

56810363

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



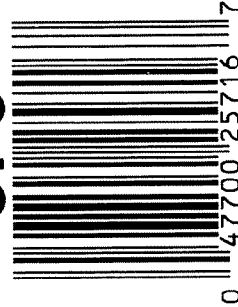
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6810363

UPC



GUN SERIAL # G6810363

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	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	3/13/09	(H)
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-26-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

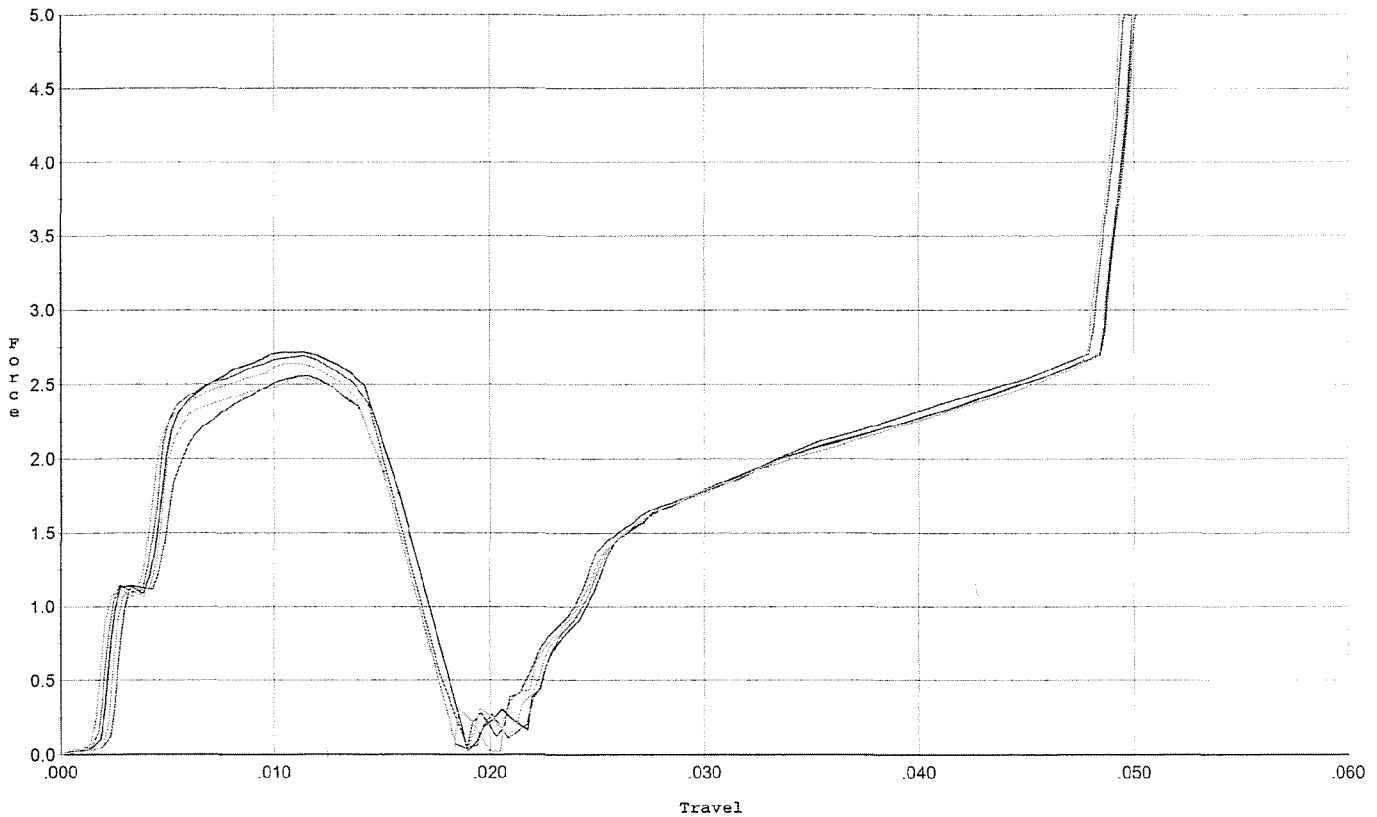
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>30</u> <u>30</u>	3-30-09	LH
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	3-30-09	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-30-09	LH
	J) ASSEMBLE STOCK		3-26-09	LH
	K) ASSEMBLE SWIVEL STUDS		3-30-09	RJ
	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	3-27-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-30-09	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.41</u> <u>2.35</u> <u>2.43</u> <u>2.51</u>	3-28-09	TL
	C) FUNCTION		3-30-09	LH
690	PACK		3/31/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



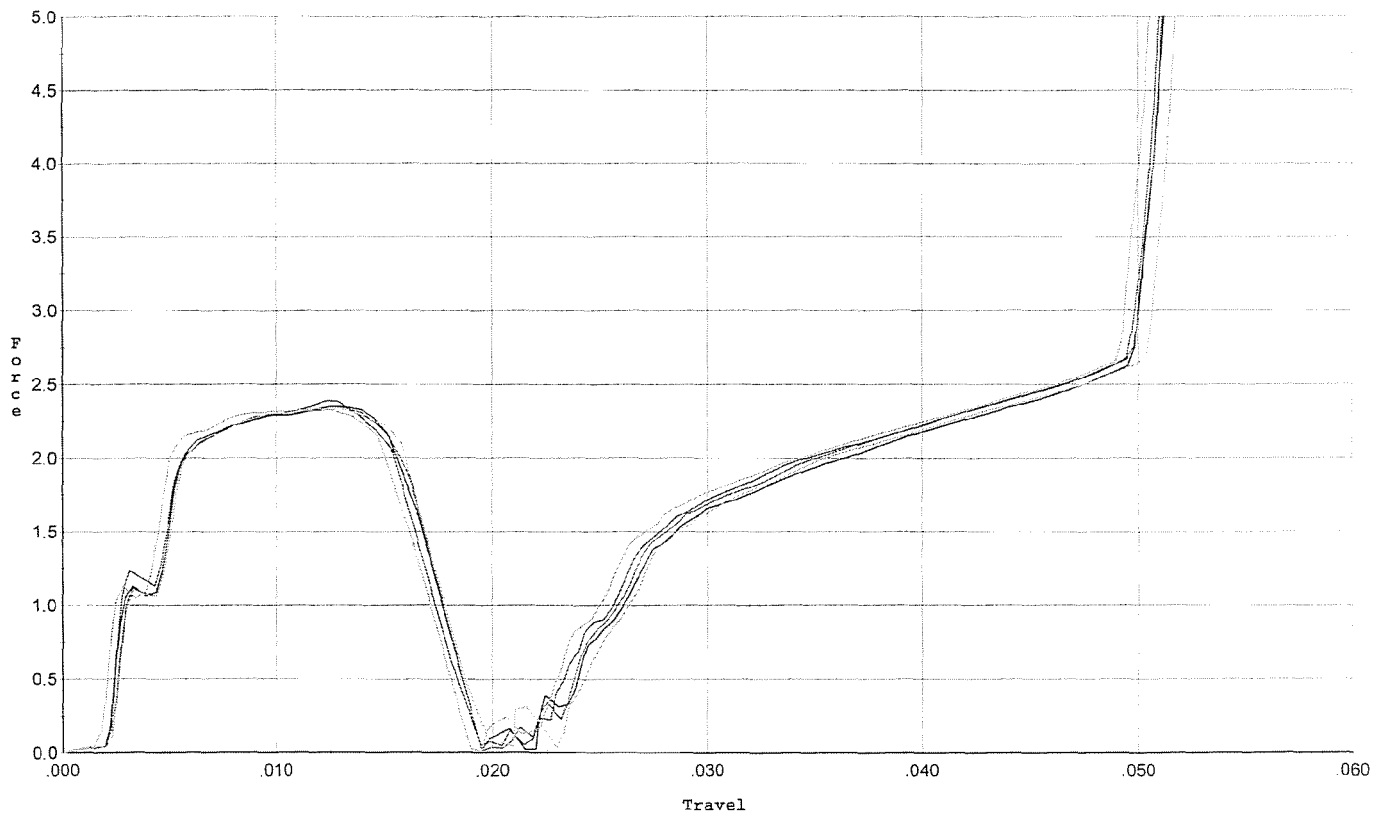
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.558	0.015	0.005	0.038	0.025		Set Trigger
2	2.720	0.016	0.00	0.038	0.029		Set Trigger
3	2.691	0.014	0.00	0.039	0.026		Set Trigger
4	2.550	0.015	0.00	0.038	0.026		Set Trigger
5	2.642	0.015	0.00	0.038	0.027		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

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

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



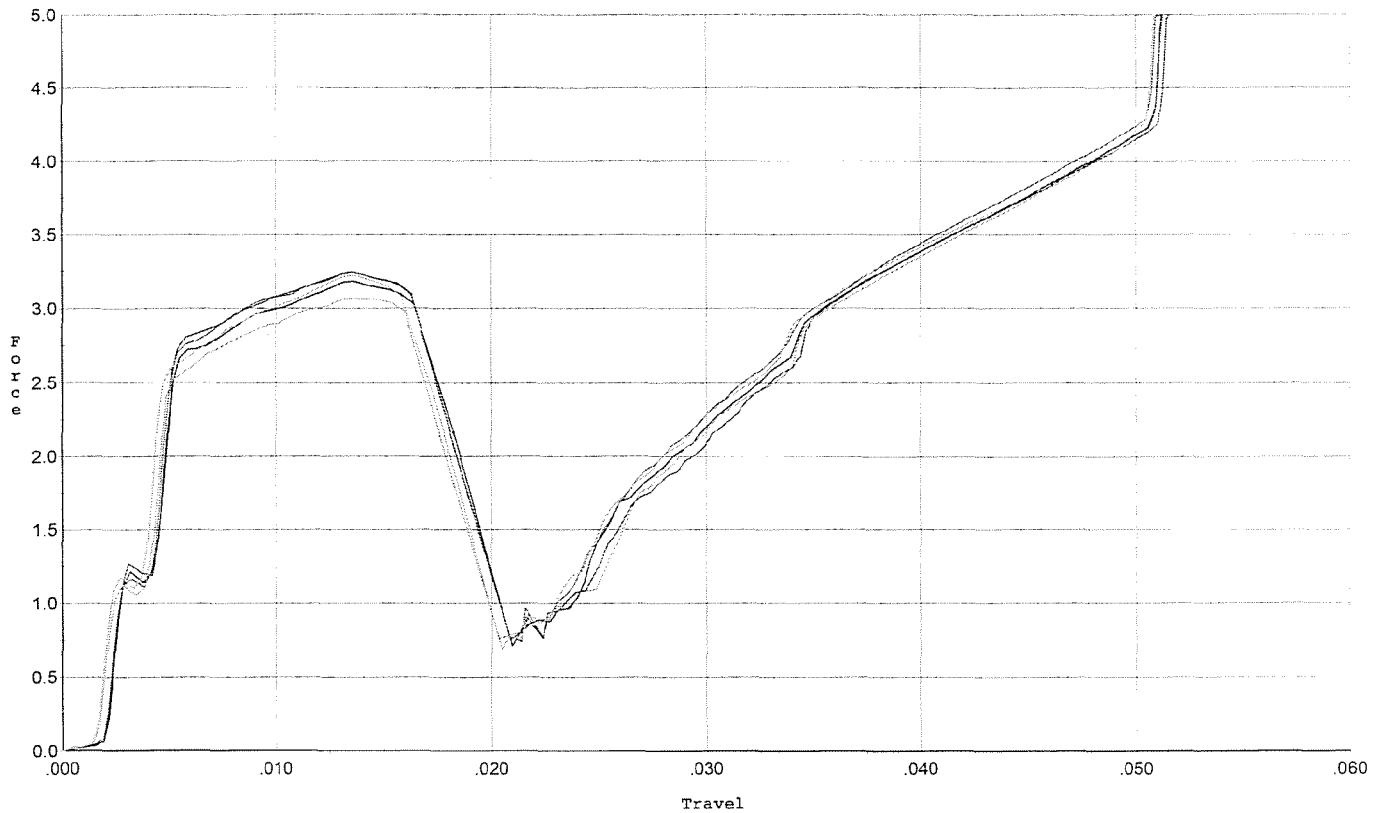
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.387	0.015	0.005	0.039	0.025		Set Trigger
2	2.351	0.017	0.00	0.039	0.027		Set Trigger
3	2.348	0.016	0.00	0.039	0.026		Set Trigger
4	2.337	0.016	0.005	0.039	0.025		Set Trigger
5	2.337	0.016	0.00	0.039	0.027		Set Trigger

A-2-35

Trigger Profile [lbs,inch]

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

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



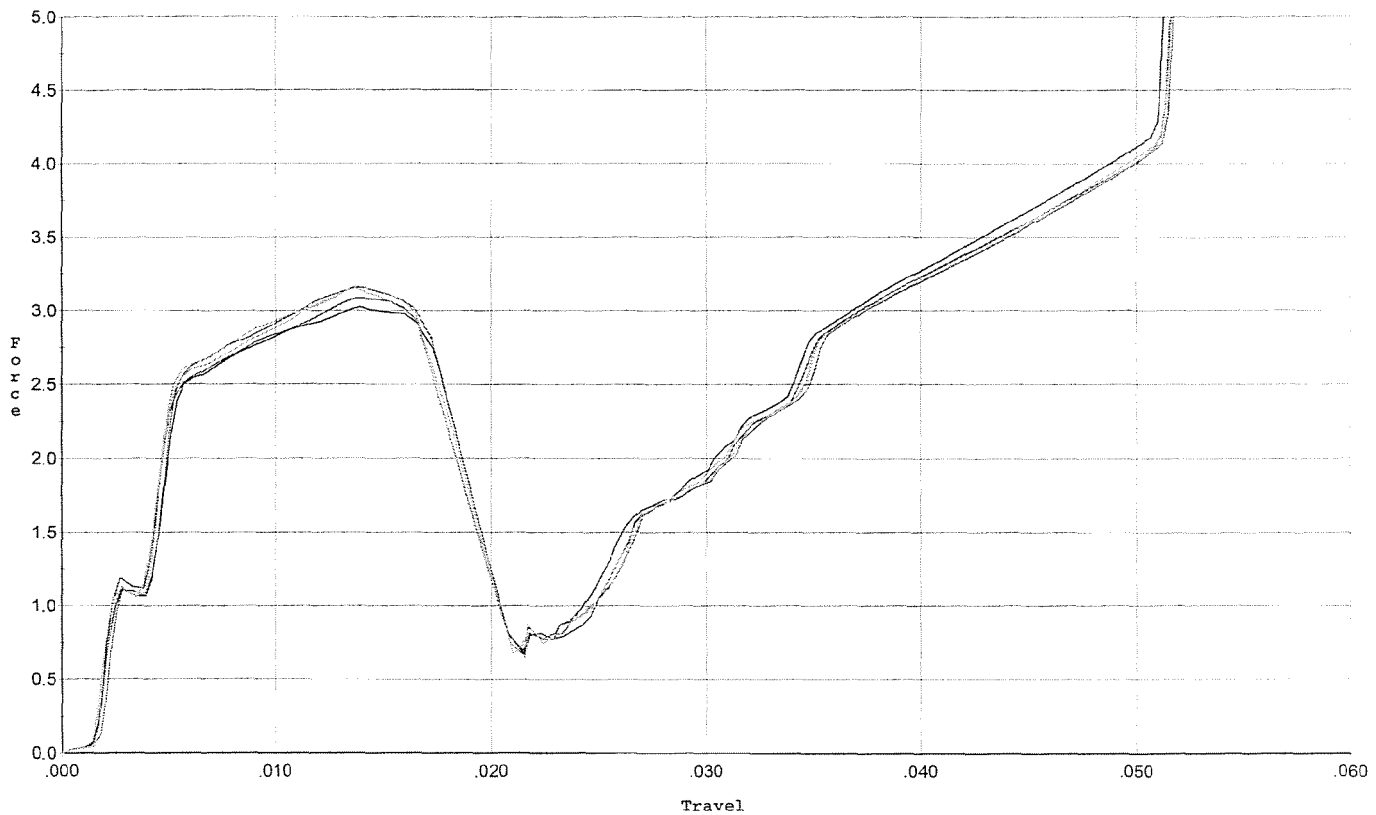
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.242	0.016	0.004	0.036	0.036		Set Trigger
2	3.181	0.018	0.00	0.035	0.039		Set Trigger
3	3.244	0.016	0.00	0.035	0.036		Set Trigger
4	3.226	0.017	0.00	0.035	0.038		Set Trigger
5	3.069	0.016	0.00	0.036	0.034		Set Trigger

A-3-19

Trigger Profile [lbs,inch]

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

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



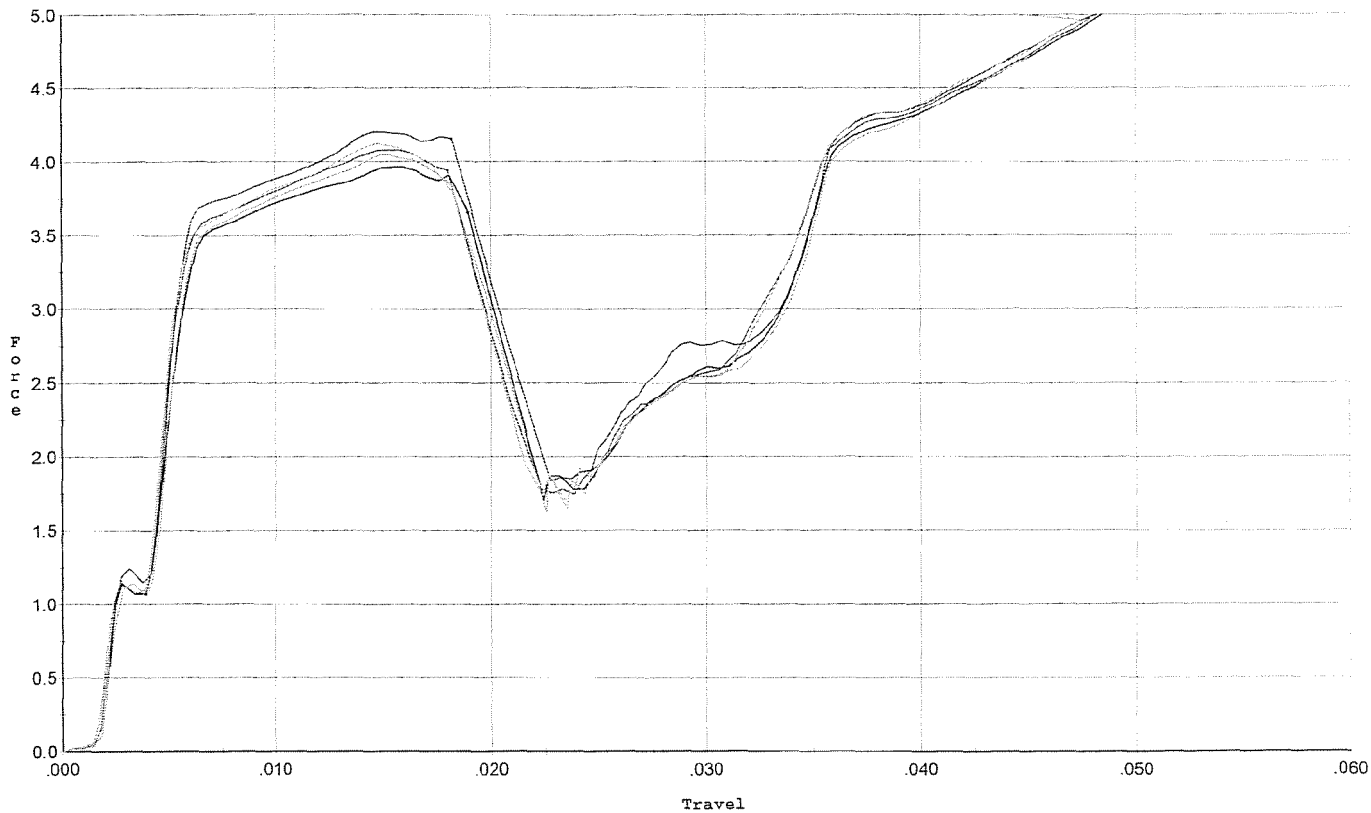
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.086	0.017	0.004	0.036	0.035		Set Trigger
2	3.024	0.017	0.004	0.035	0.036		Set Trigger
3	3.156	0.017	0.004	0.036	0.037		Set Trigger
4	3.168	0.018	0.00	0.036	0.039		Set Trigger
5	3.153	0.017	0.00	0.036	0.036		Set Trigger

A.3.11

Trigger Profile [lbs,inch]

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

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



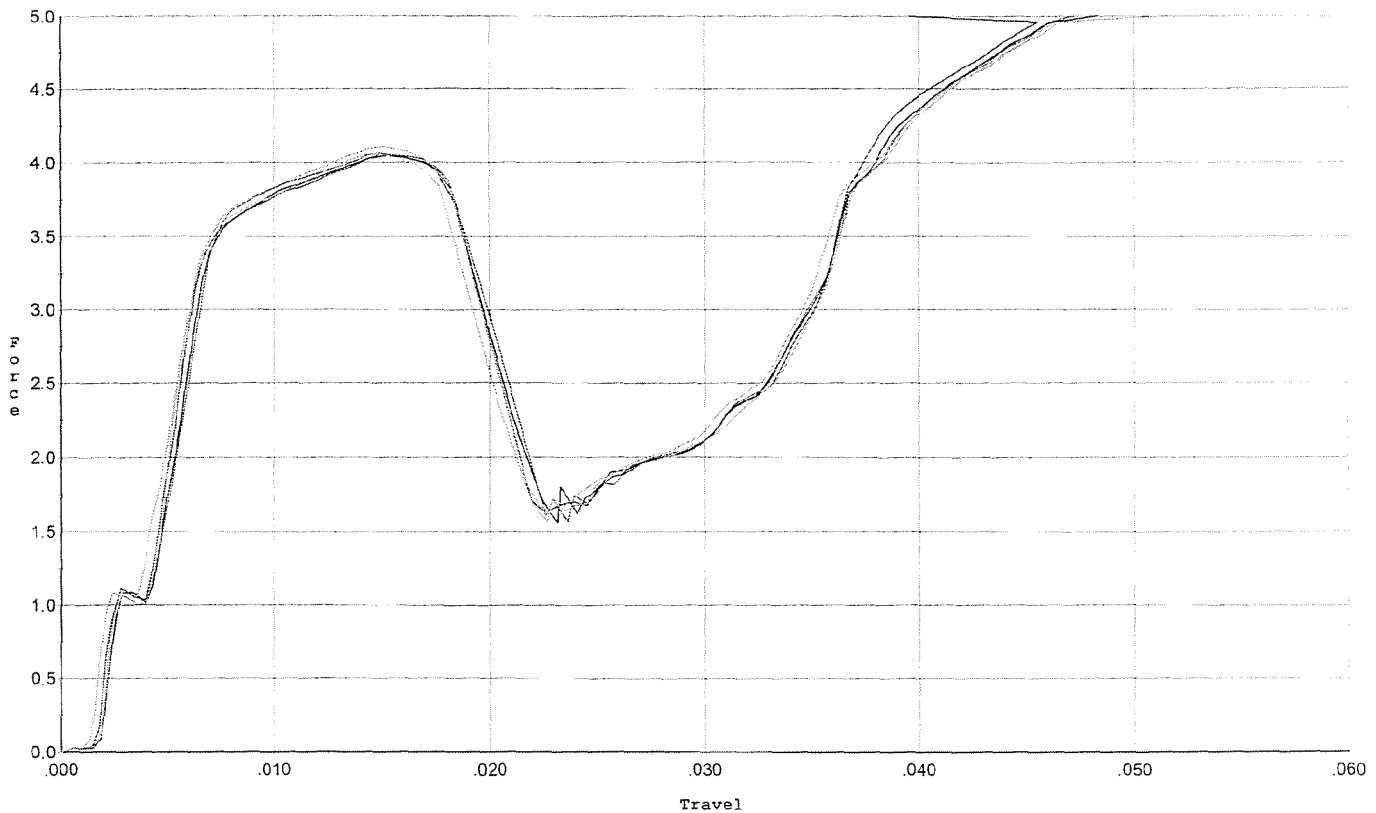
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.205	0.018	0.00	0.032	0.052		Set Trigger
2	3.964	0.019	0.004	0.032	0.051		Set Trigger
3	4.079	0.018	0.004	0.032	0.050		Set Trigger
4	4.124	0.018	0.00	0.033	0.051		Set Trigger
5	4.045	0.020	0.00	0.032	0.054		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

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

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



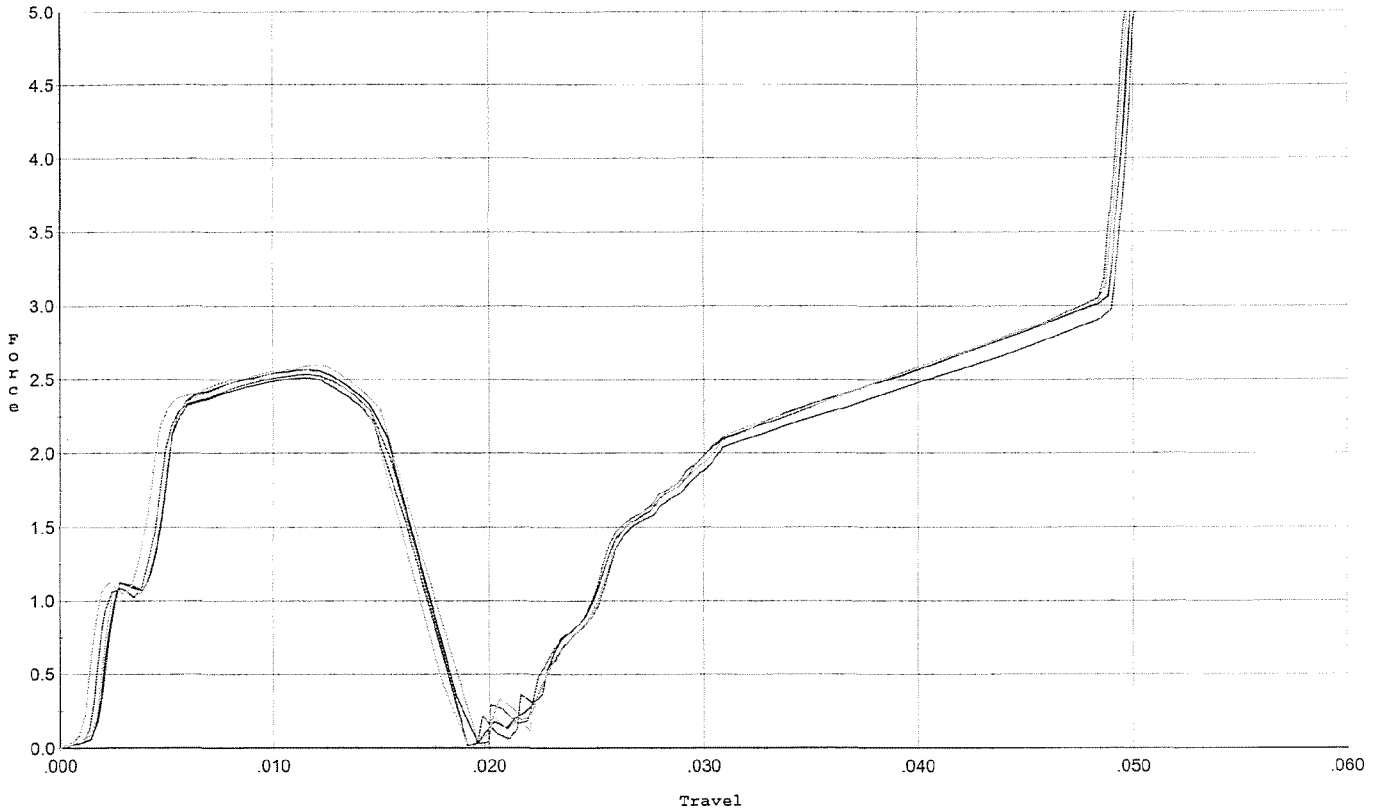
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.018	0.004	0.033	0.049		Set Trigger
2	4.047	0.018	0.002	0.033	0.048		Set Trigger
3	4.066	0.020	0.002	0.033	0.053		Set Trigger
4	4.065	0.018	0.004	0.033	0.048		Set Trigger
5	4.104	0.018	0.004	0.034	0.049		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

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

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



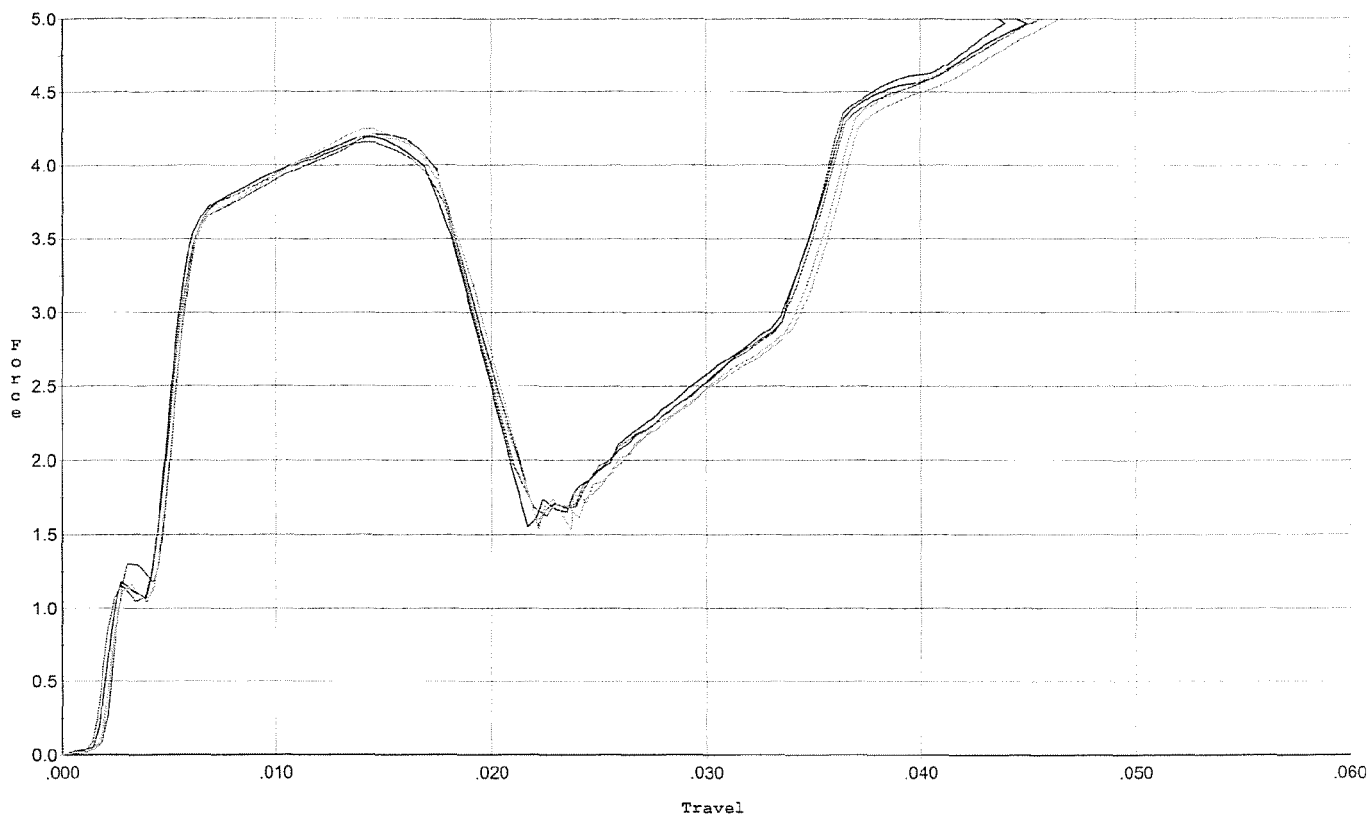
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.513	0.016	0.004	0.038	0.028		Set Trigger
2	2.566	0.015	0.004	0.037	0.027		Set Trigger
3	2.535	0.016	0.00	0.037	0.028		Set Trigger
4	2.569	0.015	0.00	0.038	0.027		Set Trigger
5	2.599	0.015	0.00	0.037	0.027		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

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

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	4.212	0.017	0.005	0.033	0.048		Set Trigger
2	4.195	0.018	0.004	0.033	0.051		Set Trigger
3	4.159	0.018	0.00	0.033	0.049		Set Trigger
4	4.209	0.018	0.00	0.034	0.048		Set Trigger
5	4.252	0.019	0.00	0.033	0.053		Set Trigger

A. 4.20