

G680 7758

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



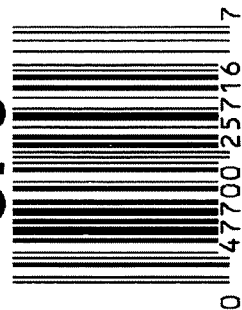
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807758

UPC



GUN SERIAL # G 6807758

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	MAGNA - FLUX MAR 0 - 2009 OPERATOR D	2-27-09	SP
470	DIS-ASSEMBLE ACTION		2-27-09	SP
472	SERIALIZE BOLT HANDLE		3-2-09	RTZ
480	MAGNAFLUX BBL ACTION		3/5/09	AD
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	MR
540	APPLY COATINGS (BARREL ACTION)		5/9	
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			

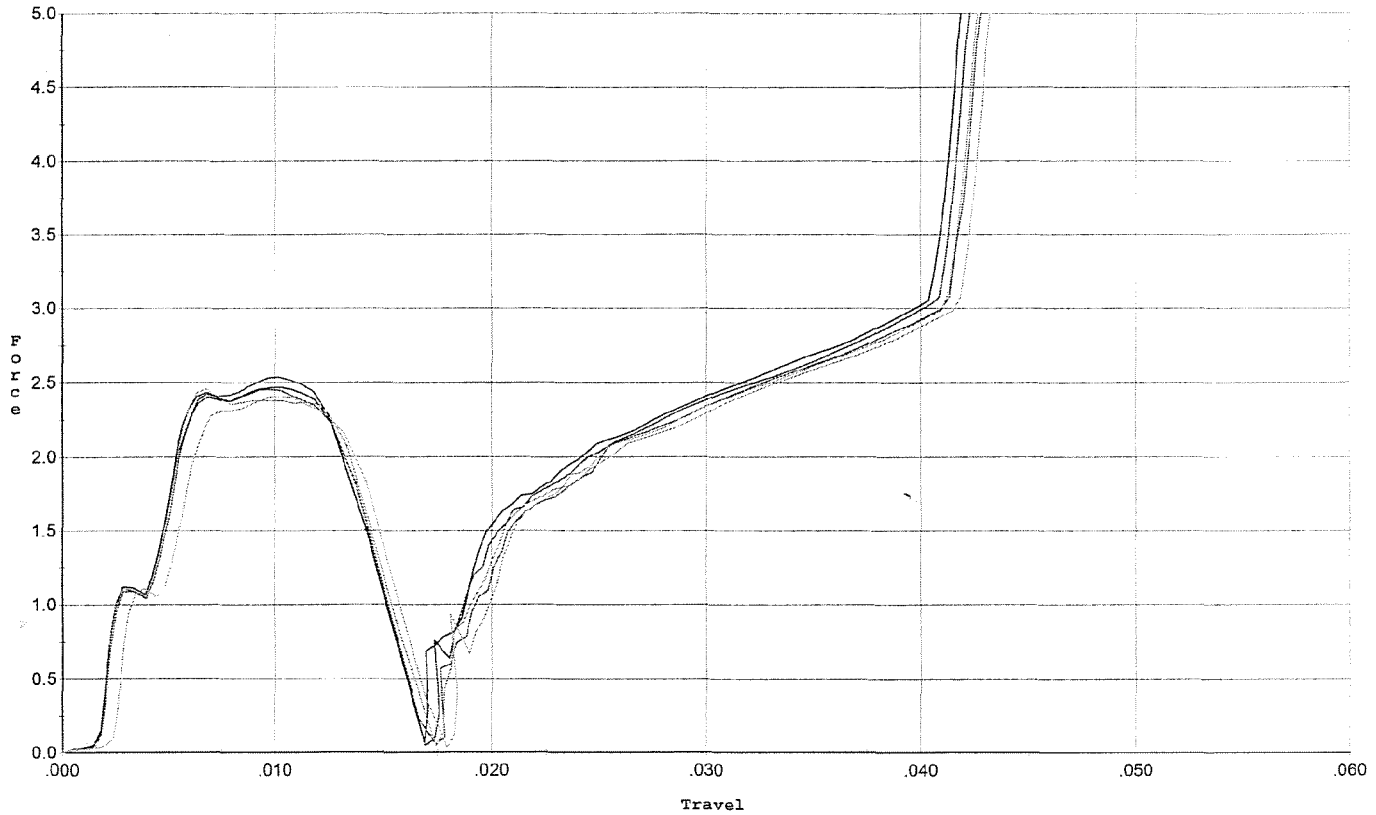
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</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>.022</u> <u>.023</u> <u>.022</u>	3-18-09	NW
	J) ASSEMBLE STOCK		3-12-09	R.D.
	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	TL
	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>2.44</u> <u>2.56</u> <u>2.56</u> <u>2.49</u> <u>2.70</u>	3-18-09	NW
	C) FUNCTION		3-18-09	NW
690	PACK		3/19/09	FM

Trigger Profile [lbs,inch]

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

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



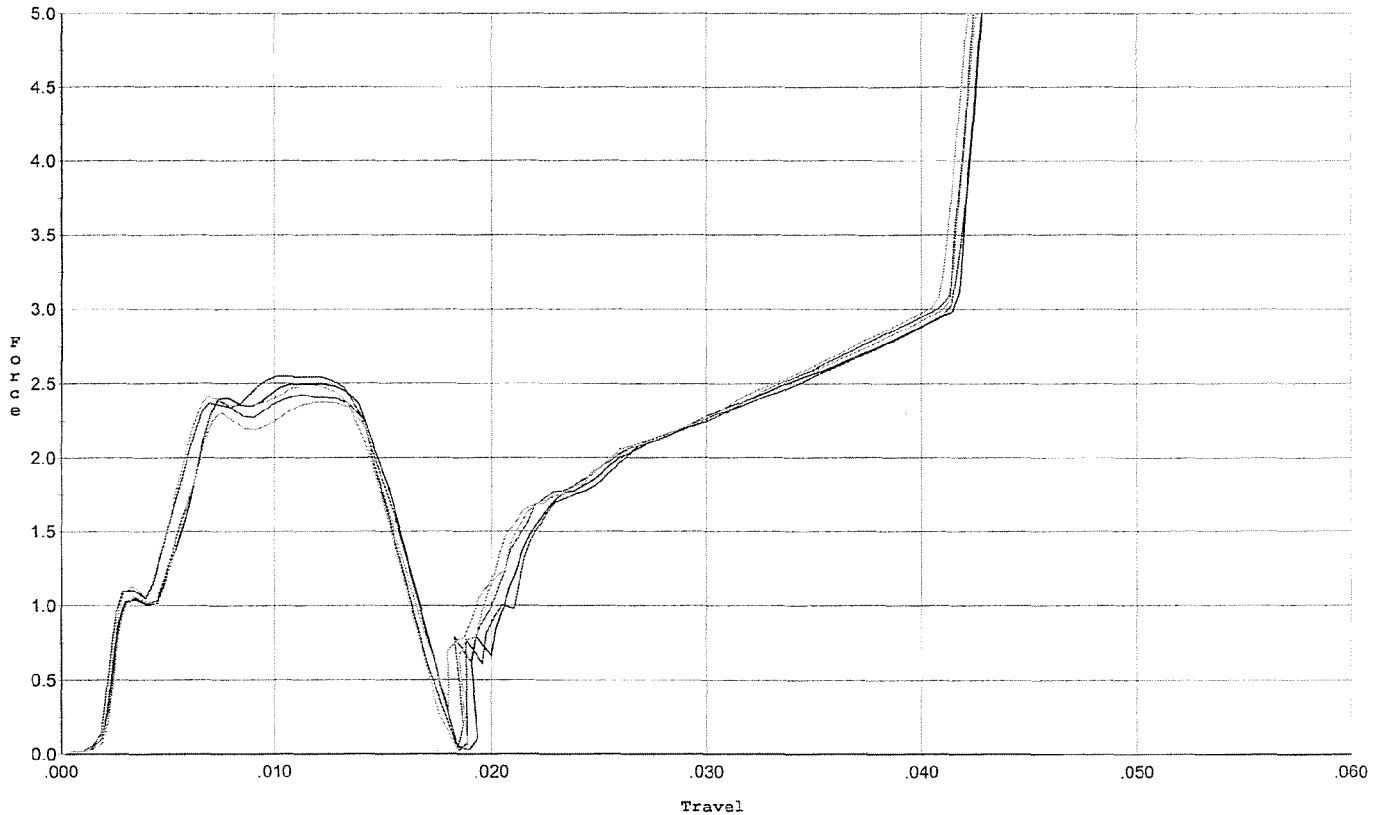
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.537	0.014	0.004	0.032	0.023		Set Trigger
2	2.468	0.014	0.004	0.031	0.023		Set Trigger
3	2.455	0.014	0.004	0.032	0.022		Set Trigger
4	2.402	0.014	0.00	0.032	0.021		Set Trigger
5	2.458	0.013	0.004	0.032	0.021		Set Trigger

A-2.46

Trigger Profile [lbs,inch]

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

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



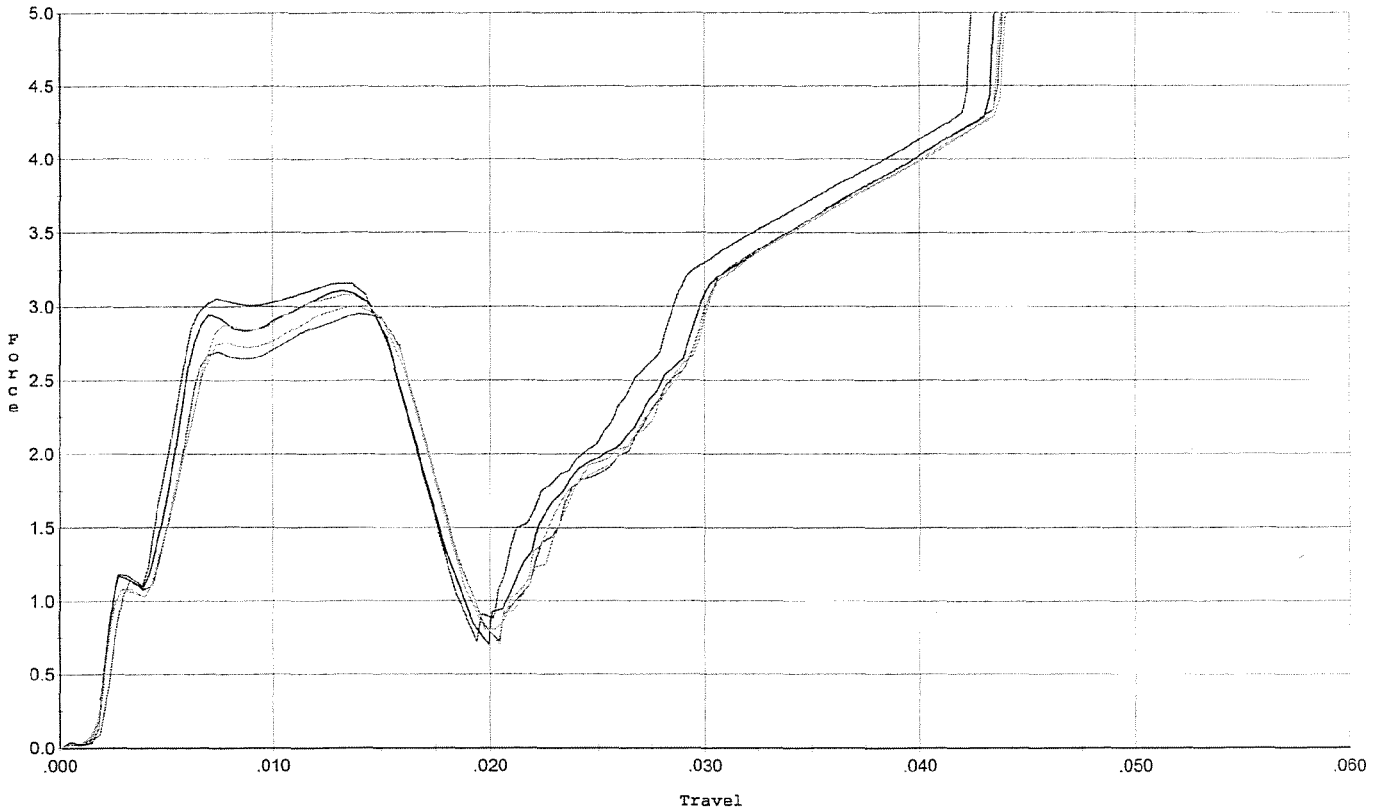
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.014	0.004	0.031	0.023		Set Trigger
2	2.496	0.015	0.00	0.031	0.025		Set Trigger
3	2.425	0.016	0.00	0.031	0.025		Set Trigger
4	2.489	0.014	0.00	0.031	0.024		Set Trigger
5	2.377	0.014	0.005	0.031	0.022		Set Trigger

A-2.46

Trigger Profile [lbs,inch]

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

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



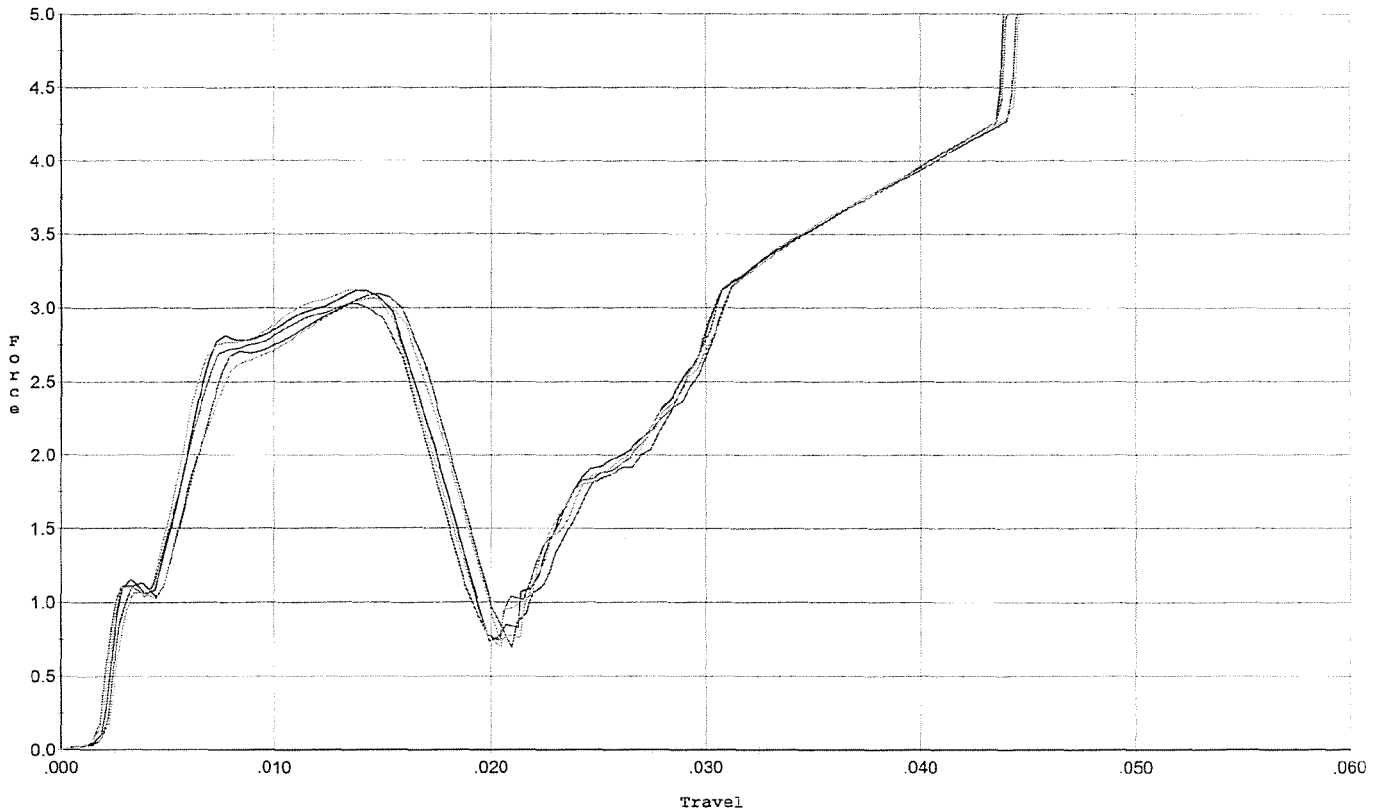
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.015	0.004	0.028	0.032		Set Trigger
2	3.109	0.015	0.004	0.029	0.031		Set Trigger
3	2.952	0.016	0.00	0.029	0.031		Set Trigger
4	3.083	0.016	0.00	0.029	0.032		Set Trigger
5	3.000	0.016	0.004	0.030	0.031		Set Trigger

A-3.06

Trigger Profile [lbs,inch]

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

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



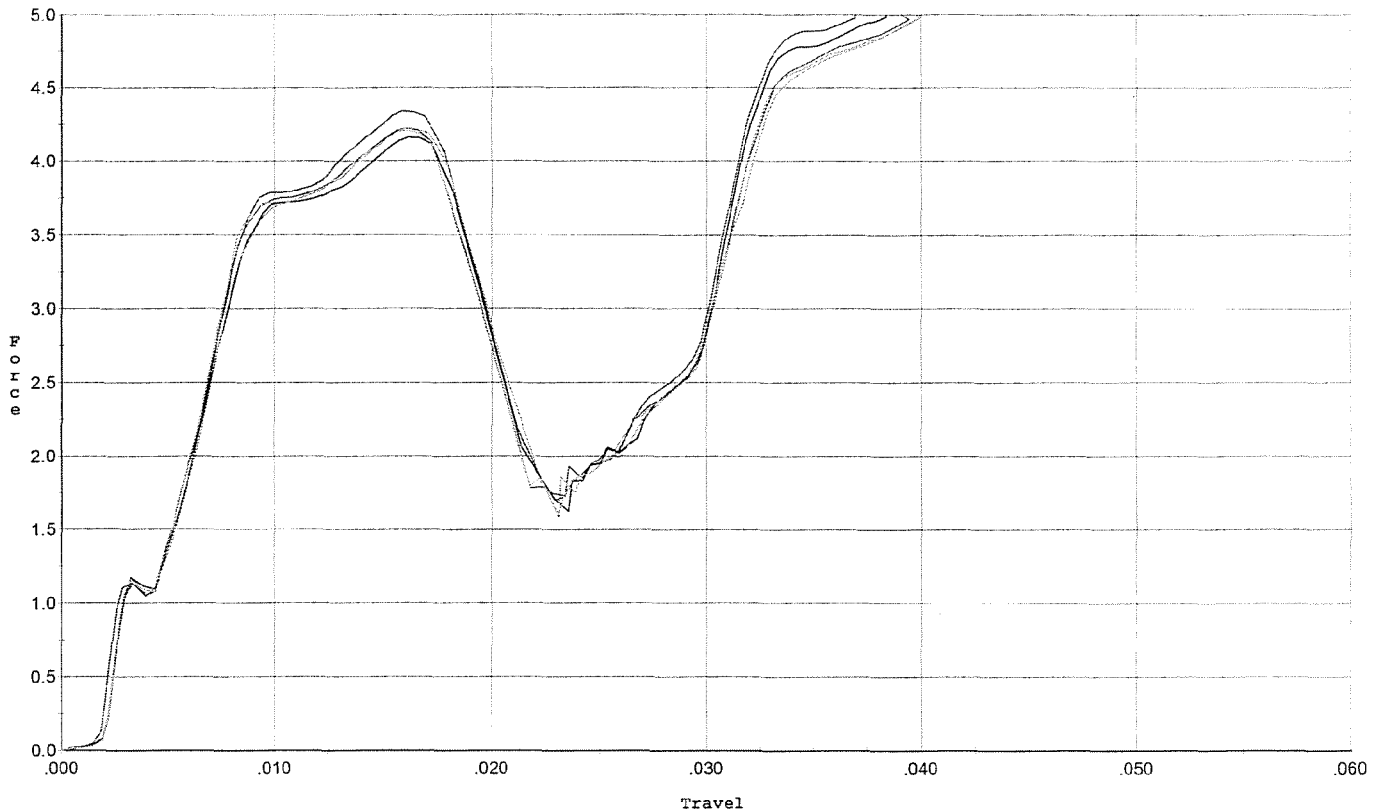
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.096	0.017	0.00	0.030	0.033		Set Trigger
2	3.116	0.017	0.00	0.029	0.034		Set Trigger
3	3.026	0.016	0.004	0.030	0.031		Set Trigger
4	3.125	0.016	0.004	0.030	0.031		Set Trigger
5	3.068	0.018	0.005	0.030	0.034		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

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

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



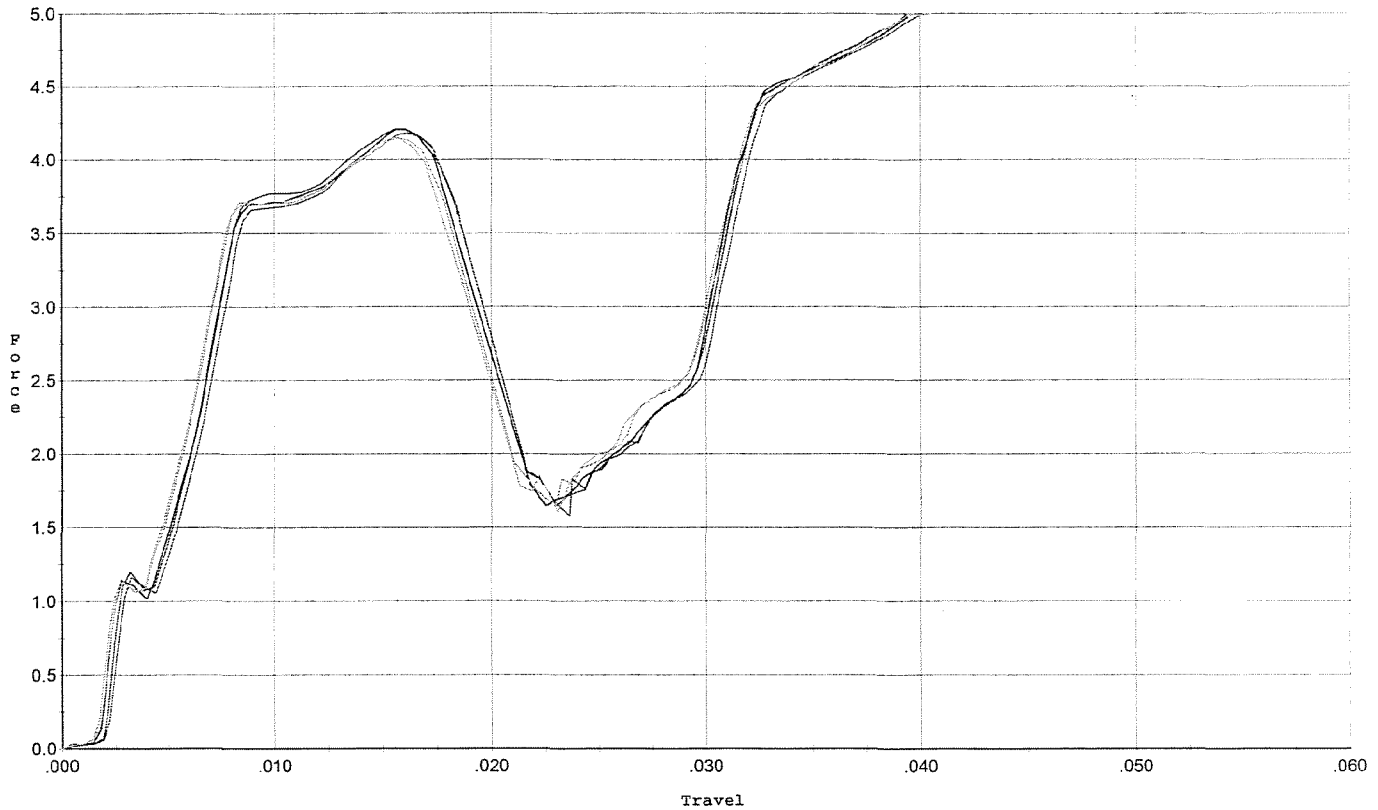
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.339	0.018	0.00	0.027	0.047		Set Trigger
2	4.161	0.018	0.005	0.027	0.046		Set Trigger
3	4.224	0.019	0.00	0.027	0.049		Set Trigger
4	4.207	0.019	0.002	0.027	0.049		Set Trigger
5	4.226	0.018	0.005	0.027	0.046		Set Trigger

A-4.23

Trigger Profile [lbs,inch]

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

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



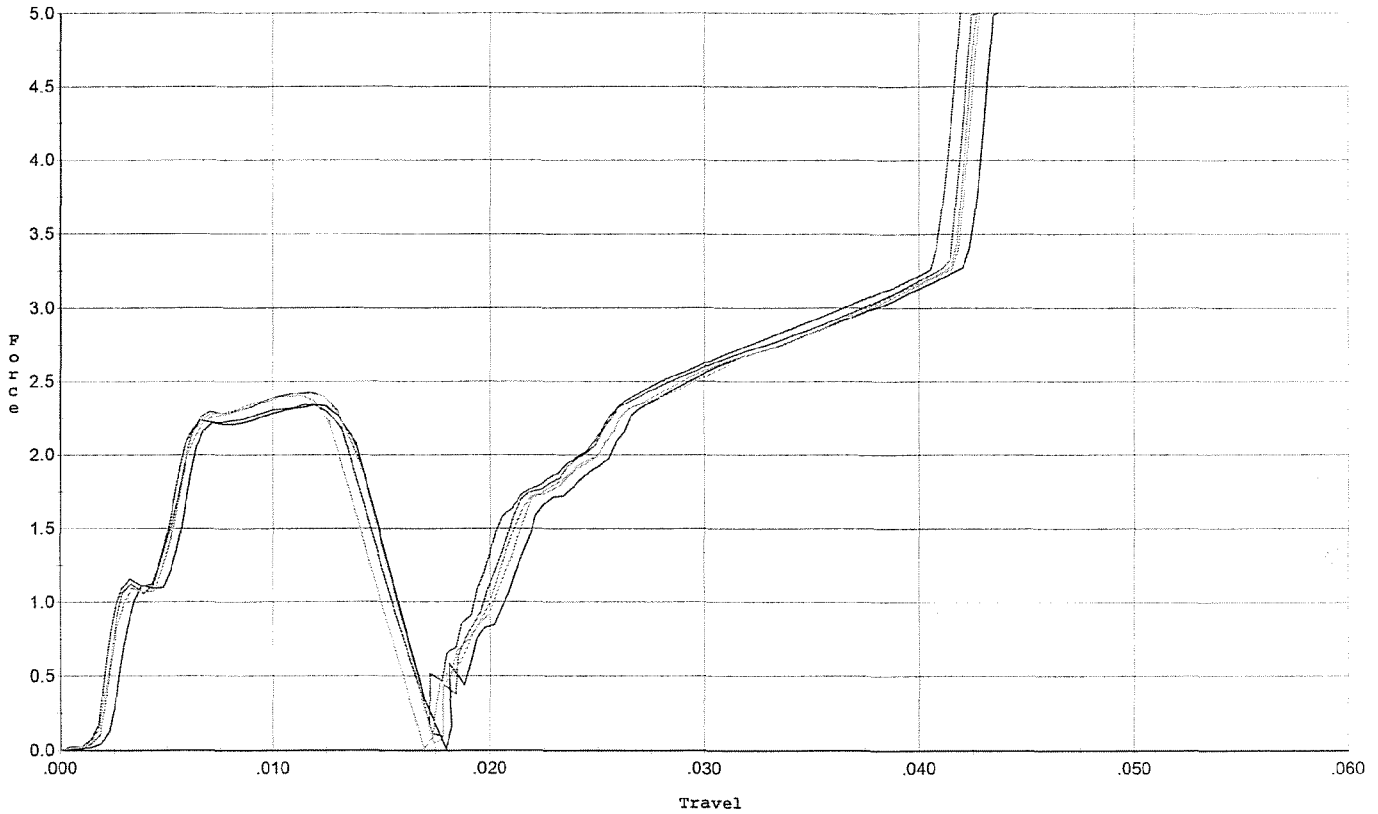
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.207	0.018	0.002	0.027	0.048		Set Trigger
2	4.203	0.017	0.004	0.028	0.045		Set Trigger
3	4.182	0.018	0.005	0.027	0.047		Set Trigger
4	4.146	0.019	0.00	0.027	0.048		Set Trigger
5	4.145	0.018	0.004	0.027	0.046		Set Trigger

A-4.17

Trigger Profile [lbs,inch]

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

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



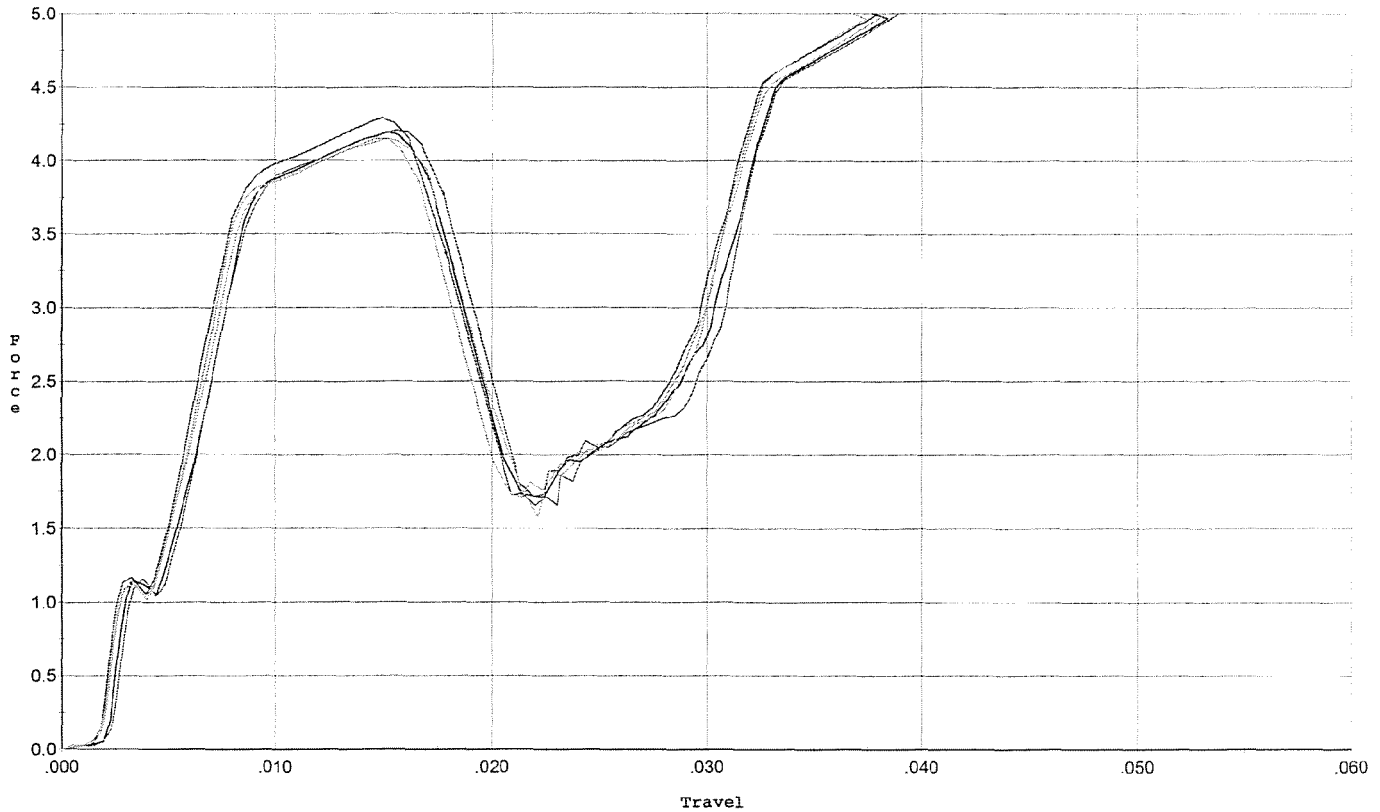
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.342	0.013	0.00	0.031	0.021		Set Trigger
2	2.342	0.014	0.005	0.032	0.021		Set Trigger
3	2.422	0.014	0.00	0.031	0.022		Set Trigger
4	2.431	0.014	0.00	0.031	0.022		Set Trigger
5	2.404	0.013	0.005	0.032	0.019		Set Trigger

A.2.38

Trigger Profile [lbs,inch]

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

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	4.291	0.018	0.00	0.028	0.047		Set Trigger
2	4.193	0.017	0.005	0.028	0.043		Set Trigger
3	4.206	0.018	0.00	0.028	0.045		Set Trigger
4	4.149	0.017	0.00	0.028	0.044		Set Trigger
5	4.149	0.017	0.00	0.028	0.042		Set Trigger

A-4.19