

66801369

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



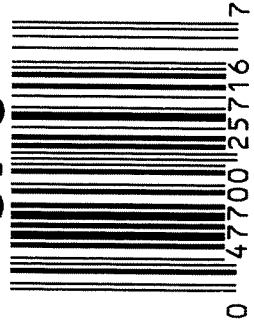
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801369

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801369

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		3/5/09	(A)
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	W
540	APPLY COATINGS (BARREL ACTION)		3/9	
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

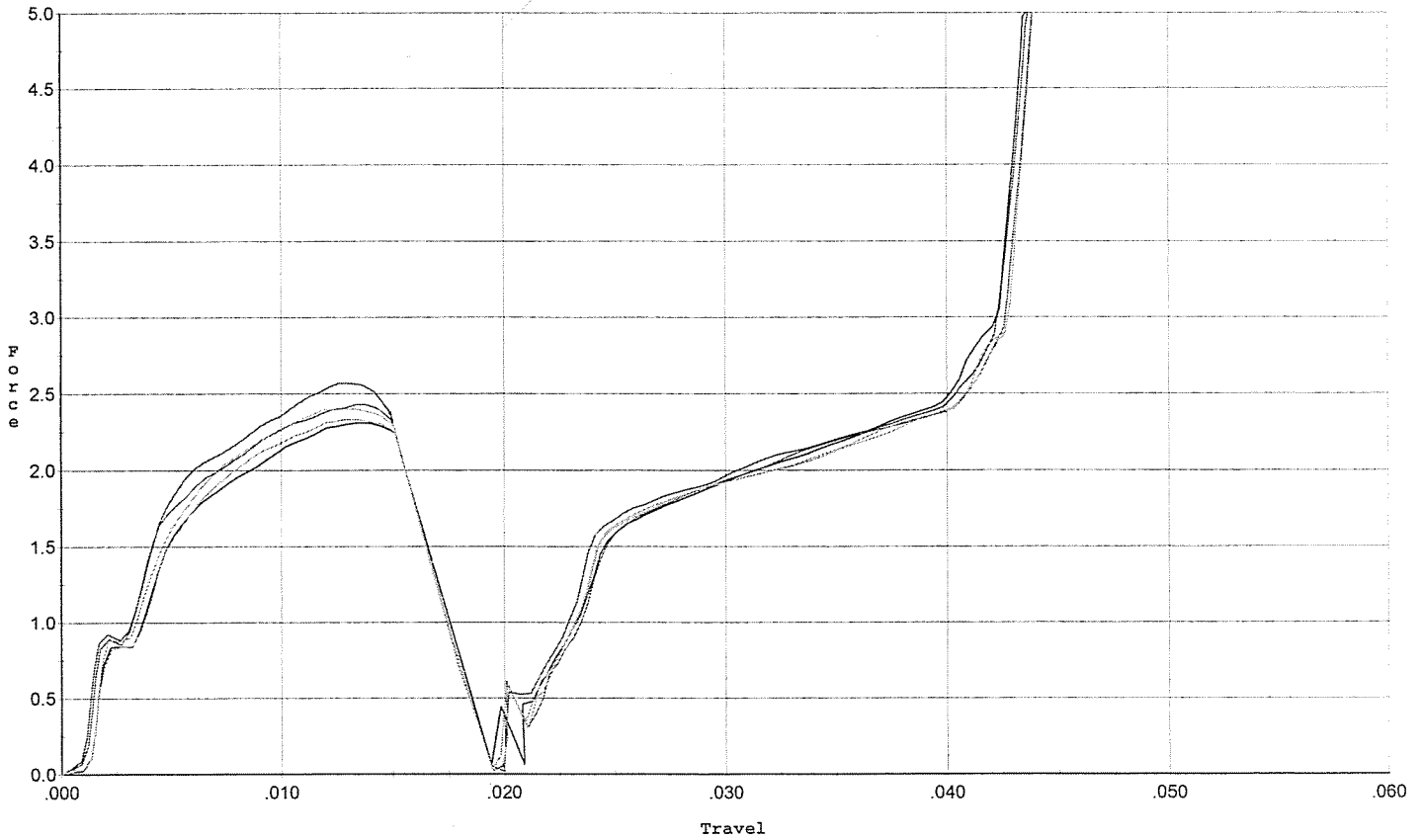
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4</u> <u>4.5</u>	3-18-09	NW
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-18-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-18-09	NW
	J) ASSEMBLE STOCK			3-12-09	L.N.
	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	TC
	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>2.45</u> <u>2.54</u> <u>2.49</u> <u>2.47</u> <u>2.29</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 3/11/2009

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



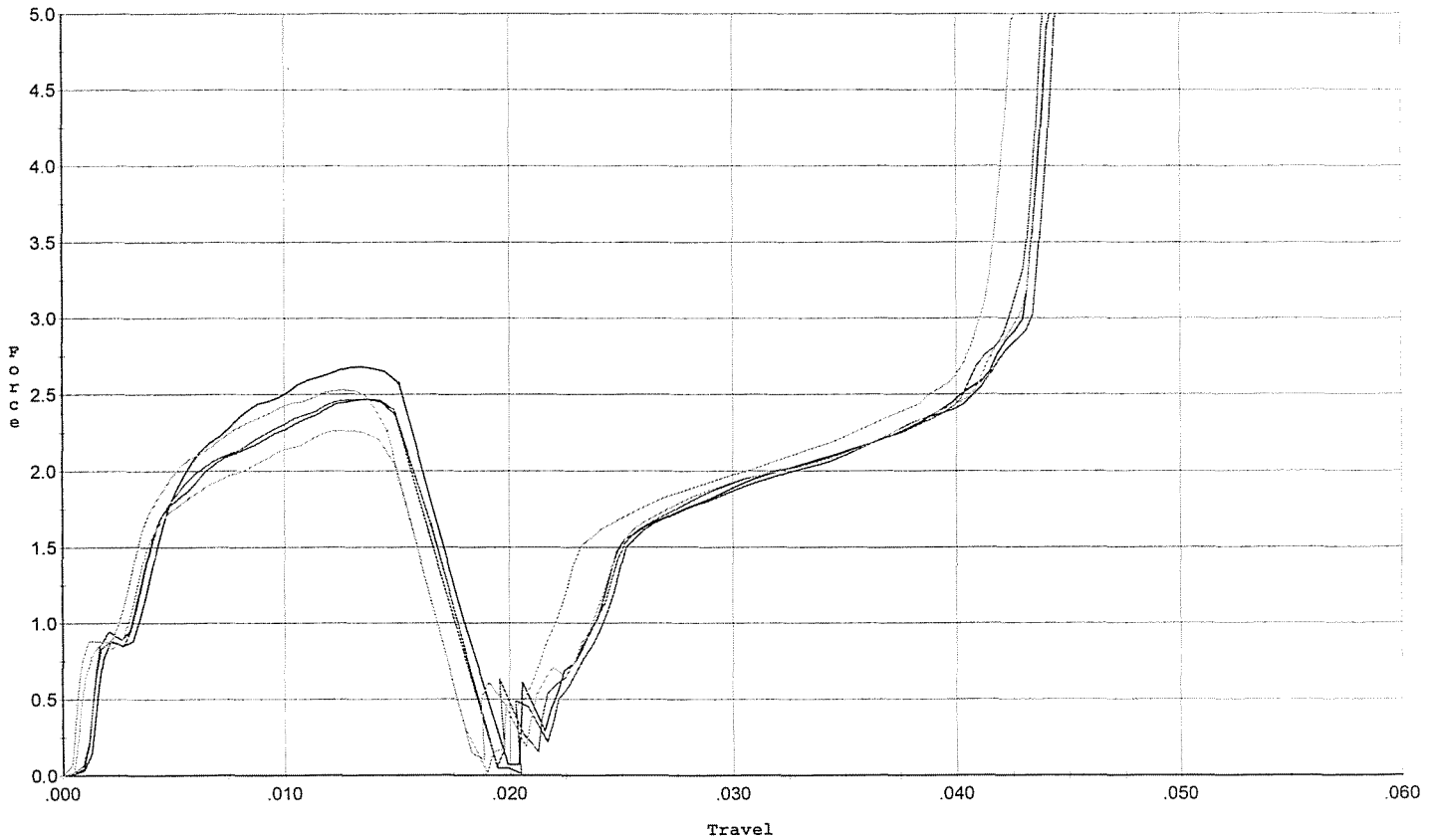
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.015	0.00	0.032	0.026		Set Trigger
2	2.311	0.015	0.004	0.032	0.023		Set Trigger
3	2.428	0.015	0.00	0.032	0.025		Set Trigger
4	2.401	0.015	0.00	0.032	0.025		Set Trigger
5	2.333	0.015	0.00	0.032	0.024		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



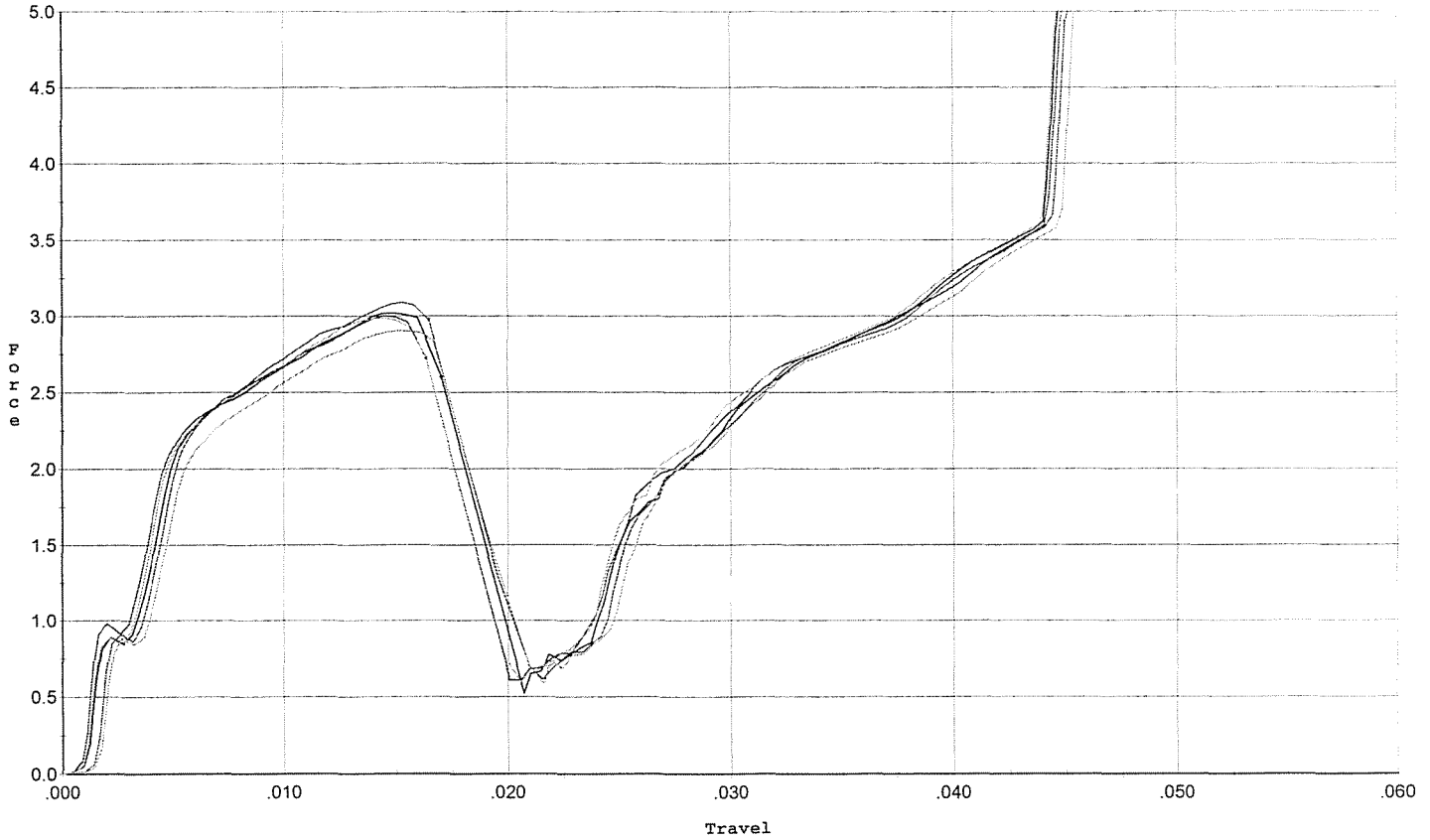
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.469	0.016	0.00	0.032	0.028		Set Trigger
2	2.680	0.015	0.00	0.032	0.027		Set Trigger
3	2.467	0.015	0.00	0.032	0.025		Set Trigger
4	2.265	0.015	0.00	0.033	0.024		Set Trigger
5	2.529	0.015	0.002	0.031	0.026		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



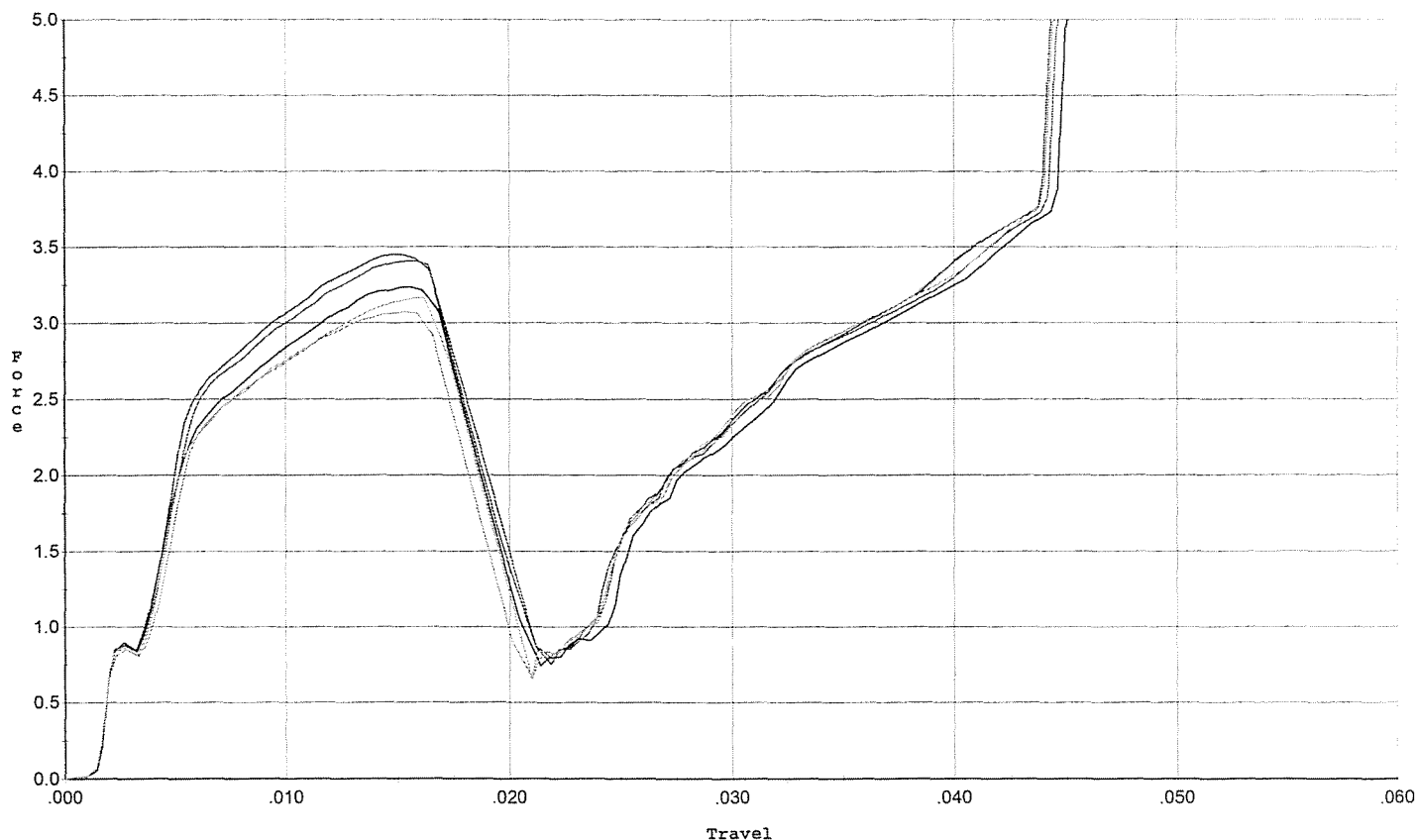
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.001	0.016	0.00	0.030	0.033		Set Trigger
2	3.019	0.017	0.00	0.030	0.034		Set Trigger
3	3.089	0.016	0.00	0.030	0.033		Set Trigger
4	2.987	0.016	0.00	0.030	0.033		Set Trigger
5	2.904	0.017	0.00	0.030	0.032		Set Trigger

A-3.00

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



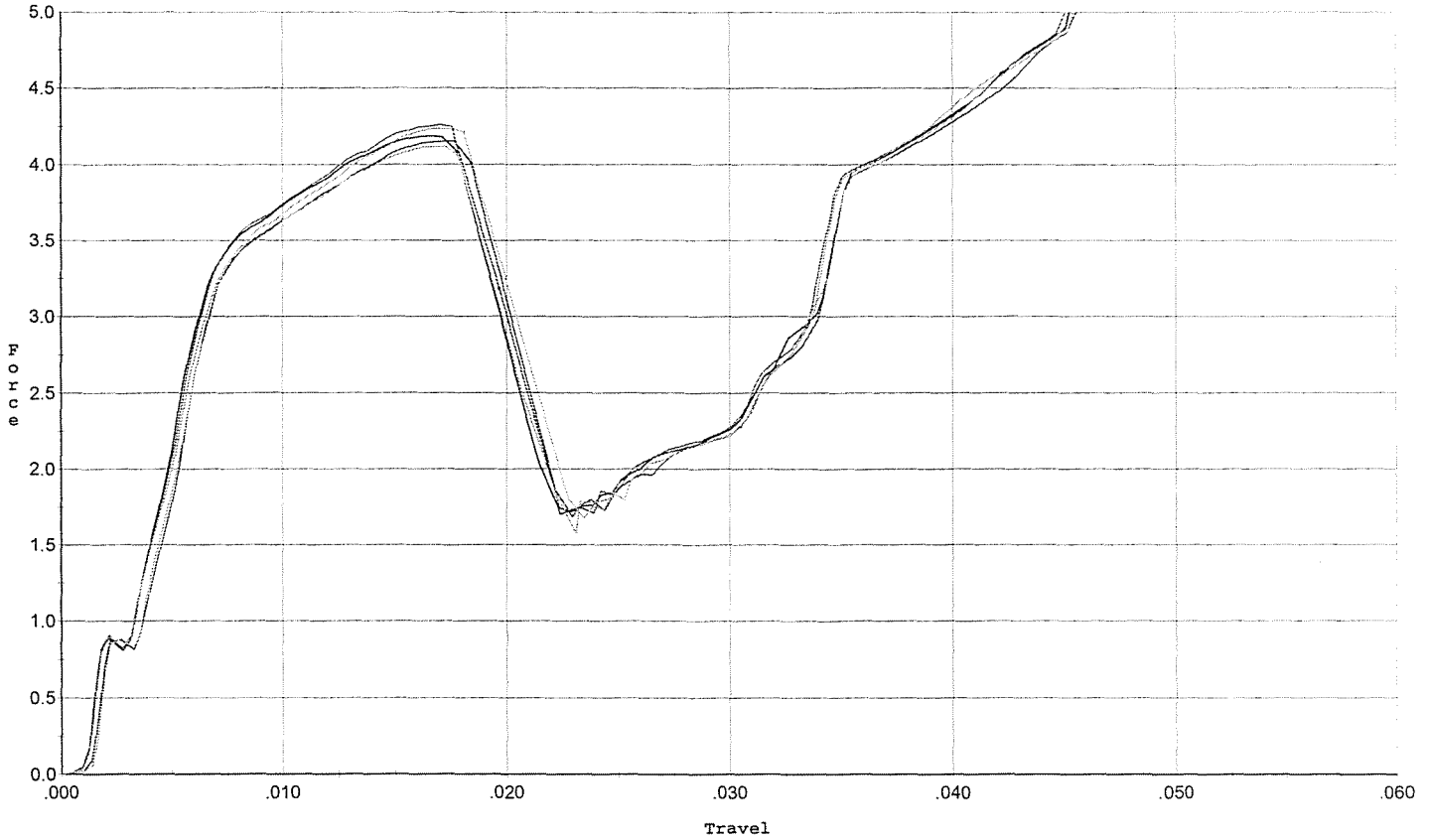
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.452	0.016	0.00	0.029	0.037		Set Trigger
2	3.234	0.017	0.00	0.030	0.035		Set Trigger
3	3.405	0.019	0.00	0.029	0.041		Set Trigger
4	3.162	0.017	0.00	0.029	0.035		Set Trigger
5	3.071	0.017	0.00	0.030	0.033		Set Trigger

A-3.26

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



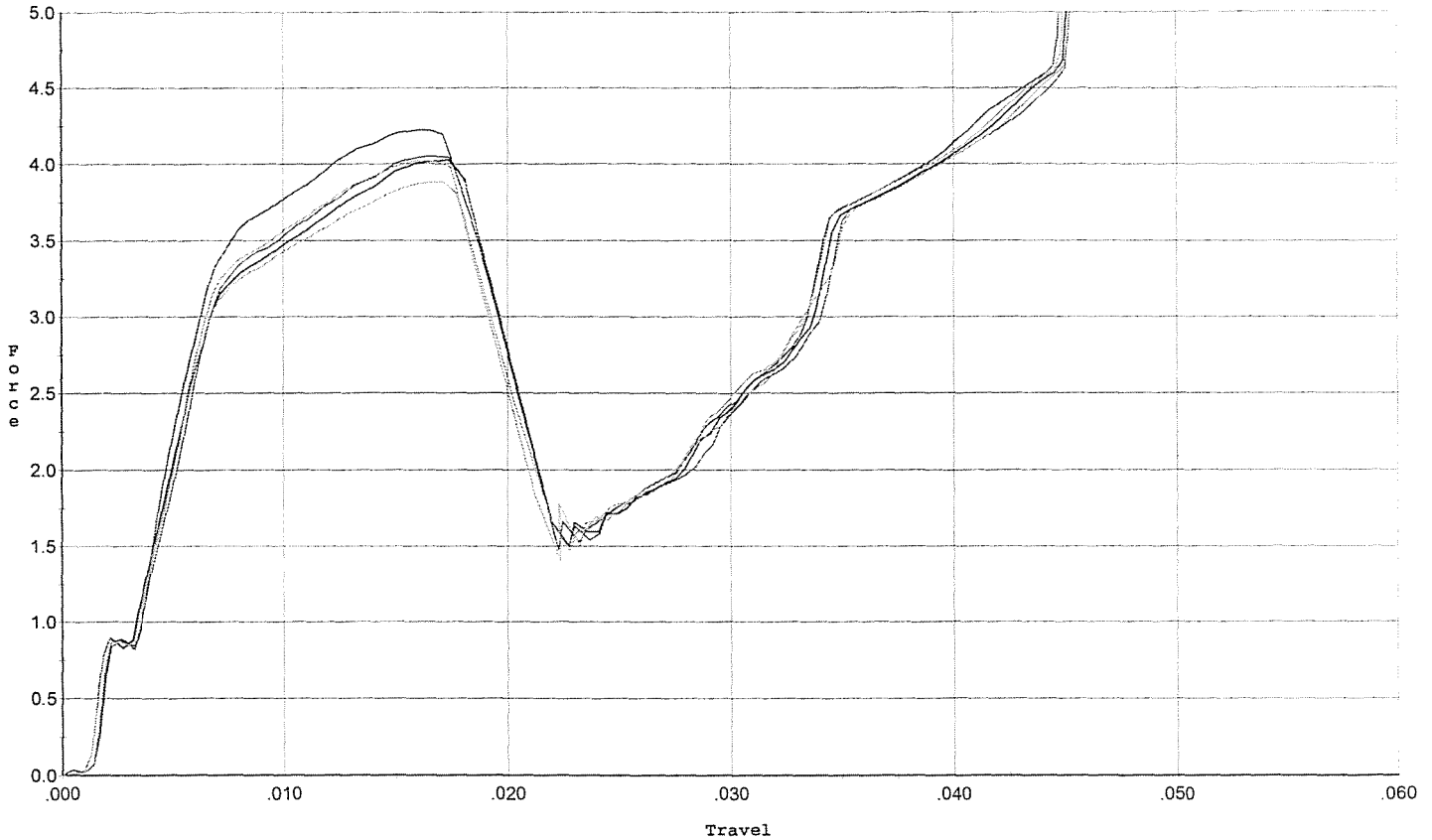
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.151	0.018	0.004	0.027	0.049		Set Trigger
2	4.185	0.018	0.00	0.028	0.049		Set Trigger
3	4.260	0.020	0.00	0.027	0.054		Set Trigger
4	4.235	0.018	0.00	0.027	0.049		Set Trigger
5	4.118	0.018	0.00	0.028	0.048		Set Trigger

A-4.19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



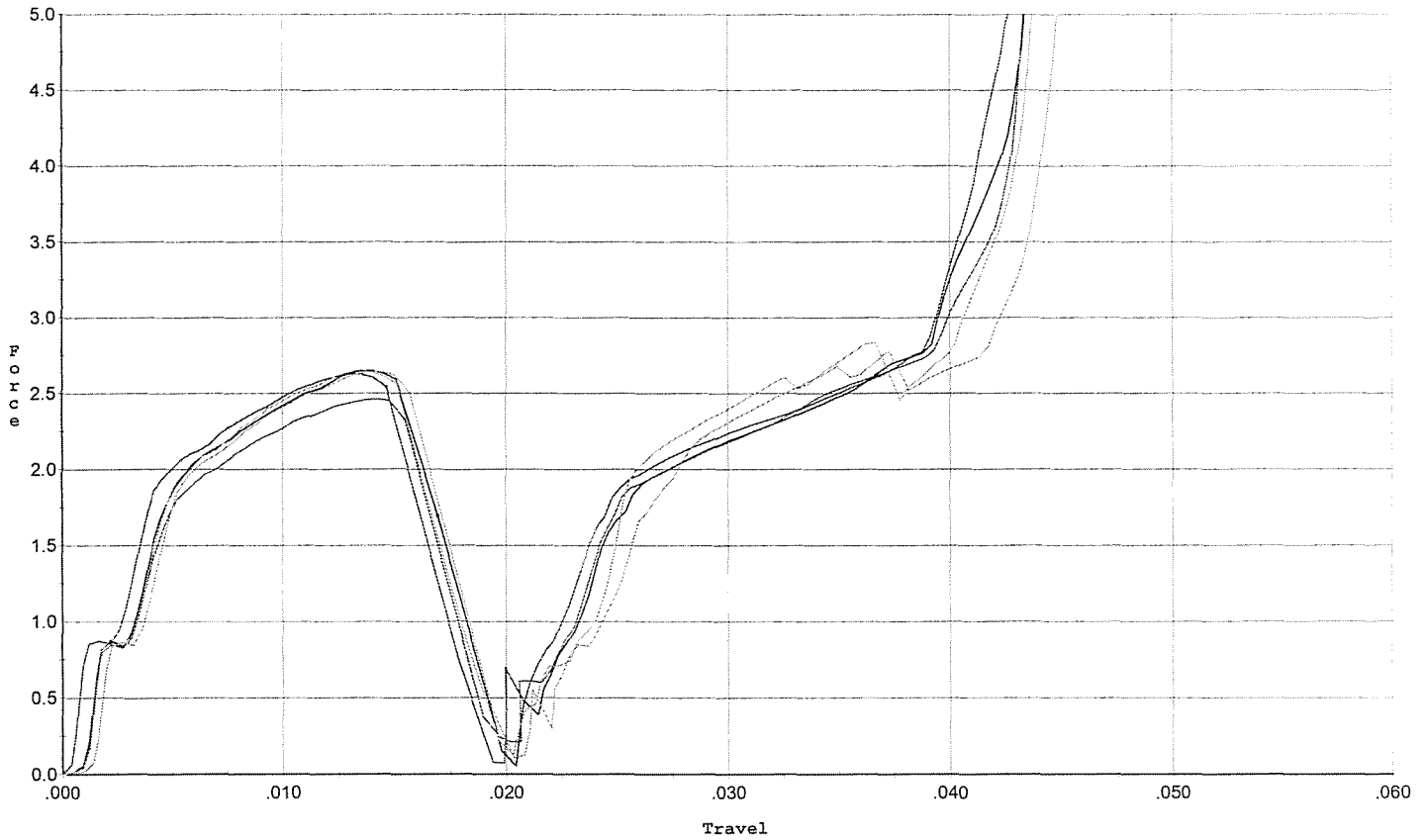
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.222	0.019	0.00	0.027	0.051		Set Trigger
2	4.025	0.018	0.00	0.028	0.047		Set Trigger
3	4.049	0.018	0.00	0.028	0.047		Set Trigger
4	3.885	0.018	0.00	0.028	0.045		Set Trigger
5	4.018	0.017	0.004	0.028	0.045		Set Trigger

A-4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



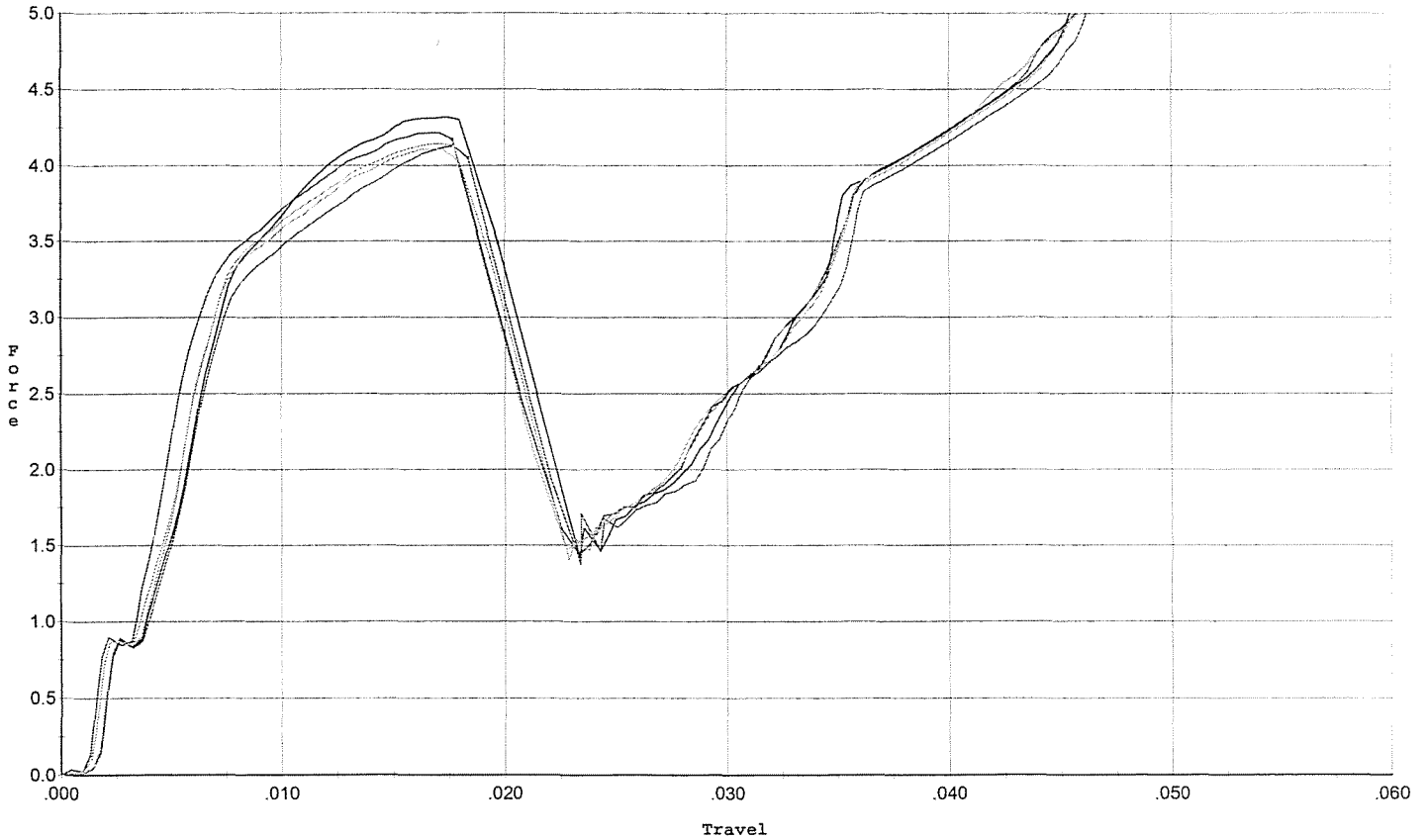
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.628	0.015	0.00	0.031	0.027		Set Trigger
2	2.650	0.017	0.00	0.030	0.030		Set Trigger
3	2.464	0.015	0.00	0.031	0.026		Set Trigger
4	2.653	0.015	0.00	0.031	0.027		Set Trigger
5	2.646	0.016	0.00	0.031	0.028		Set Trigger

A-2-60

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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	4.211	0.018	0.00	0.028	0.048		Set Trigger
2	4.318	0.020	0.00	0.028	0.053		Set Trigger
3	4.124	0.018	0.00	0.029	0.047		Set Trigger
4	4.108	0.018	0.004	0.028	0.047		Set Trigger
5	4.144	0.019	0.00	0.028	0.051		Set Trigger

A-4.18