

G680 7799

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



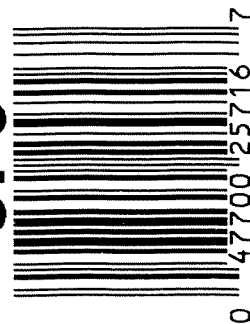
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807799

UPC



GUN SERIAL # G6807799

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD.
430	ASSEMBLE TO STOCK		2-27-09	R.P.
440	PROOF		2-27-09	SPD.
460	CHECK HEADSPACE		2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION		3/5/09	(A)
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	MTM
540	APPLY COATINGS (BARREL ACTION)		3/11	
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		3-13-09	SPD.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

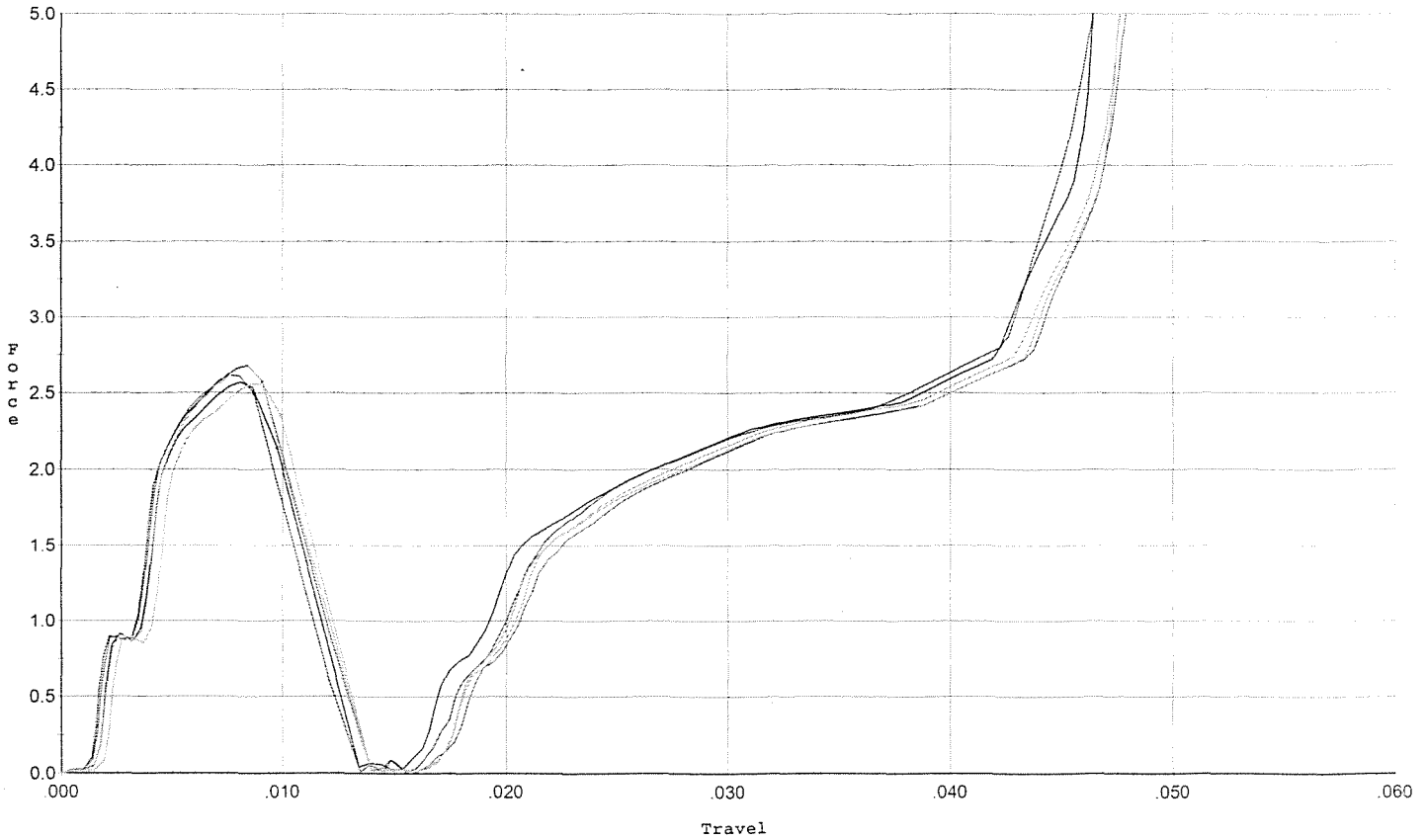
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5</u> <u>5</u>	3-20-09	WN
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	WN
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-20-09	WN
	J) ASSEMBLE STOCK			3-13-09	RP
	K) ASSEMBLE SWIVEL STUDS			3-20-09	WN
	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	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			3-18-09	RP
670	FINAL INSPECTION A) HEADSPACE			3-20-09	WN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.84</u> <u>2.89</u> <u>2.76</u> <u>2.86</u>	3-19-09	K
	C) FUNCTION			3-20-09	WN
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



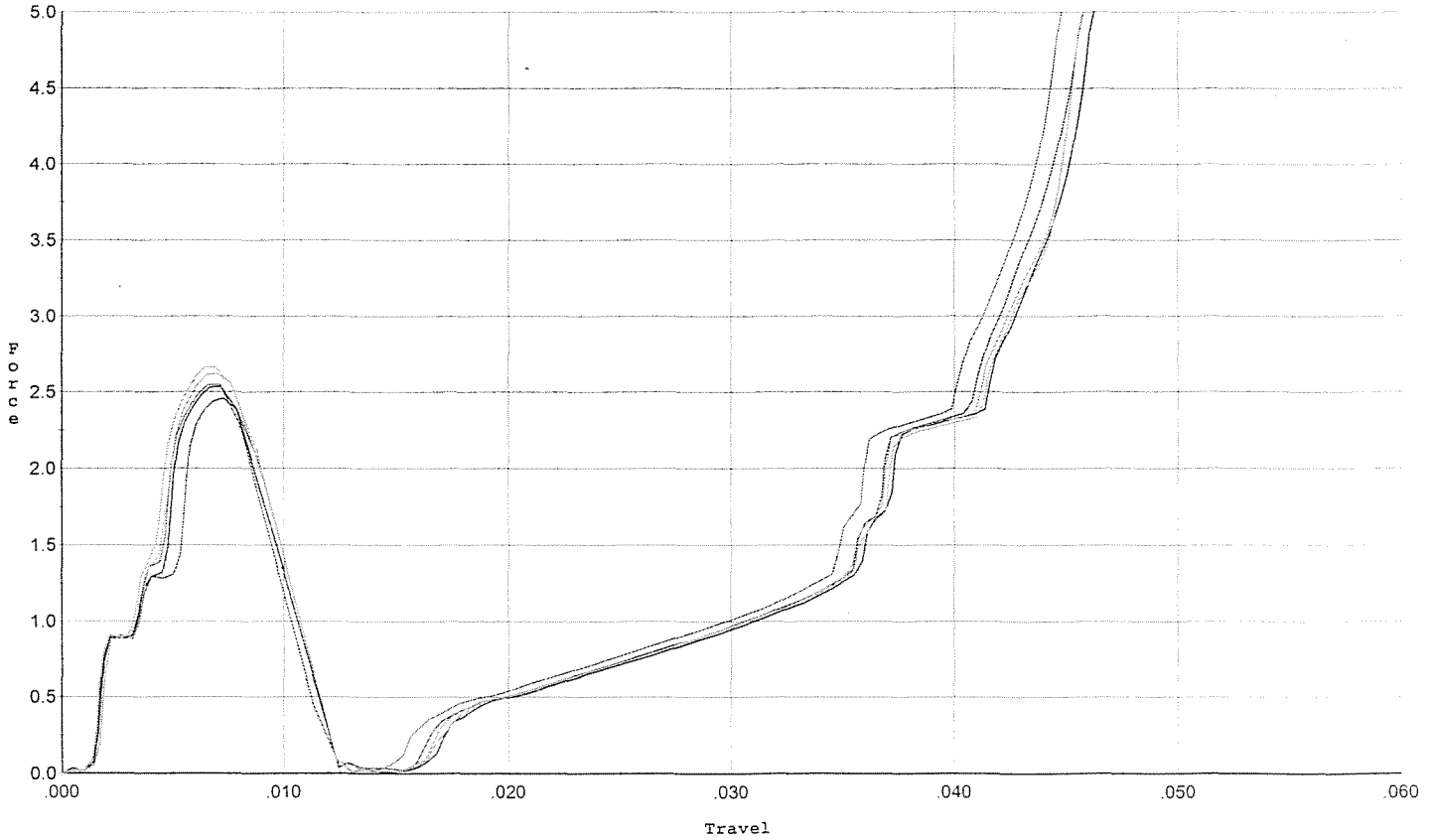
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.614	0.009	0.003	0.040	0.013		Set Trigger
2	2.567	0.010	0.00	0.040	0.014		Set Trigger
3	2.677	0.009	0.00	0.041	0.014		Set Trigger
4	2.669	0.011	0.00	0.040	0.017		Set Trigger
5	2.559	0.010	0.002	0.040	0.014		Set Trigger

A.2.61

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



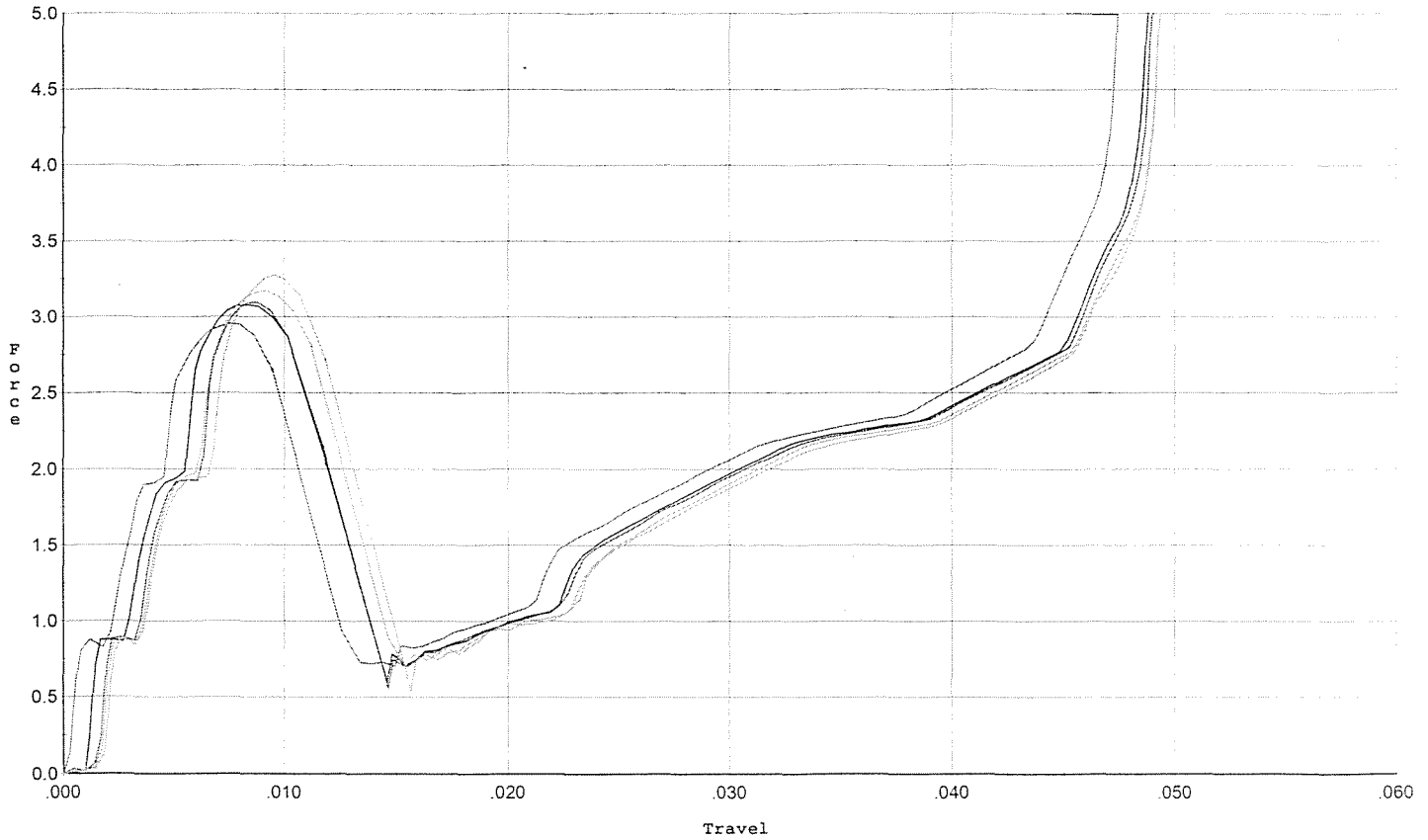
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.459	0.009	0.00	0.040	0.012		Set Trigger
2	2.535	0.010	0.003	0.040	0.013		Set Trigger
3	2.547	0.008	0.00	0.039	0.011		Set Trigger
4	2.664	0.009	0.00	0.040	0.013		Set Trigger
5	2.622	0.009	0.00	0.040	0.012		Set Trigger

A-2-56

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



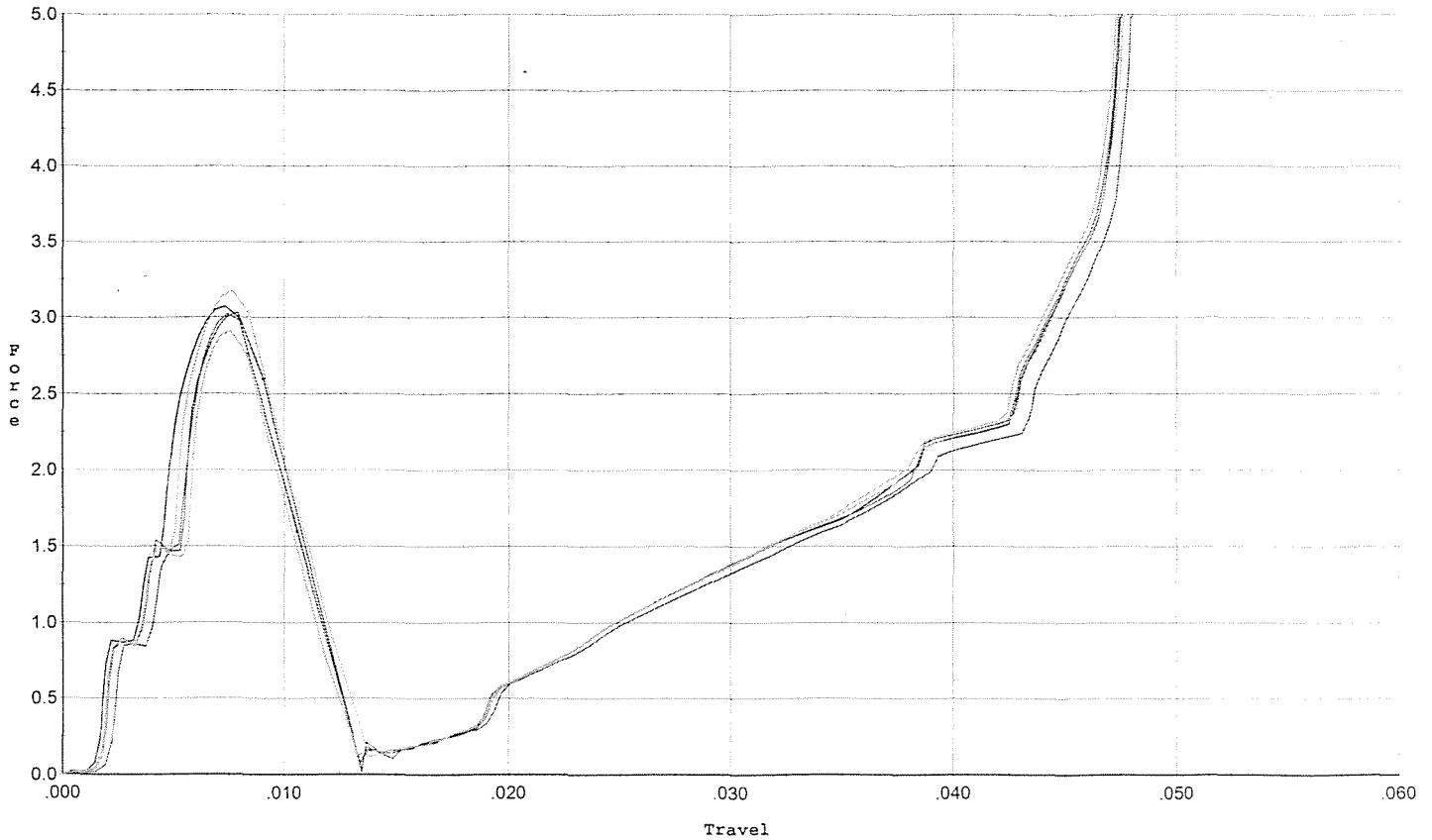
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.095	0.012	0.00	0.040	0.020		Set Trigger
2	3.077	0.012	0.003	0.040	0.022		Set Trigger
3	2.954	0.009	0.00	0.040	0.018		Set Trigger
4	3.171	0.011	0.00	0.040	0.020		Set Trigger
5	3.275	0.012	0.00	0.039	0.021		Set Trigger

A.3.11

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



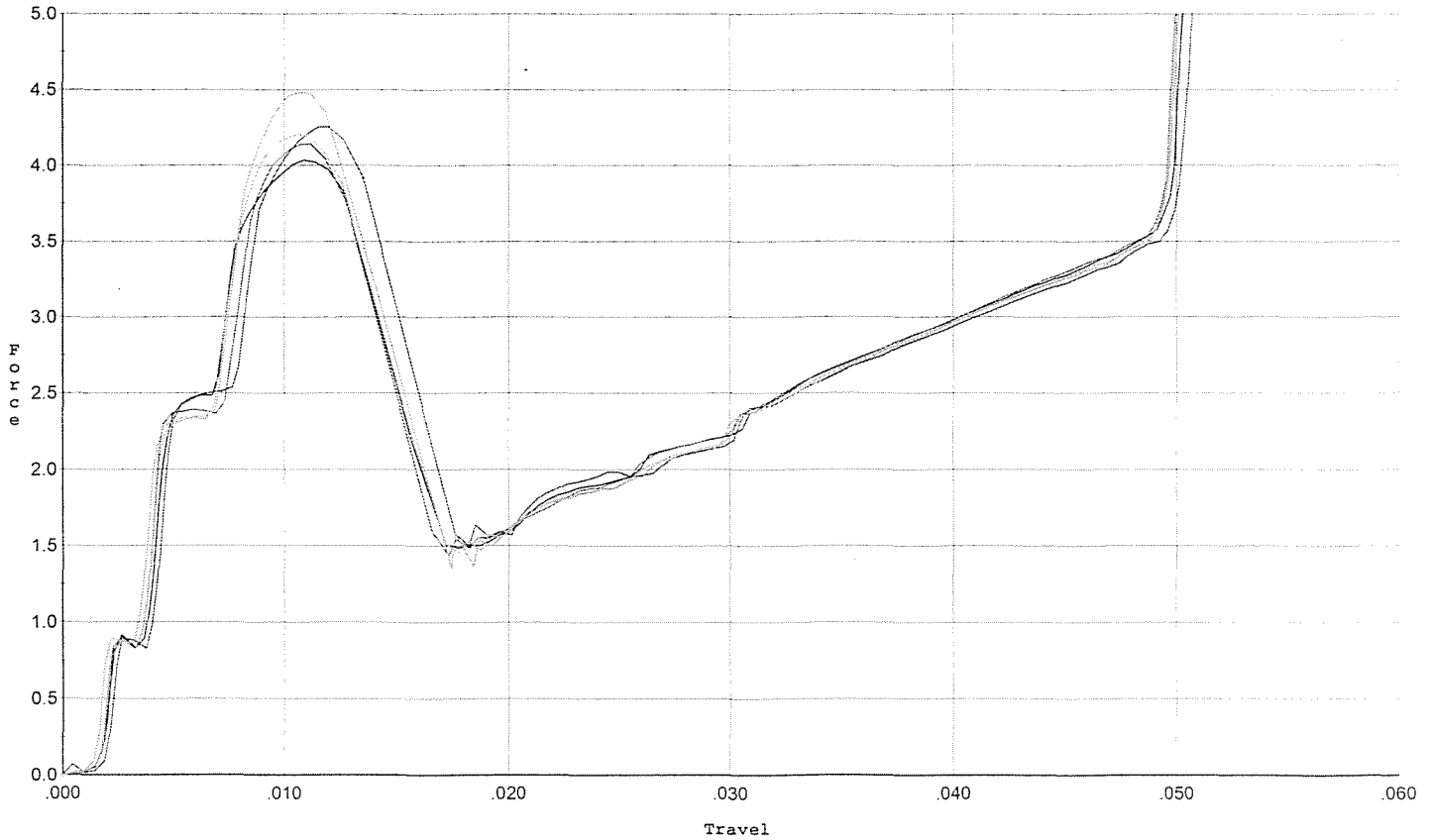
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.030	0.009	0.002	0.041	0.013		Set Trigger
2	3.072	0.011	0.00	0.041	0.017		Set Trigger
3	3.020	0.010	0.00	0.041	0.016		Set Trigger
4	3.173	0.008	0.00	0.041	0.013		Set Trigger
5	2.909	0.008	0.006	0.041	0.012		Set Trigger

A.3.04

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



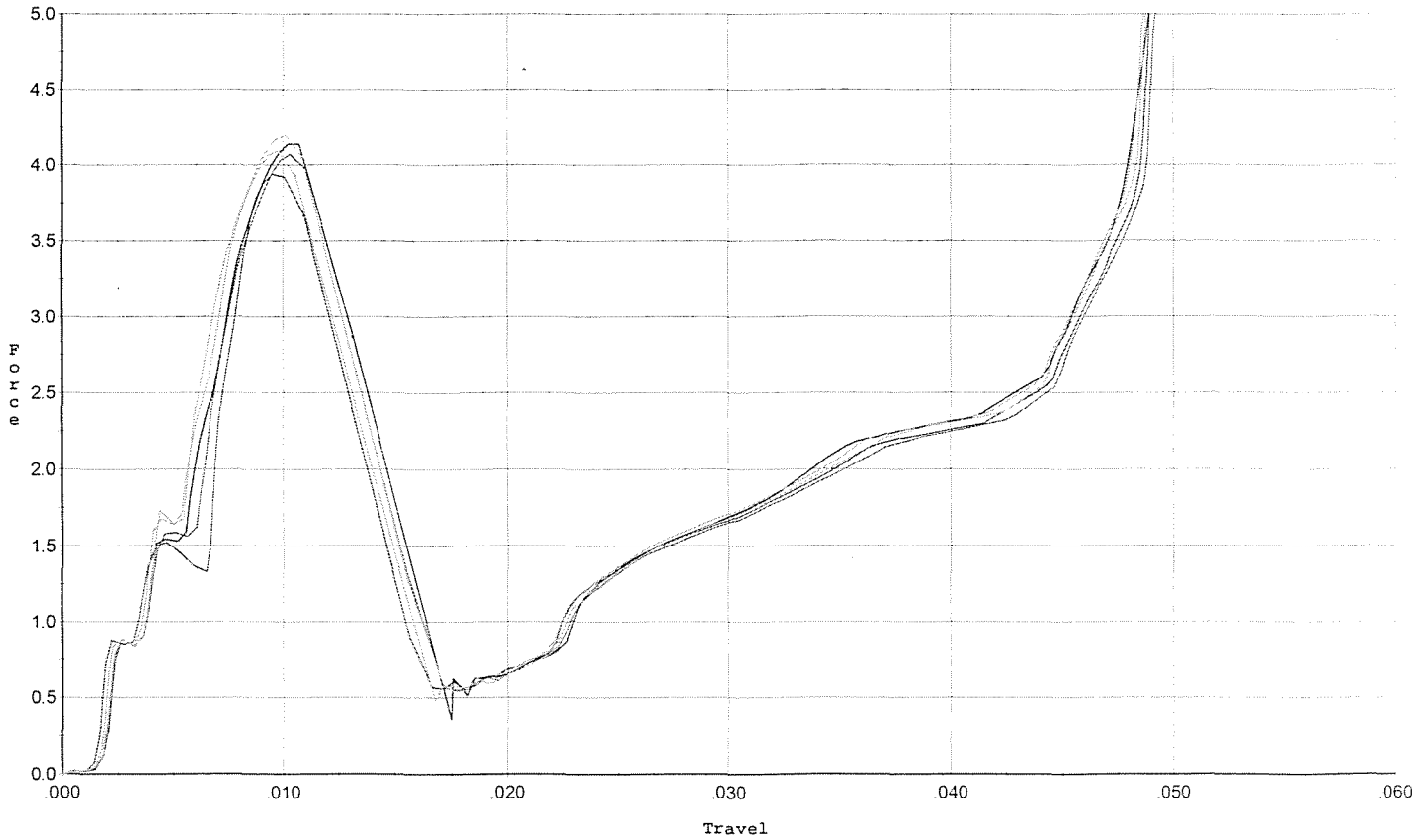
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.253	0.014	0.004	0.037	0.032		Set Trigger
2	4.034	0.013	0.00	0.037	0.029		Set Trigger
3	4.140	0.013	0.007	0.037	0.029		Set Trigger
4	4.208	0.013	0.003	0.037	0.030		Set Trigger
5	4.484	0.014	0.00	0.037	0.034		Set Trigger

A-4.22

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



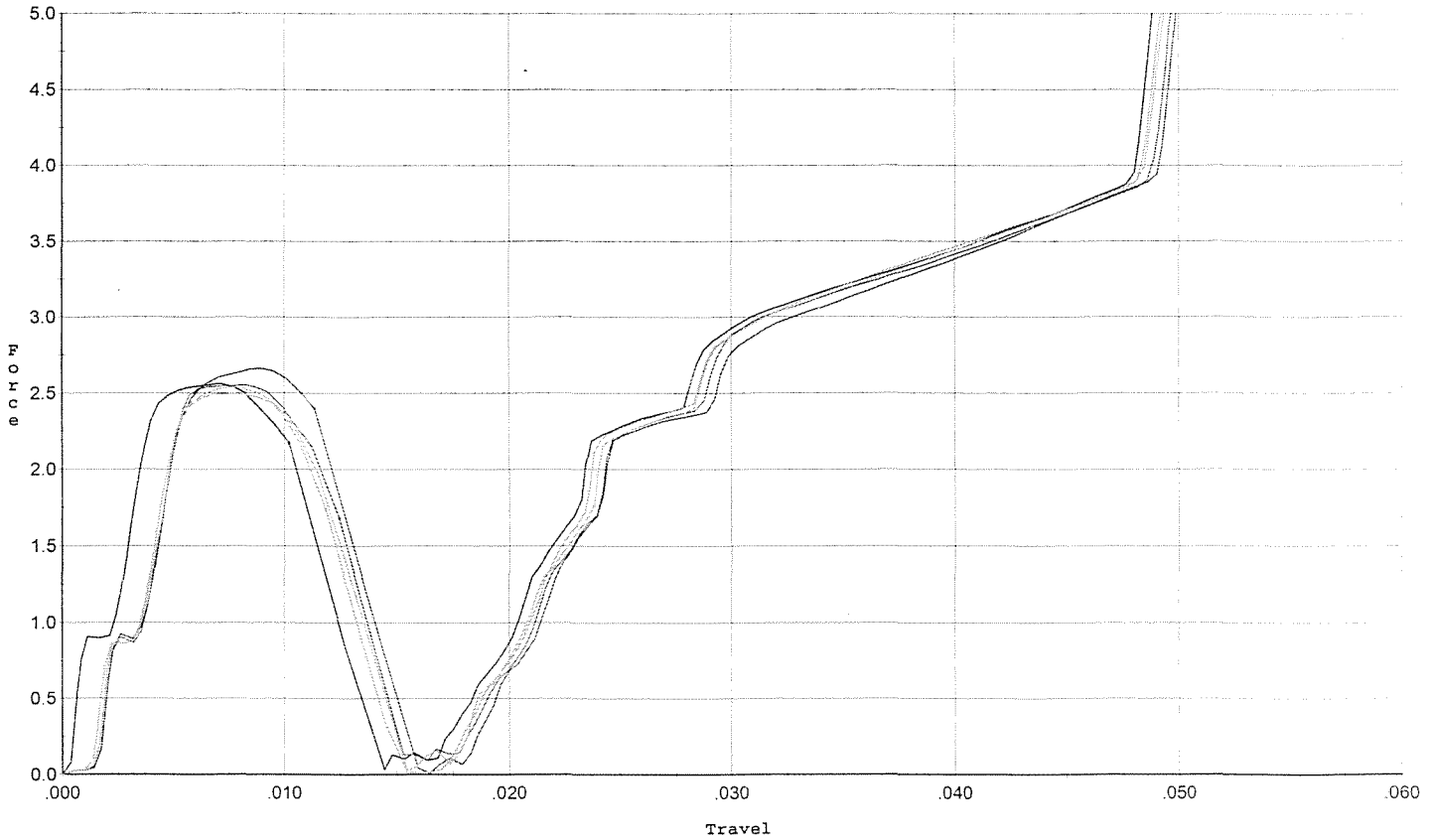
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.939	0.011	0.007	0.039	0.021		Set Trigger
2	4.134	0.013	0.00	0.038	0.027		Set Trigger
3	4.069	0.011	0.006	0.039	0.022		Set Trigger
4	4.199	0.011	0.00	0.038	0.023		Set Trigger
5	4.092	0.011	0.00	0.039	0.022		Set Trigger

A-4.08

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



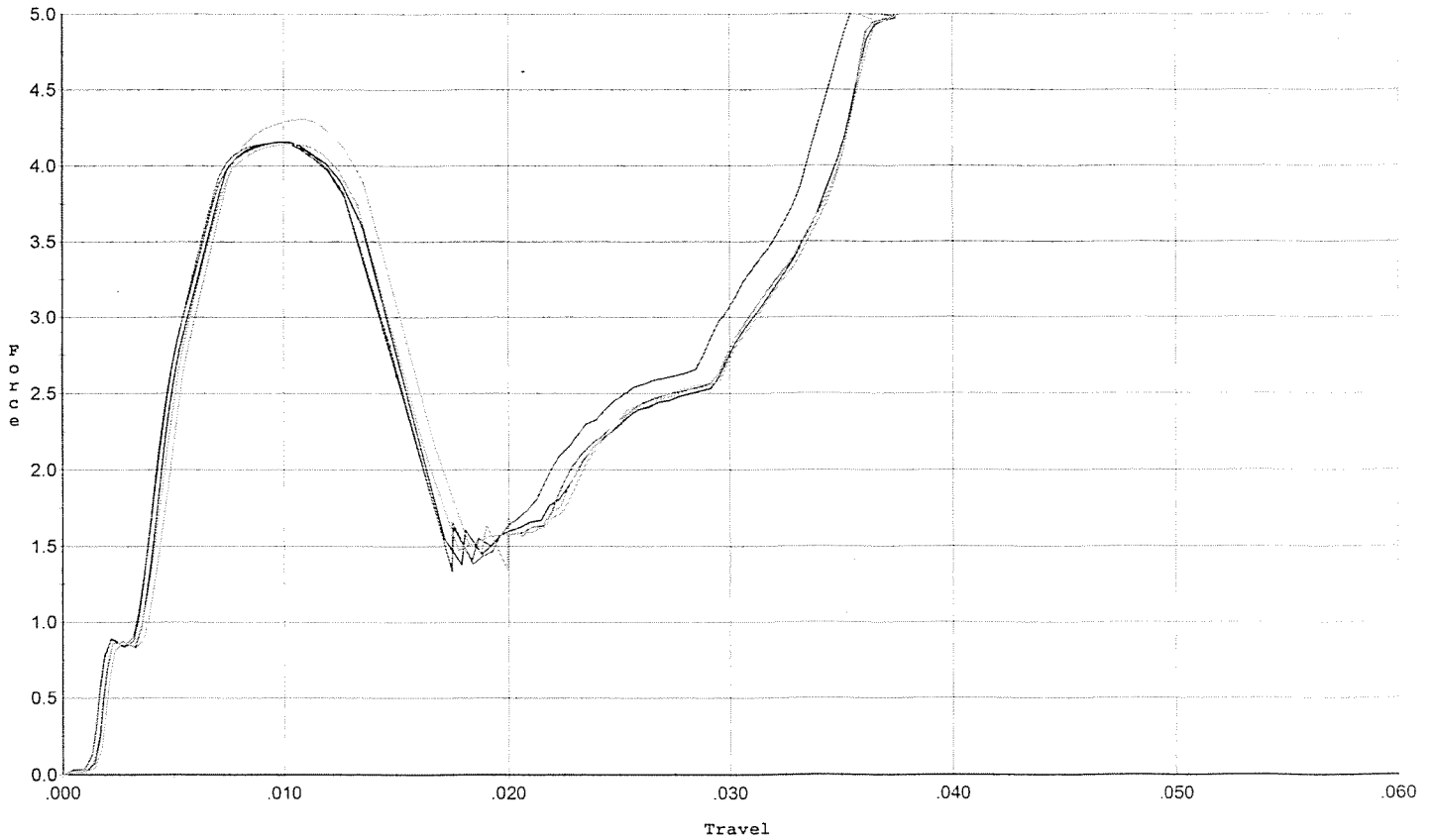
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.664	0.011	0.00	0.039	0.019		Set Trigger
2	2.562	0.010	0.00	0.040	0.018		Set Trigger
3	2.553	0.012	0.00	0.039	0.020		Set Trigger
4	2.540	0.013	0.00	0.039	0.021		Set Trigger
5	2.498	0.012	0.00	0.039	0.018		Set Trigger

A-2-56

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 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	4.156	0.015	0.00	0.032	0.038		Set Trigger
2	4.158	0.014	0.004	0.035	0.034		Set Trigger
3	4.153	0.015	0.00	0.035	0.037		Set Trigger
4	4.142	0.013	0.00	0.035	0.033		Set Trigger
5	4.311	0.014	0.00	0.035	0.034		Set Trigger

A-4.18