

66794755

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



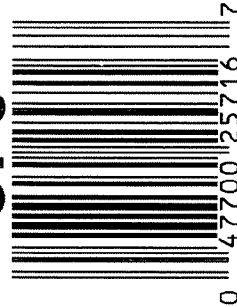
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794755

UPC



GUN SERIAL #

G 6794755

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TE
460	CHECK HEADSPACE		3-6-09	TE
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE		3-6-09	RT
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION	(H)	3-9-09	(H)
490	MAGNAFLUX BOLT		3-9-09	MP
500	ROLLMARK CALIBER		3-9-09	RT
520	GOFF BLAST BBL / REC		3-11	W
542	APPLY COATINGS (BARREL ACTION)		3-12-09	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-24-09	X. J.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

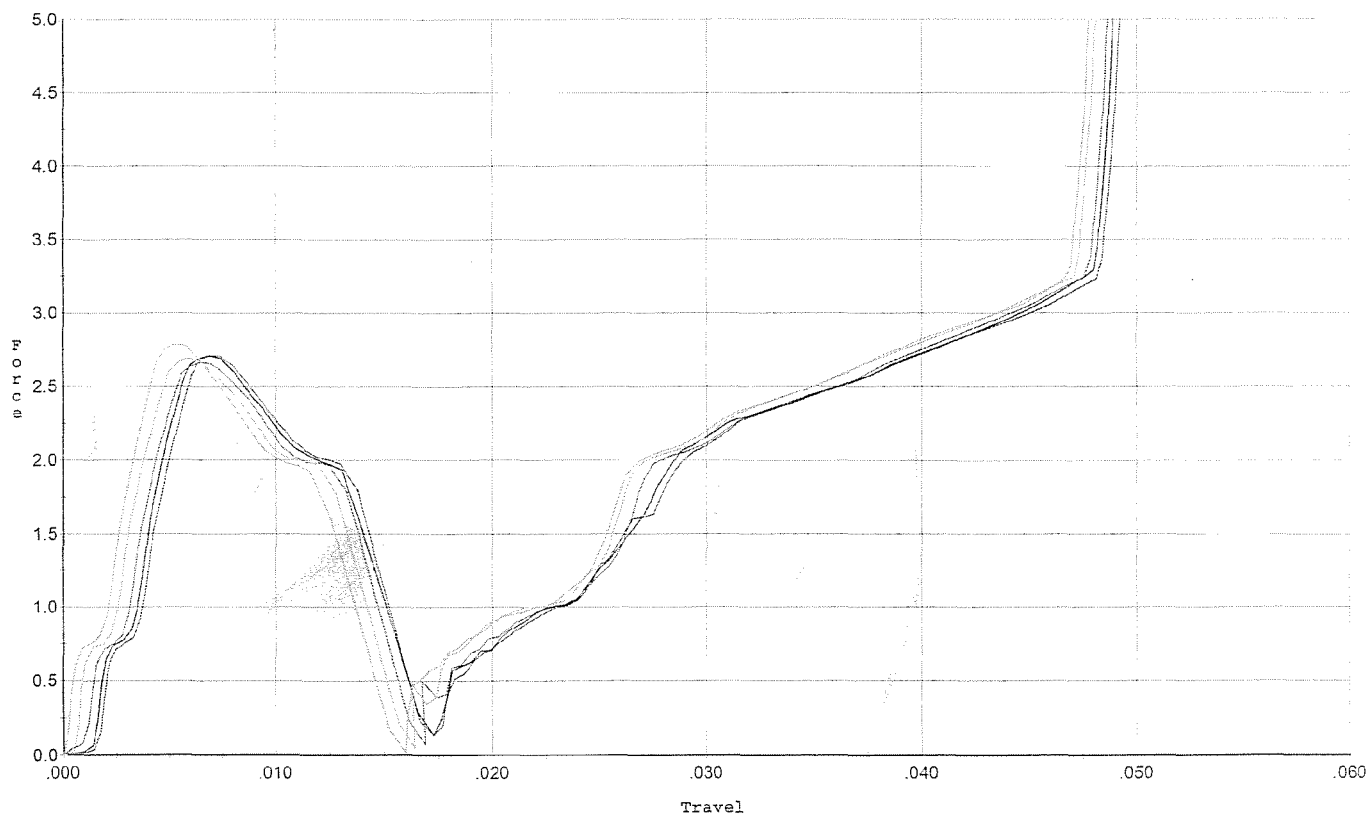
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>30</u>	3-30-09	RN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	3-30-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-30-09	RN
	J) ASSEMBLE STOCK		3-24-09	RN
	K) ASSEMBLE SWIVEL STUDS		3-30-09	RN
	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	PASS PASS FAIL FAIL	3-26-09	RN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TC
670	FINAL INSPECTION A) HEADSPACE		3-30-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.42</u> <u>2.56</u> <u>2.55</u> <u>2.55</u>	3-30-09	TC
	C) FUNCTION		3-30-09	RN
690	PACK		3/30/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



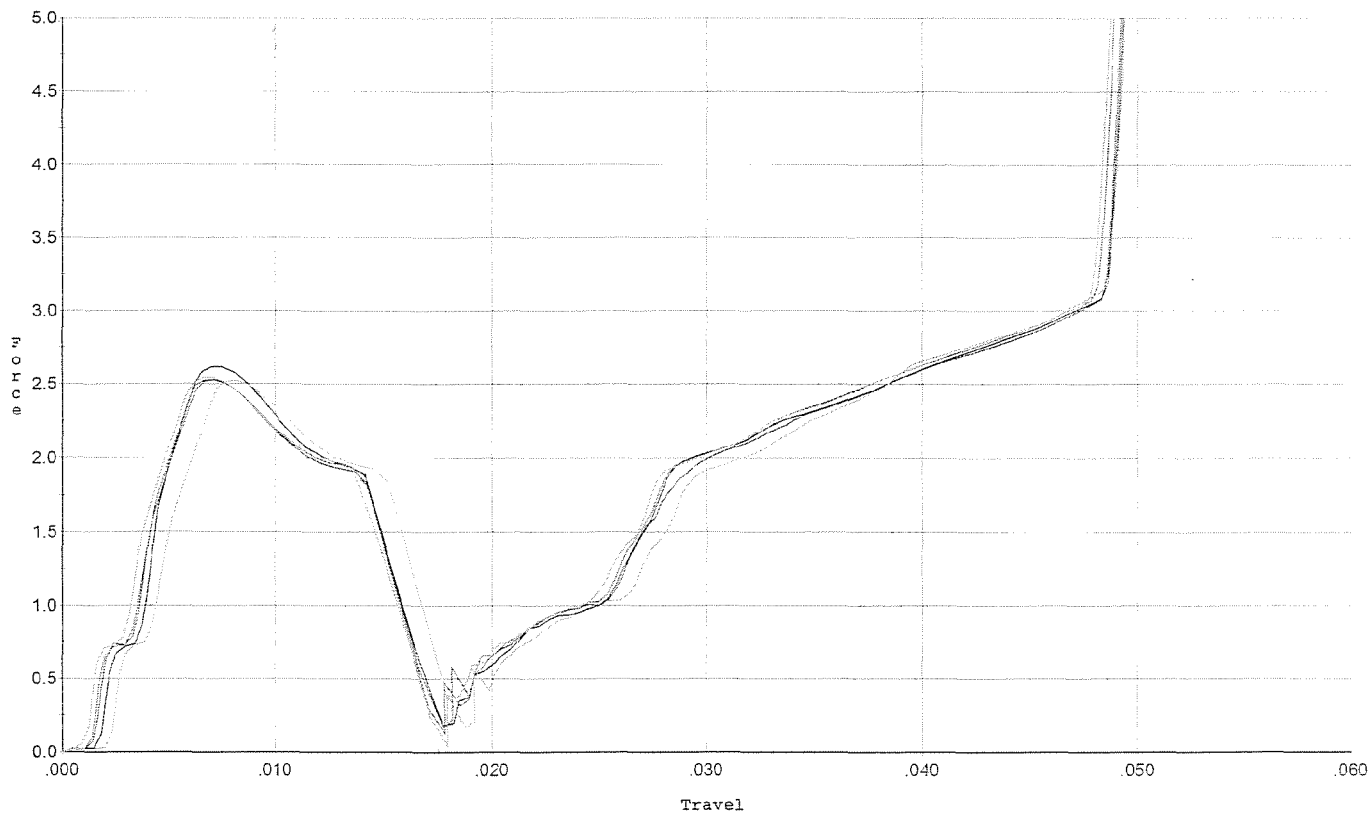
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.709	0.014	0.00	0.038	0.022		Set Trigger
2	2.709	0.015	0.00	0.038	0.024		Set Trigger
3	2.663	0.013	0.00	0.038	0.022		Set Trigger
4	2.685	0.013	0.00	0.038	0.022		Set Trigger
5	2.785	0.013	0.00	0.038	0.022		Set Trigger

A-2-71

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



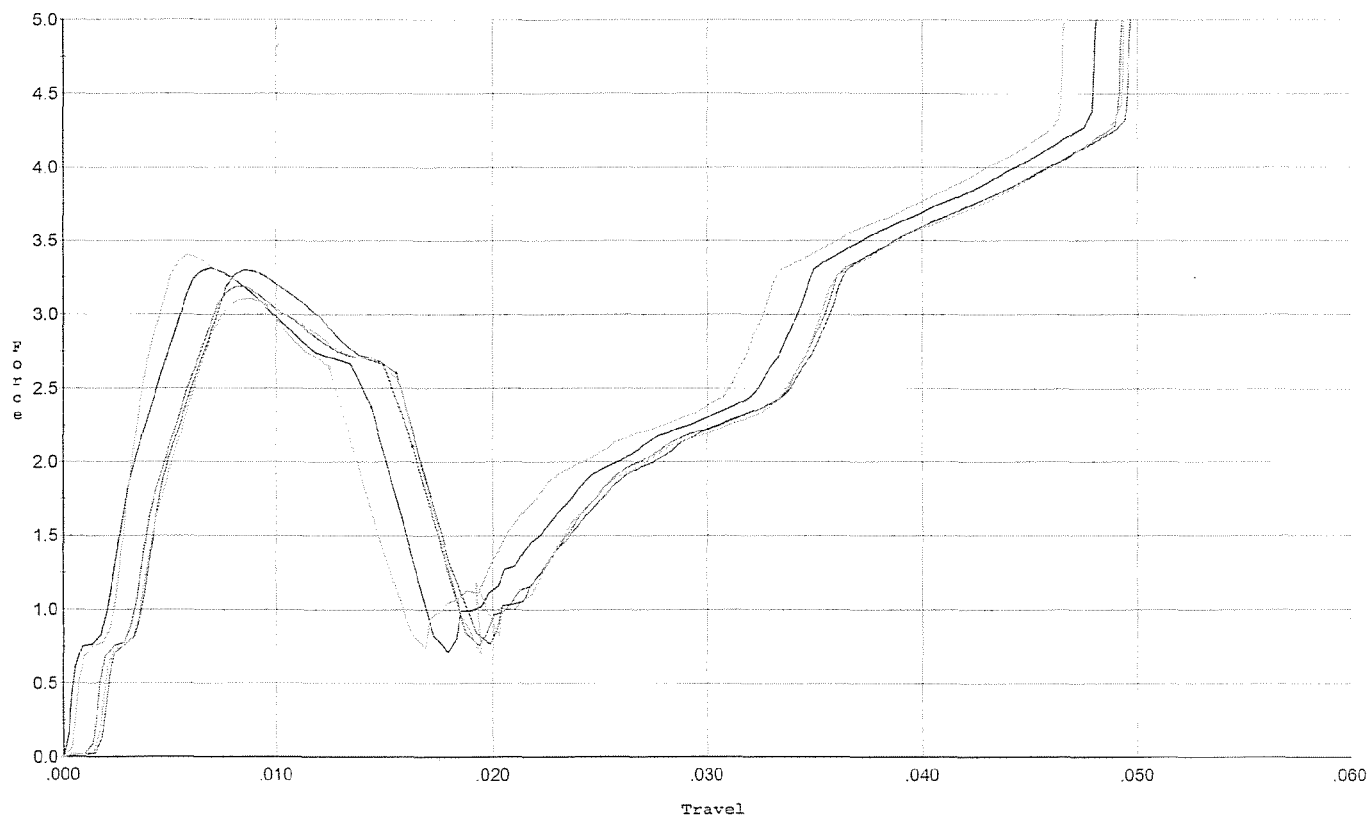
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.529	0.014	0.00	0.038	0.022		Set Trigger
2	2.617	0.014	0.002	0.038	0.022		Set Trigger
3	2.528	0.014	0.00	0.038	0.023		Set Trigger
4	2.524	0.015	0.002	0.037	0.023		Set Trigger
5	2.545	0.015	0.00	0.038	0.024		Set Trigger

A-254

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



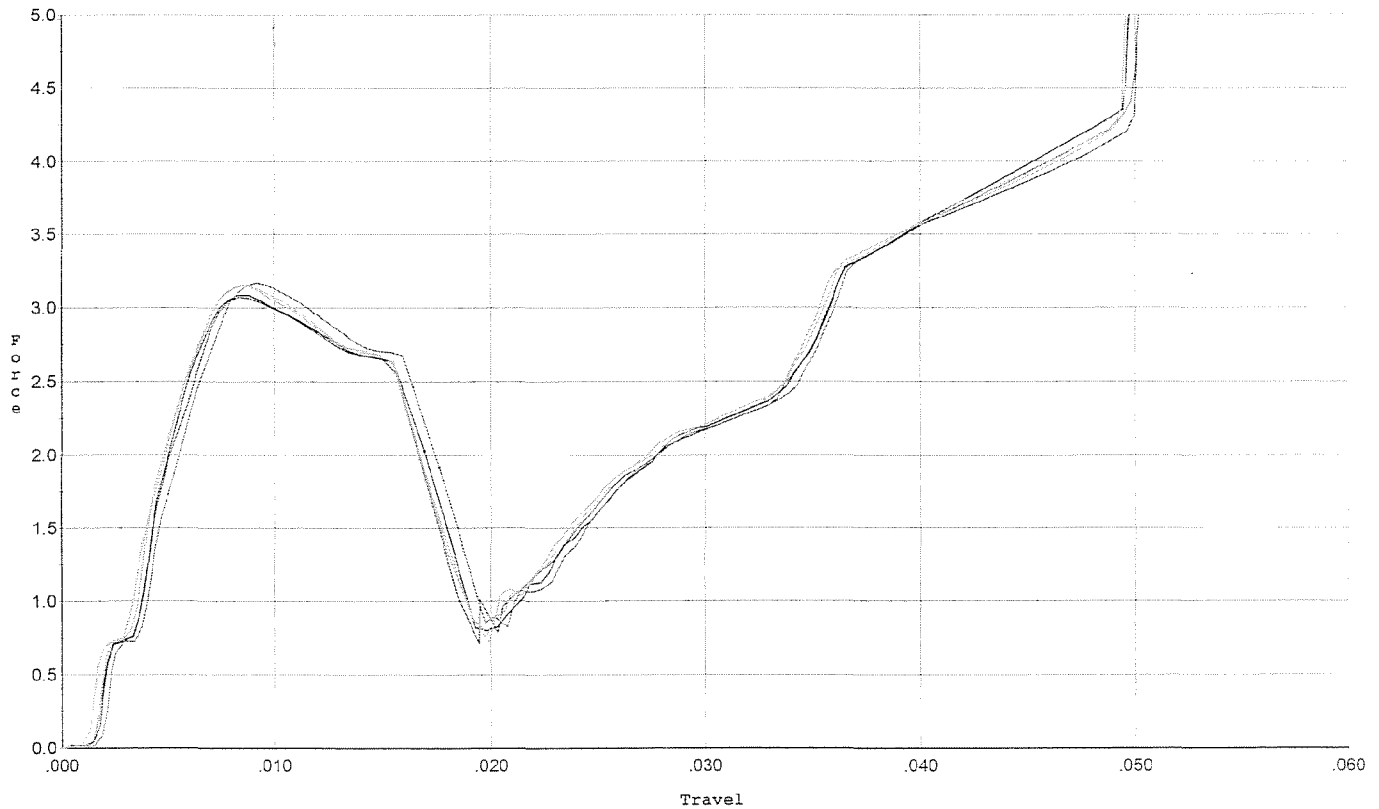
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.301	0.016	0.00	0.036	0.032		Set Trigger
2	3.315	0.014	0.00	0.035	0.032		Set Trigger
3	3.188	0.016	0.00	0.035	0.033		Set Trigger
4	3.106	0.016	0.00	0.035	0.031		Set Trigger
5	3.404	0.012	0.00	0.035	0.028		Set Trigger

A-3-26

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



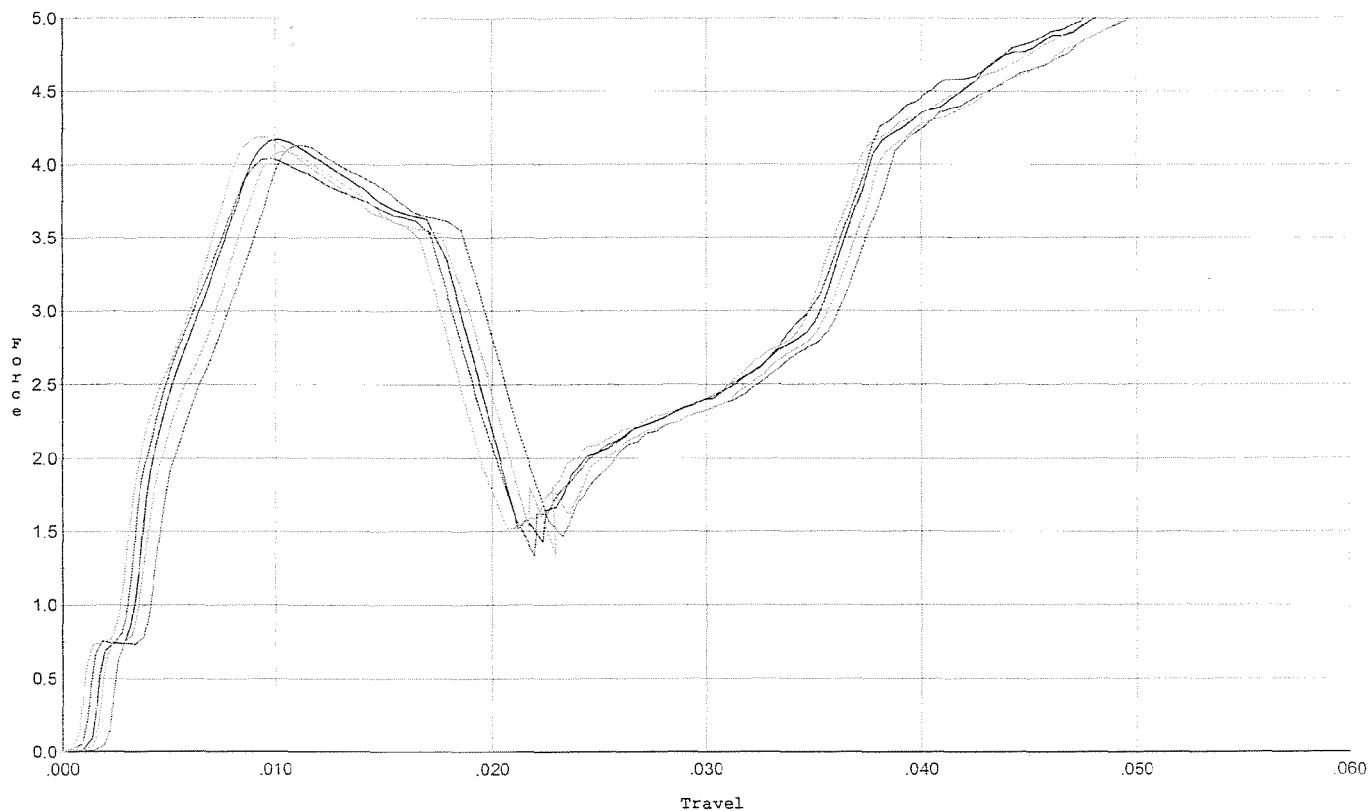
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.073	0.016	0.00	0.036	0.031		Set Trigger
2	3.085	0.017	0.00	0.035	0.034		Set Trigger
3	3.169	0.018	0.002	0.035	0.035		Set Trigger
4	3.150	0.015	0.00	0.035	0.032		Set Trigger
5	3.156	0.016	0.00	0.035	0.032		Set Trigger

A3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



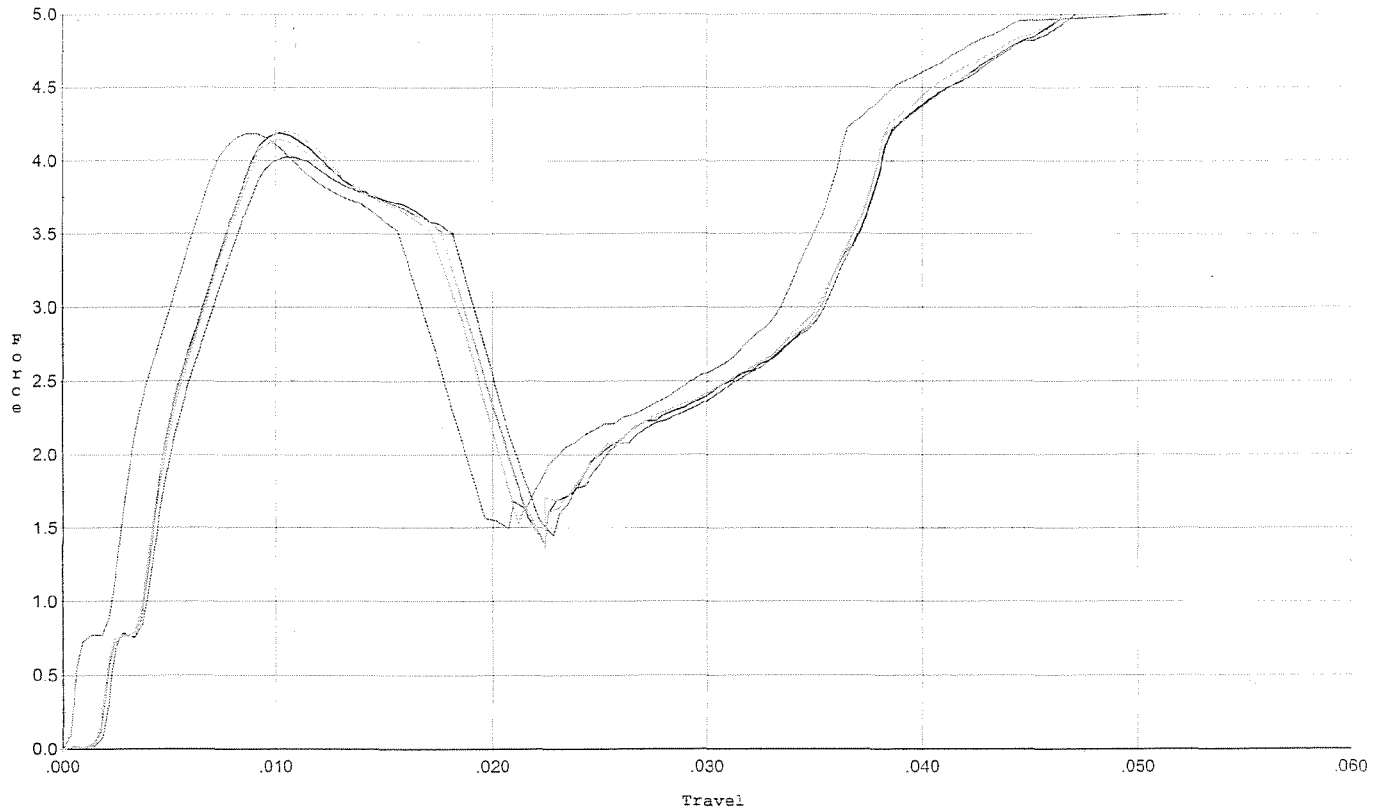
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.039	0.017	0.00	0.033	0.046		Set Trigger
2	4.176	0.018	0.00	0.033	0.048		Set Trigger
3	4.133	0.019	0.002	0.033	0.047		Set Trigger
4	4.186	0.017	0.00	0.033	0.045		Set Trigger
5	4.088	0.019	0.00	0.033	0.049		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



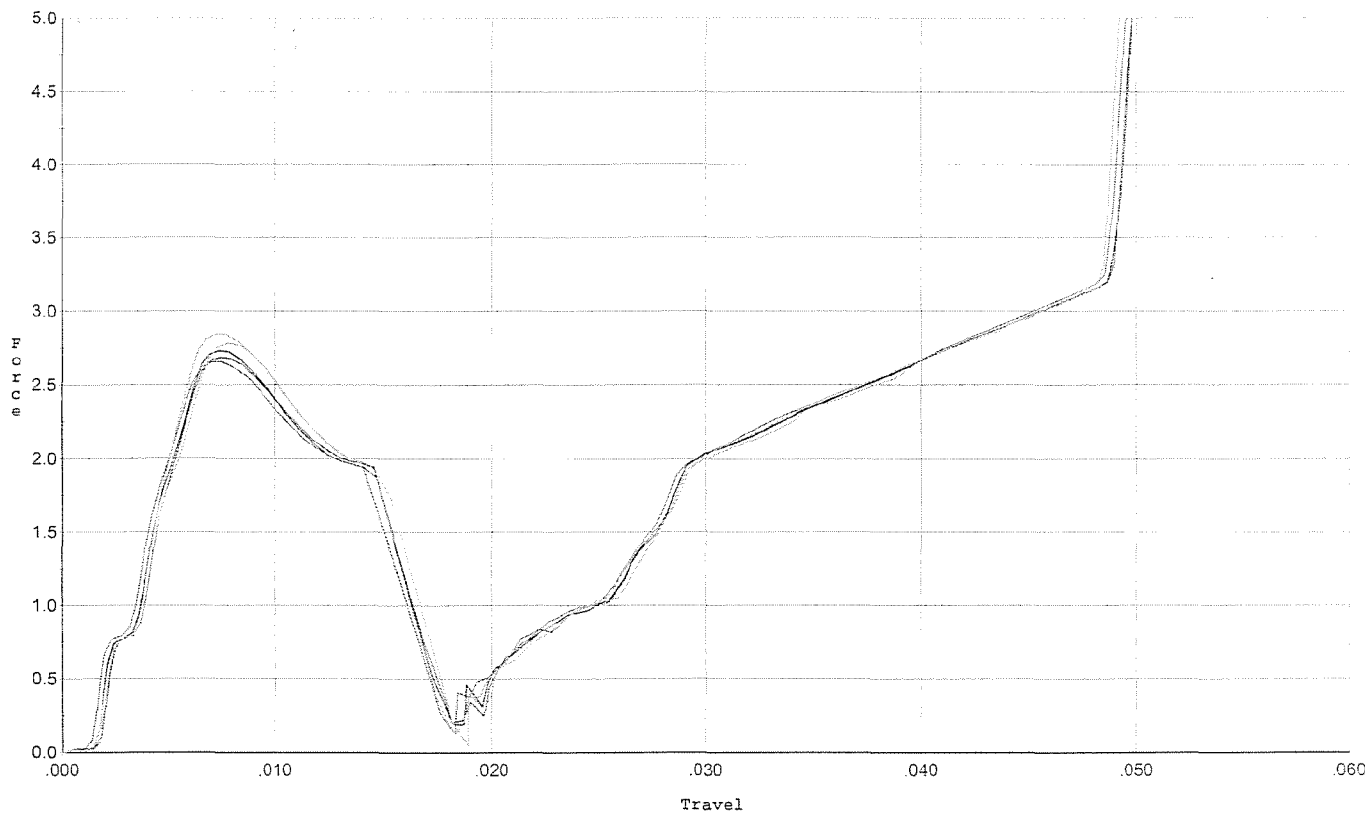
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.025	0.018	0.002	0.033	0.046		Set Trigger
2	4.188	0.018	0.00	0.033	0.046		Set Trigger
3	4.184	0.018	0.00	0.033	0.049		Set Trigger
4	4.203	0.018	0.00	0.033	0.046		Set Trigger
5	4.147	0.019	0.00	0.033	0.048		Set Trigger

A 4-14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



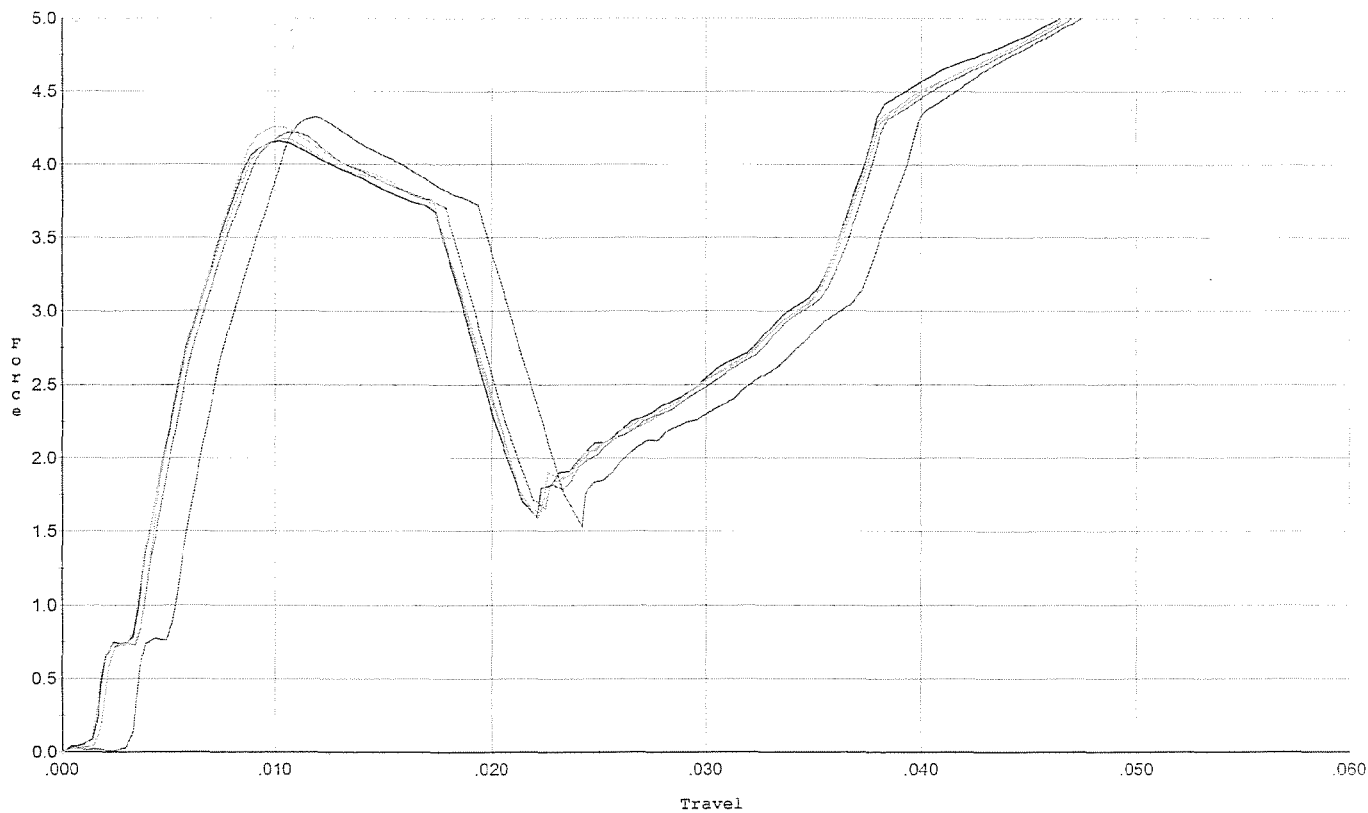
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.686	0.015	0.002	0.038	0.024		Set Trigger
2	2.731	0.015	0.00	0.038	0.024		Set Trigger
3	2.658	0.016	0.00	0.038	0.026		Set Trigger
4	2.785	0.015	0.002	0.037	0.025		Set Trigger
5	2.842	0.015	0.00	0.038	0.025		Set Trigger

A-2-74

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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	4.326	0.019	0.003	0.033	0.049		Set Trigger
2	4.158	0.017	0.00	0.033	0.046		Set Trigger
3	4.218	0.018	0.00	0.033	0.047		Set Trigger
4	4.260	0.019	0.00	0.033	0.052		Set Trigger
5	4.176	0.017	0.00	0.033	0.046		Set Trigger

A-4.22