

56801493

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



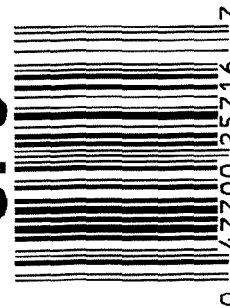
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801493

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6801493

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	TE
460	CHECK HEADSPACE		3-6-09	TE
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES	TIME 20 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	3/13/09	(D)
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		5/24	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-26-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

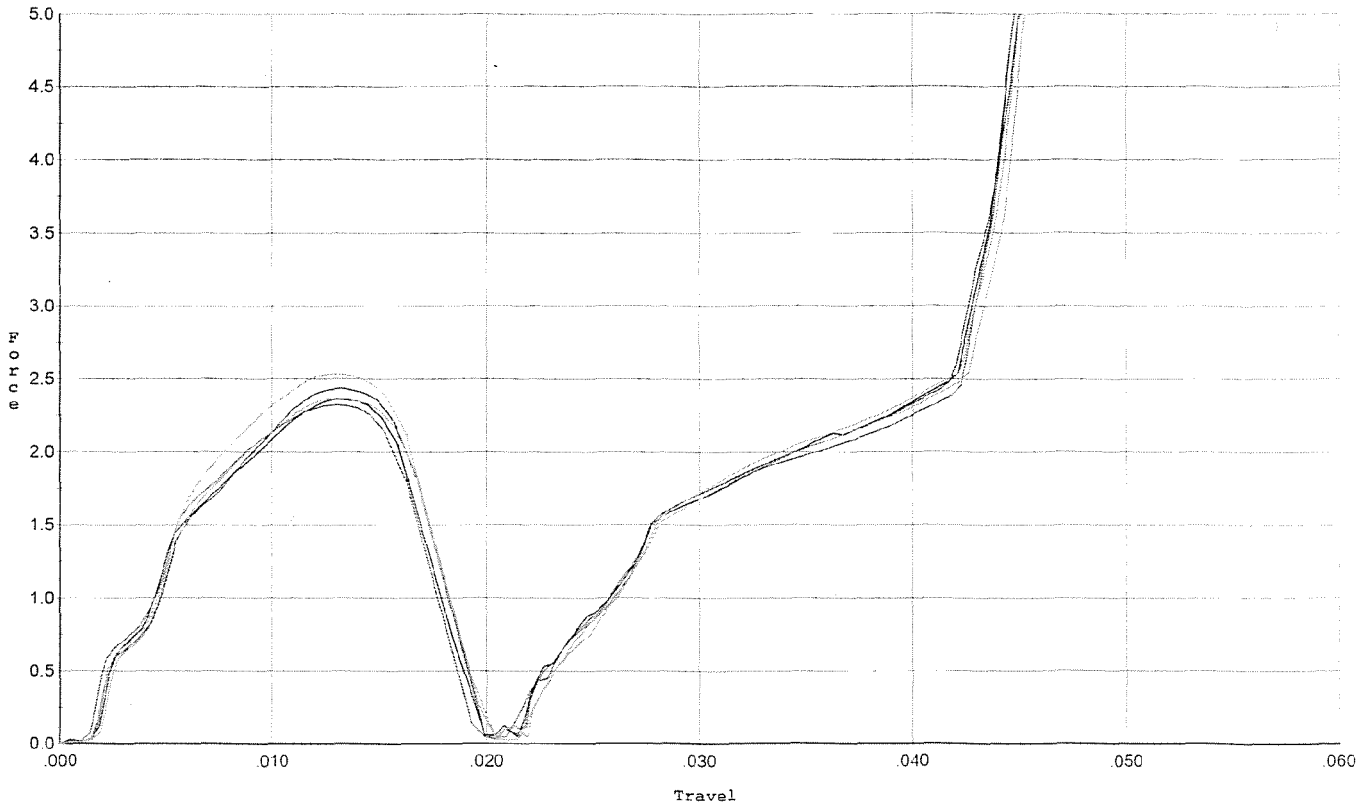
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.9</u> <u>4.8</u> <u>4.9</u>	3-30-09	LH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.9</u> <u>6.9</u> <u>6.9</u>	3-30-09	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-30-09	LH
	J) ASSEMBLE STOCK		3-26-09	MLD
	K) ASSEMBLE SWIVEL STUDS		3-30-09	LH
	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	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	NH
670	FINAL INSPECTION A) HEADSPACE		3-30-09	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.49</u> <u>2.51</u> <u>2.60</u> <u>2.41</u>	3-28-09	TL
	C) FUNCTION		3-30-09	LH
690	PACK		3/31/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



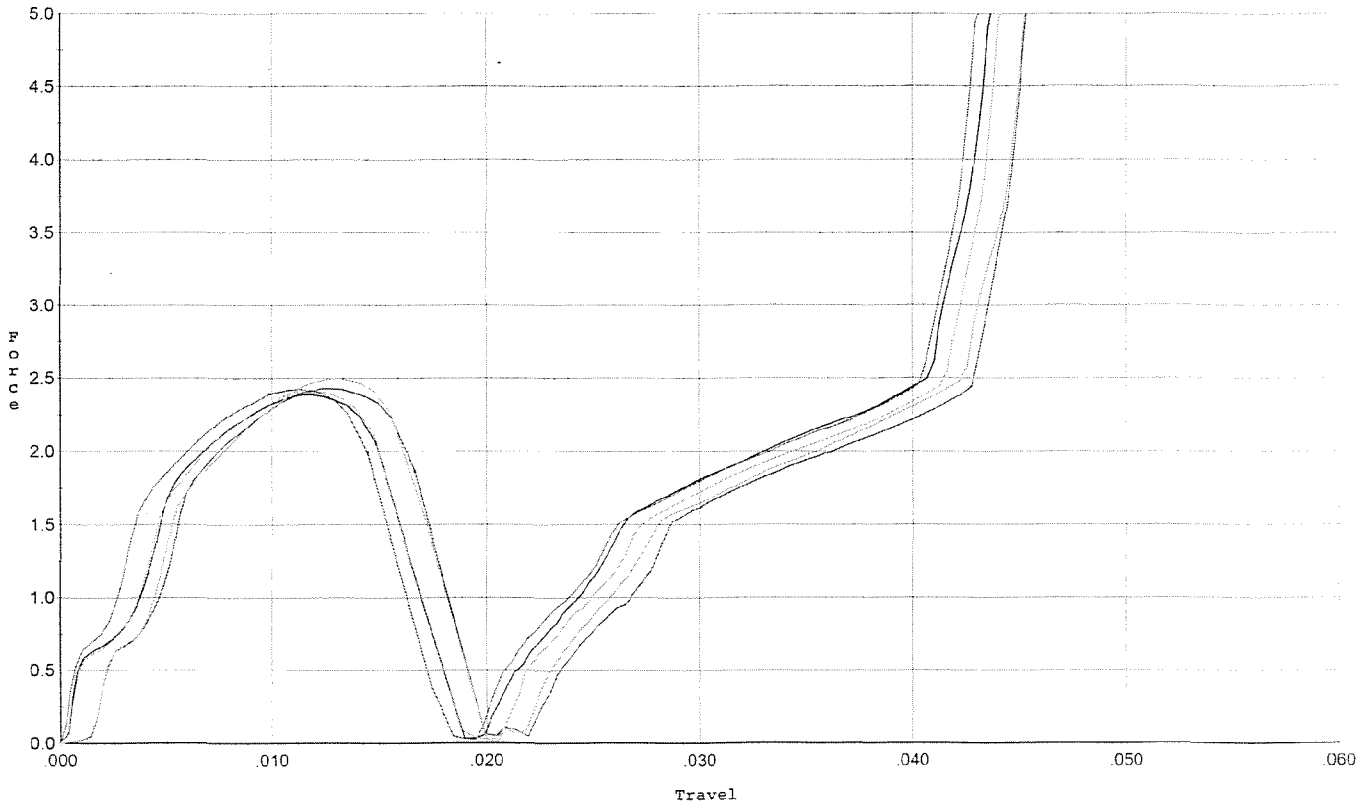
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.434	0.017	0.00	0.033	0.025		Set Trigger
2	2.361	0.016	0.00	0.033	0.024		Set Trigger
3	2.324	0.016	0.00	0.033	0.024		Set Trigger
4	2.532	0.016	0.00	0.033	0.026		Set Trigger
5	2.373	0.017	0.00	0.033	0.025		Set Trigger

A-2-40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



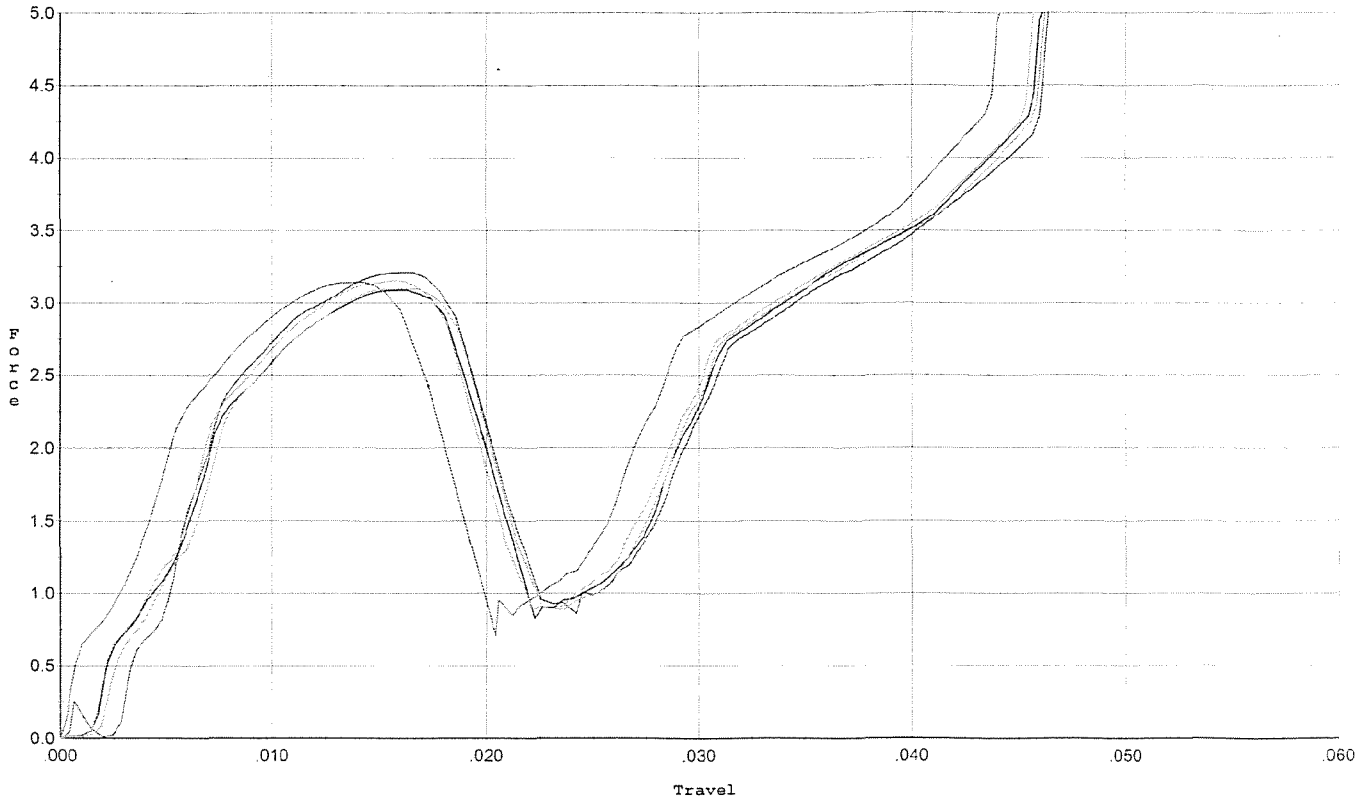
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.429	0.017	0.00	0.033	0.026		Set Trigger
2	2.391	0.015	0.00	0.033	0.024		Set Trigger
3	2.424	0.014	0.00	0.033	0.025		Set Trigger
4	2.422	0.015	0.00	0.033	0.024		Set Trigger
5	2.497	0.017	0.00	0.033	0.027		Set Trigger

A-2-43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



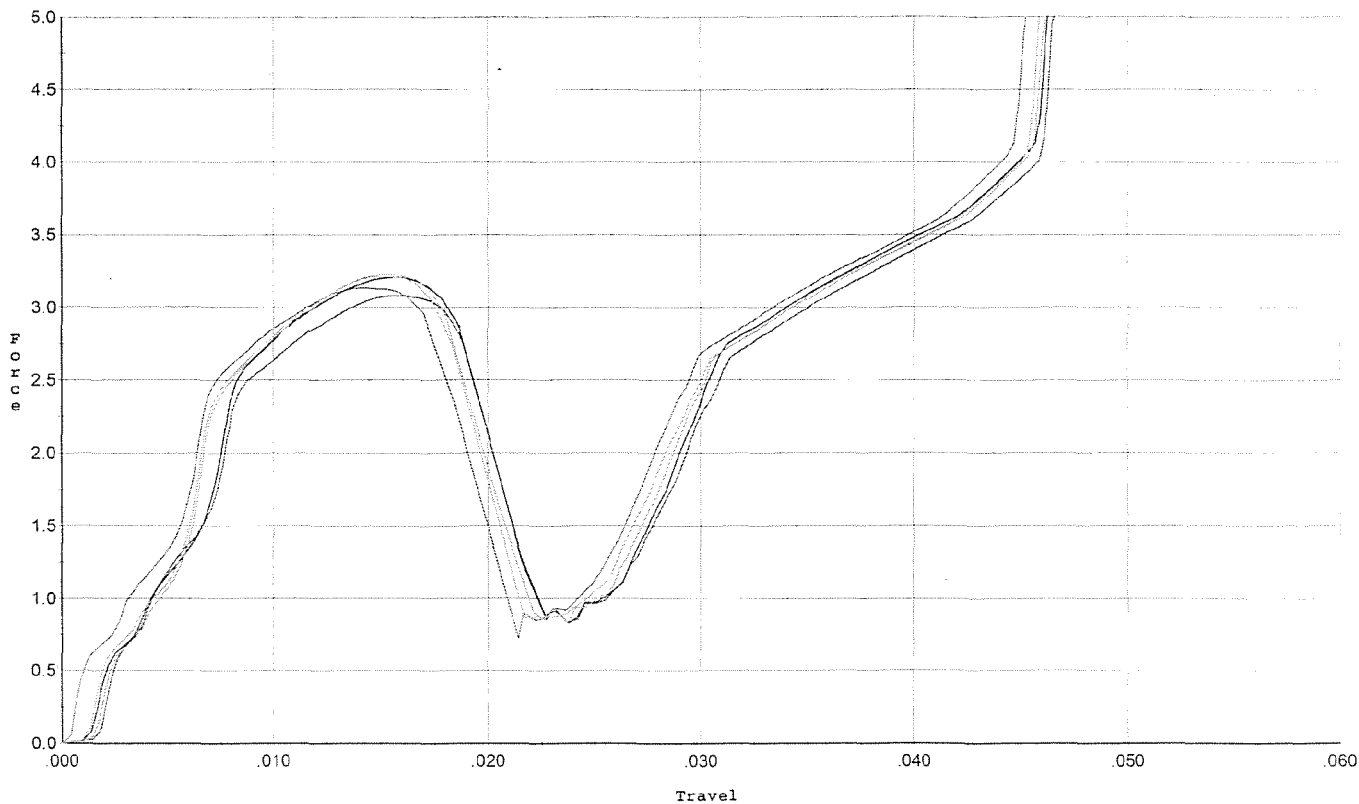
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.212	0.019	0.003	0.030	0.037		Set Trigger
2	3.090	0.020	0.00	0.030	0.038		Set Trigger
3	3.144	0.017	0.00	0.029	0.037		Set Trigger
4	3.155	0.018	0.00	0.030	0.036		Set Trigger
5	3.100	0.019	0.00	0.030	0.036		Set Trigg.

A-3-14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



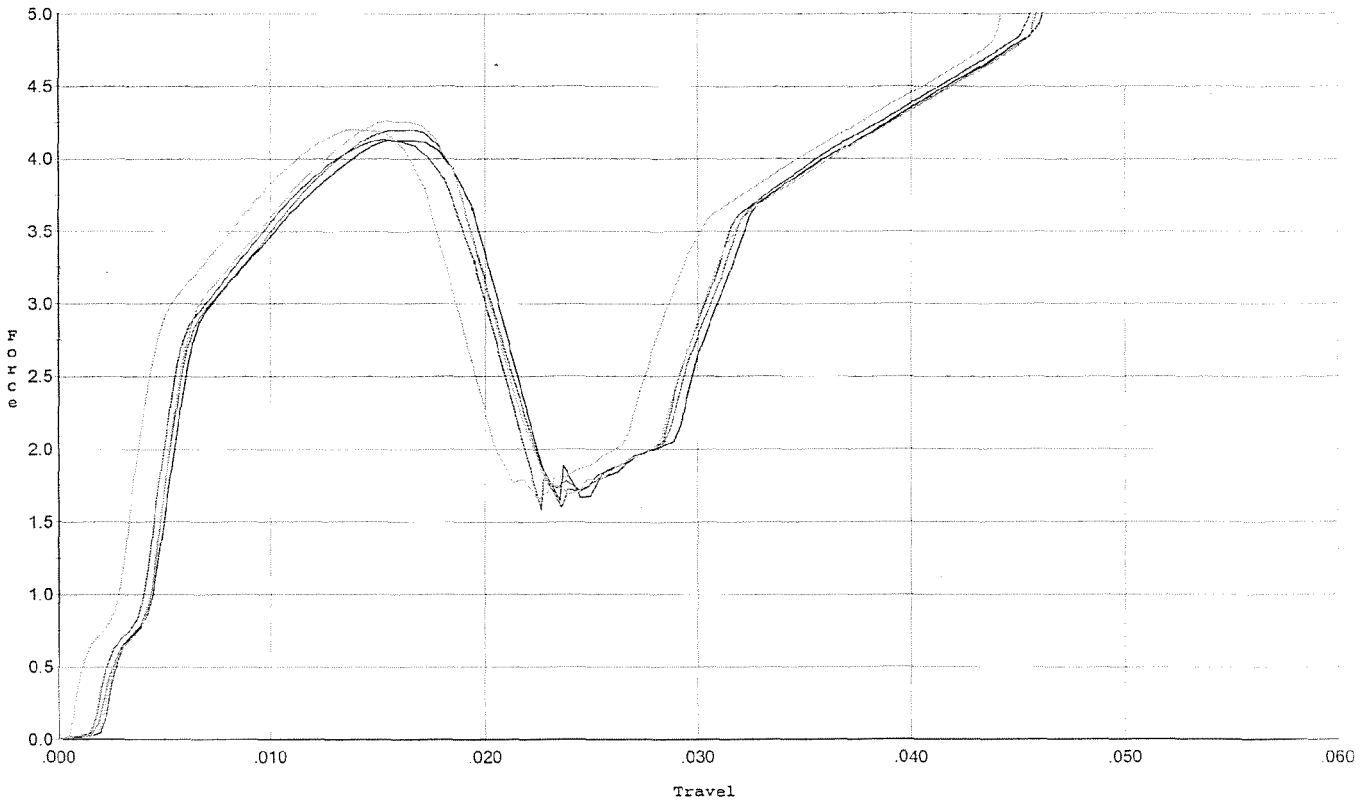
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.077	0.019	0.002	0.030	0.036		Set Trigger
2	3.209	0.019	0.00	0.030	0.037		Set Trigger
3	3.133	0.018	0.00	0.029	0.038		Set Trigger
4	3.210	0.018	0.00	0.030	0.037		Set Trigger
5	3.222	0.018	0.00	0.030	0.036		Set Trigger

A-3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



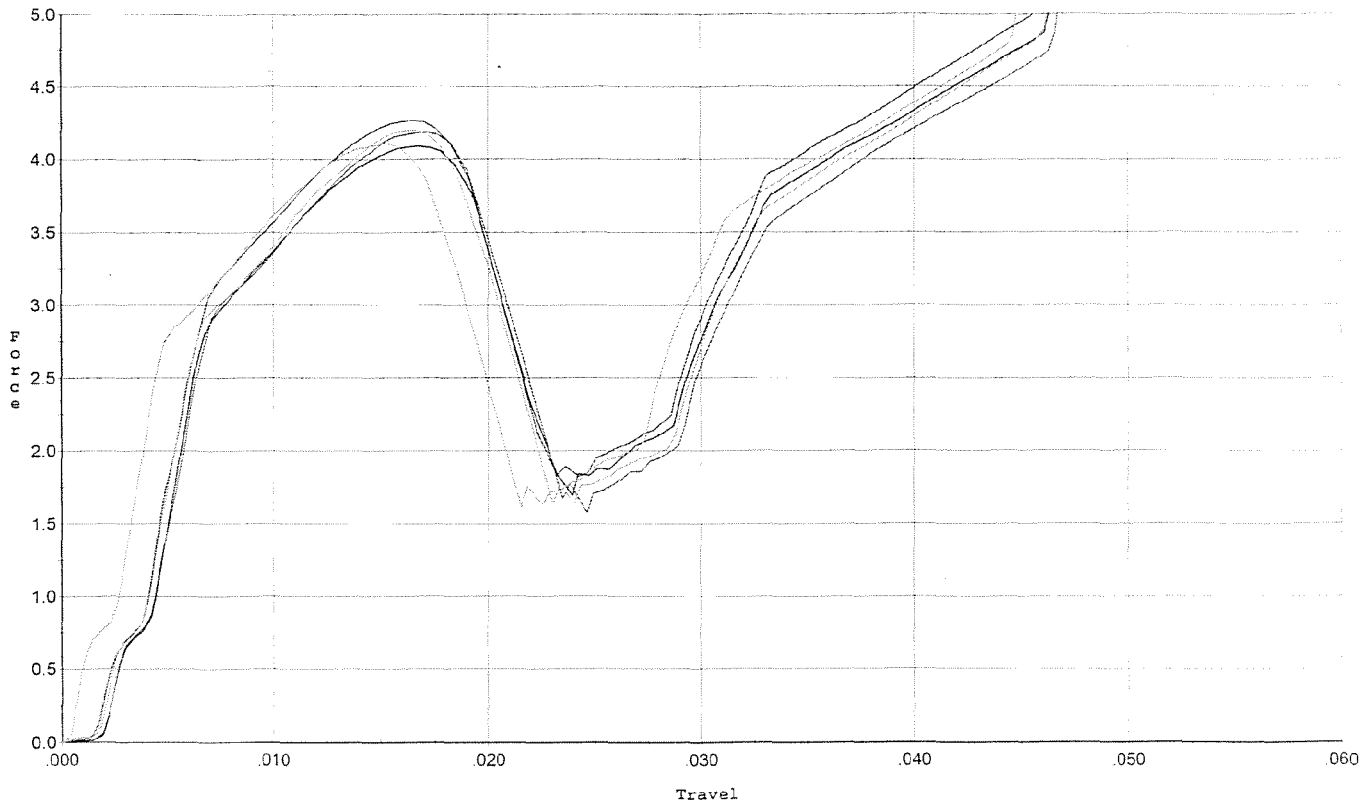
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.134	0.020	0.00	0.028	0.051		Set Trigger
2	4.129	0.019	0.00	0.028	0.050		Set Trigger
3	4.199	0.019	0.00	0.028	0.048		Set Trigger
4	4.260	0.019	0.002	0.028	0.049		Set Trigger
5	4.199	0.017	0.00	0.027	0.048		Set Trigger

A 4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



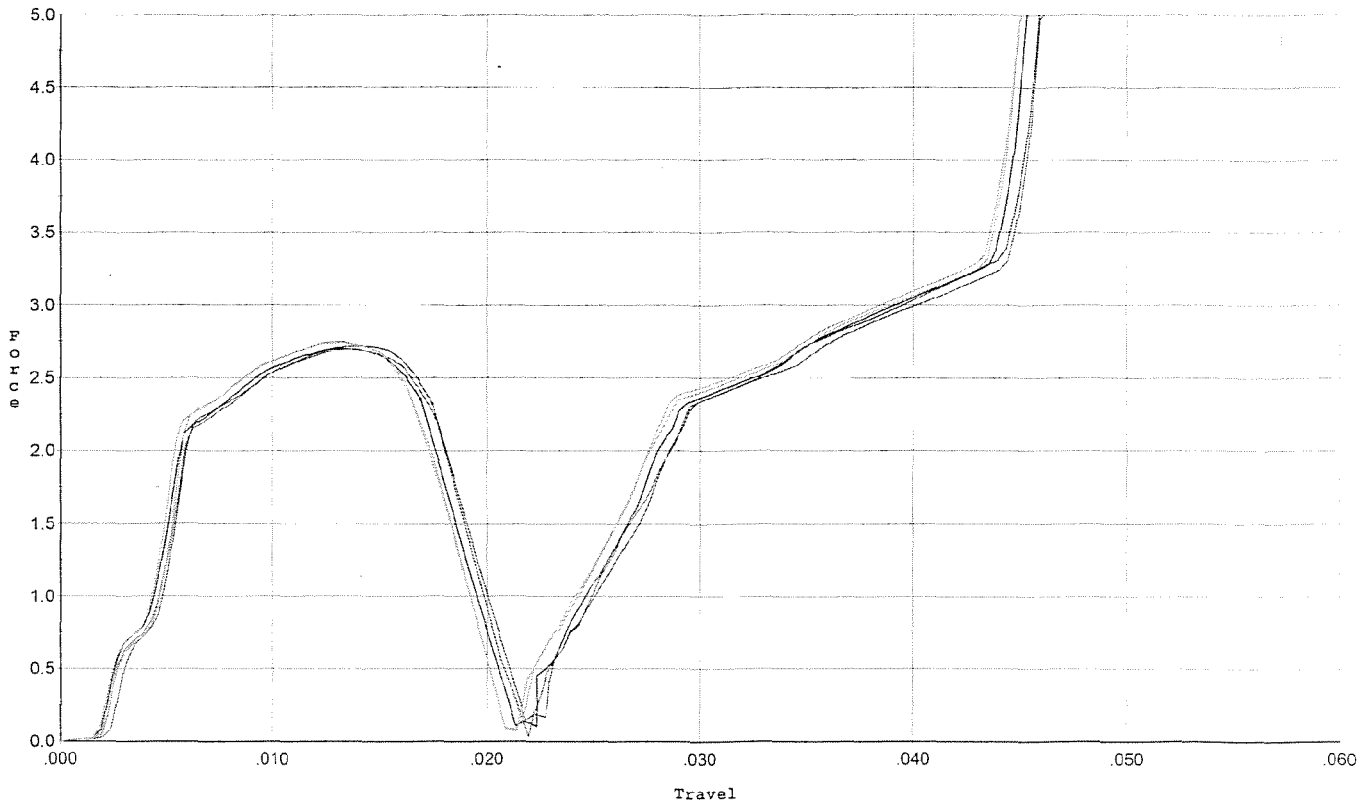
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.269	0.019	0.00	0.028	0.051		Set Trigger
2	4.092	0.019	0.002	0.028	0.049		Set Trigger
3	4.191	0.021	0.00	0.028	0.054		Set Trigger
4	4.201	0.020	0.00	0.028	0.052		Set Trigger
5	4.112	0.019	0.00	0.028	0.051		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



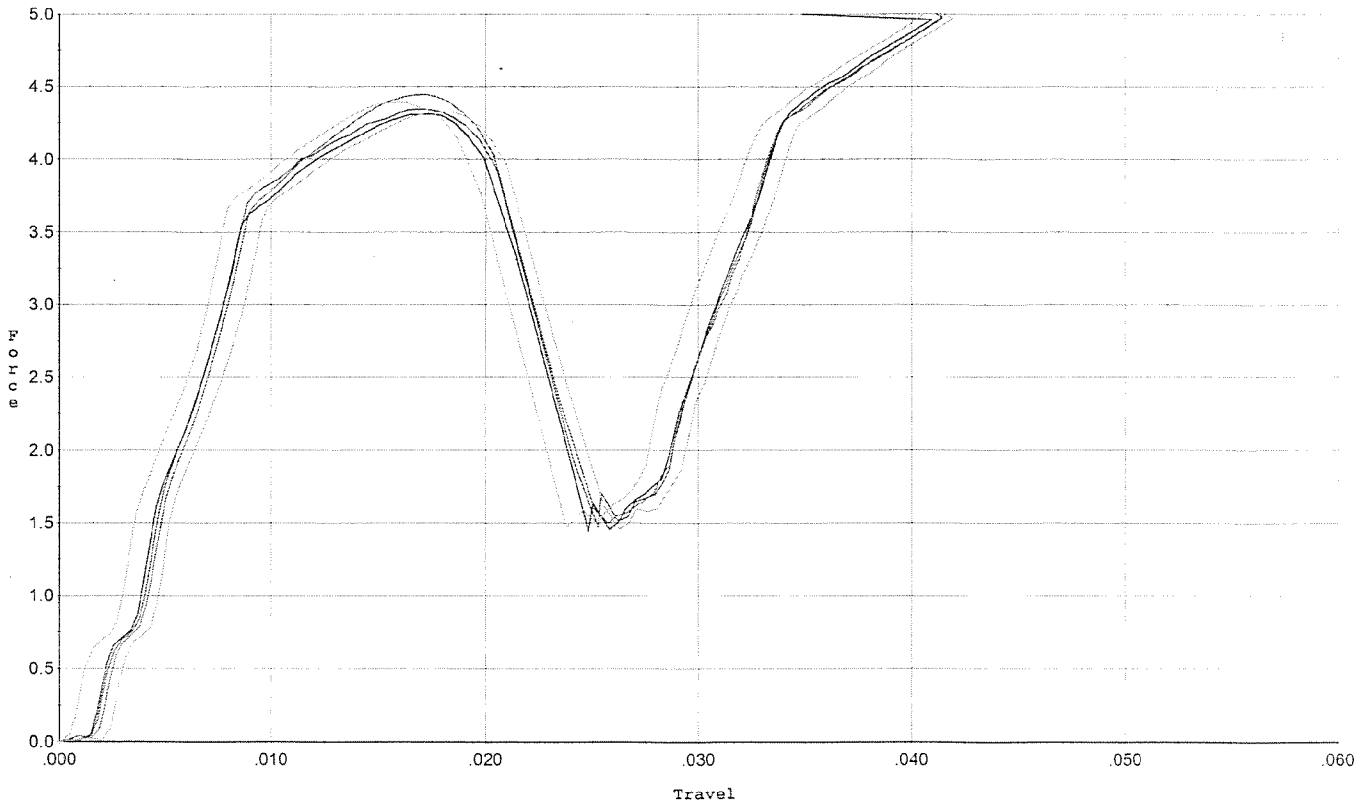
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.719	0.017	0.002	0.031	0.031		Set Trigger
2	2.701	0.017	0.00	0.031	0.030		Set Trigger
3	2.696	0.018	0.002	0.031	0.031		Set Trigger
4	2.739	0.018	0.00	0.031	0.032		Set Trigger
5	2.745	0.018	0.00	0.031	0.031		Set Trigger

A-2-72

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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	4.347	0.021	0.00	0.028	0.057		Set Trigger
2	4.313	0.021	0.00	0.028	0.059		Set Trigger
3	4.446	0.020	0.00	0.028	0.057		Set Trigger
4	4.390	0.020	0.00	0.028	0.057		Set Trigger
5	4.329	0.021	0.002	0.028	0.056		Set Trigger

A-4-36