

66801460

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



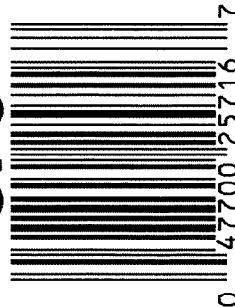
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801460

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801460

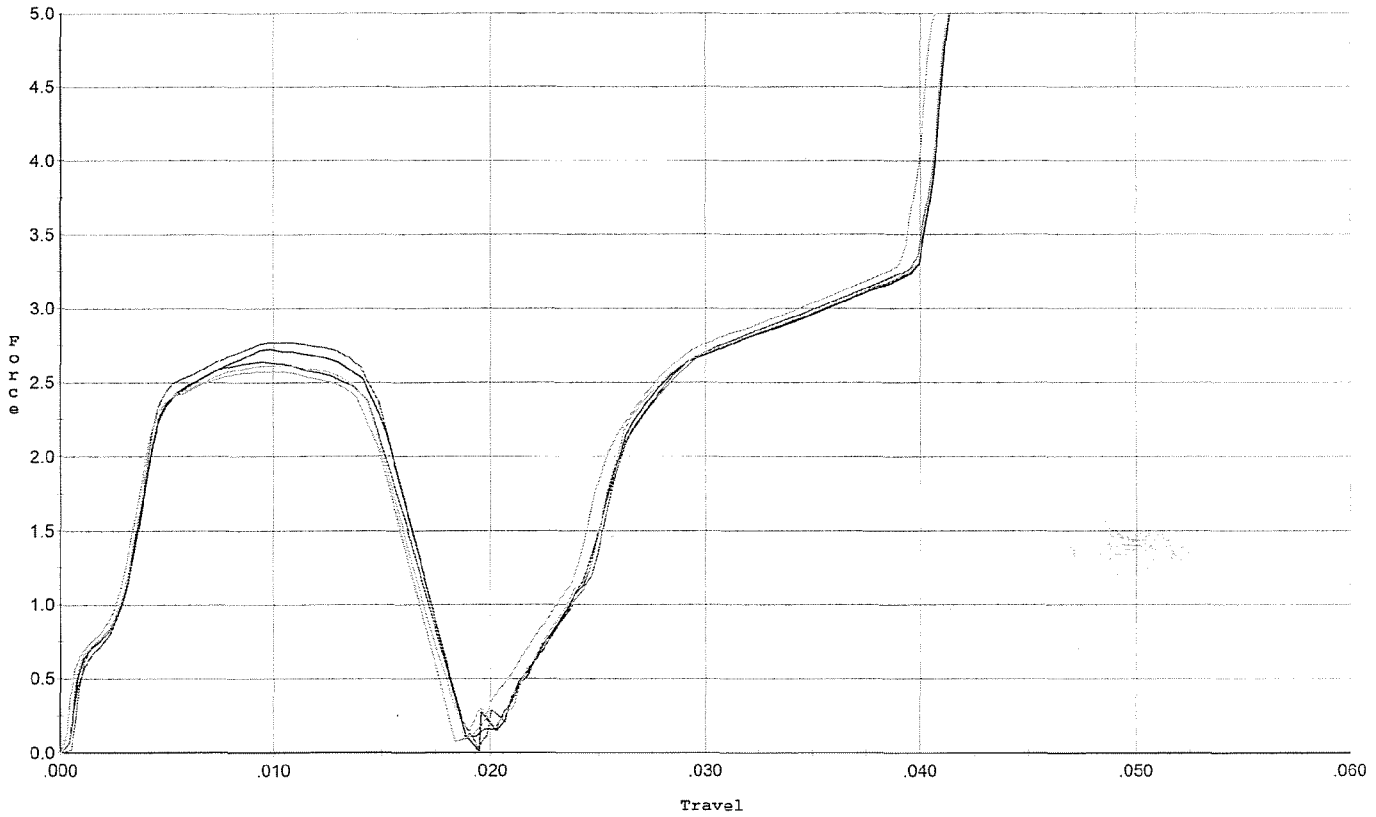
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE	MAG VA - FLUX	3-6-09	RT
475	DRILL AND TAP SIGHT HOLES	CHAM 0.0003	3-6-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	3/9/09	(A)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	RM
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIALS
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>5.5</u>	3-26-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3</u>	3-26-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-26-09	WV
	J) ASSEMBLE STOCK		3-24-09	2.9.
	K) ASSEMBLE SWIVEL STUDS		3-26-09	WV
	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	3-25-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-26-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.59</u> <u>2.56</u> <u>2.58</u> <u>2.61</u>	3-25-09	TC
	C) FUNCTION		3-26-09	WV
690	PACK		3-27-09	FM

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



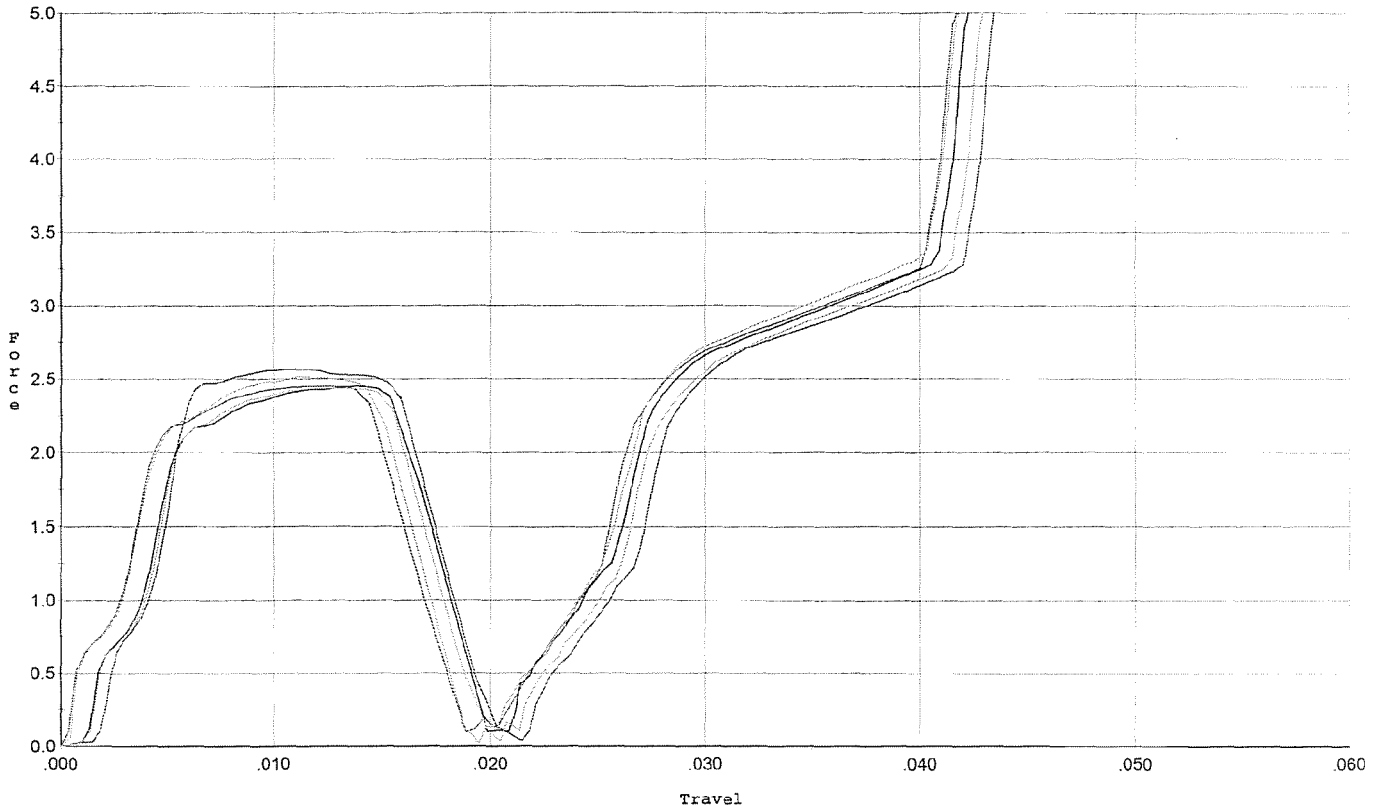
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.639	0.016	0.00	0.029	0.031		Set Trigger
2	2.726	0.015	0.00	0.029	0.030		Set Trigger
3	2.768	0.015	0.00	0.029	0.030		Set Trigger
4	2.614	0.014	0.00	0.029	0.028		Set Trigger
5	2.572	0.015	0.00	0.029	0.028		Set Trigger

A-2-66

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



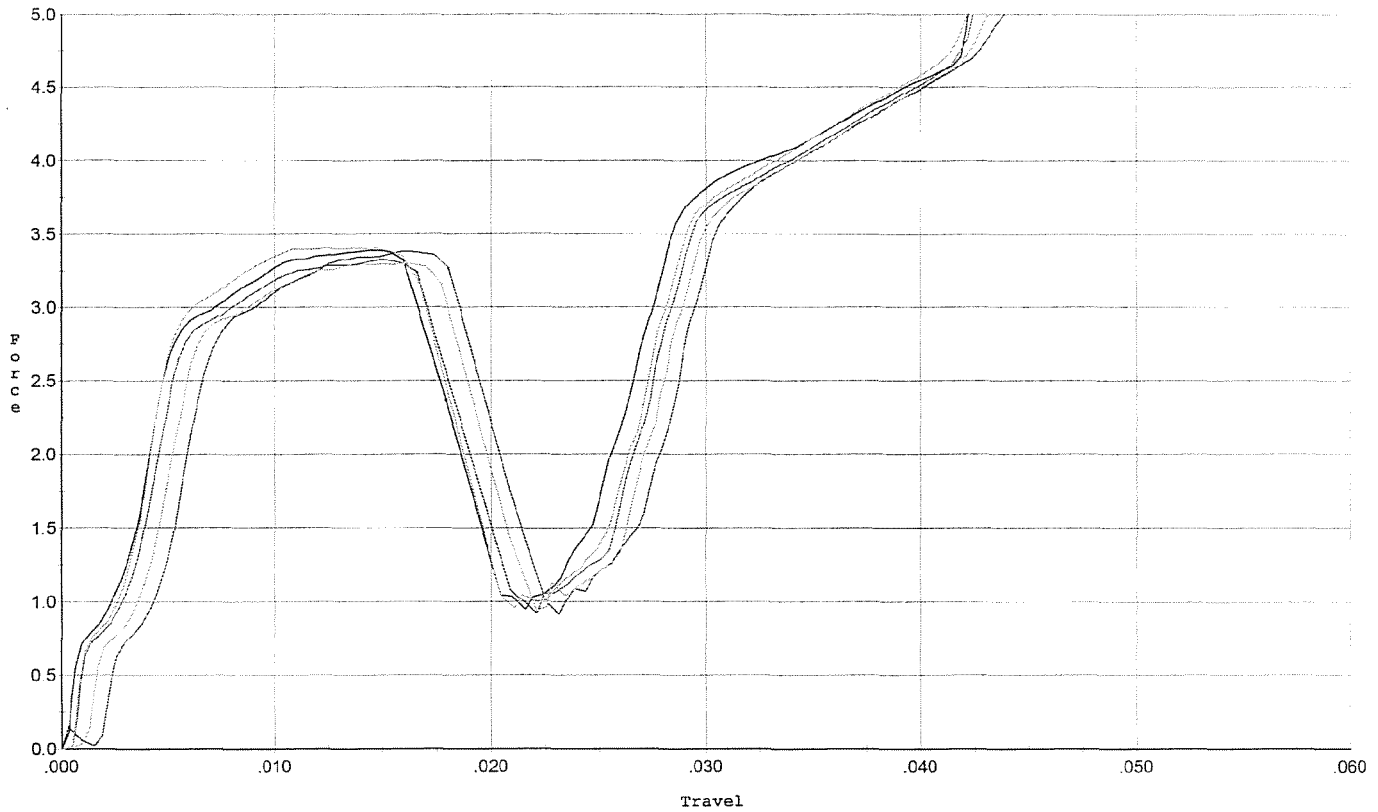
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.568	0.016	0.00	0.030	0.028		Set Trigger
2	2.452	0.017	0.00	0.029	0.029		Set Trigger
3	2.450	0.014	0.00	0.029	0.026		Set Trigger
4	2.436	0.016	0.00	0.030	0.026		Set Trigger
5	2.518	0.015	0.00	0.029	0.028		Set Trigger

A-2.48

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

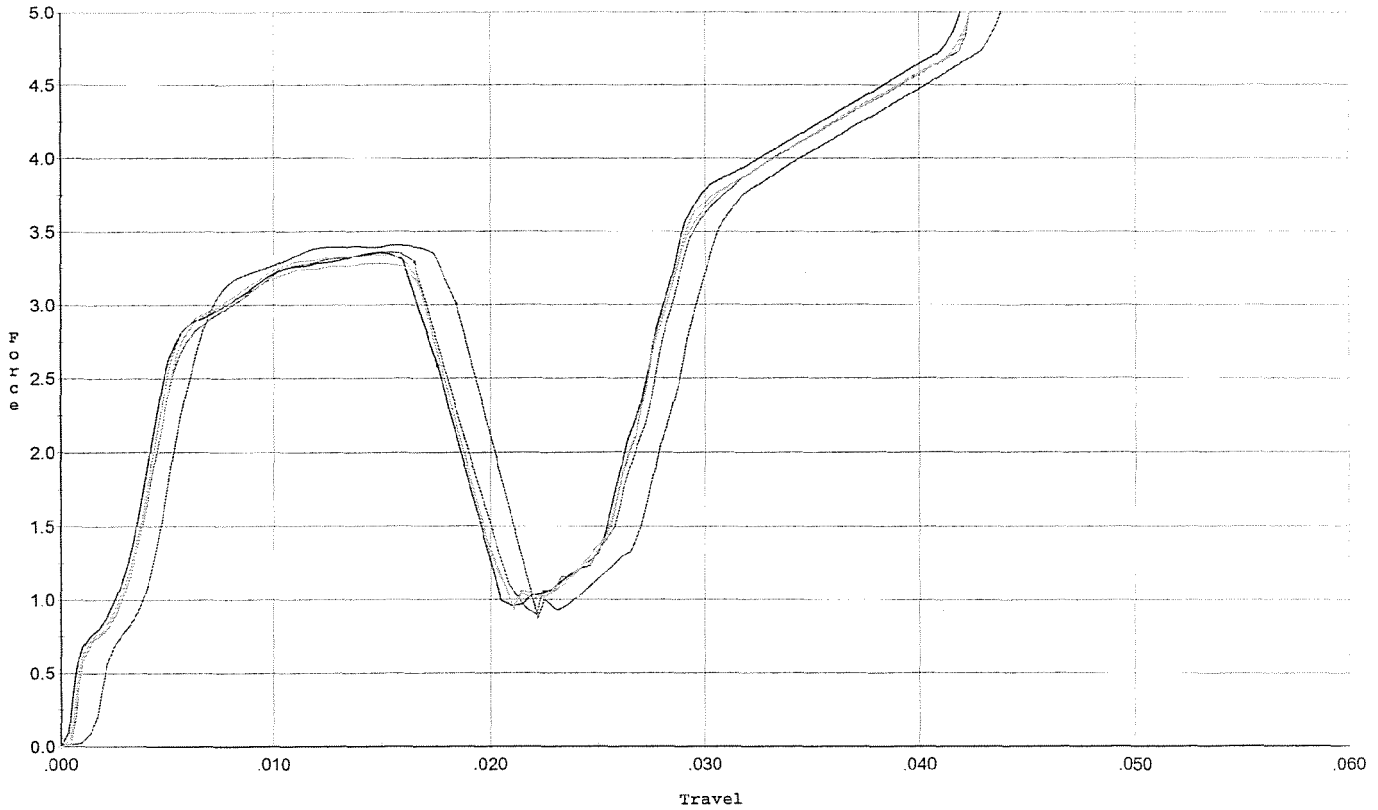


A-336

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 50 cycles+/- .75 lb



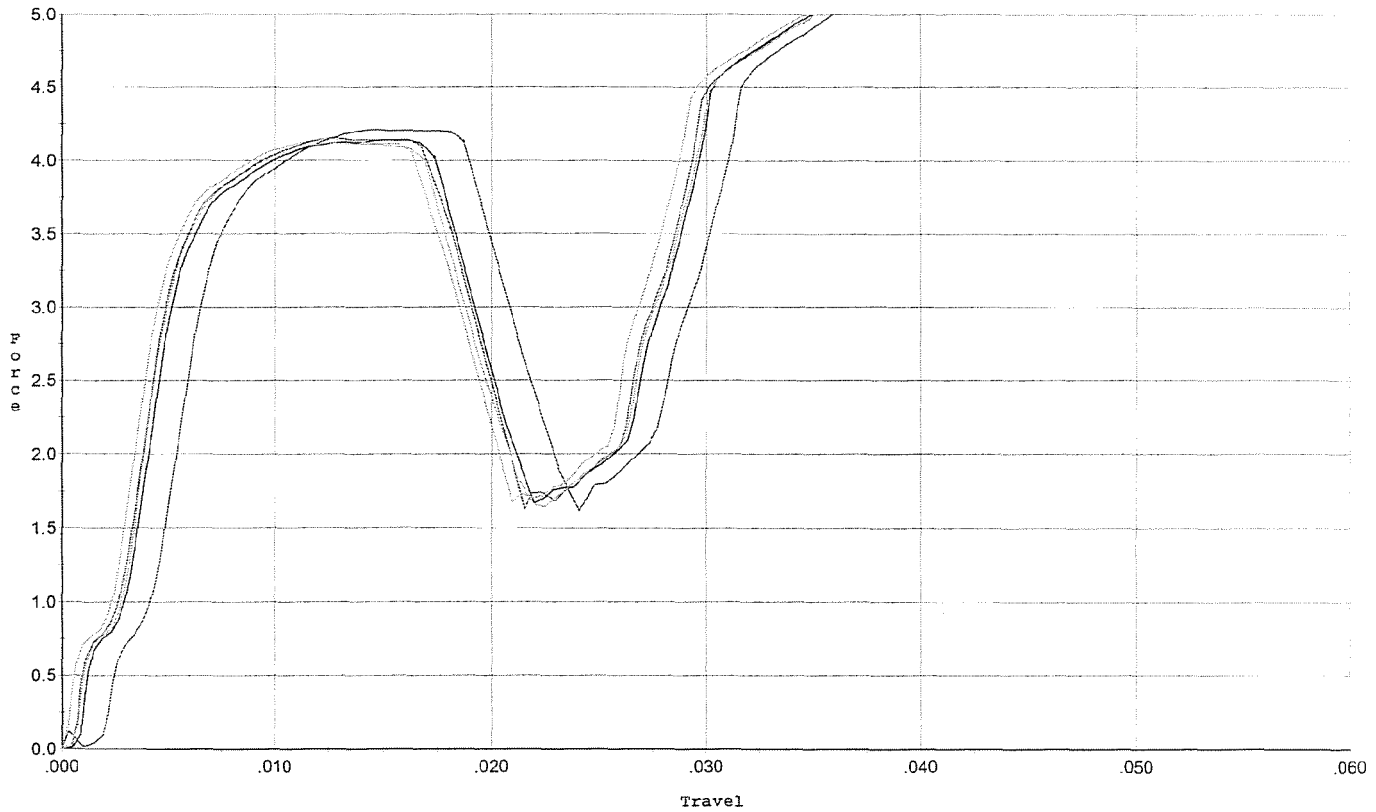
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.407	0.018	0.00	0.028	0.043		Set Trigger
2	3.357	0.018	0.00	0.027	0.042		Set Trigger
3	3.361	0.016	0.00	0.027	0.039		Set Trigger
4	3.341	0.017	0.00	0.027	0.039		Set Trigger
5	3.282	0.017	0.00	0.027	0.039		Set Trigger

A-3-35-

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



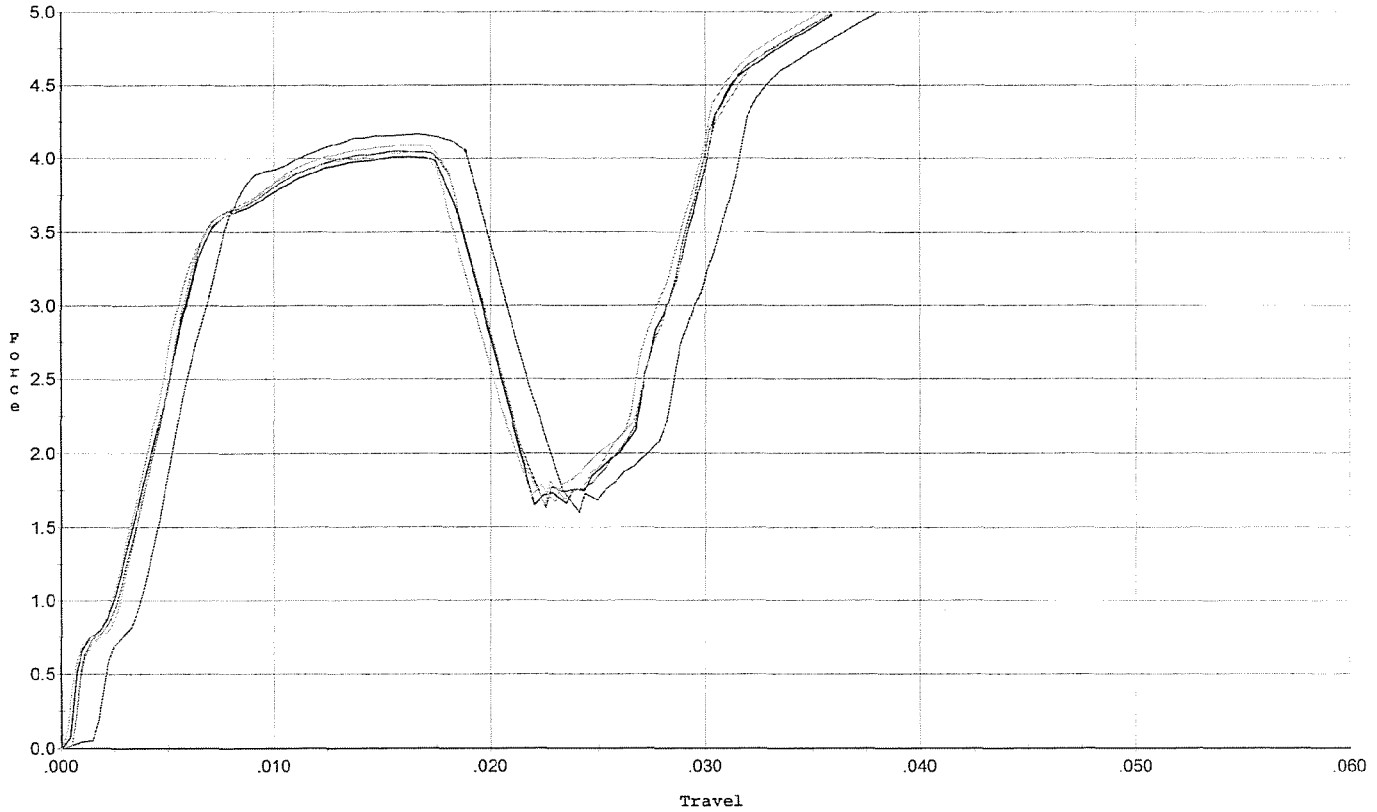
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.211	0.019	0.00	0.025	0.052		Set Trigger
2	4.139	0.017	0.00	0.025	0.050		Set Trigger
3	4.156	0.018	0.00	0.025	0.053		Set Trigger
4	4.148	0.018	0.00	0.025	0.053		Set Trigger
5	4.123	0.017	0.00	0.025	0.049		Set Trigger

At 4.15

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



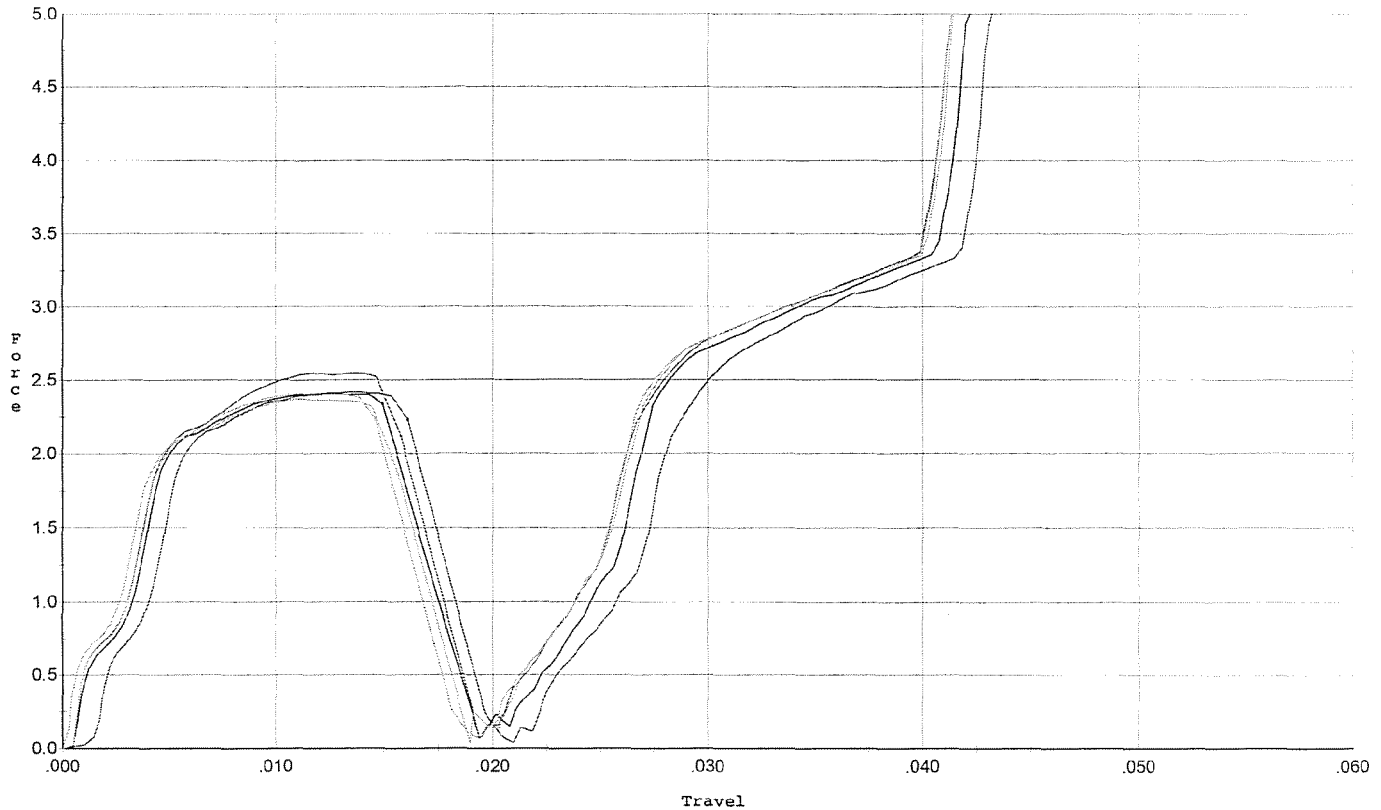
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.019	0.00	0.026	0.052		Set Trigger
2	4.009	0.018	0.00	0.026	0.052		Set Trigger
3	4.048	0.018	0.00	0.026	0.051		Set Trigger
4	4.042	0.018	0.00	0.025	0.049		Set Trigger
5	4.092	0.018	0.00	0.025	0.051		Set Trigger

A-4.07

Trigger Profile [lbs,inch]

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

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



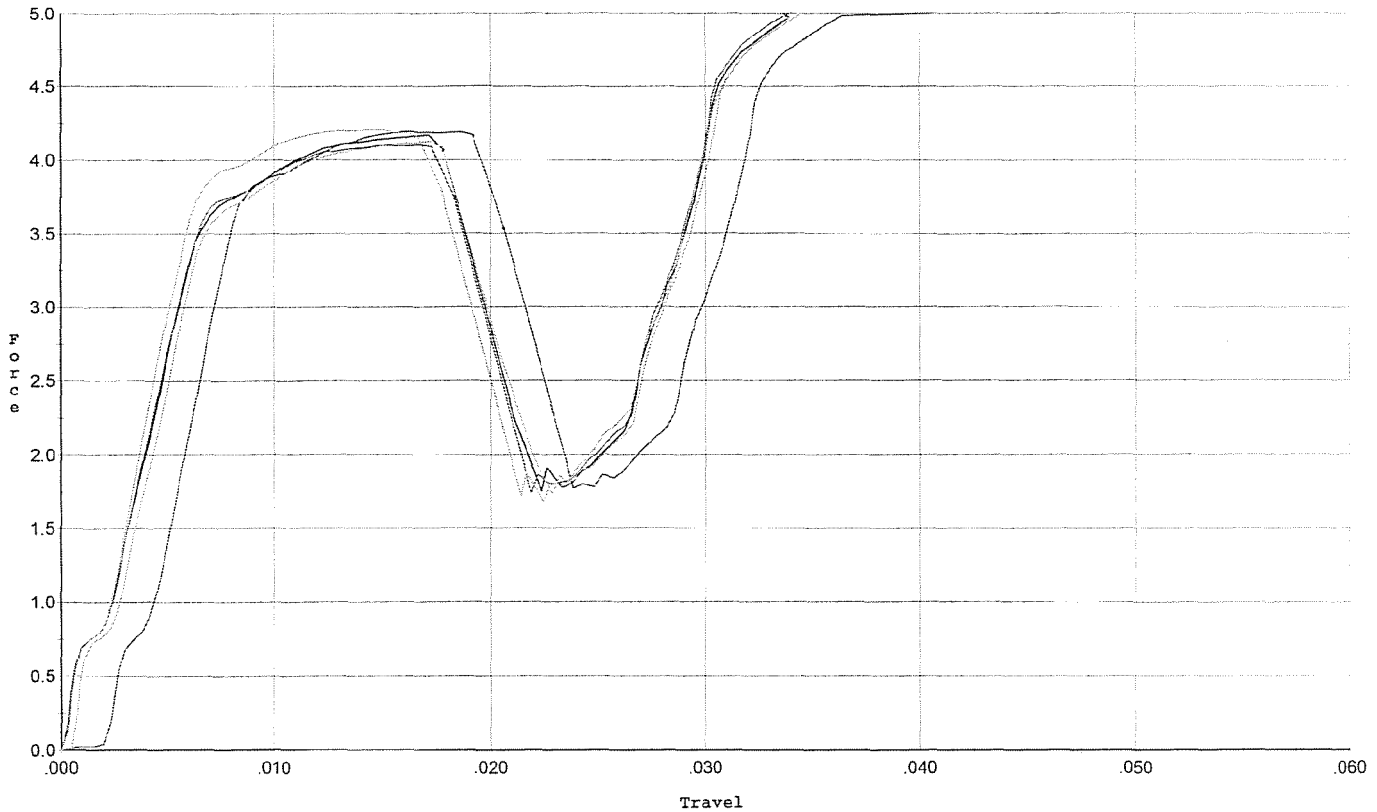
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.419	0.016	0.00	0.030	0.027		Set Trigger
2	2.407	0.015	0.00	0.029	0.026		Set Trigger
3	2.547	0.016	0.00	0.029	0.029		Set Trigger
4	2.372	0.016	0.00	0.029	0.027		Set Trigger
5	2.406	0.015	0.00	0.029	0.026		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: 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	4.191	0.021	0.00	0.026	0.056		Set Trigger
2	4.166	0.018	0.00	0.025	0.052		Set Trigger
3	4.098	0.018	0.00	0.025	0.053		Set Trigger
4	4.124	0.018	0.00	0.025	0.050		Set Trigger
5	4.209	0.018	0.00	0.025	0.053		Set Trigger

A-4.15