

56794780

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



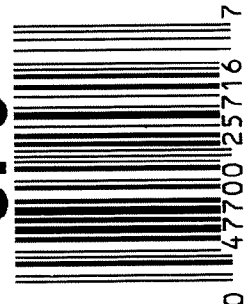
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794780

UPC



GUN SERIAL #

66194180

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TE
460	CHECK HEADSPACE		3-6-09	TE
470	DIS-ASSEMBLE ACTION		3-6-09	RTZ
472	SERIALIZE BOLT HANDLE		3-6-09	RTZ
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	RTZ
500	ROLLMARK CALIBER		3/9/09	RTZ
520	GOFF BLAST BBL / REC		3/11	RTZ
542	APPLY COATINGS (BARREL ACTION)		3-20	—
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		3-23-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

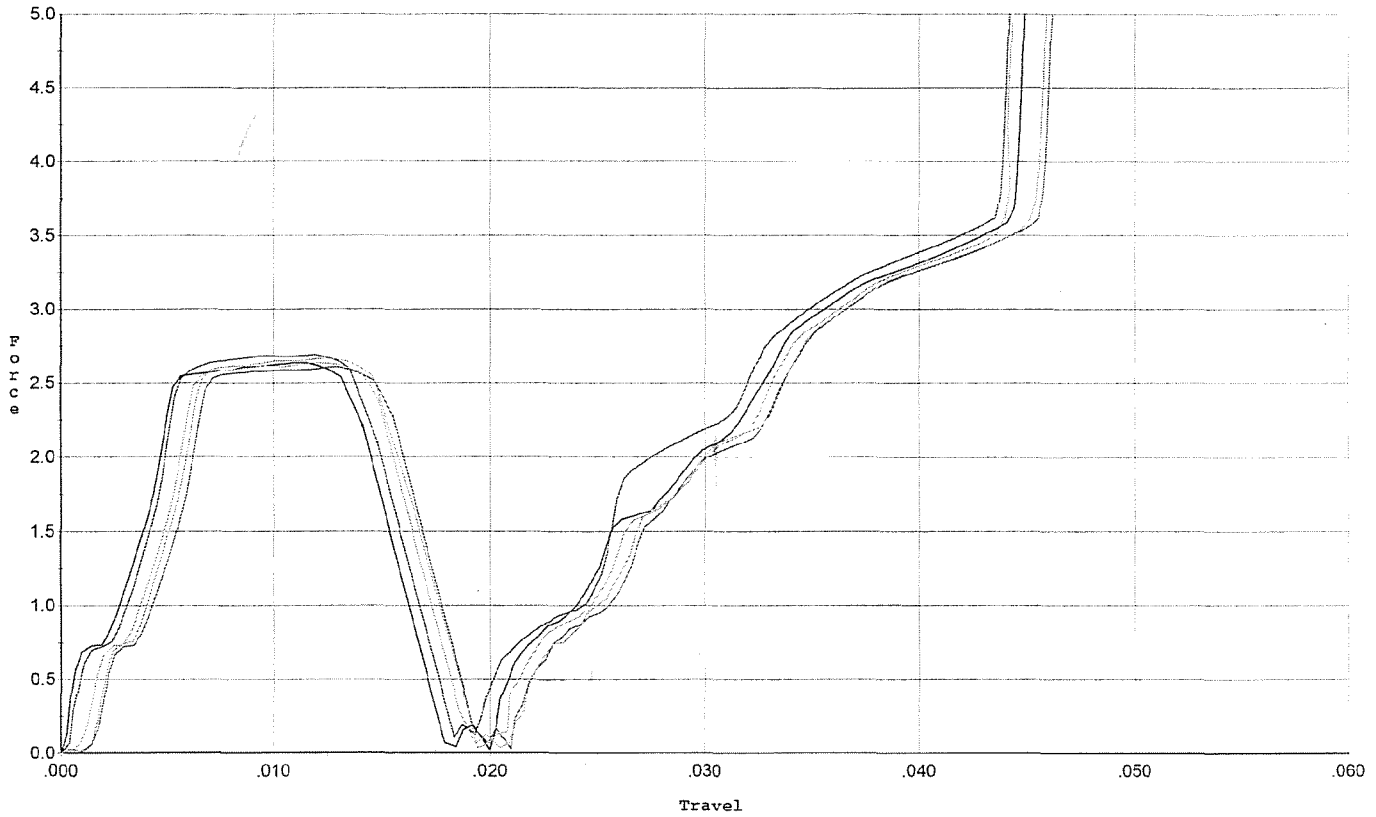
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>6</u>	3-25-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-25-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	3-25-09	WV
	J) ASSEMBLE STOCK		3-23-09	TK
	K) ASSEMBLE SWIVEL STUDS		3-25-09	WV
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	3-24-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.22</u> <u>2.22</u> <u>2.31</u> <u>2.35</u>	3-24-09	TK
	C) FUNCTION		3-25-09	WV
690	PACK		3/27/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



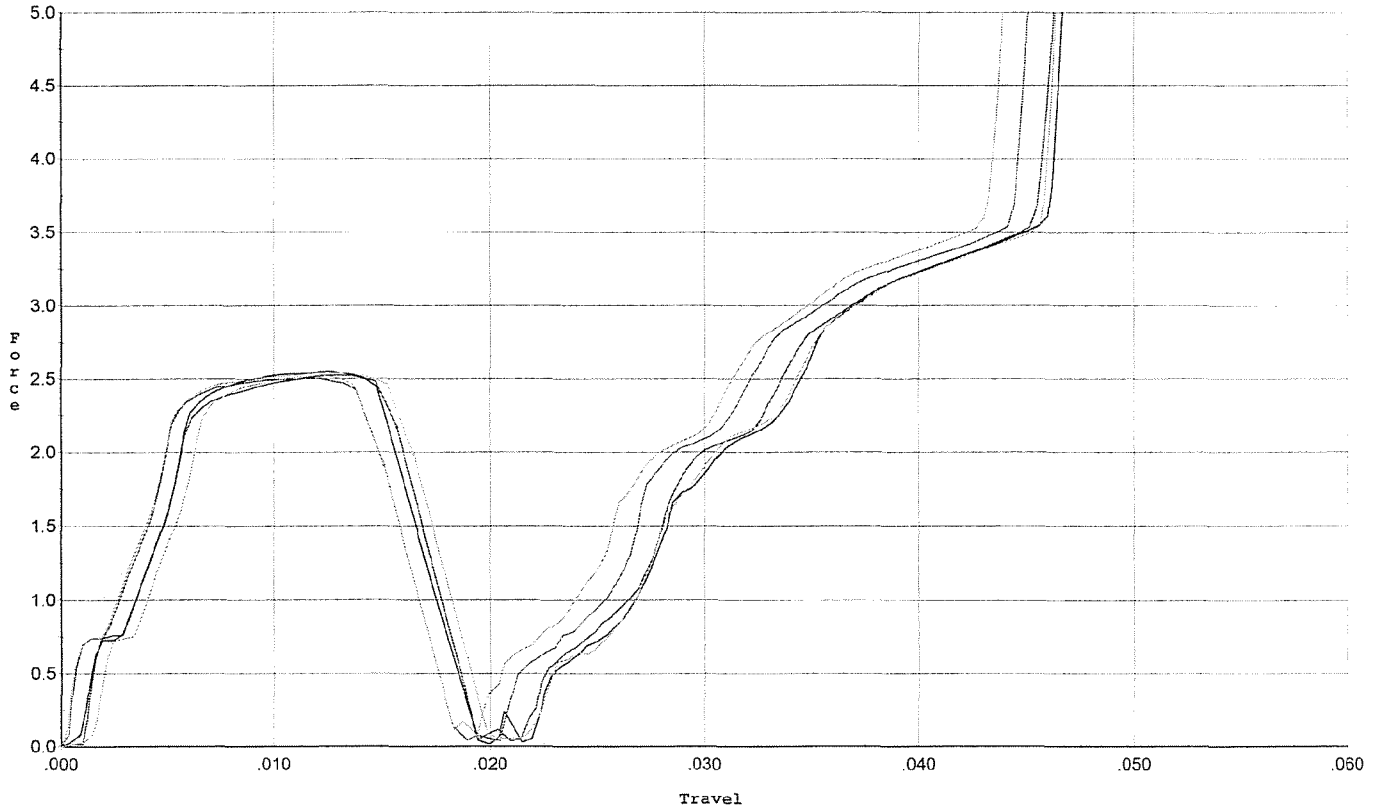
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.690	0.015	0.00	0.032	0.028		Set Trigger
2	2.635	0.014	0.00	0.033	0.027		Set Trigger
3	2.604	0.016	0.00	0.033	0.027		Set Trigger
4	2.636	0.015	0.00	0.032	0.027		Set Trigger
5	2.665	0.016	0.00	0.033	0.029		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



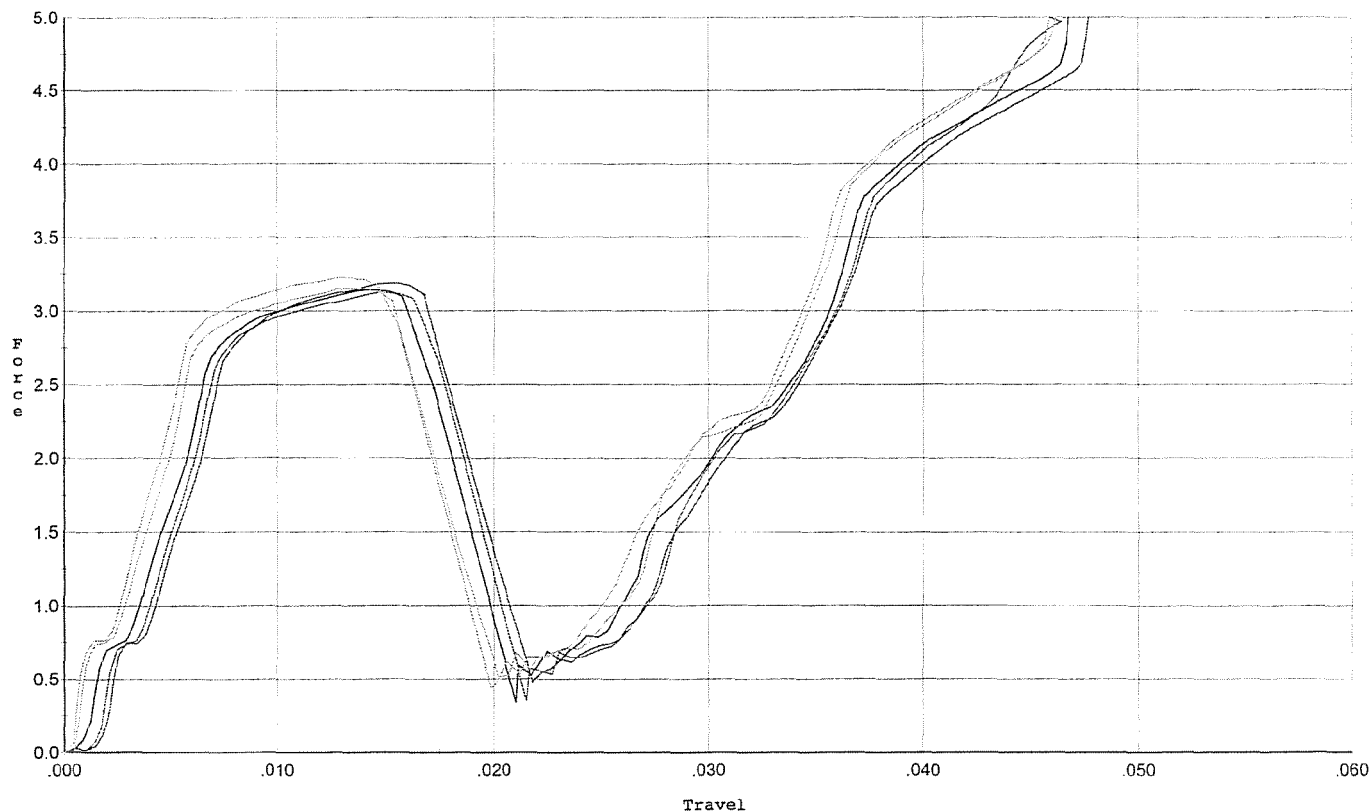
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.525	0.016	0.00	0.033	0.028		Set Trigger
2	2.552	0.015	0.00	0.034	0.026		Set Trigger
3	2.507	0.015	0.00	0.033	0.027		Set Trigger
4	2.545	0.016	0.00	0.033	0.028		Set Trigger
5	2.536	0.015	0.00	0.032	0.028		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



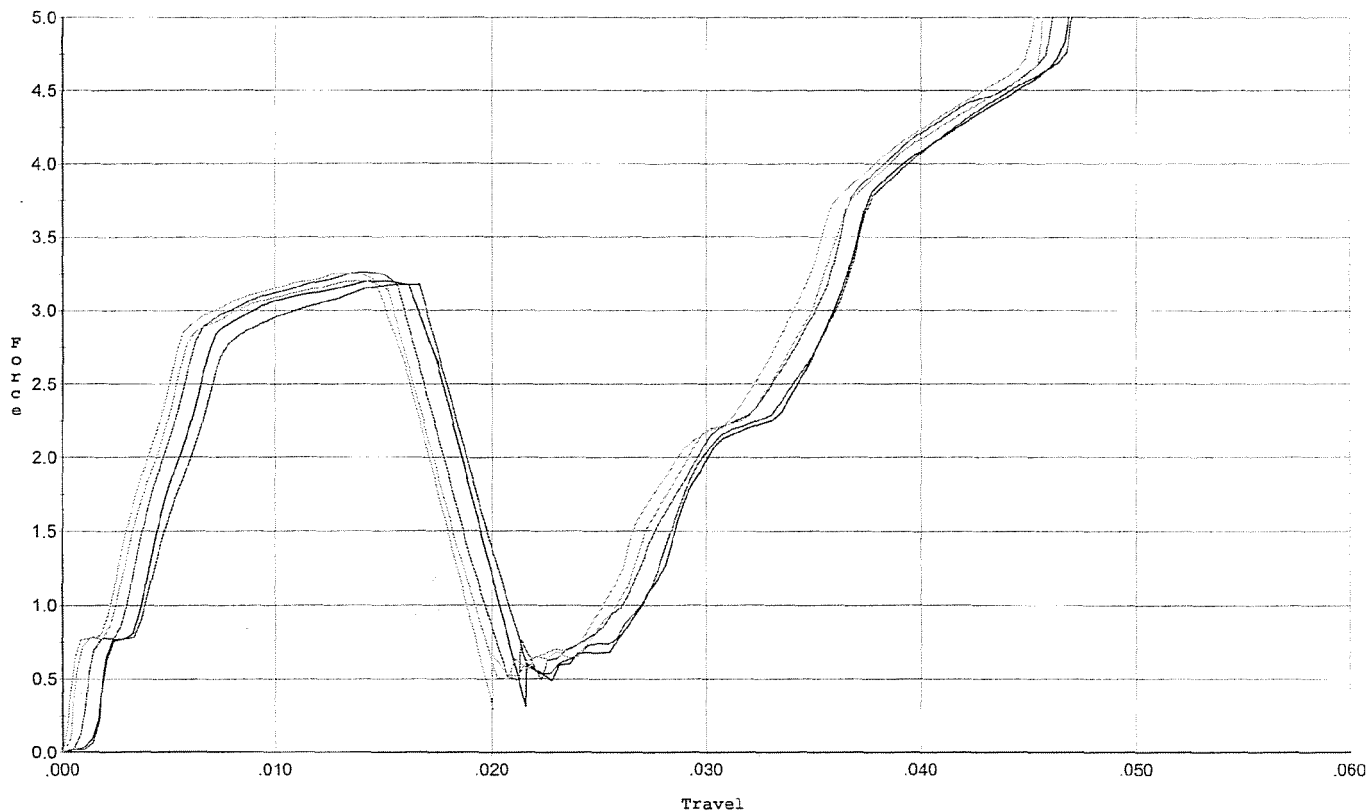
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.186	0.017	0.00	0.033	0.034		Set Trigger
2	3.142	0.017	0.00	0.032	0.036		Set Trigger
3	3.124	0.017	0.00	0.032	0.036		Set Trigger
4	3.153	0.015	0.00	0.033	0.033		Set Trigger
5	3.230	0.016	0.00	0.032	0.035		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



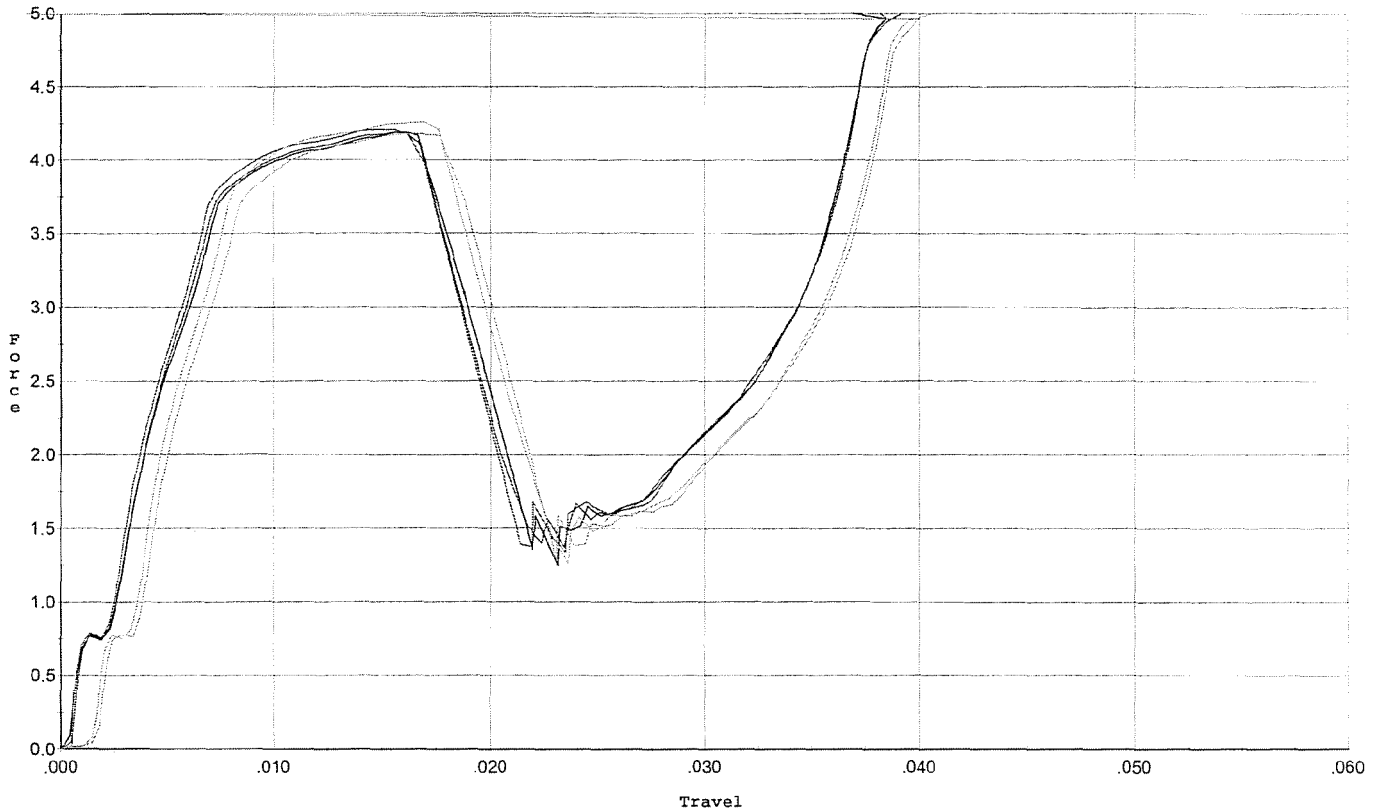
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.176	0.017	0.00	0.032	0.035		Set Trigger
2	3.202	0.017	0.00	0.032	0.037		Set Trigger
3	3.260	0.016	0.00	0.032	0.035		Set Trigger
4	3.255	0.016	0.00	0.031	0.037		Set Trigger
5	3.200	0.015	0.00	0.032	0.034		Set Trigger

A.3.21

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schuits 3/18/2009

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



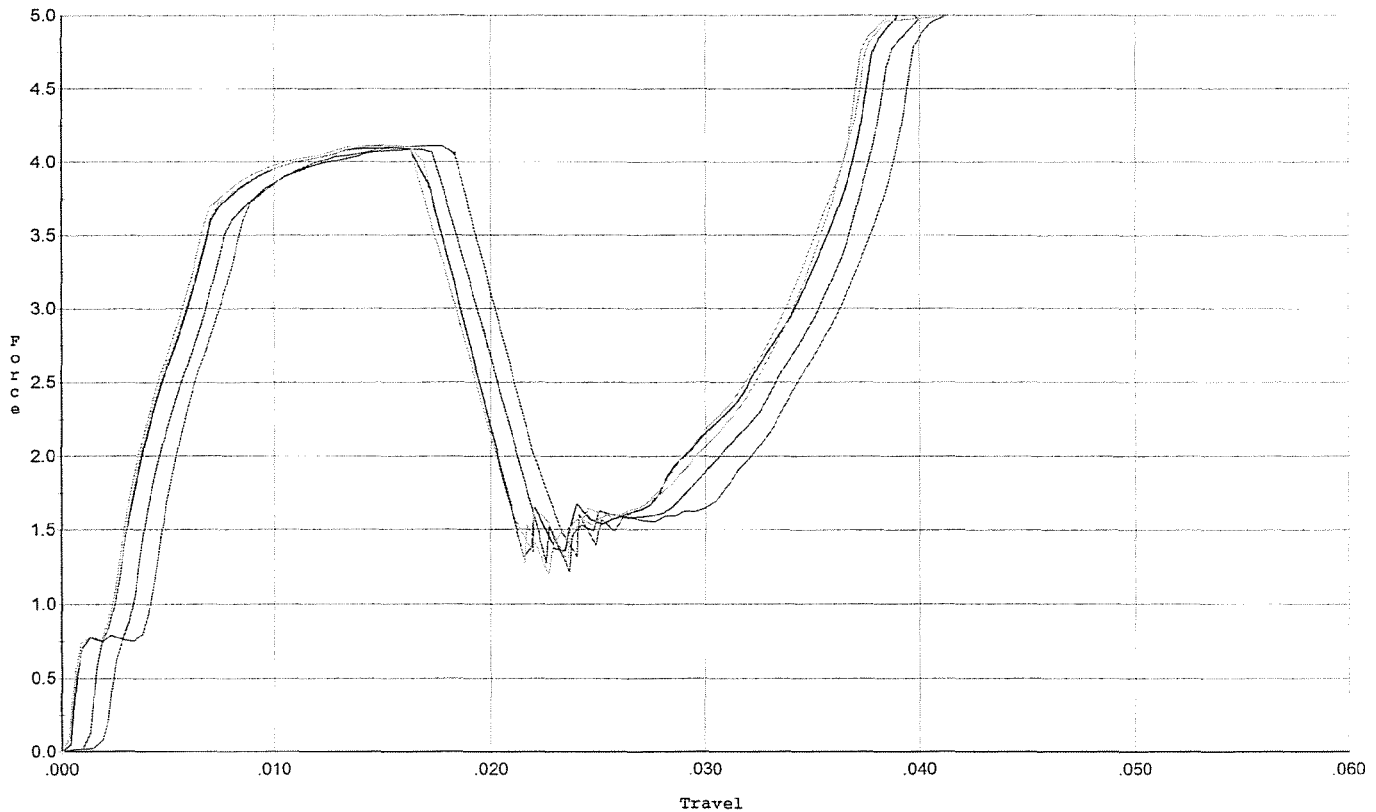
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.187	0.017	0.00	0.029	0.048		Set Trigger
2	4.188	0.019	0.00	0.029	0.053		Set Trigger
3	4.209	0.017	0.00	0.029	0.049		Set Trigger
4	4.254	0.018	0.00	0.030	0.049		Set Trigger
5	4.177	0.019	0.00	0.030	0.051		Set Trigger

A. 4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



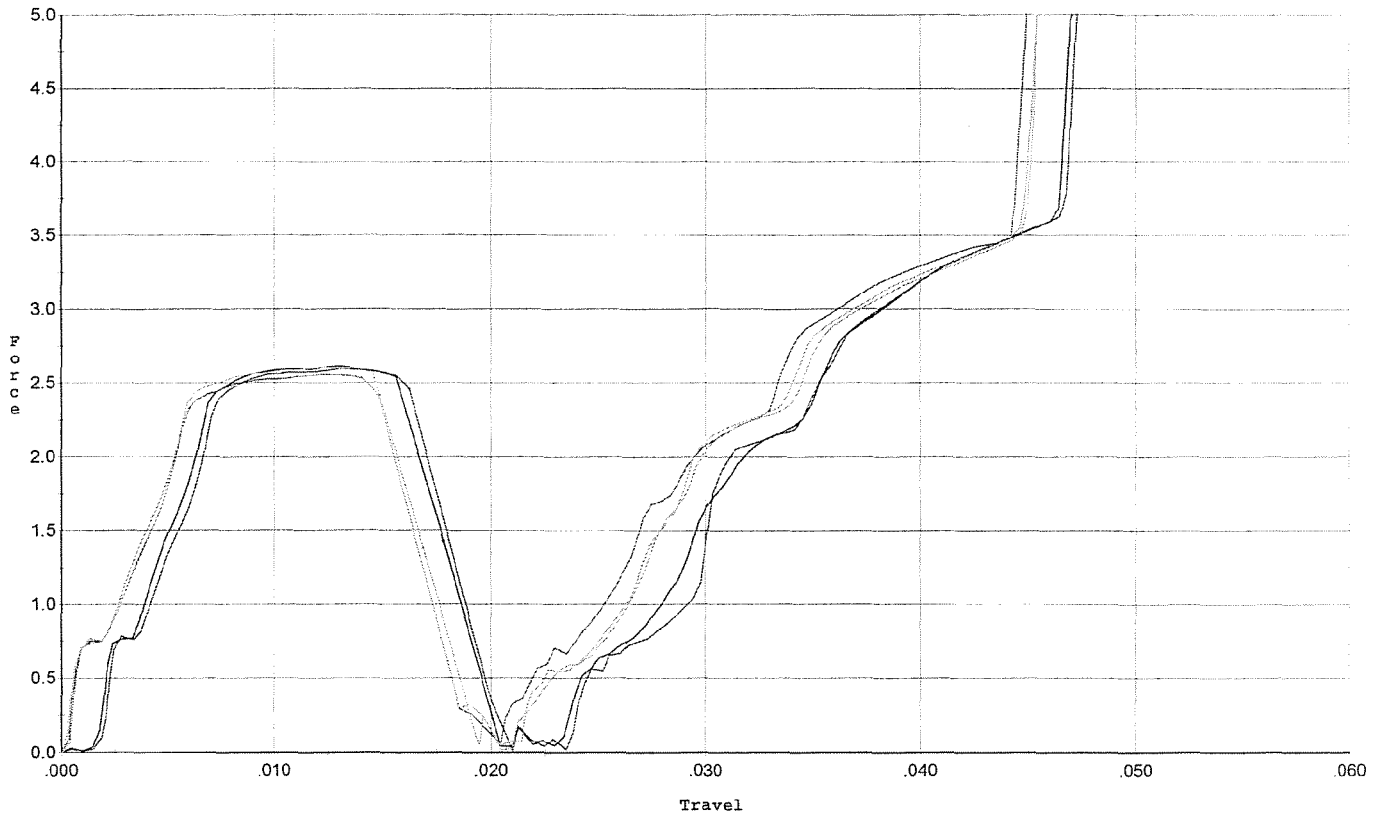
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.020	0.00	0.030	0.053		Set Trigger
2	4.092	0.017	0.00	0.030	0.049		Set Trigger
3	4.109	0.018	0.002	0.030	0.049		Set Trigger
4	4.110	0.017	0.00	0.029	0.048		Set Trigger
5	4.118	0.019	0.00	0.029	0.053		Set Trigger

A. 4.10

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



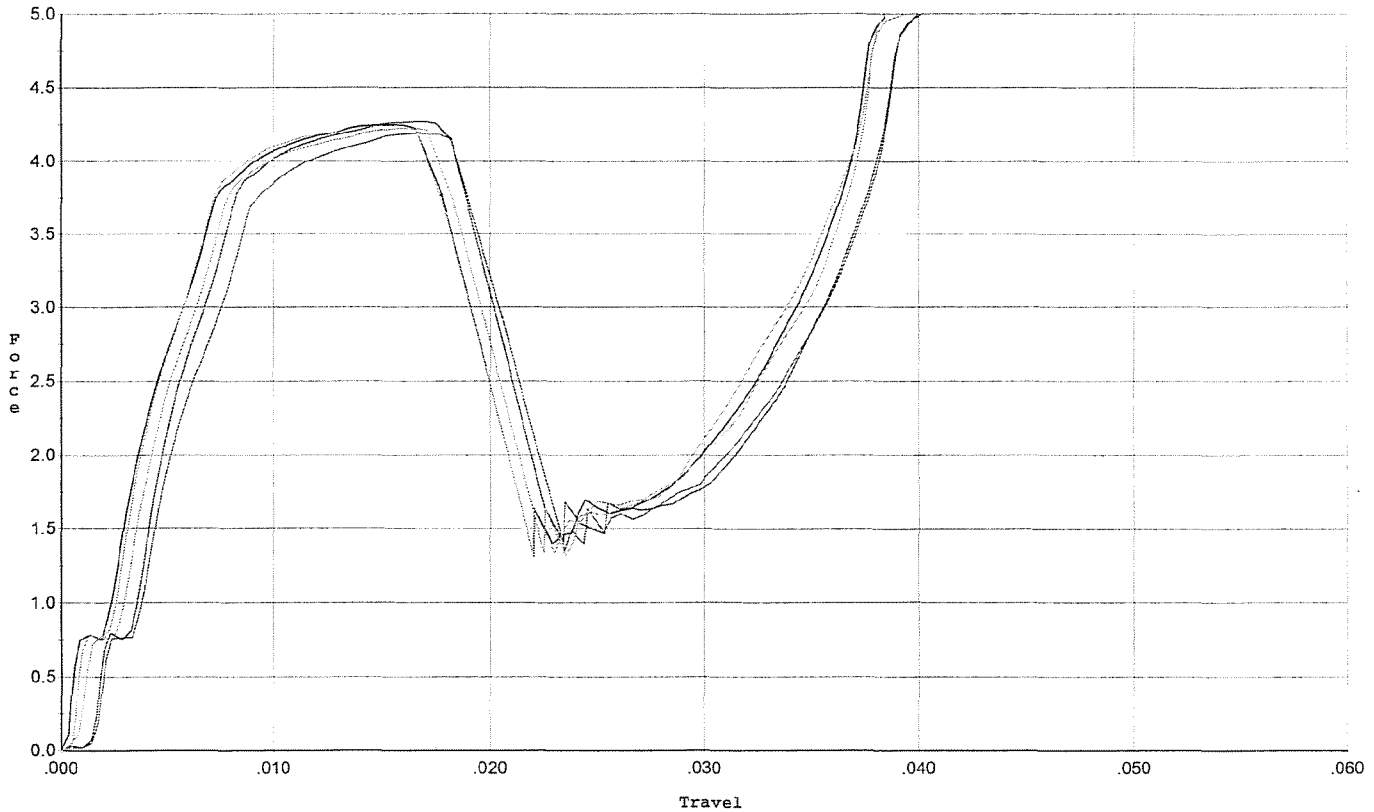
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.598	0.016	0.00	0.034	0.028		Set Trigger
2	2.612	0.018	0.00	0.033	0.031		Set Trigger
3	2.555	0.015	0.00	0.033	0.027		Set Trigger
4	2.552	0.015	0.00	0.033	0.027		Set Trigger
5	2.606	0.017	0.00	0.033	0.032		Set Trigger

A-258

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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	4.268	0.018	0.00	0.030	0.051		Set Trigger
2	4.247	0.018	0.00	0.030	0.052		Set Trigger
3	4.186	0.021	0.004	0.030	0.055		Set Trigger
4	4.241	0.018	0.00	0.030	0.052		Set Trigger
5	4.223	0.018	0.00	0.029	0.052		Set Trigger

A-4.23