

G680 1349

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



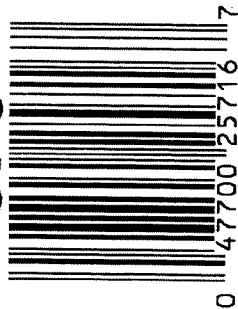
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801349

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801349

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SP
460	CHECK HEADSPACE		2-27-09	SP
470	DIS-ASSEMBLE ACTION		2-27-09	SP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	(S)	3/5/09	(S)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/4	mon
540	APPLY COATINGS (BARREL ACTION)		3/5	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-12-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

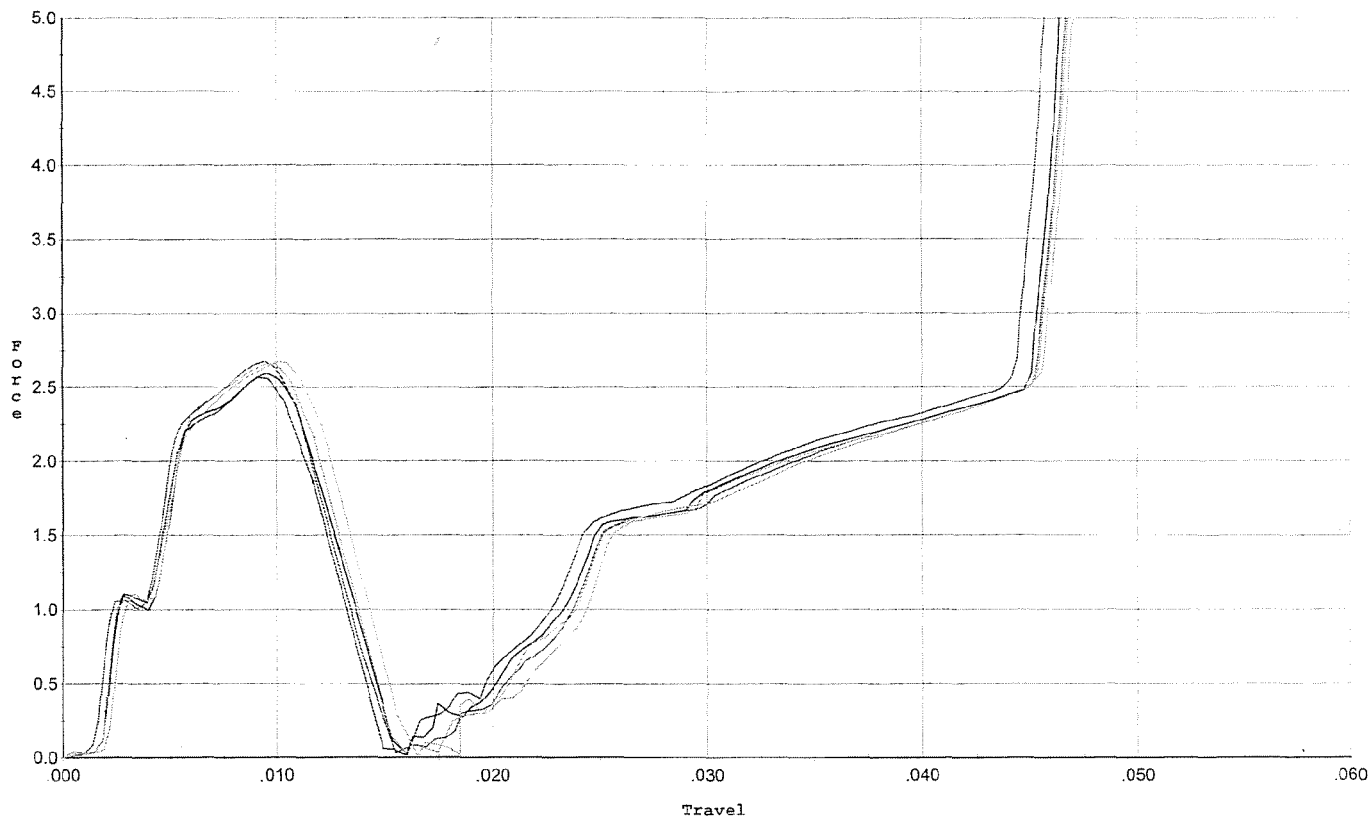
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>5.5</u> <u>6</u>	3-18-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-18-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	3-18-09	NW
	J) ASSEMBLE STOCK		3-18-09	NW
	K) ASSEMBLE SWIVEL STUDS		3-18-09	NW
	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	3-17-09	TL
	MALFUNCTION	CORRECTION	/	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-18-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.51</u> <u>2.61</u> <u>2.50</u> <u>2.42</u>	3-18-09	NW
	C) FUNCTION		3-18-09	NW
690	PACK		3/19/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



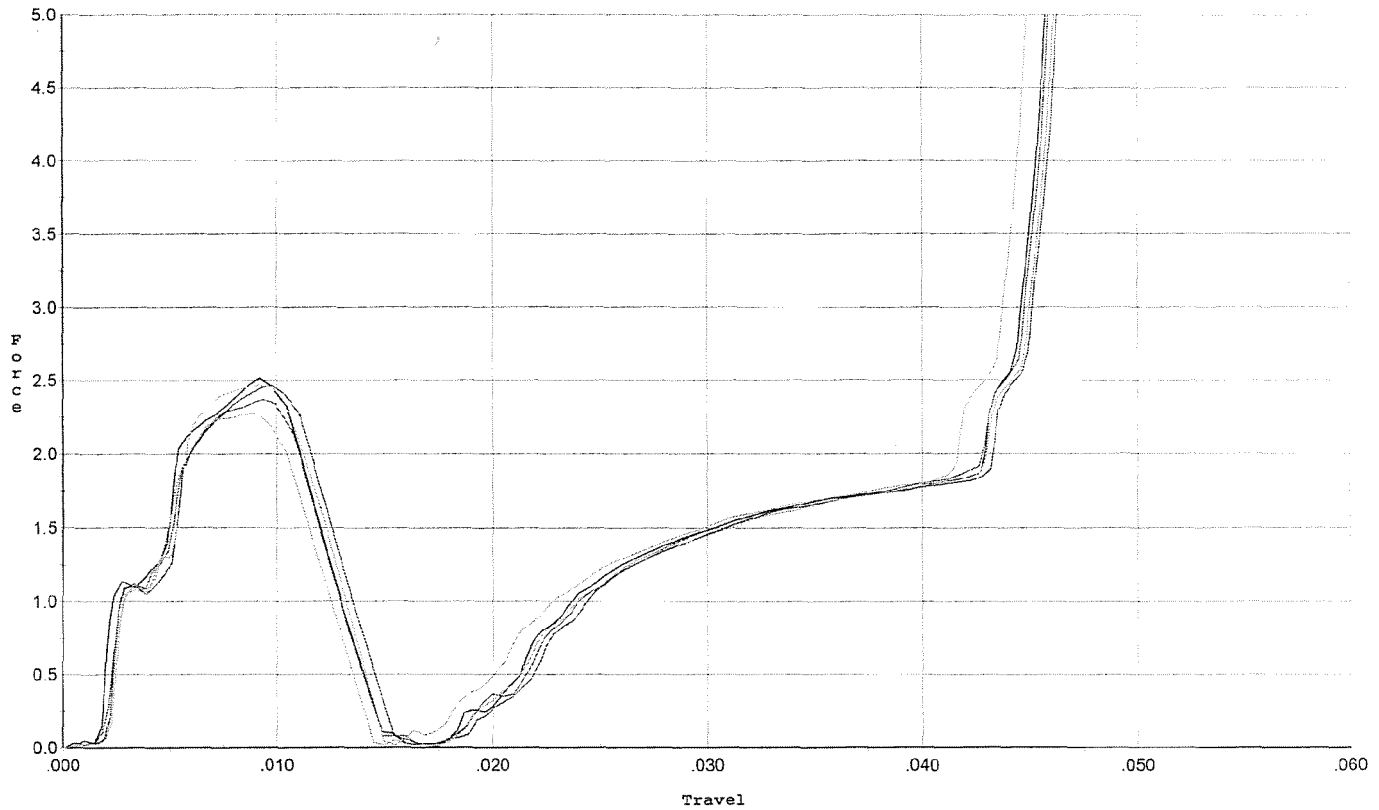
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.012	0.004	0.038	0.018		Set Trigger
2	2.593	0.013	0.004	0.038	0.020		Set Trigger
3	2.673	0.011	0.00	0.039	0.017		Set Trigger
4	2.670	0.012	0.00	0.038	0.019		Set Trigger
5	2.656	0.012	0.004	0.038	0.019		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

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

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



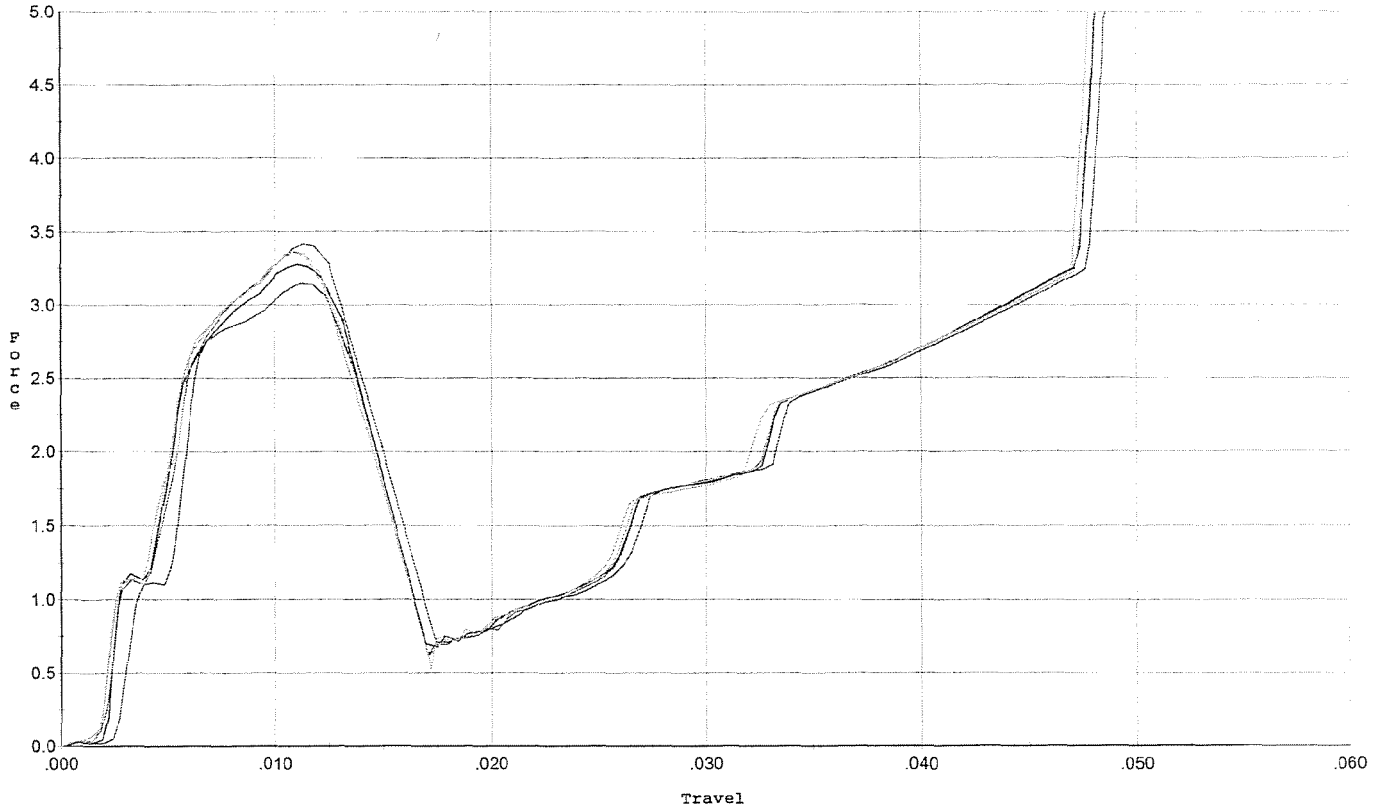
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.464	0.011	0.00	0.039	0.016		Set Trigger
2	2.515	0.010	0.00	0.039	0.016		Set Trigger
3	2.368	0.011	0.00	0.039	0.015		Set Trigger
4	2.470	0.012	0.002	0.037	0.017		Set Trigger
5	2.278	0.012	0.00	0.039	0.017		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

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

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



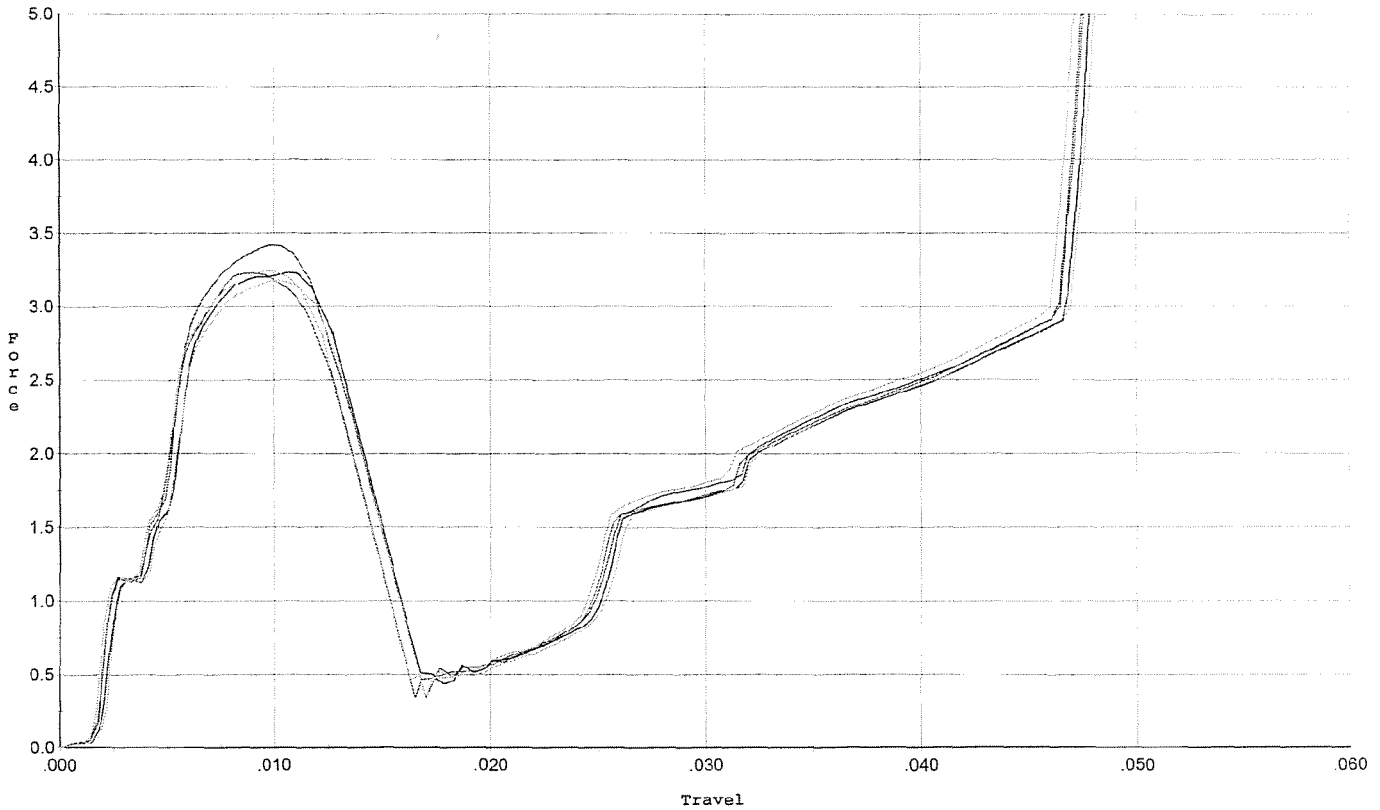
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.014	0.003	0.037	0.024		Set Trigger
2	3.278	0.013	0.00	0.037	0.026		Set Trigger
3	3.417	0.015	0.00	0.036	0.030		Set Trigger
4	3.362	0.013	0.002	0.036	0.027		Set Trigger
5	3.360	0.014	0.00	0.037	0.028		Set Trigger

A-3.31

Trigger Profile [lbs,inch]

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

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



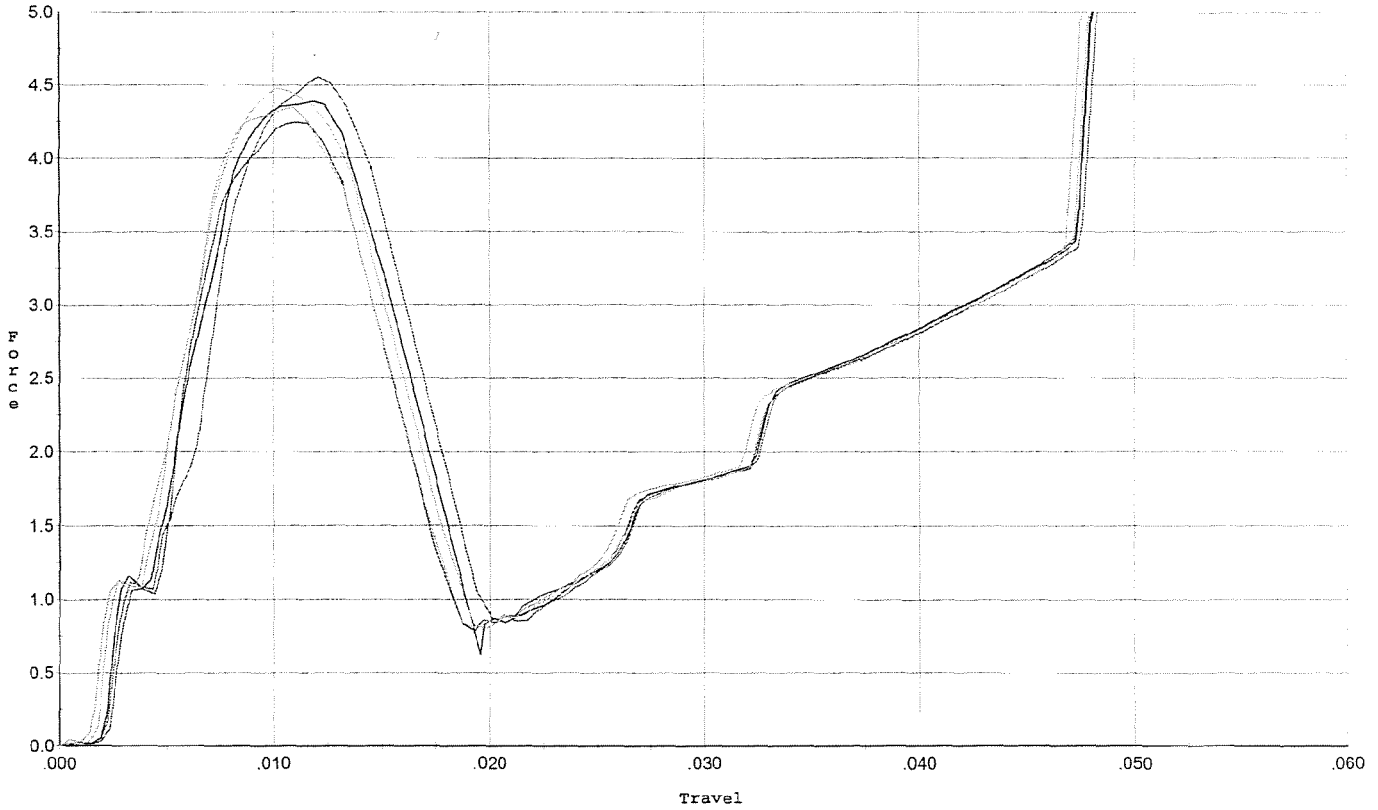
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.421	0.013	0.00	0.036	0.027		Set Trigger
2	3.235	0.013	0.00	0.037	0.025		Set Trigger
3	3.231	0.013	0.00	0.037	0.024		Set Trigger
4	3.180	0.013	0.00	0.037	0.025		Set Trigger
5	3.245	0.012	0.00	0.037	0.024		Set Trigger

A-3.26

Trigger Profile [lbs,inch]

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

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



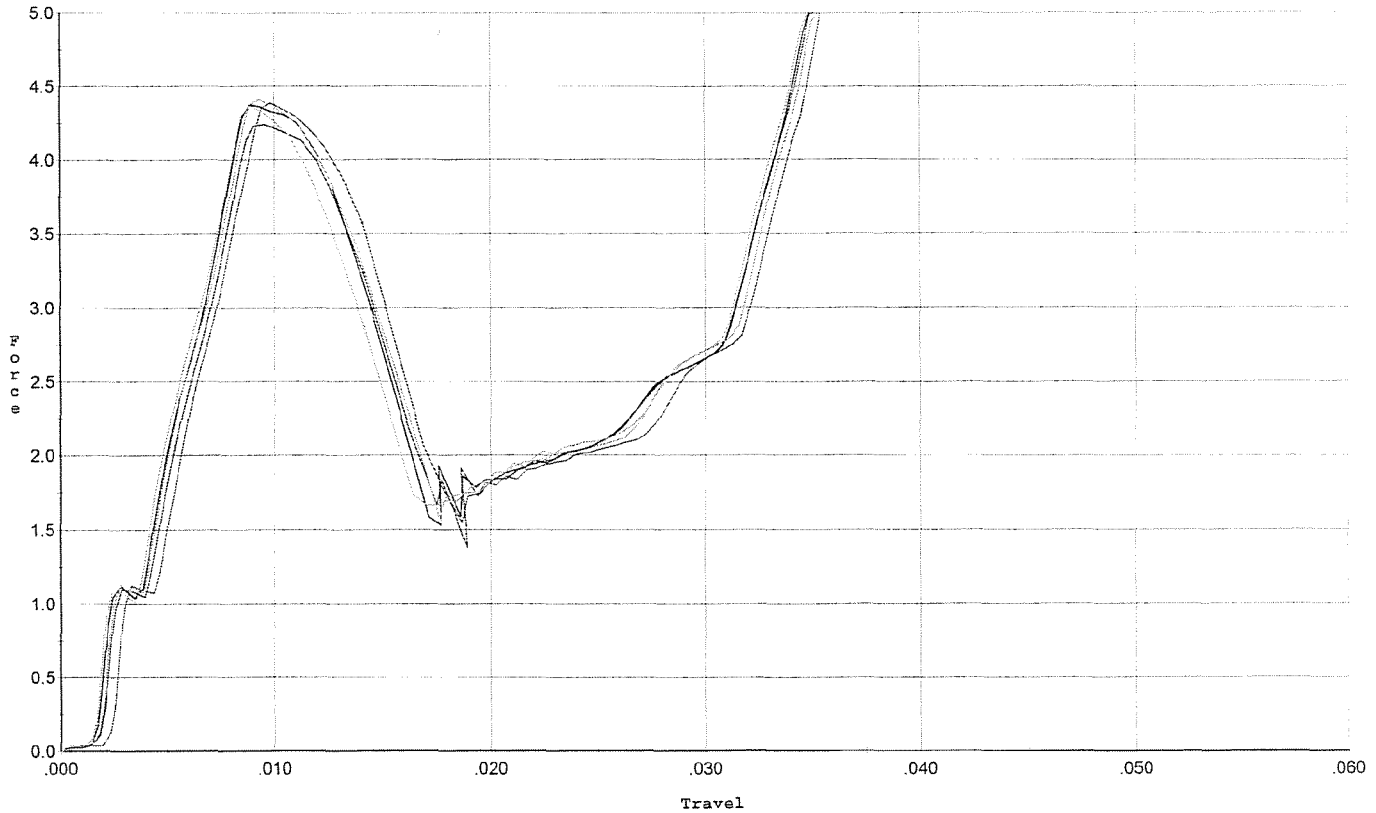
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.242	0.013	0.002	0.035	0.031		Set Trigger
2	4.388	0.015	0.002	0.034	0.037		Set Trigger
3	4.552	0.015	0.002	0.034	0.036		Set Trigger
4	4.477	0.014	0.004	0.034	0.034		Set Trigger
5	4.345	0.013	0.00	0.035	0.033		Set Trigger

A. 4.40

Trigger Profile [lbs,inch]

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

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



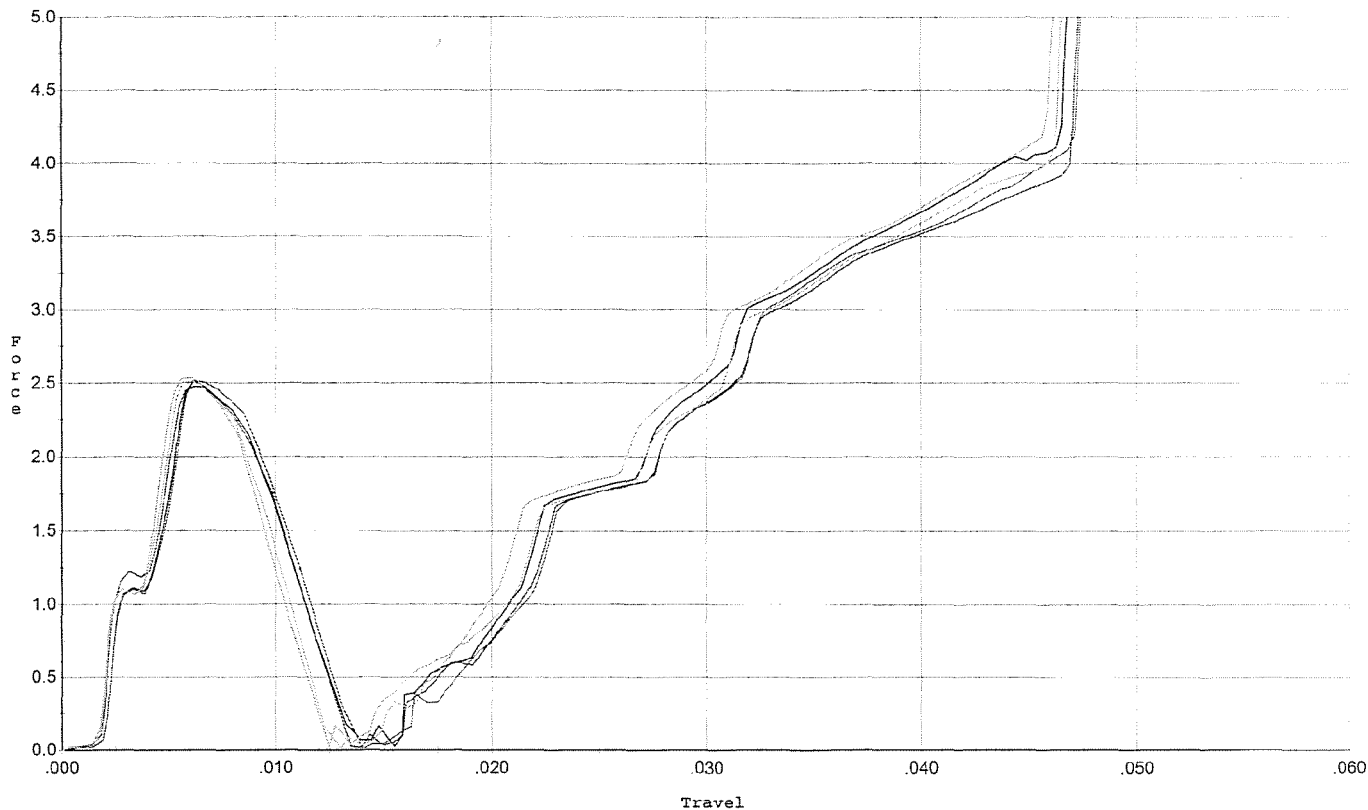
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.241	0.014	0.004	0.031	0.033		Set Trigger
2	4.374	0.014	0.00	0.031	0.035		Set Trigger
3	4.387	0.014	0.005	0.031	0.033		Set Trigger
4	4.371	0.014	0.004	0.031	0.034		Set Trigger
5	4.411	0.016	0.004	0.030	0.038		Set Trigger

A-4.35

Trigger Profile [lbs,inch]

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

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



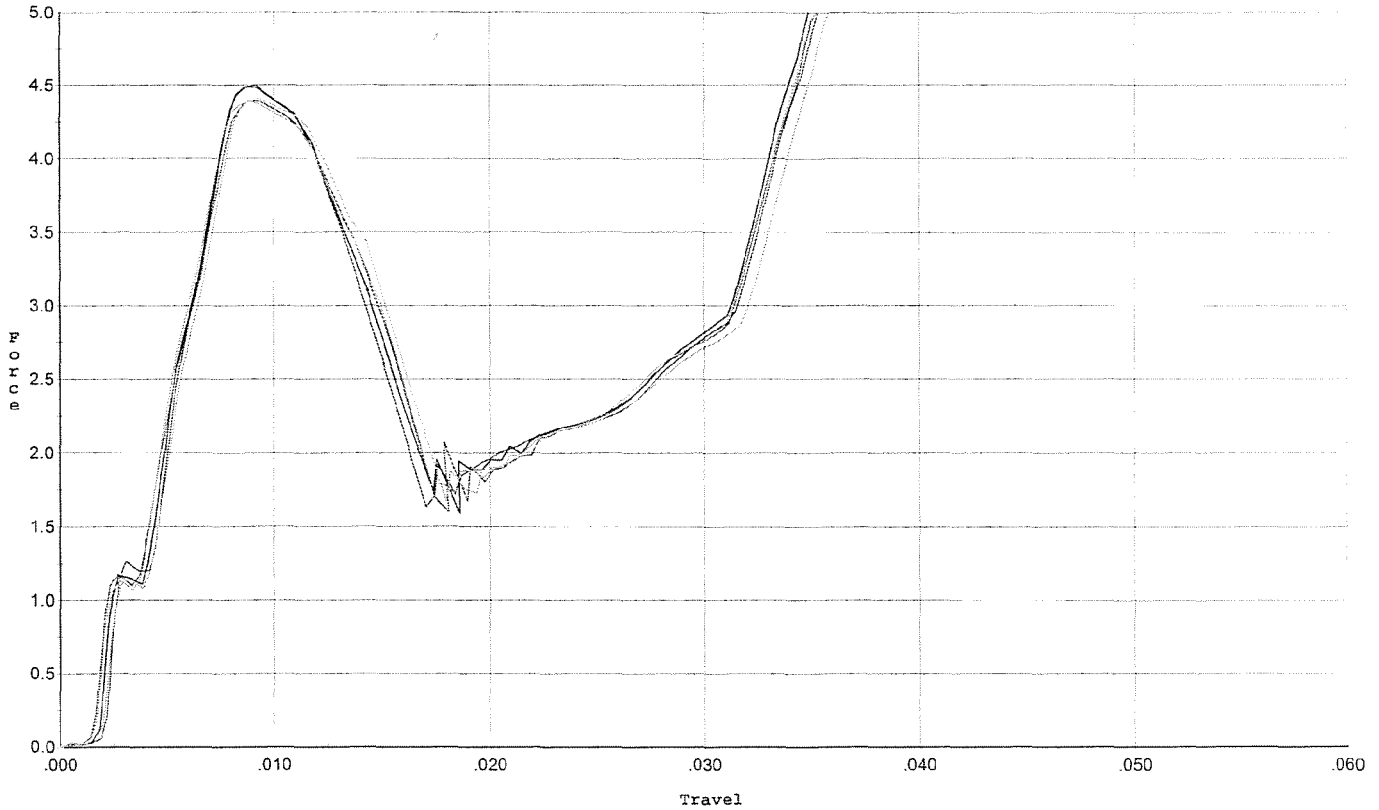
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.010	0.00	0.039	0.014		Set Trigger
2	2.516	0.010	0.00	0.039	0.013		Set Trigger
3	2.519	0.011	0.002	0.039	0.015		Set Trigger
4	2.509	0.010	0.00	0.039	0.013		Set Trigger
5	2.535	0.008	0.00	0.039	0.011		Set Trigger

A-2.51

Trigger Profile [lbs,inch]

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

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	4.499	0.015	0.004	0.029	0.037		Set Trigger
2	4.488	0.014	0.004	0.029	0.036		Set Trigger
3	4.393	0.015	0.00	0.029	0.038		Set Trigger
4	4.409	0.014	0.00	0.029	0.035		Set Trigger
5	4.390	0.015	0.00	0.029	0.038		Set Trigger

A-4.43