

6680 7798

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



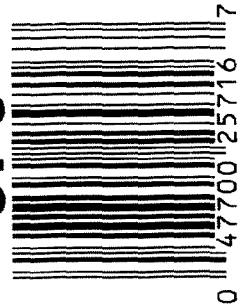
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807798

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807798

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		2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RTZ
480	MAGNAFLUX BBL ACTION		3/5/09	(H)
490	MAGNAFLUX BOLT		3/5/09	ML
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		2-27-09	SP
520	GOFF BLAST BBL / REC		3/6	mon
540	APPLY COATINGS (BARREL ACTION)		3/16	
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		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-16-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

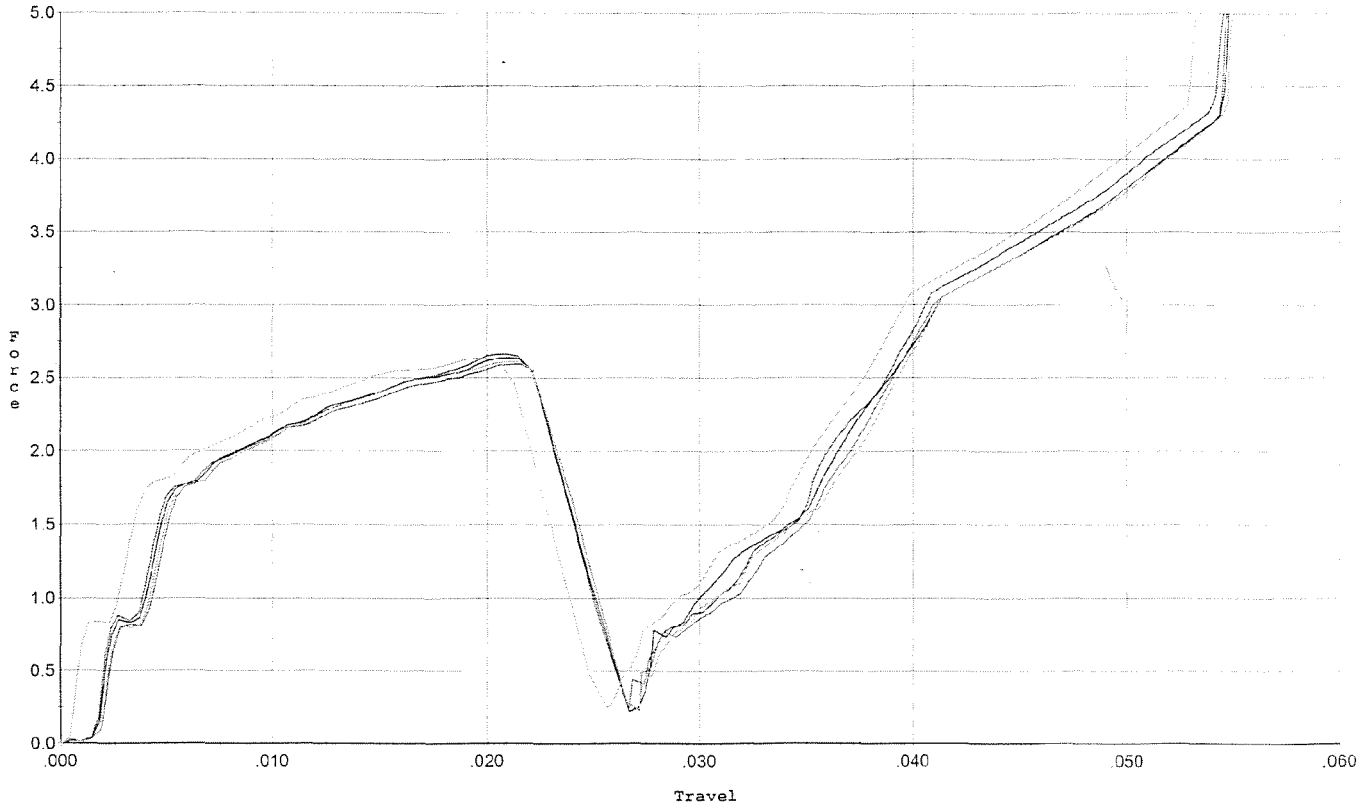
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>5.5</u>	3-18-09	WZ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-18-09	WZ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	3-18-09	WZ
	J) ASSEMBLE STOCK		3-16-09	XZ
	K) ASSEMBLE SWIVEL STUDS		3-18-09	WZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	3-18-09	TC
650	TARGET	<u>PASS</u> FAIL	3-17-09	TC
	MALFUNCTION <i>BAC</i> CORRECTION		3-18-09	TC
	MALFUNCTION <i>OH</i> CORRECTION		3-18-09	TC
	MALFUNCTION CORRECTION			
	MALFUNCTION CORRECTION			
660	INSPECT FOR LIVE AMMO		3-17-09	WZ
670	FINAL INSPECTION A) HEADSPACE		3-18-09	WZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.65</u> <u>2.64</u> <u>2.61</u> <u>2.61</u>	3-18-09	TC
	C) FUNCTION		3-18-09	WZ
690	PACK		3/24/09	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



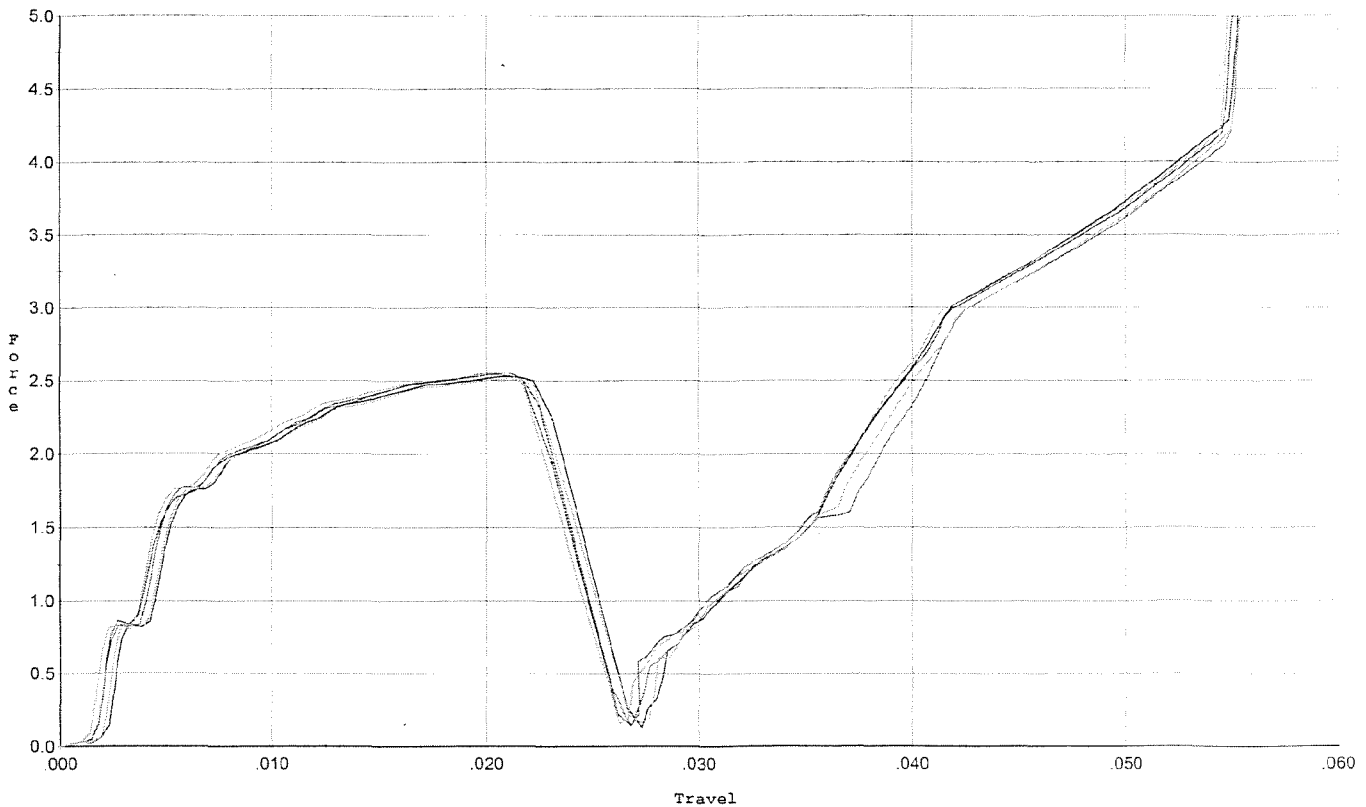
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.022	0.00	0.036	0.041		Set Trigger
2	2.634	0.022	0.00	0.036	0.041		Set Trigger
3	2.593	0.024	0.00	0.036	0.043		Set Trigger
4	2.635	0.021	0.00	0.035	0.042		Set Trigger
5	2.609	0.024	0.00	0.036	0.044		Set Trigger

A-2-62

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



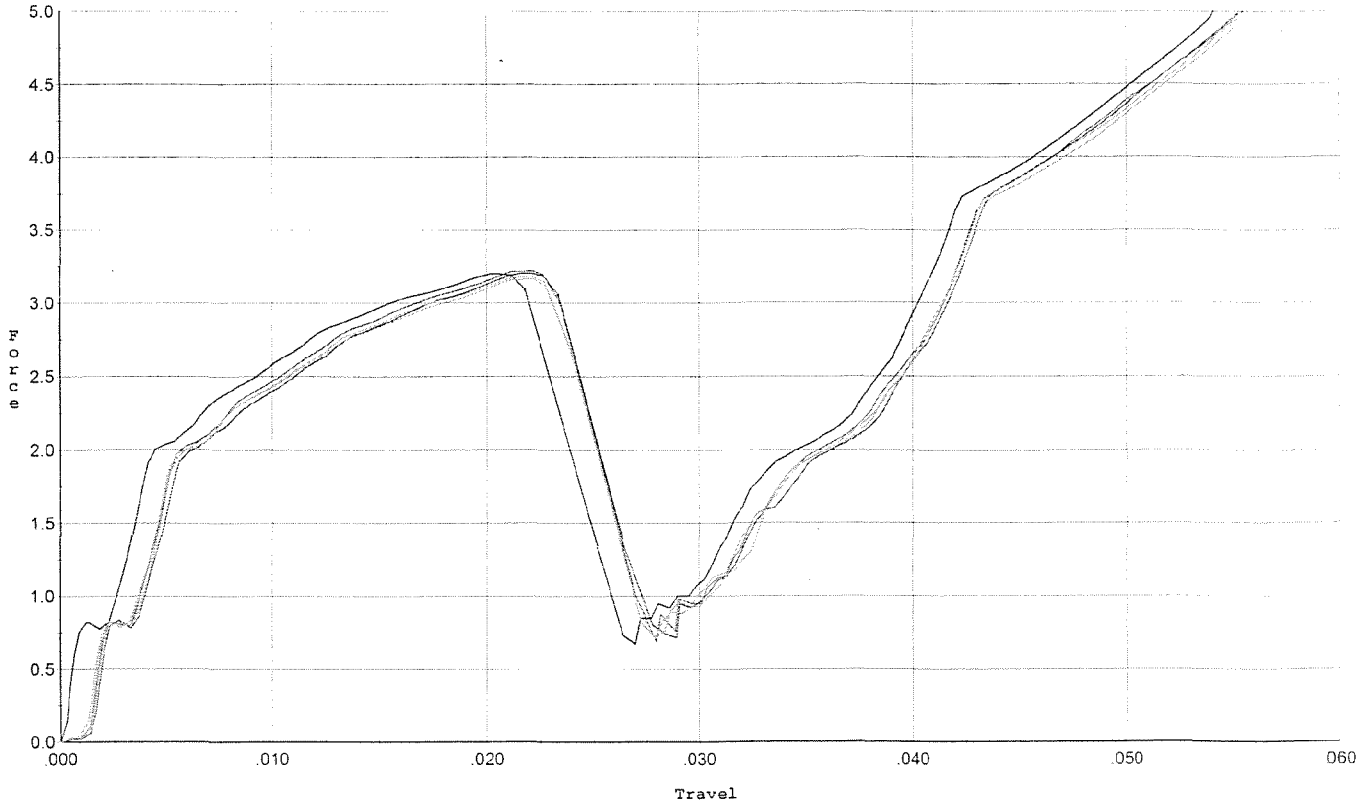
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.556	0.023	0.00	0.036	0.042		Set Trigger
2	2.528	0.023	0.00	0.036	0.041		Set Trigger
3	2.543	0.022	0.00	0.037	0.041		Set Trigger
4	2.513	0.024	0.00	0.036	0.043		Set Trigger
5	2.559	0.022	0.00	0.036	0.040		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: 3.0 lbs ini +/- .75 lb



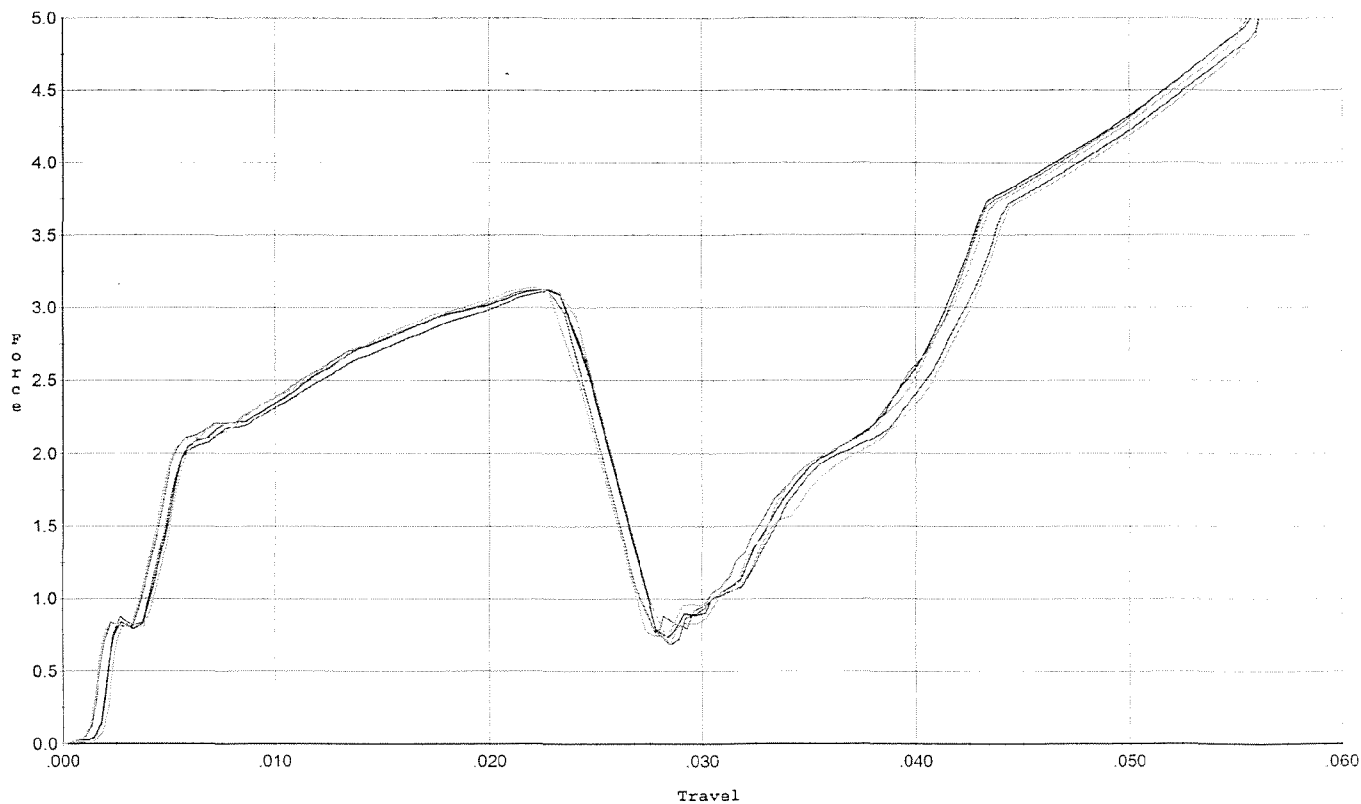
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.202	0.023	0.00	0.034	0.050		Set Trigger
2	3.197	0.022	0.00	0.034	0.050		Set Trigger
3	3.218	0.023	0.004	0.034	0.052		Set Trigger
4	3.161	0.024	0.00	0.034	0.052		Set Trigger
5	3.178	0.024	0.00	0.034	0.052		Set Trigger

A-3-19

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



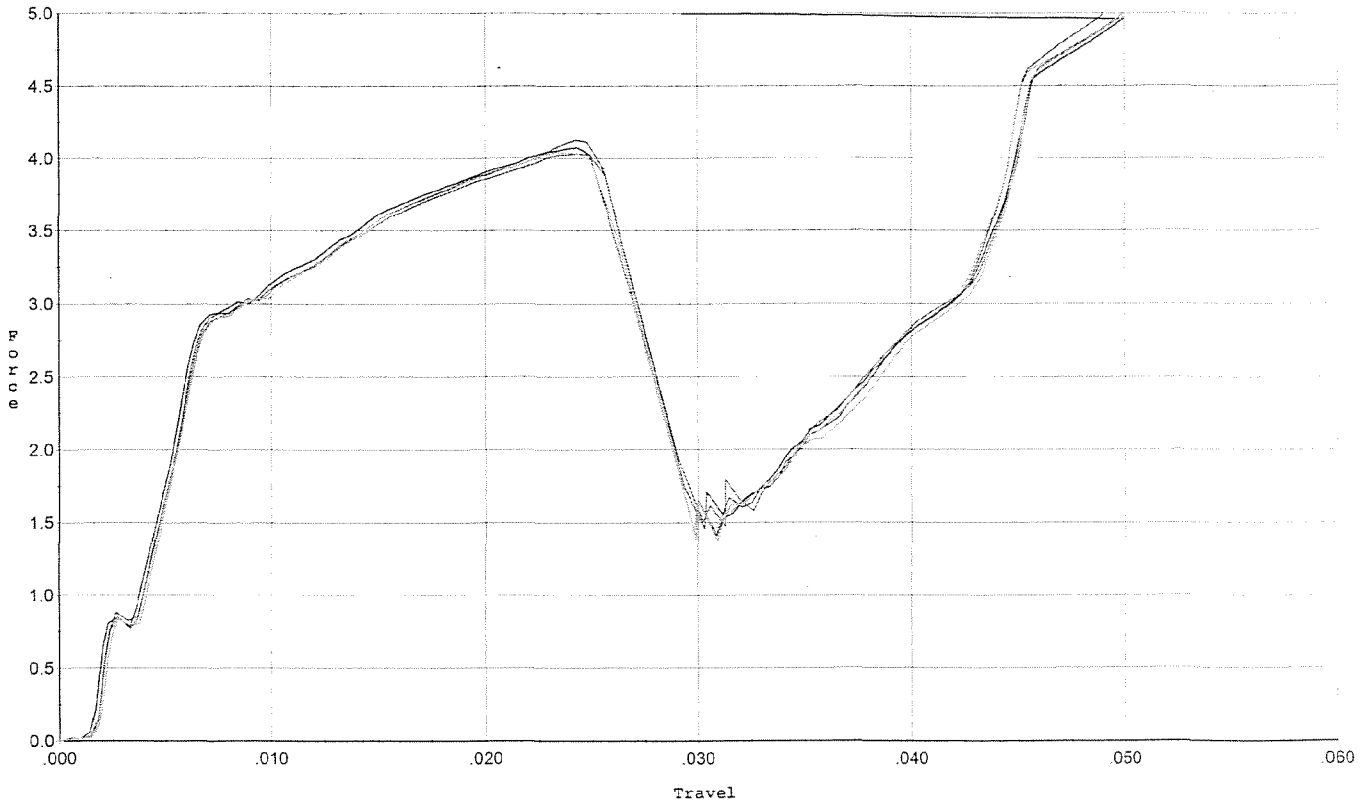
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.115	0.024	0.00	0.035	0.052		Set Trigger
2	3.123	0.025	0.00	0.034	0.052		Set Trigger
3	3.126	0.023	0.004	0.035	0.051		Set Trigger
4	3.141	0.024	0.00	0.034	0.052		Set Trigger
5	3.131	0.024	0.002	0.035	0.051		Set Trigger

A-3-12

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



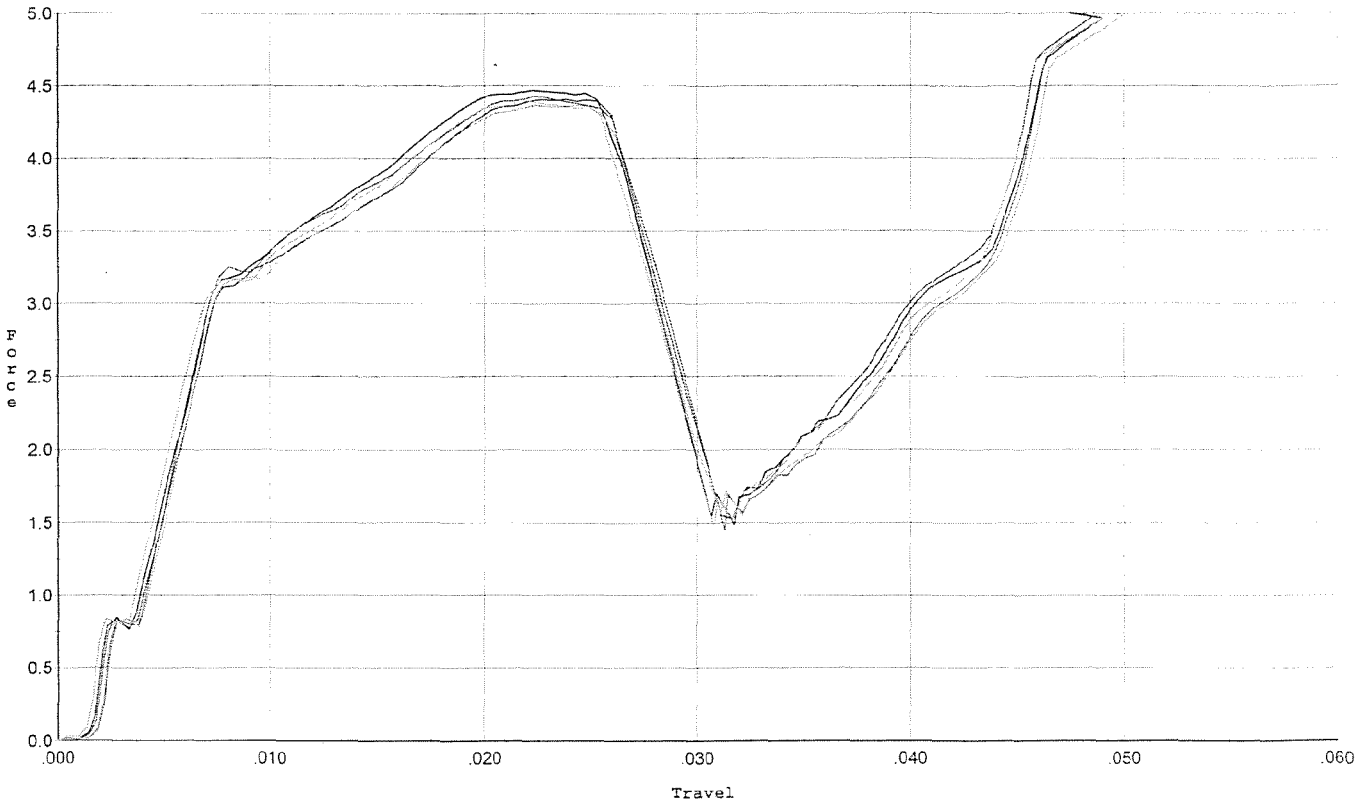
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.127	0.026	0.00	0.032	0.070		Set Trigger
2	4.072	0.027	0.00	0.032	0.074		Set Trigger
3	4.031	0.026	0.00	0.033	0.070		Set Trigger
4	4.034	0.027	0.00	0.032	0.073		Set Trigger
5	4.042	0.026	0.00	0.032	0.072		Set Trigger

A.4.06

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 lb



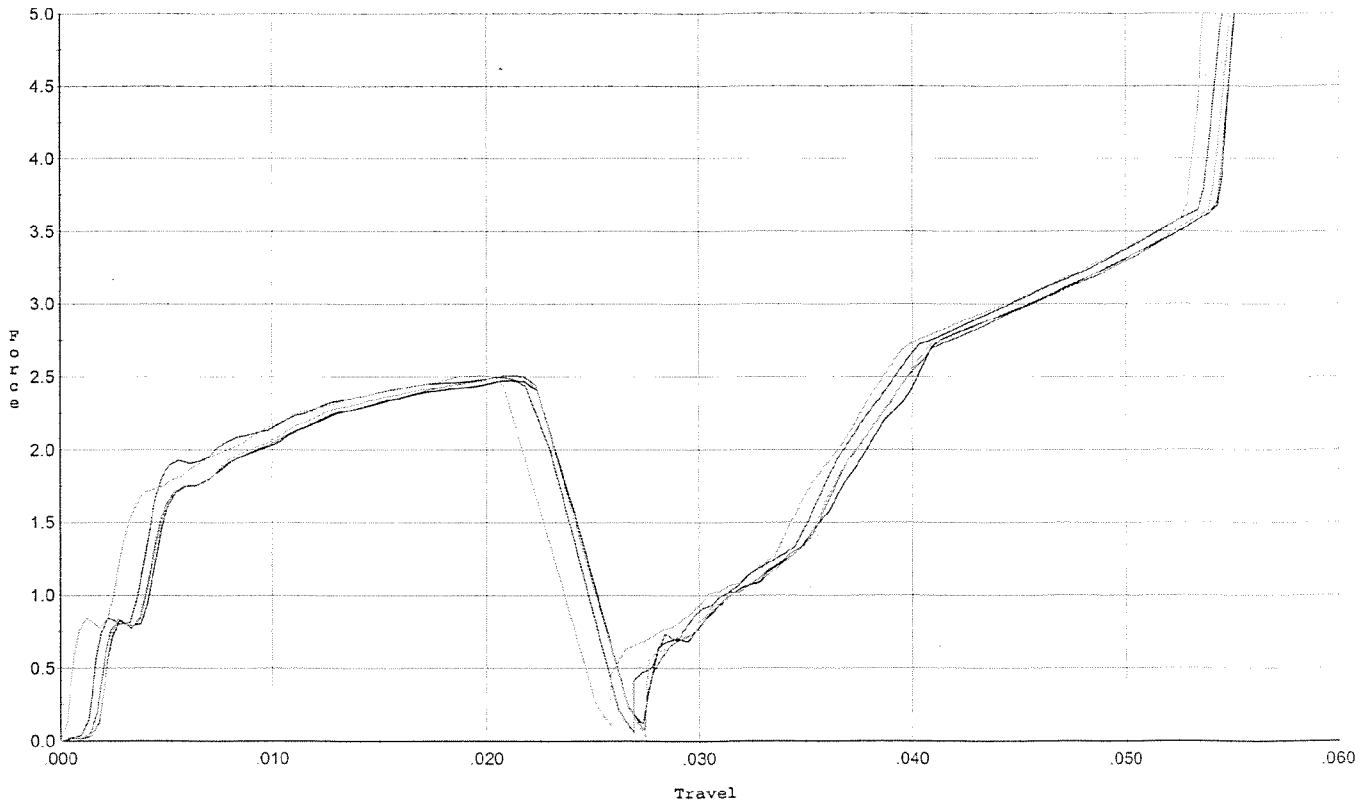
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.408	0.026	0.00	0.032	0.076		Set Trigger
2	4.468	0.026	0.00	0.032	0.080		Set Trigger
3	4.428	0.028	0.002	0.031	0.084		Set Trigger
4	4.396	0.028	0.004	0.032	0.082		Set Trigger
5	4.369	0.026	0.002	0.032	0.076		Set Trigger

A 4.41

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



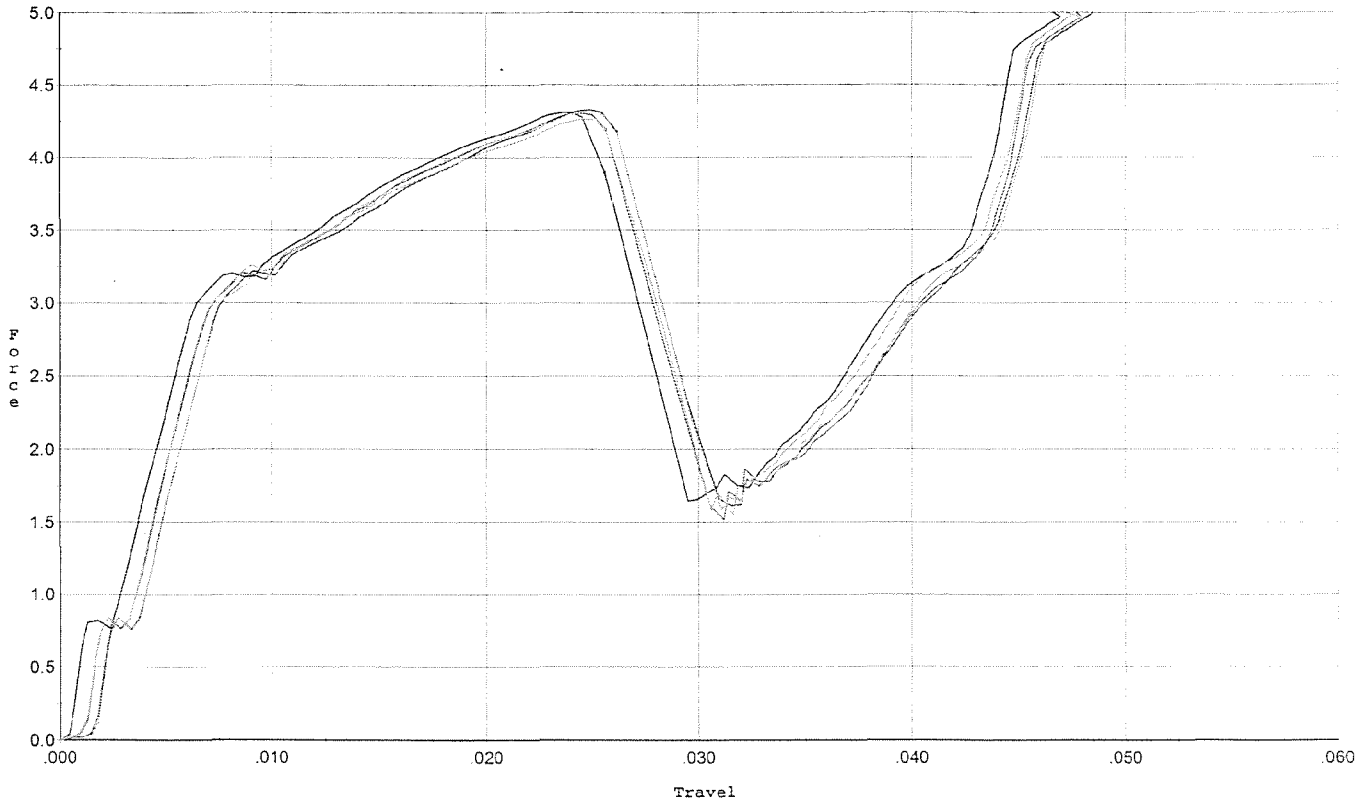
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.023	0.00	0.036	0.043		Set Trigger
2	2.474	0.024	0.00	0.036	0.043		Set Trigger
3	2.509	0.024	0.00	0.036	0.043		Set Trigger
4	2.501	0.022	0.00	0.036	0.040		Set Trigger
5	2.511	0.023	0.00	0.036	0.043		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

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

Model: M/24
Serial No: Form #F005
Trigger: 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	4.329	0.026	0.00	0.032	0.075		Set Trigger
2	4.313	0.026	0.00	0.031	0.076		Set Trigger
3	4.304	0.026	0.00	0.032	0.075		Set Trigger
4	4.314	0.026	0.00	0.032	0.076		Set Trigger
5	4.265	0.028	0.00	0.032	0.080		Set Trigger

A-4.30