

5679 4665-

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



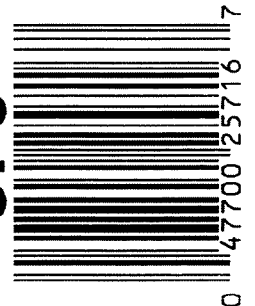
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794665

UPC



GUN SERIAL # G 6794665

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE		2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	(A)	3/5/09	(P)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	MR
540	APPLY COATINGS (BARREL ACTION)		3/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-11-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

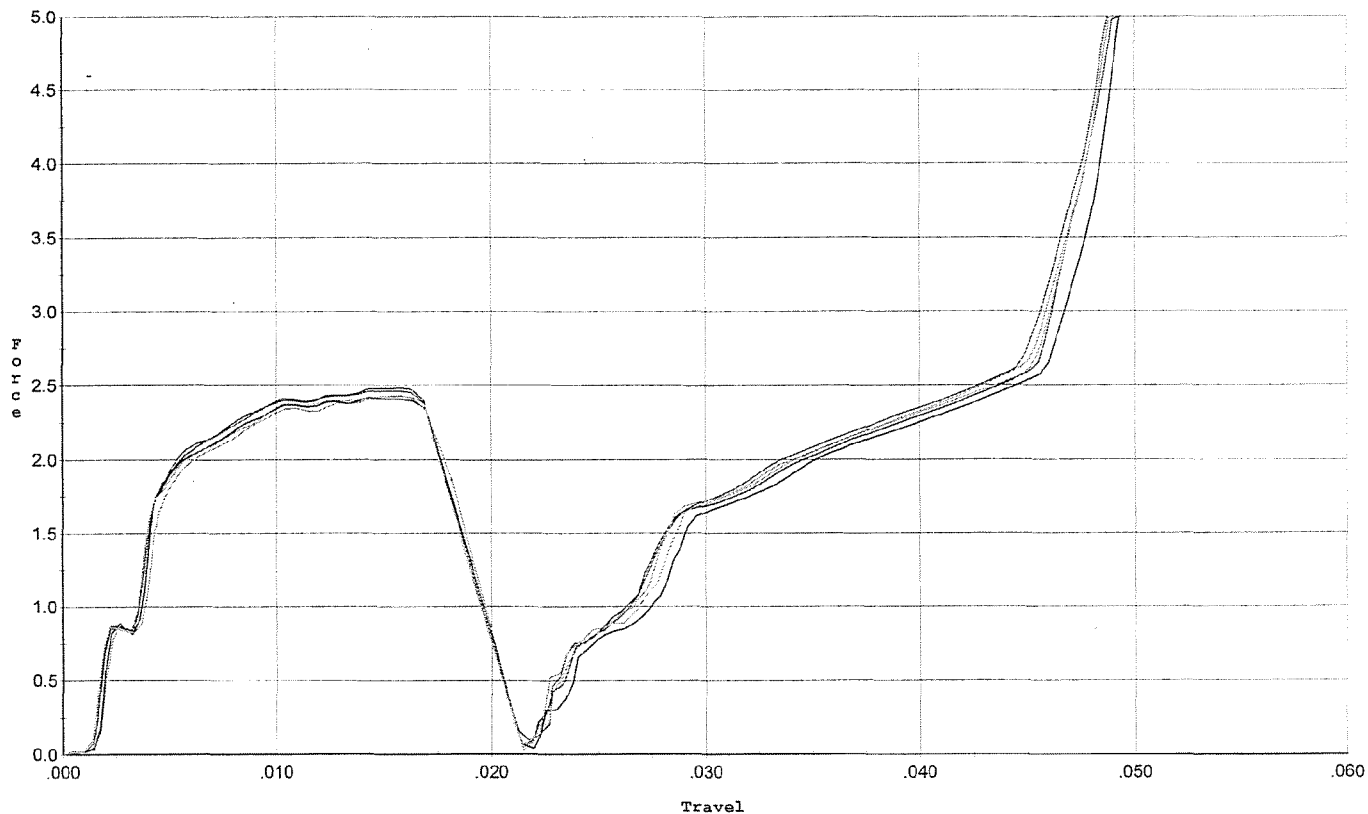
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>6</u>	3-19-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-19-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	3-19-09	W/W
	J) ASSEMBLE STOCK		3-19-09	R.P.D.
	K) ASSEMBLE SWIVEL STUDS		3-19-09	W/W
	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	3-16-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	W/W
670	FINAL INSPECTION A) HEADSPACE		3-19-09	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.72</u> <u>2.70</u> <u>2.74</u> <u>2.76</u>	3-18-09	TL
	C) FUNCTION		3-19-09	W/W
690	PACK		3/20/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



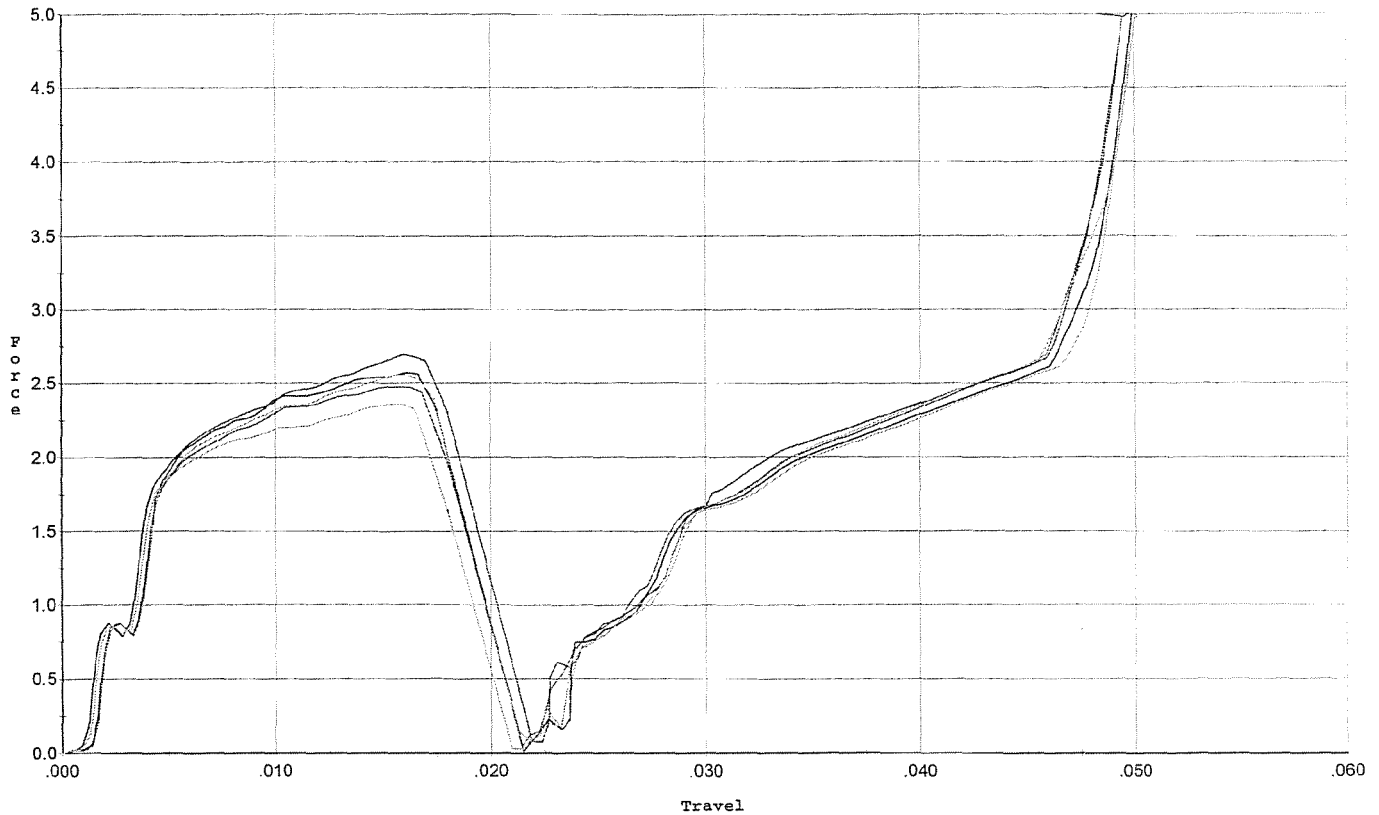
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.482	0.019	0.004	0.035	0.034		Set Trigger
2	2.420	0.017	0.00	0.036	0.029		Set Trigger
3	2.464	0.017	0.00	0.035	0.030		Set Trigger
4	2.432	0.017	0.004	0.035	0.030		Set Trigger
5	2.425	0.018	0.00	0.035	0.031		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



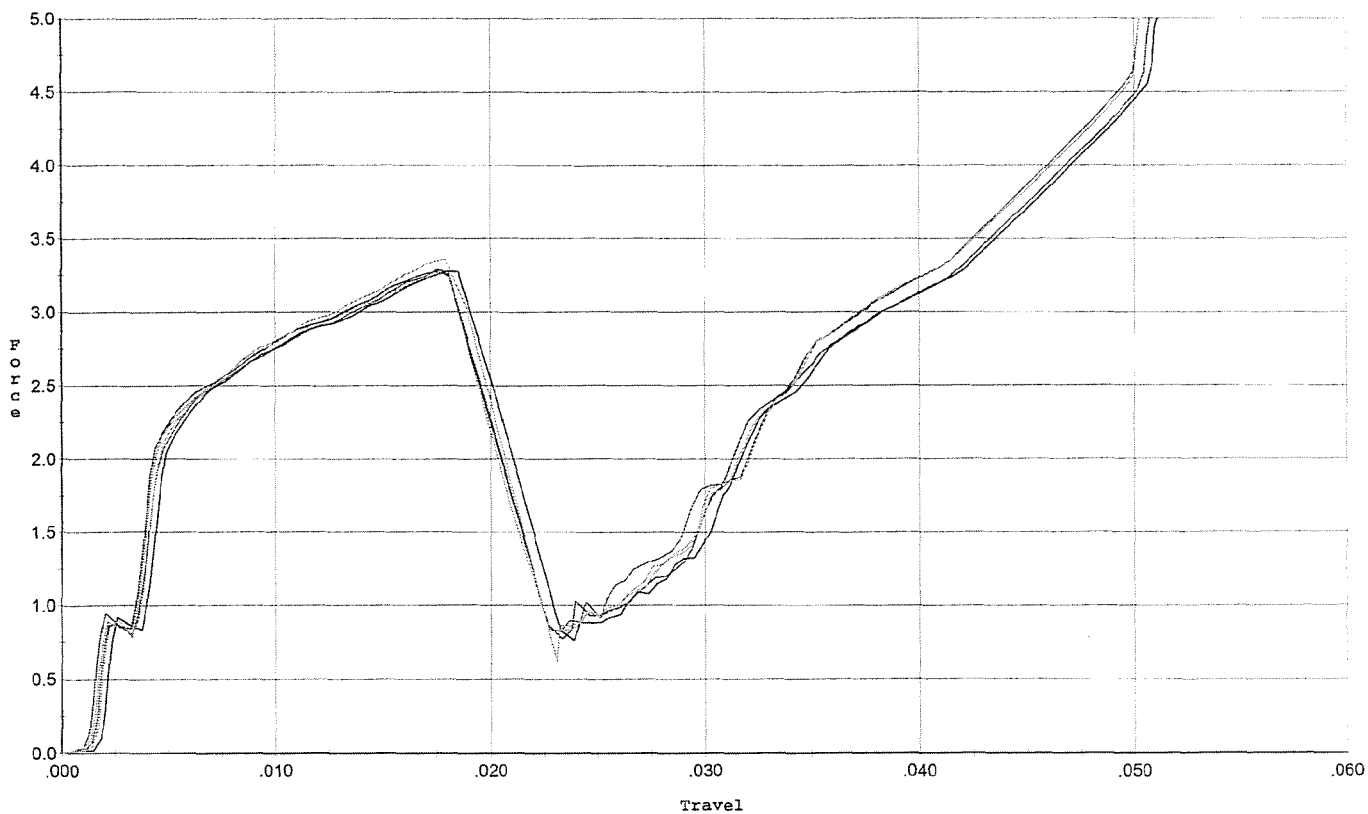
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.696	0.018	0.00	0.035	0.033		Set Trigger
2	2.571	0.017	0.00	0.036	0.032		Set Trigger
3	2.474	0.018	0.00	0.035	0.032		Set Trigger
4	2.360	0.018	0.00	0.036	0.030		Set Trigger
5	2.557	0.017	0.00	0.036	0.031		Set Trigger

A. 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



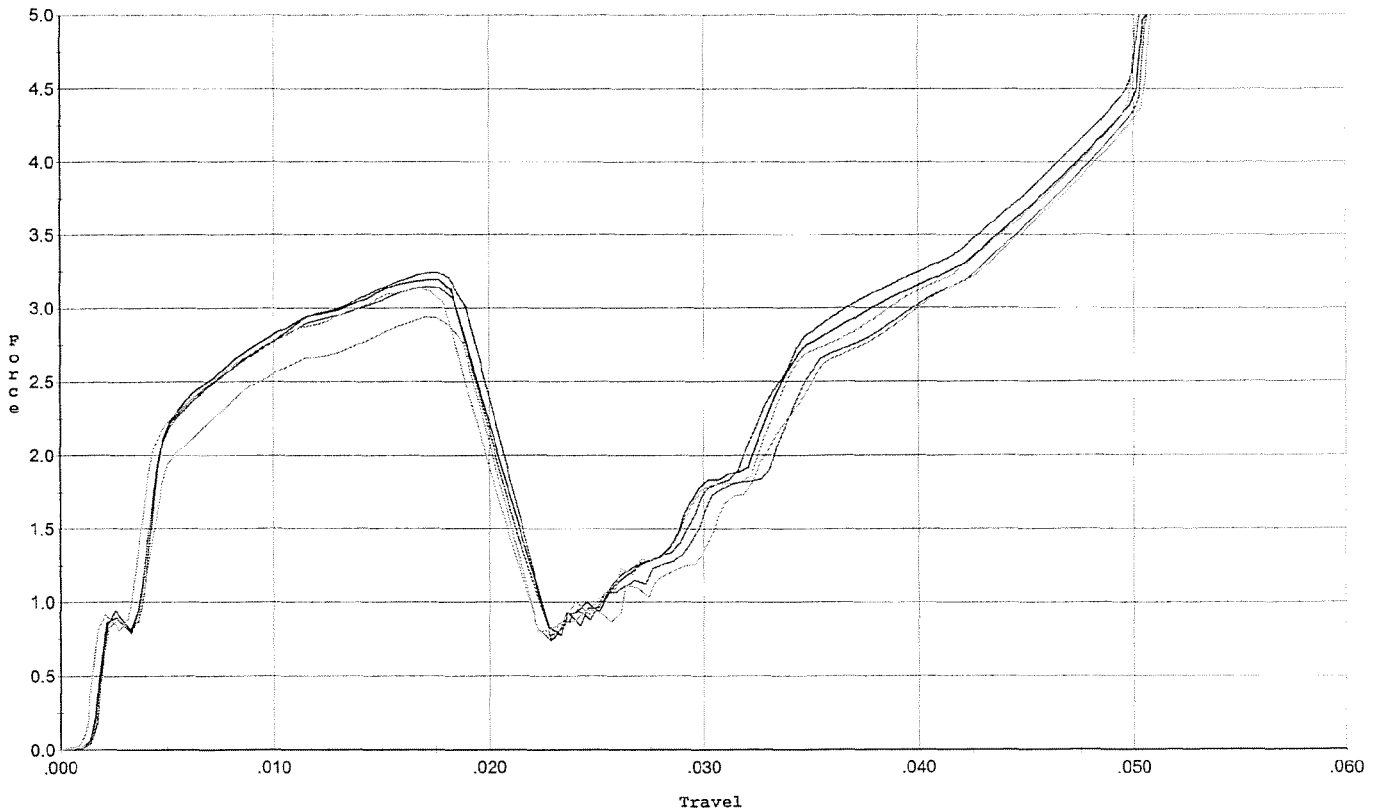
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.273	0.018	0.003	0.034	0.040		Set Trigger
2	3.280	0.021	0.002	0.033	0.044		Set Trigger
3	3.289	0.020	0.004	0.033	0.044		Set Trigger
4	3.360	0.019	0.00	0.033	0.042		Set Trigger
5	3.282	0.018	0.004	0.034	0.040		Set Trigger

A.3.29

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



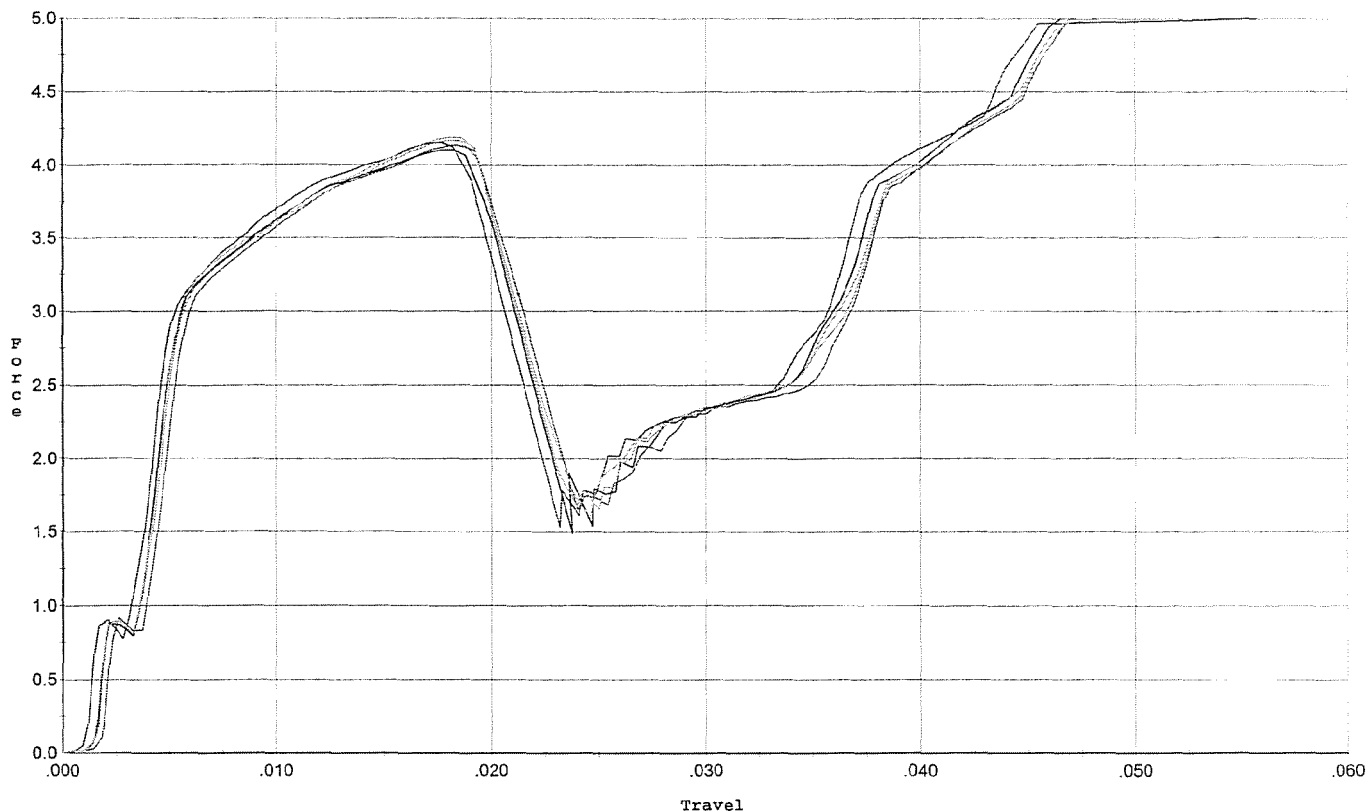
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.244	0.019	0.00	0.033	0.041		Set Trigger
2	3.192	0.018	0.00	0.034	0.040		Set Trigger
3	3.147	0.018	0.00	0.034	0.039		Set Trigger
4	3.134	0.018	0.00	0.034	0.039		Set Trigger
5	2.937	0.019	0.00	0.034	0.037		Set Trigger

A-3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



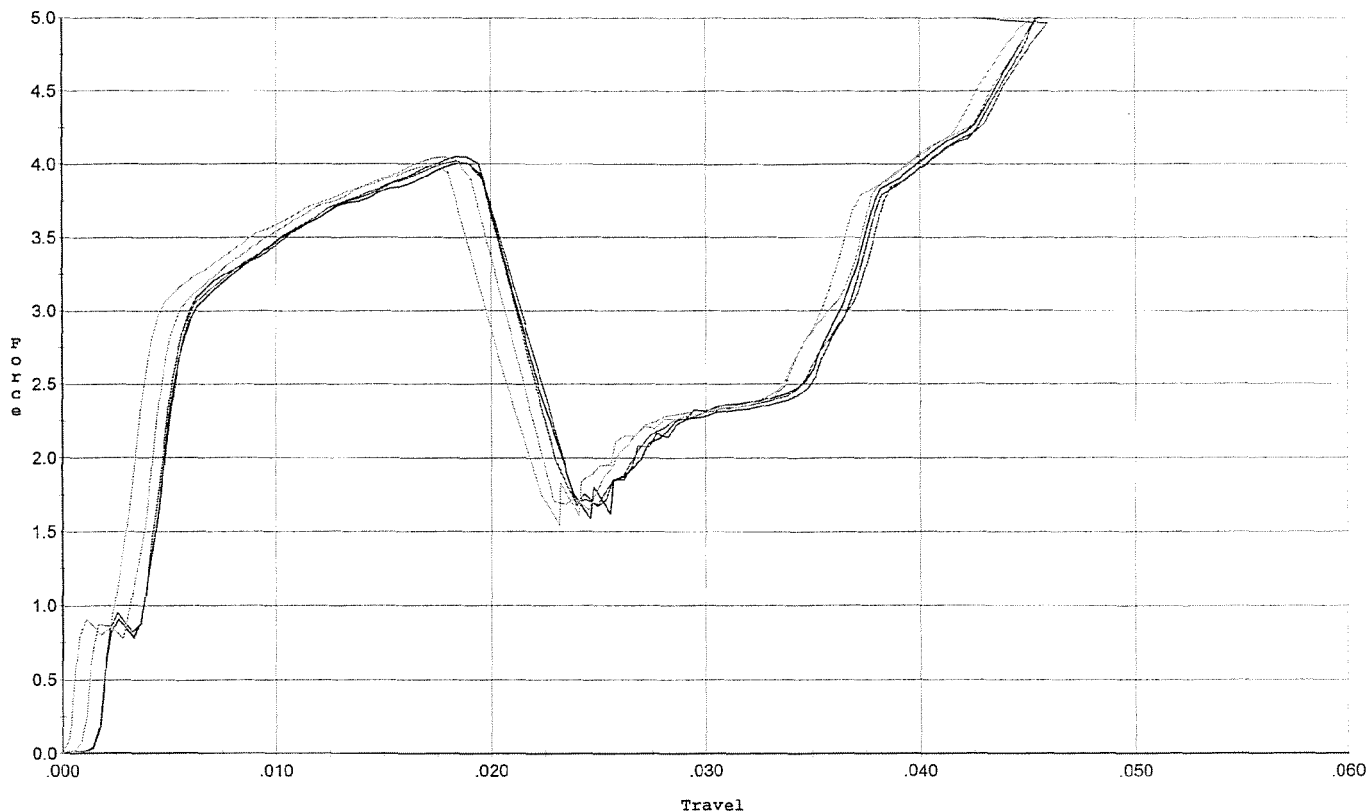
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.152	0.019	0.00	0.028	0.054		Set Trigger
2	4.102	0.020	0.004	0.029	0.055		Set Trigger
3	4.134	0.021	0.004	0.029	0.058		Set Trigger
4	4.185	0.019	0.00	0.032	0.054		Set Trigger
5	4.165	0.019	0.00	0.032	0.054		Set Trigger

A. 4.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



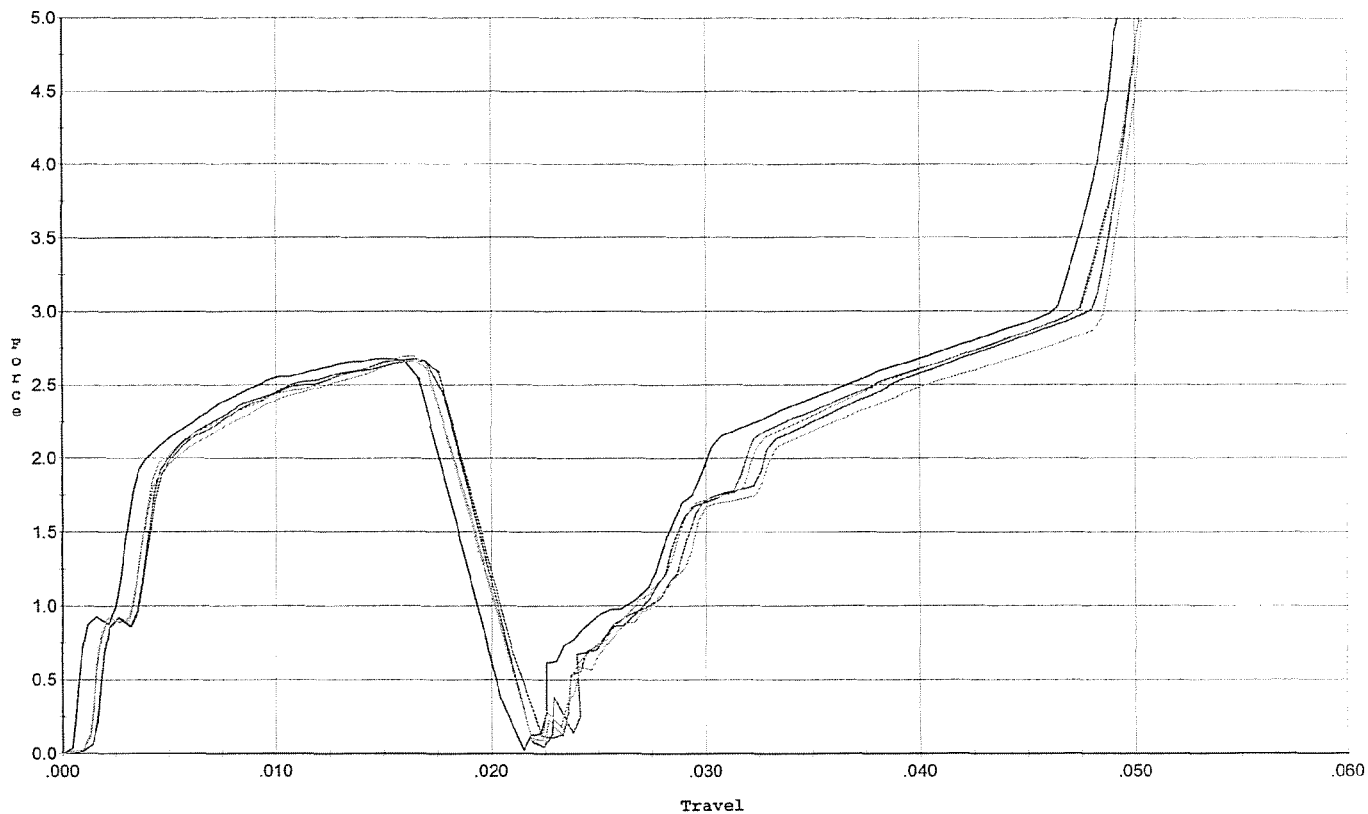
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.051	0.022	0.00	0.027	0.058		Set Trigger
2	4.004	0.020	0.00	0.028	0.052		Set Trigger
3	4.018	0.020	0.00	0.028	0.052		Set Trigger
4	3.993	0.018	0.00	0.029	0.051		Set Trigger
5	4.048	0.019	0.003	0.029	0.053		Set Trigger

A-4.02

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



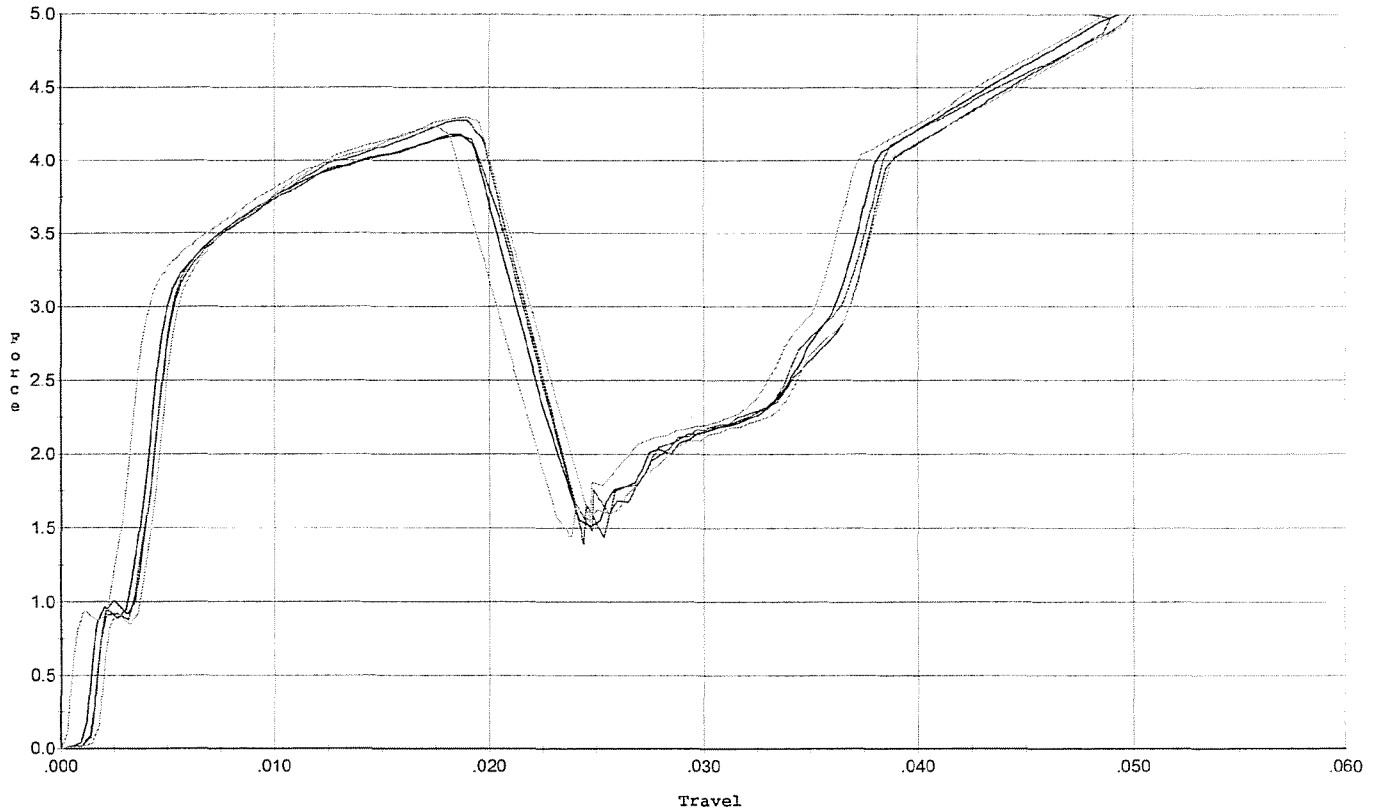
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.678	0.018	0.00	0.036	0.034		Set Trigger
2	2.679	0.017	0.00	0.035	0.033		Set Trigger
3	2.664	0.018	0.00	0.035	0.033		Set Trigger
4	2.659	0.019	0.00	0.036	0.036		Set Trigger
5	2.696	0.019	0.003	0.035	0.036		Set Trigger

A-2-67

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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	4.169	0.021	0.00	0.032	0.059		Set Trigger
2	4.179	0.019	0.00	0.032	0.056		Set Trigger
3	4.274	0.020	0.00	0.032	0.057		Set Trigger
4	4.299	0.022	0.00	0.032	0.063		Set Trigger
5	4.231	0.018	0.00	0.032	0.054		Set Trigger

A-4.23