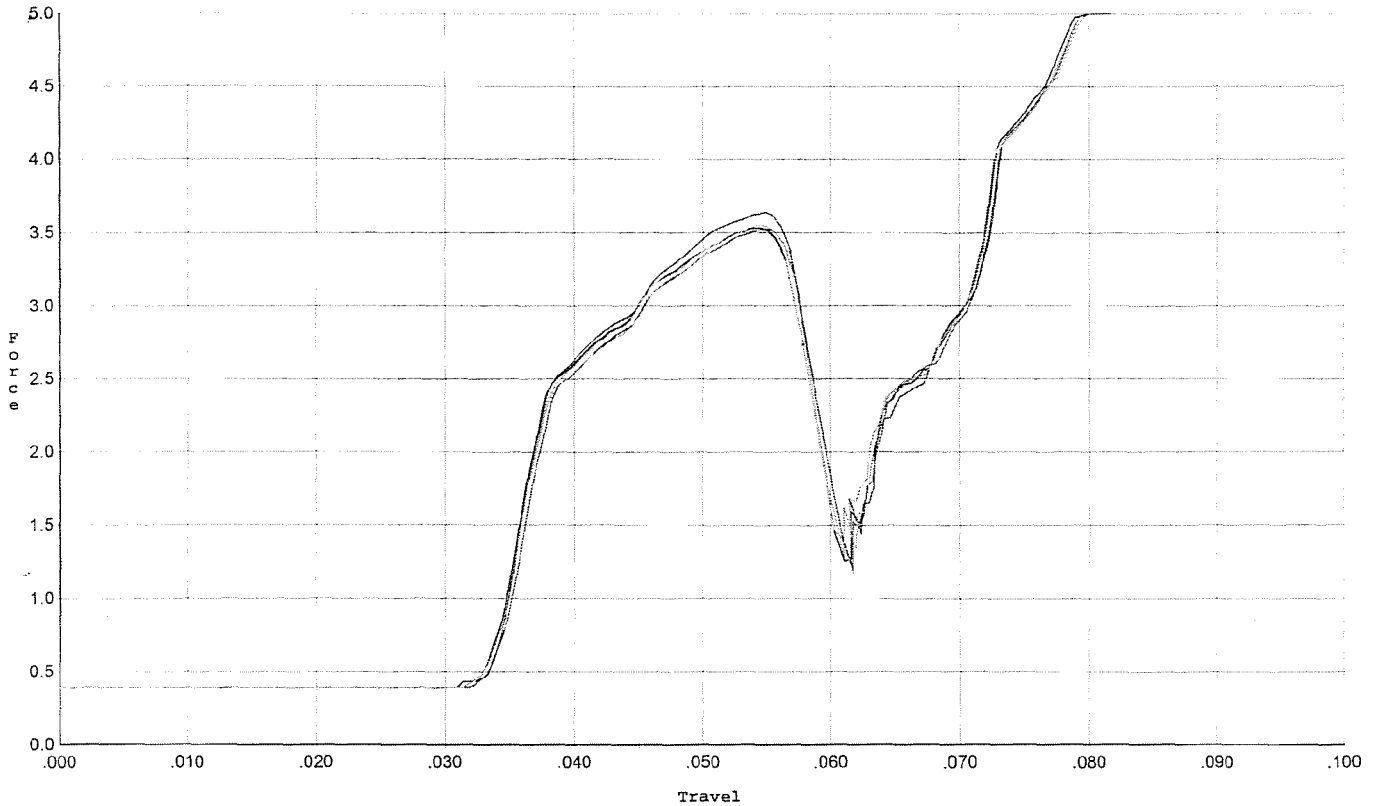
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.530	0.059	0.035	0.031	0.082		Set Trigger
2	3.526	0.058	0.035	0.031	0.080		Set Trigger
3	3.530	0.059	0.035	0.031	0.081		Set Trigger
4	3.542	0.058	0.035	0.031	0.080		Set Trigger
5	3.768	0.058	0.034	0.031	0.087		Set Trigger

A-357

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



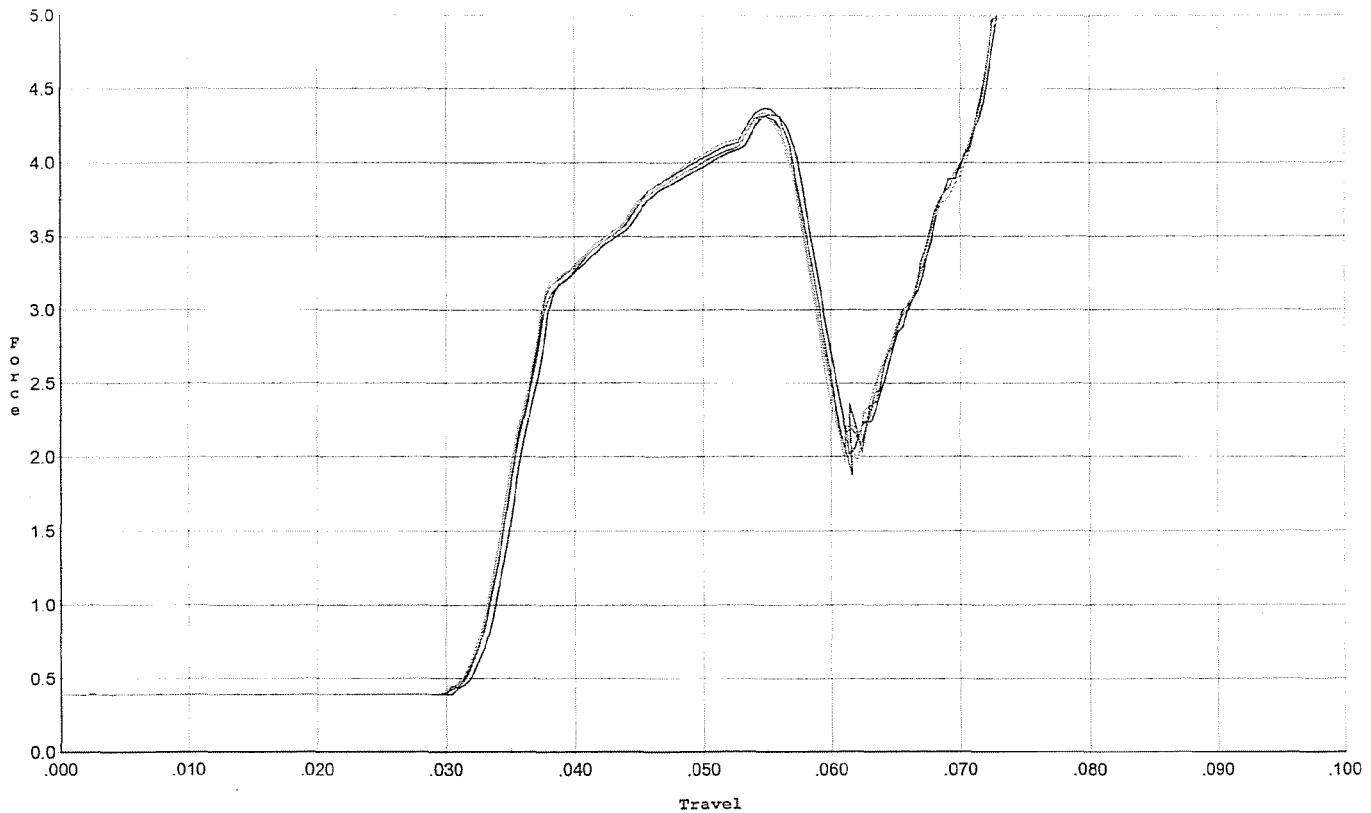
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.639	0.057	0.034	0.031	0.082		Set Trigger
2	3.531	0.058	0.033	0.031	0.082		Set Trigger
3	3.528	0.057	0.034	0.031	0.080		Set Trigger
4	3.548	0.057	0.033	0.031	0.081		Set Trigger
5	3.519	0.058	0.033	0.031	0.081		Set Trigger

A-3-SS

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



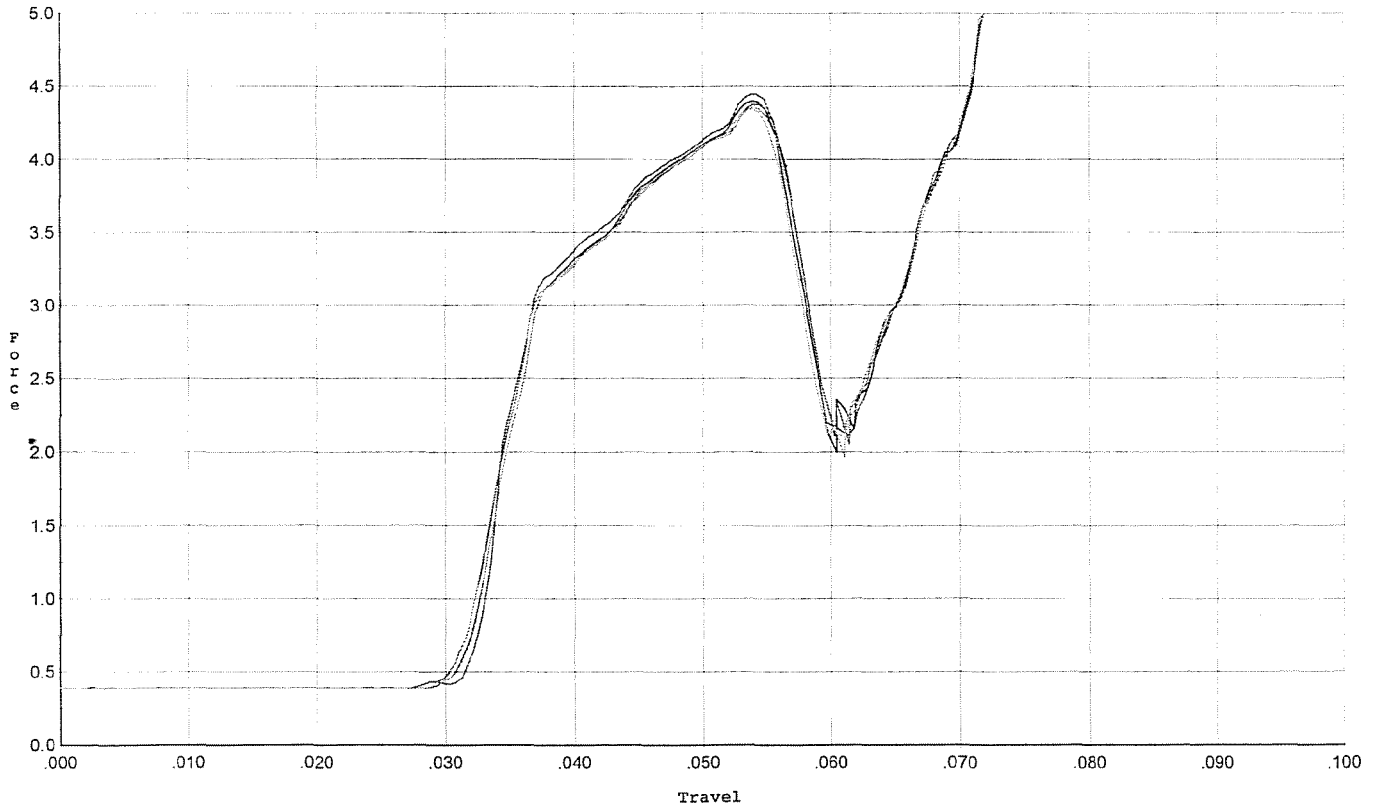
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.370	0.058	0.032	0.029	0.102		Set Trigger
2	4.325	0.057	0.032	0.029	0.099		Set Trigger
3	4.309	0.057	0.032	0.029	0.098		Set Trigger
4	4.301	0.057	0.032	0.029	0.099		Set Trigger
5	4.338	0.057	0.032	0.028	0.099		Set Trigger

A-4.32

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



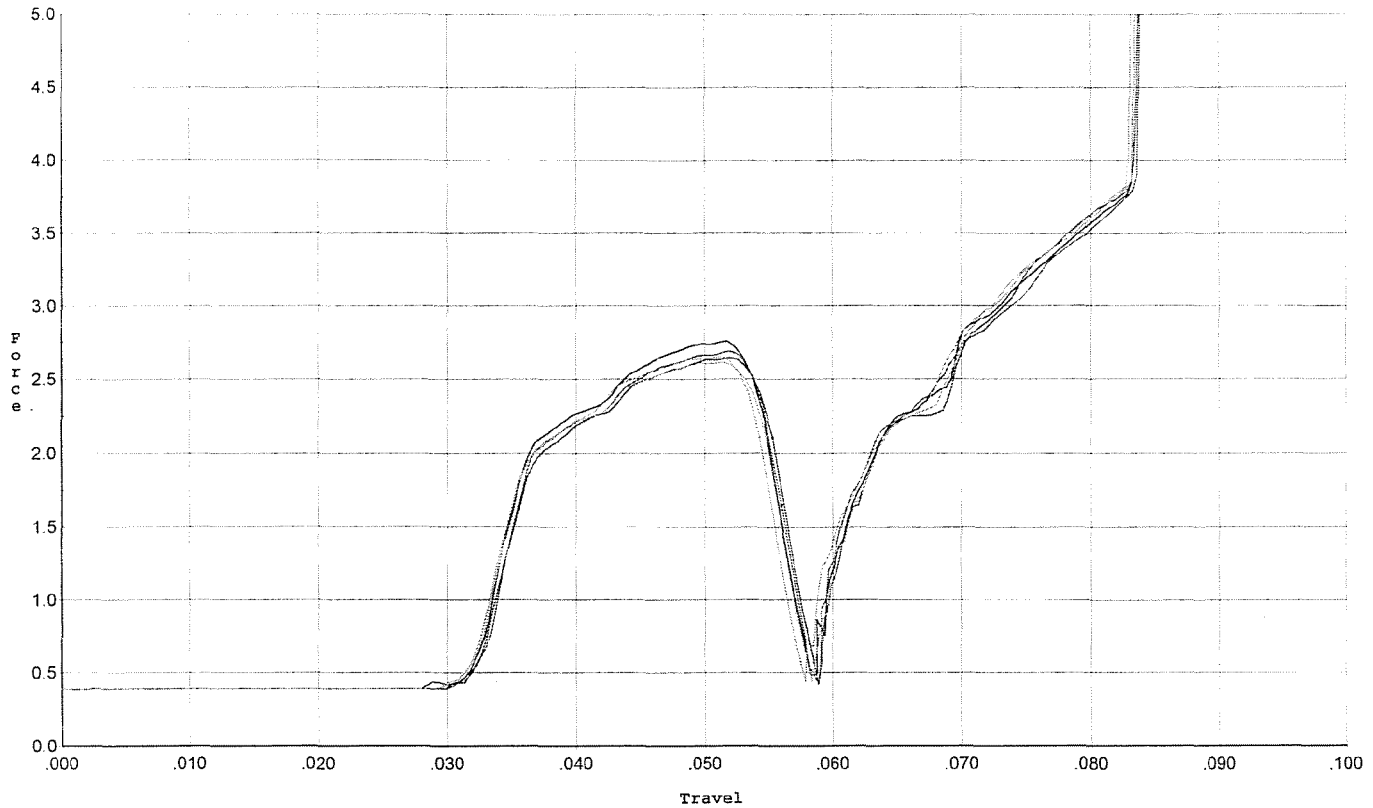
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.443	0.057	0.032	0.028	0.100		Set Trigger
2	4.397	0.058	0.031	0.027	0.101		Set Trigger
3	4.375	0.056	0.031	0.028	0.099		Set Trigger
4	4.343	0.056	0.031	0.028	0.098		Set Trigger
5	4.354	0.057	0.031	0.028	0.099		Set Trigger

A-4.38

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



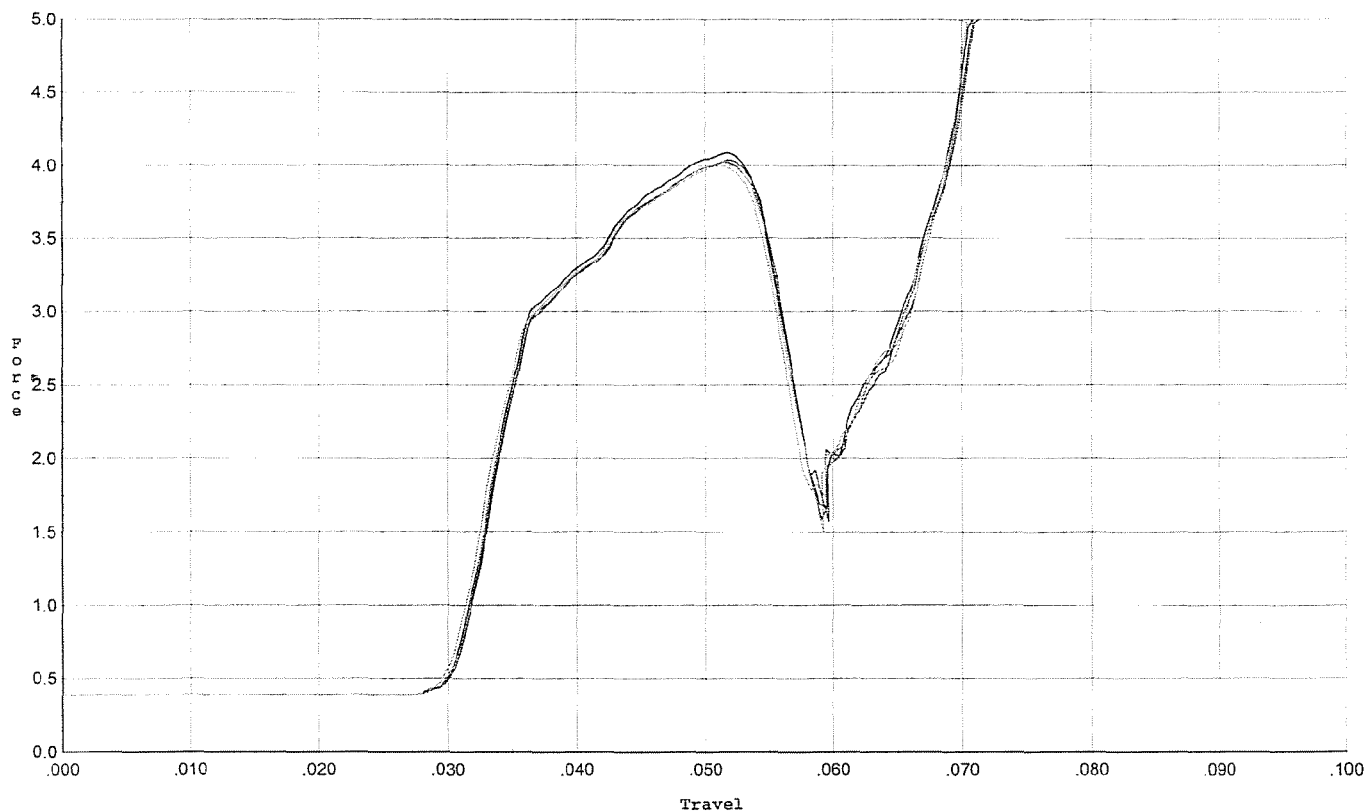
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.646	0.055	0.032	0.034	0.063		Set Trigger
2	2.758	0.055	0.032	0.033	0.064		Set Trigger
3	2.691	0.056	0.033	0.034	0.064		Set Trigger
4	2.612	0.055	0.032	0.033	0.063		Set Trigger
5	2.653	0.054	0.032	0.034	0.062		Set Trigger

A-2.67

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	4.038	0.056	0.030	0.031	0.092		Set Trigger
2	4.087	0.056	0.030	0.031	0.094		Set Trigger
3	4.024	0.056	0.030	0.031	0.093		Set Trigger
4	3.999	0.055	0.030	0.031	0.091		Set Trigger
5	4.028	0.055	0.030	0.031	0.090		Set Trigger

A 4.03