

76814683

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

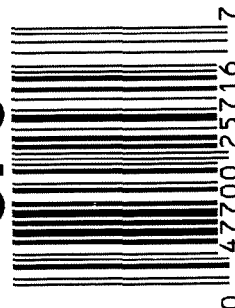
24"

CAPACITY

6

G6814683

UPC



GUN SERIAL # G 6814683

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	MAGNA - FLUX	3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE		3-6-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	3/9/09	(H)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-6-09	SP
520	GOFF BLAST BBL / REC		3/11	mm
540	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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

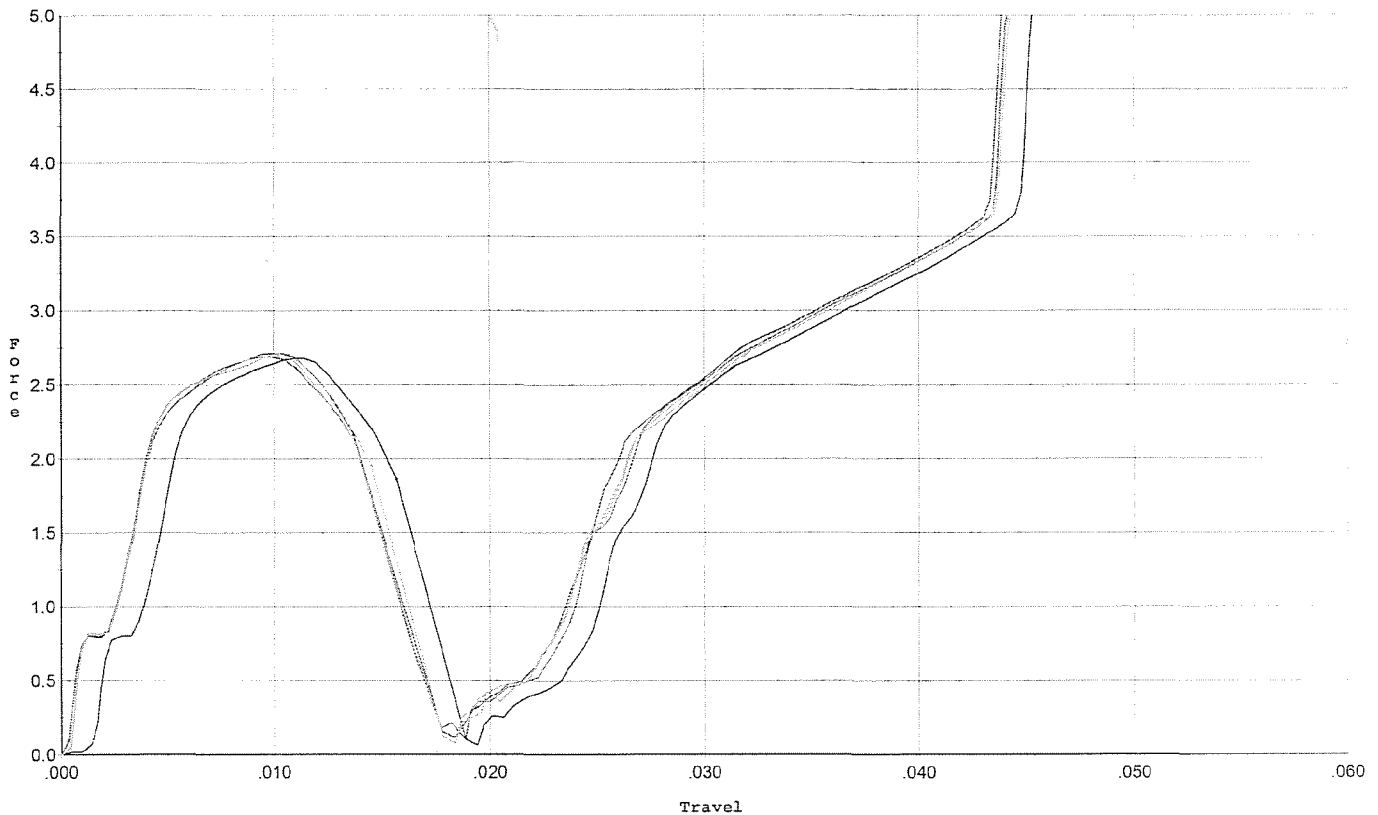
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-26-09	WW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>5</u>	3-26-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	3-26-09	WW
	J) ASSEMBLE STOCK		3-26-09	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		3-26-09	WW
	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	3-25-09	TK
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WW
670	FINAL INSPECTION A) HEADSPACE		3-26-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.34</u> <u>2.42</u> <u>2.32</u> <u>2.44</u>	3-25-09	TK
	C) FUNCTION		3-26-09	WW
690	PACK		3-26-09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



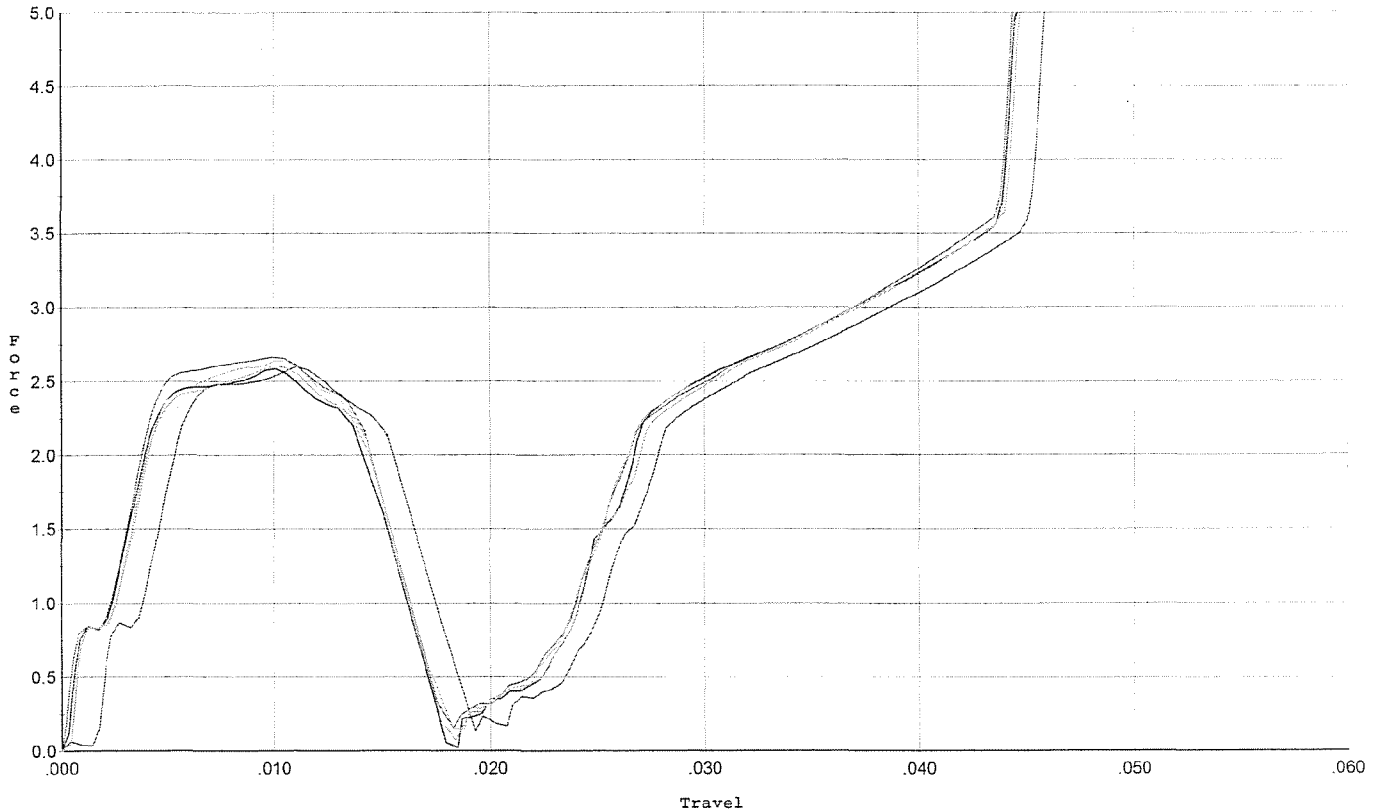
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.714	0.014	0.00	0.032	0.026		Set Trigger
2	2.678	0.016	0.00	0.032	0.027		Set Trigger
3	2.690	0.014	0.00	0.033	0.026		Set Trigger
4	2.707	0.014	0.00	0.033	0.026		Set Trigger
5	2.715	0.015	0.00	0.032	0.028		Set Trigger

A-2.70

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



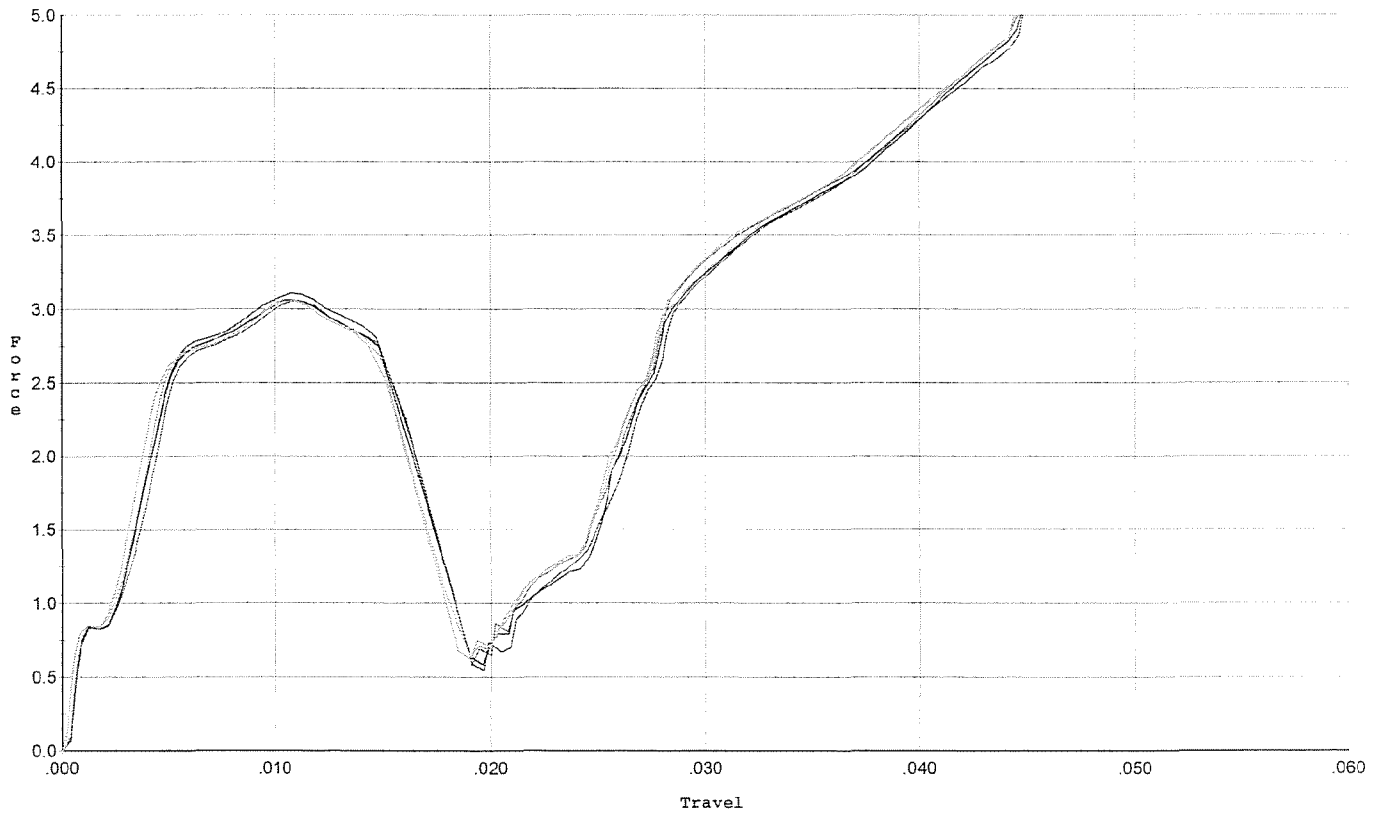
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.015	0.002	0.033	0.026		Set Trigger
2	2.587	0.015	0.00	0.033	0.028		Set Trigger
3	2.664	0.014	0.00	0.032	0.028		Set Trigger
4	2.642	0.014	0.00	0.033	0.027		Set Trigger
5	2.607	0.014	0.00	0.033	0.027		Set Trigger

A. 2.62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



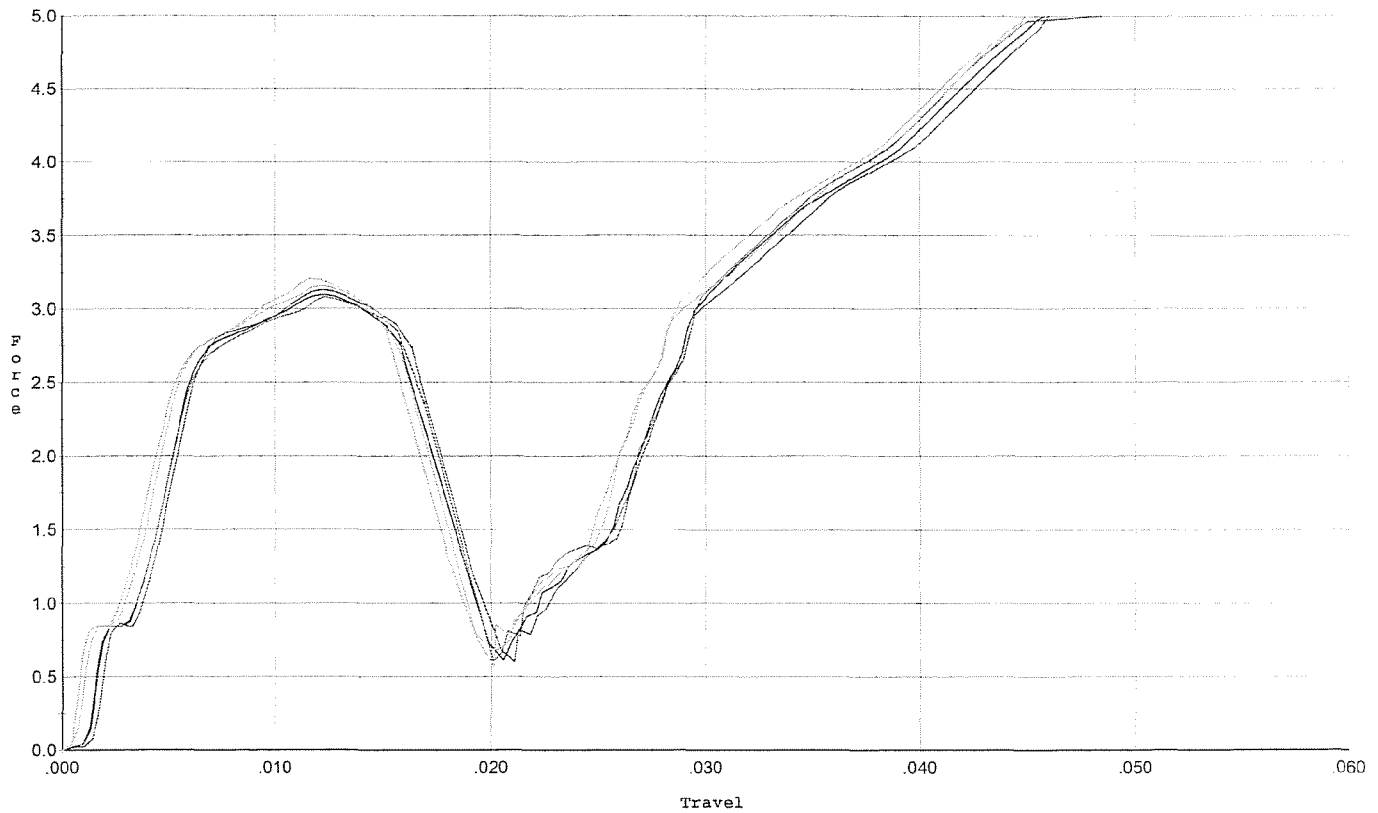
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.108	0.016	0.00	0.030	0.035		Set Trigger
2	3.067	0.017	0.00	0.030	0.035		Set Trigger
3	3.055	0.016	0.00	0.030	0.034		Set Trigger
4	3.069	0.015	0.00	0.030	0.033		Set Trigger
5	3.055	0.015	0.00	0.030	0.032		Set Trigger

A-3-07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



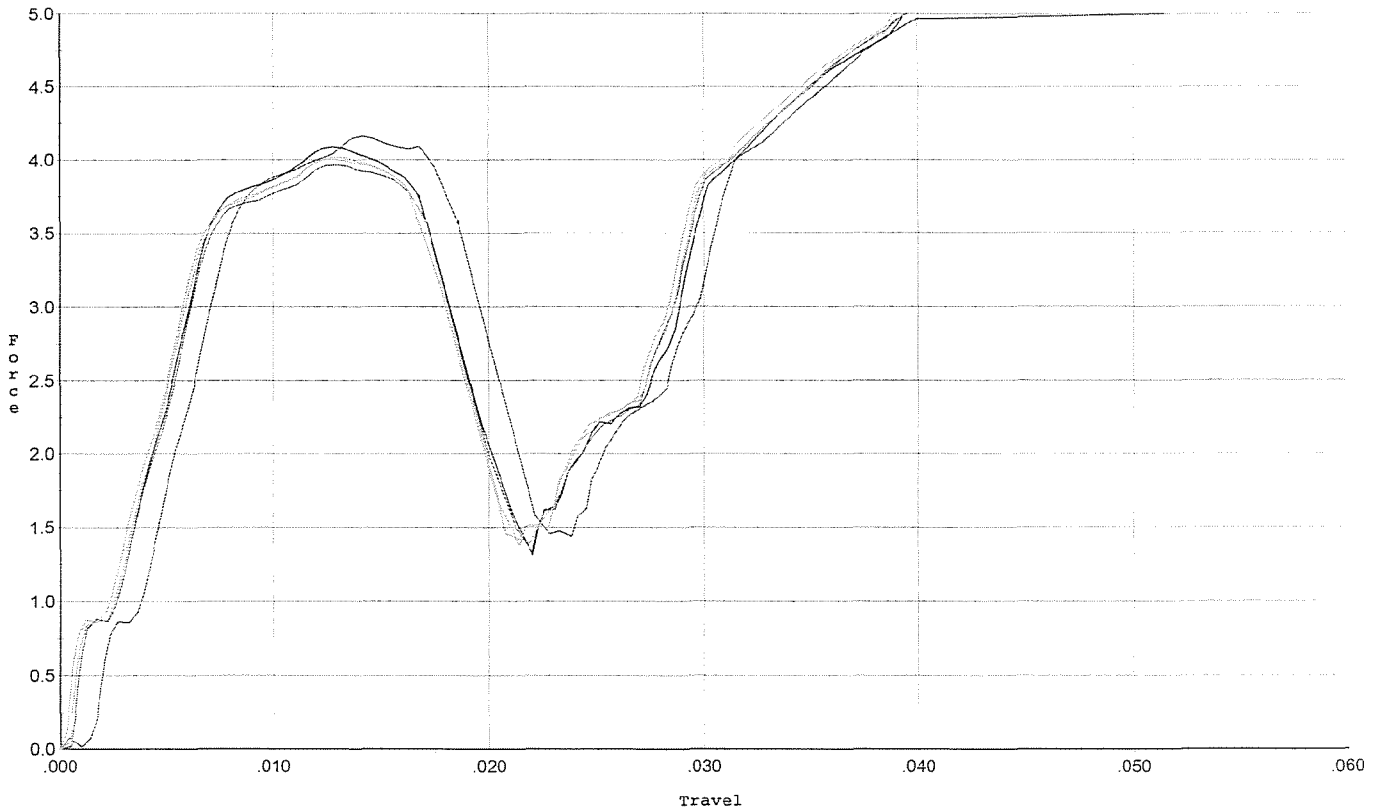
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.127	0.016	0.00	0.031	0.034		Set Trigger
2	3.093	0.016	0.00	0.031	0.032		Set Trigger
3	3.080	0.017	0.00	0.030	0.035		Set Trigger
4	3.159	0.016	0.00	0.030	0.034		Set Trigger
5	3.205	0.015	0.00	0.030	0.033		Set Trigger

A-3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



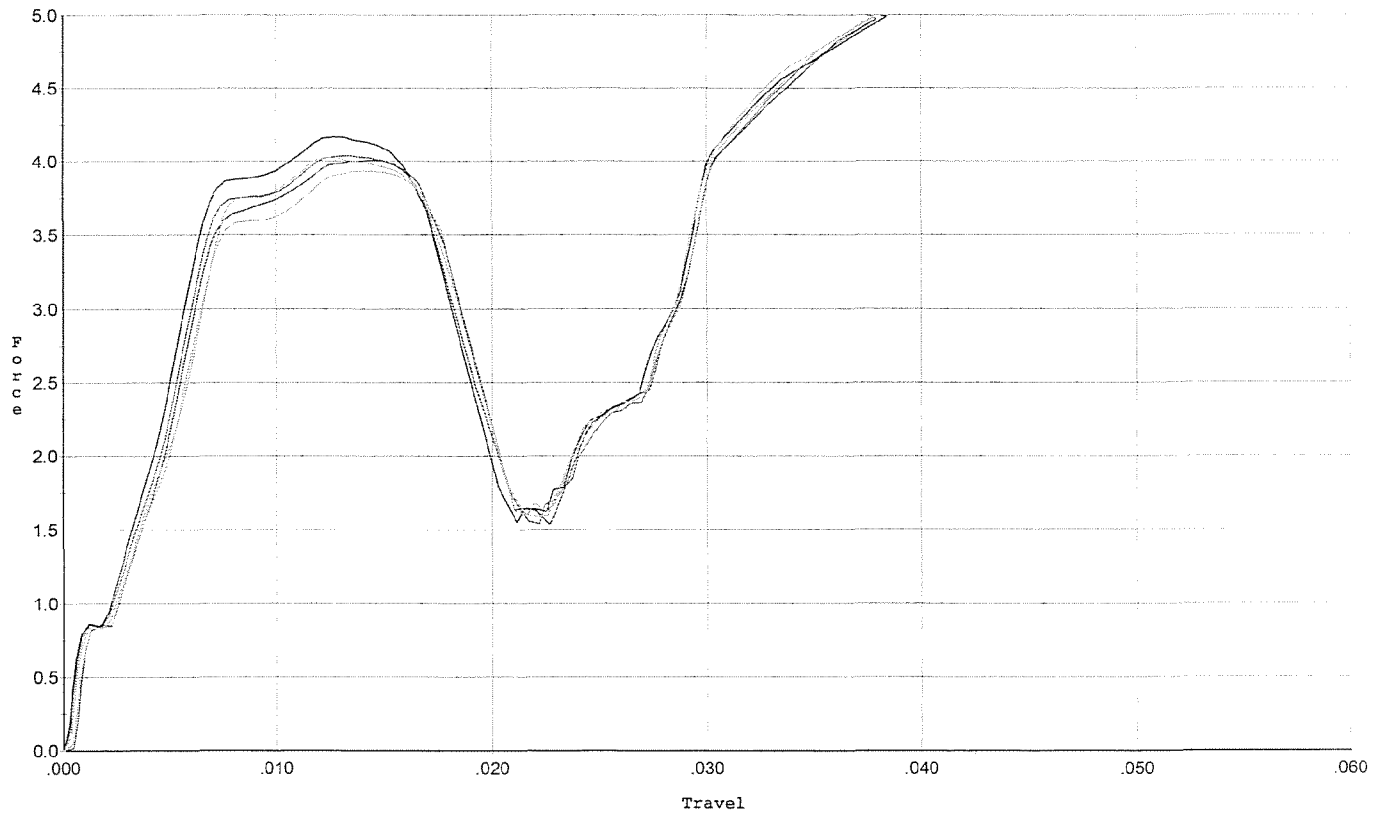
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.158	0.019	0.00	0.025	0.049		Set Trigger
2	4.091	0.017	0.00	0.025	0.046		Set Trigger
3	3.965	0.017	0.00	0.025	0.046		Set Trigger
4	4.004	0.018	0.00	0.025	0.048		Set Trigger
5	4.019	0.017	0.00	0.025	0.046		Set Trigger

A-4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



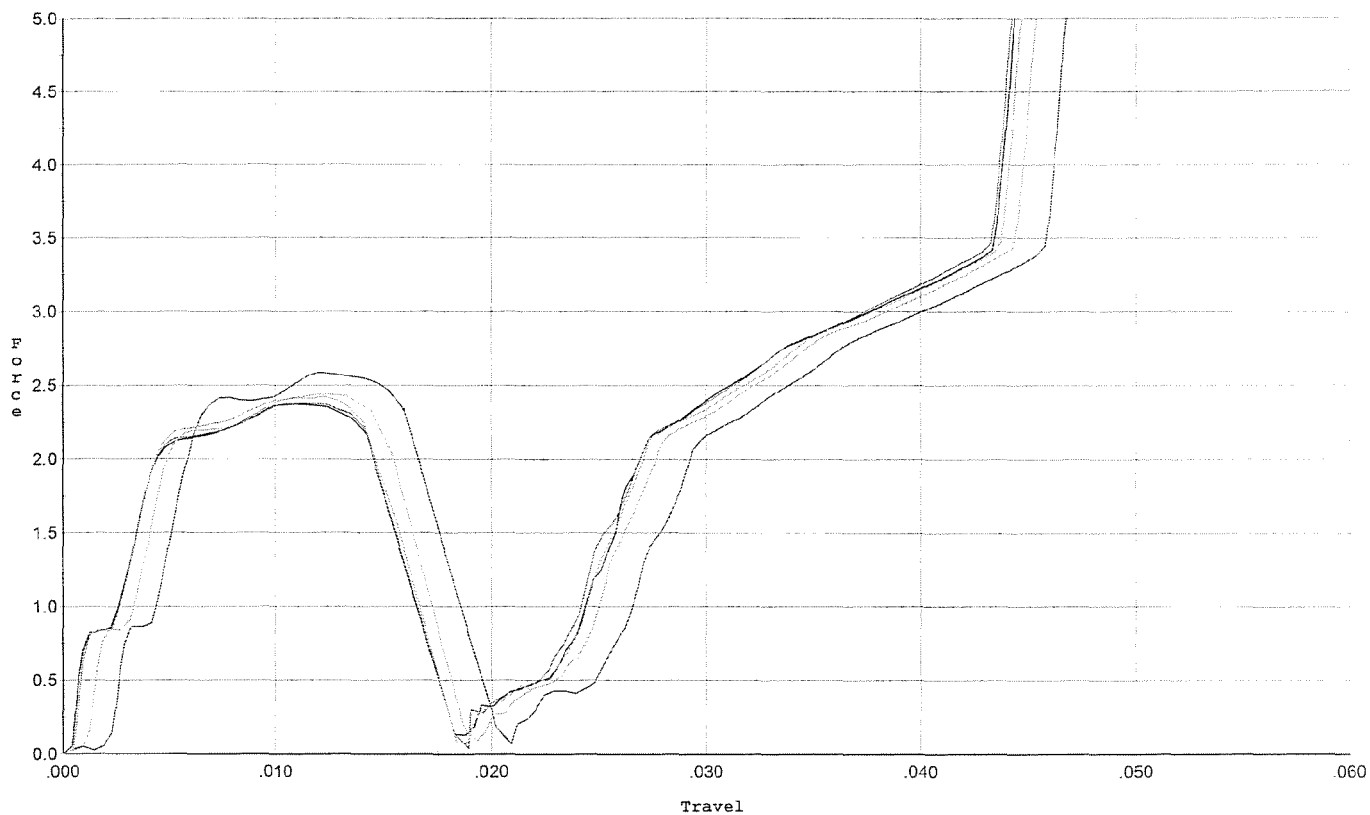
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.007	0.018	0.00	0.028	0.048		Set Trigger
2	4.165	0.017	0.00	0.028	0.048		Set Trigger
3	4.037	0.017	0.00	0.028	0.046		Set Trigger
4	3.930	0.018	0.00	0.028	0.047		Set Trigger
5	4.027	0.018	0.00	0.028	0.049		Set Trigger

A-4-03

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



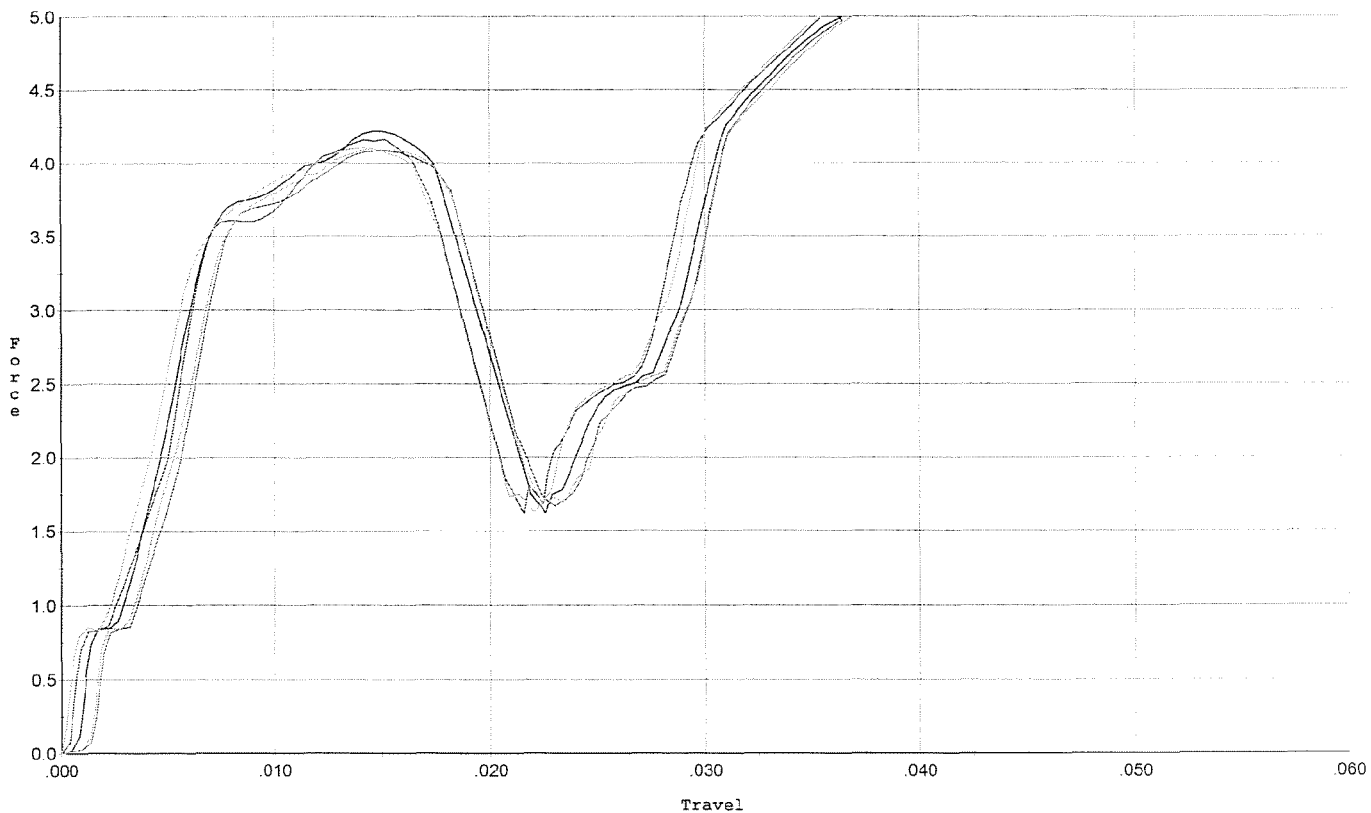
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.585	0.016	0.00	0.033	0.027		Set Trigger
2	2.373	0.014	0.00	0.033	0.025		Set Trigger
3	2.380	0.014	0.00	0.033	0.025		Set Trigger
4	2.441	0.015	0.00	0.033	0.027		Set Trigger
5	2.423	0.016	0.00	0.033	0.028		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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	4.162	0.017	0.00	0.027	0.047		Set Trigger
2	4.220	0.020	0.00	0.028	0.055		Set Trigger
3	4.083	0.018	0.00	0.028	0.048		Set Trigger
4	4.110	0.018	0.00	0.028	0.049		Set Trigger
5	4.096	0.018	0.00	0.028	0.049		Set Trigger

A-4-13