

676801471

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



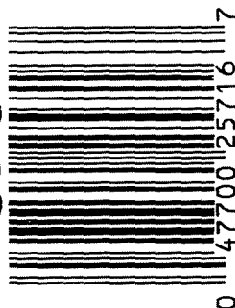
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801471

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801471

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-9-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-9-09	JP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/13/09	
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BJ
542	APPLY COATINGS (BARREL ACTION)		3/14	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

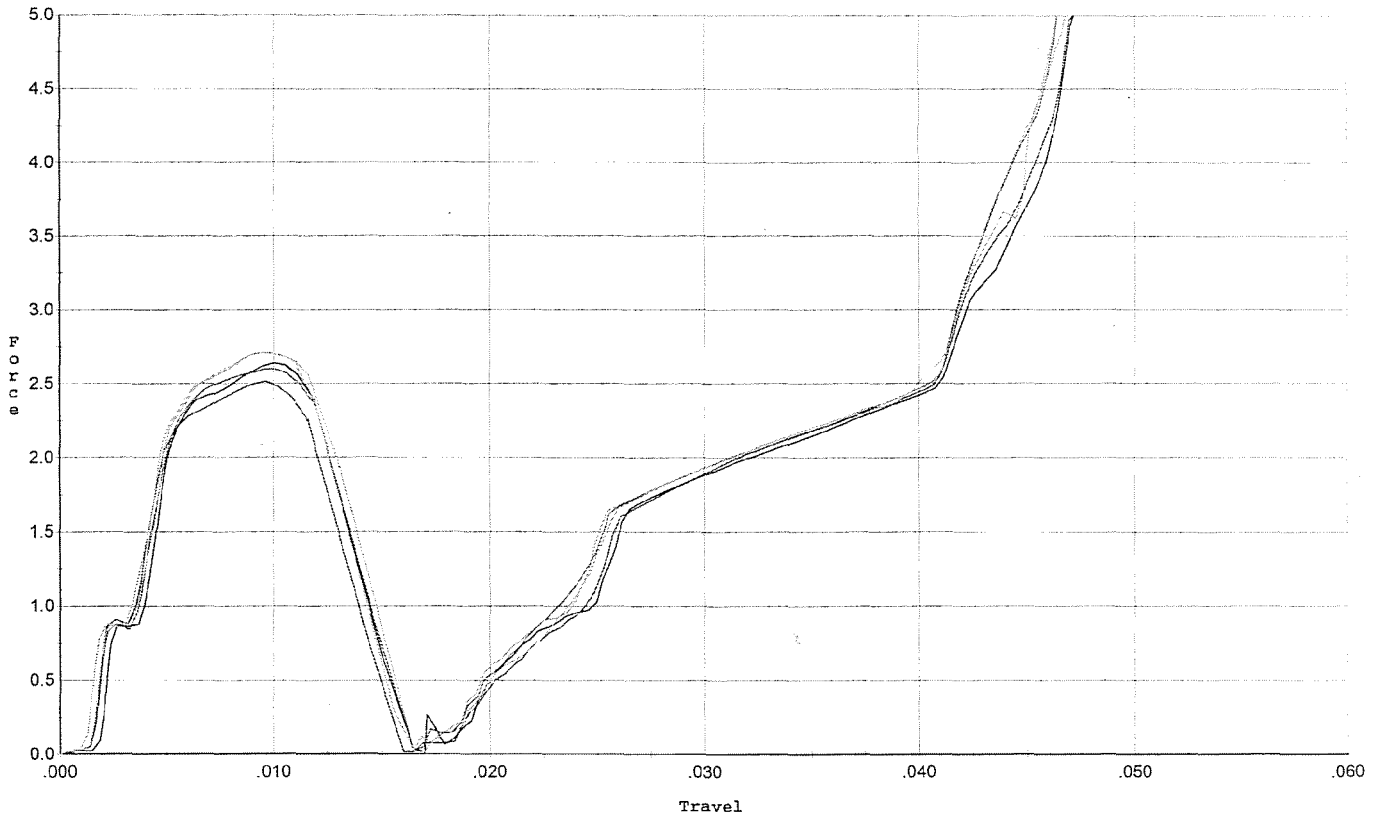
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	3-30-09	L. W.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	3-30-09	L. W.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-30-09	R. W.
	J) ASSEMBLE STOCK		3-25-09	L. W.
	K) ASSEMBLE SWIVEL STUDS		3-30-09	L. W.
	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	3-27-09	TC
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	
670	FINAL INSPECTION A) HEADSPACE		3-30-09	L. W.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.31</u> <u>2.41</u> <u>2.41</u> <u>2.34</u>	3-30-09	TC
	C) FUNCTION		3-30-09	L. W.
690	PACK		3/31/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



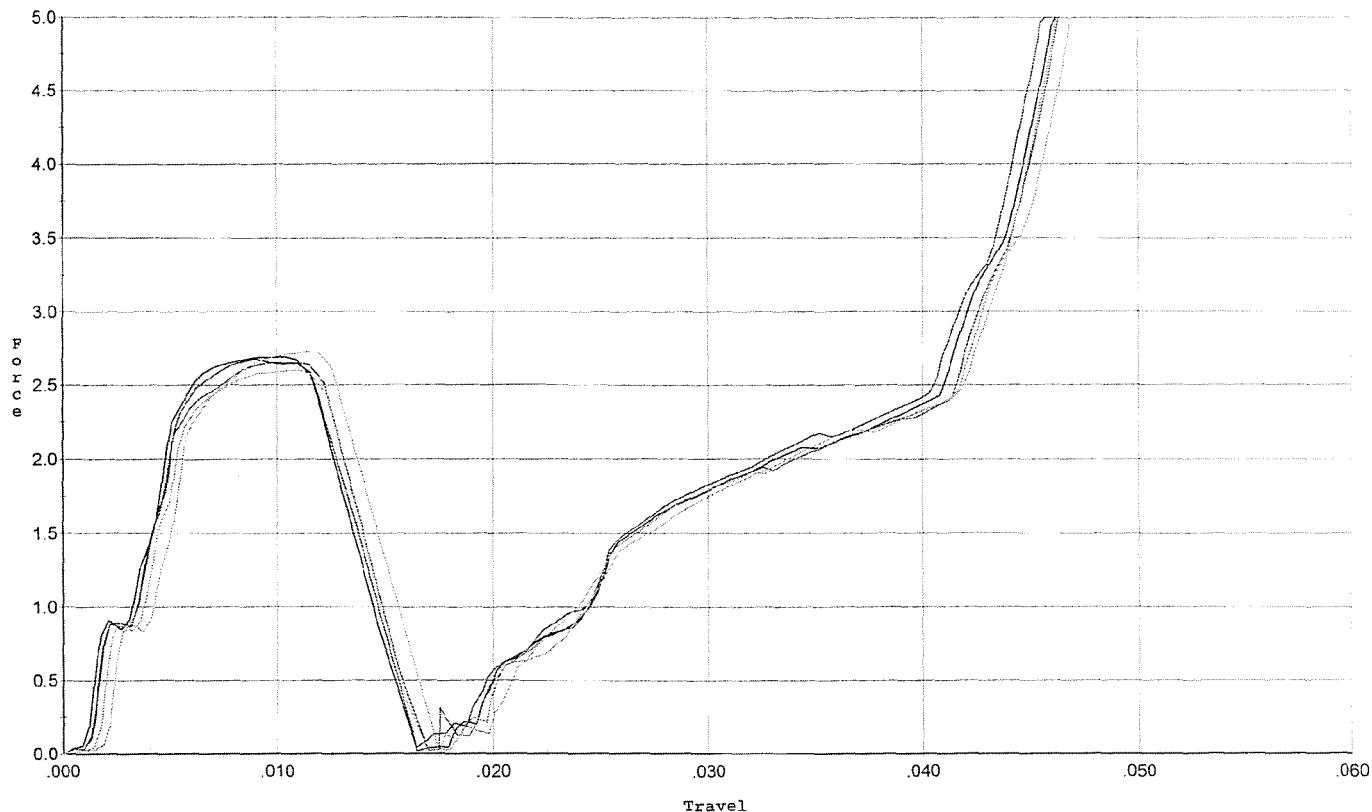
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.012	0.00	0.038	0.019		Set Trigger
2	2.640	0.012	0.00	0.038	0.019		Set Trigger
3	2.601	0.012	0.00	0.037	0.020		Set Trigger
4	2.710	0.012	0.00	0.038	0.021		Set Trigger
5	2.711	0.013	0.00	0.037	0.022		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



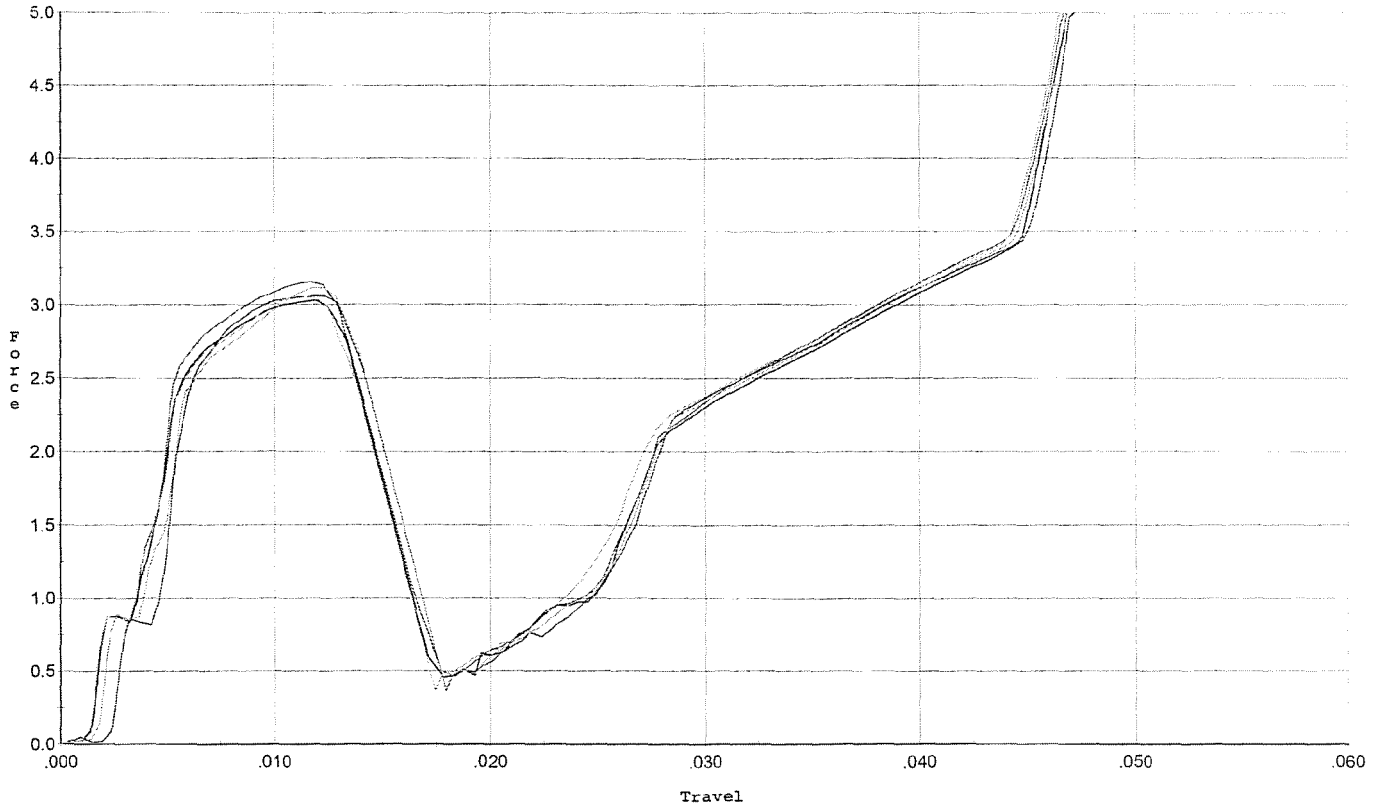
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.676	0.014	0.00	0.037	0.023		Set Trigger
2	2.693	0.012	0.00	0.038	0.020		Set Trigger
3	2.655	0.012	0.003	0.037	0.021		Set Trigger
4	2.601	0.012	0.00	0.038	0.020		Set Trigger
5	2.729	0.015	0.00	0.036	0.025		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



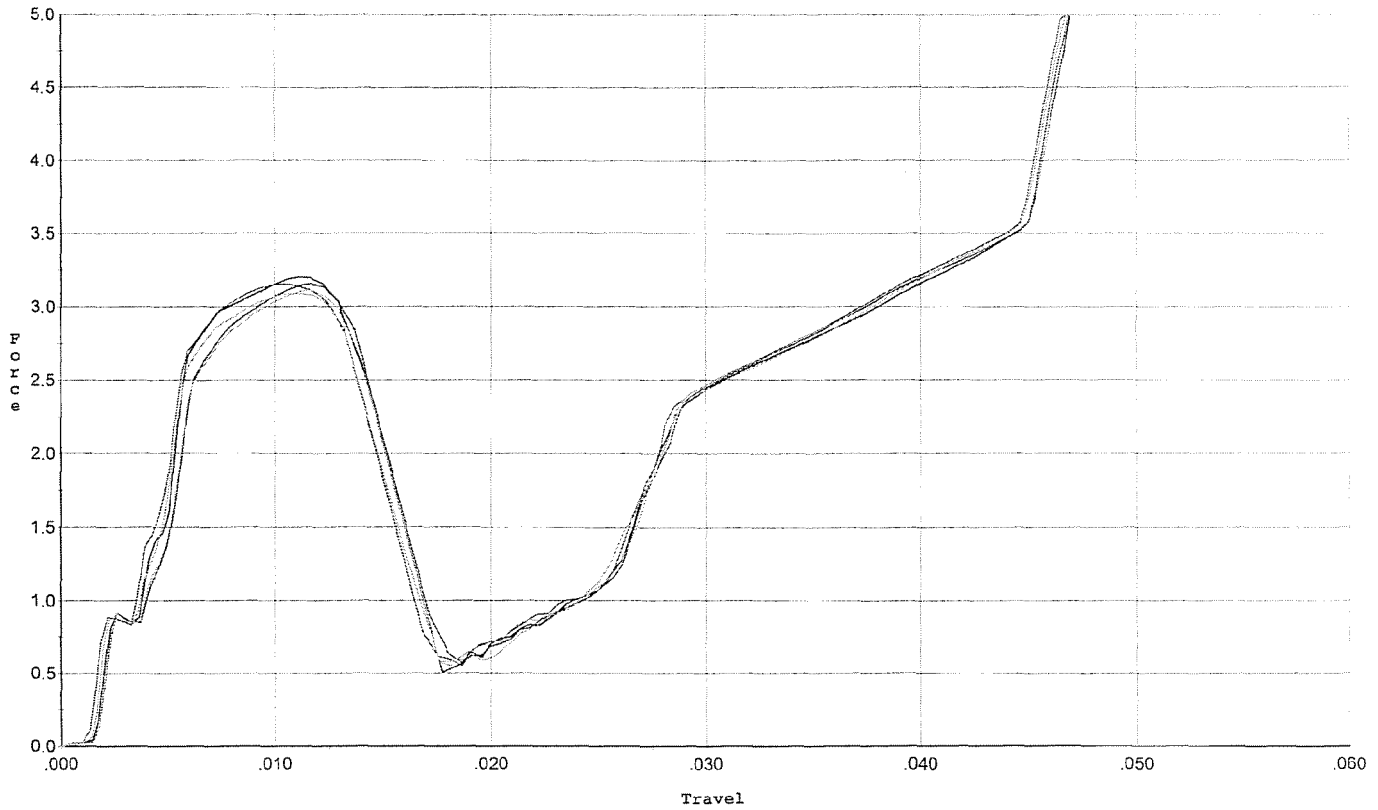
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.014	0.005	0.035	0.026		Set Trigger
2	3.029	0.013	0.004	0.035	0.026		Set Trigger
3	3.155	0.013	0.004	0.035	0.026		Set Trigger
4	3.057	0.014	0.003	0.035	0.026		Set Trigger
5	3.118	0.014	0.00	0.035	0.026		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



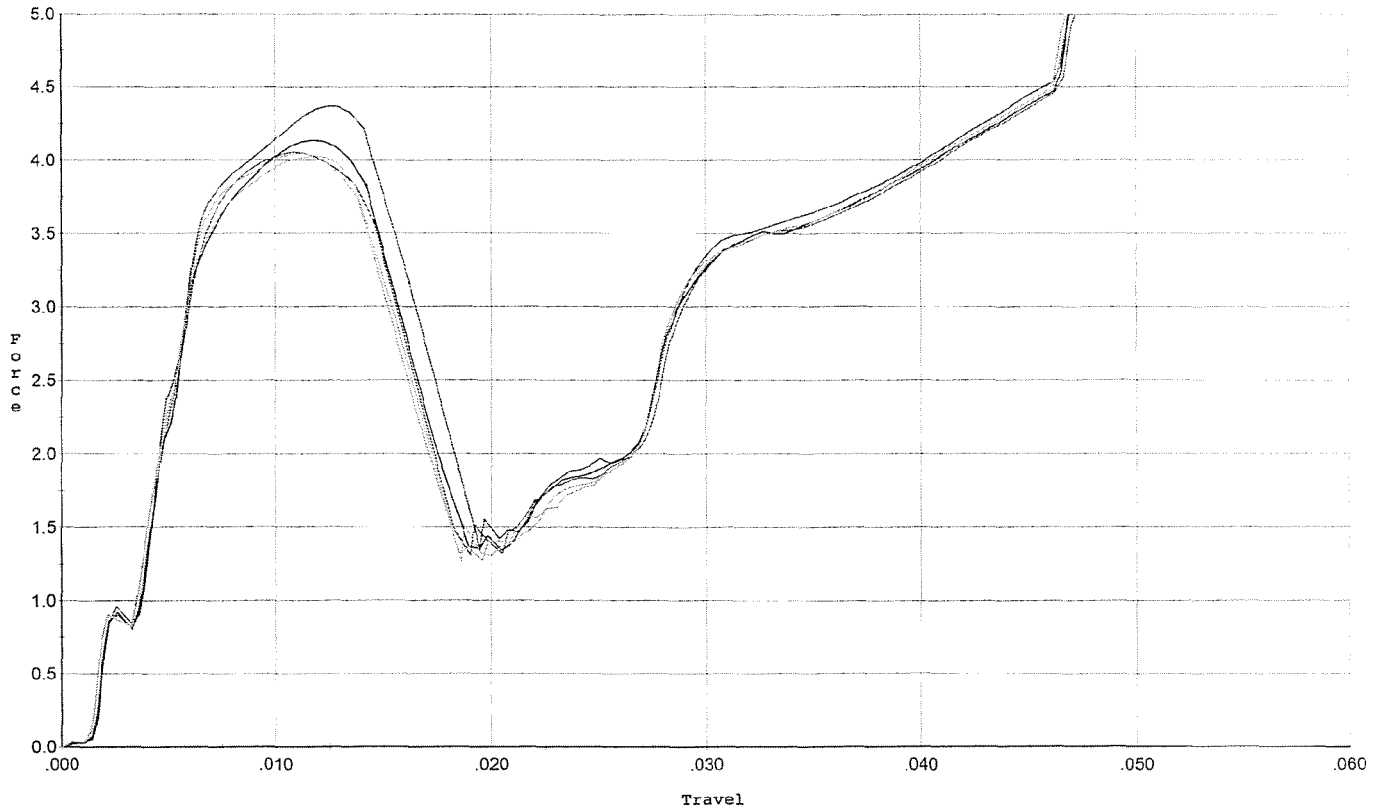
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.156	0.014	0.004	0.035	0.026		Set Trigger
2	3.202	0.014	0.00	0.035	0.028		Set Trigger
3	3.155	0.013	0.004	0.035	0.026		Set Trigger
4	3.109	0.014	0.00	0.035	0.026		Set Trigger
5	3.088	0.013	0.00	0.035	0.025		Set Trigger

A-3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



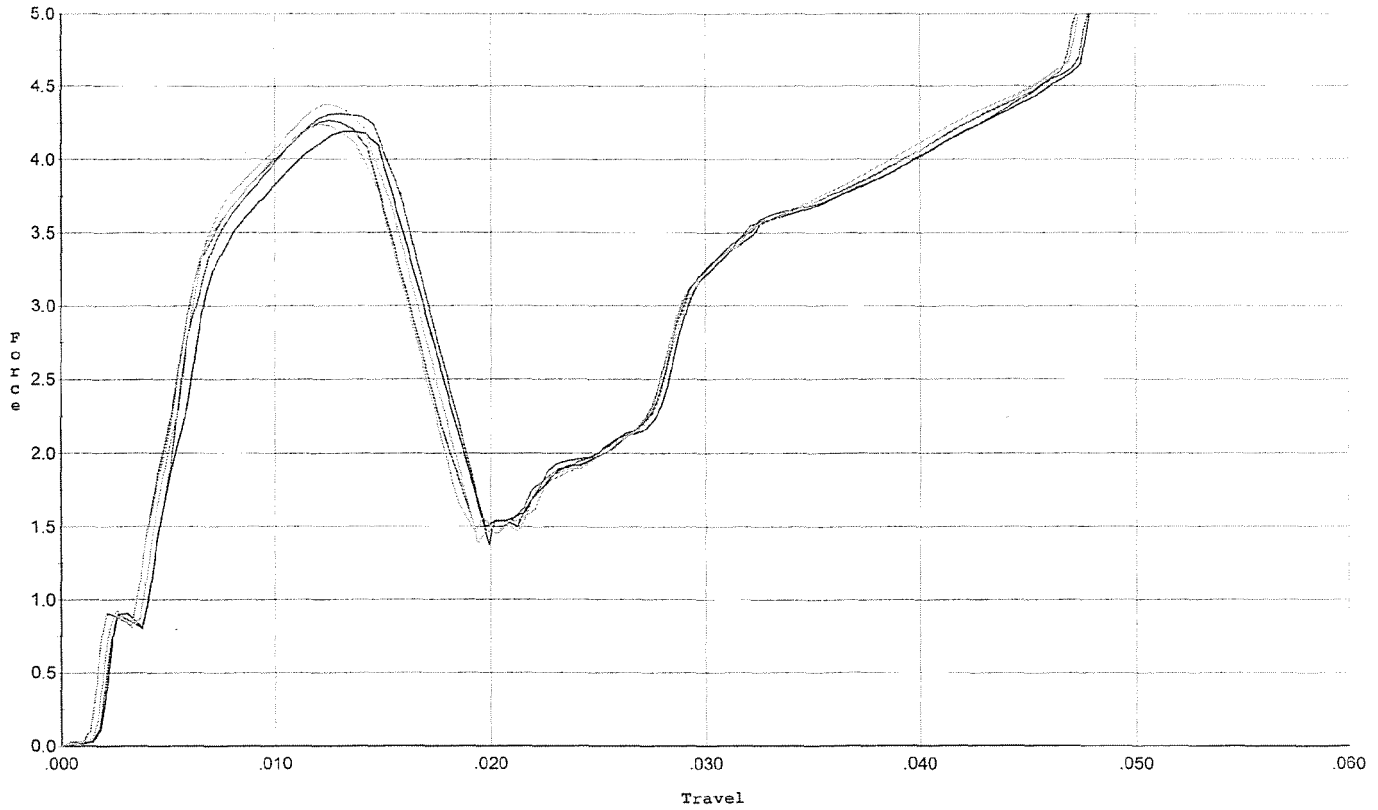
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.367	0.016	0.00	0.031	0.043		Set Trigger
2	4.135	0.014	0.00	0.032	0.036		Set Trigger
3	4.055	0.015	0.00	0.032	0.036		Set Trigger
4	4.028	0.016	0.004	0.032	0.039		Set Trigger
5	4.046	0.014	0.003	0.032	0.035		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schuits 3/13/2009

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



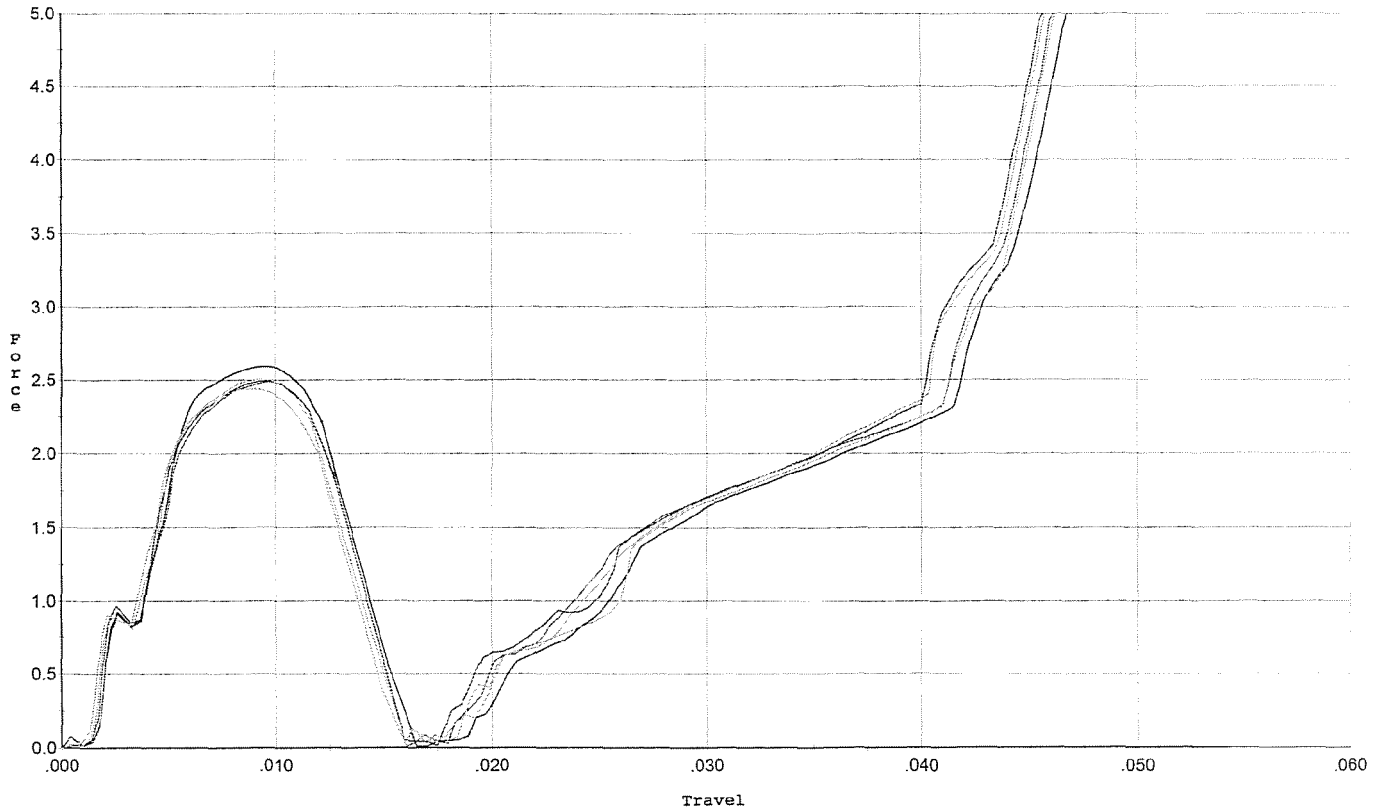
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.312	0.016	0.004	0.031	0.041		Set Trigger
2	4.185	0.017	0.004	0.031	0.043		Set Trigger
3	4.264	0.014	0.004	0.032	0.037		Set Trigger
4	4.375	0.015	0.00	0.031	0.040		Set Trigger
5	4.239	0.015	0.003	0.032	0.038		Set Trigger

A-4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



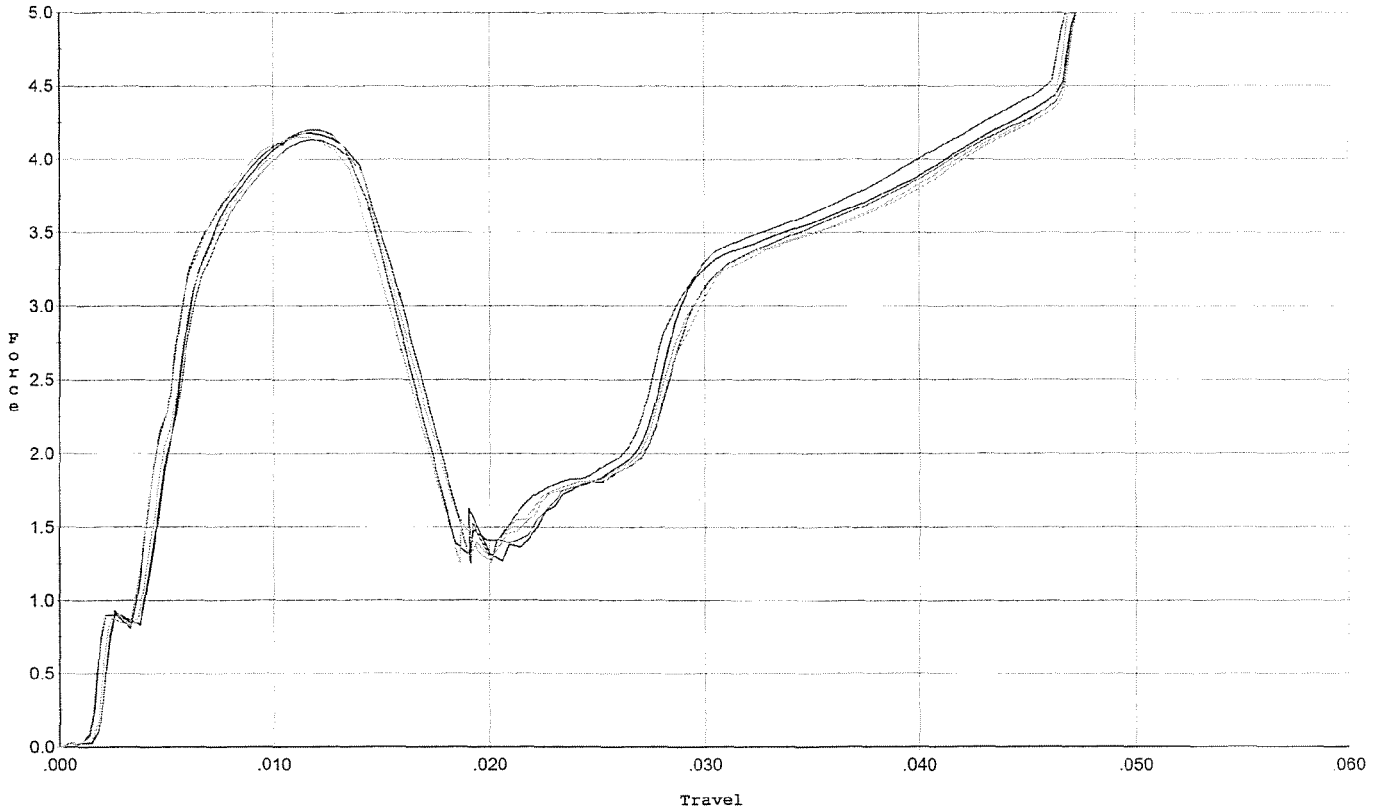
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.013	0.00	0.037	0.020		Set Trigger
2	2.591	0.012	0.00	0.038	0.019		Set Trigger
3	2.487	0.013	0.00	0.038	0.019		Set Trigger
4	2.439	0.012	0.003	0.038	0.019		Set Trigger
5	2.505	0.012	0.00	0.038	0.018		Set Trigger

A-2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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	4.205	0.014	0.004	0.032	0.037		Set Trigger
2	4.180	0.016	0.004	0.032	0.039		Set Trigger
3	4.133	0.016	0.004	0.032	0.039		Set Trigger
4	4.190	0.014	0.00	0.032	0.035		Set Trigger
5	4.153	0.016	0.003	0.032	0.040		Set Trigger

A - 4.17