

G681 4705

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



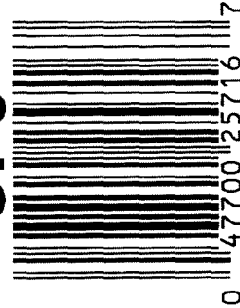
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6814705

UPC



GUN SERIAL #

G6814705

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RZ
430	ASSEMBLE TO STOCK		3-6-09	RZ
440	PROOF		3-6-09	TK
460	CHECK HEADSPACE		3-6-09	TK
470	DIS-ASSEMBLE ACTION		3-6-09	RZ
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-6-09	RZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (P)	3/9/09	(P)
490	MAGNAFLUX BOLT		3/9/09	PK
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	hmg
542	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	RZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

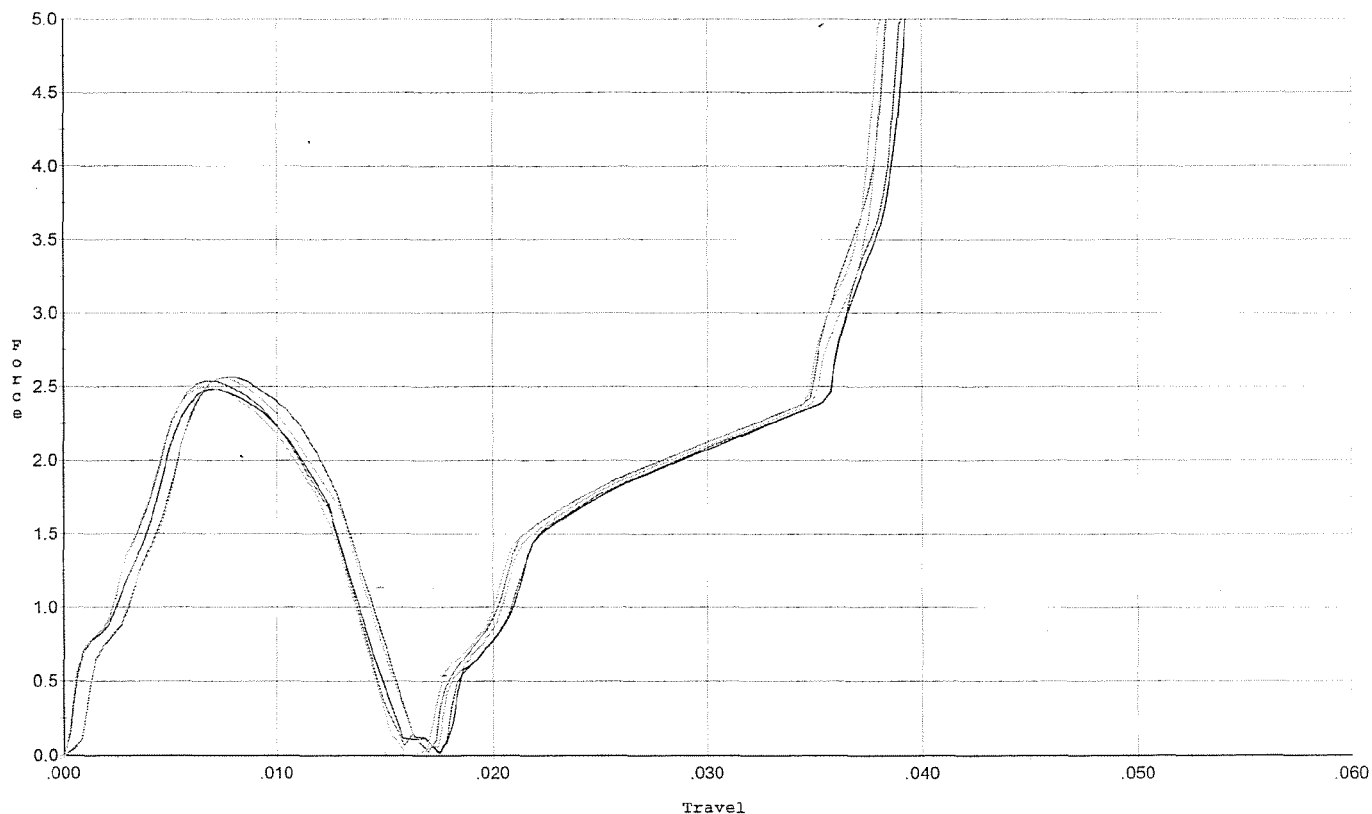
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	3-25-09	NW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-25-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-25-09	NW
	J) ASSEMBLE STOCK		3-23-09	WJ
	K) ASSEMBLE SWIVEL STUDS		3-27-09	WJ
	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	3-24-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-25-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.27</u> <u>2.26</u> <u>2.27</u> <u>2.26</u>	3-24-09	TC
	C) FUNCTION		3-25-09	NW
690	PACK		3-28-09	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



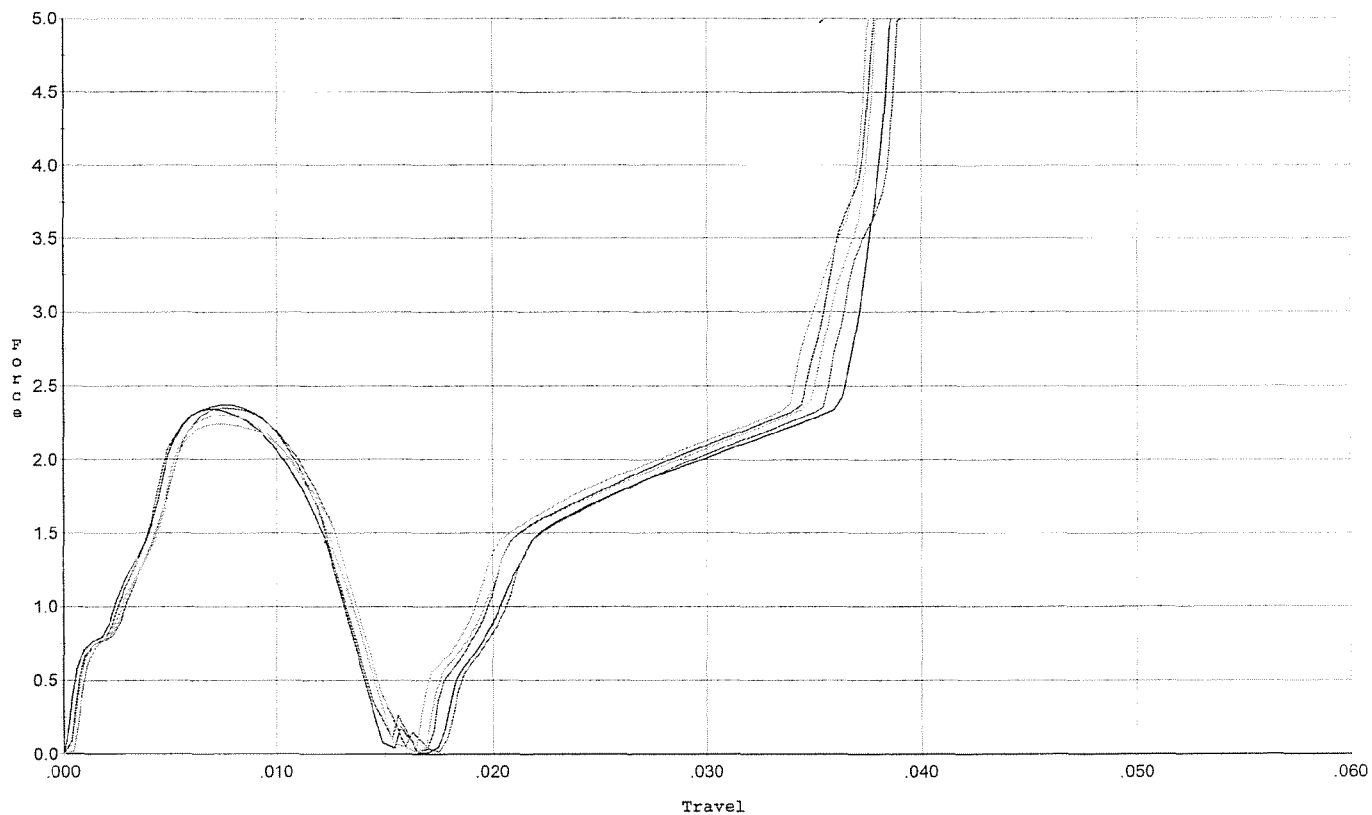
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.563	0.014	0.00	0.030	0.023		Set Trigger
2	2.482	0.012	0.00	0.031	0.020		Set Trigger
3	2.538	0.012	0.00	0.030	0.021		Set Trigger
4	2.495	0.013	0.00	0.030	0.021		Set Trigger
5	2.559	0.013	0.00	0.029	0.021		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



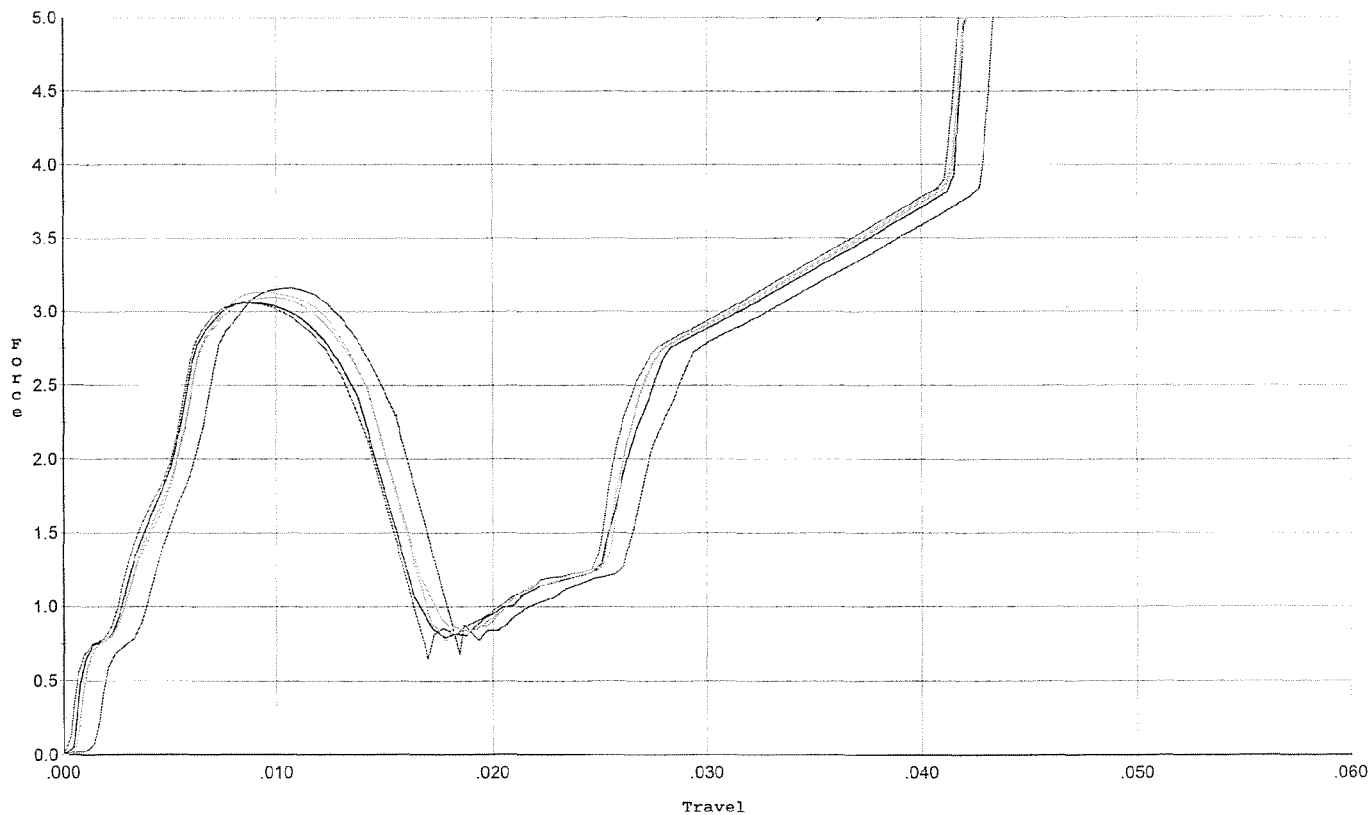
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.372	0.012	0.00	0.030	0.019		Set Trigger
2	2.345	0.012	0.00	0.031	0.019		Set Trigger
3	2.350	0.013	0.00	0.030	0.020		Set Trigger
4	2.304	0.013	0.00	0.030	0.020		Set Trigger
5	2.242	0.013	0.00	0.029	0.019		Set Trigger

A-2.32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



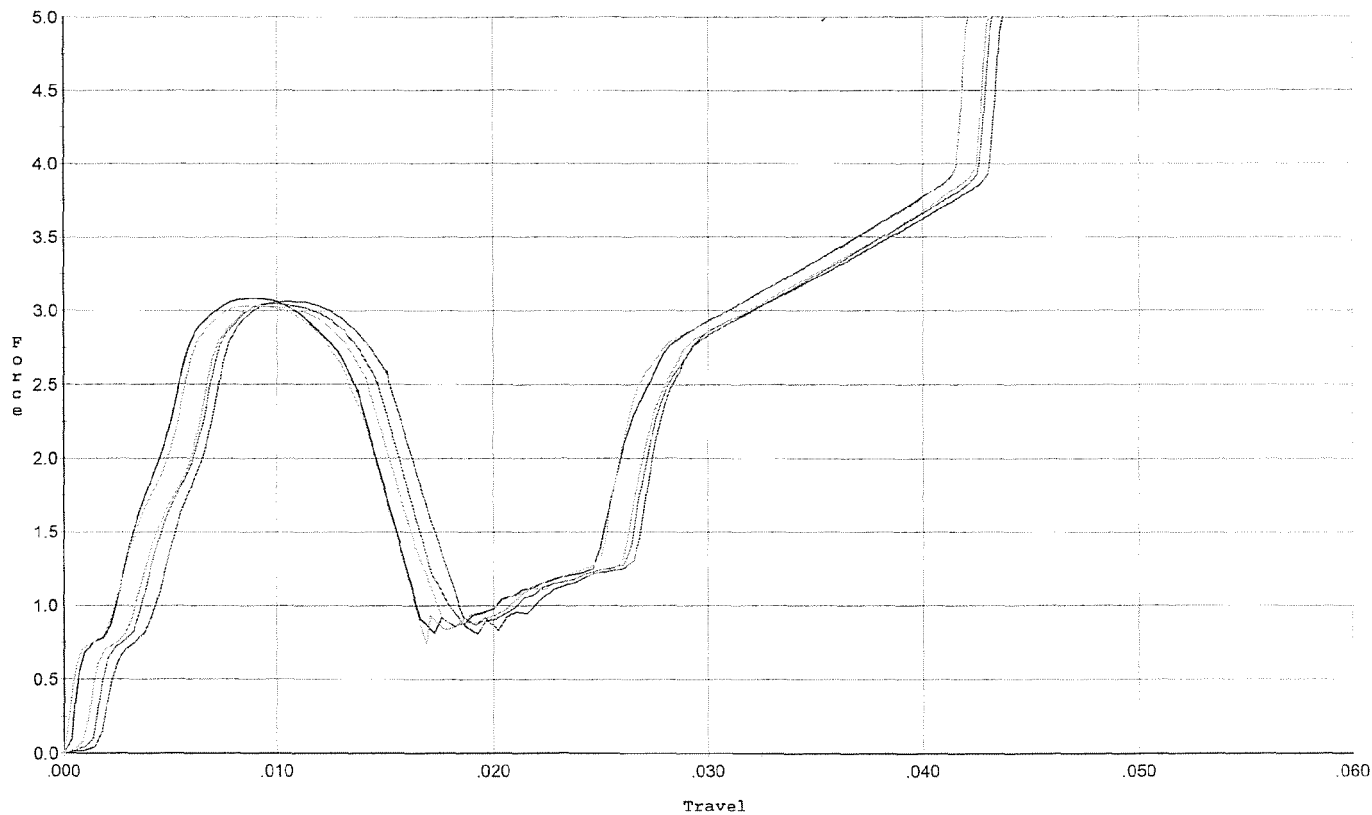
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.160	0.016	0.00	0.030	0.030		Set Trigger
2	3.058	0.014	0.00	0.030	0.028		Set Trigger
3	3.060	0.014	0.00	0.030	0.029		Set Trigger
4	3.098	0.014	0.00	0.030	0.028		Set Trigger
5	3.133	0.014	0.00	0.030	0.029		Set Trigger

A.3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



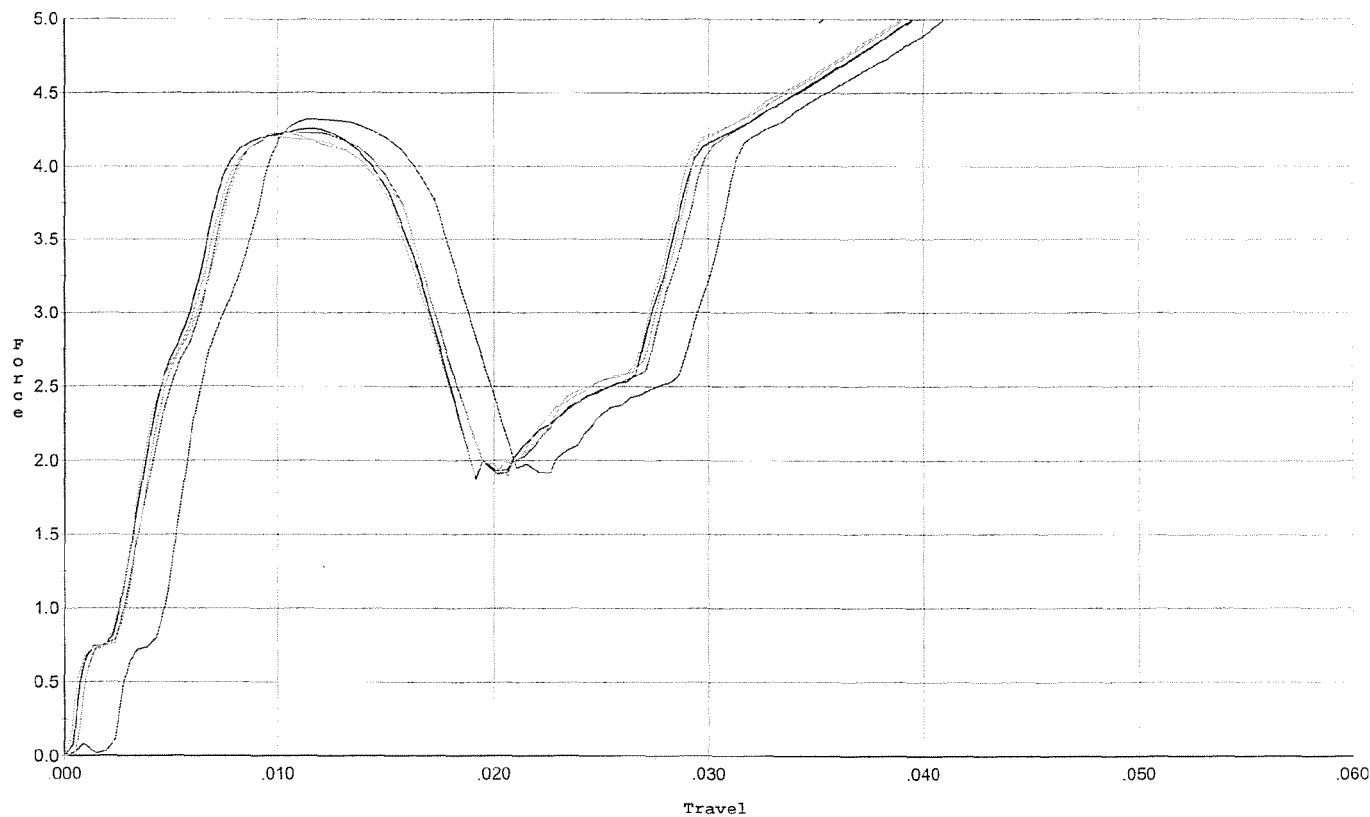
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.059	0.015	0.00	0.030	0.028		Set Trigger
2	3.082	0.014	0.00	0.030	0.029		Set Trigger
3	3.047	0.015	0.00	0.030	0.028		Set Trigger
4	3.031	0.014	0.00	0.030	0.029		Set Trigger
5	3.028	0.014	0.00	0.031	0.027		Set Trigger

A-3.04

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



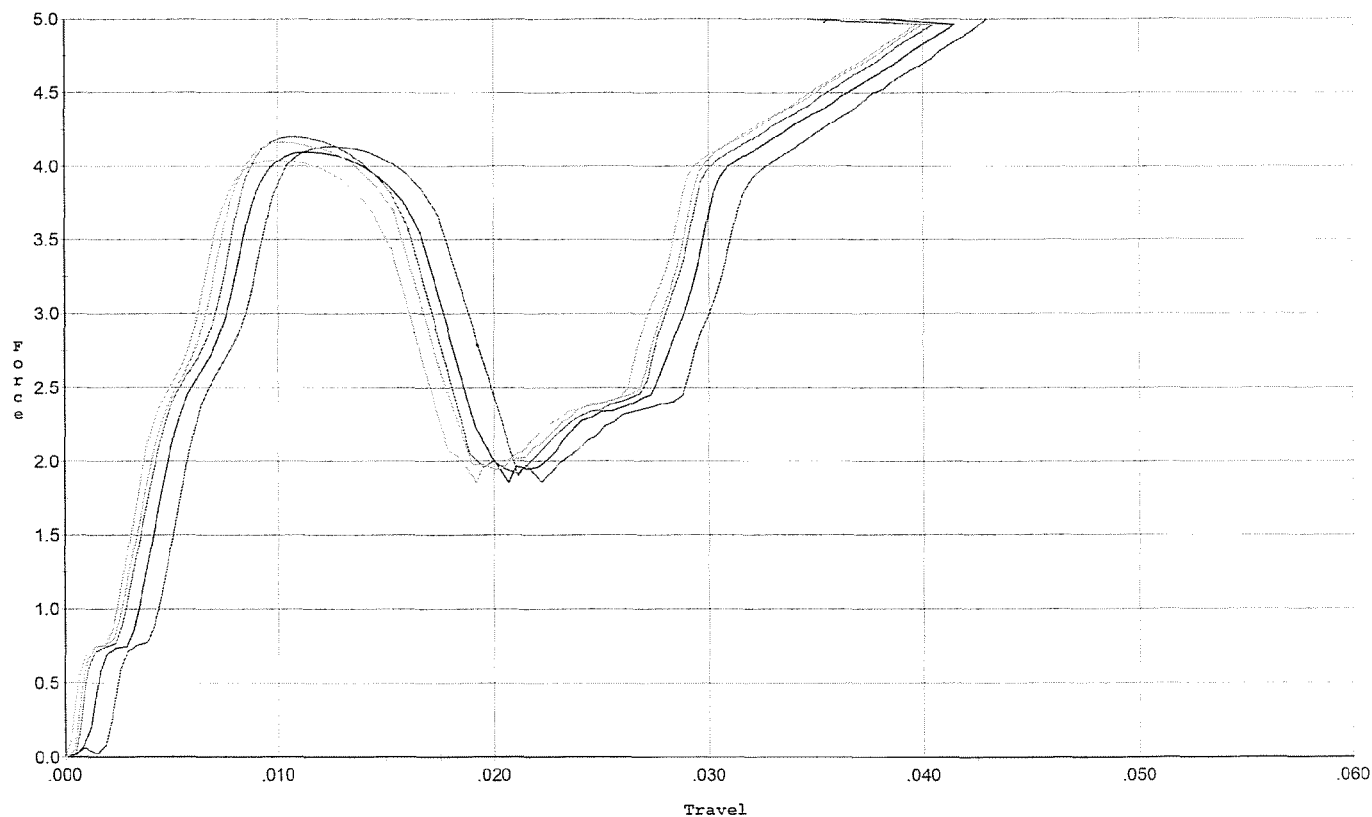
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.319	0.017	0.00	0.027	0.044		Set Trigger
2	4.257	0.016	0.00	0.027	0.046		Set Trigger
3	4.228	0.016	0.00	0.027	0.043		Set Trigger
4	4.201	0.017	0.00	0.026	0.047		Set Trigger
5	4.233	0.016	0.00	0.027	0.043		Set Trigger

A. 4.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/20/2009

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



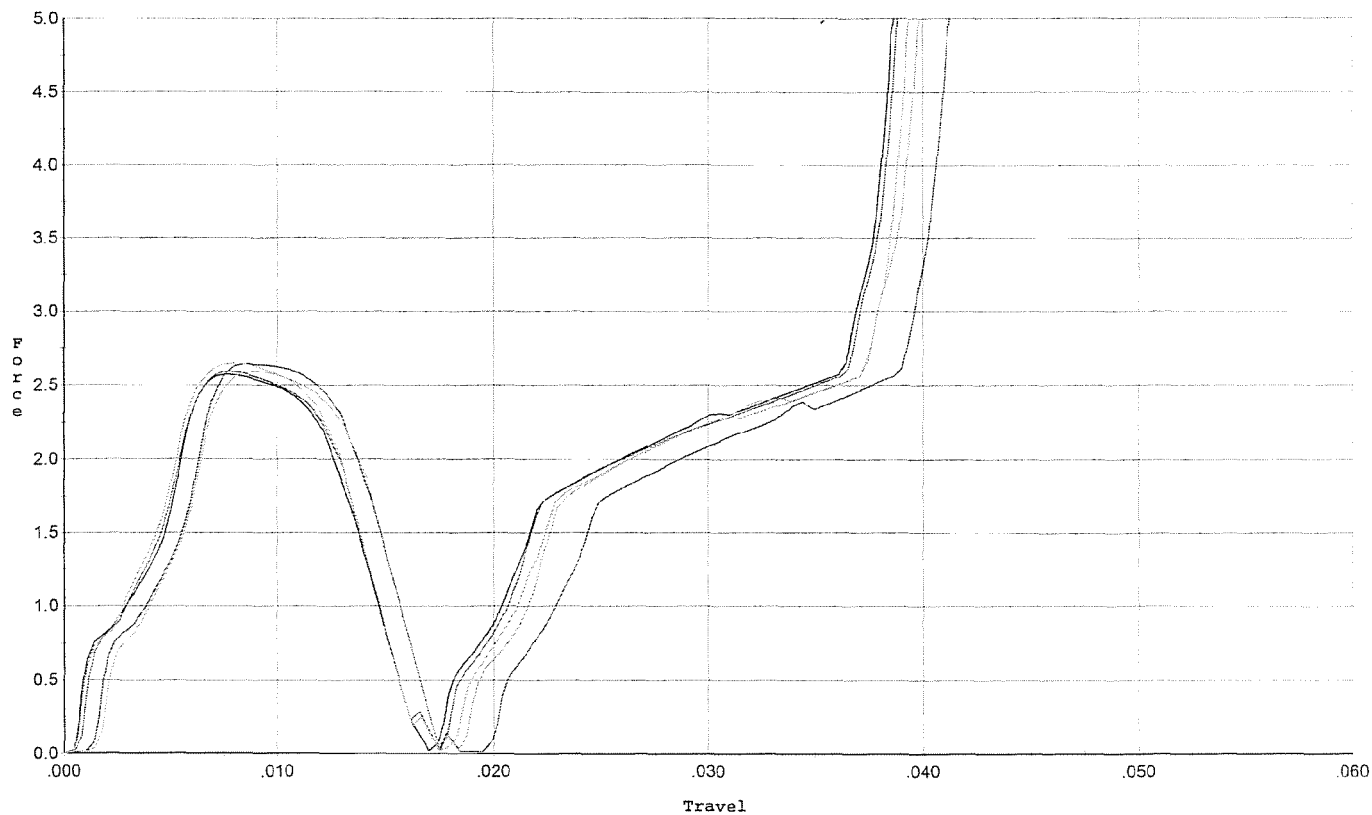
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.133	0.019	0.00	0.027	0.048		Set Trigger
2	4.099	0.017	0.00	0.027	0.042		Set Trigger
3	4.199	0.016	0.00	0.027	0.043		Set Trigger
4	4.042	0.015	0.00	0.027	0.040		Set Trigger
5	4.167	0.015	0.00	0.027	0.041		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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



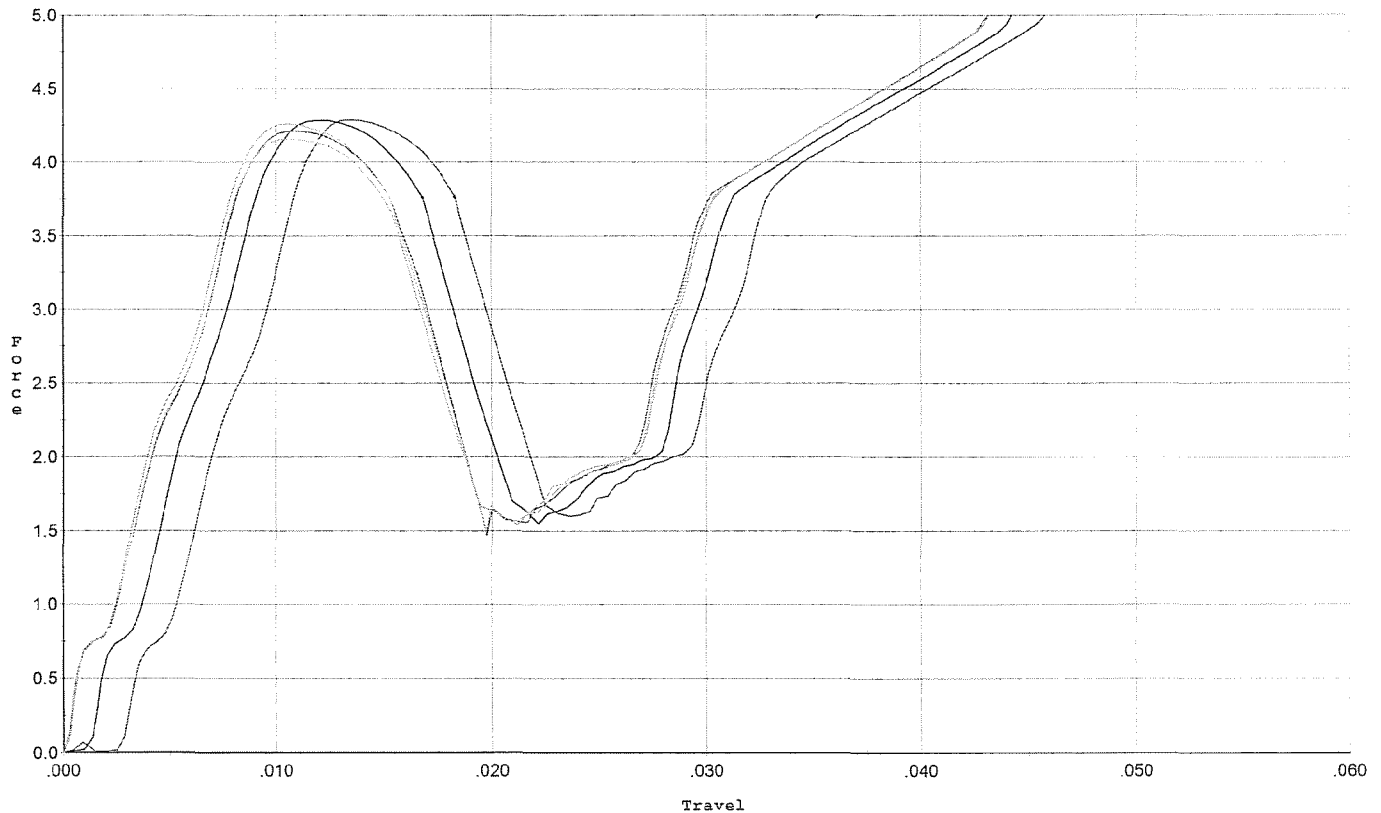
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.642	0.014	0.00	0.031	0.023		Set Trigger
2	2.572	0.014	0.00	0.029	0.023		Set Trigger
3	2.592	0.013	0.00	0.029	0.022		Set Trigger
4	2.647	0.013	0.00	0.030	0.022		Set Trigger
5	2.593	0.014	0.00	0.029	0.022		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/20/2009

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	4.288	0.018	0.003	0.028	0.044		Set Trigger
2	4.284	0.017	0.00	0.028	0.043		Set Trigger
3	4.210	0.017	0.00	0.028	0.044		Set Trigger
4	4.158	0.015	0.00	0.028	0.041		Set Trigger
5	4.260	0.017	0.00	0.028	0.046		Set Trigger

A-4.24