

66807765

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



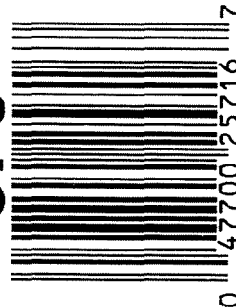
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807765

UPC



GUN SERIAL # G 6807765

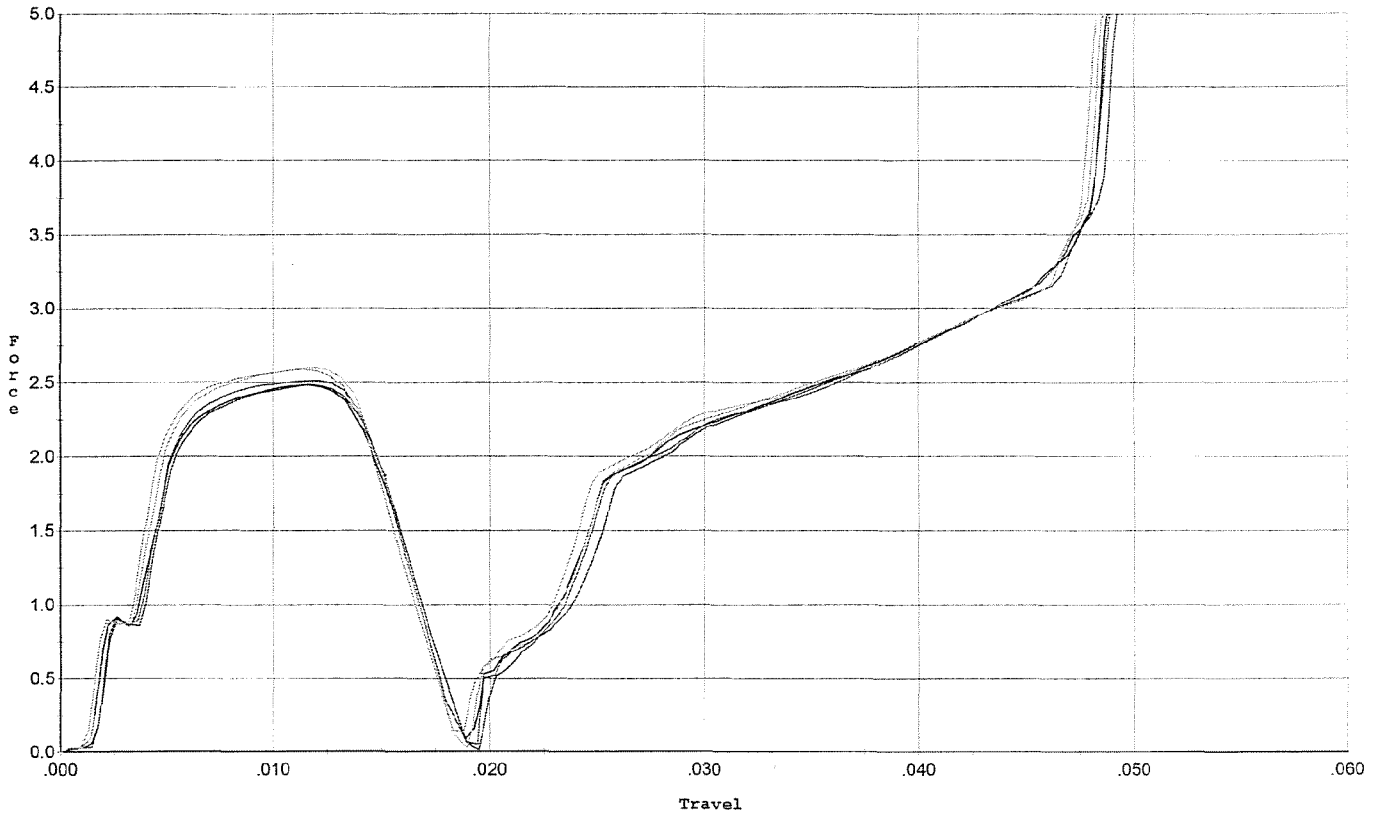
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RPD
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RPD
470	DIS-ASSEMBLE ACTION		2-27-09	RPD
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
490	MAGNAFLUX BOLT		3/5/09	MM
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	MM
540	APPLY COATINGS (BARREL ACTION)		3/6	SP
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		3-13-09	RPD
	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>5.5</u> <u>5.5</u> <u>5.5</u>	3-20-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3</u> <u>3.5</u>	3-20-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-20-09	NW
	J) ASSEMBLE STOCK		3-18-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-20-09	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	3-18-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-18-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.60</u> <u>2.60</u> <u>2.63</u> <u>2.59</u>	3-19-09	TL
	C) FUNCTION		3-20-09	NW
690	PACK		3-20-09	TL

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



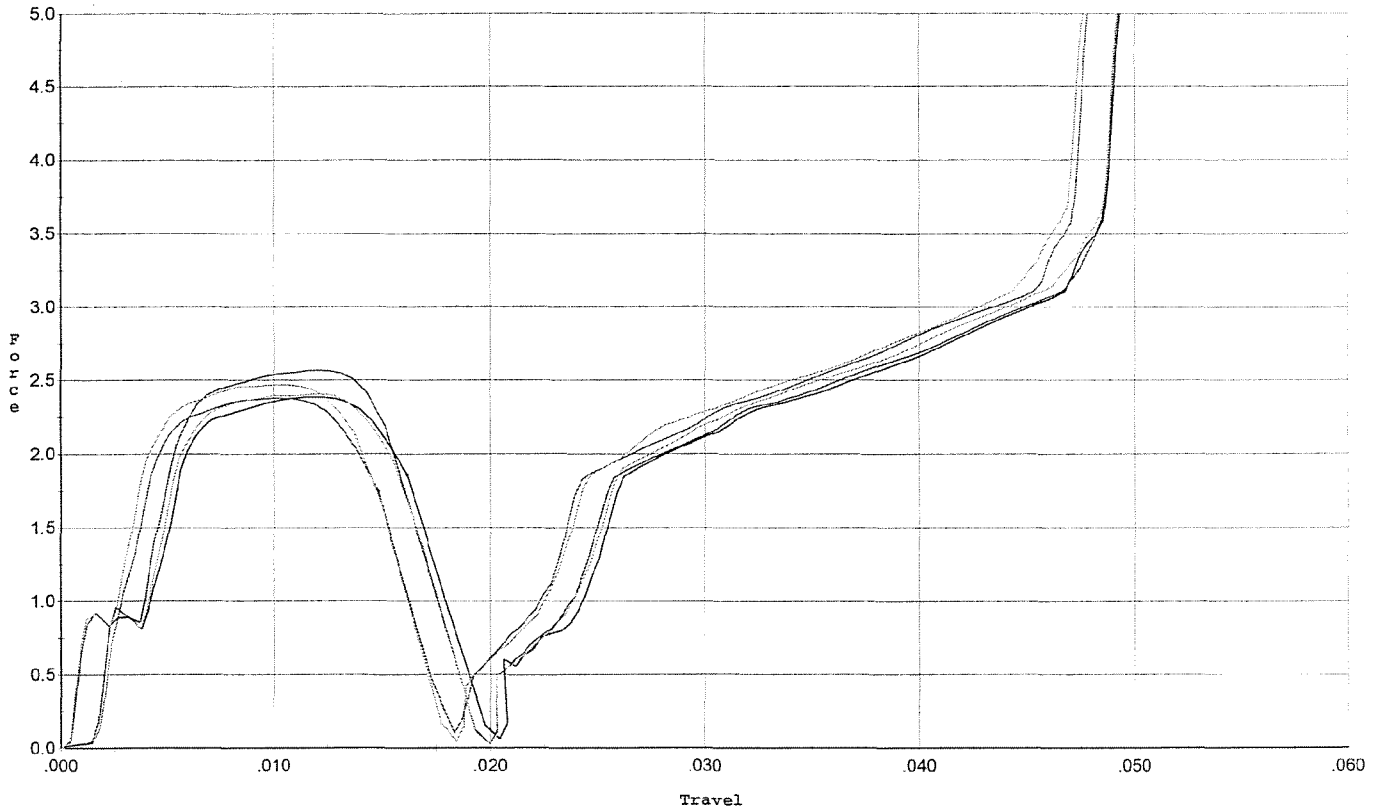
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.484	0.015	0.004	0.037	0.025		Set Trigger
2	2.480	0.015	0.00	0.037	0.026		Set Trigger
3	2.509	0.015	0.00	0.037	0.026		Set Trigger
4	2.599	0.015	0.00	0.036	0.027		Set Trigger
5	2.585	0.014	0.003	0.037	0.025		Set Trigger

A-2.53

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



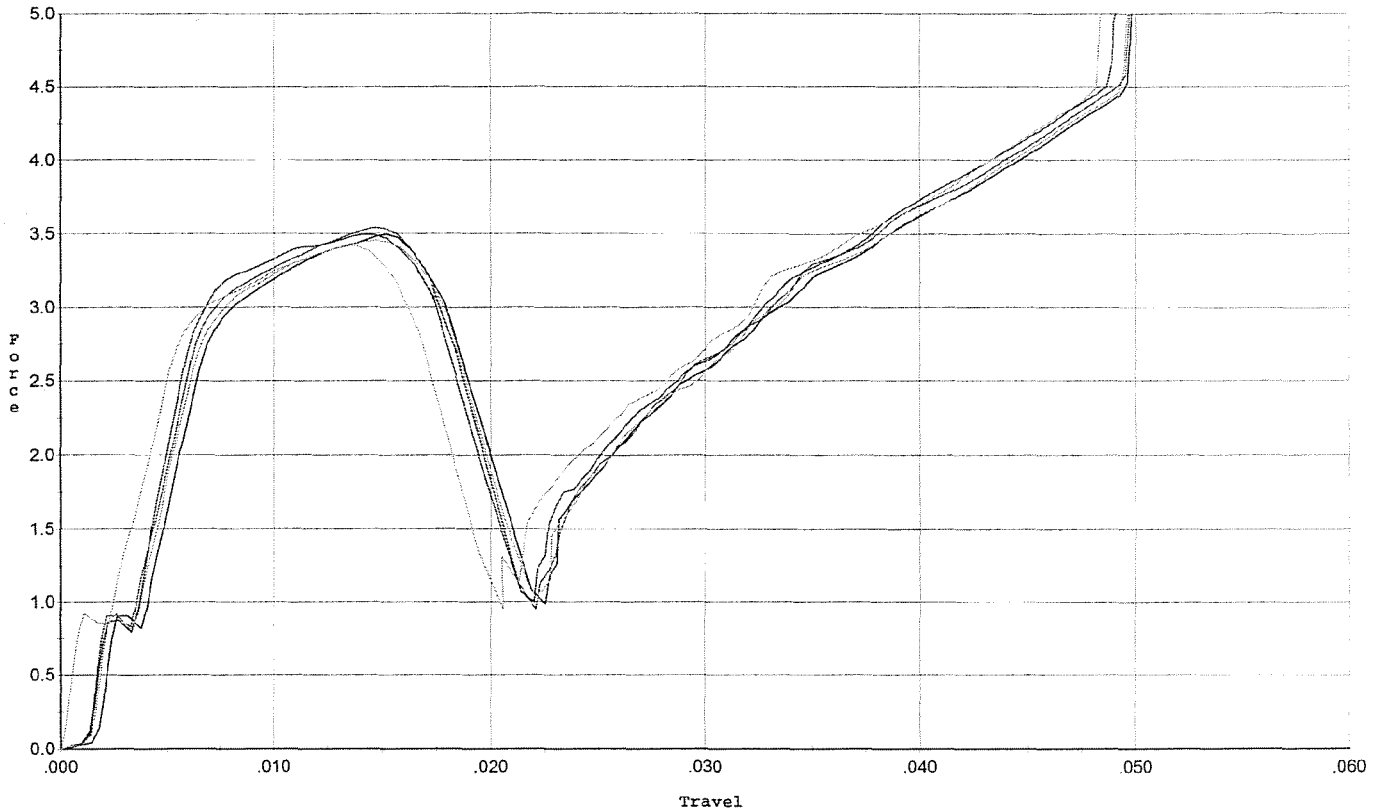
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.566	0.017	0.004	0.036	0.030		Set Trigger
2	2.386	0.016	0.004	0.036	0.026		Set Trigger
3	2.377	0.015	0.00	0.036	0.026		Set Trigger
4	2.407	0.017	0.004	0.036	0.028		Set Trigger
5	2.468	0.015	0.00	0.036	0.027		Set Trigger

A-2.44

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



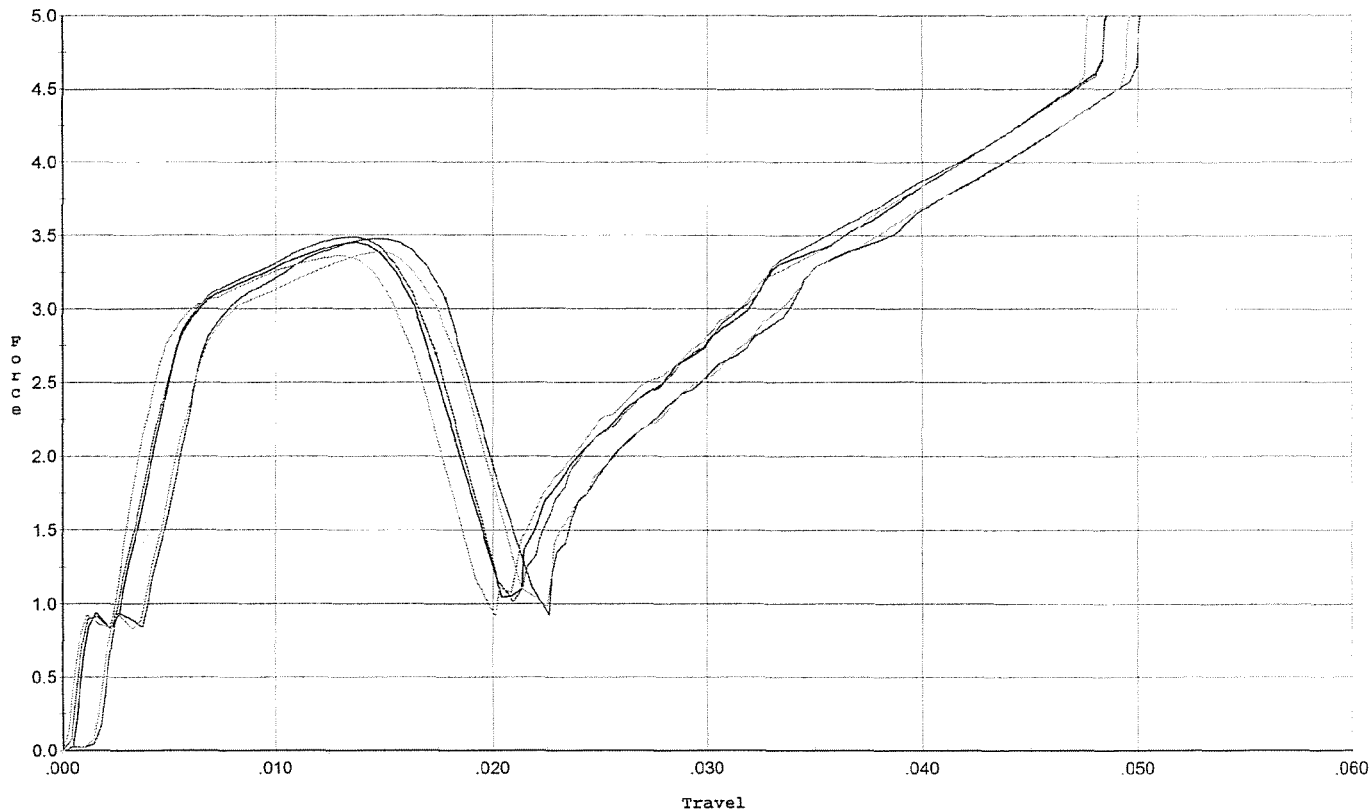
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.494	0.017	0.00	0.032	0.041		Set Trigger
2	3.496	0.020	0.004	0.032	0.045		Set Trigger
3	3.539	0.018	0.004	0.033	0.043		Set Trigger
4	3.419	0.017	0.002	0.032	0.040		Set Trigger
5	3.455	0.018	0.00	0.033	0.041		Set Trigger

A. 3.48

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



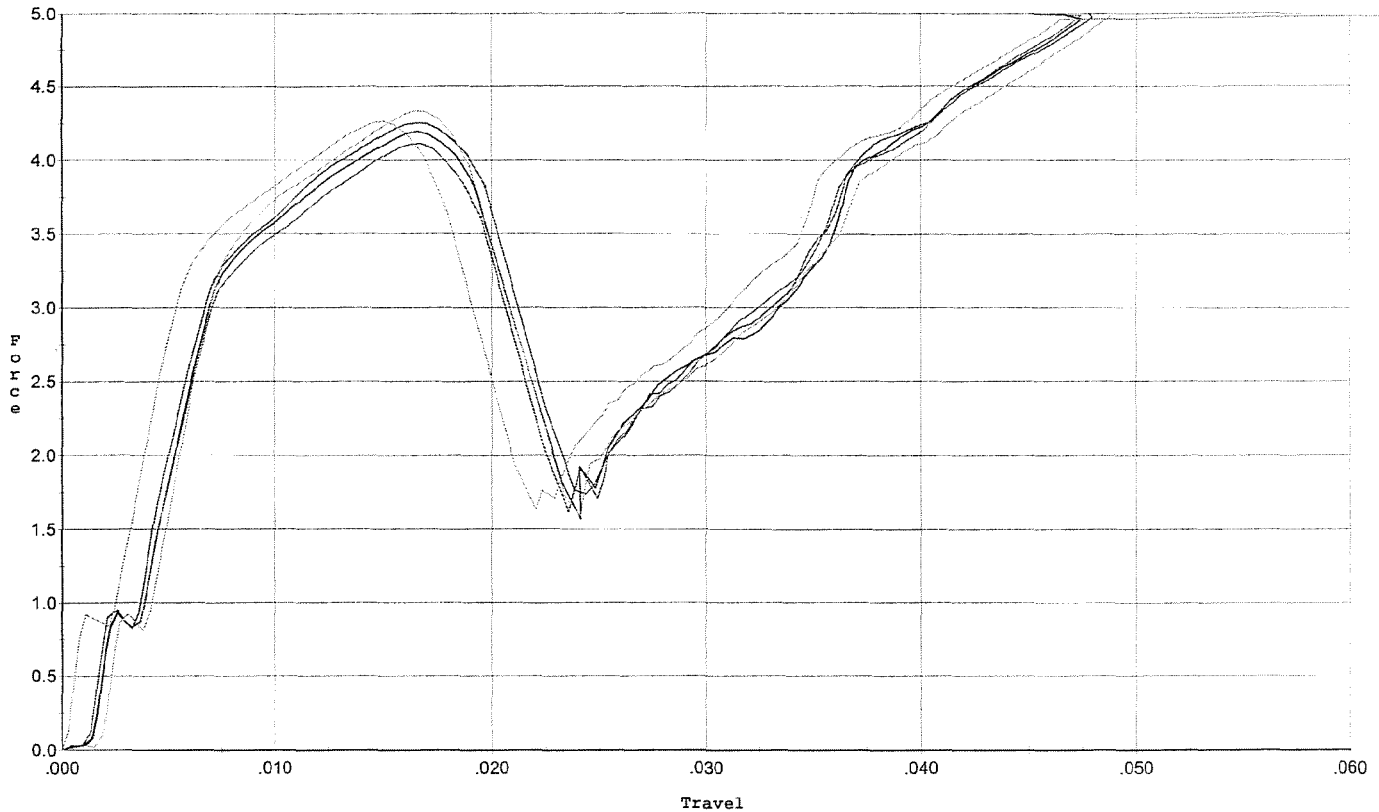
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.476	0.018	0.004	0.033	0.041		Set Trigger
2	3.451	0.018	0.00	0.032	0.044		Set Trigger
3	3.488	0.017	0.00	0.032	0.042		Set Trigger
4	3.390	0.019	0.00	0.033	0.042		Set Trigger
5	3.364	0.016	0.002	0.032	0.039		Set Trigger

A-3.43

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



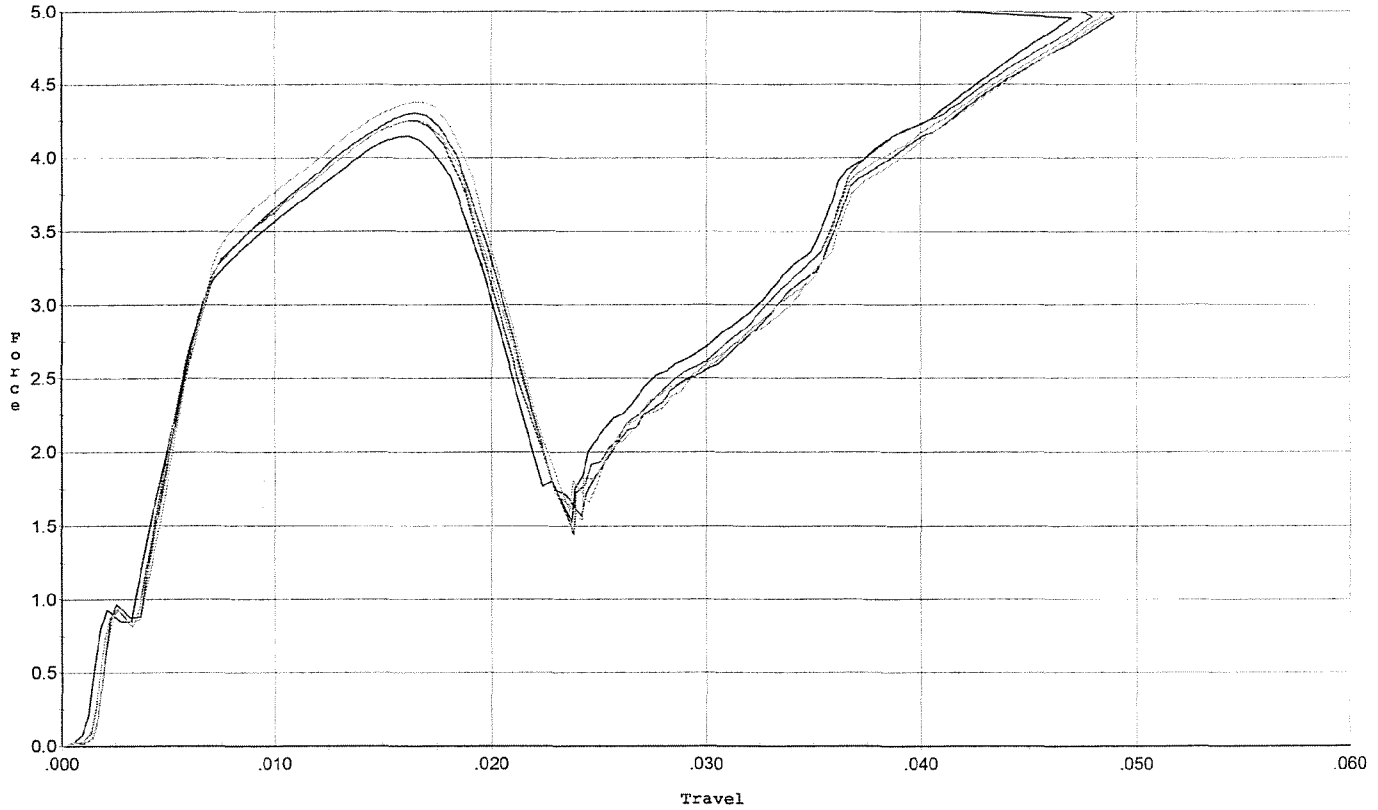
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.250	0.020	0.00	0.030	0.054		Set Trigger
2	4.193	0.019	0.00	0.031	0.051		Set Trigger
3	4.110	0.020	0.00	0.030	0.051		Set Trigger
4	4.333	0.019	0.00	0.031	0.051		Set Trigger
5	4.263	0.018	0.002	0.031	0.051		Set Trigger

A-4.23

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 after 20 cycles +/- 1.0 lb



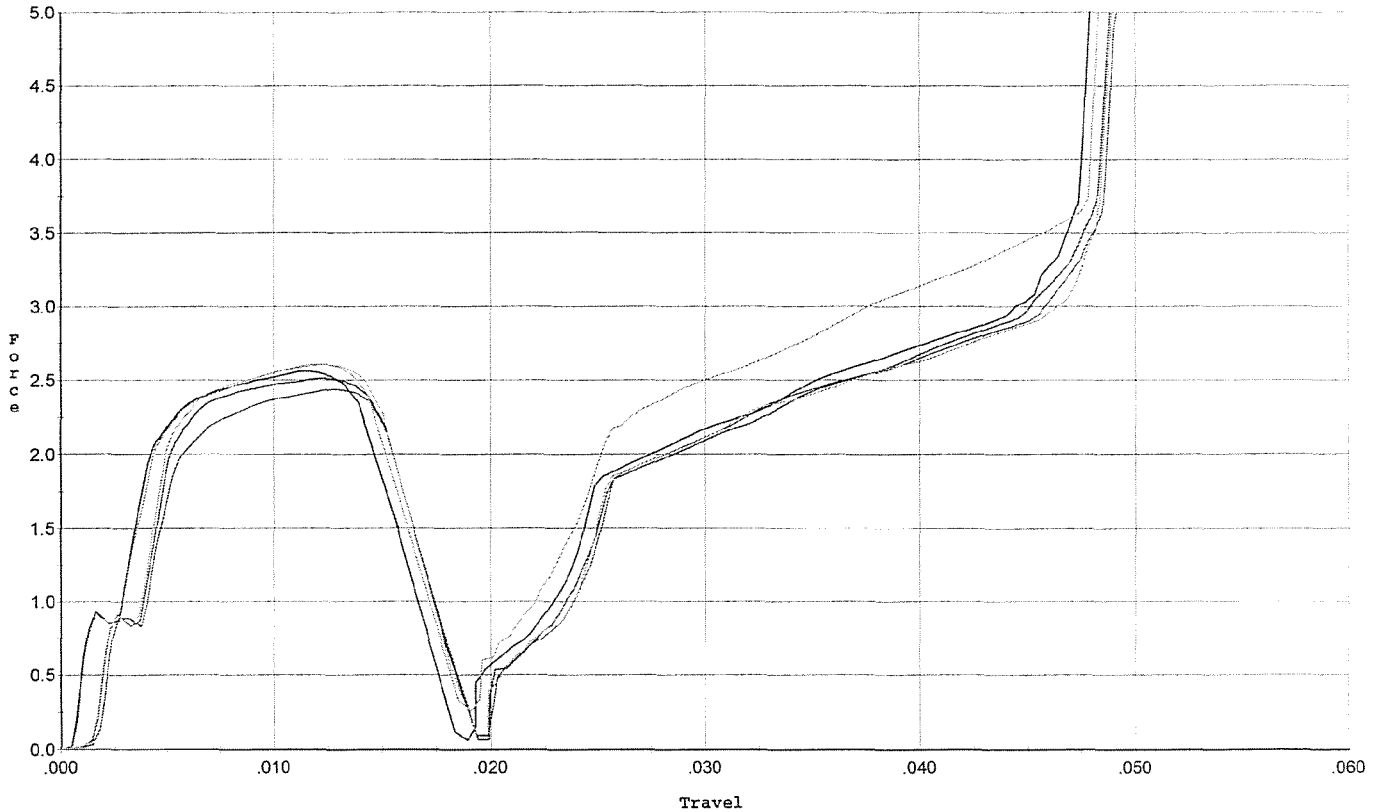
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.307	0.020	0.004	0.031	0.054		Set Trigger
2	4.148	0.020	0.003	0.031	0.052		Set Trigger
3	4.251	0.019	0.00	0.032	0.051		Set Trigger
4	4.382	0.019	0.00	0.031	0.053		Set Trigger
5	4.258	0.021	0.00	0.031	0.056		Set Trigger

A- 41.26

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 test



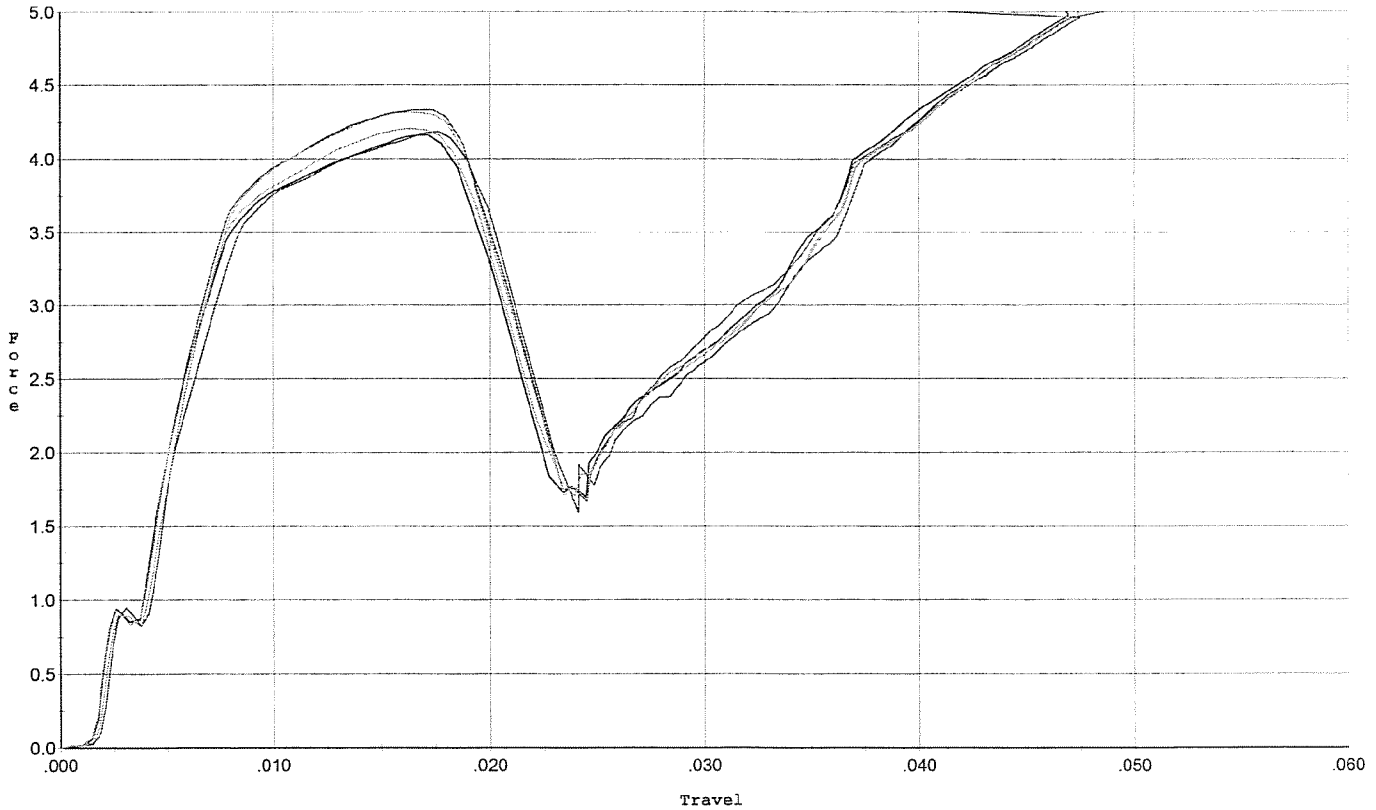
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.512	0.015	0.00	0.036	0.026		Set Trigger
2	2.559	0.016	0.00	0.036	0.029		Set Trigger
3	2.439	0.015	0.004	0.037	0.025		Set Trigger
4	2.604	0.015	0.00	0.037	0.027		Set Trigger
5	2.607	0.016	0.003	0.035	0.030		Set Trigger

A.2-54

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	4.185	0.020	0.00	0.031	0.054		Set Trigger
2	4.161	0.020	0.00	0.031	0.054		Set Trigger
3	4.331	0.021	0.00	0.031	0.058		Set Trigger
4	4.203	0.019	0.00	0.031	0.053		Set Trigger
5	4.315	0.021	0.004	0.031	0.059		Set Trigger

A.4123