

676814700

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



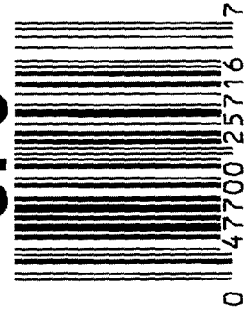
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6814700

UPC



GUN SERIAL #

G 6814700

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	RT
480	MAGNAFLUX BBL ACTION	(D)	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 5/2005

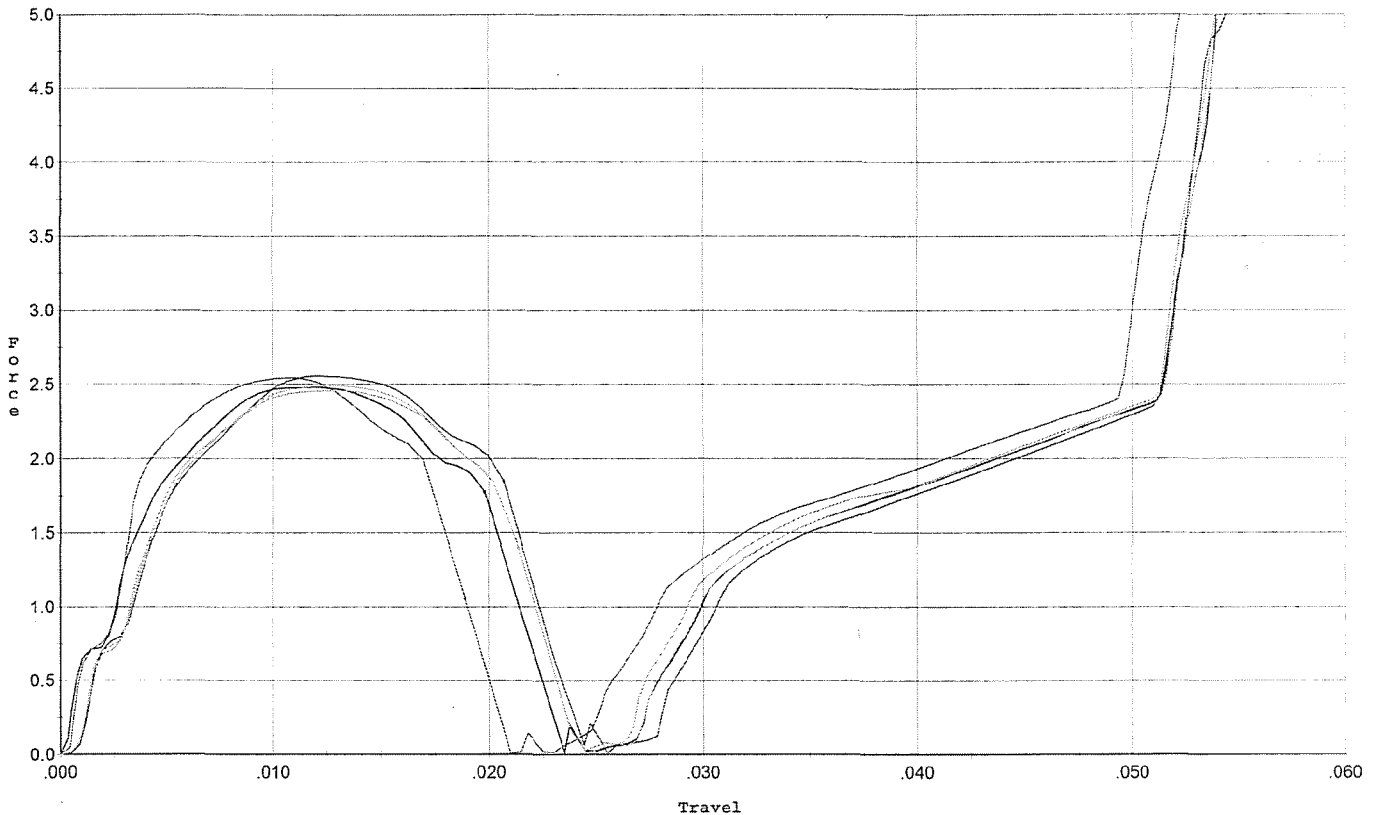
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>30</u>	3-31-09	RN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	3-31-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-31-09	RN
	J) ASSEMBLE STOCK		3-28-09	R.P.D.
	K) ASSEMBLE SWIVEL STUDS		3-31-09	RN
	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	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.40</u> <u>2.50</u> <u>2.52</u> <u>2.45</u>	3-31-09	WN
	C) FUNCTION		3-31-09	RN
690	PACK		4/13/09	Fm

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



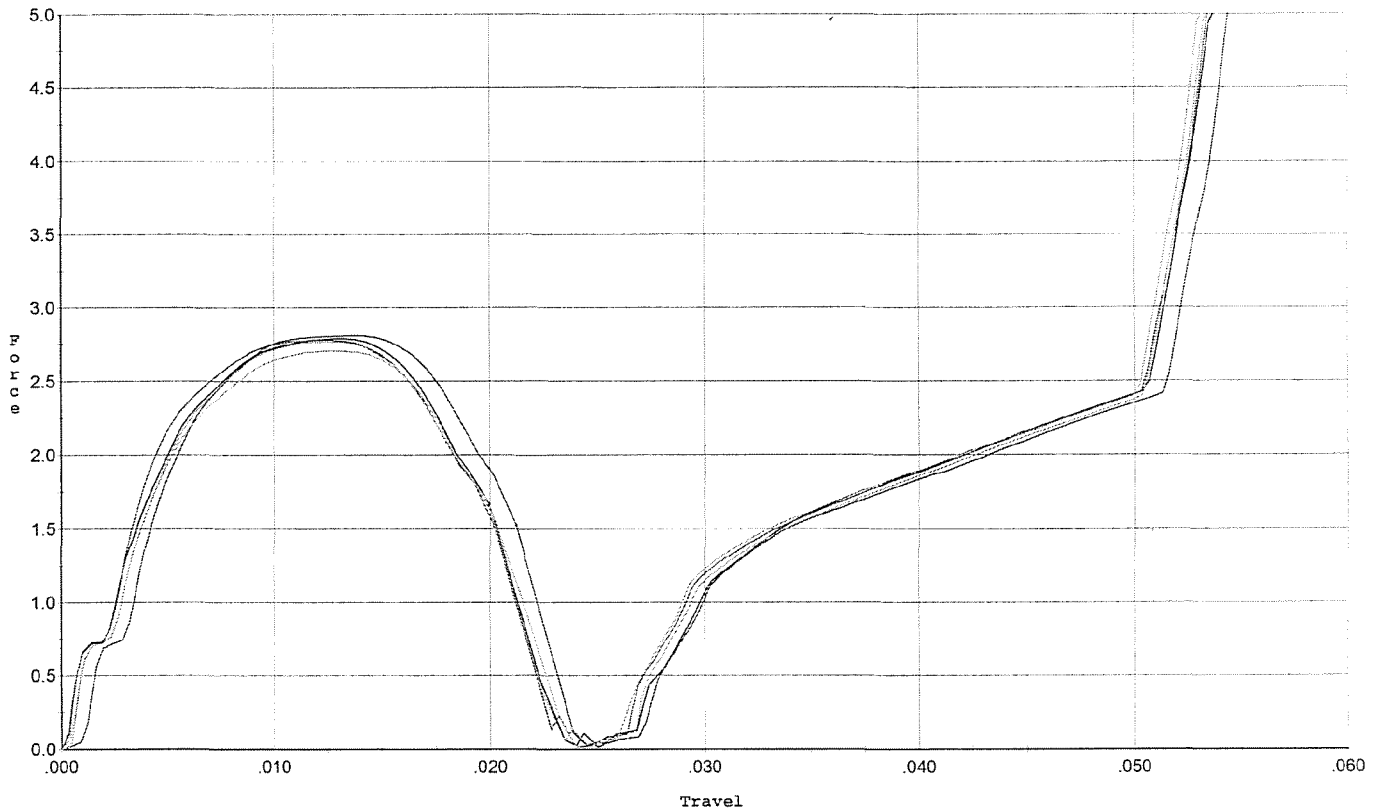
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.021	0.00	0.038	0.038		Set Trigger
2	2.479	0.020	0.00	0.039	0.036		Set Trigger
3	2.542	0.019	0.00	0.039	0.035		Set Trigger
4	2.490	0.021	0.00	0.038	0.038		Set Trigger
5	2.456	0.021	0.00	0.038	0.038		Set Trigger

A-2-50

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



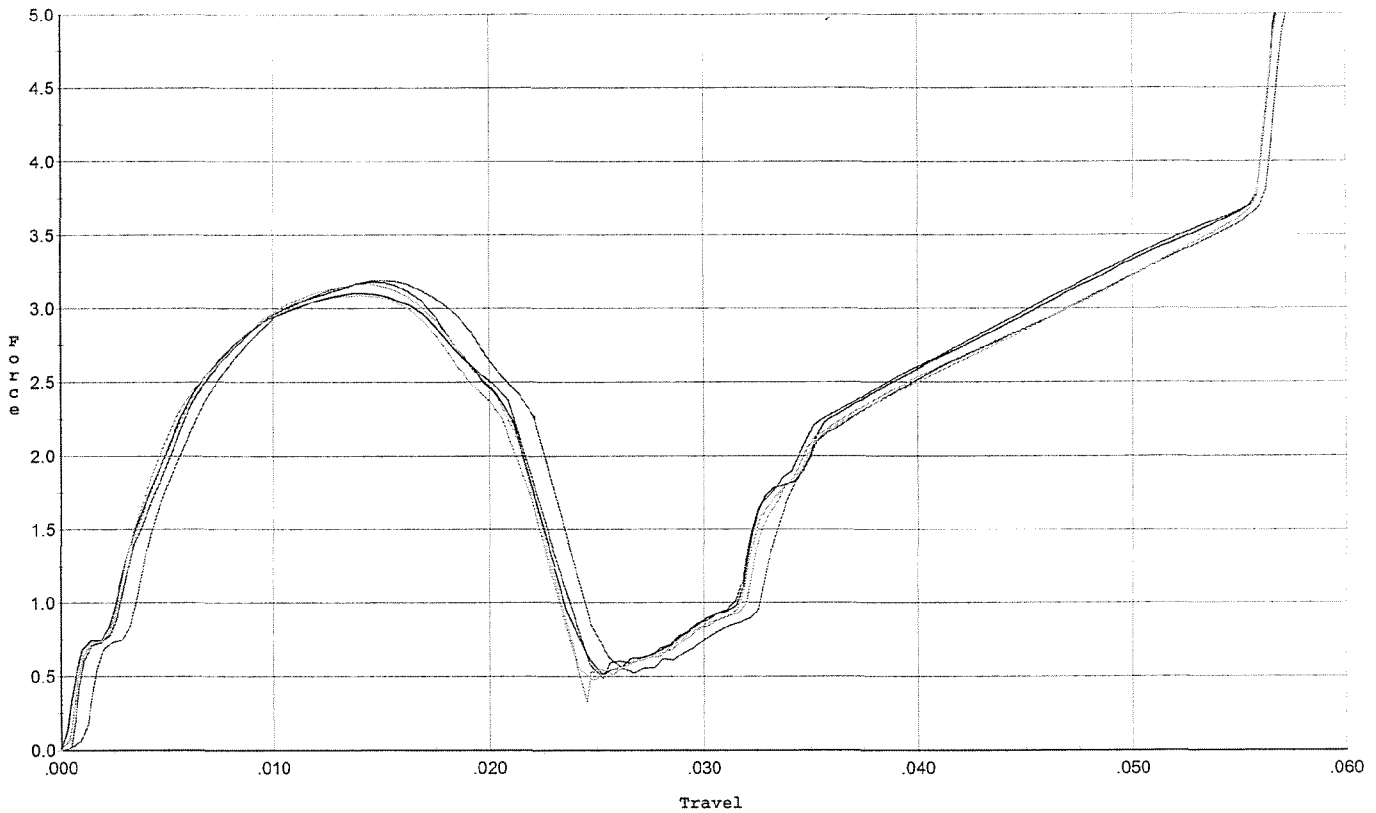
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.809	0.021	0.00	0.038	0.042		Set Trigger
2	2.788	0.020	0.00	0.038	0.040		Set Trigger
3	2.776	0.020	0.00	0.038	0.041		Set Trigger
4	2.705	0.021	0.00	0.038	0.041		Set Trigger
5	2.767	0.020	0.00	0.038	0.039		Set Trigger

A-2-76

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



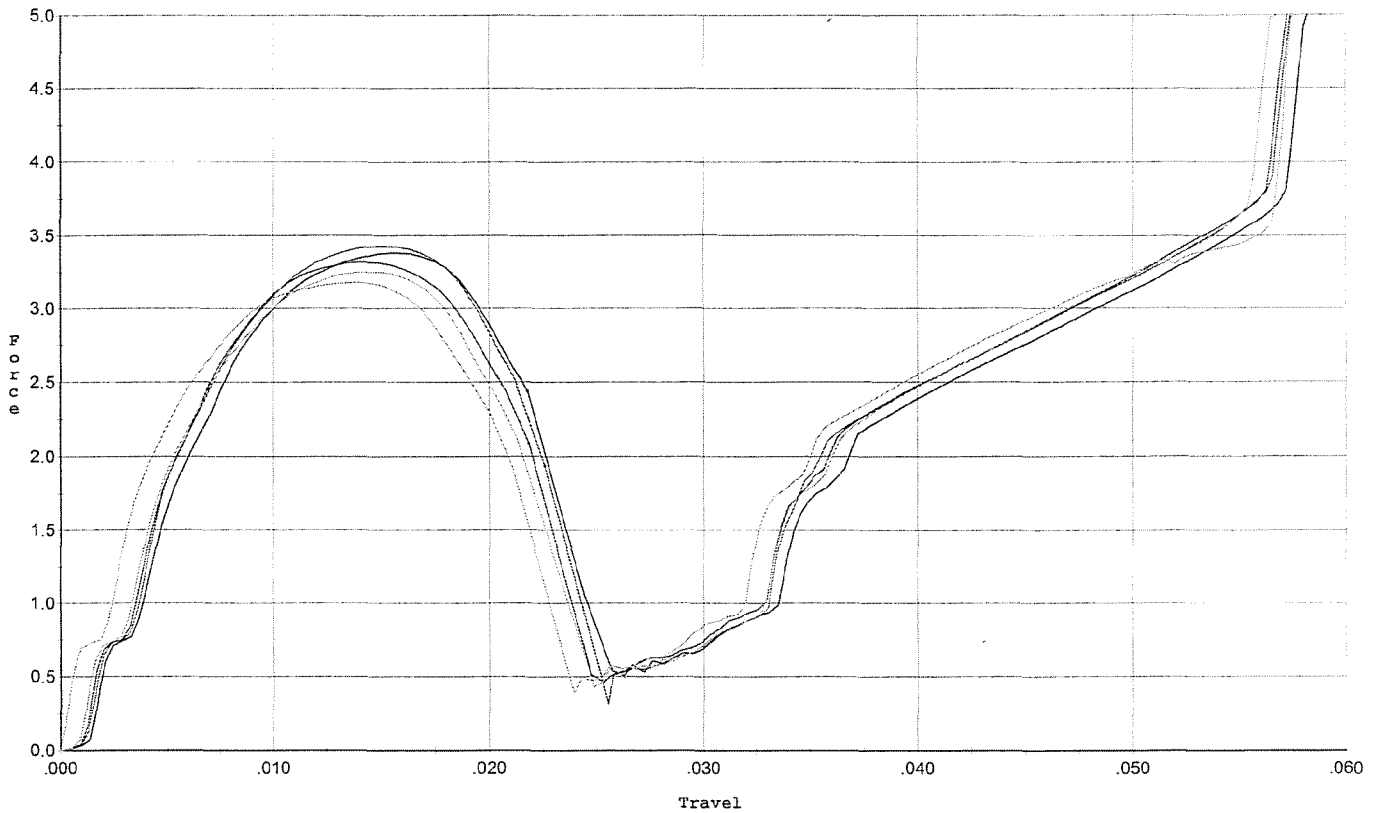
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.179	0.021	0.00	0.038	0.047		Set Trigger
2	3.102	0.021	0.00	0.038	0.047		Set Trigger
3	3.190	0.022	0.00	0.038	0.049		Set Trigger
4	3.164	0.021	0.00	0.039	0.048		Set Trigger
5	3.086	0.022	0.00	0.038	0.048		Set Trigger

A-3-14

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



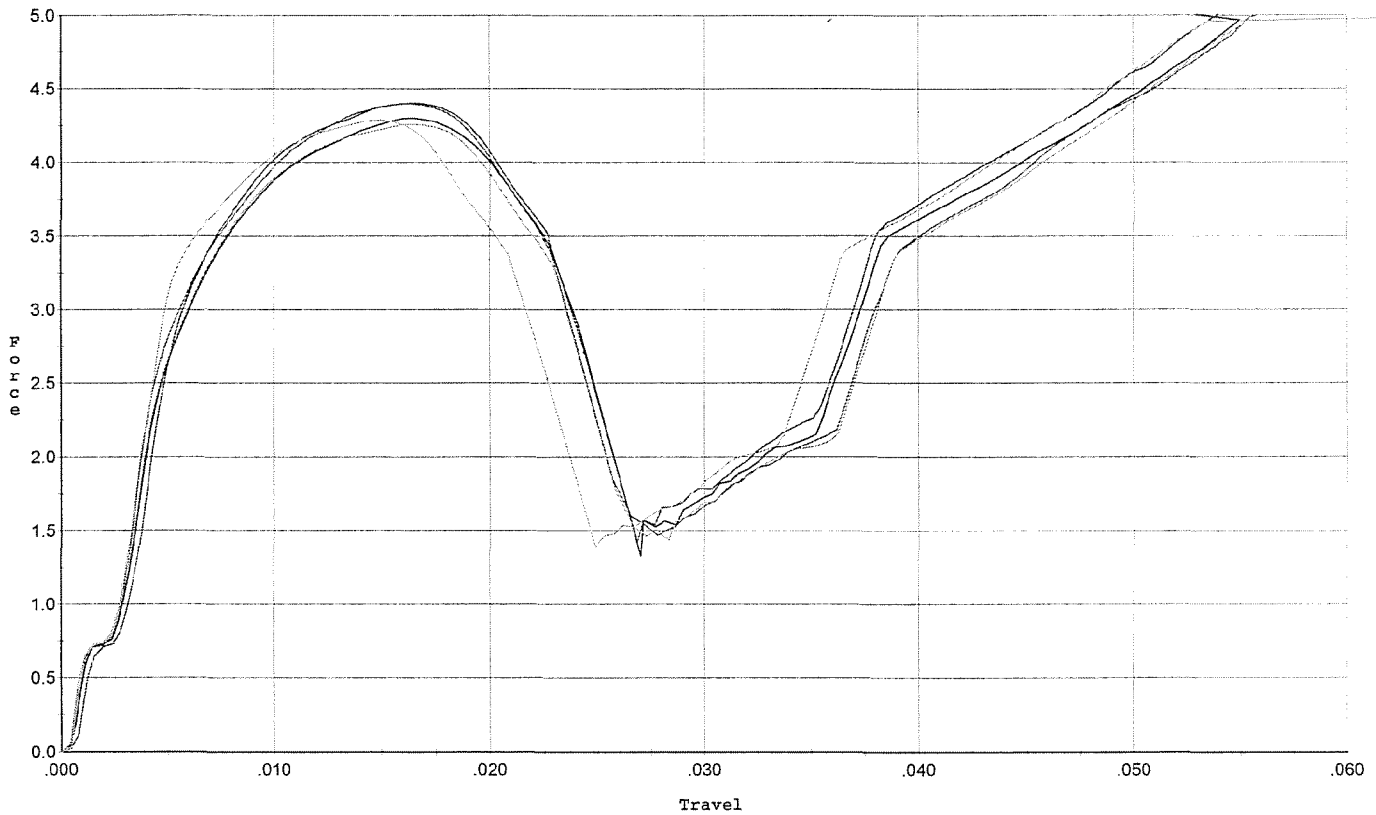
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.318	0.022	0.00	0.038	0.049		Set Trigger
2	3.379	0.022	0.00	0.039	0.049		Set Trigger
3	3.425	0.023	0.00	0.038	0.052		Set Trigger
4	3.249	0.023	0.00	0.039	0.051		Set Trigger
5	3.176	0.021	0.00	0.039	0.048		Set Trigger

A-3-30

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



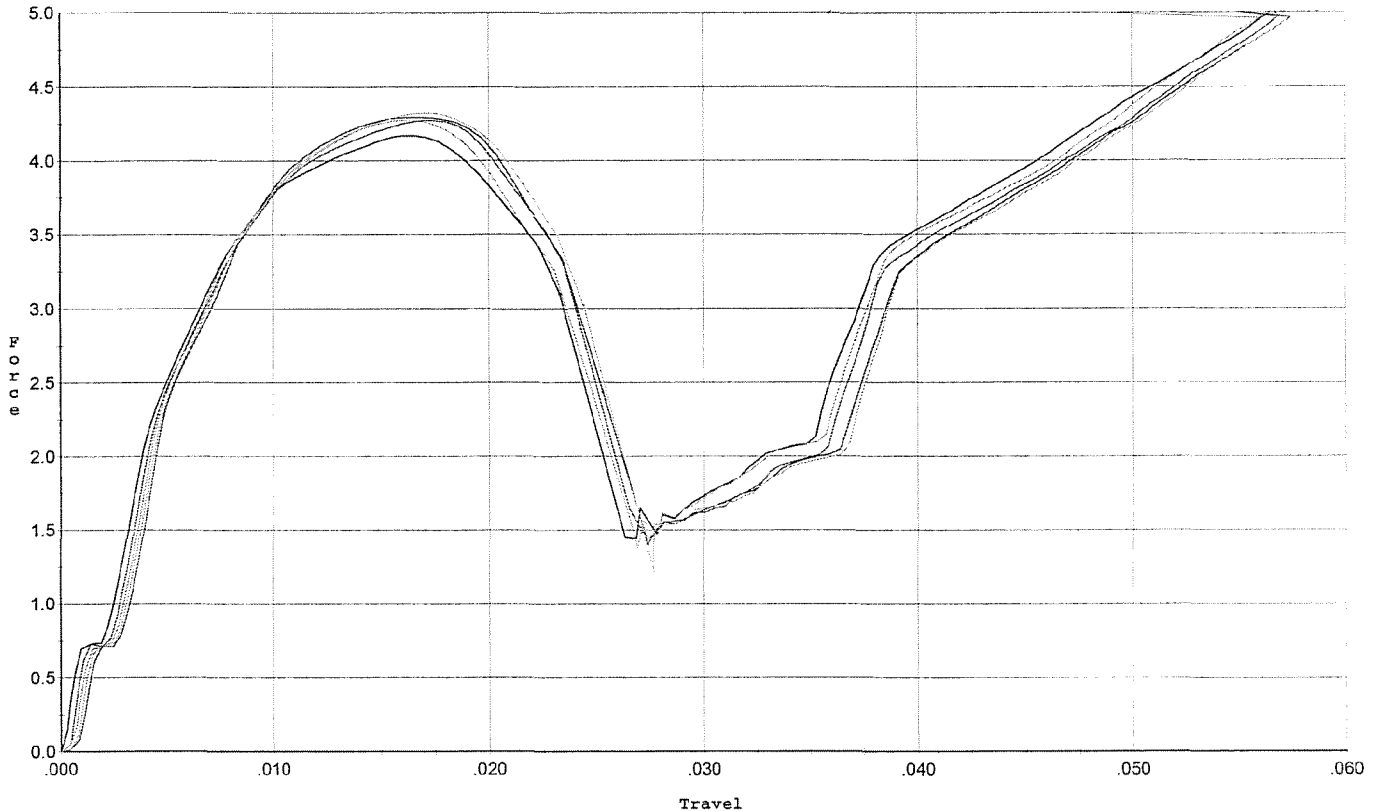
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.402	0.024	0.00	0.034	0.074		Set Trigger
2	4.301	0.024	0.00	0.035	0.073		Set Trigger
3	4.400	0.023	0.00	0.035	0.070		Set Trigger
4	4.290	0.023	0.00	0.035	0.068		Set Trigger
5	4.261	0.023	0.00	0.035	0.069		Set Trigger

A-4-33

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



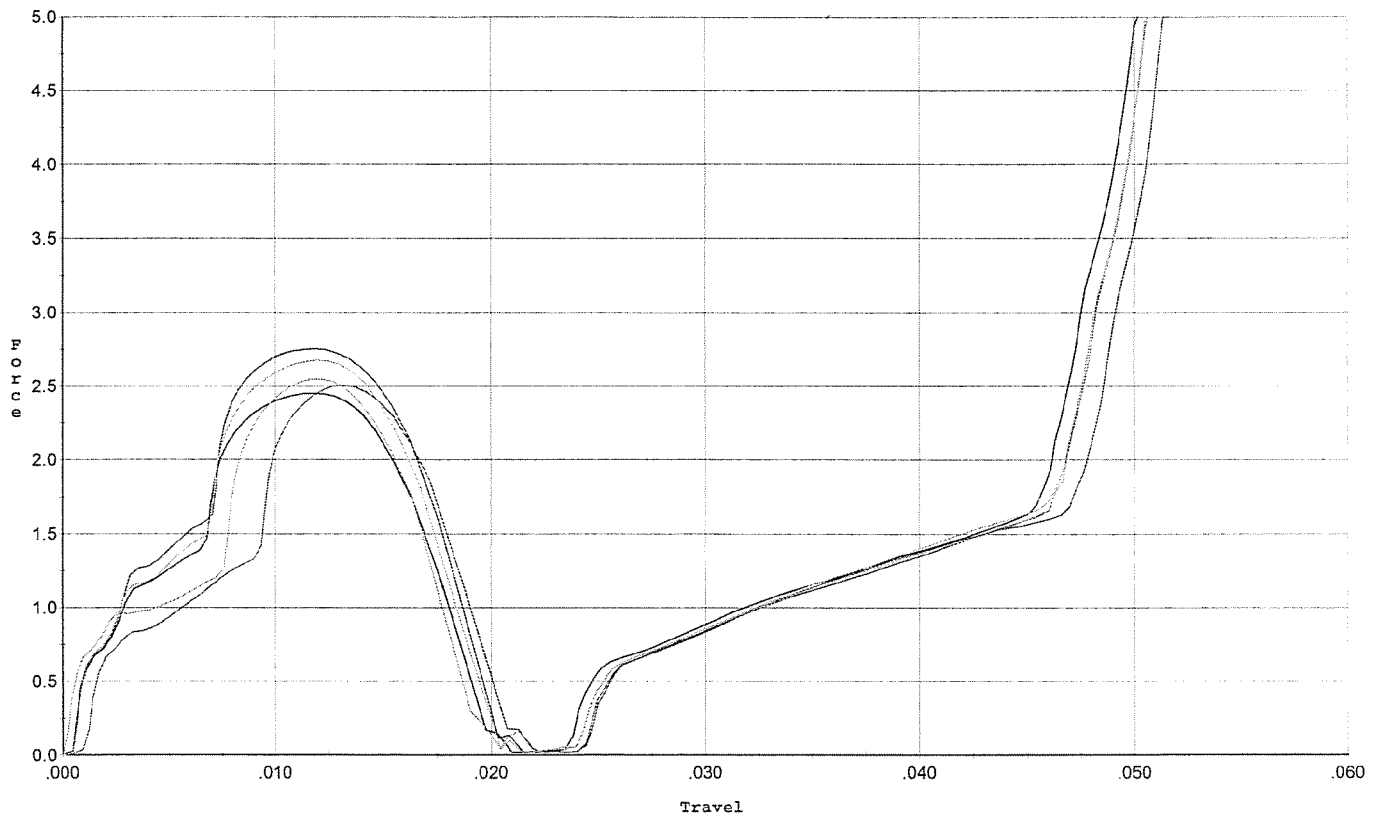
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.293	0.025	0.00	0.036	0.074		Set Trigger
2	4.172	0.023	0.00	0.036	0.069		Set Trigger
3	4.275	0.023	0.00	0.036	0.070		Set Trigger
4	4.324	0.024	0.00	0.036	0.073		Set Trigger
5	4.277	0.025	0.00	0.036	0.073		Set Trigger

A-4-26

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



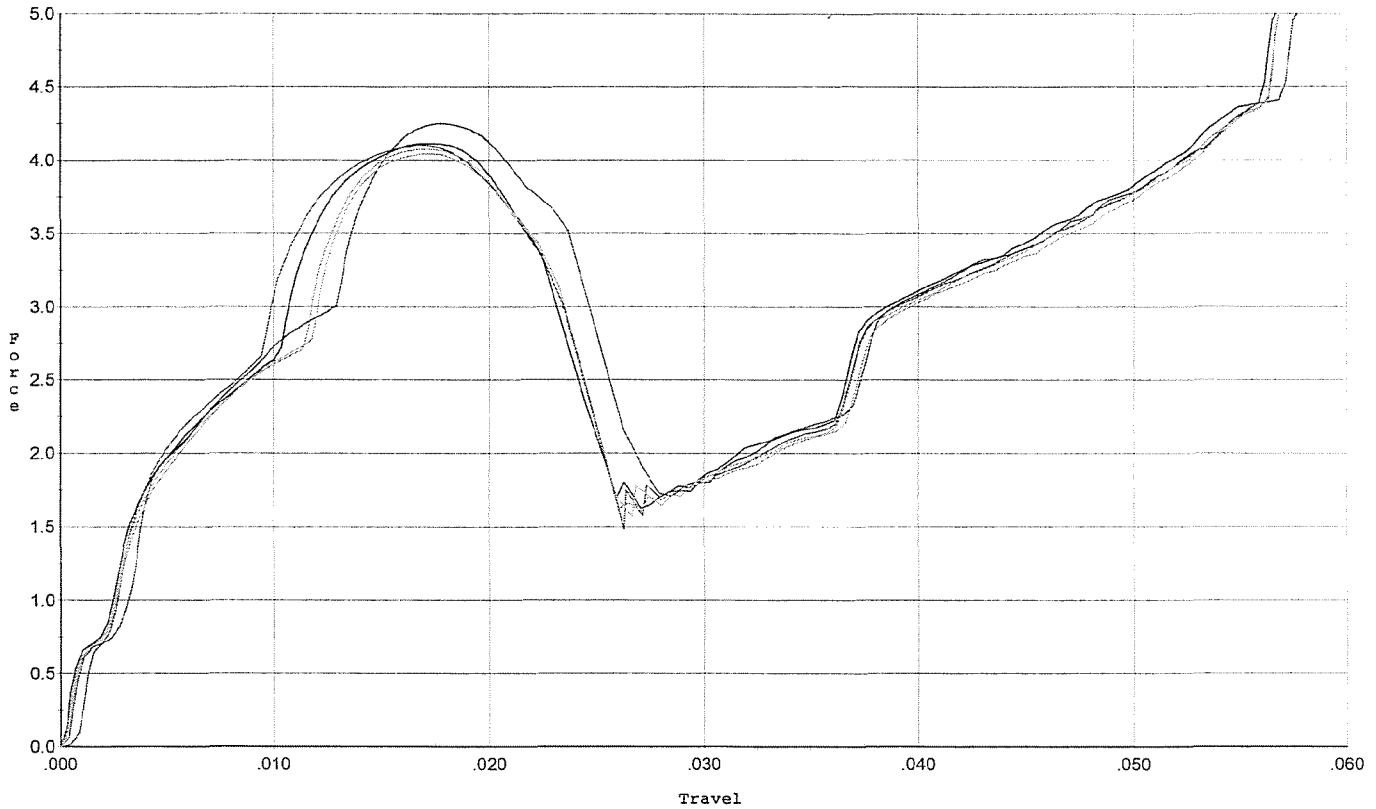
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.753	0.018	0.00	0.039	0.032		Set Trigger
2	2.450	0.018	0.00	0.038	0.028		Set Trigger
3	2.507	0.019	0.00	0.038	0.027		Set Trigger
4	2.677	0.017	0.00	0.039	0.029		Set Trigger
5	2.549	0.016	0.00	0.039	0.026		Set Trigger

A 2-58

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	4.247	0.024	0.00	0.035	0.063		Set Trigger
2	4.112	0.022	0.00	0.036	0.060		Set Trigger
3	4.103	0.023	0.00	0.036	0.063		Set Trigger
4	4.045	0.023	0.00	0.036	0.060		Set Trigger
5	4.074	0.023	0.00	0.036	0.061		Set Trigger

A-4.11