

G68/4685

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

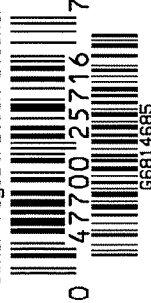
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



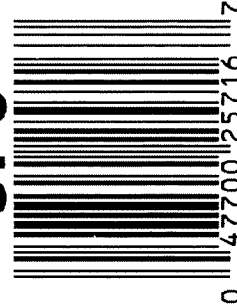
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6814685

UPC



GUN SERIAL #

G 6814685

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SPD
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SPD
460	CHECK HEADSPACE		3-20-09	SPD
470	DIS-ASSEMBLE ACTION		3-20-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	3-23-09	RT
475	DRILL AND TAP SIGHT HOLES		3-23-09	JP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/25/09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-7-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

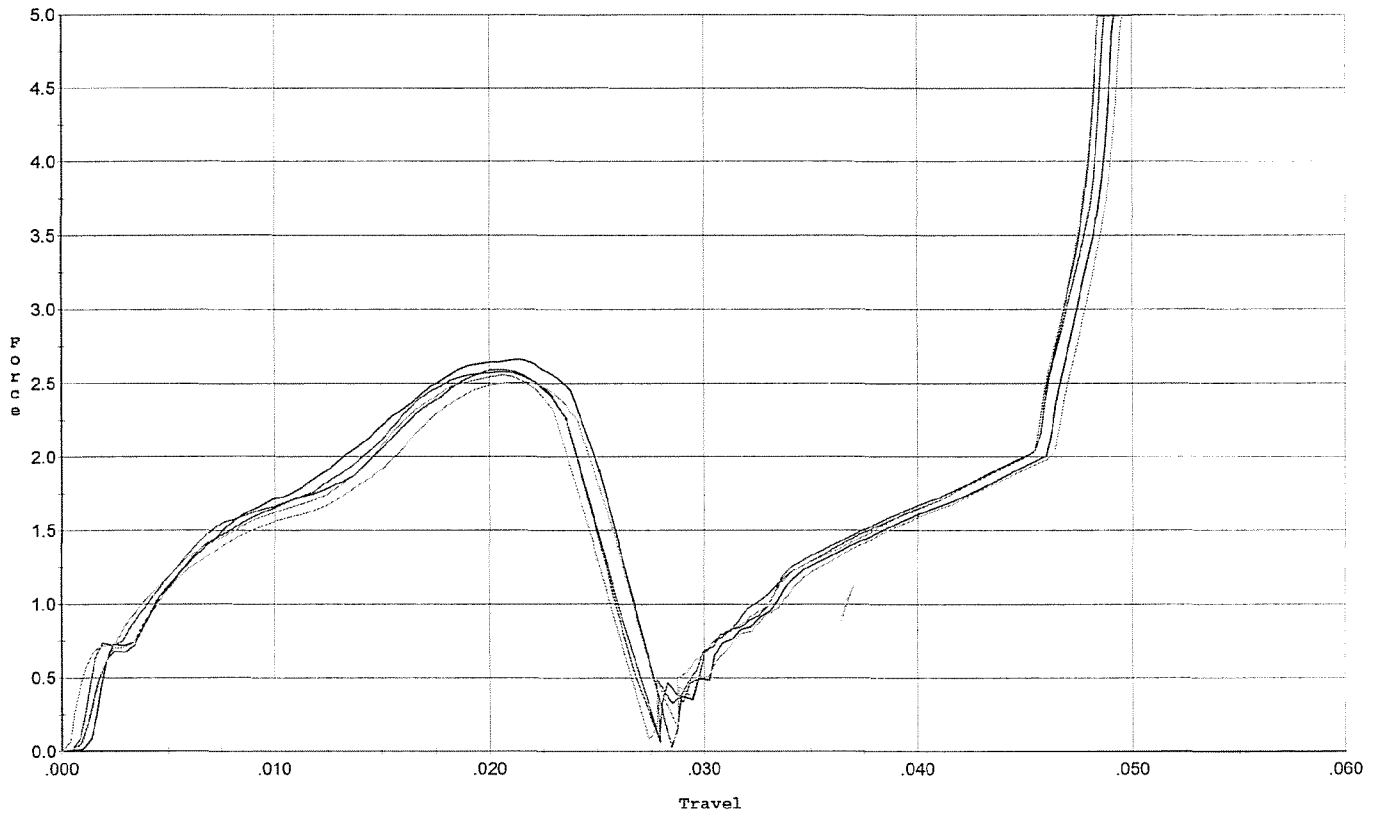
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	4-17-09	WN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-17-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	4-17-09	WN
	J) ASSEMBLE STOCK		4-7-09	LN
	K) ASSEMBLE SWIVEL STUDS		4-17-09	WN
	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	4-9-09	WN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE		4-17-09	WN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.94</u> <u>2.95</u> <u>2.72</u> <u>2.87</u> <u>2.72</u>	4-14-09	WN
	C) FUNCTION		4-17-09	WN
690	PACK		5/3/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/3/2009

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



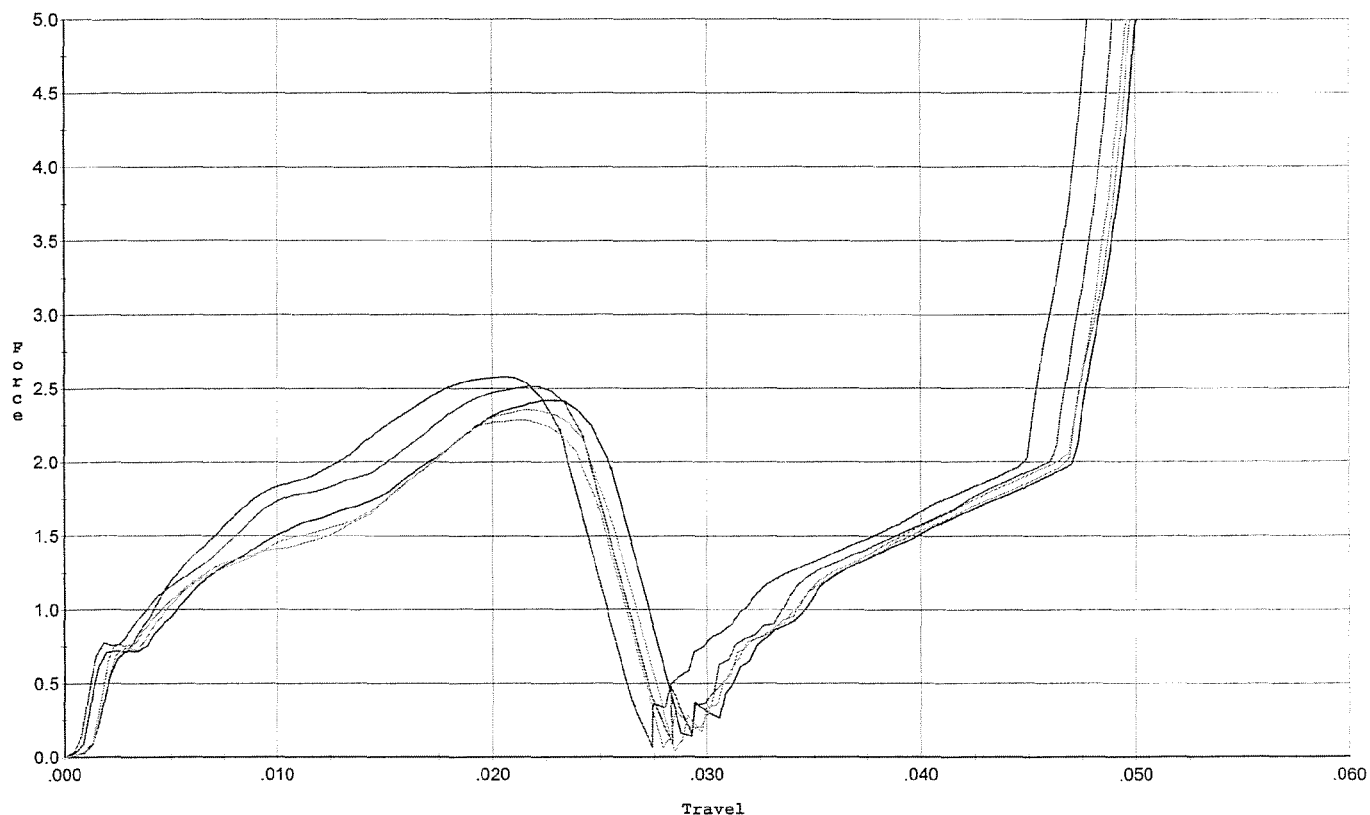
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.024	0.00	0.030	0.039		Set Trigger
2	2.661	0.025	0.00	0.030	0.043		Set Trigger
3	2.577	0.024	0.00	0.030	0.040		Set Trigger
4	2.511	0.026	0.00	0.031	0.041		Set Trigger
5	2.556	0.025	0.00	0.030	0.041		Set Trigger

A 2.58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/3/2009

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



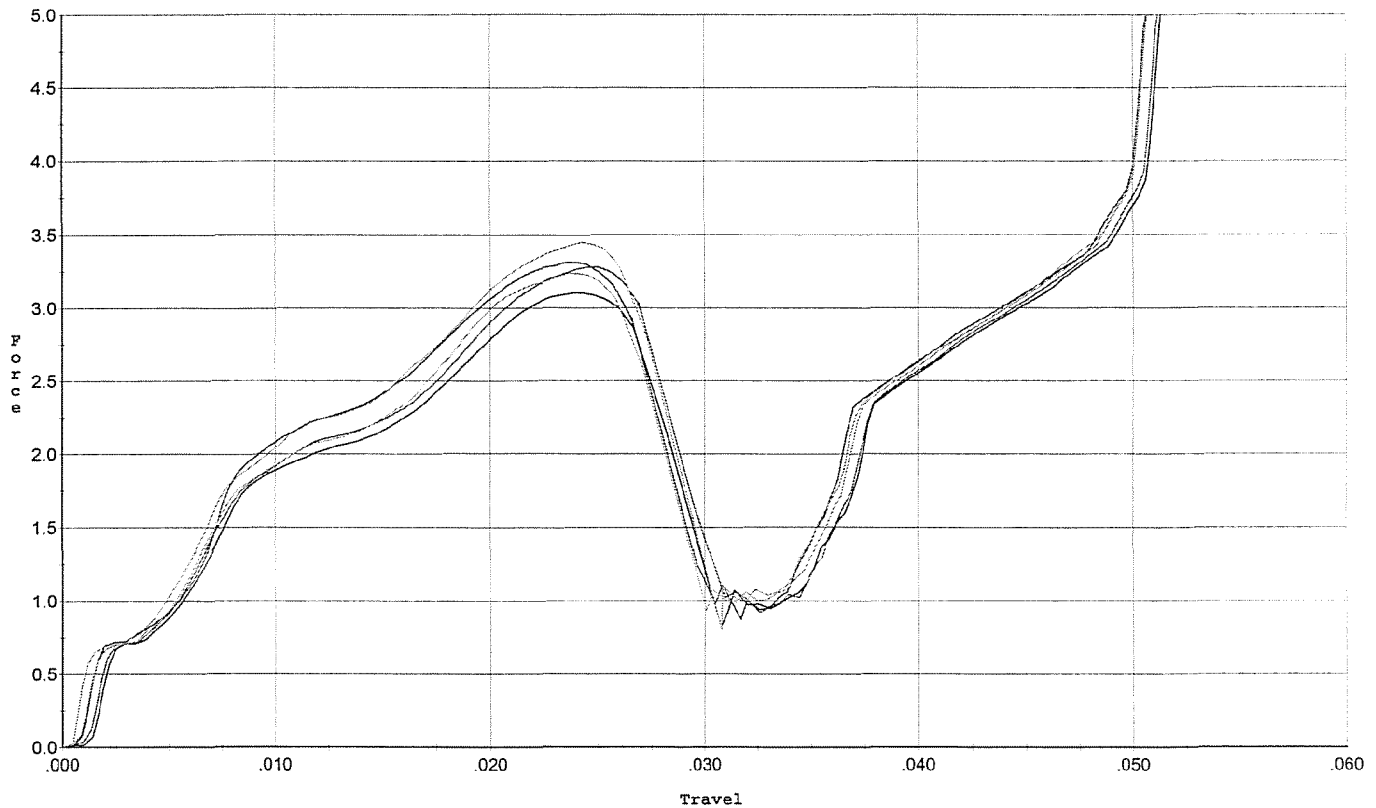
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.579	0.023	0.00	0.030	0.040		Set Trigger
2	2.418	0.026	0.00	0.031	0.039		Set Trigger
3	2.513	0.024	0.00	0.031	0.040		Set Trigger
4	2.359	0.026	0.00	0.031	0.038		Set Trigger
5	2.285	0.025	0.00	0.031	0.037		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



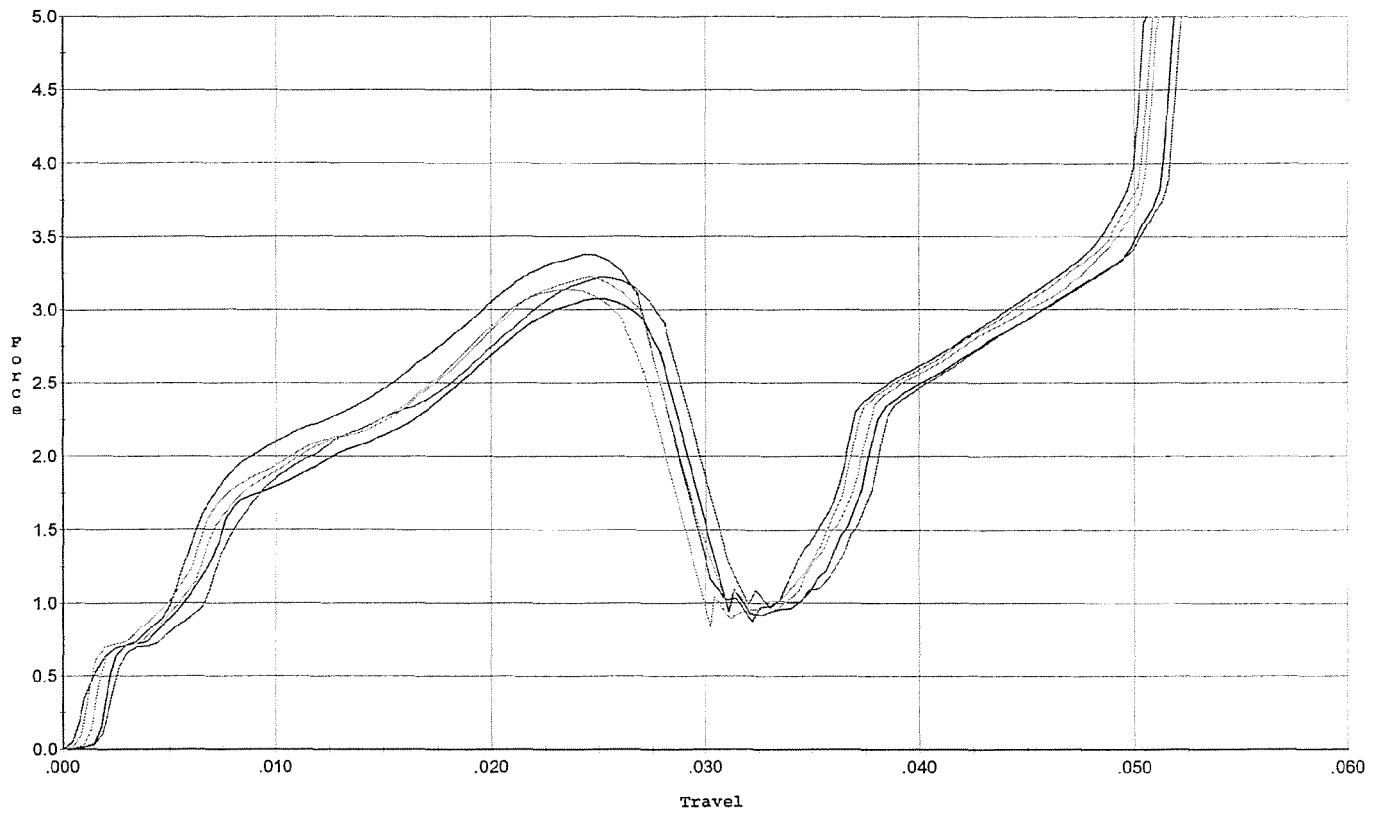
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.309	0.027	0.00	0.024	0.055		Set Trigger
2	3.101	0.028	0.00	0.025	0.054		Set Trigger
3	3.282	0.027	0.00	0.025	0.053		Set Trigger
4	3.236	0.027	0.00	0.025	0.054		Set Trigger
5	3.449	0.027	0.00	0.024	0.058		Set Trigger

A-3-27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



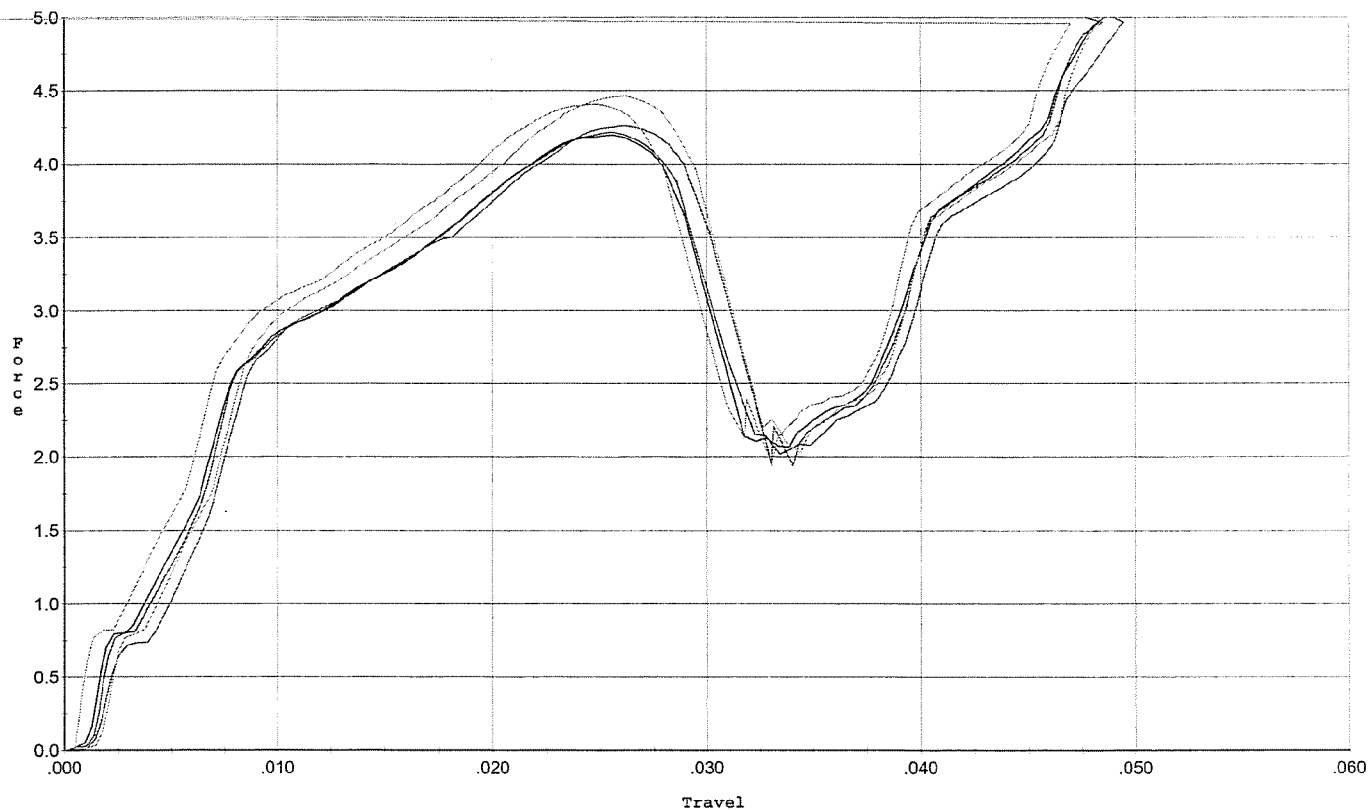
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.380	0.027	0.00	0.024	0.057		Set Trigger
2	3.077	0.028	0.00	0.025	0.053		Set Trigger
3	3.222	0.028	0.00	0.025	0.055		Set Trigger
4	3.225	0.027	0.00	0.025	0.053		Set Trigger
5	3.142	0.027	0.00	0.025	0.054		Set Trigger

A.3-20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/3/2009

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



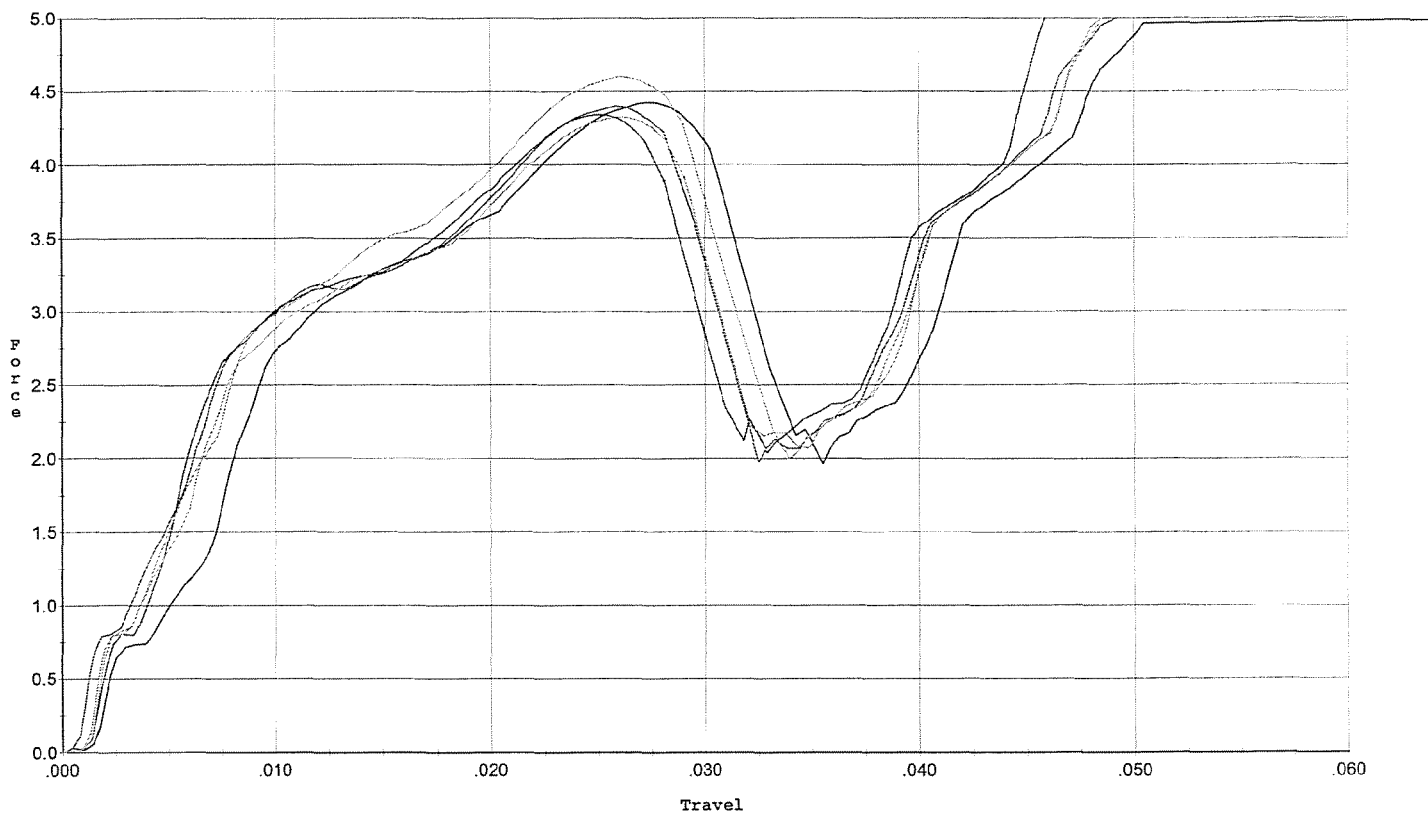
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.216	0.029	0.00	0.021	0.078		Set Trigger
2	4.197	0.029	0.00	0.021	0.079		Set Trigger
3	4.260	0.030	0.00	0.022	0.082		Set Trigger
4	4.465	0.029	0.00	0.021	0.084		Set Trigger
5	4.411	0.028	0.00	0.021	0.082		Set Trigger

A-4.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/3/2009

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



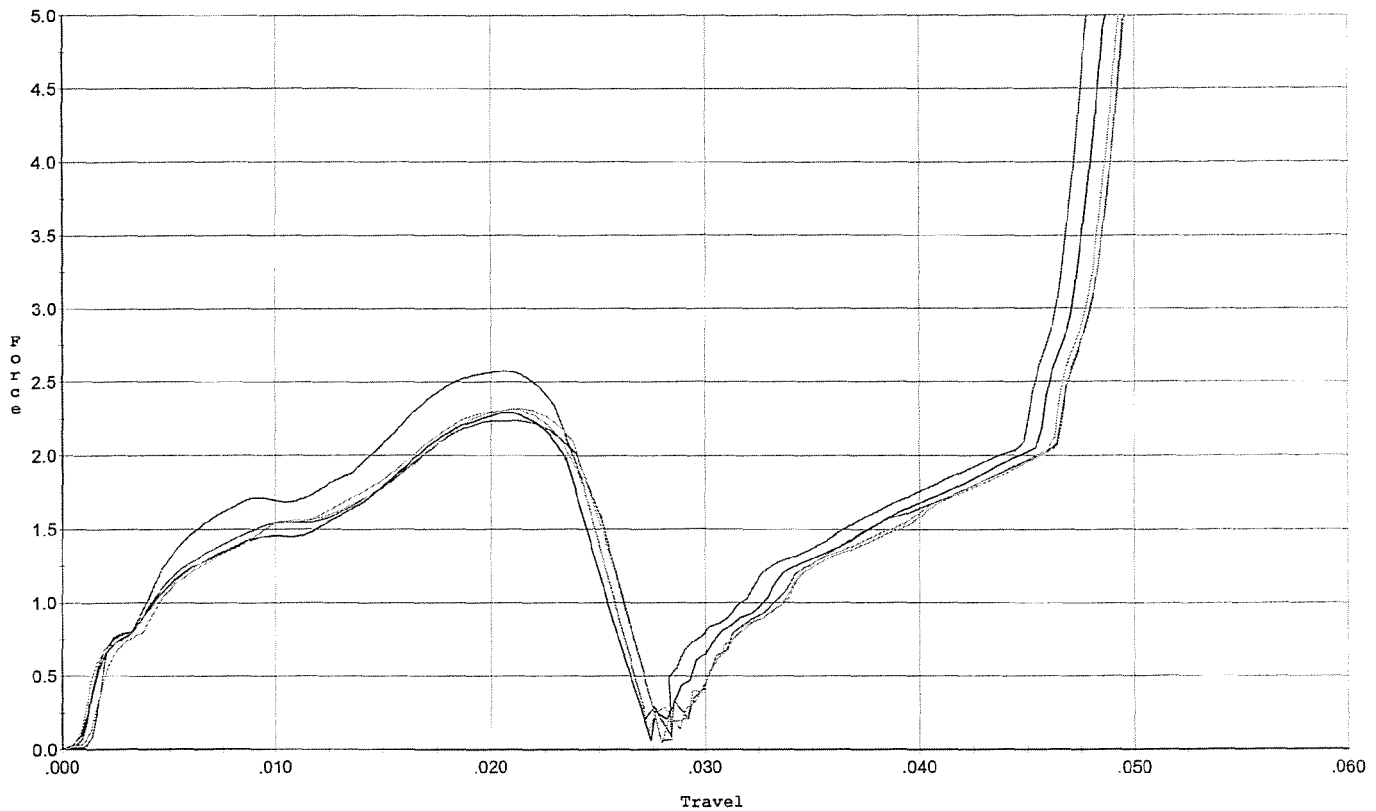
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.340	0.028	0.00	0.018	0.079		Set Trigger
2	4.427	0.030	0.00	0.021	0.083		Set Trigger
3	4.399	0.030	0.00	0.021	0.084		Set Trigger
4	4.325	0.029	0.00	0.021	0.081		Set Trigger
5	4.602	0.029	0.00	0.020	0.085		Set Trigger

A. 4.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/3/2009

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



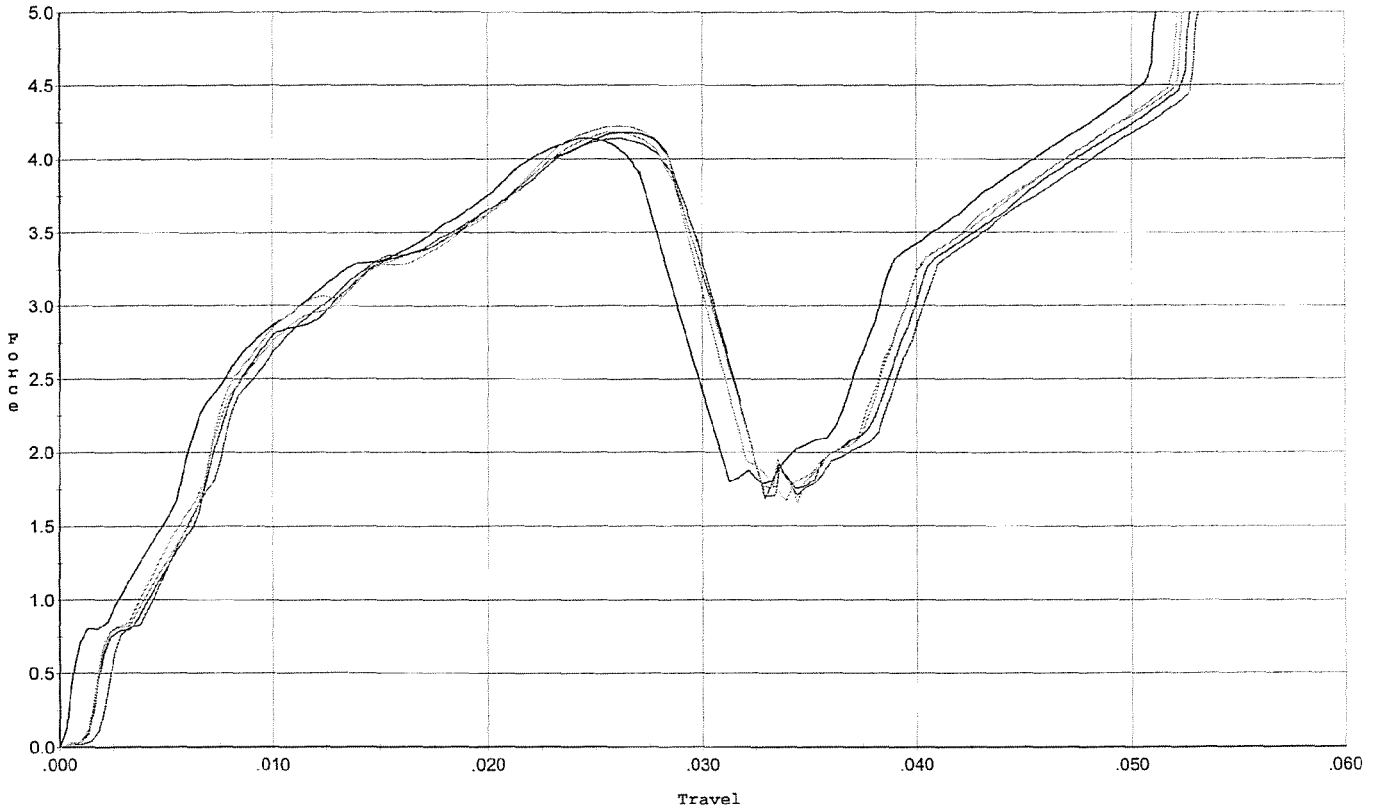
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.573	0.024	0.00	0.029	0.041		Set Trigger
2	2.293	0.023	0.00	0.031	0.035		Set Trigger
3	2.237	0.025	0.00	0.031	0.038		Set Trigger
4	2.315	0.024	0.00	0.031	0.037		Set Trigger
5	2.318	0.025	0.00	0.031	0.038		Set Trigger

A-234

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/3/2009

Model: M24
 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	4.182	0.030	0.00	0.022	0.080		Set Trigger
2	4.145	0.027	0.00	0.022	0.074		Set Trigger
3	4.145	0.030	0.00	0.022	0.081		Set Trigger
4	4.186	0.029	0.00	0.022	0.077		Set Trigger
5	4.226	0.030	0.00	0.021	0.082		Set Trigger

A.4.17