

4184 0894

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

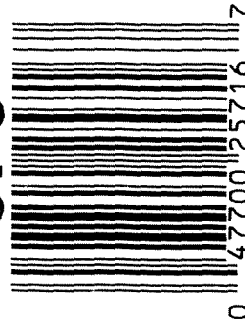
24"

CAPACITY

6

G6807814

UPC



GUN SERIAL # G 6807814

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR	3/5/09	RT
490	MAGNAFLUX BOLT		3/5/09	RT
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	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	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

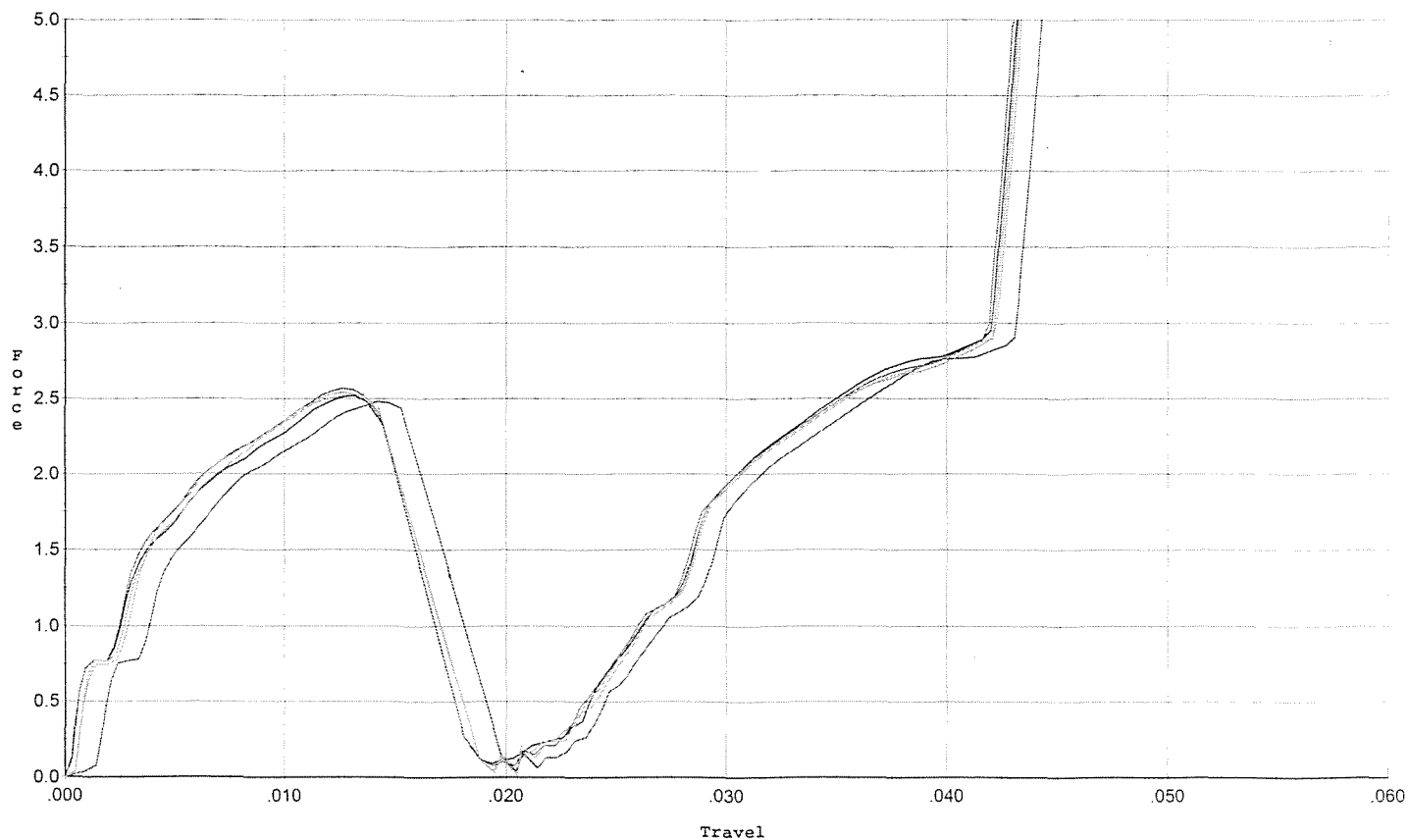
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7</u>	<u>7</u>	<u>7</u>	3-20-09	WW		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4</u>	<u>4</u>	<u>4</u>	3-20-09	WW		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	3-20-09	WW		
	J) ASSEMBLE STOCK					3-16-09	L.P.D.		
	K) ASSEMBLE SWIVEL STUDS					3-20-09	WW		
	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		PASS	FAIL		3-19-09	L.P.D.		
			PASS	FAIL					
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION			N/A				
	MALFUNCTION	CORRECTION							
	MALFUNCTION	CORRECTION							
660	INSPECT FOR LIVE AMMO					3-19-09	RP		
670	FINAL INSPECTION A) HEADSPACE					3-20-09	WW		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u>	<u>2.57</u>	<u>2.46</u>	<u>2.58</u>	<u>2.33</u>	3-20-09	TK
	C) FUNCTION					3-20-09	WW		
690	PACK					3-21-09	TK		

F004 REV 5/2006

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 ini +/- .50 lb



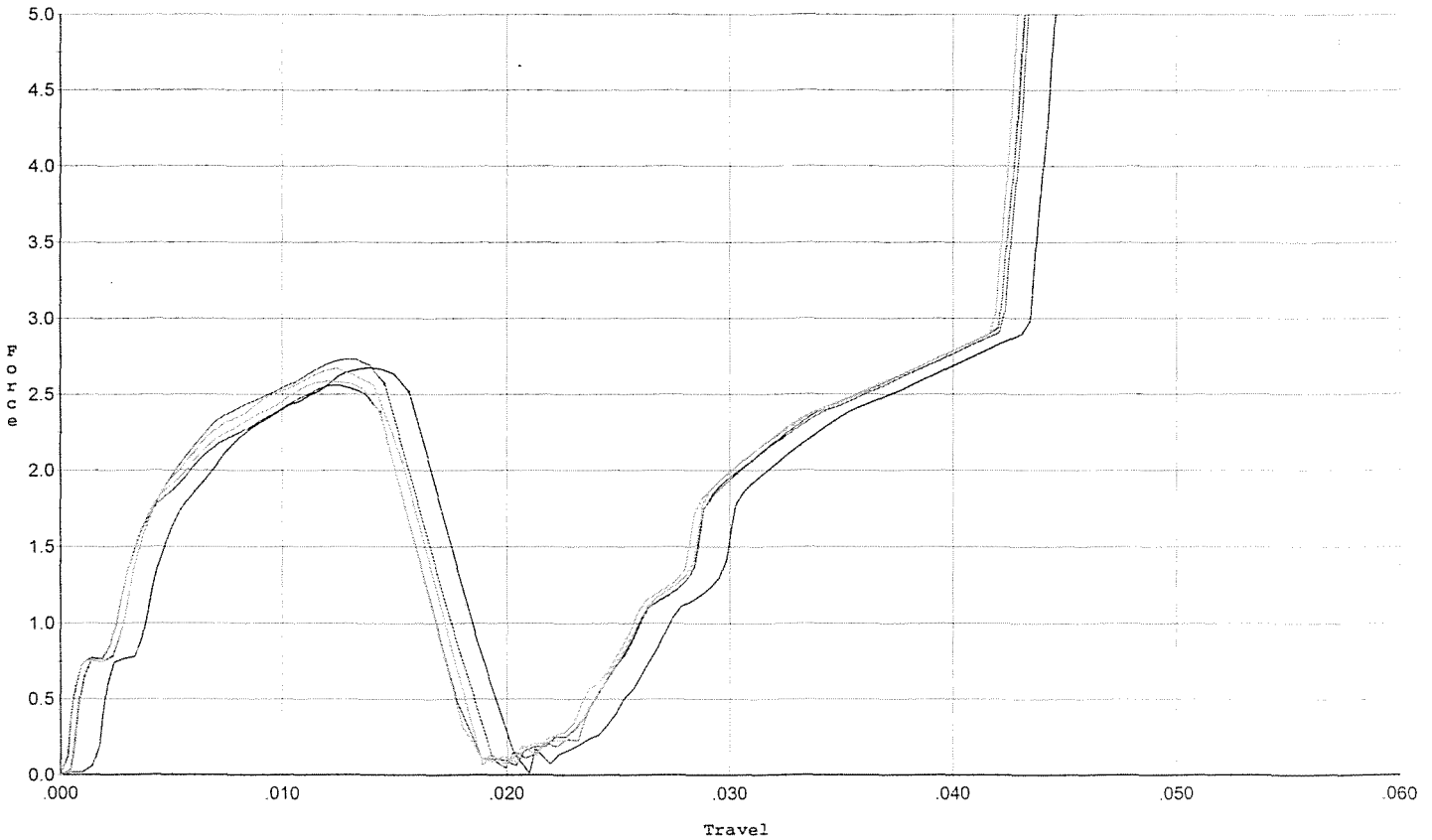
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.481	0.017	0.00	0.031	0.028		Set Trigger
2	2.519	0.014	0.00	0.032	0.025		Set Trigger
3	2.566	0.014	0.00	0.032	0.025		Set Trigger
4	2.539	0.014	0.00	0.032	0.025		Set Trigger
5	2.526	0.014	0.00	0.032	0.025		Set Trigger

A-252

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



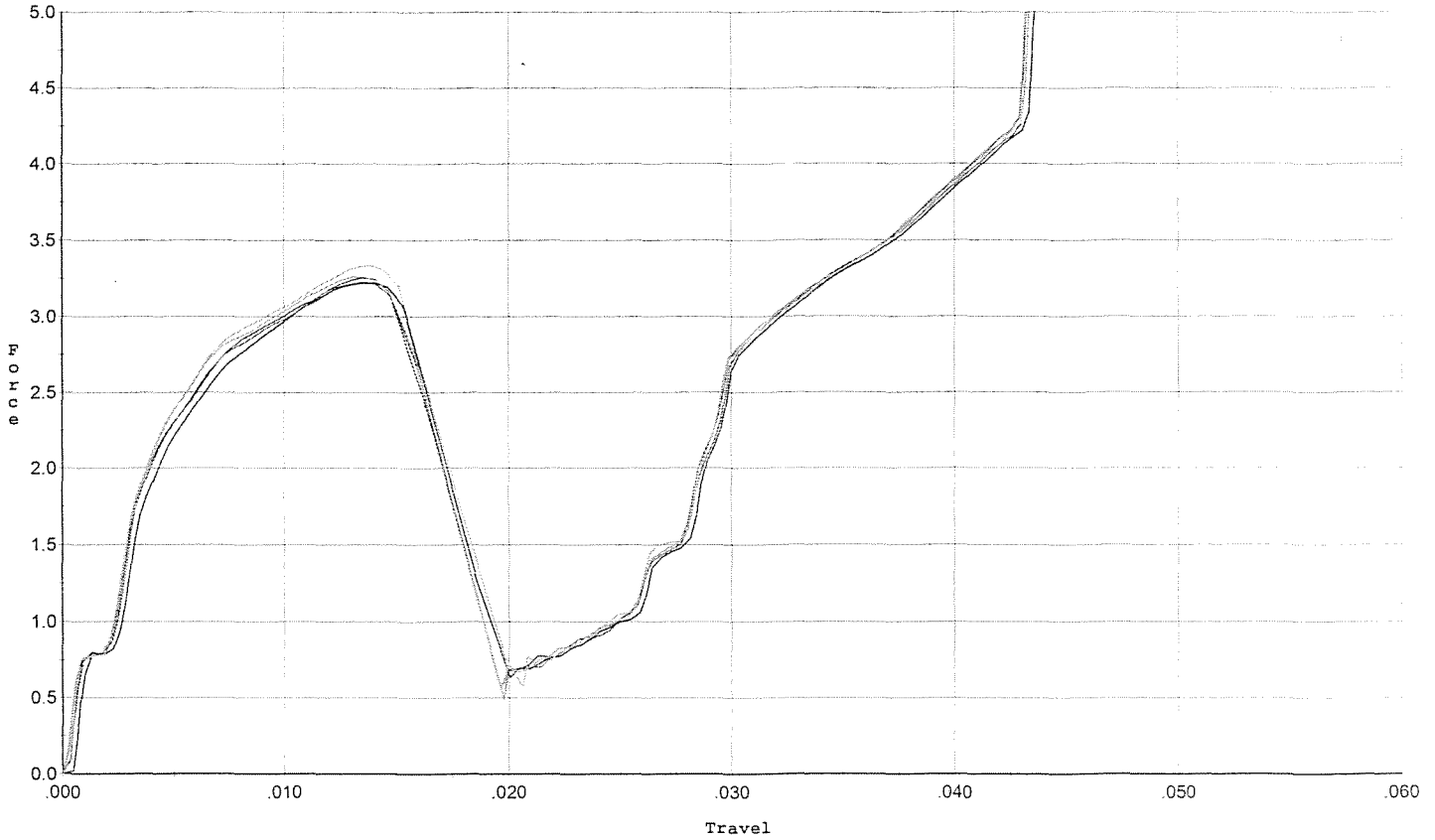
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.559	0.014	0.00	0.032	0.026		Set Trigger
2	2.674	0.016	0.00	0.032	0.027		Set Trigger
3	2.731	0.015	0.00	0.031	0.027		Set Trigger
4	2.588	0.014	0.00	0.032	0.026		Set Trigger
5	2.672	0.015	0.00	0.031	0.028		Set Trigger

A-2.64

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 in i +/- .75 lb



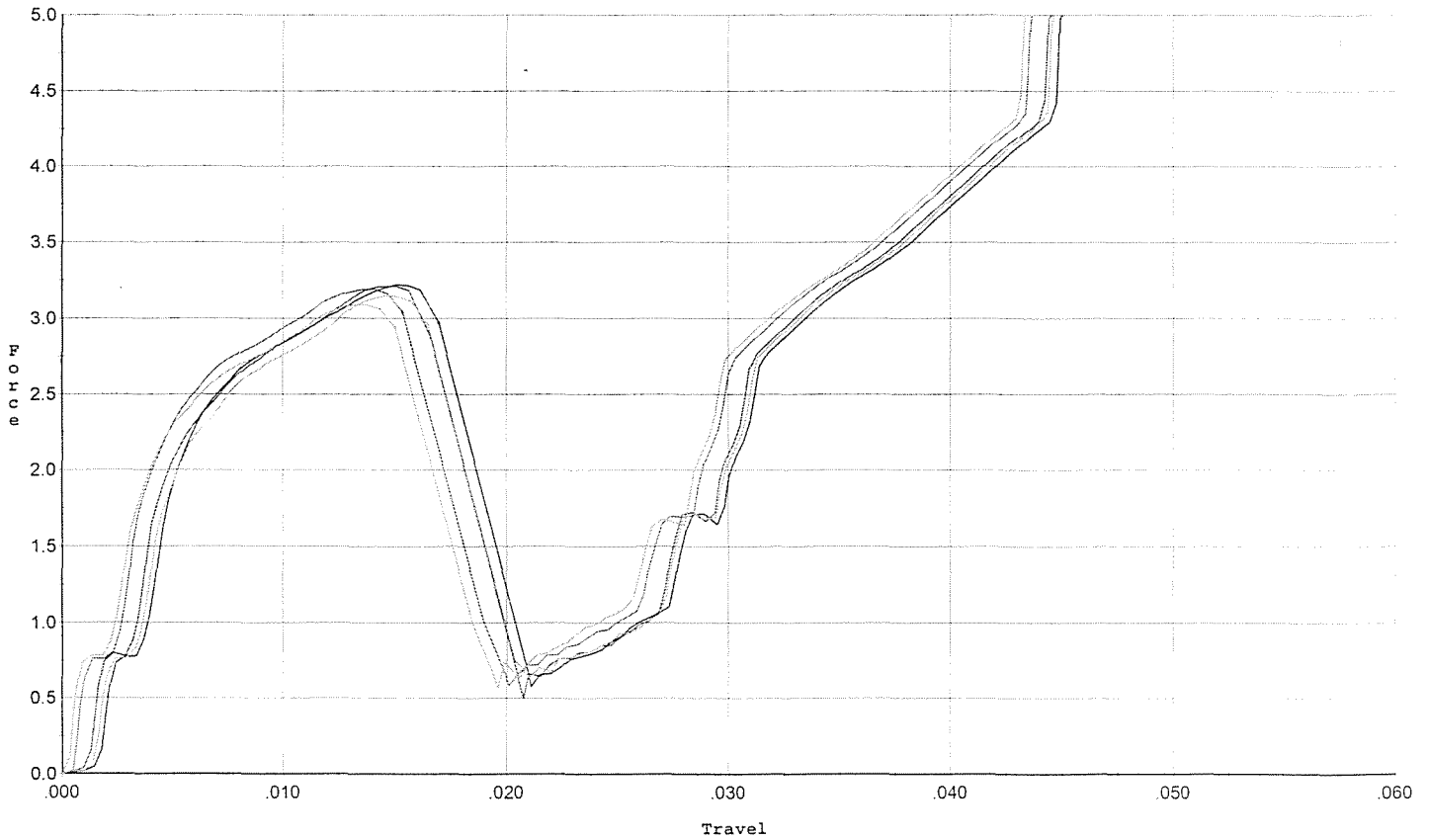
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.226	0.016	0.00	0.030	0.035		Set Trigger
2	3.220	0.015	0.00	0.030	0.033		Set Trigger
3	3.255	0.016	0.00	0.029	0.036		Set Trigger
4	3.335	0.015	0.00	0.029	0.034		Set Trigger
5	3.259	0.016	0.00	0.029	0.036		Set Trigger

A-3-25

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



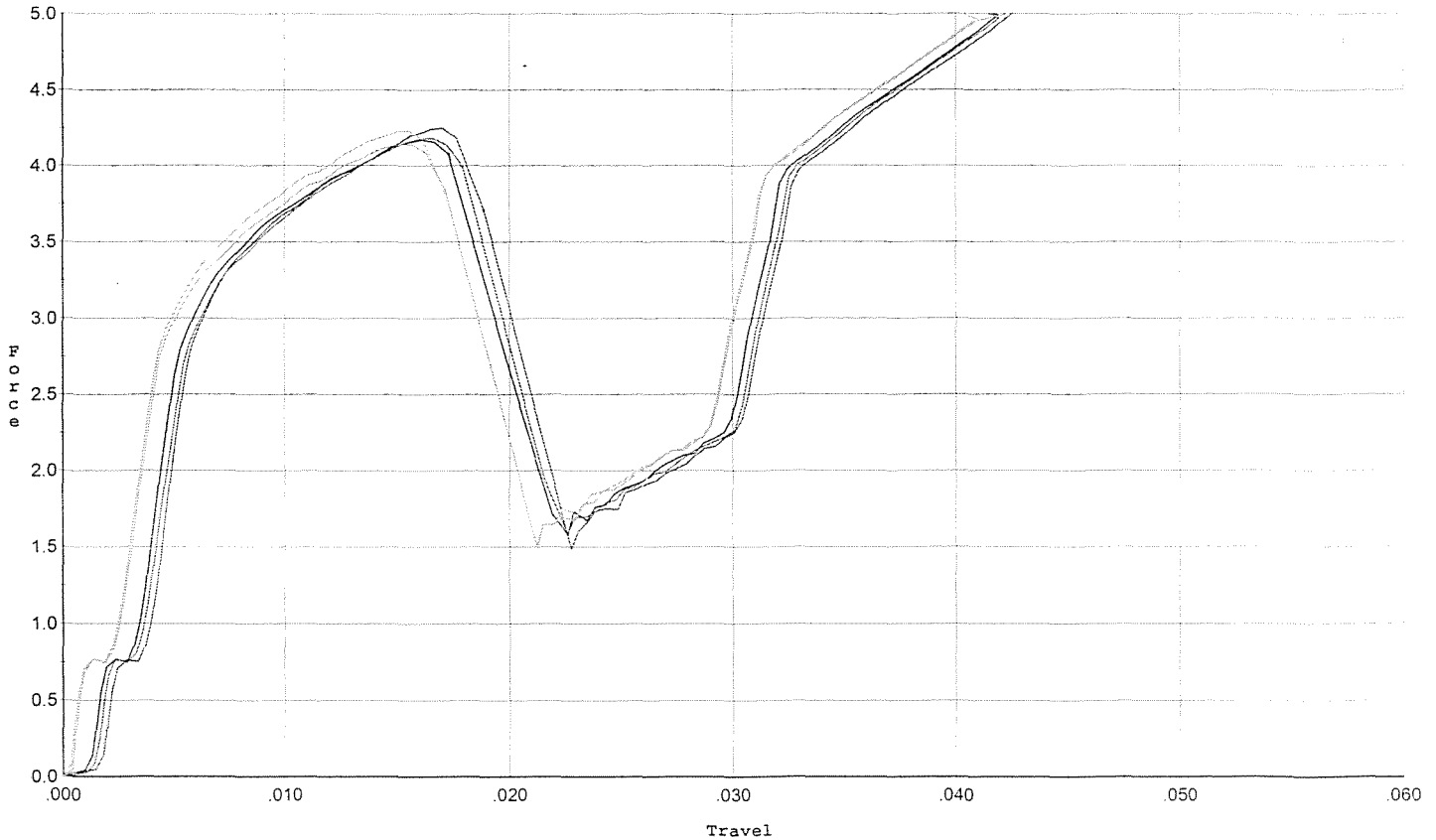
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.017	0.00	0.030	0.035		Set Trigger
2	3.221	0.017	0.00	0.030	0.035		Set Trigger
3	3.192	0.015	0.00	0.030	0.034		Set Trigger
4	3.150	0.016	0.00	0.030	0.034		Set Trigger
5	3.091	0.015	0.00	0.030	0.032		Set Trigger

A-3-17

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



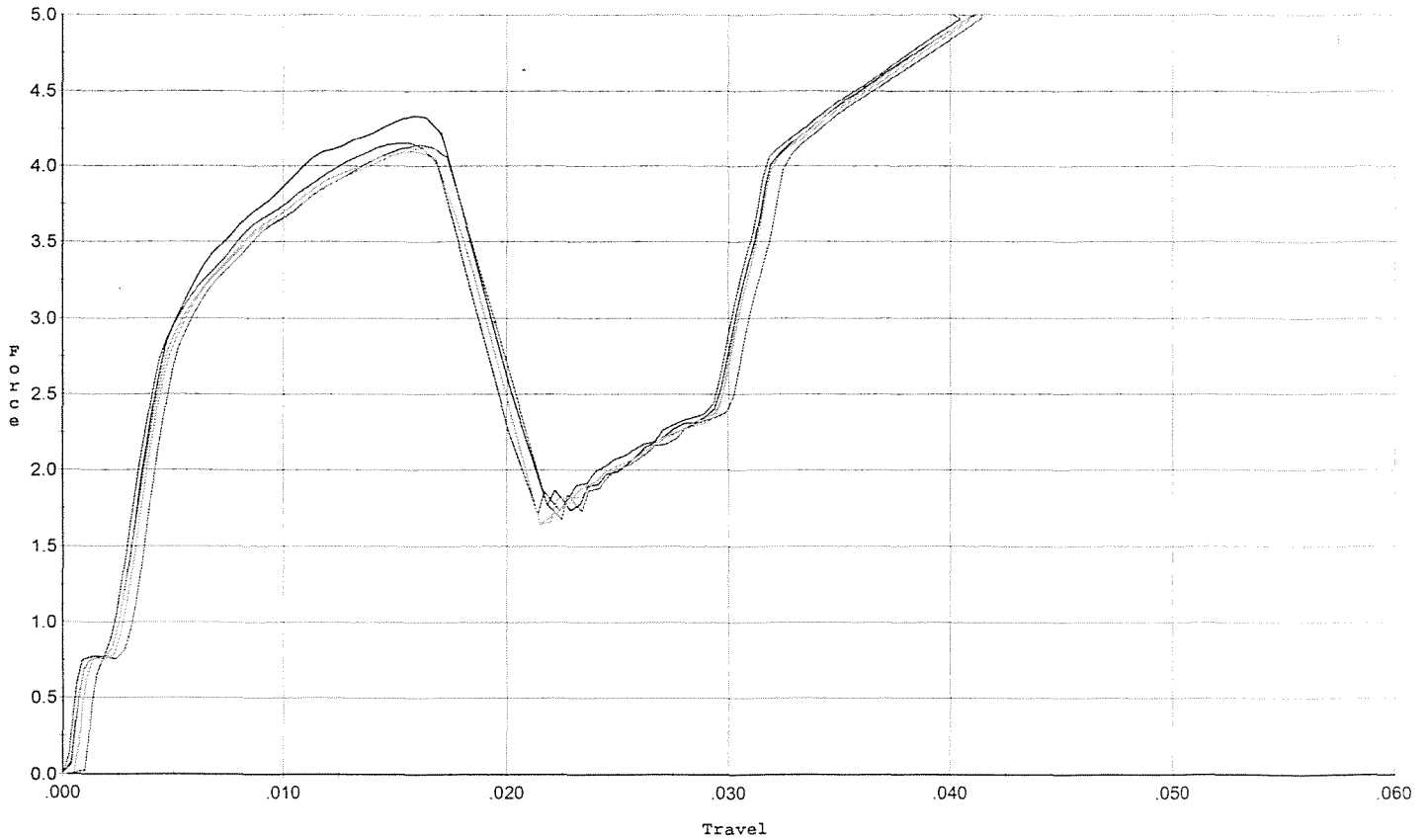
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.250	0.019	0.00	0.027	0.051		Set Trigger
2	4.169	0.017	0.00	0.028	0.047		Set Trigger
3	4.177	0.018	0.00	0.027	0.048		Set Trigger
4	4.231	0.017	0.00	0.027	0.049		Set Trigger
5	4.141	0.017	0.00	0.027	0.048		Set Trigger

A-4.19

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



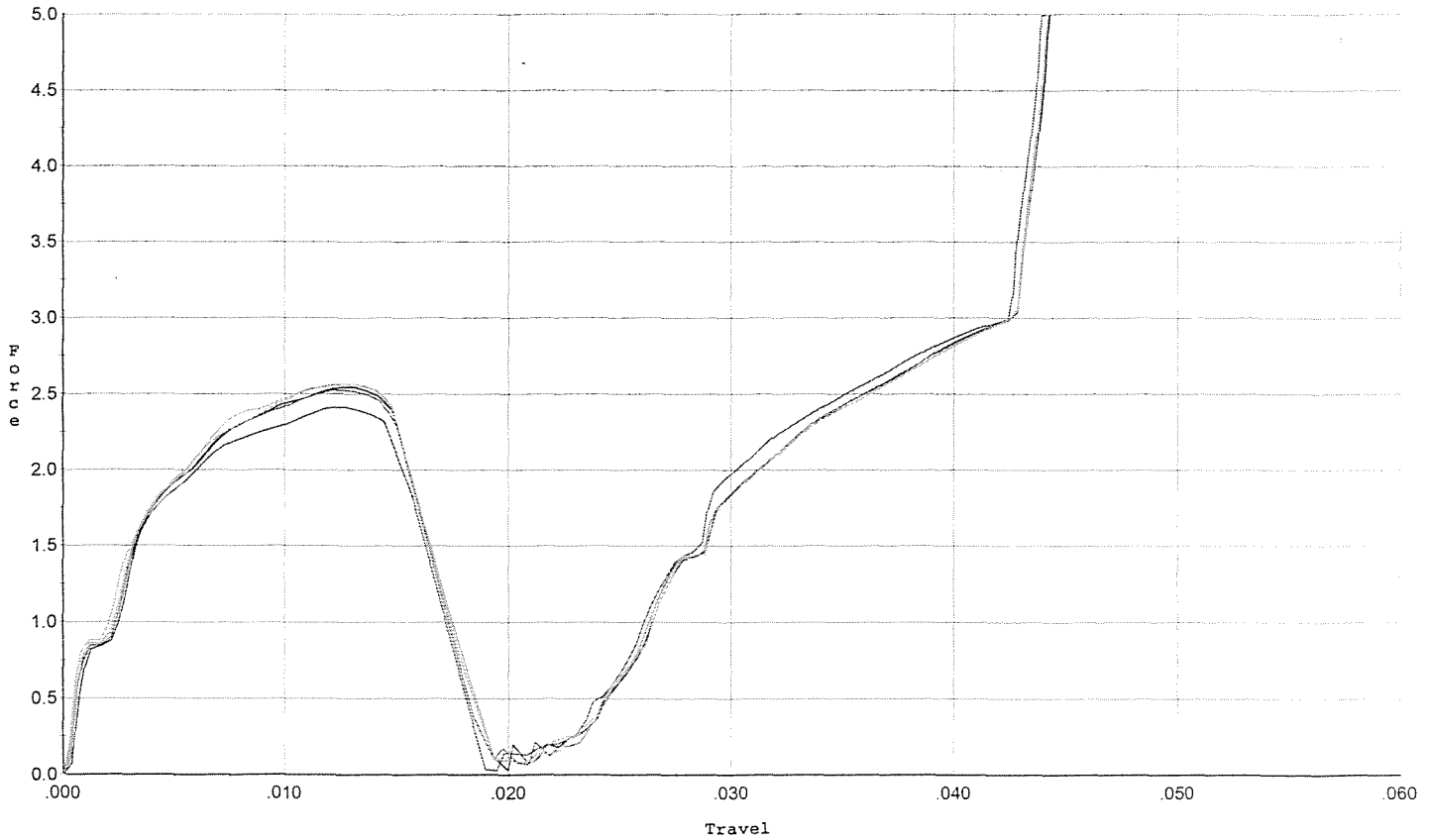
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.151	0.017	0.00	0.027	0.048		Set Trigger
2	4.336	0.017	0.00	0.027	0.050		Set Trigger
3	4.139	0.019	0.00	0.027	0.053		Set Trigger
4	4.101	0.018	0.00	0.027	0.051		Set Trigger
5	4.118	0.018	0.00	0.027	0.051		Set Trigger

A 4.1 lb

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



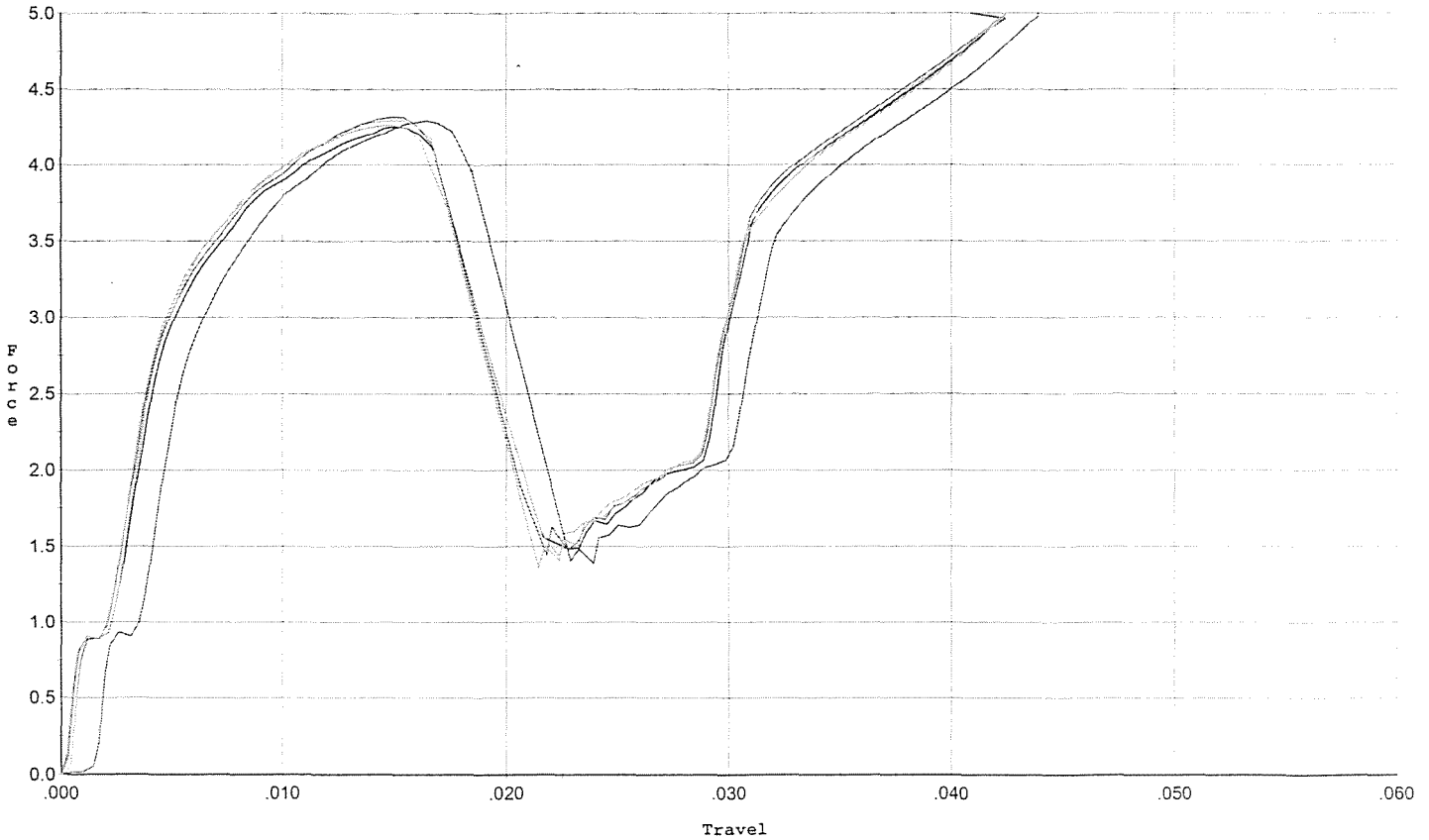
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.413	0.016	0.00	0.032	0.028		Set Trigger
2	2.545	0.015	0.00	0.032	0.027		Set Trigger
3	2.527	0.015	0.00	0.032	0.027		Set Trigger
4	2.559	0.015	0.00	0.032	0.028		Set Trigger
5	2.569	0.015	0.00	0.032	0.028		Set Trigger

A-2-52

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	4.293	0.018	0.00	0.028	0.051		Set Trigger
2	4.254	0.017	0.00	0.028	0.048		Set Trigger
3	4.320	0.017	0.00	0.028	0.049		Set Trigger
4	4.294	0.017	0.00	0.028	0.049		Set Trigger
5	4.262	0.017	0.00	0.028	0.051		Set Trigger

A. 4-28