

66794657

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



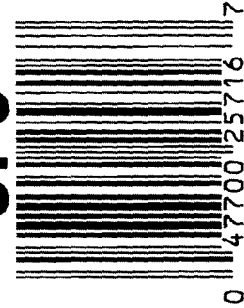
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794657

UPC



GUN SERIAL #

G 6794657

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-28-08	RSR
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/26/08	SP
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		11-5-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-7-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

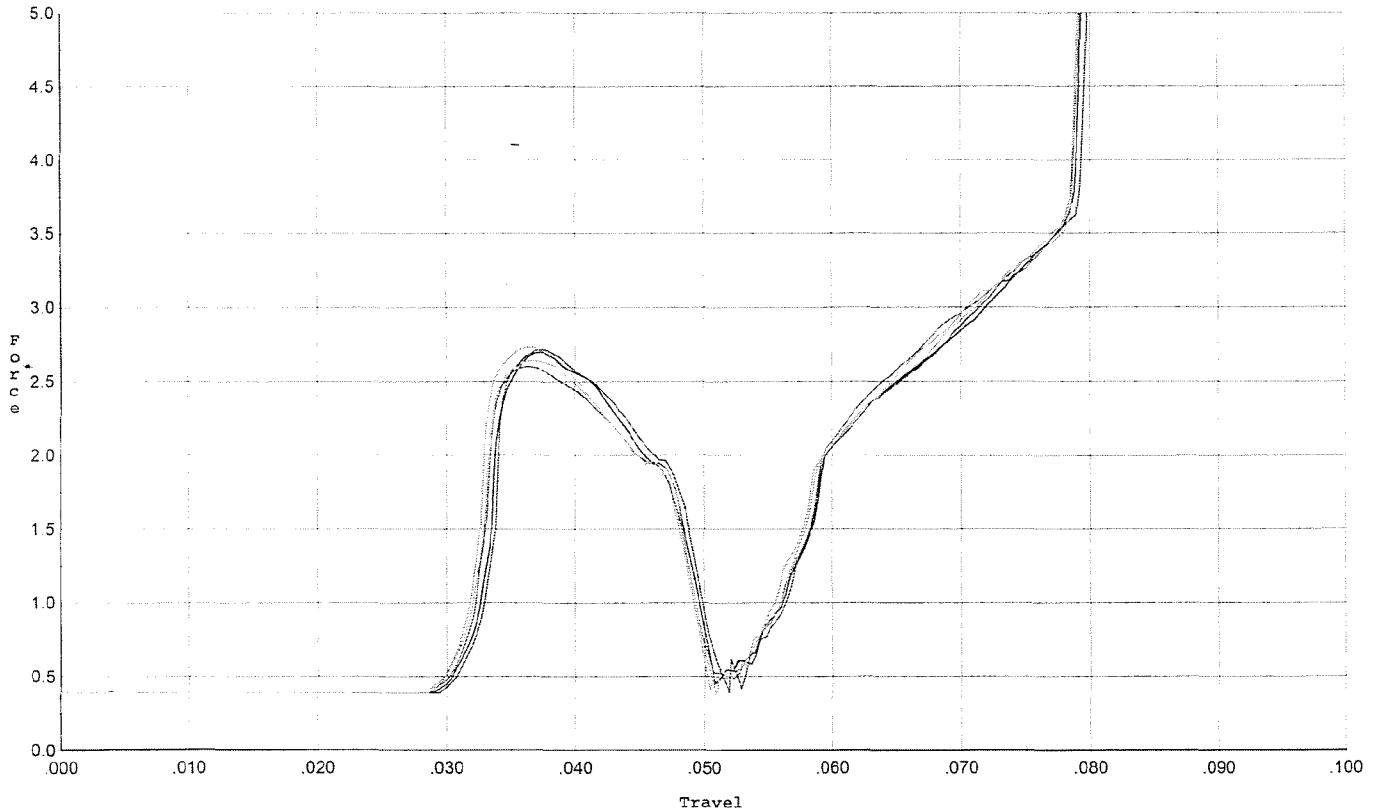
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>50</u>	11-13-08	R. Q
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	11-13-08	R. Q
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	R. Q
	J) ASSEMBLE STOCK		11-7-08	SPD
	K) ASSEMBLE SWIVEL STUDS		11-13-08	R. Q
	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	11-10-08	R. Q
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-10-08	TL
670	FINAL INSPECTION A) HEADSPACE		11-13-08	R. Q
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.63</u> <u>2.41</u> <u>2.46</u> <u>2.55</u> <u>2.54</u>	11-10-08	TL
	C) FUNCTION		11-13-08	R. Q
690	PACK		12-1-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



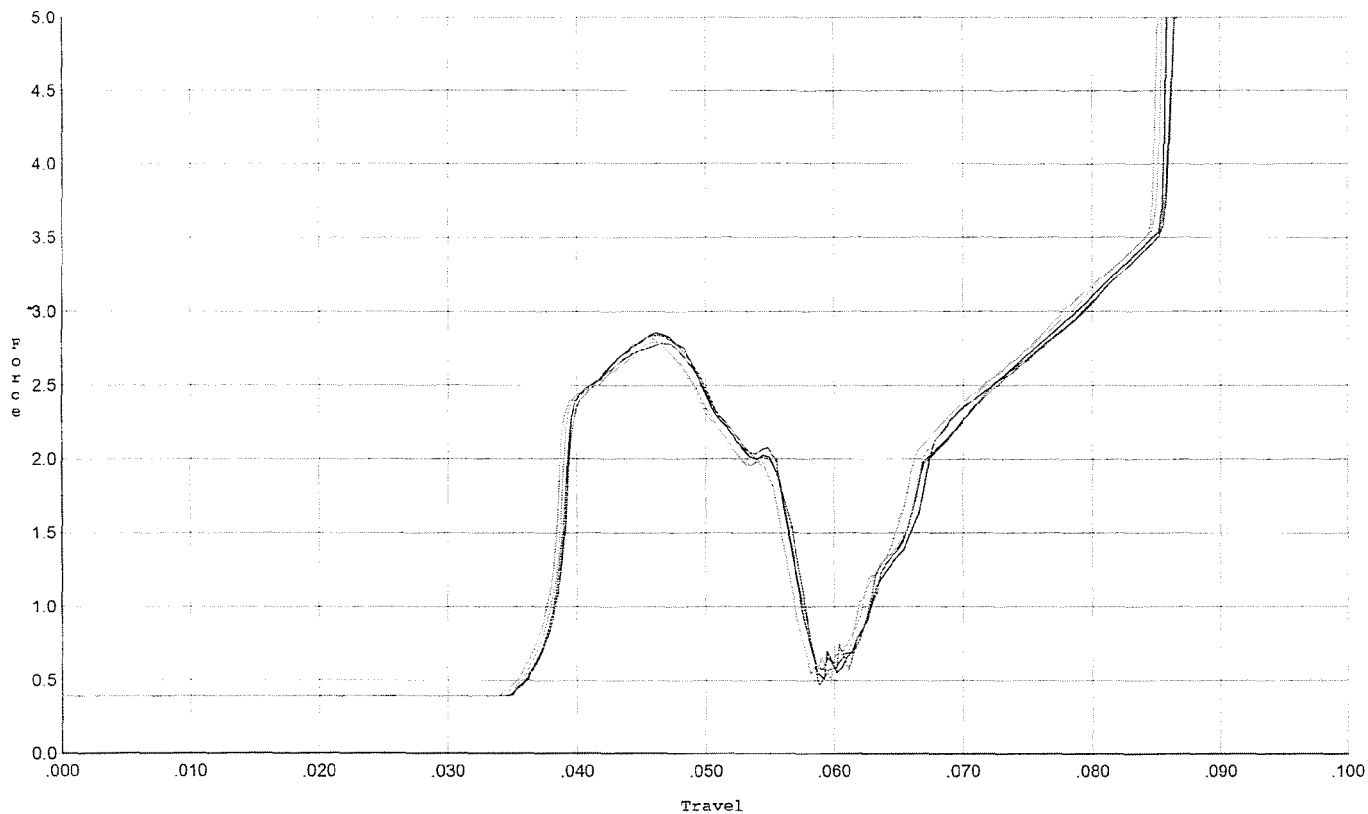
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.718	0.048	0.031	0.035	0.049		Set Trigger
2	2.698	0.049	0.031	0.034	0.050		Set Trigger
3	2.599	0.048	0.031	0.035	0.048		Set Trigger
4	2.639	0.048	0.030	0.035	0.049		Set Trigger
5	2.734	0.048	0.030	0.034	0.050		Set Trigger

A 267

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



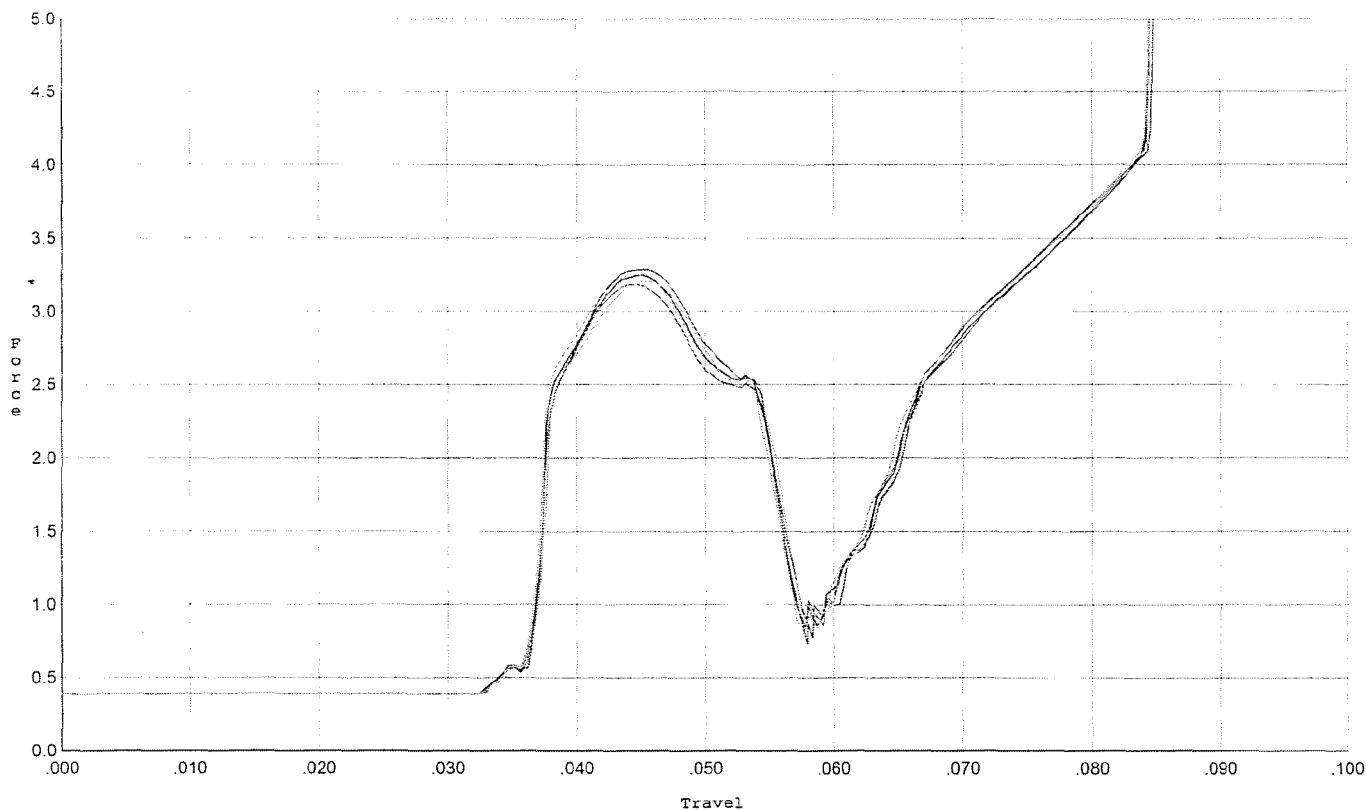
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.788	0.057	0.037	0.036	0.059		Set Trigger
2	2.858	0.056	0.037	0.036	0.058		Set Trigger
3	2.842	0.055	0.037	0.037	0.058		Set Trigger
4	2.793	0.055	0.036	0.036	0.056		Set Trigger
5	2.831	0.055	0.036	0.036	0.057		Set Trigger

A-2.82

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



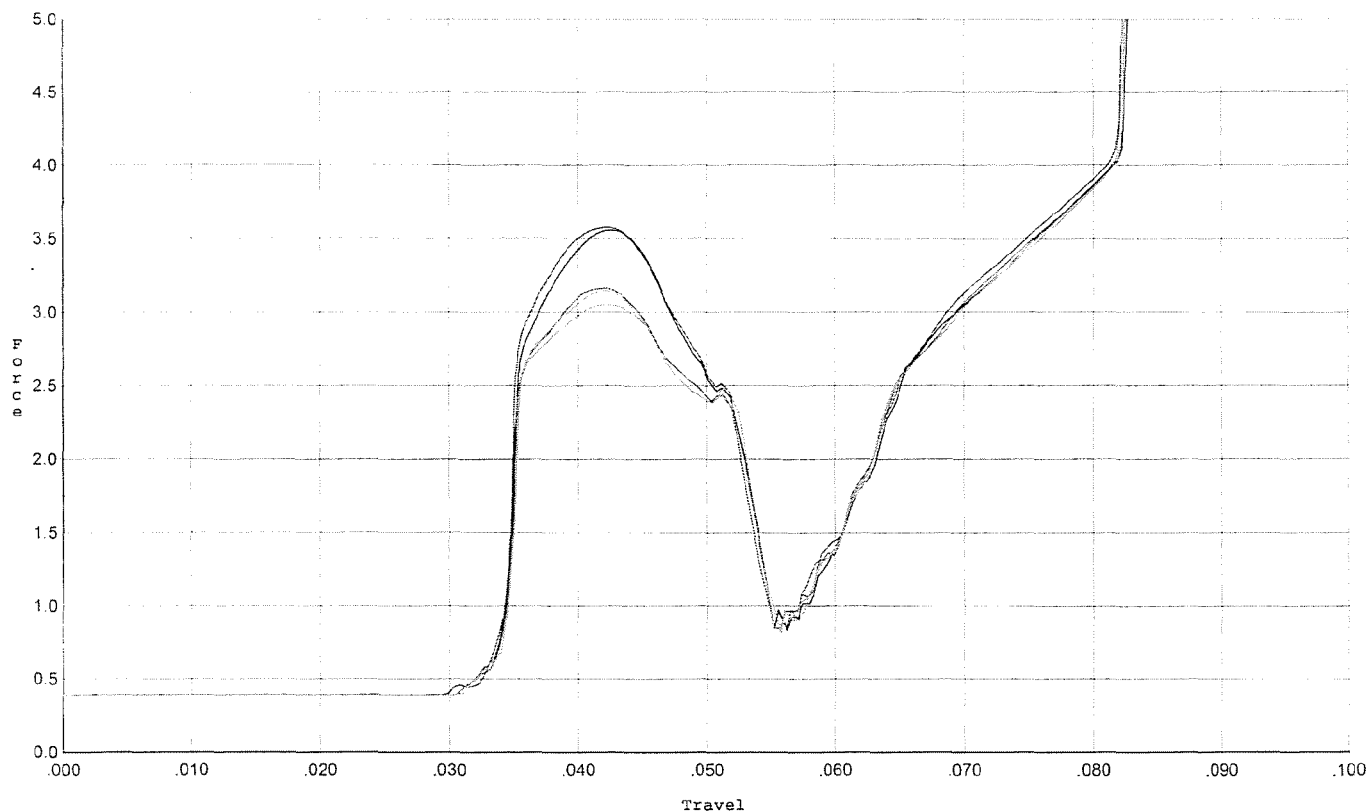
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.286	0.054	0.036	0.036	0.065		Set Trigger
2	3.251	0.054	0.036	0.035	0.065		Set Trigger
3	3.185	0.055	0.036	0.036	0.064		Set Trigger
4	3.204	0.055	0.036	0.035	0.066		Set Trigger
5	3.255	0.055	0.036	0.035	0.066		Set Trigger

A-3-23

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

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



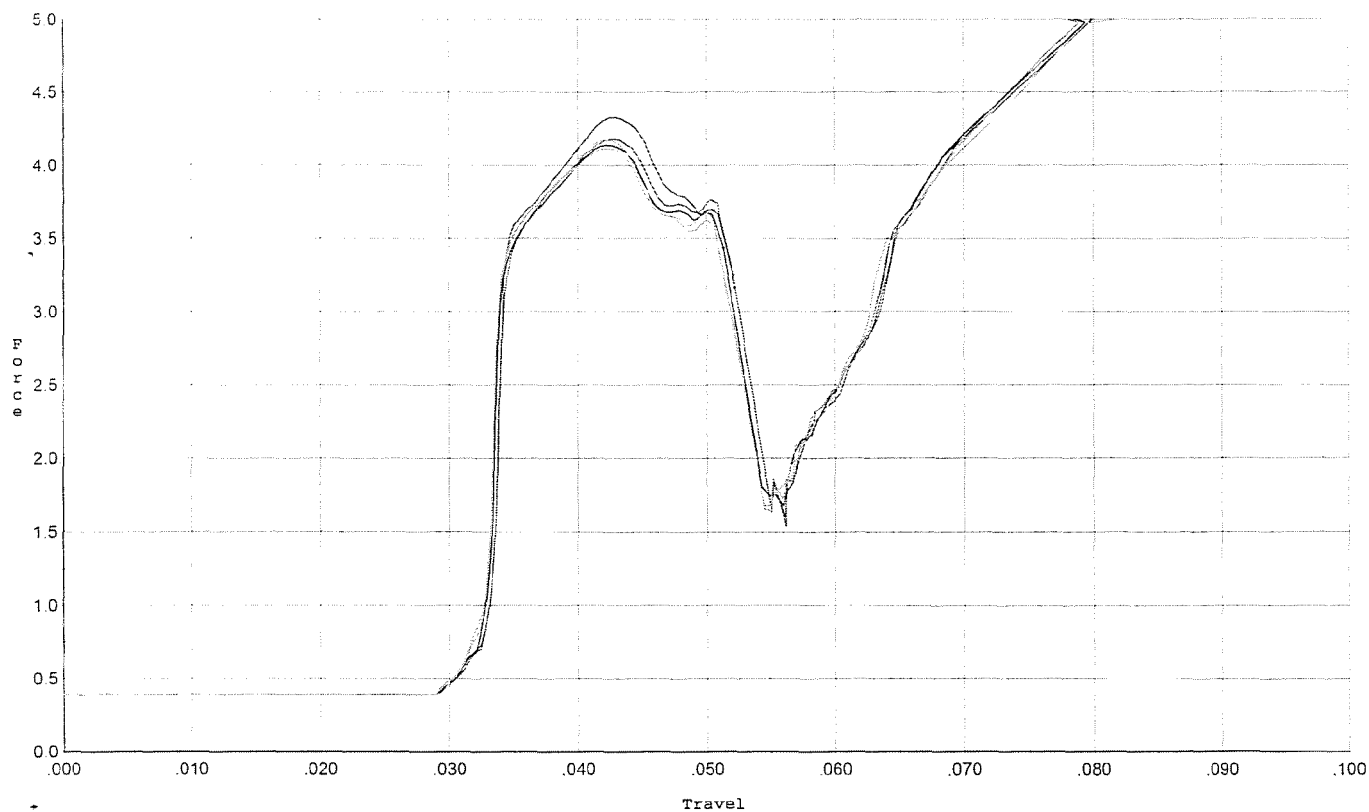
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.576	0.053	0.033	0.034	0.070		Set Trigger
2	3.557	0.053	0.034	0.035	0.069		Set Trigger
3	3.164	0.052	0.034	0.035	0.063		Set Trigger
4	3.145	0.053	0.033	0.035	0.064		Set Trigger
5	3.052	0.052	0.034	0.034	0.063		Set Trigger

A-3-29

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



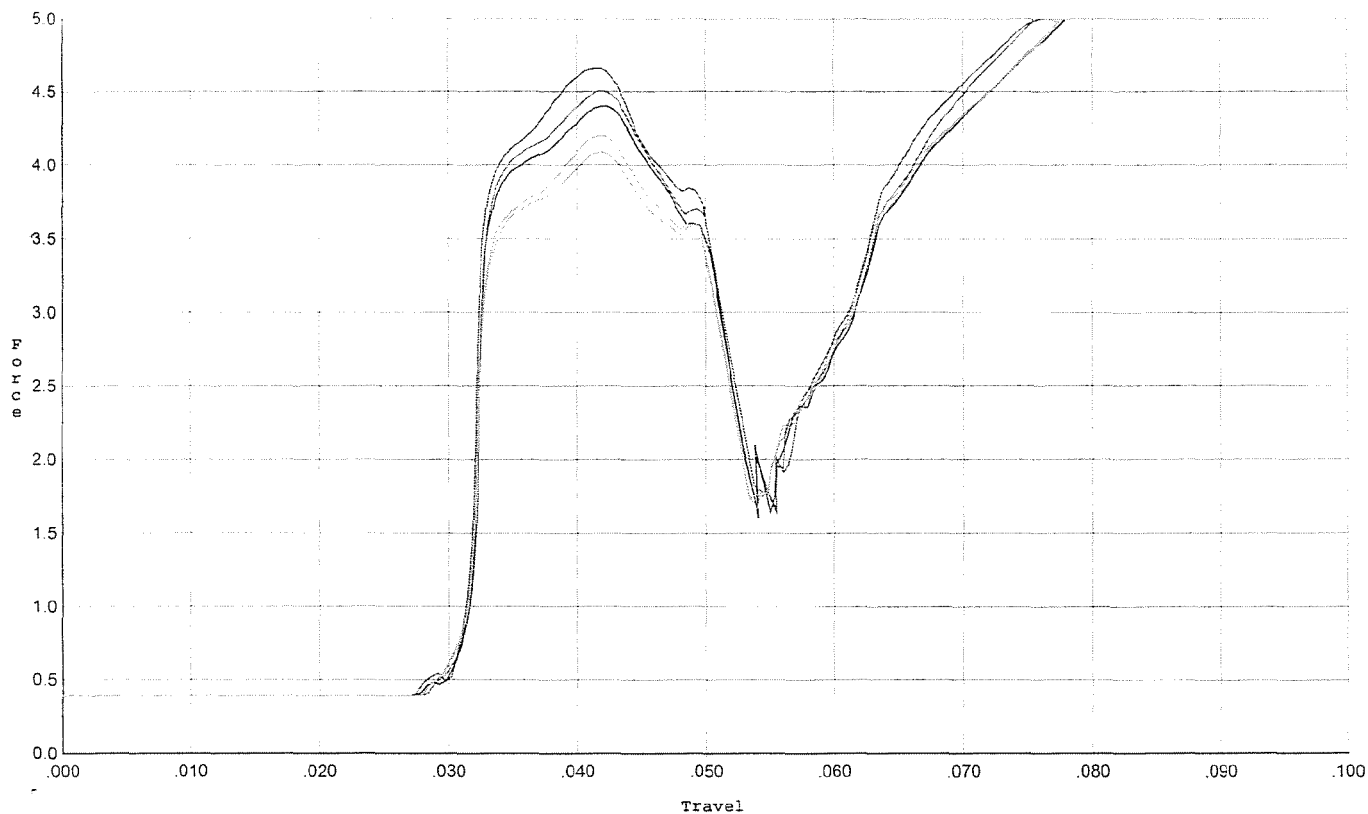
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.328	0.052	0.031	0.032	0.087		Set Trigger
2	4.131	0.051	0.031	0.033	0.083		Set Trigger
3	4.174	0.052	0.032	0.032	0.085		Set Trigger
4	4.112	0.052	0.031	0.032	0.084		Set Trigger
5	4.168	0.052	0.031	0.032	0.085		Set Trigger

A: 4.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



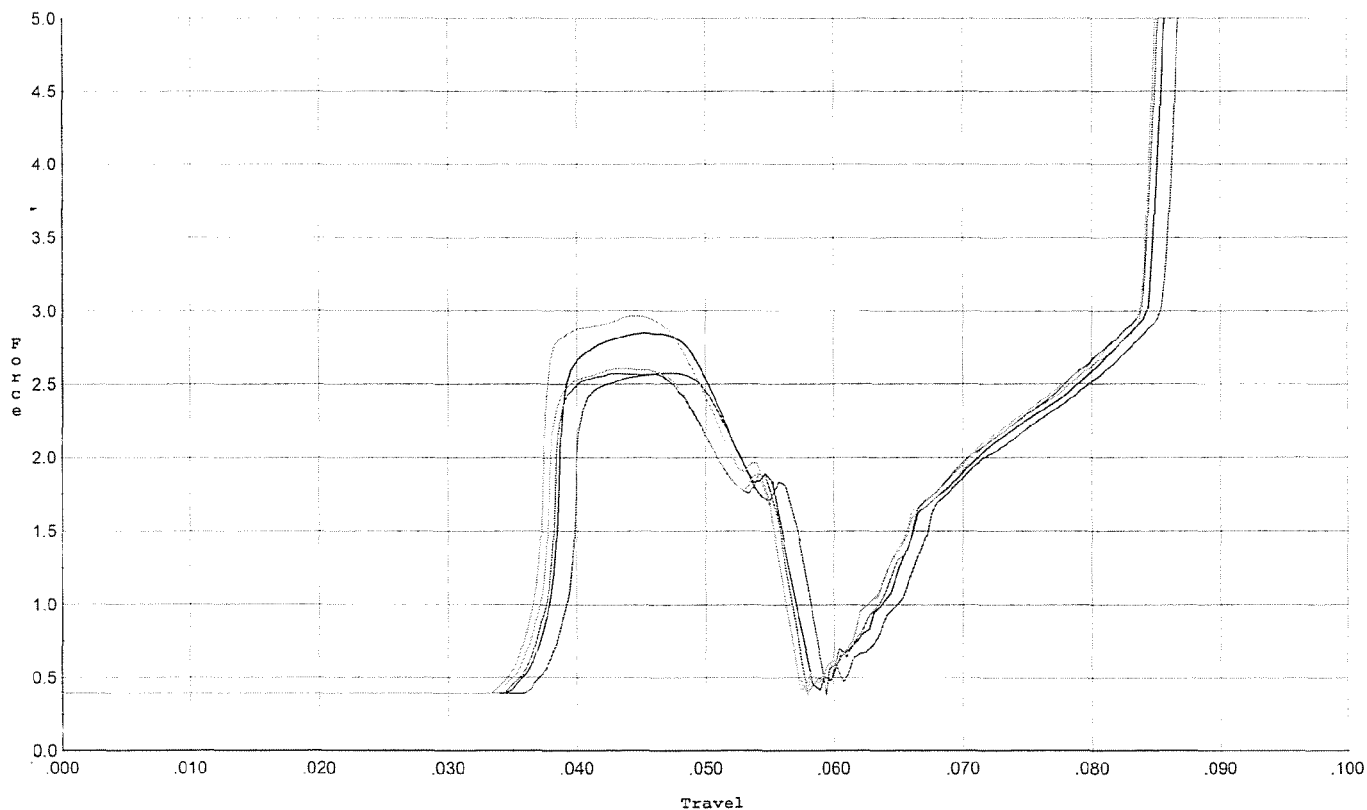
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.663	0.050	0.028	0.032	0.090		Set Trigger
2	4.402	0.050	0.030	0.032	0.087		Set Trigger
3	4.505	0.050	0.029	0.032	0.087		Set Trigger
4	4.088	0.051	0.030	0.032	0.084		Set Trigger
5	4.200	0.051	0.028	0.032	0.085		Set Trigger

A-24-37

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

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



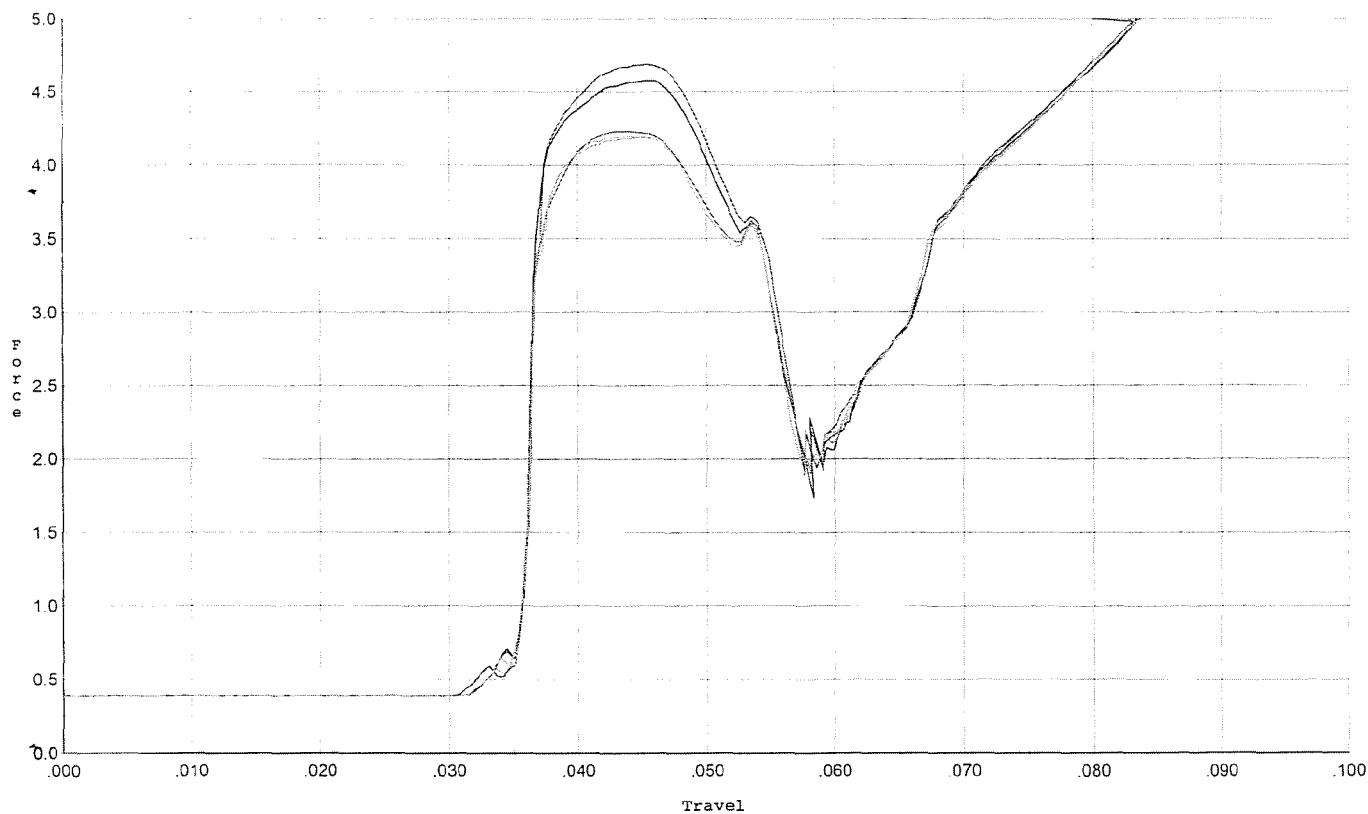
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.577	0.057	0.038	0.036	0.056		Set Trigger
2	2.850	0.055	0.037	0.037	0.059		Set Trigger
3	2.574	0.056	0.036	0.036	0.056		Set Trigger
4	2.607	0.055	0.036	0.036	0.056		Set Trigger
5	2.966	0.055	0.035	0.036	0.061		Set Trigger

A-2.71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: set at 4.0 lbs +/- 10 lbs for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.690	0.055	0.035	0.033	0.095		Set Trigger
2	4.574	0.054	0.034	0.033	0.092		Set Trigger
3	4.227	0.054	0.034	0.034	0.087		Set Trigger
4	4.196	0.054	0.034	0.033	0.086		Set Trigger
5	4.194	0.054	0.035	0.033	0.087		Set Trigger

A 4.37