

G680 7750

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



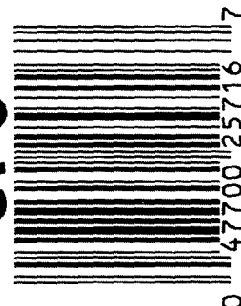
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807750

UPC



GUN SERIAL # G 6807750

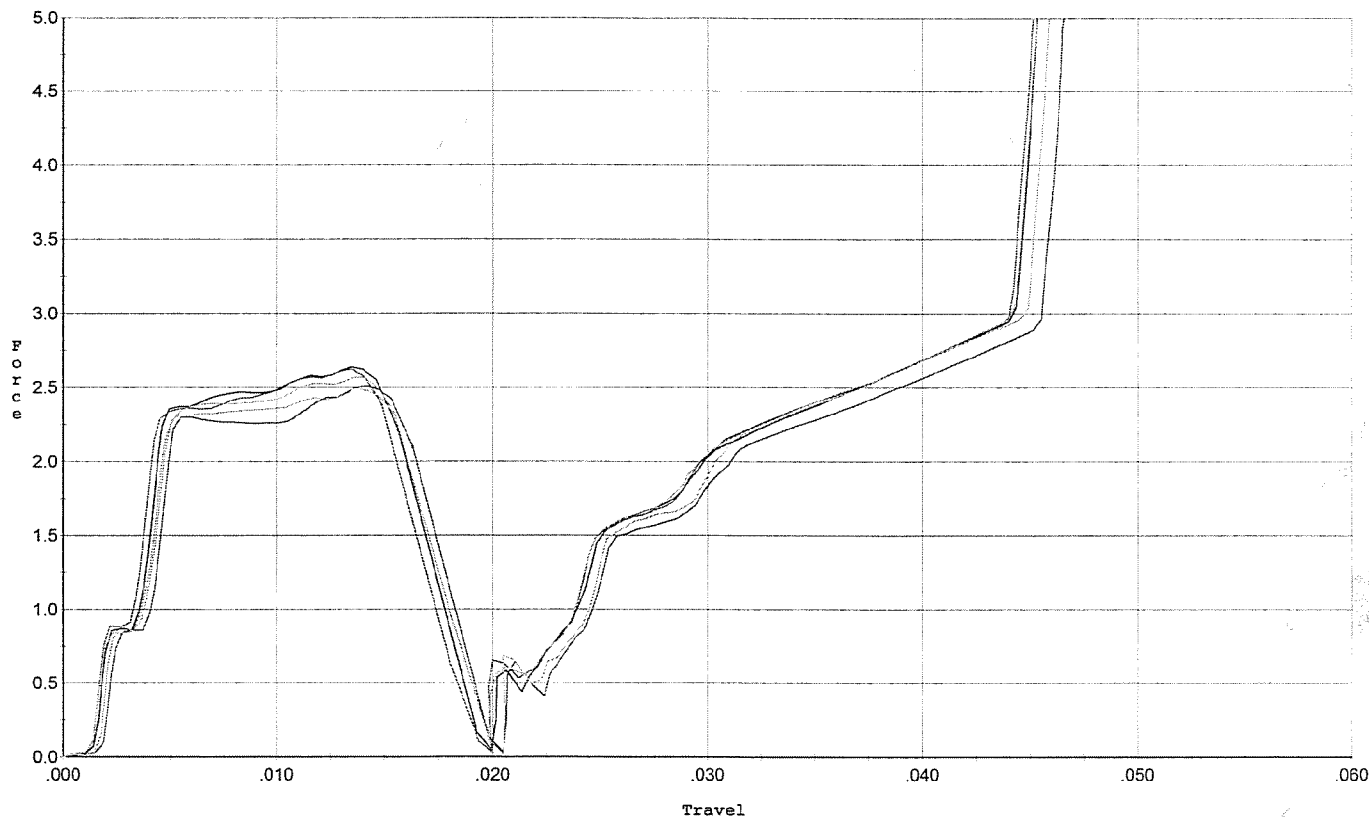
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	3/5/09	SPD
490	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		3/6	mon
540	APPLY COATINGS (BARREL ACTION)		3/9	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>4</u> <u>6</u>	3-19-09	W W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3.5</u>	3-19-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-19-09	W W
	J) ASSEMBLE STOCK		3-12-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-19-09	W 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	3-16-09	TK
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	W W
670	FINAL INSPECTION A) HEADSPACE		3-19-09	W W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.64</u> <u>2.52</u> <u>2.63</u> <u>2.64</u>	3-18-09	W W
	C) FUNCTION		3-19-09	W W
690	PACK		3/19/09	RM

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



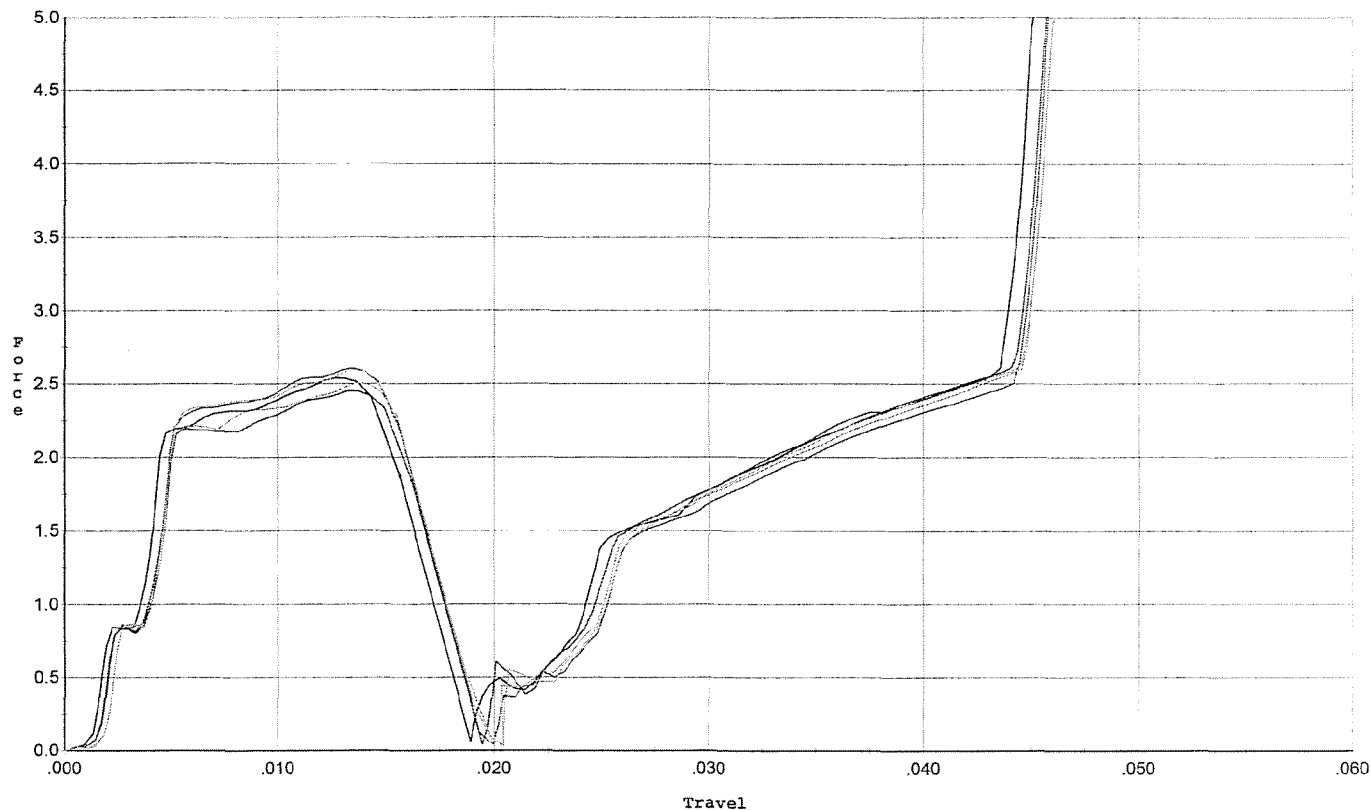
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.511	0.016	0.00	0.033	0.028		Set Trigger
2	2.639	0.016	0.00	0.033	0.029		Set Trigger
3	2.624	0.015	0.00	0.033	0.027		Set Trigger
4	2.568	0.015	0.00	0.033	0.028		Set Trigger
5	2.493	0.015	0.00	0.033	0.027		Set Trigger

A. 2.56

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



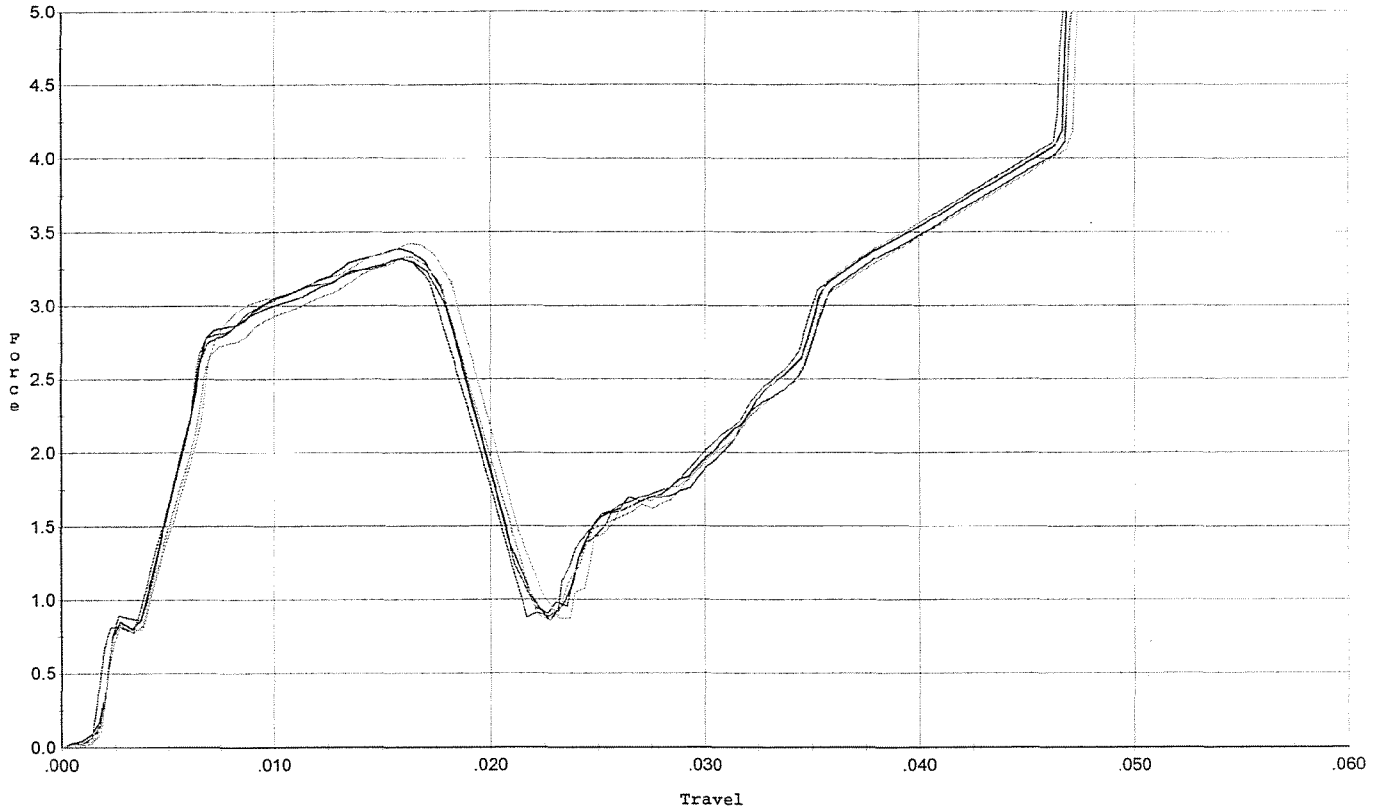
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.452	0.016	0.00	0.033	0.027		Set Trigger
2	2.540	0.016	0.00	0.033	0.027		Set Trigger
3	2.605	0.016	0.00	0.034	0.028		Set Trigger
4	2.596	0.016	0.004	0.033	0.027		Set Trigger
5	2.504	0.016	0.00	0.033	0.026		Set Trigger

A-2.53

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



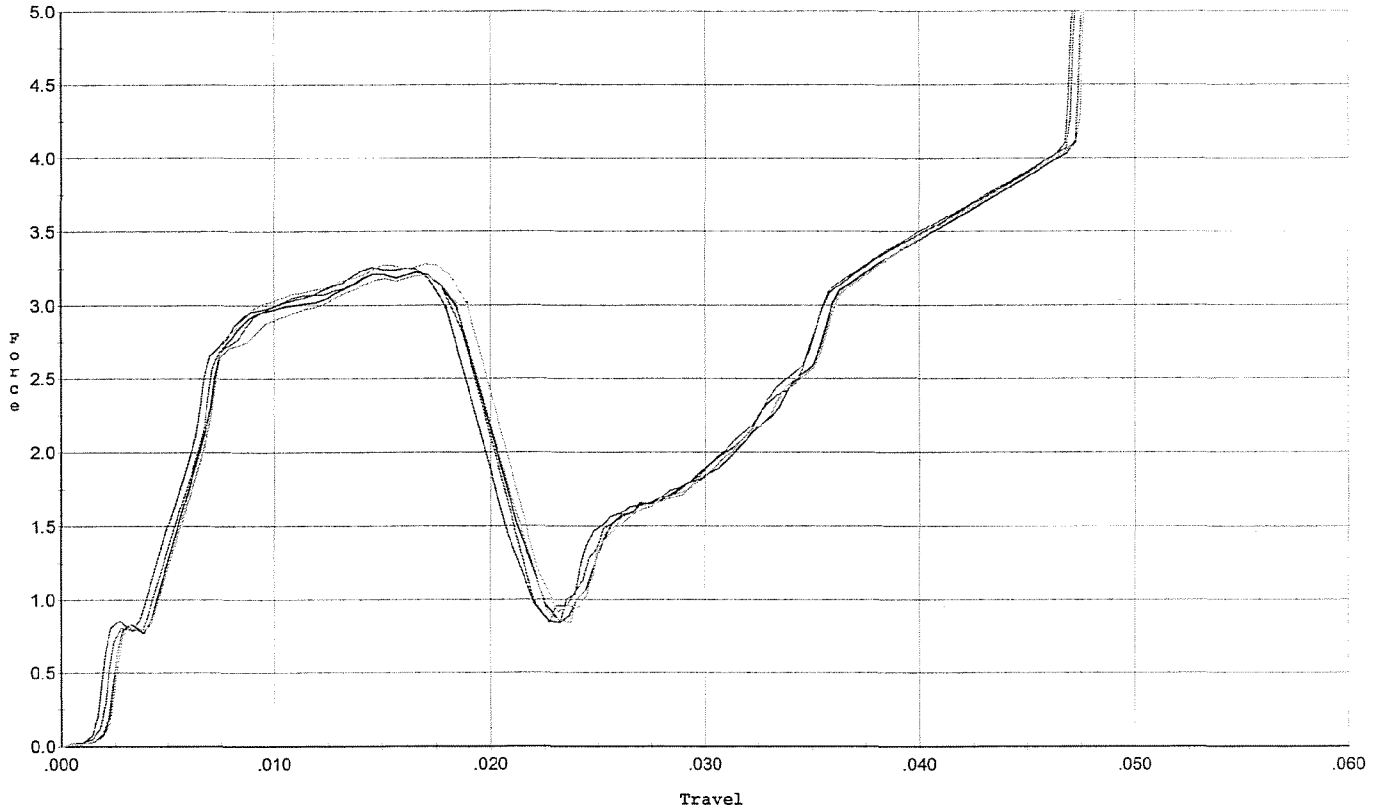
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.317	0.018	0.004	0.031	0.039		Set Trigger
2	3.391	0.018	0.00	0.031	0.039		Set Trigger
3	3.323	0.019	0.004	0.031	0.042		Set Trigger
4	3.423	0.018	0.004	0.031	0.040		Set Trigger
5	3.326	0.018	0.00	0.031	0.038		Set Trigger

A-3.35

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



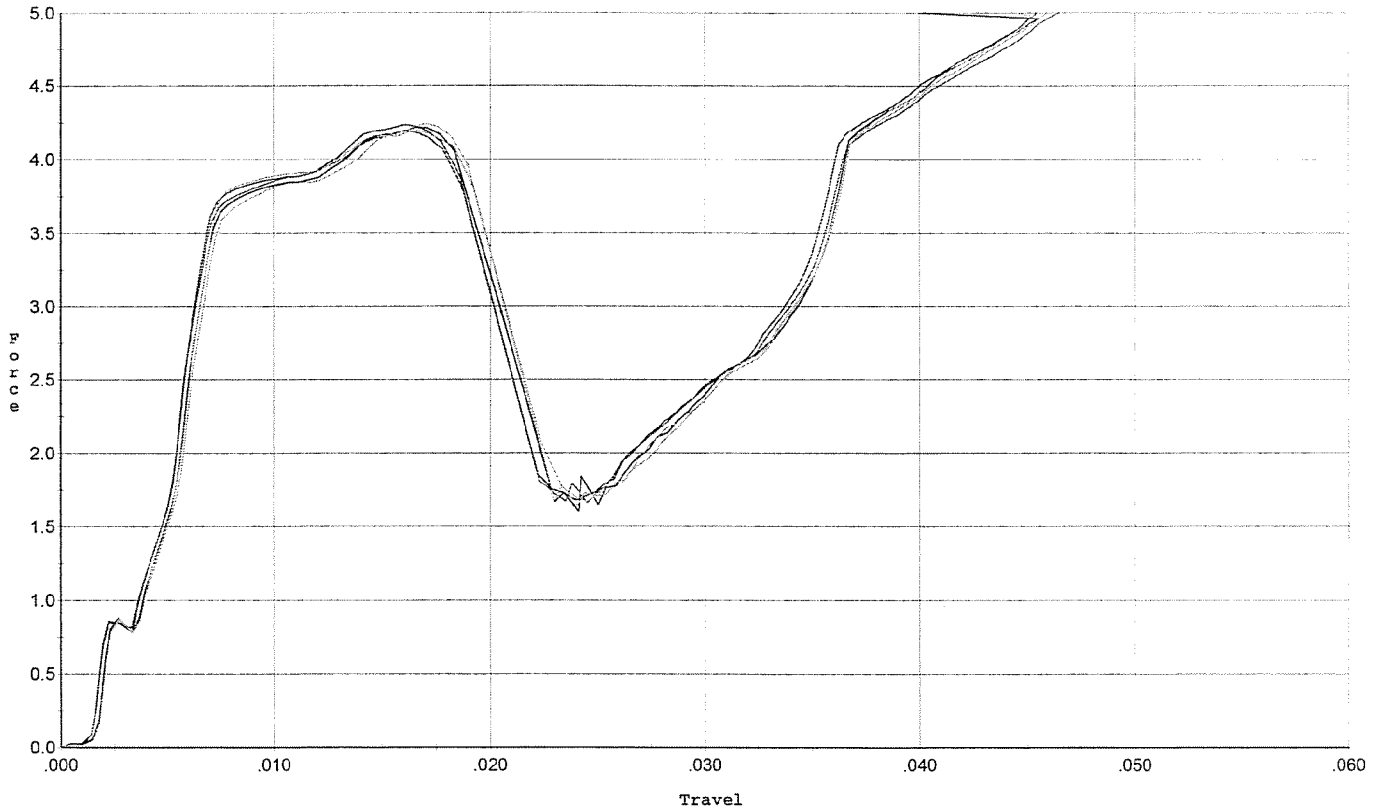
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.257	0.018	0.00	0.031	0.039		Set Trigger
2	3.226	0.018	0.00	0.031	0.039		Set Trigger
3	3.220	0.019	0.004	0.031	0.040		Set Trigger
4	3.279	0.019	0.00	0.031	0.040		Set Trigger
5	3.202	0.018	0.00	0.031	0.038		Set Trigger

A-3-73

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



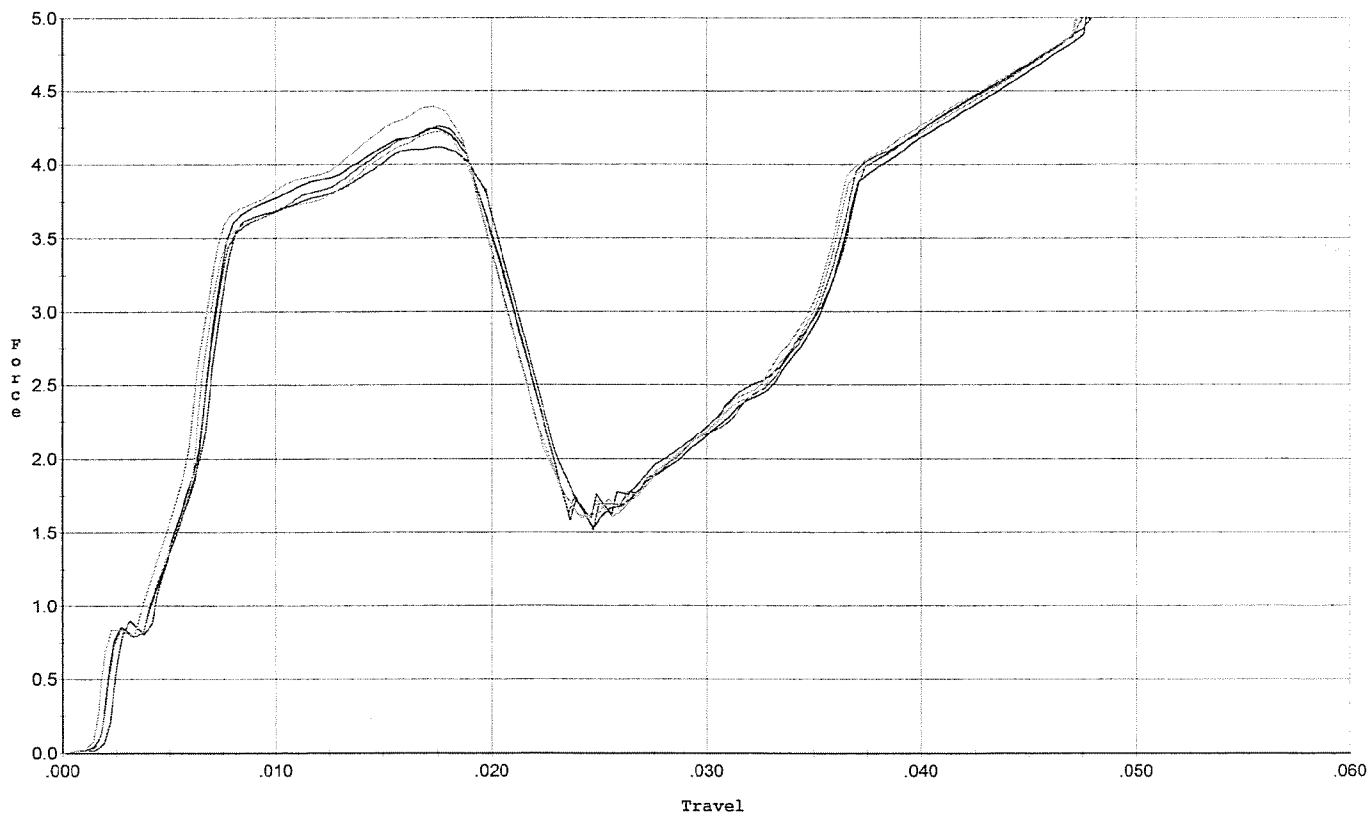
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.236	0.019	0.004	0.029	0.051		Set Trigger
2	4.217	0.020	0.00	0.029	0.056		Set Trigger
3	4.194	0.019	0.004	0.029	0.051		Set Trigger
4	4.244	0.019	0.00	0.029	0.052		Set Trigger
5	4.196	0.019	0.00	0.029	0.053		Set Trigger

A-4.21

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



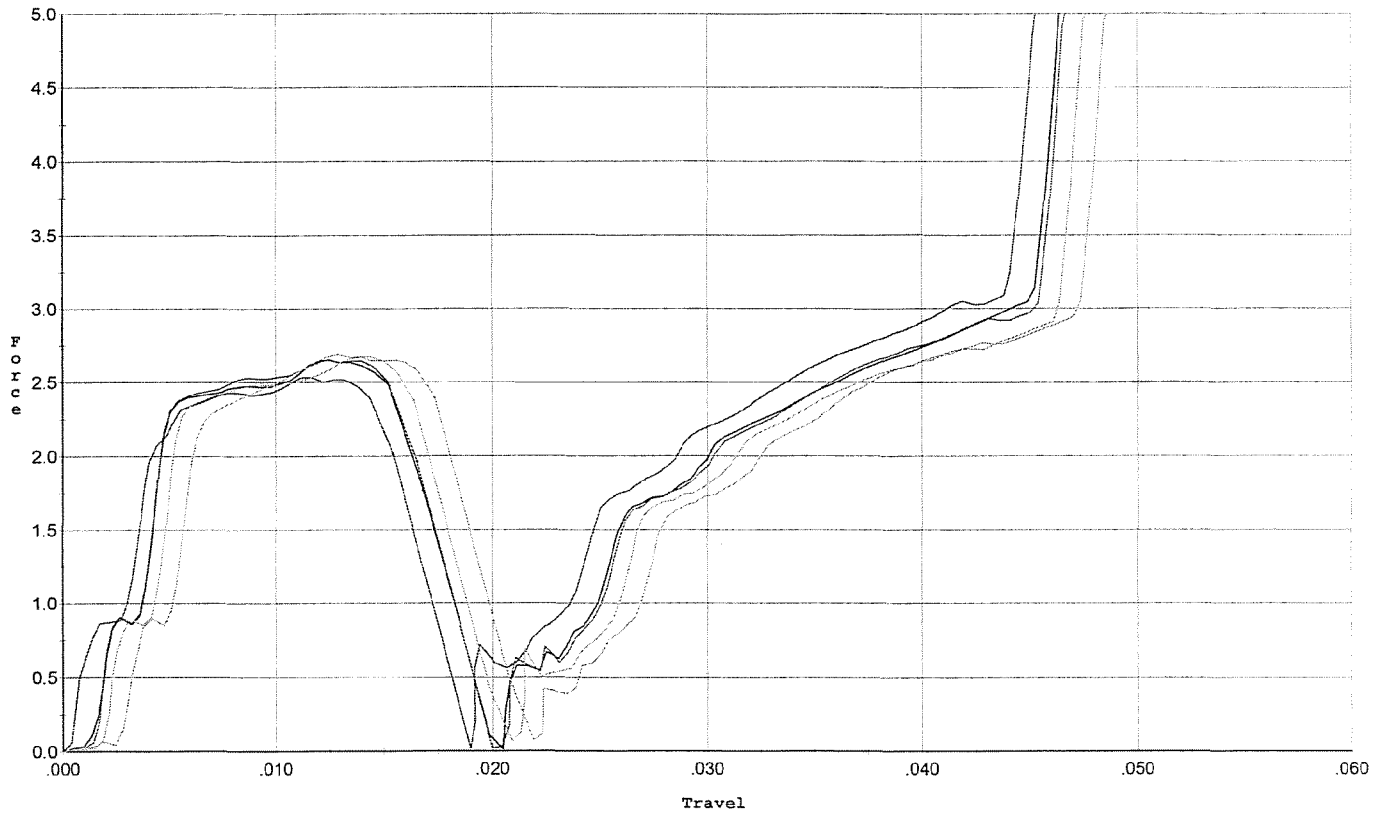
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.113	0.020	0.002	0.029	0.052		Set Trigger
2	4.239	0.021	0.00	0.029	0.055		Set Trigger
3	4.258	0.021	0.00	0.028	0.055		Set Trigger
4	4.223	0.019	0.00	0.029	0.050		Set Trigger
5	4.396	0.019	0.004	0.029	0.052		Set Trigger

A-4-24

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



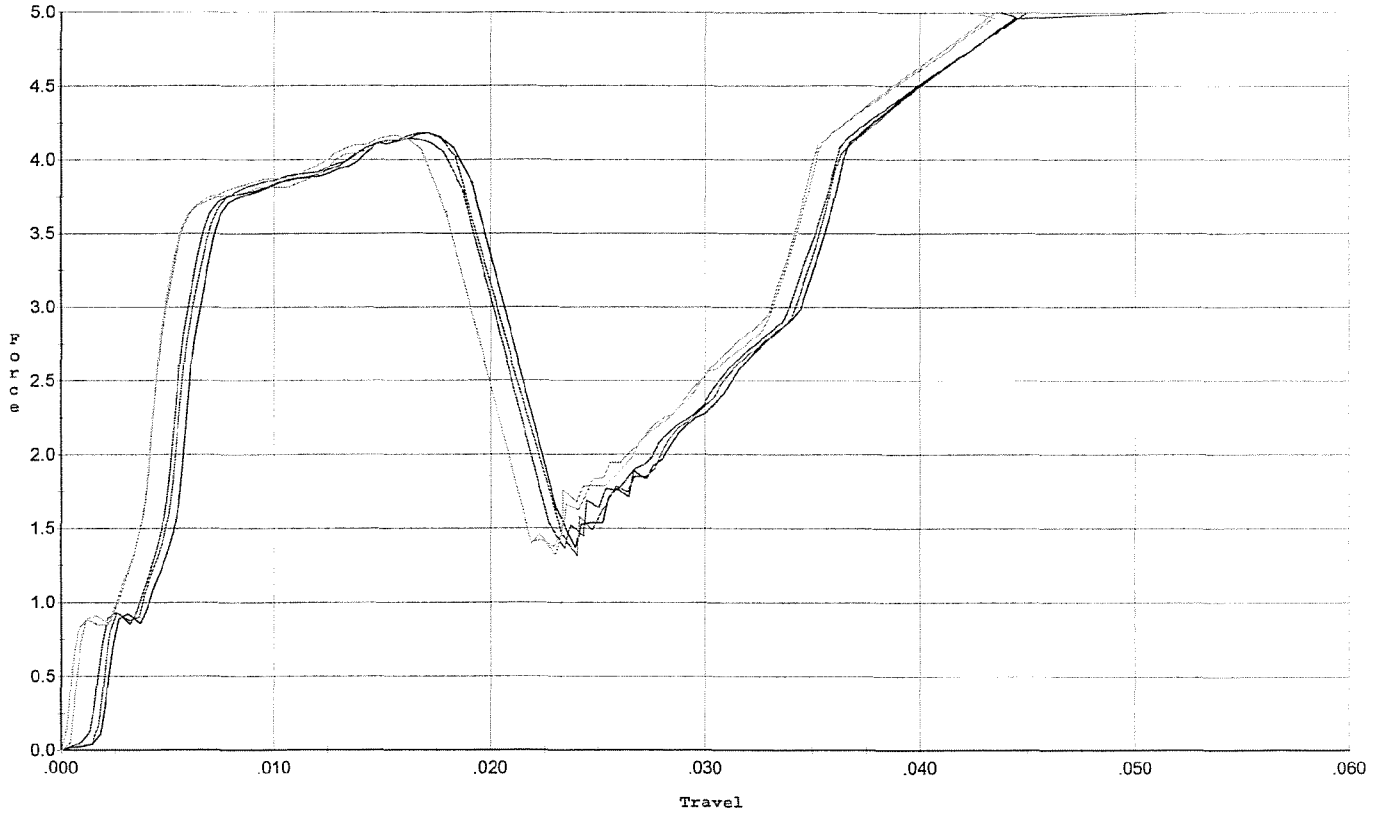
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.533	0.015	0.00	0.033	0.029		Set Trigger
2	2.649	0.017	0.00	0.033	0.031		Set Trigger
3	2.653	0.017	0.00	0.034	0.031		Set Trigger
4	2.687	0.016	0.00	0.034	0.030		Set Trigger
5	2.671	0.017	0.00	0.034	0.030		Set Trigger

A-2-63

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	4.146	0.019	0.00	0.029	0.052		Set Trigger
2	4.183	0.019	0.00	0.029	0.052		Set Trigger
3	4.182	0.018	0.00	0.029	0.050		Set Trigger
4	4.164	0.018	0.003	0.029	0.052		Set Trigger
5	4.136	0.018	0.00	0.029	0.051		Set Trigger

A-4.16