

66814671

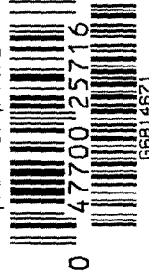
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase

owner registration sticker



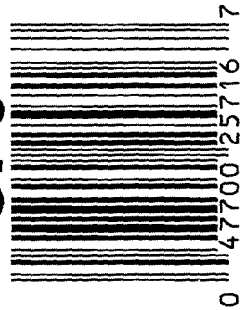
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6814671

UPC



GUN SERIAL #

G 6814671

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RIC
480	MAGNAFLUX BBL ACTION	(4)	3/9/09	(D)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	72
540	APPLY COATINGS (BARREL ACTION)		3-26	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-28-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

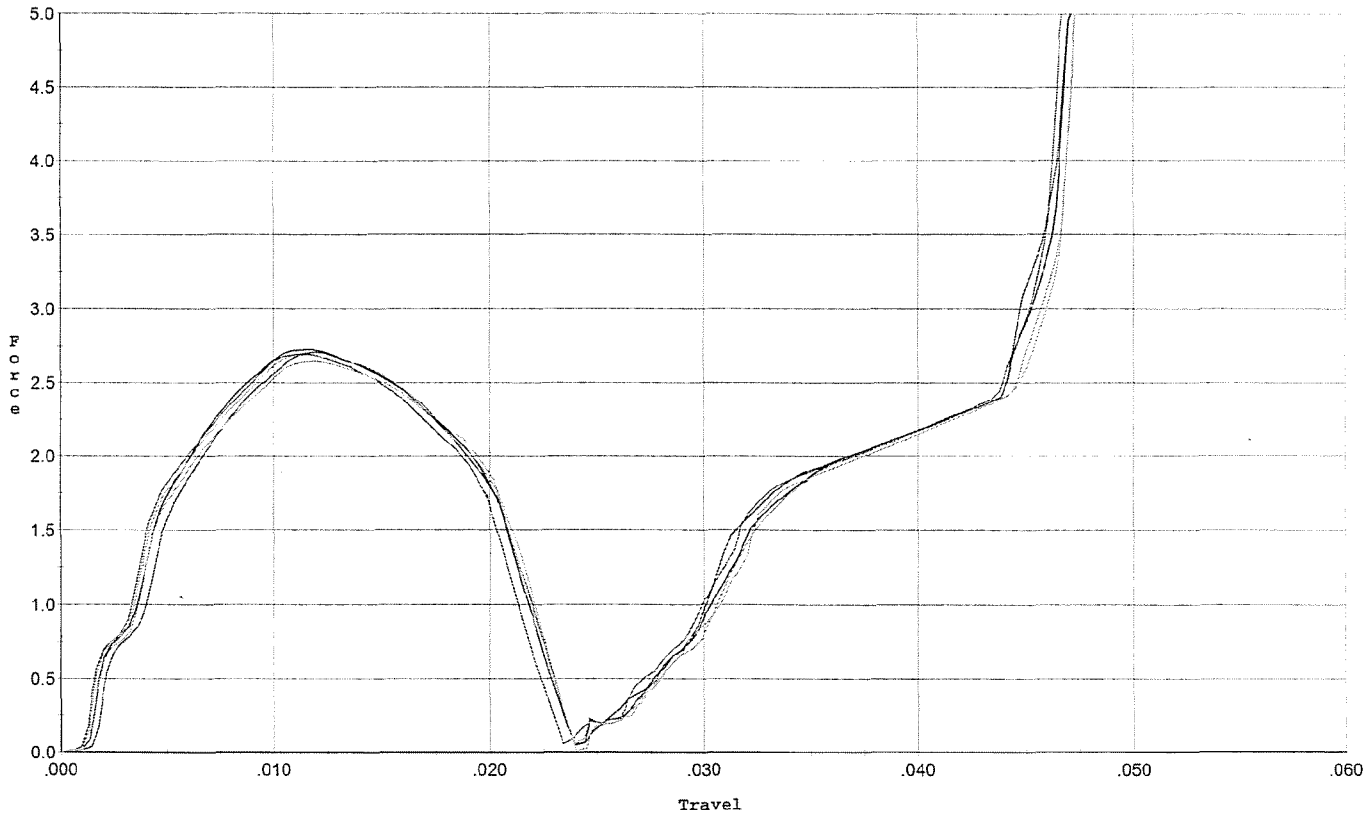
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	3-31-09	LAN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	3-31-09	LAN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-31-09	LAN
	J) ASSEMBLE STOCK		3-28-09	LAN
	K) ASSEMBLE SWIVEL STUDS		3-31-09	LAN
	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	3-30-09	LAN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	LAN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.62</u> <u>2.57</u> <u>2.50</u> <u>2.58</u>	3-31-09	WW
	C) FUNCTION		3-31-09	LAN
690	PACK		4/13/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



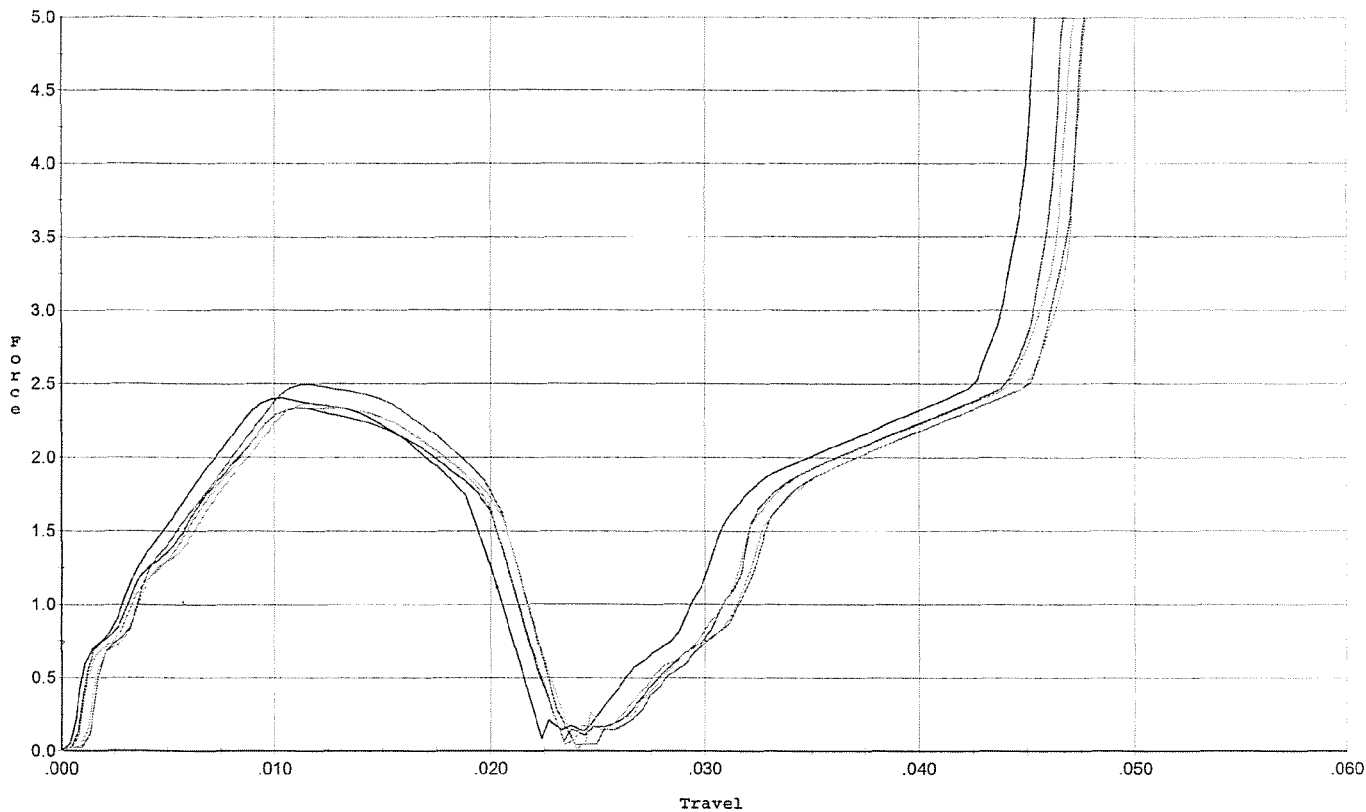
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.707	0.022	0.00	0.031	0.039		Set Trigger
2	2.724	0.020	0.00	0.032	0.038		Set Trigger
3	2.699	0.020	0.00	0.032	0.037		Set Trigger
4	2.687	0.021	0.00	0.032	0.040		Set Trigger
5	2.645	0.022	0.00	0.032	0.040		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



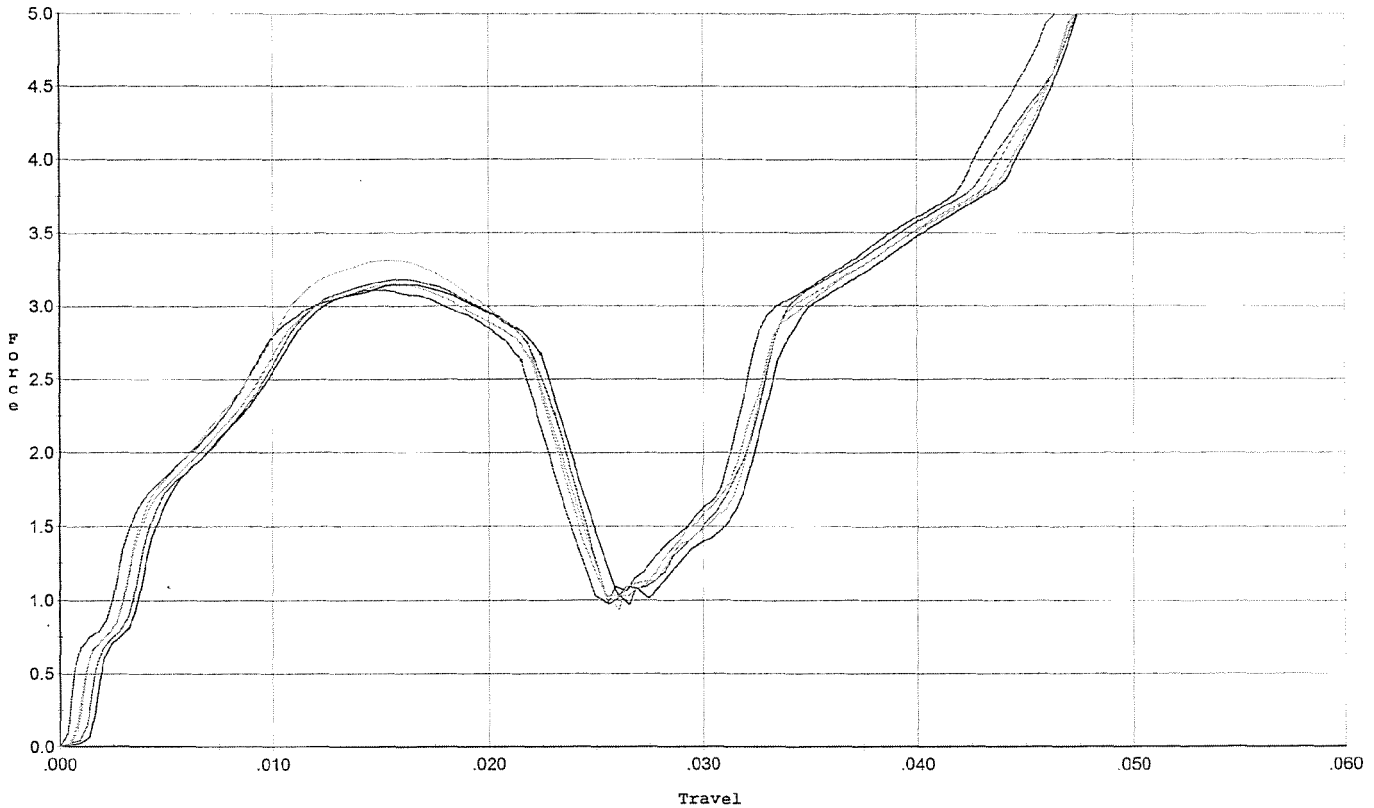
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.334	0.020	0.00	0.032	0.033		Set Trigger
2	2.404	0.020	0.00	0.031	0.034		Set Trigger
3	2.496	0.021	0.00	0.032	0.035		Set Trigger
4	2.369	0.021	0.00	0.032	0.033		Set Trigger
5	2.339	0.020	0.00	0.032	0.033		Set Trigger

A 2.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



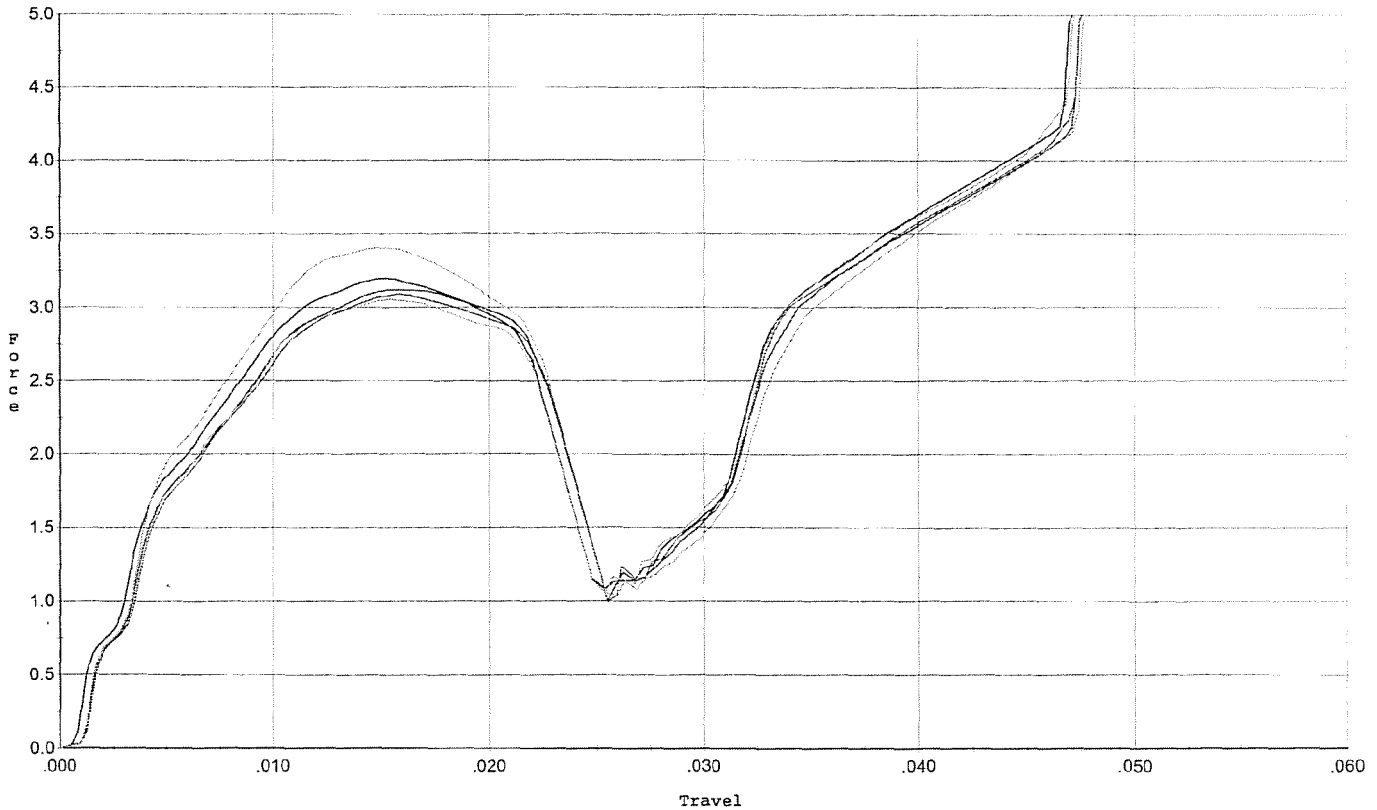
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.111	0.022	0.00	0.029	0.048		Set Trigger
2	3.147	0.022	0.00	0.029	0.048		Set Trigger
3	3.185	0.023	0.00	0.029	0.050		Set Trigger
4	3.315	0.022	0.00	0.029	0.050		Set Trigger
5	3.151	0.022	0.00	0.029	0.048		Set Trigger

A3-18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



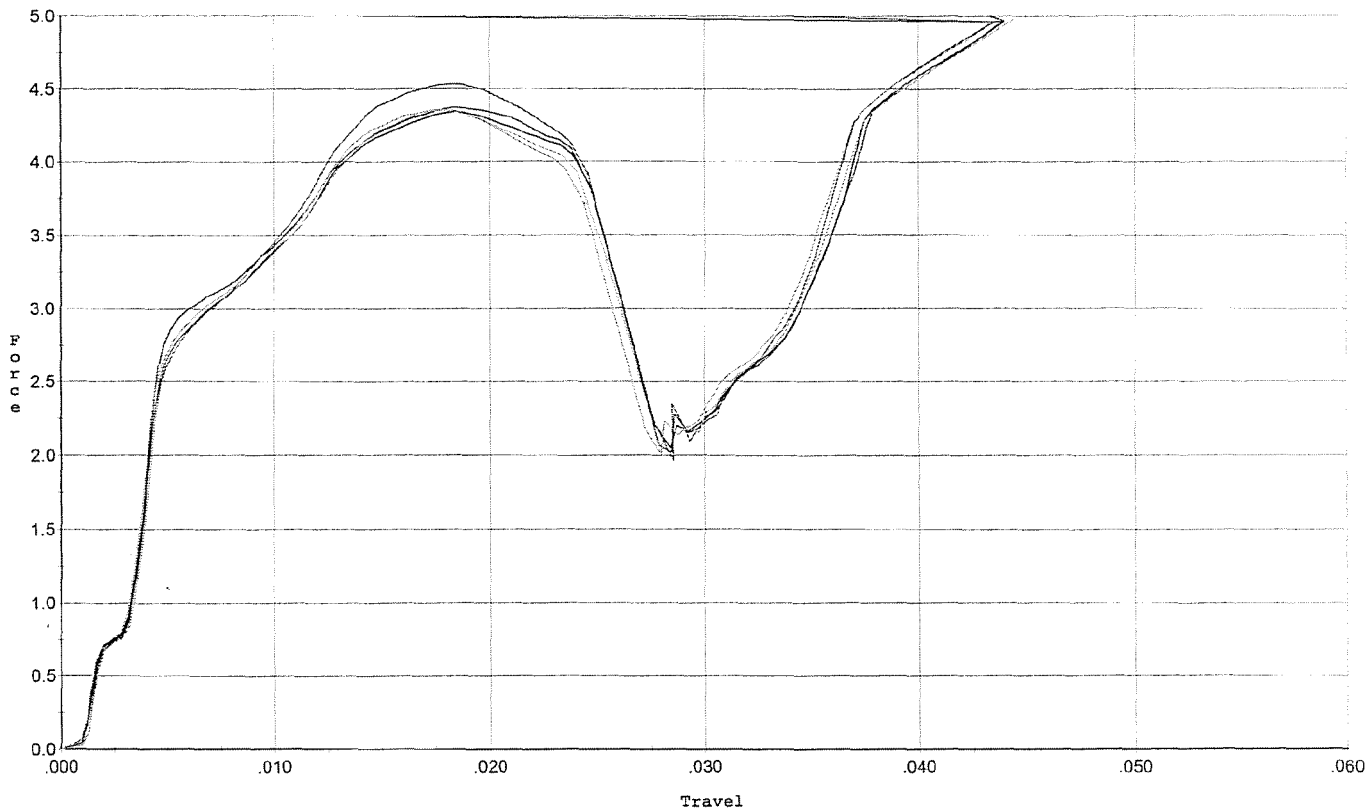
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.120	0.023	0.00	0.029	0.050		Set Trigger
2	3.199	0.022	0.00	0.029	0.049		Set Trigger
3	3.091	0.023	0.00	0.029	0.049		Set Trigger
4	3.056	0.022	0.00	0.029	0.047		Set Trigger
5	3.404	0.022	0.00	0.029	0.053		Set Trigger

A.3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



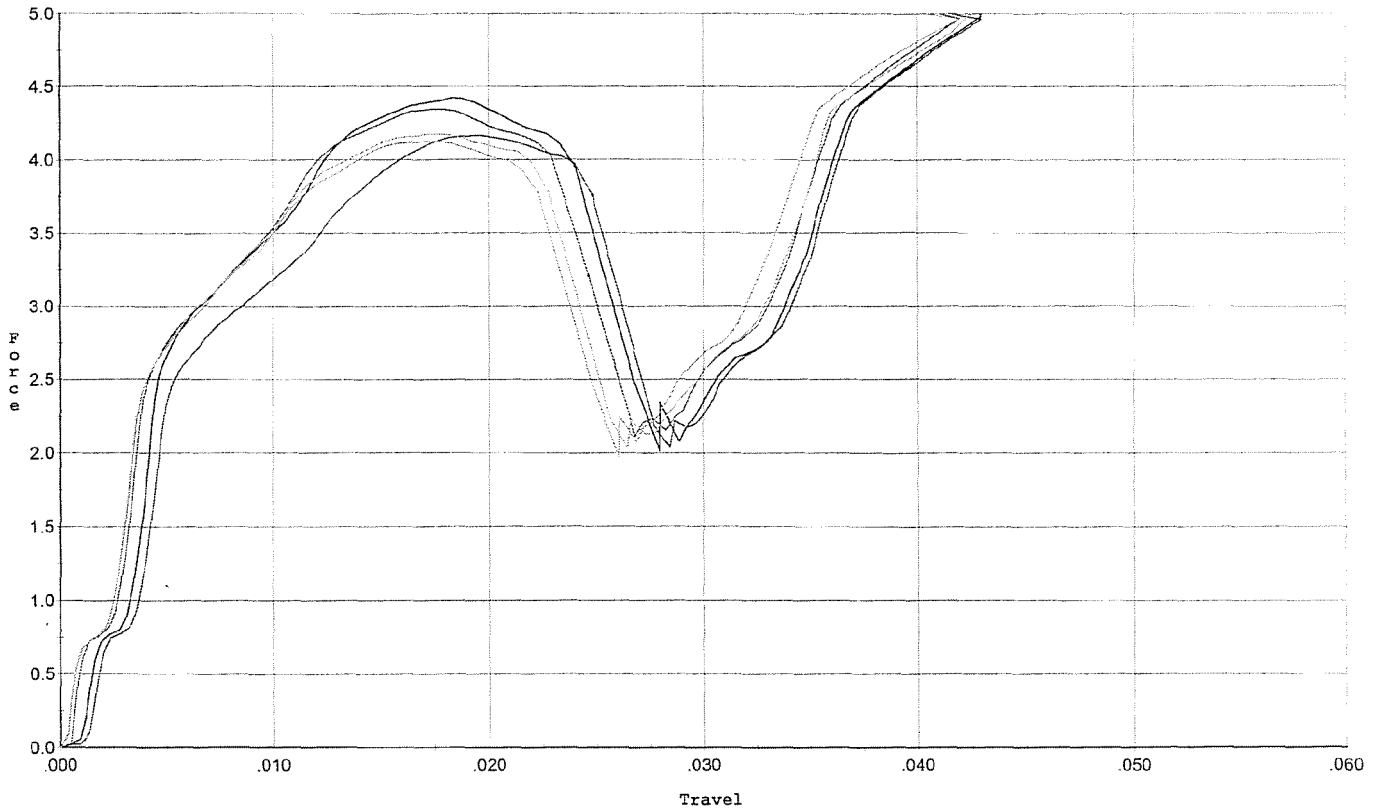
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.374	0.025	0.00	0.022	0.076		Set Trigger
2	4.343	0.025	0.00	0.021	0.074		Set Trigger
3	4.536	0.025	0.00	0.021	0.076		Set Trigger
4	4.353	0.025	0.00	0.021	0.076		Set Trigger
5	4.361	0.024	0.00	0.021	0.073		Set Trigger

A. 4.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



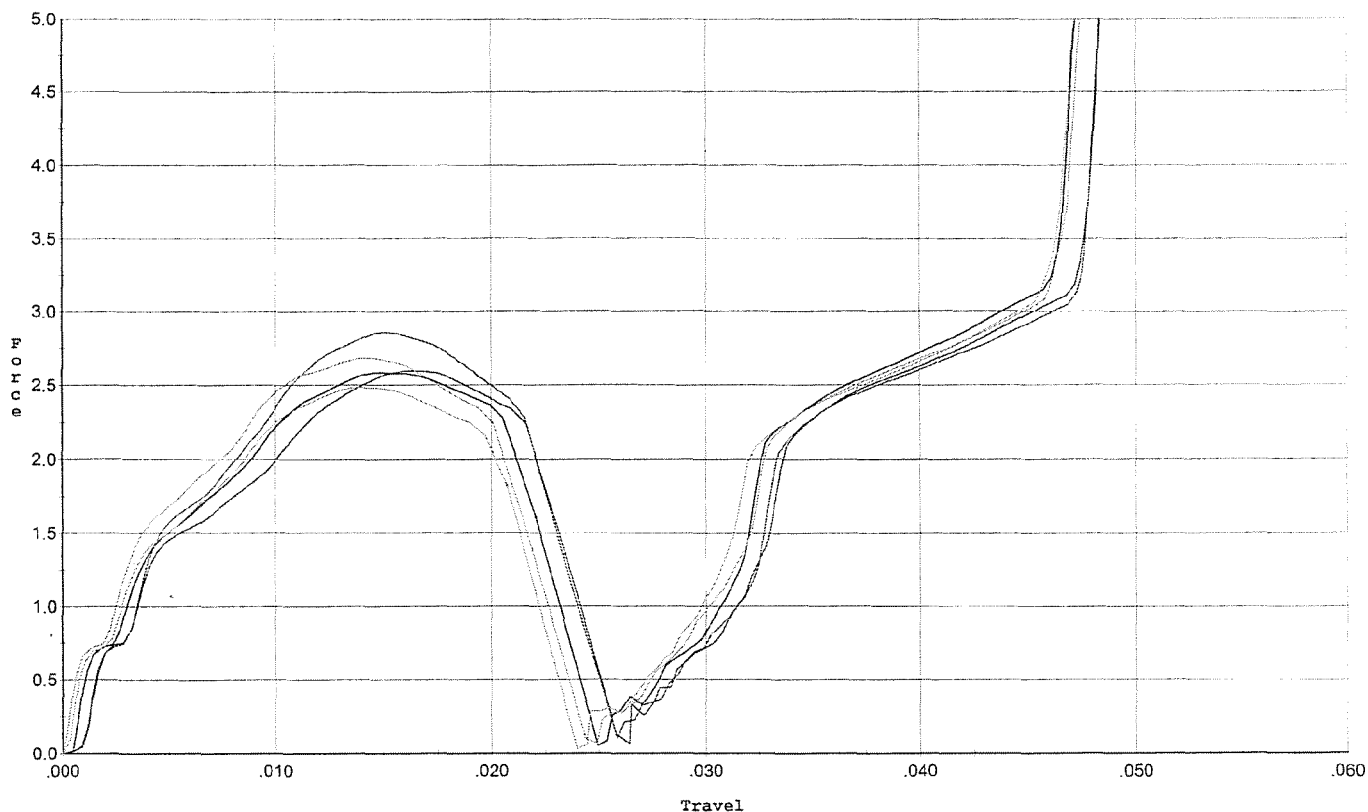
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.162	0.025	0.00	0.021	0.071		Set Trigger
2	4.420	0.024	0.00	0.020	0.073		Set Trigger
3	4.345	0.025	0.00	0.021	0.075		Set Trigger
4	4.174	0.023	0.00	0.022	0.068		Set Trigger
5	4.123	0.022	0.00	0.022	0.066		Set Trigger

A-4.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



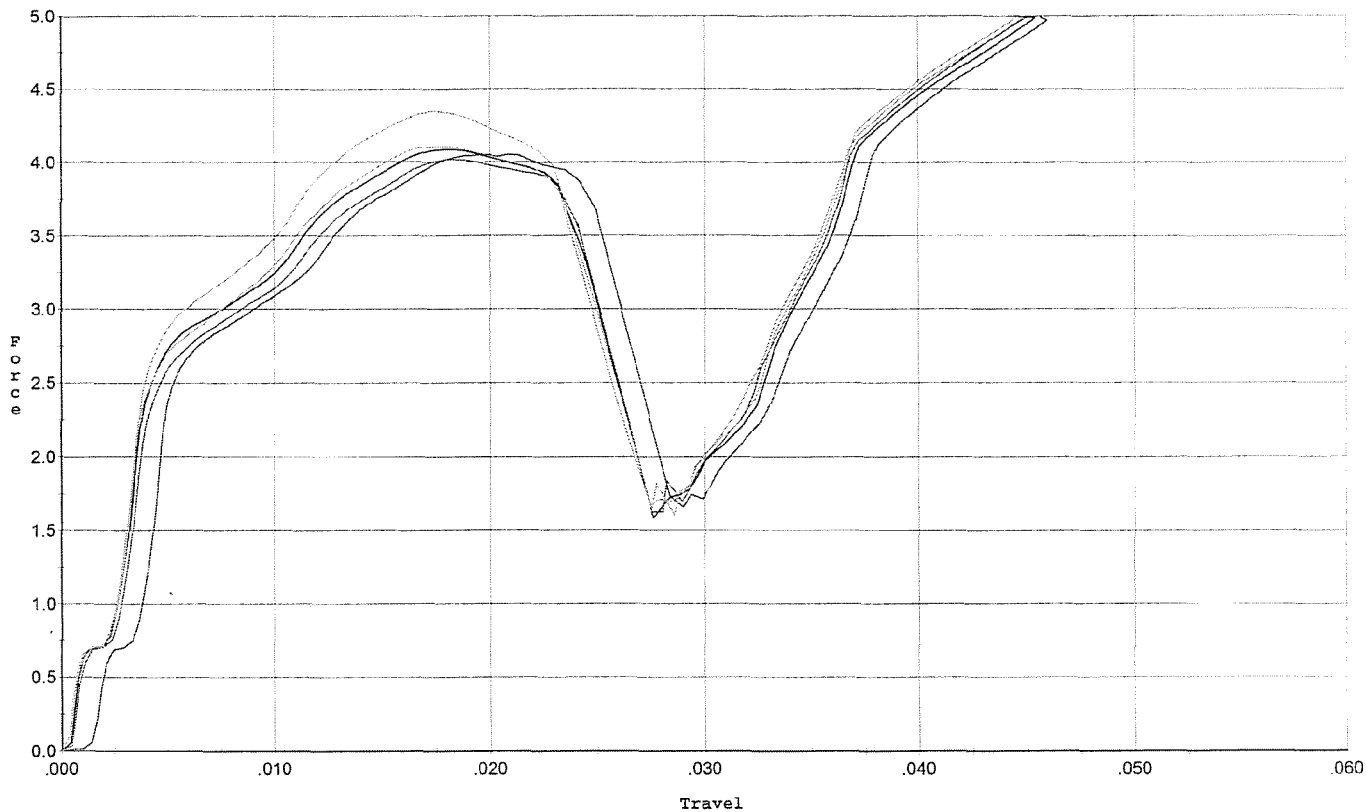
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.023	0.00	0.031	0.042		Set Trigger
2	2.582	0.022	0.00	0.031	0.040		Set Trigger
3	2.858	0.022	0.00	0.031	0.042		Set Trigger
4	2.485	0.021	0.00	0.031	0.037		Set Trigger
5	2.686	0.022	0.00	0.031	0.042		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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	4.056	0.025	0.00	0.022	0.070		Set Trigger
2	4.088	0.024	0.00	0.023	0.071		Set Trigger
3	4.015	0.024	0.00	0.023	0.069		Set Trigger
4	4.107	0.023	0.00	0.023	0.068		Set Trigger
5	4.352	0.025	0.00	0.022	0.076		Set Trigger

A-4.12