

576801366

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



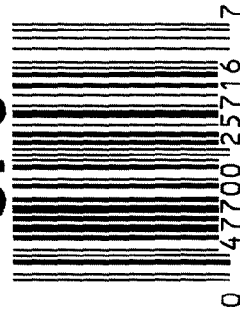
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801366

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801366

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	TR
460	CHECK HEADSPACE		3-6-09	TR
470	DIS-ASSEMBLE ACTION		3-6-09	RZ
472	SERIALIZE BOLT HANDLE		3-6-09	RZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION		3/9/09	MR
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	MR
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		3-24-09	Z.N
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

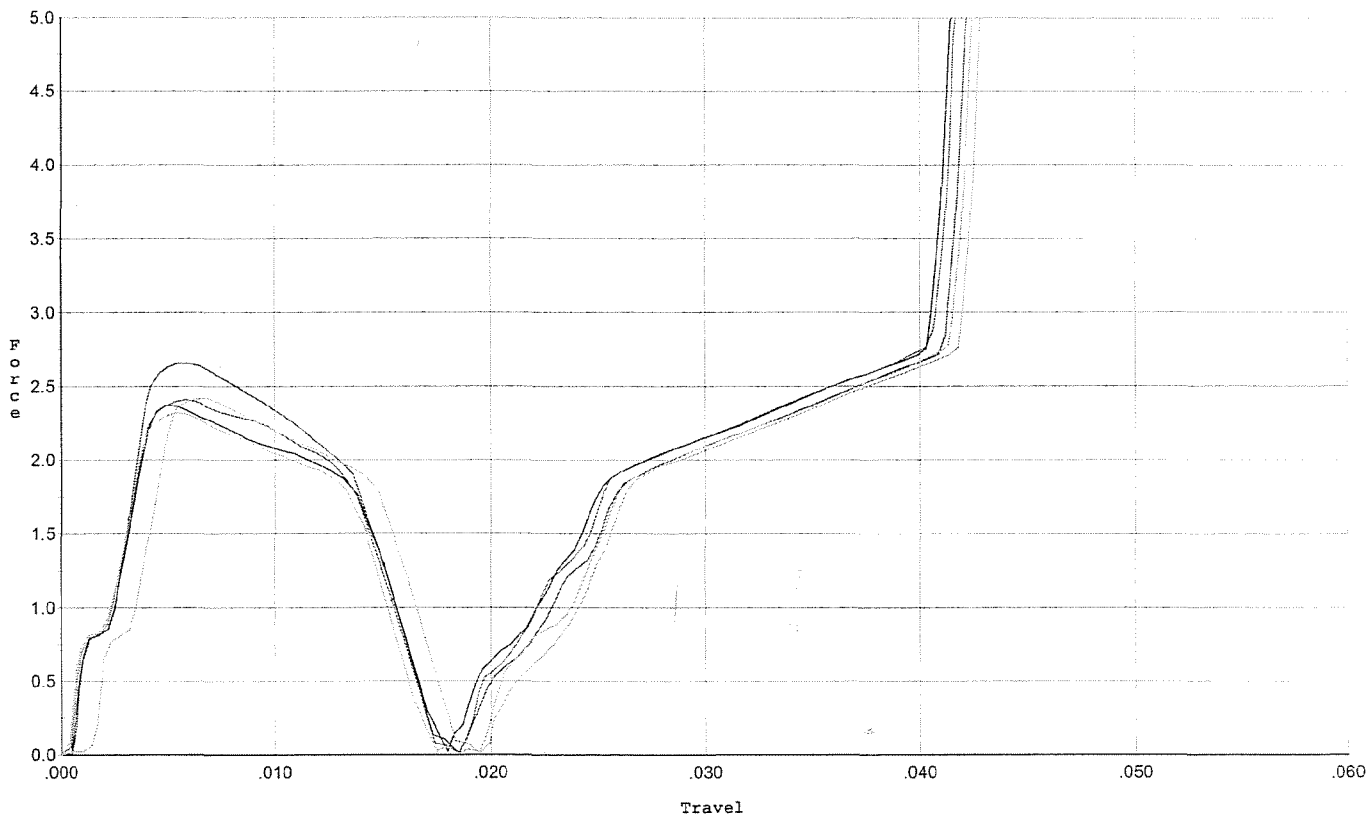
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>50</u> <u>50</u>	3-28-09	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	3-28-09	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-28-09	LJ
	J) ASSEMBLE STOCK		3-24-09	LJ
	K) ASSEMBLE SWIVEL STUDS		3-28-09	LJ
	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	3-26-09	N/A
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-28-09	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.60</u> <u>2.63</u> <u>2.65</u> <u>2.61</u>	3-28-09	TL
	C) FUNCTION		3-28-09	LJ
690	PACK		3/24/09	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



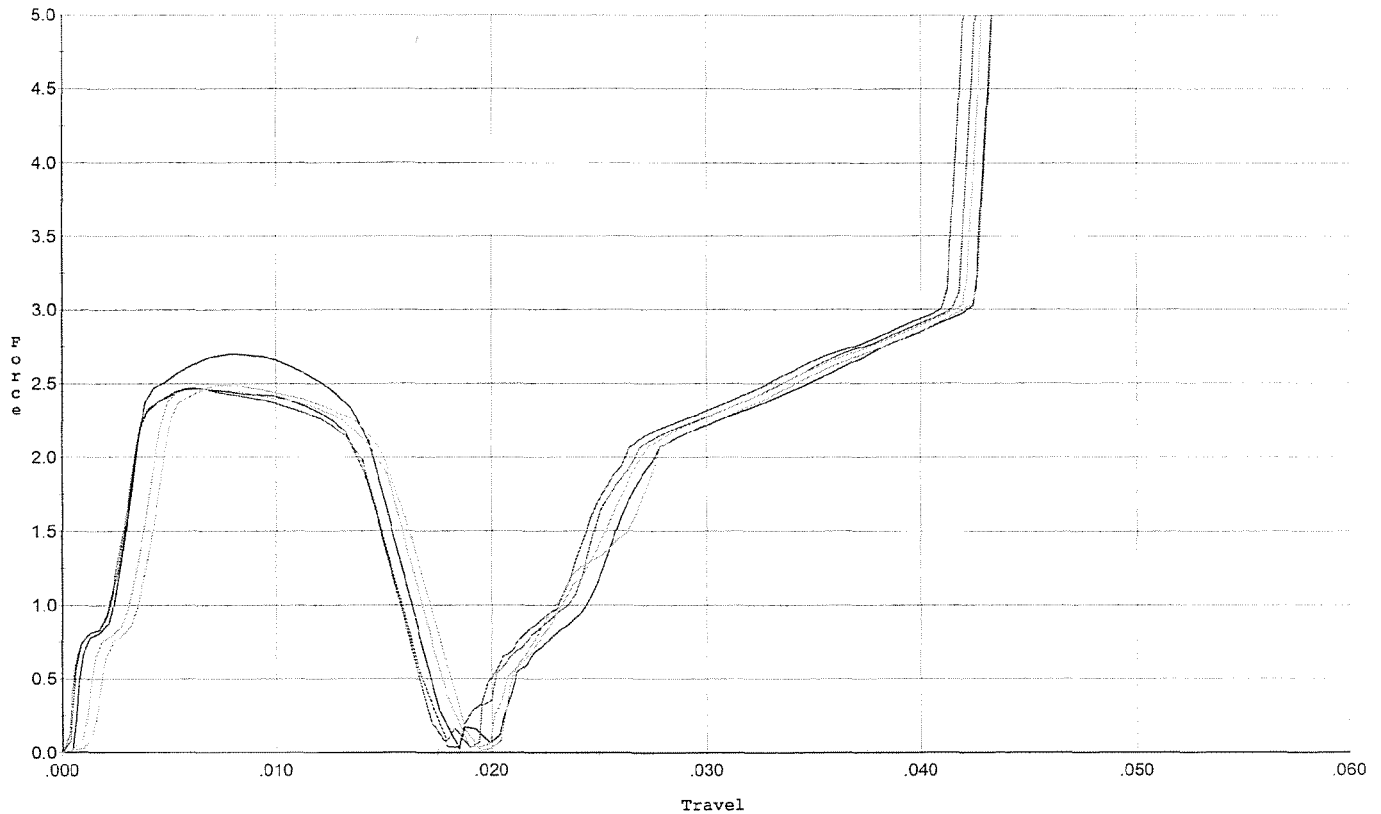
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.662	0.015	0.00	0.032	0.027		Set Trigger
2	2.373	0.015	0.00	0.031	0.025		Set Trigger
3	2.410	0.015	0.00	0.031	0.026		Set Trigger
4	2.321	0.014	0.00	0.032	0.024		Set Trigger
5	2.420	0.016	0.00	0.031	0.026		Set Trigger

A-2.43

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



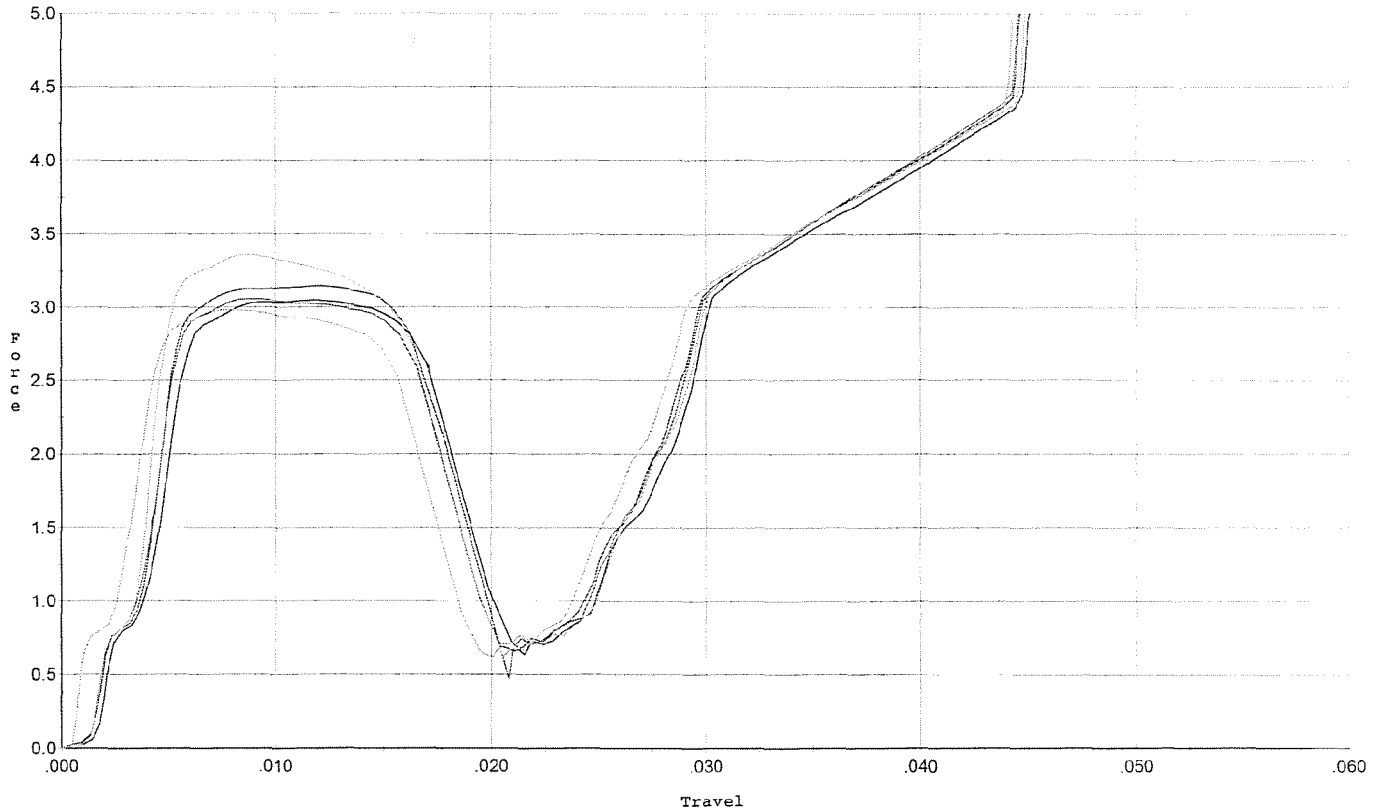
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.468	0.014	0.00	0.031	0.026		Set Trigger
2	2.701	0.014	0.00	0.032	0.028		Set Trigger
3	2.464	0.014	0.00	0.032	0.026		Set Trigger
4	2.460	0.015	0.00	0.031	0.027		Set Trigger
5	2.487	0.016	0.00	0.031	0.028		Set Trigger

A-7.51

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



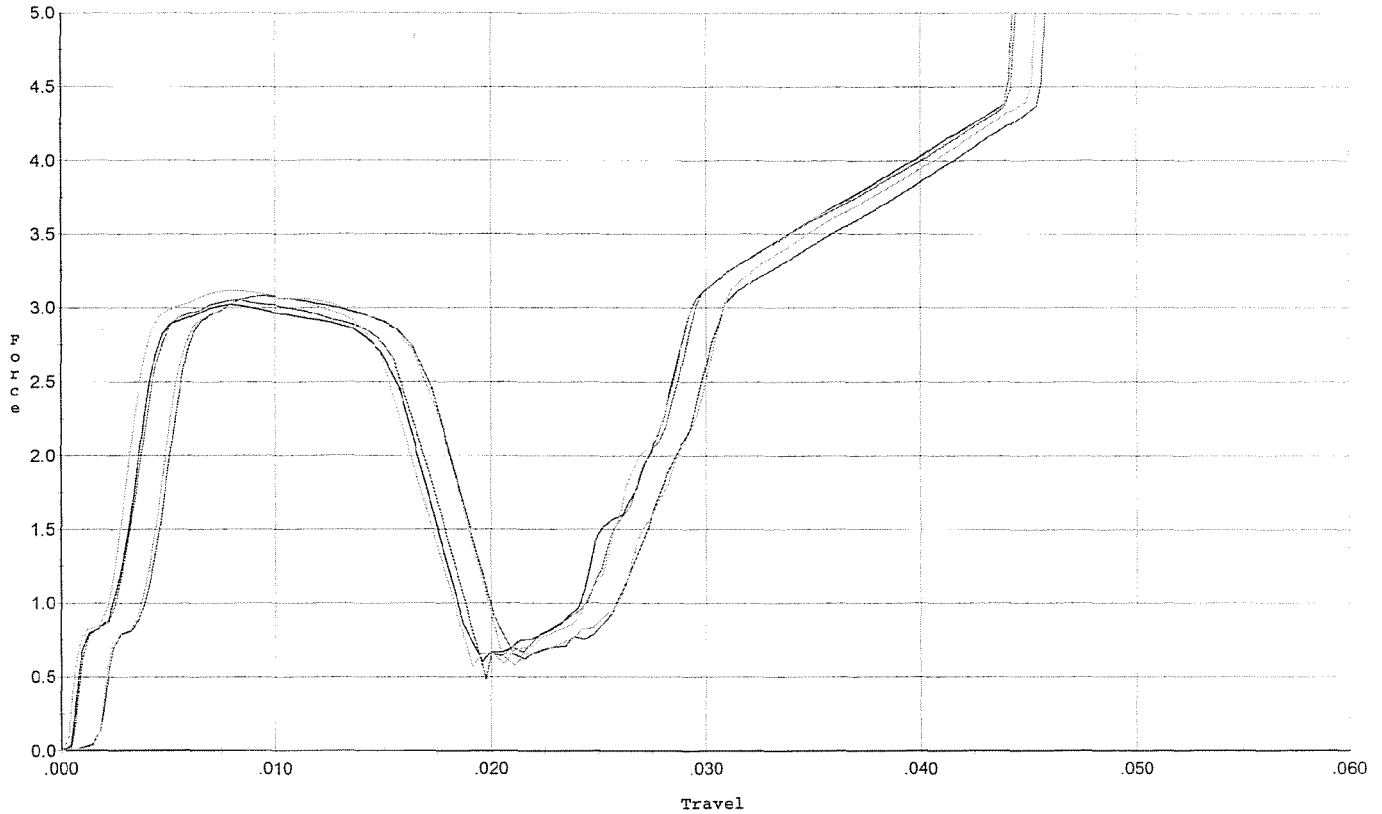
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.144	0.018	0.00	0.029	0.039		Set Trigger
2	3.049	0.017	0.00	0.030	0.036		Set Trigger
3	3.055	0.017	0.00	0.030	0.035		Set Trigger
4	3.361	0.016	0.00	0.030	0.038		Set Trigger
5	2.985	0.016	0.00	0.030	0.034		Set Trigger

A3.11

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



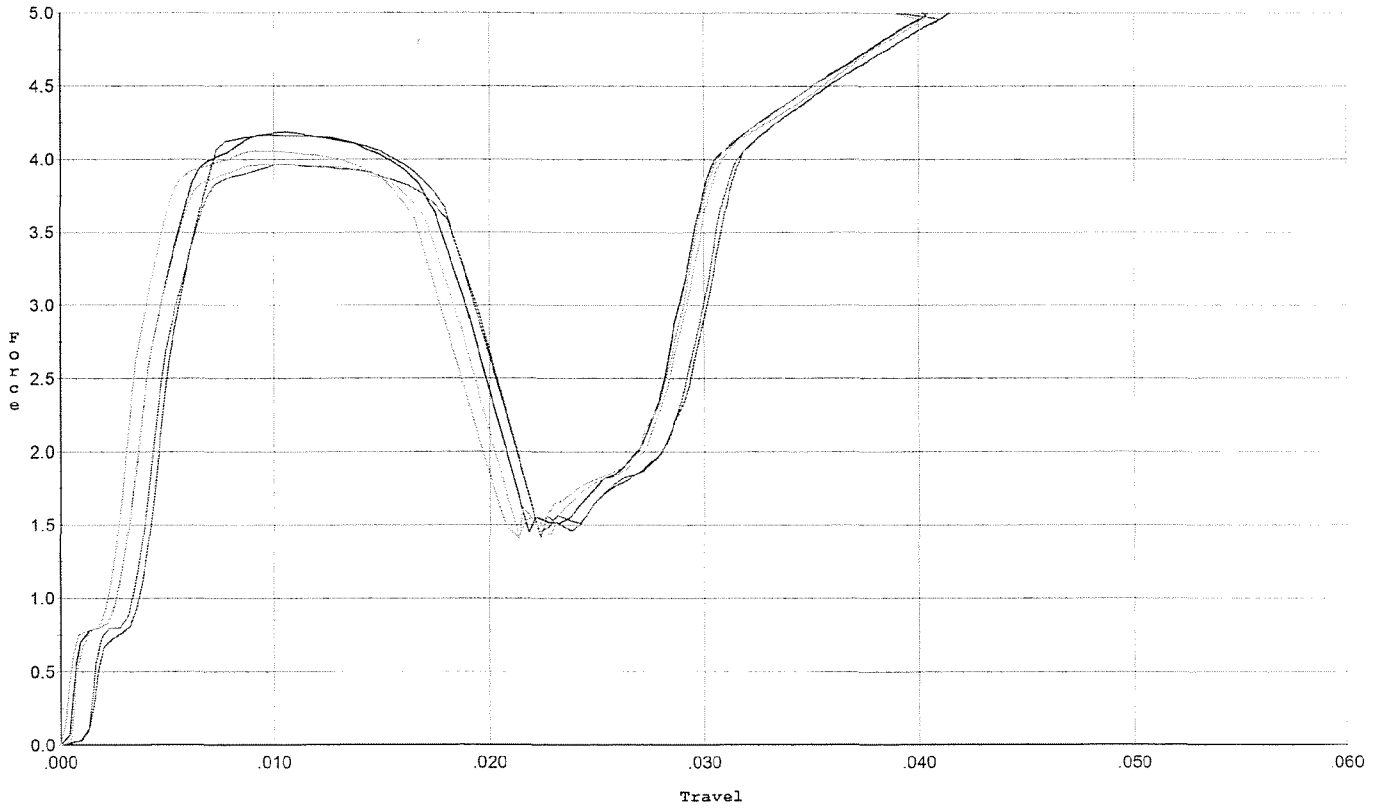
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.081	0.017	0.00	0.030	0.036		Set Trigger
2	3.018	0.016	0.00	0.030	0.035		Set Trigger
3	3.051	0.017	0.00	0.029	0.038		Set Trigger
4	3.115	0.017	0.00	0.030	0.039		Set Trigger
5	3.079	0.018	0.00	0.030	0.037		Set Trigger

A.3.06

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



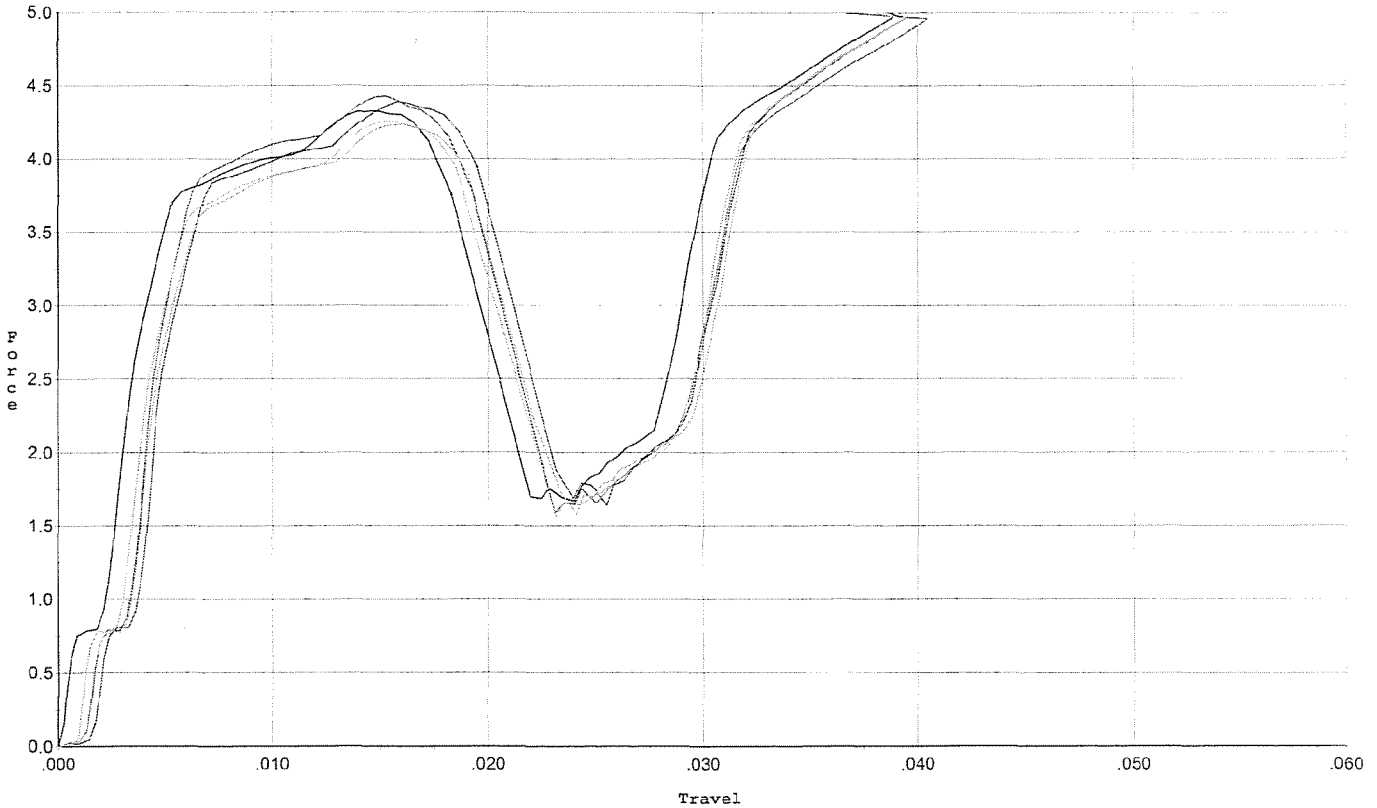
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.189	0.020	0.00	0.028	0.056		Set Trigger
2	4.171	0.019	0.00	0.027	0.056		Set Trigger
3	3.965	0.020	0.00	0.028	0.054		Set Trigger
4	3.964	0.019	0.00	0.028	0.053		Set Trigger
5	4.058	0.017	0.00	0.028	0.049		Set Trigger

A-4.06

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



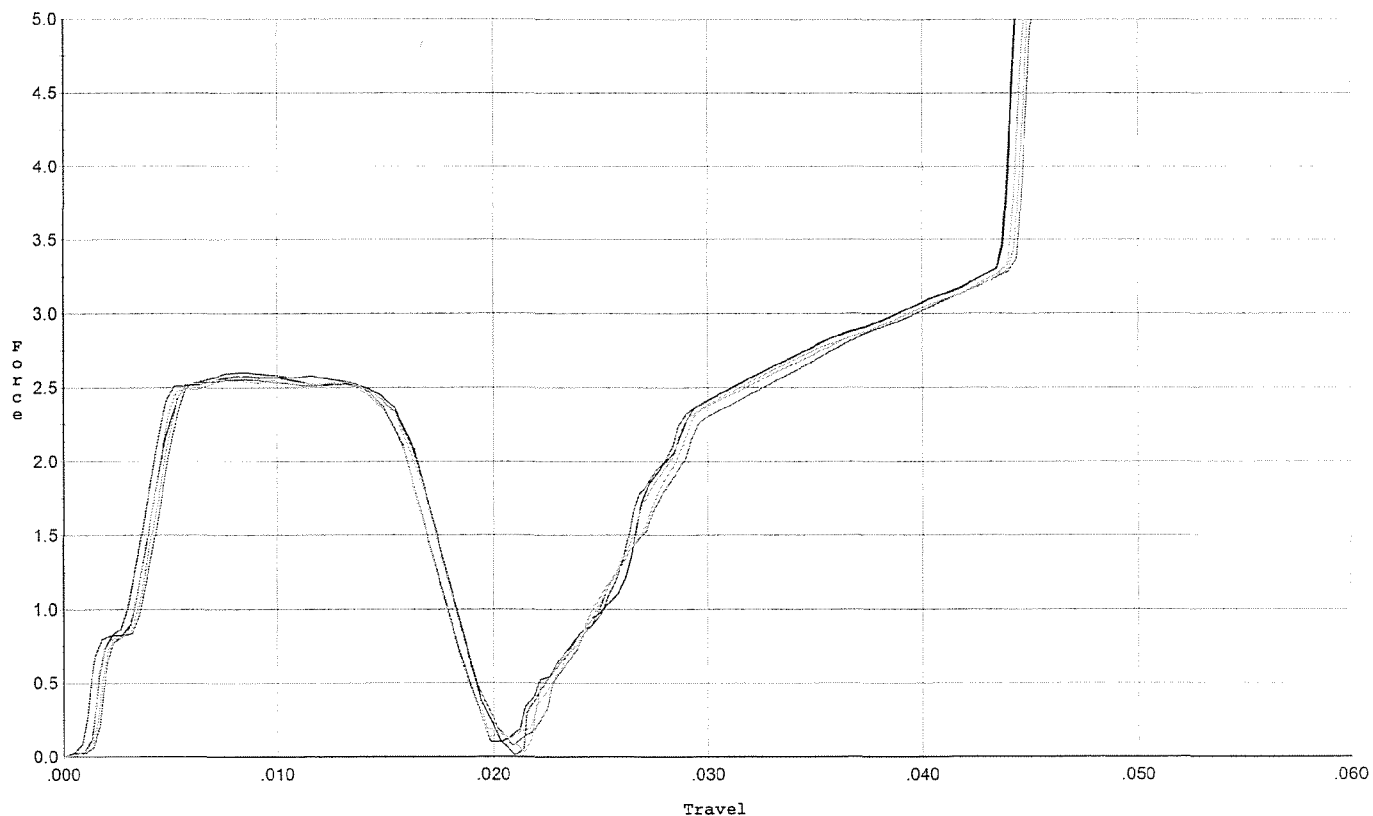
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.390	0.019	0.00	0.027	0.057		Set Trigger
2	4.325	0.018	0.00	0.027	0.056		Set Trigger
3	4.426	0.019	0.00	0.027	0.058		Set Trigger
4	4.258	0.021	0.00	0.027	0.061		Set Trigger
5	4.236	0.019	0.00	0.027	0.055		Set Trigger

A-4.32

Trigger Profile [lbs,inch]

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

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



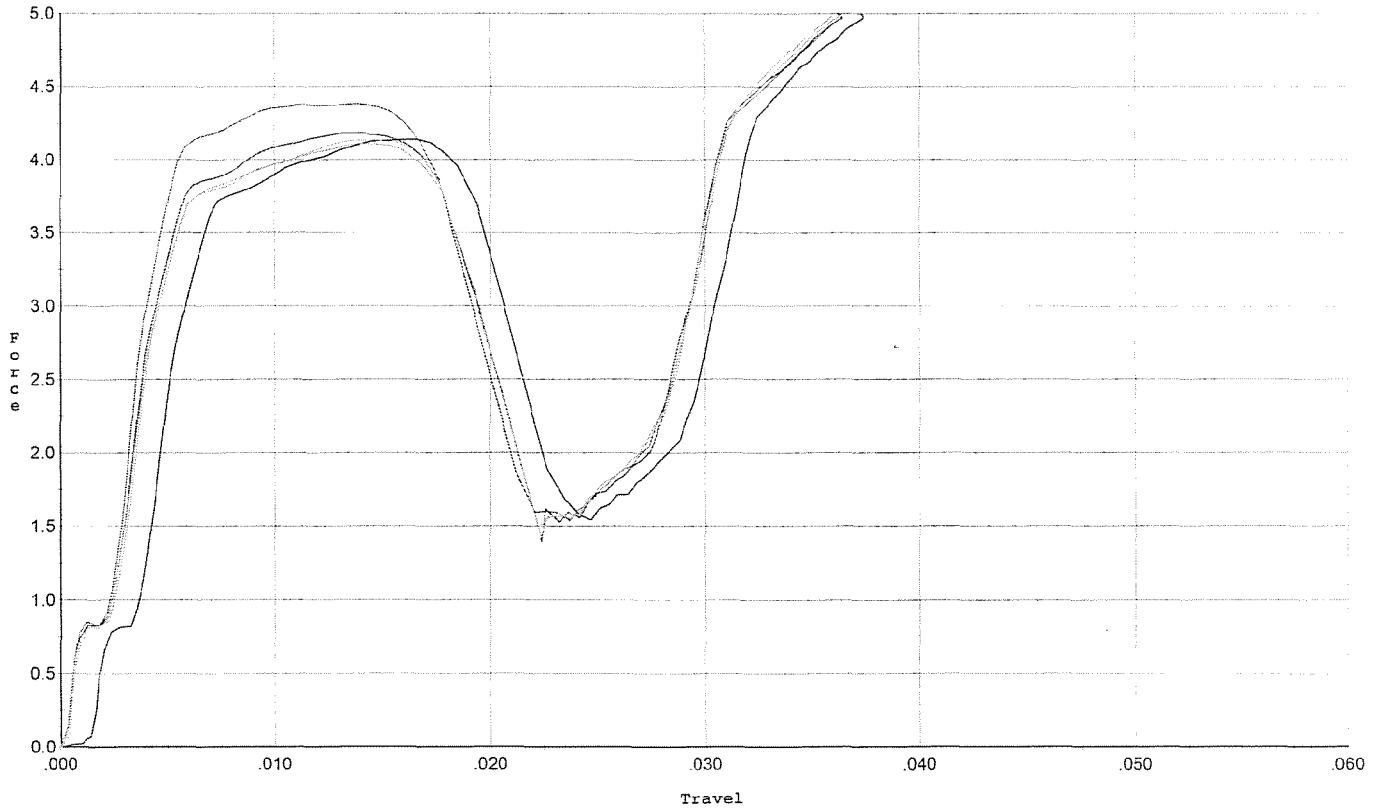
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.601	0.016	0.00	0.031	0.030		Set Trigger
2	2.575	0.016	0.00	0.031	0.031		Set Trigger
3	2.553	0.016	0.00	0.032	0.030		Set Trigger
4	2.579	0.017	0.00	0.031	0.031		Set Trigger
5	2.543	0.016	0.00	0.032	0.029		Set Trigger

A. 2.57

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	4.183	0.020	0.00	0.027	0.059		Set Trigger
2	4.141	0.019	0.00	0.028	0.055		Set Trigger
3	4.383	0.018	0.00	0.028	0.056		Set Trigger
4	4.136	0.019	0.00	0.028	0.057		Set Trigger
5	4.110	0.019	0.00	0.027	0.057		Set Trigger

A-4.19