

56794756

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



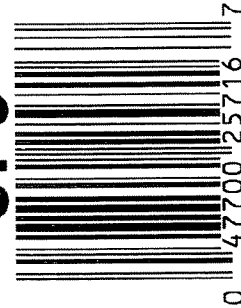
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794756

UPC



GUN SERIAL #

G 6794756

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		10-8-08	BSN
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (18)	10/11/08	(18)
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		11-5-08	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

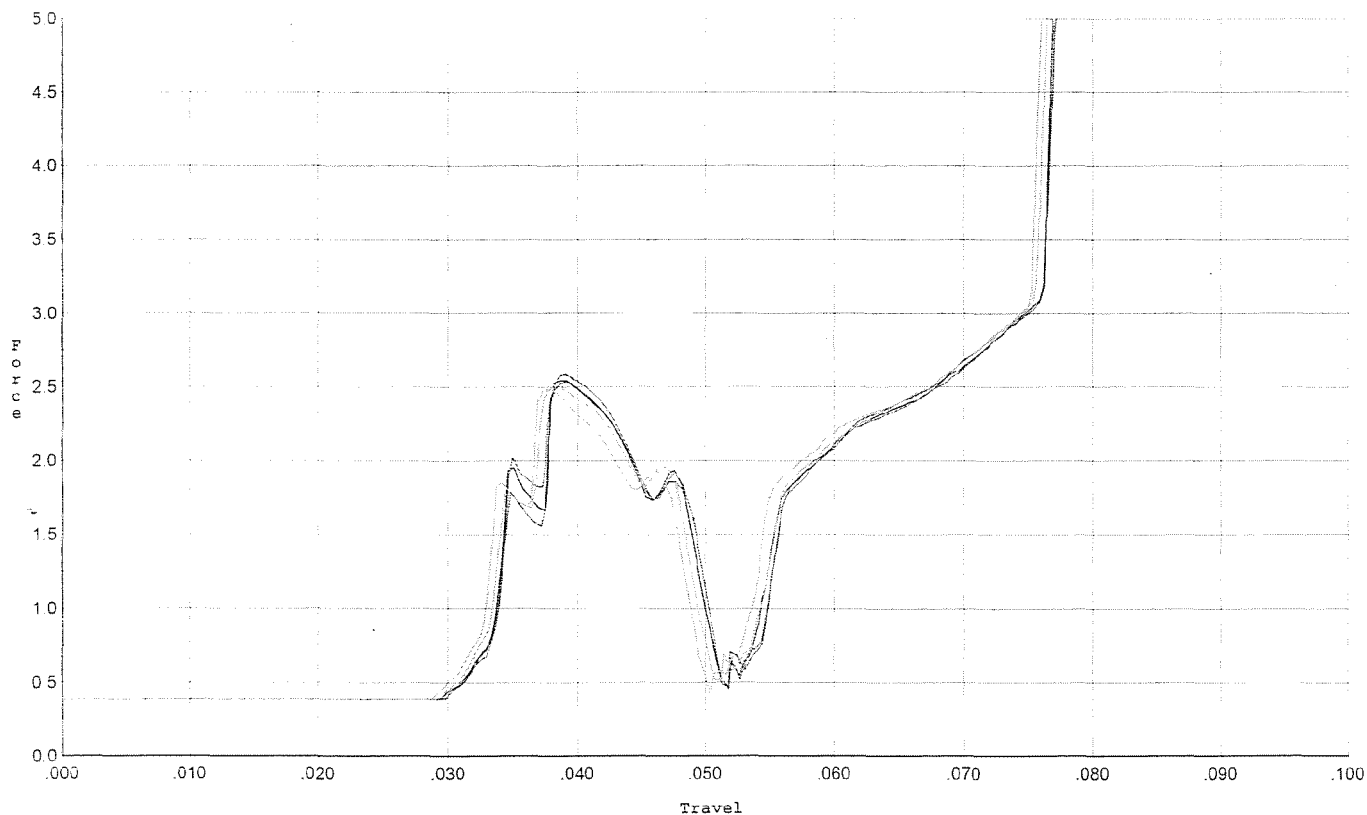
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>5°</u>	11-11-08	L. J.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>6°</u>	11-11-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	11-11-08	L. J.
	J) ASSEMBLE STOCK		11-5-08	RBN
	K) ASSEMBLE SWIVEL STUDS		11-11-08	L. J.
	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	11-5-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	RBN
670	FINAL INSPECTION A) HEADSPACE		11-11-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.36</u> <u>2.37</u> <u>2.37</u> <u>2.37</u>	11-6-08	TC
	C) FUNCTION		11-11-08	L. J.
690	PACK		11/13/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



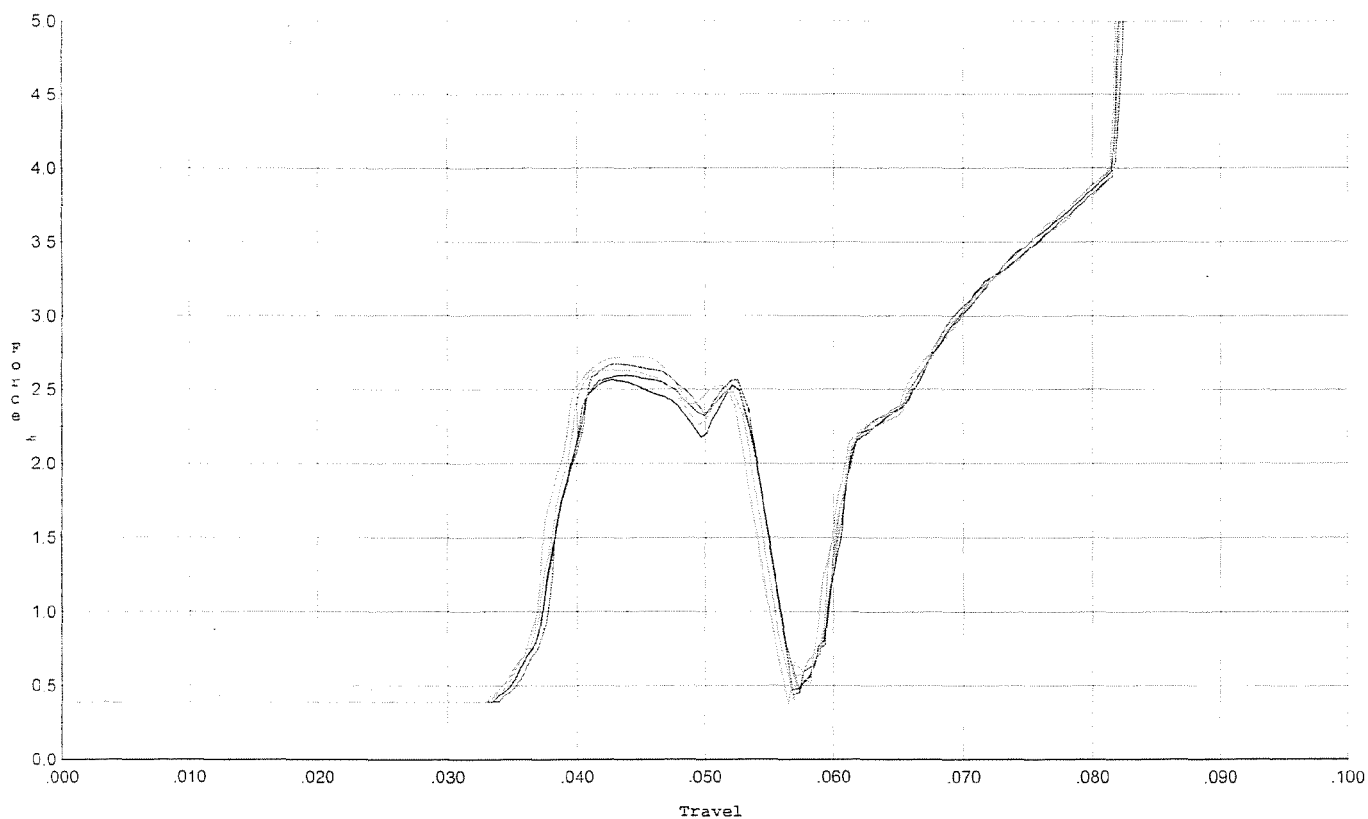
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.534	0.048	0.032	0.034	0.043		Set Trigger
2	2.542	0.048	0.032	0.034	0.044		Set Trigger
3	2.586	0.049	0.033	0.034	0.046		Set Trigger
4	2.515	0.048	0.032	0.034	0.044		Set Trigger
5	2.482	0.047	0.031	0.034	0.043		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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



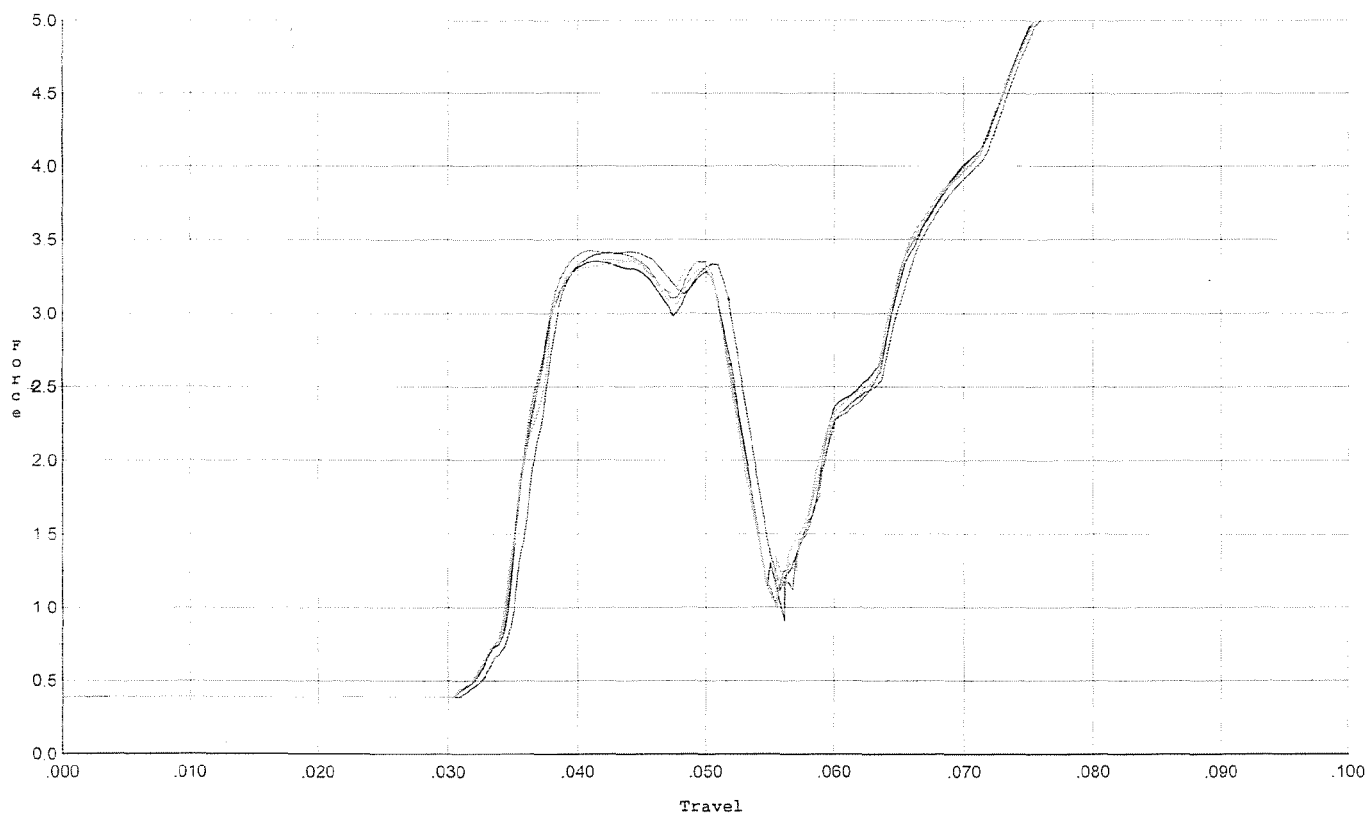
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.053	0.036	0.034	0.054		Set Trigger
2	2.562	0.054	0.036	0.034	0.054		Set Trigger
3	2.673	0.054	0.036	0.034	0.055		Set Trigger
4	2.634	0.053	0.035	0.035	0.054		Set Trigger
5	2.725	0.052	0.035	0.035	0.055		Set Trigger

A-2.63

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



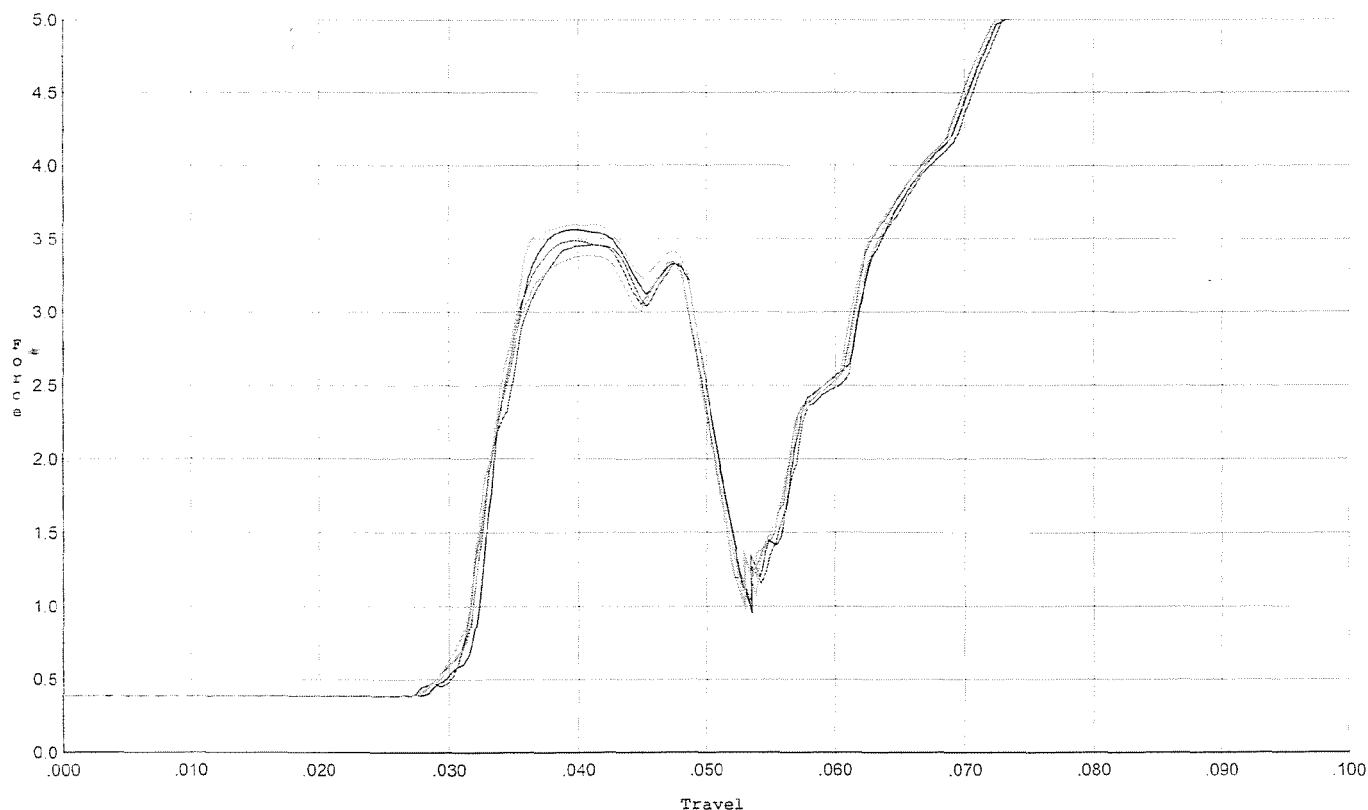
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.415	0.052	0.033	0.032	0.067		Set Trigger
2	3.354	0.052	0.033	0.032	0.067		Set Trigger
3	3.425	0.052	0.033	0.033	0.069		Set Trigger
4	3.379	0.051	0.033	0.033	0.065		Set Trigger
5	3.370	0.051	0.033	0.033	0.065		Set Trigger

A-338

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



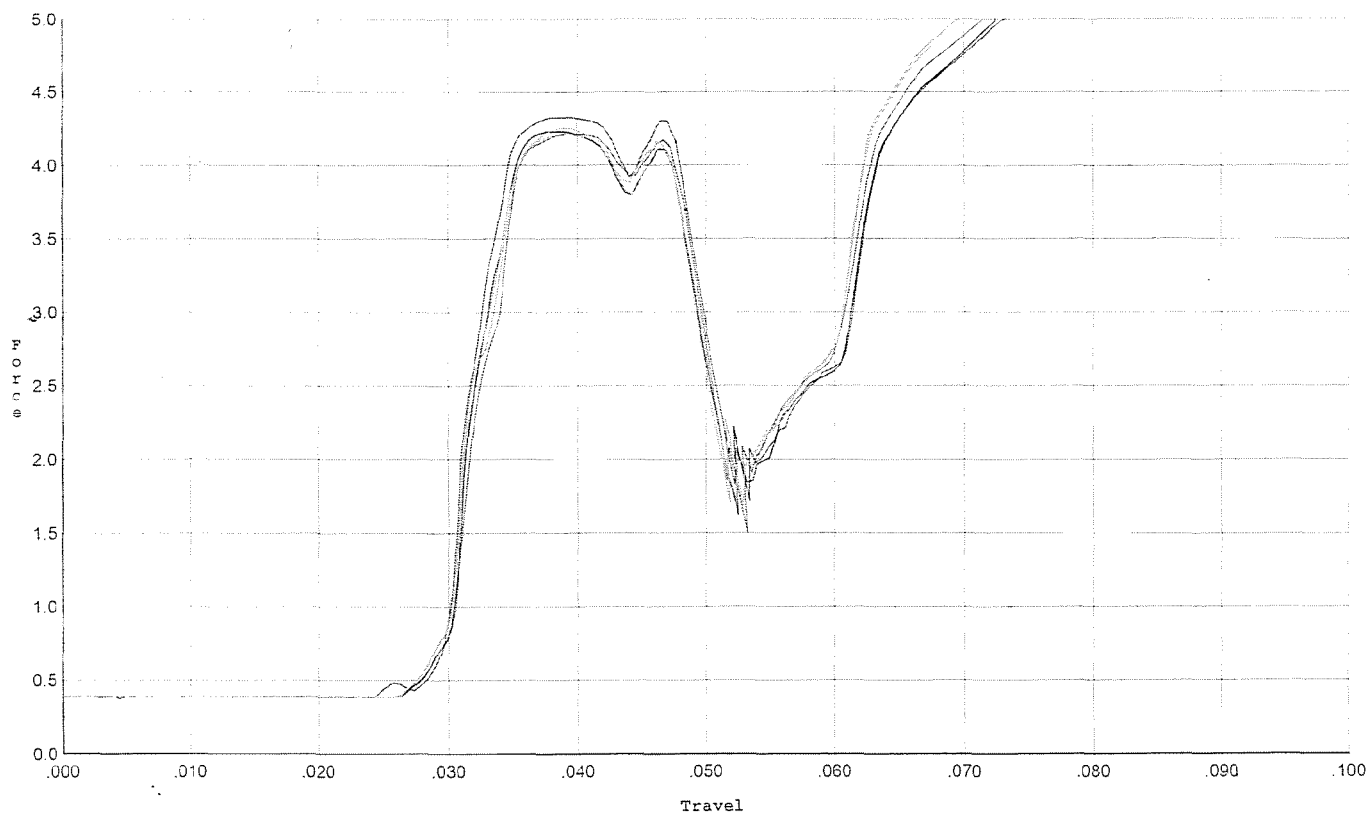
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.461	0.049	0.031	0.032	0.066		Set Trigger
2	3.565	0.049	0.031	0.032	0.067		Set Trigger
3	3.489	0.050	0.031	0.032	0.068		Set Trigger
4	3.596	0.049	0.030	0.032	0.068		Set Trigger
5	3.387	0.048	0.030	0.032	0.065		Set Trigger

A-3-50

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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



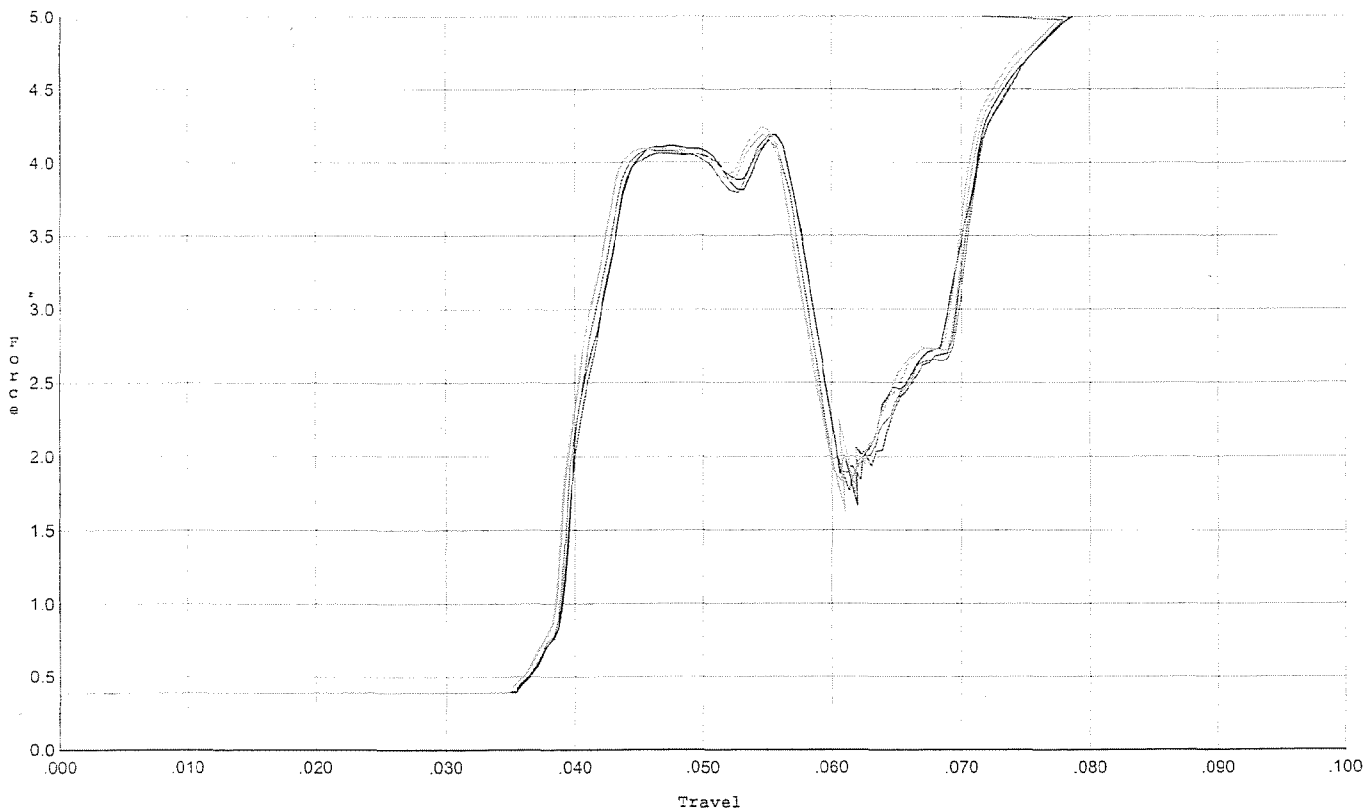
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.326	0.048	0.029	0.031	0.083		Set Trigger
2	4.228	0.047	0.029	0.031	0.079		Set Trigger
3	4.215	0.048	0.029	0.031	0.081		Set Trigger
4	4.220	0.047	0.029	0.031	0.080		Set Trigger
5	4.253	0.049	0.028	0.031	0.083		Set Trigger

A-4.24

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



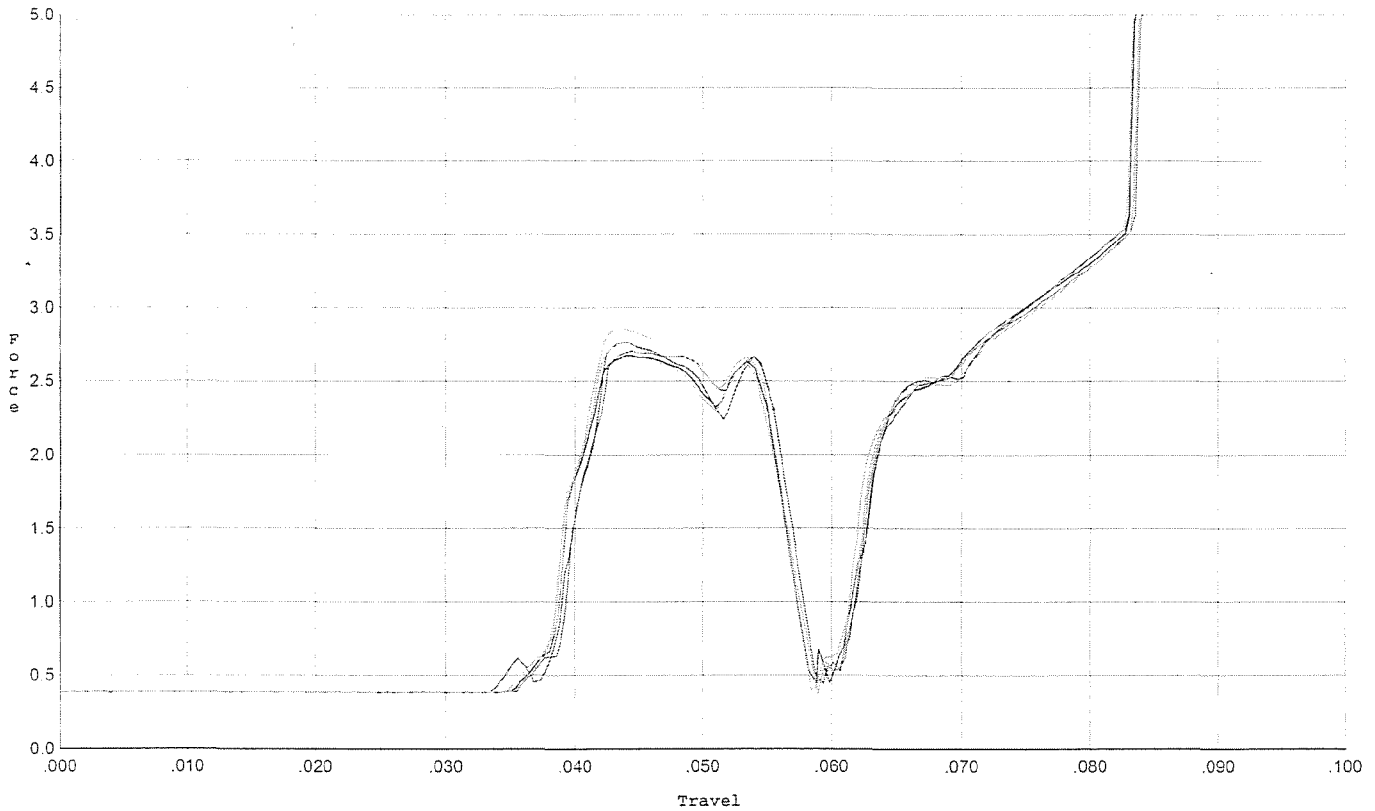
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.192	0.058	0.036	0.032	0.087		Set Trigger
2	4.191	0.058	0.038	0.032	0.087		Set Trigger
3	4.150	0.057	0.036	0.032	0.085		Set Trigger
4	4.190	0.056	0.035	0.032	0.084		Set Trigger
5	4.242	0.056	0.035	0.032	0.084		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



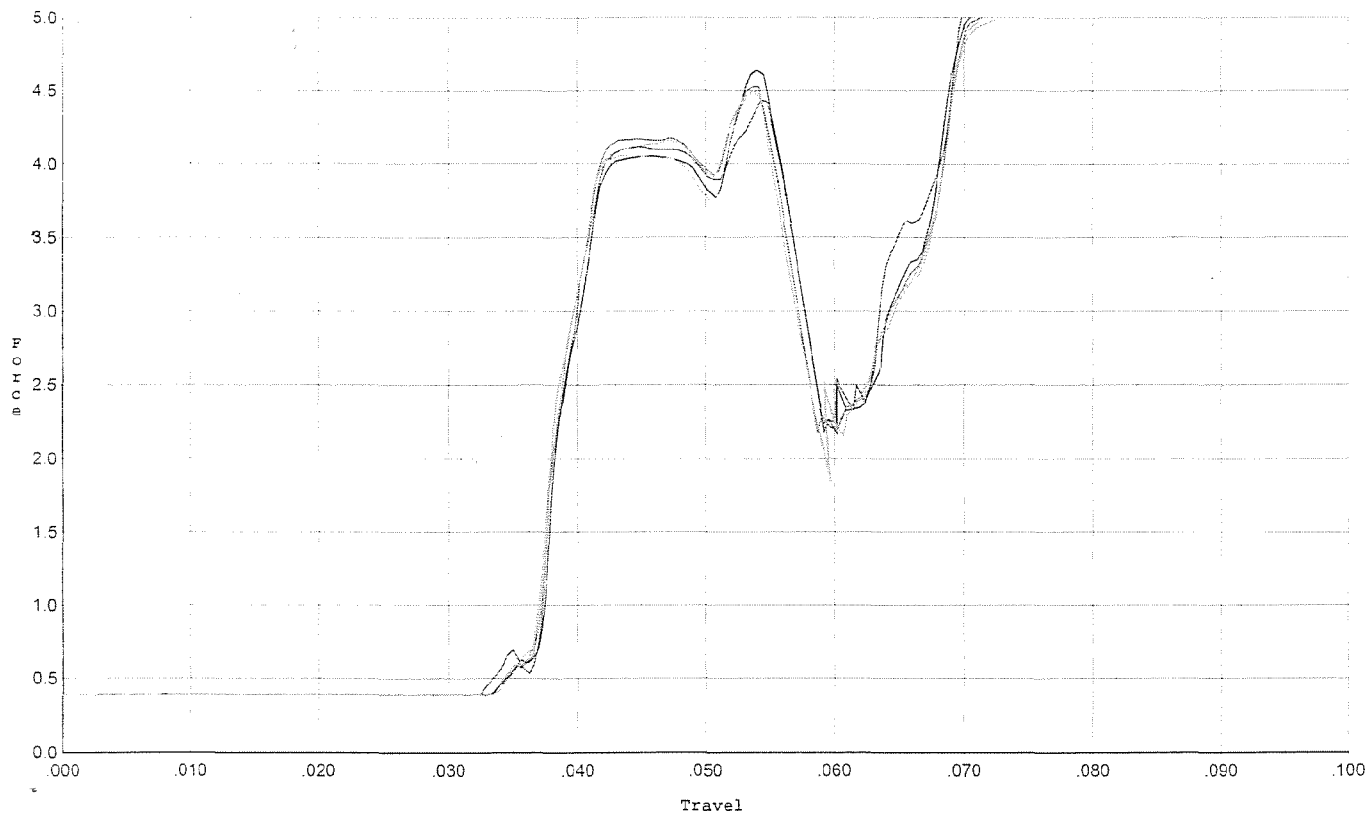
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.760	0.055	0.035	0.034	0.057		Set Trigger
2	2.672	0.055	0.038	0.034	0.056		Set Trigger
3	2.702	0.055	0.039	0.034	0.057		Set Trigger
4	2.737	0.055	0.038	0.034	0.057		Set Trigger
5	2.856	0.055	0.037	0.034	0.058		Set Trigger

A-2-74

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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	4.431	0.056	0.034	0.031	0.090		Set Trigger
2	4.639	0.056	0.037	0.031	0.089		Set Trigger
3	4.523	0.056	0.037	0.031	0.089		Set Trigger
4	4.481	0.054	0.036	0.032	0.085		Set Trigger
5	4.500	0.054	0.034	0.032	0.085		Set Trigger

A 4.51