

66794715

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



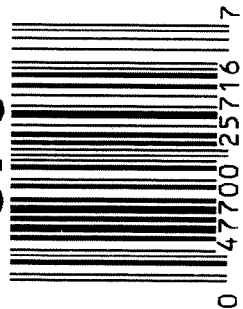
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794715

UPC



GUN SERIAL #

G 6794715

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	10-8-08	ESN
475	DRILL AND TAP SIGHT HOLES	JUL 2008	10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/11/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-29-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

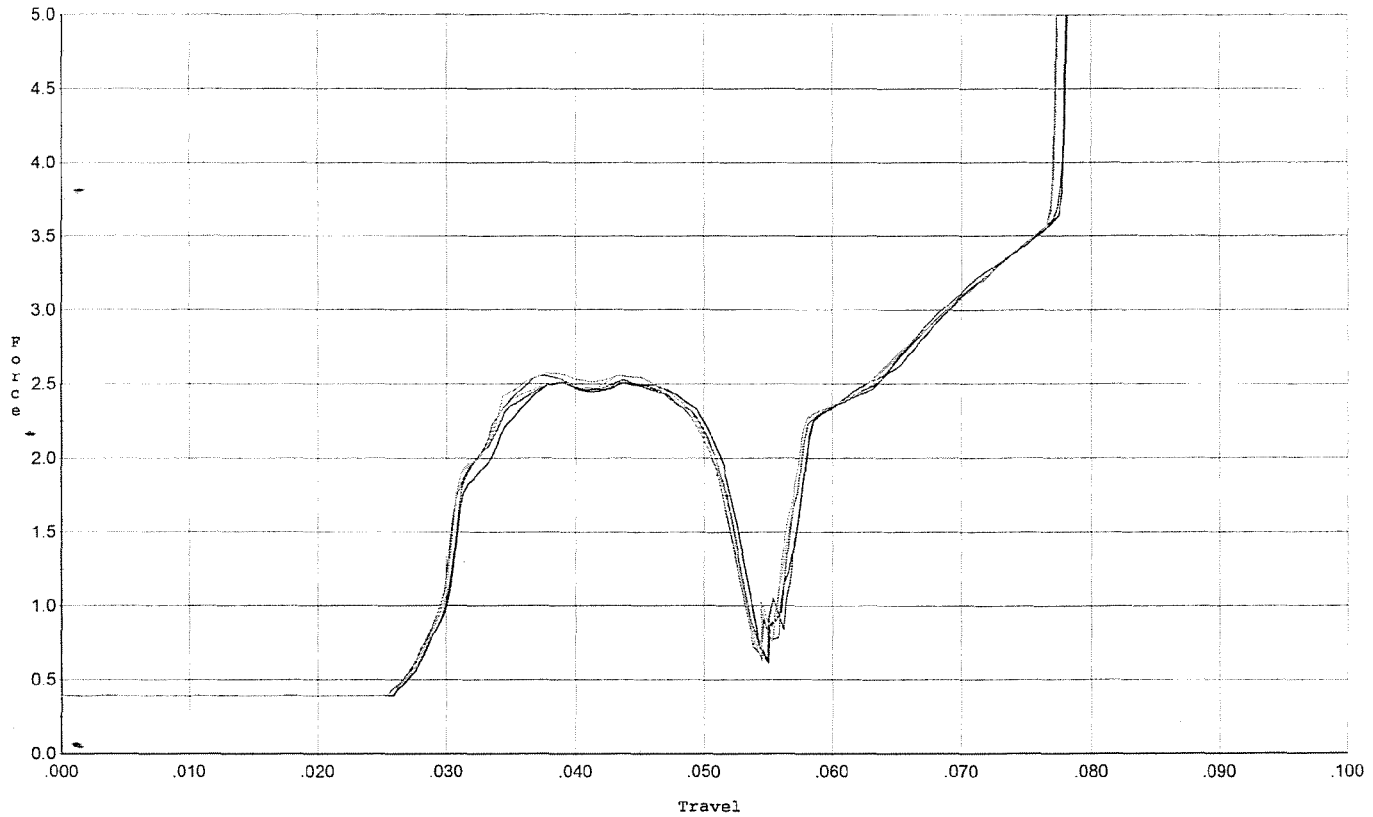
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>3.0</u>	11-11-08	L. D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-11-08	R. D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-11-08	L. D.
	J) ASSEMBLE STOCK		10-29-08	KJZ
	K) ASSEMBLE SWIVEL STUDS		11-11-08	L. 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	10-30-08	Ren
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TK
670	FINAL INSPECTION A) HEADSPACE		11-11-08	L. D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.35</u> <u>2.38</u> <u>2.39</u> <u>2.30</u>	11/5/08	Fry
	C) FUNCTION		11-11-08	L. D.
690	PACK		11/11/08	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



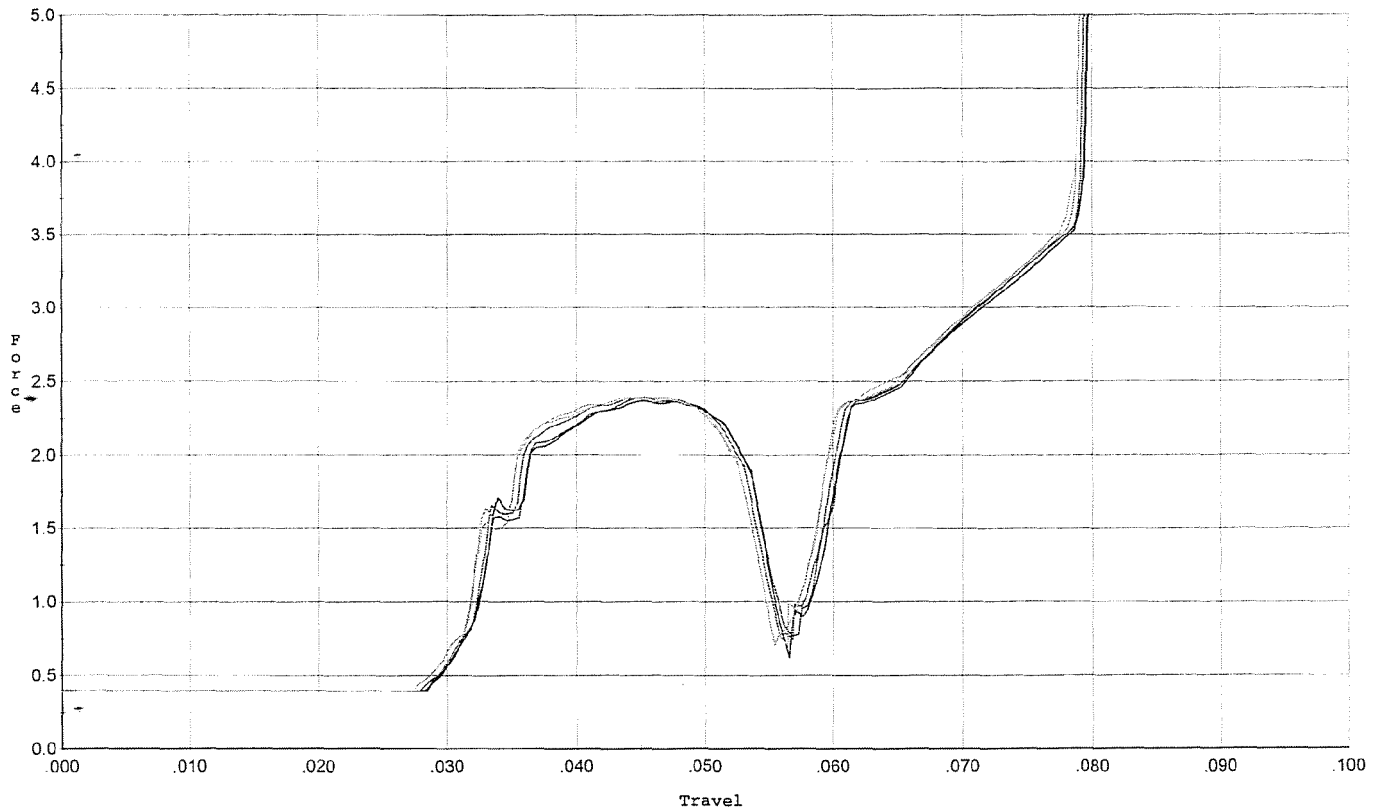
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.526	0.052	0.028	0.031	0.062		Set Trigger
2	2.511	0.053	0.028	0.031	0.063		Set Trigger
3	2.561	0.051	0.028	0.031	0.062		Set Trigger
4	2.555	0.052	0.028	0.030	0.063		Set Trigger
5	2.576	0.052	0.028	0.030	0.064		Set Trigger

A-254

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



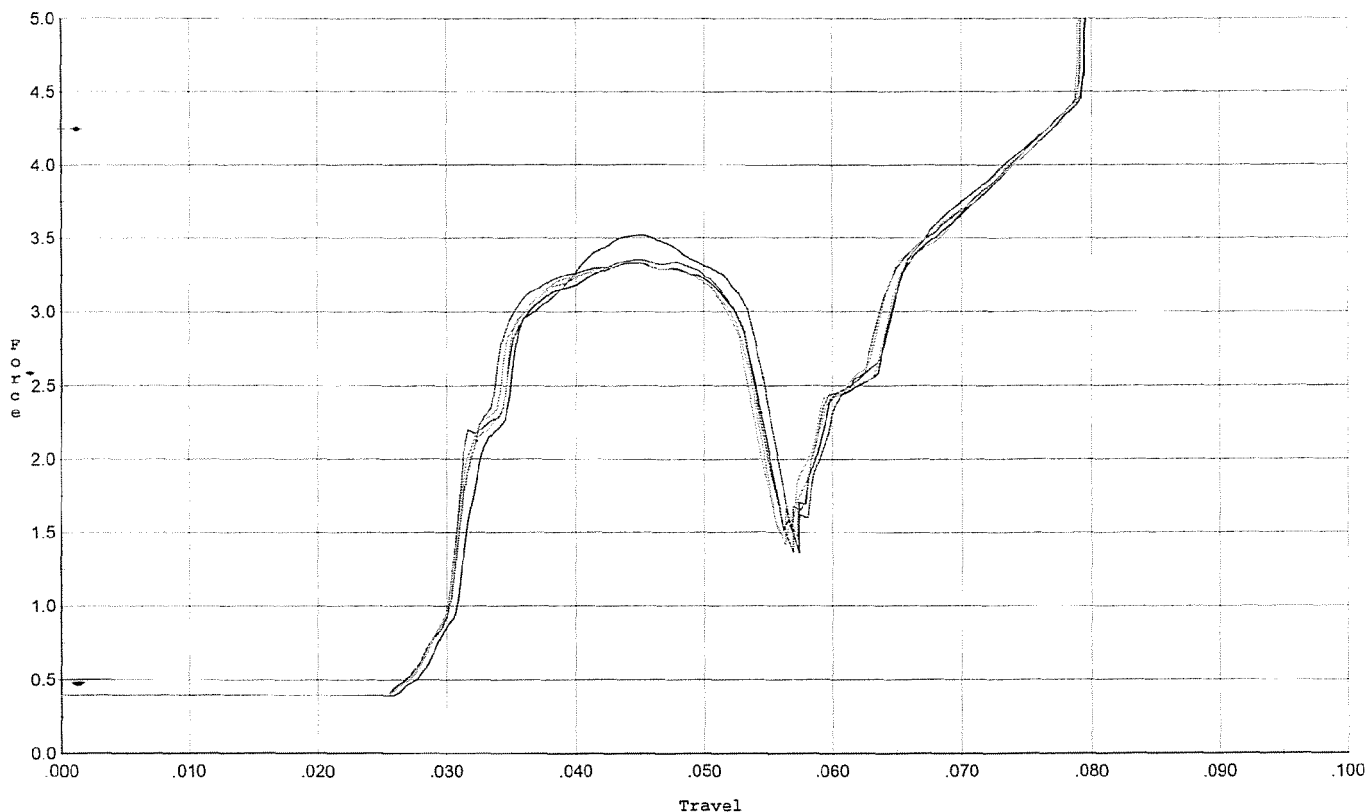
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.393	0.054	0.031	0.032	0.059		Set Trigger
2	2.364	0.054	0.031	0.032	0.059		Set Trigger
3	2.383	0.053	0.030	0.032	0.058		Set Trigger
4	2.392	0.054	0.030	0.032	0.060		Set Trigger
5	2.390	0.054	0.030	0.032	0.060		Set Trigger

A-238

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



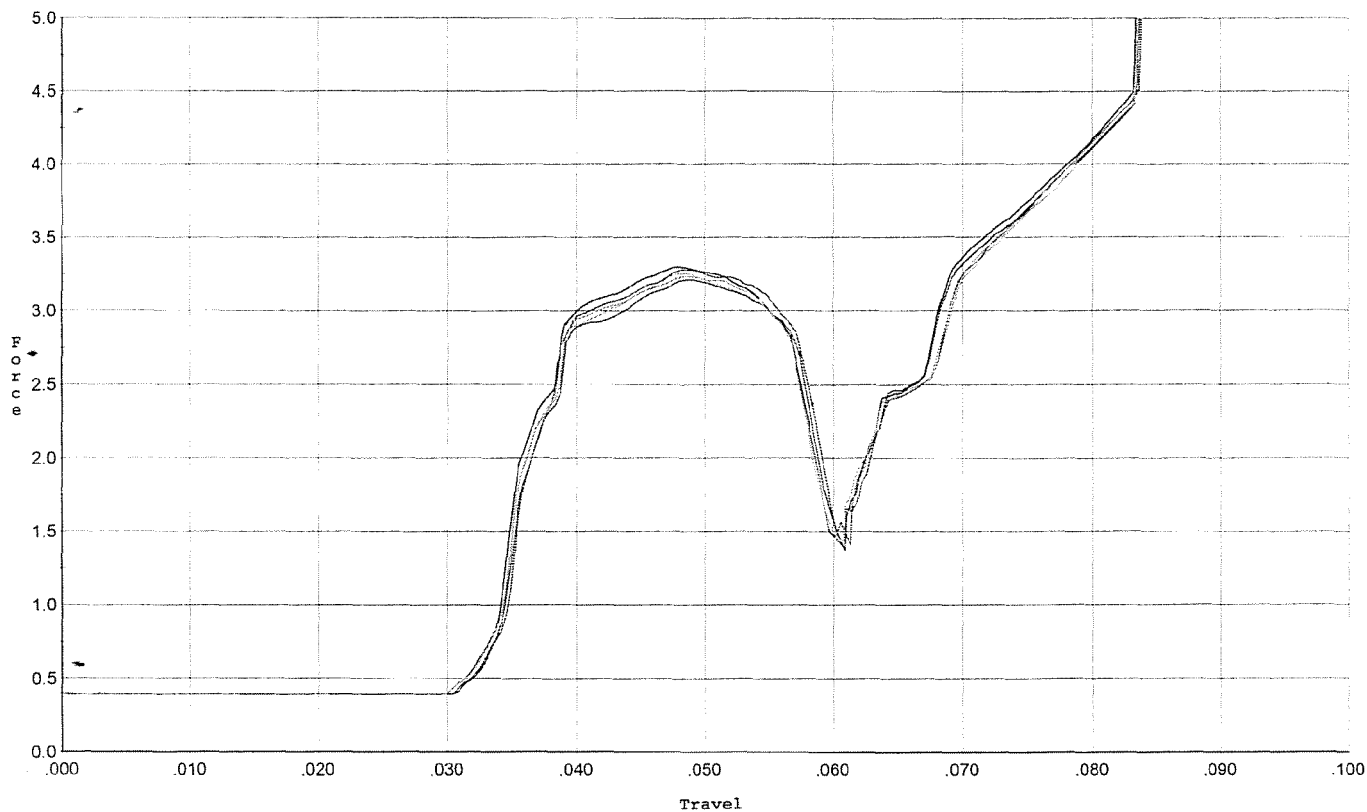
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.518	0.055	0.028	0.029	0.086		Set Trigger
2	3.329	0.054	0.029	0.030	0.082		Set Trigger
3	3.355	0.053	0.028	0.030	0.082		Set Trigger
4	3.336	0.053	0.028	0.030	0.082		Set Trigger
5	3.334	0.053	0.028	0.030	0.080		Set Trigger

A-3.37

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



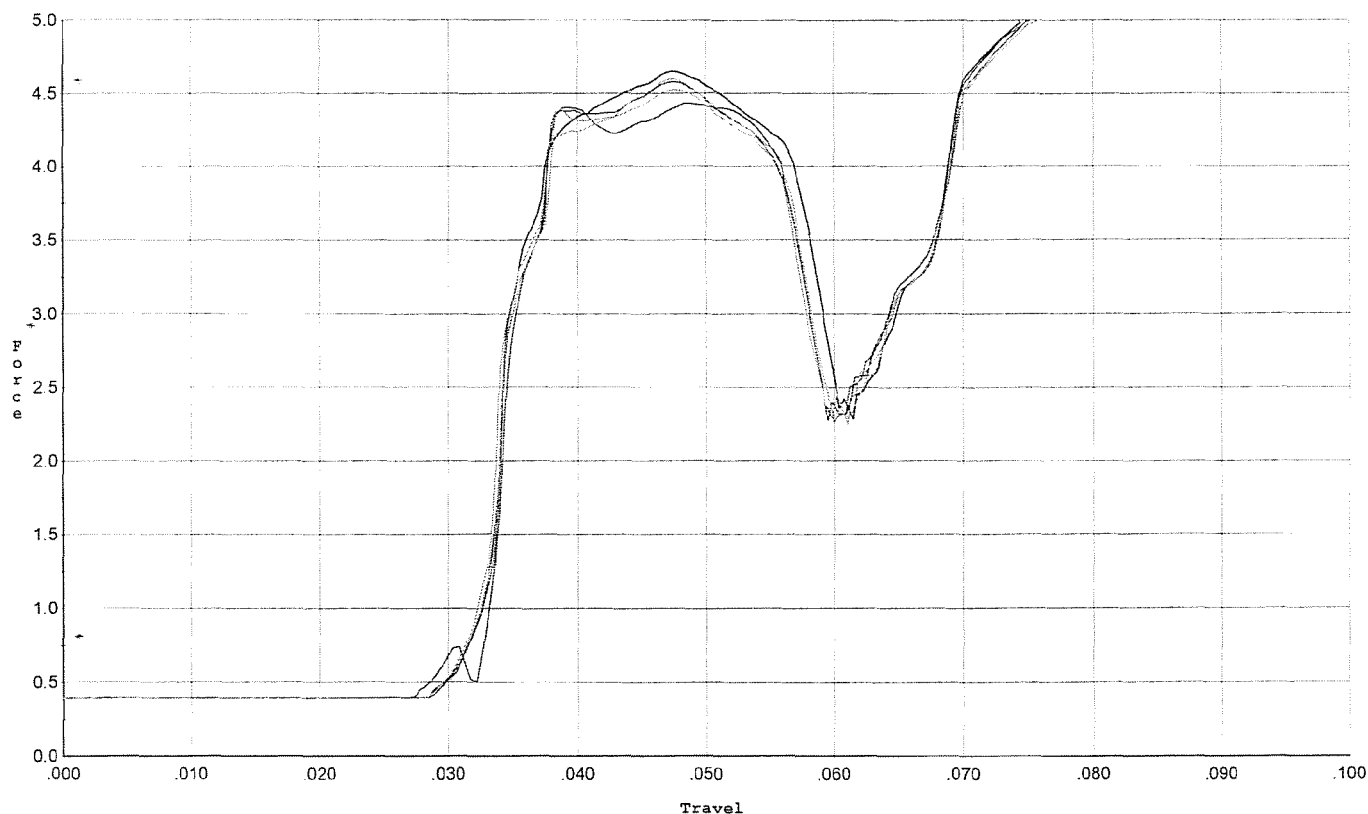
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.057	0.033	0.031	0.080		Set Trigger
2	3.295	0.058	0.033	0.031	0.083		Set Trigger
3	3.276	0.058	0.033	0.031	0.083		Set Trigger
4	3.255	0.058	0.033	0.031	0.082		Set Trigger
5	3.235	0.057	0.033	0.032	0.079		Set Trigger

A-3.25

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



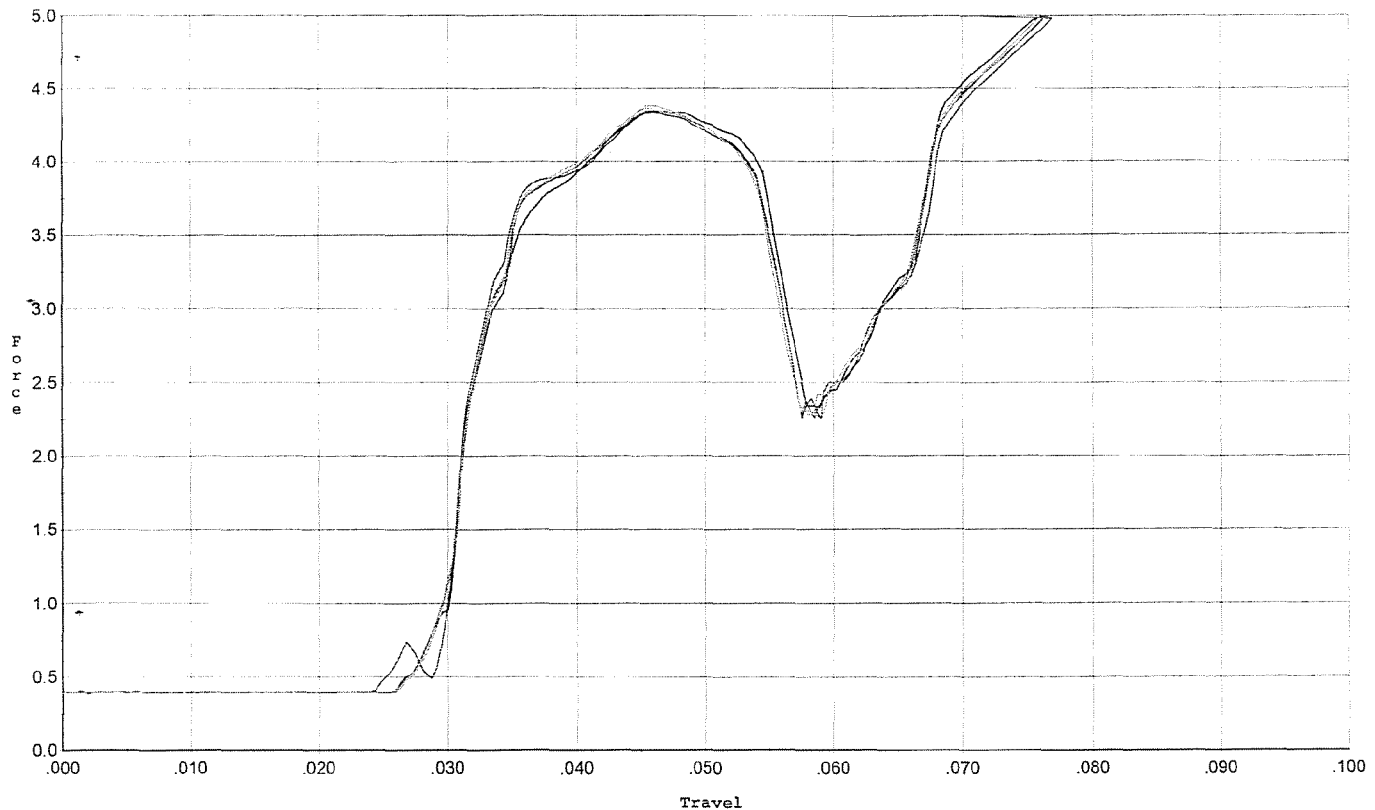
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.433	0.057	0.030	0.029	0.110		Set Trigger
2	4.655	0.058	0.031	0.028	0.117		Set Trigger
3	4.581	0.056	0.031	0.029	0.109		Set Trigger
4	4.528	0.056	0.031	0.029	0.108		Set Trigger
5	4.601	0.057	0.031	0.029	0.112		Set Trigger

A - 4.56

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



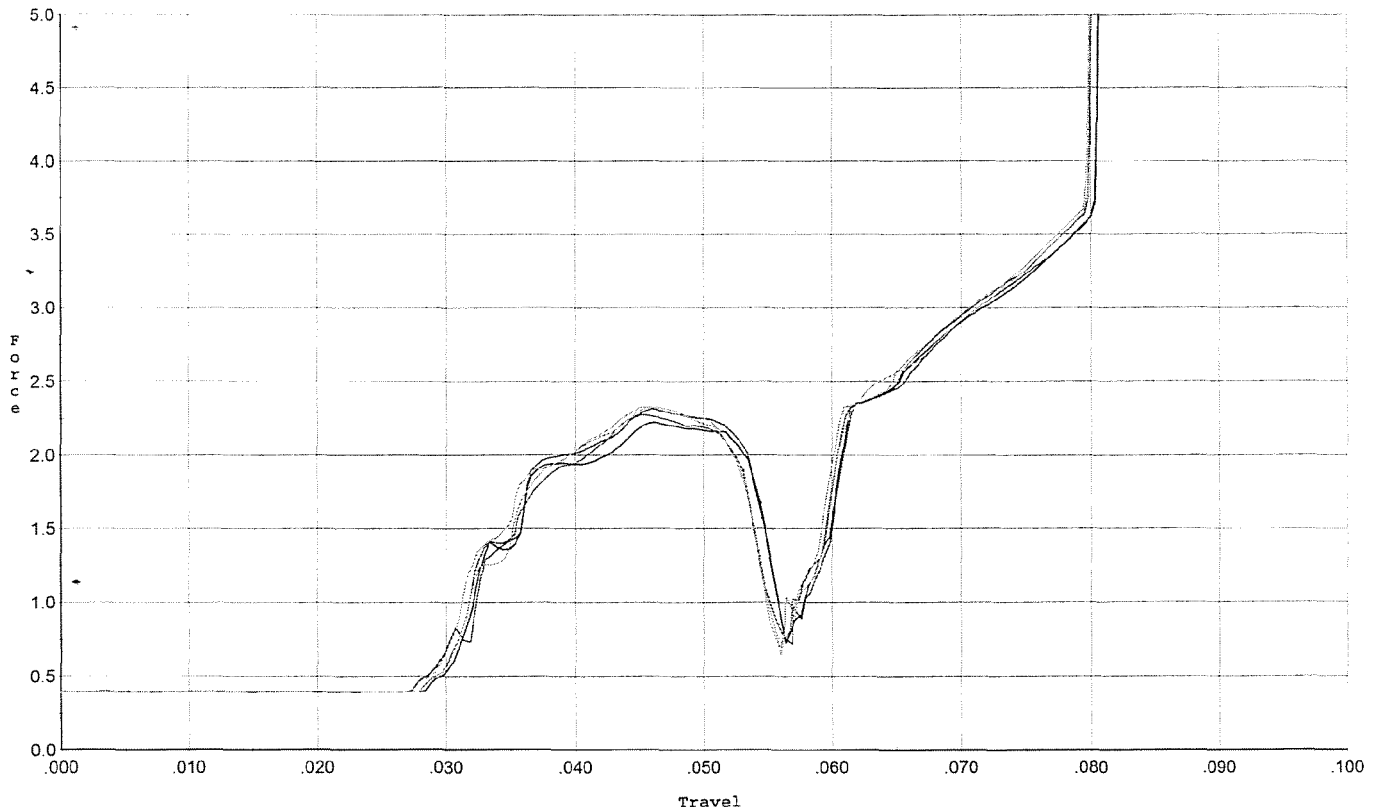
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.340	0.056	0.025	0.029	0.108		Set Trigger
2	4.344	0.055	0.026	0.029	0.106		Set Trigger
3	4.347	0.055	0.026	0.029	0.108		Set Trigger
4	4.385	0.054	0.028	0.029	0.105		Set Trigger
5	4.367	0.054	0.028	0.029	0.105		Set Trigger

A-4.35

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



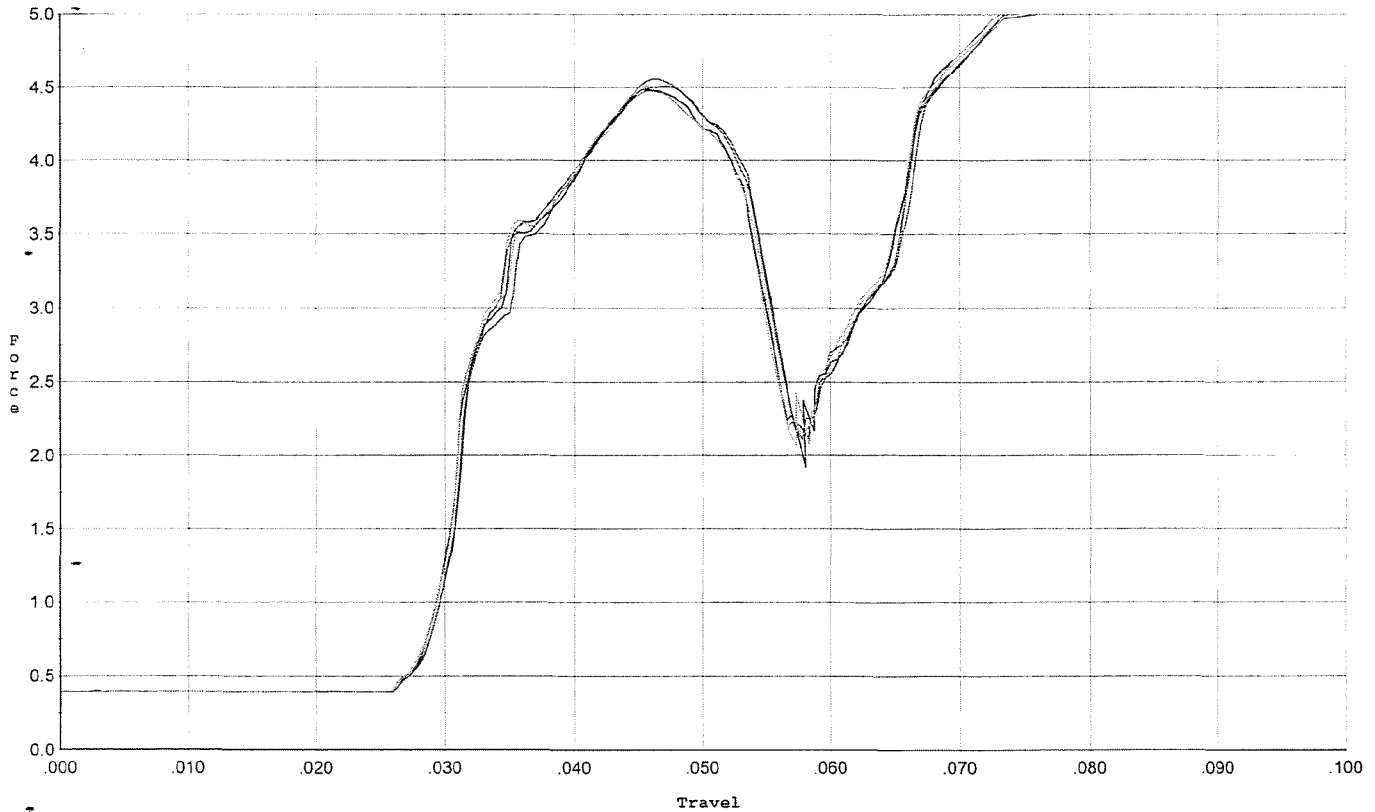
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.314	0.054	0.030	0.032	0.058		Set Trigger
2	2.223	0.055	0.031	0.032	0.057		Set Trigger
3	2.270	0.053	0.030	0.032	0.055		Set Trigger
4	2.326	0.053	0.030	0.032	0.057		Set Trigger
5	2.324	0.053	0.030	0.032	0.056		Set Trigger

A-229

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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	4.512	0.055	0.028	0.028	0.106		Set Trigger
2	4.482	0.055	0.028	0.028	0.105		Set Trigger
3	4.558	0.054	0.028	0.029	0.103		Set Trigger
4	4.513	0.053	0.026	0.029	0.102		Set Trigger
5	4.475	0.054	0.028	0.028	0.104		Set Trigger

A 4.50