

66807806

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



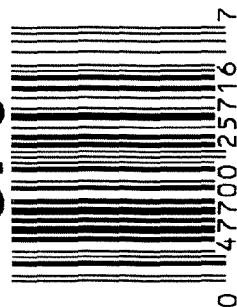
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807806

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66807806

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAGNA-FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/5/09	
490	MAGNAFLUX BOLT		3/5/09	RP
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/10	man
540	APPLY COATINGS (BARREL ACTION)		5/10	
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

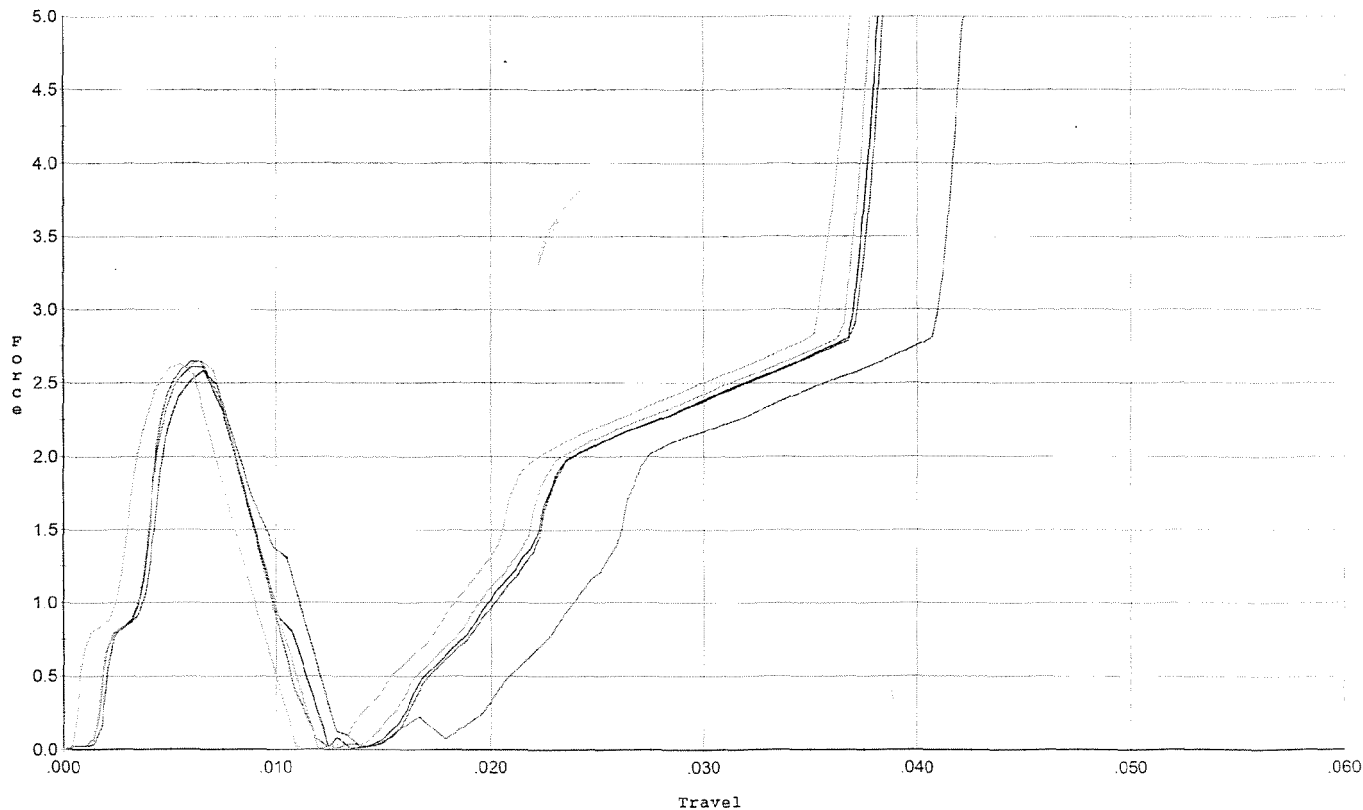
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>6</u> <u>5.5</u>	3-20-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	3-20-09	NW
	J) ASSEMBLE STOCK		3-16-09	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 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	3-19-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-19-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.67</u> <u>2.55</u> <u>2.54</u> <u>2.63</u>	3-20-09	TC
	C) FUNCTION		3-20-09	NW
690	PACK		3-21-09	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile
GunType: SWS
Make: Rifle
Note: Remington
C Schults 3/16/2009

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



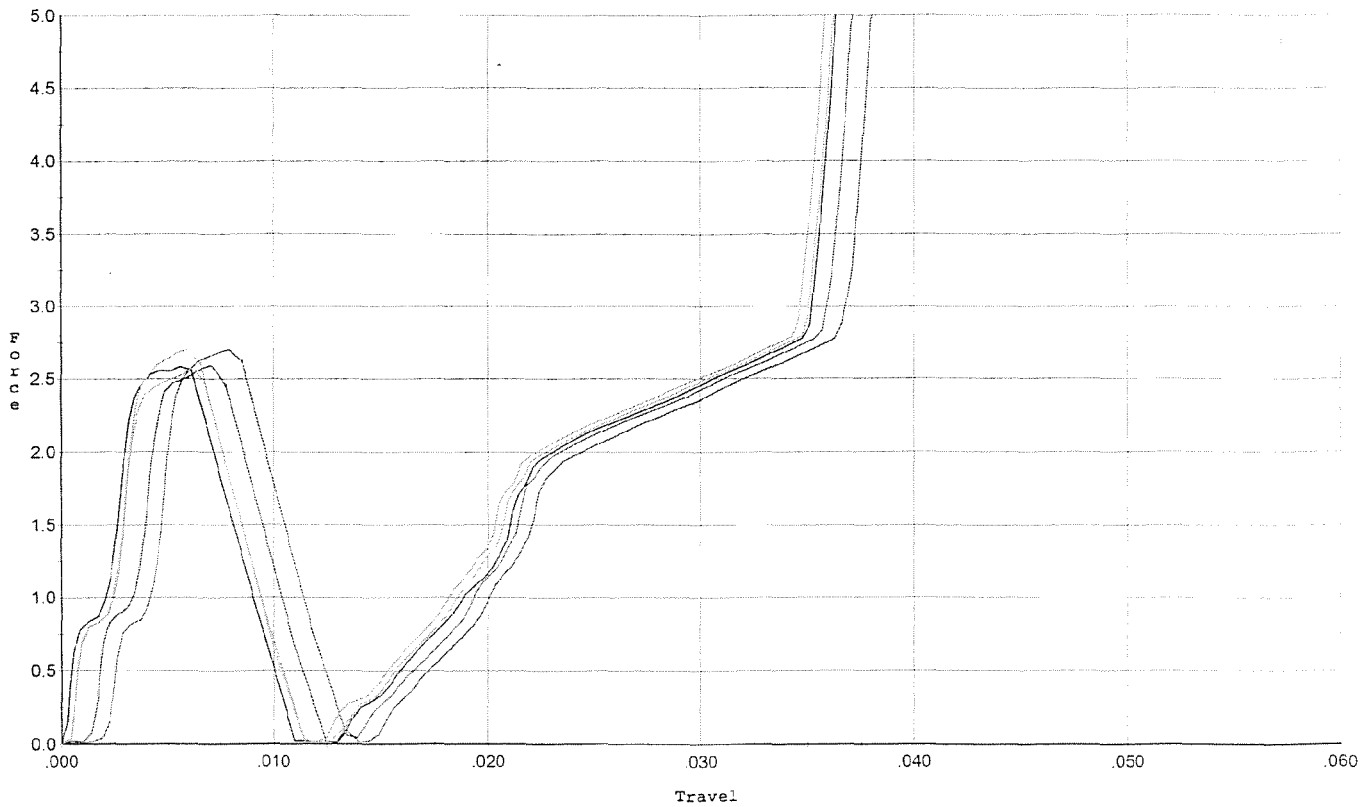
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.582	0.011	0.00	0.032	0.014		Set Trigger
2	2.607	0.008	0.00	0.033	0.010		Set Trigger
3	2.644	0.007	0.00	0.037	0.010		Set Trigger
4	2.629	0.006	0.00	0.032	0.009		Set Trigger
5	2.653	0.007	0.00	0.033	0.010		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



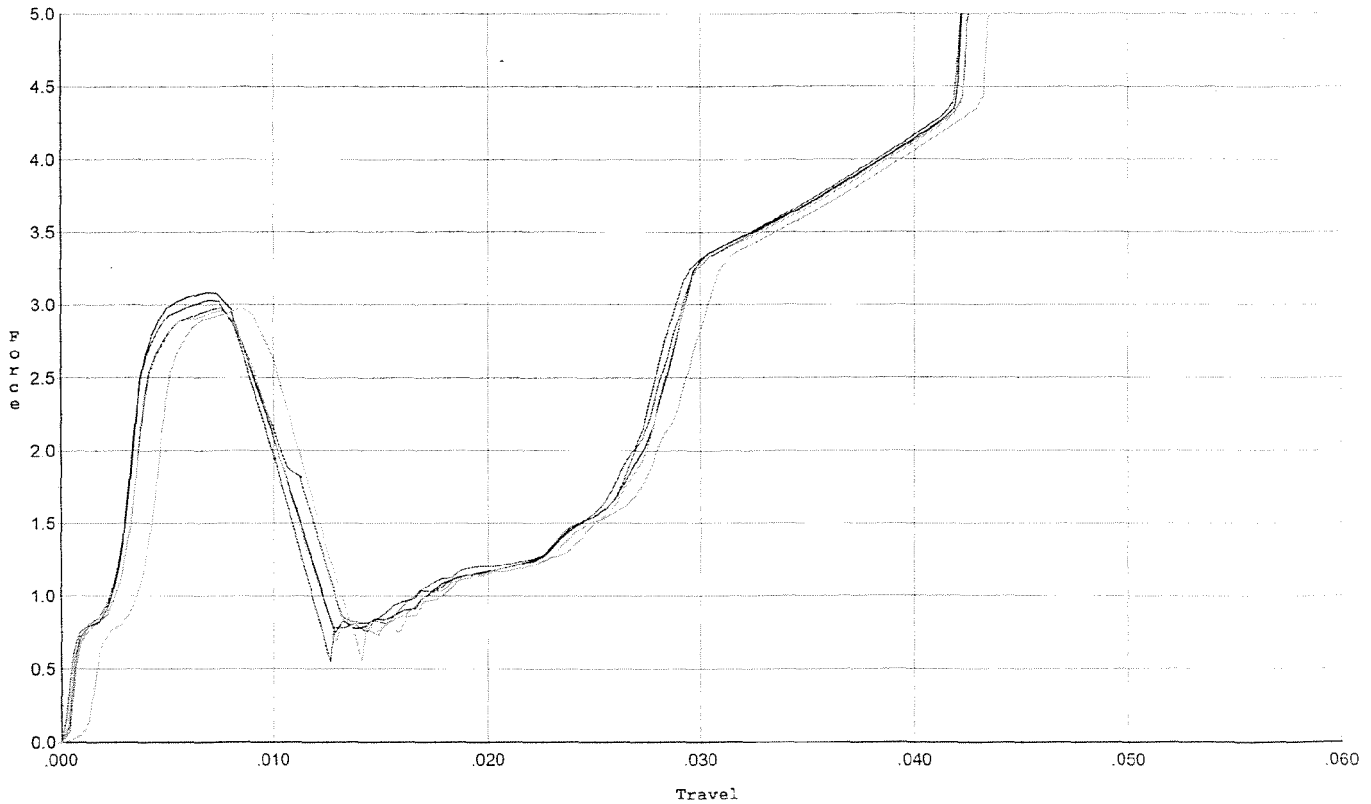
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.594	0.008	0.00	0.033	0.011		Set Trigger
2	2.583	0.006	0.00	0.032	0.010		Set Trigger
3	2.699	0.009	0.002	0.031	0.012		Set Trigger
4	2.699	0.007	0.00	0.032	0.011		Set Trigger
5	2.572	0.007	0.00	0.031	0.010		Set Trigger

A-2-62

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



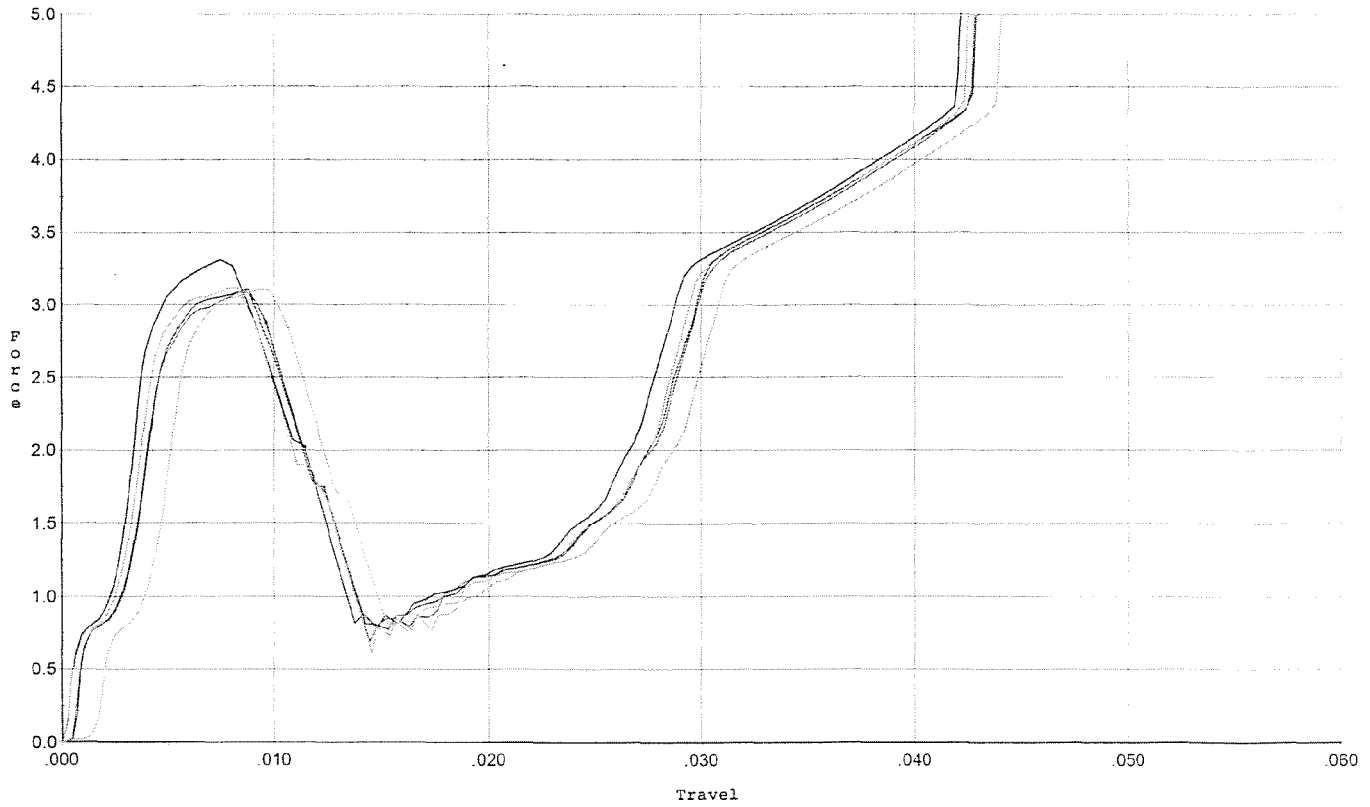
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.026	0.010	0.00	0.034	0.019		Set Trigger
2	3.082	0.011	0.00	0.033	0.021		Set Trigger
3	2.977	0.011	0.00	0.033	0.021		Set Trigger
4	2.958	0.009	0.00	0.034	0.017		Set Trigger
5	2.975	0.010	0.00	0.034	0.017		Set Trigger

A-3.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



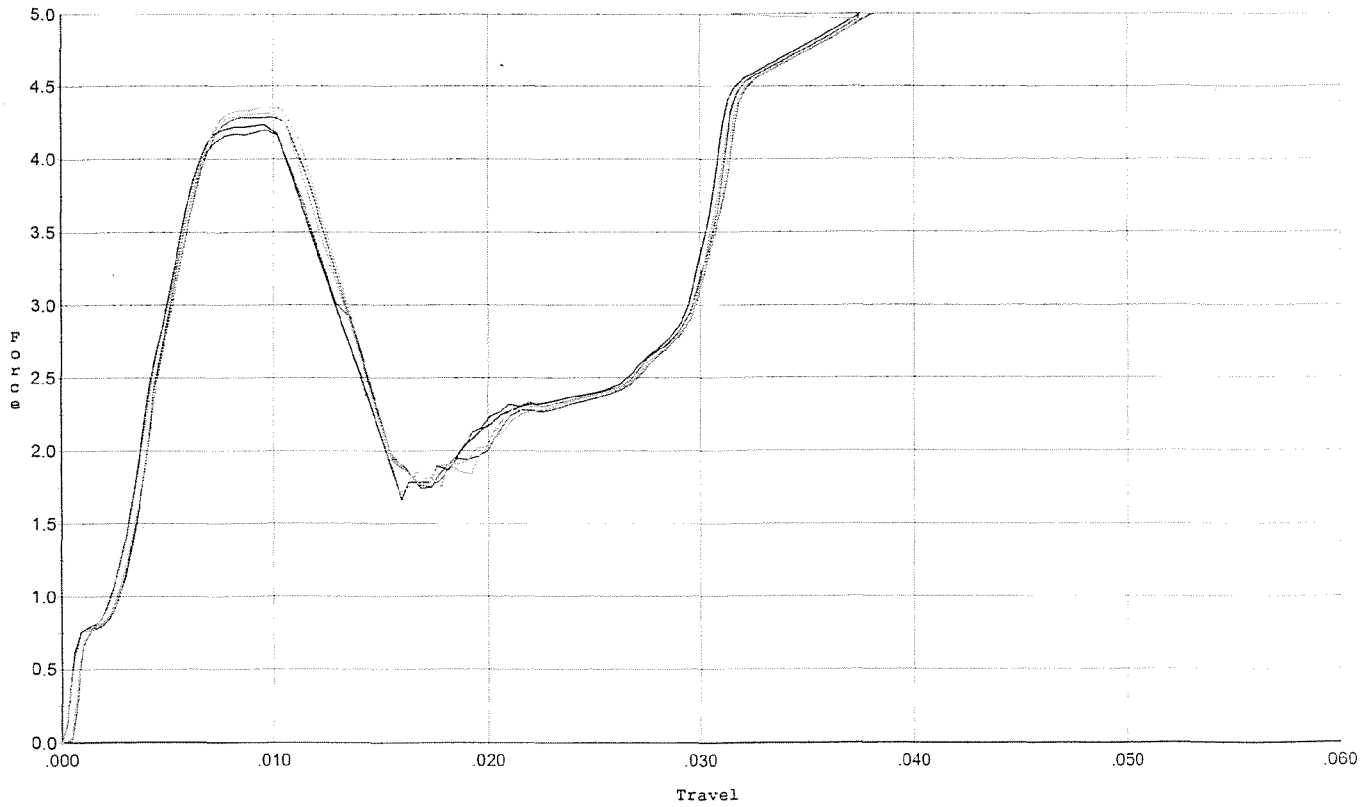
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.107	0.010	0.00	0.033	0.018		Set Trigger
2	3.310	0.011	0.00	0.032	0.023		Set Trigger
3	3.083	0.012	0.00	0.032	0.023		Set Trigger
4	3.103	0.011	0.00	0.034	0.019		Set Trigger
5	3.117	0.012	0.00	0.032	0.024		Set Trigger

A-3.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



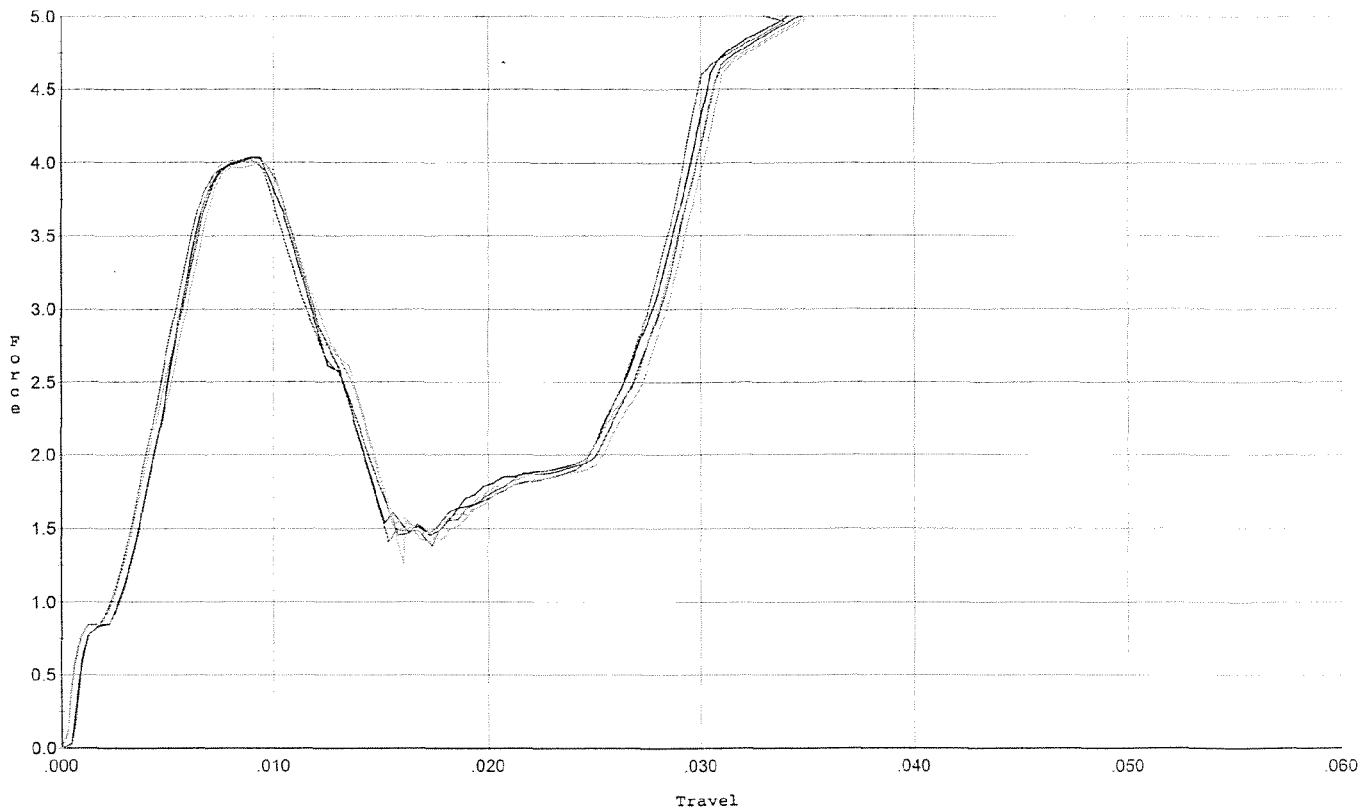
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.199	0.014	0.00	0.030	0.034		Set Trigger
2	4.236	0.014	0.00	0.030	0.037		Set Trigger
3	4.290	0.014	0.00	0.030	0.035		Set Trigger
4	4.313	0.014	0.00	0.030	0.036		Set Trigger
5	4.353	0.013	0.00	0.030	0.035		Set Trigger

A. 4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



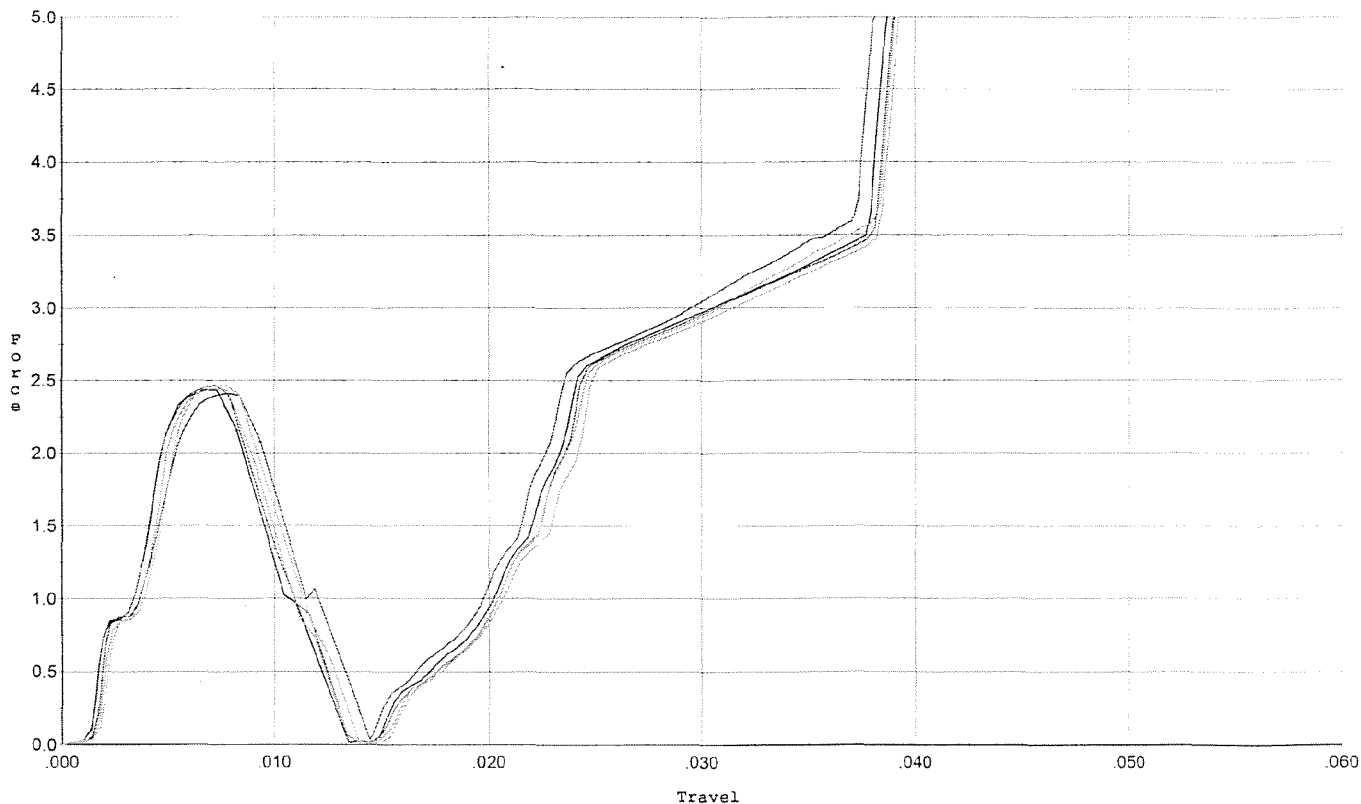
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.040	0.010	0.00	0.030	0.023		Set Trigger
2	4.037	0.013	0.00	0.030	0.030		Set Trigger
3	4.028	0.013	0.00	0.029	0.031		Set Trigger
4	4.004	0.014	0.00	0.030	0.031		Set Trigger
5	4.044	0.014	0.00	0.030	0.033		Set Trigger

A. 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



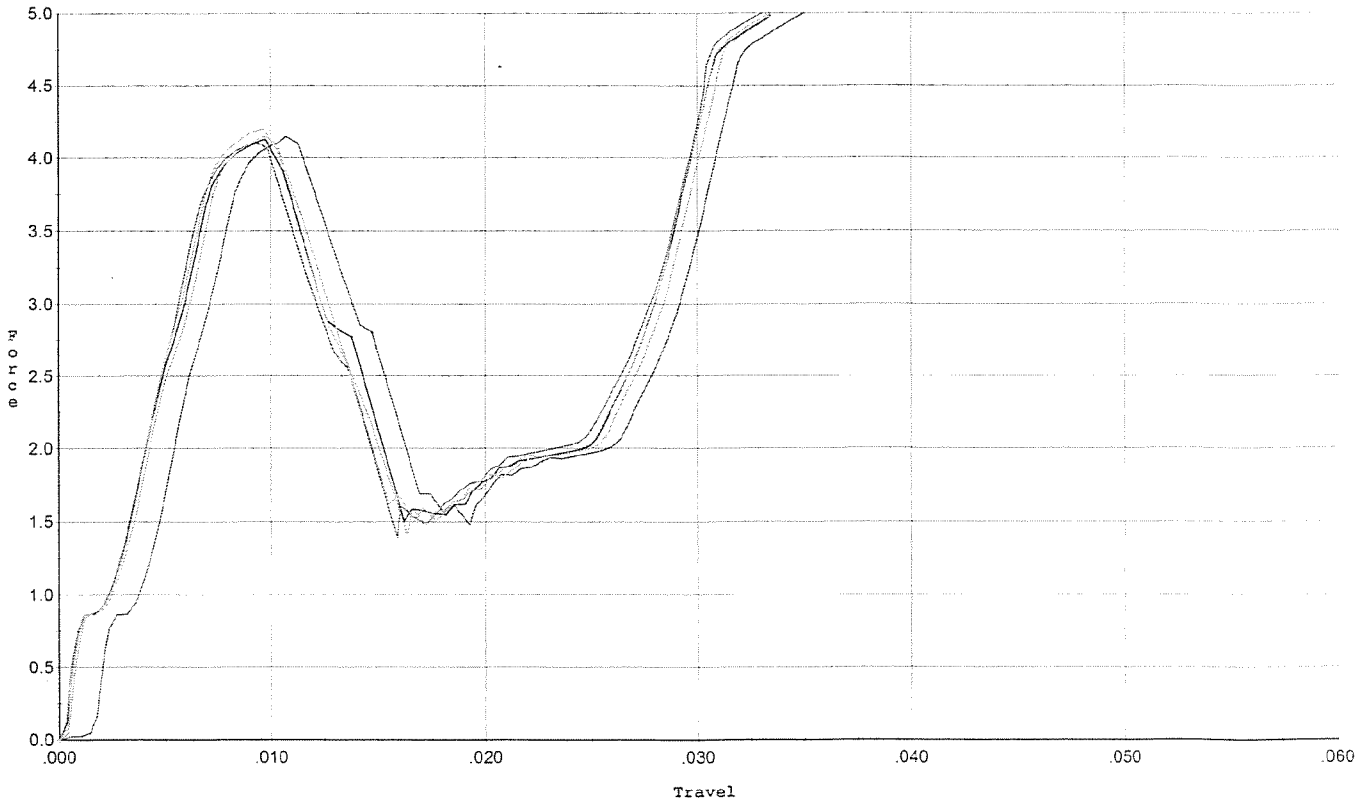
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.413	0.009	0.00	0.031	0.013		Set Trigger
2	2.436	0.008	0.00	0.032	0.011		Set Trigger
3	2.467	0.008	0.00	0.032	0.011		Set Trigger
4	2.466	0.008	0.00	0.032	0.011		Set Trigger
5	2.449	0.009	0.00	0.032	0.012		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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	0.015	0.00	0.030	0.033		Set Trigger
2	4.128	0.014	0.00	0.029	0.033		Set Trigger
3	4.111	0.014	0.00	0.030	0.033		Set Trigger
4	4.199	0.010	0.00	0.030	0.025		Set Trigger
5	4.147	0.012	0.00	0.030	0.028		Set Trigger

A-4.14