

G679 4682

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



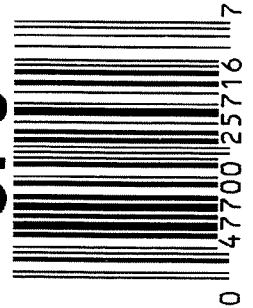
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794682

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6794682

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPJ
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPJ
460	CHECK HEADSPACE		2-27-09	SPJ
470	DIS-ASSEMBLE ACTION		2-27-09	SPJ
472	SERIALIZE BOLT HANDLE		3-2-09	RJL
480	MAGNAFLUX BBL ACTION	(A)	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	MR
540	APPLY COATINGS (BARREL ACTION)		3/9	
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		3-12-09	SPJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

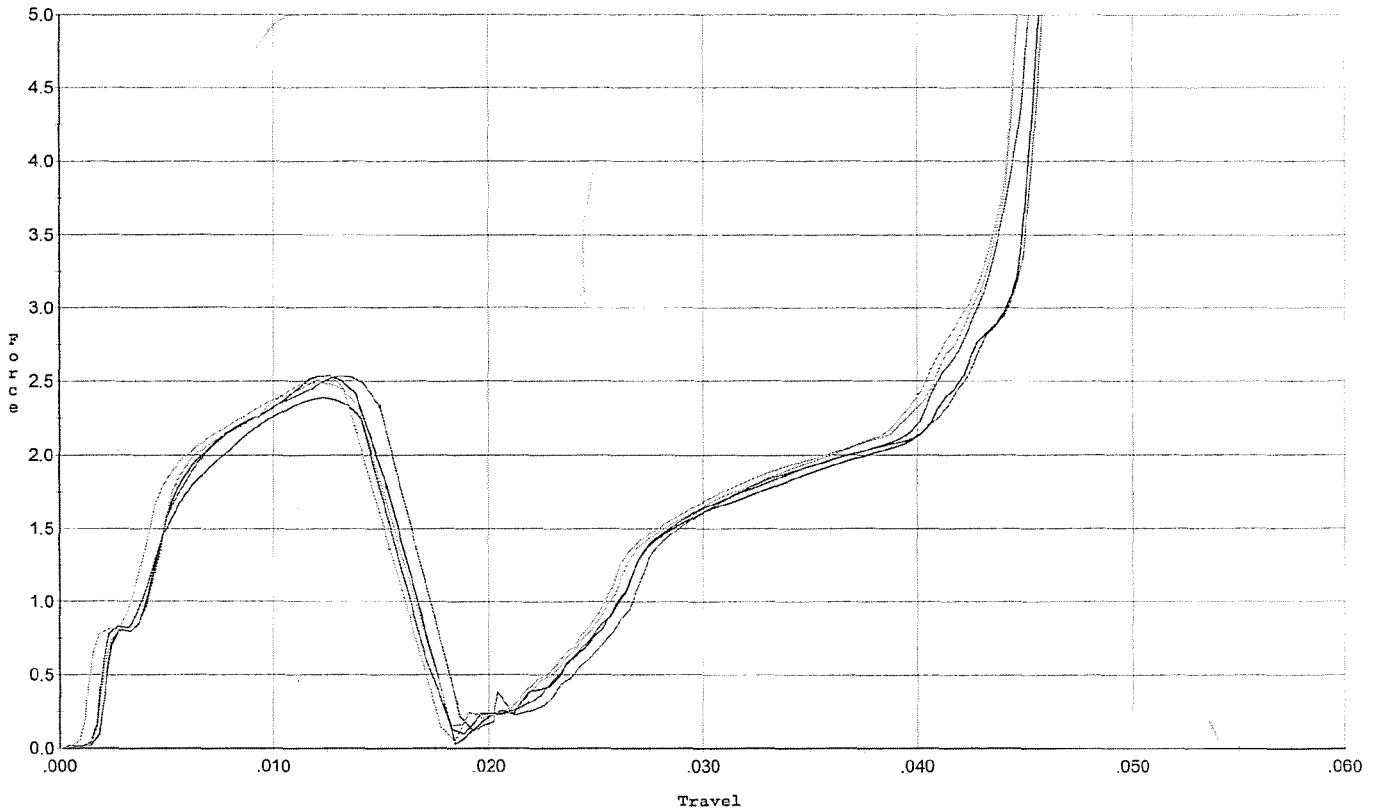
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5</u> <u>5</u>	3-19-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-19-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	3-19-09	NW
	J) ASSEMBLE STOCK		3-12-09	RL
	K) ASSEMBLE SWIVEL STUDS		3-19-09	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	3-17-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-19-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.63</u> <u>2.54</u> <u>2.59</u> <u>2.62</u>	3-18-09	NW
	C) FUNCTION		3-19-09	NW
690	PACK		3/20/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



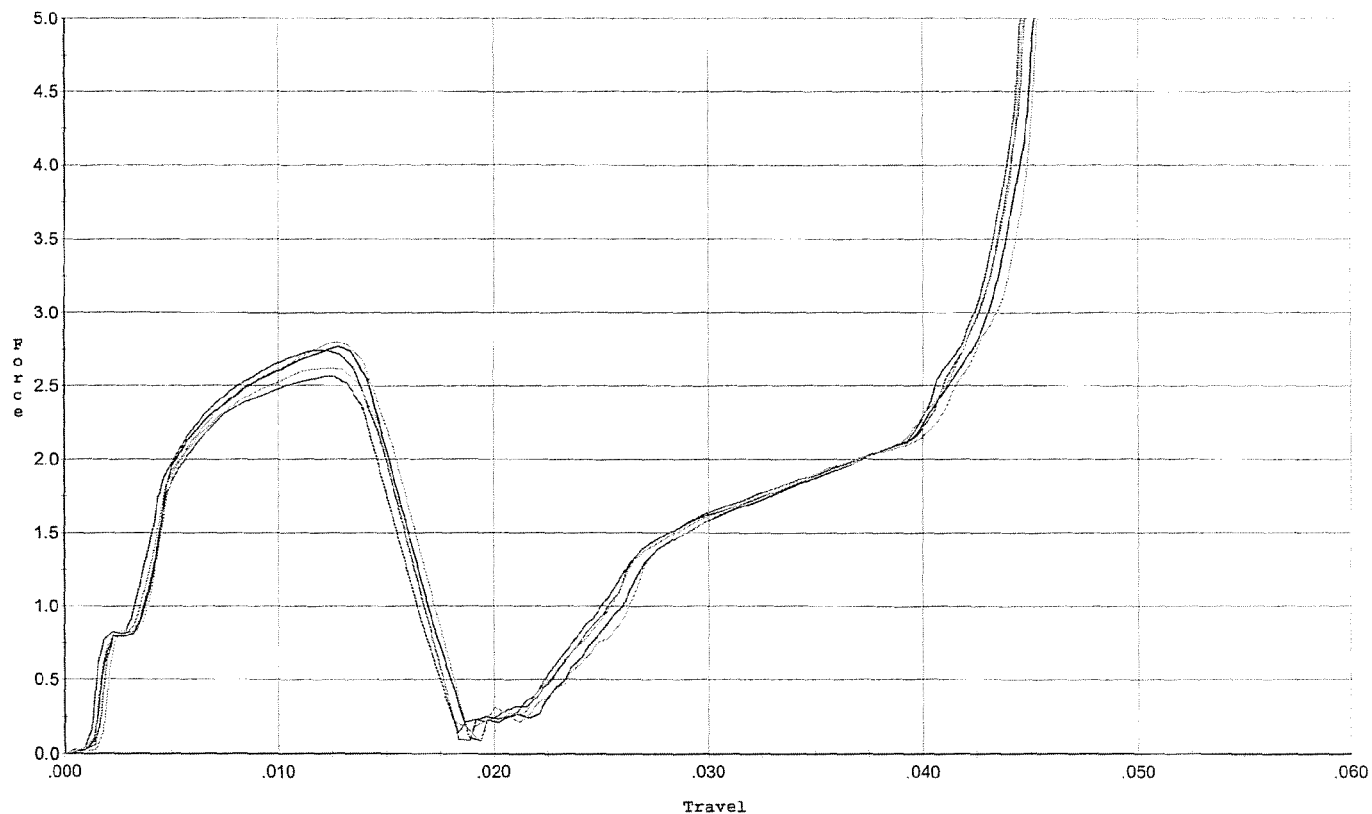
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.390	0.014	0.00	0.035	0.022		Set Trigger
2	2.537	0.015	0.002	0.035	0.024		Set Trigger
3	2.534	0.015	0.00	0.034	0.024		Set Trigger
4	2.487	0.016	0.00	0.034	0.025		Set Trigger
5	2.550	0.015	0.00	0.034	0.025		Set Trigger

A. 2.50

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



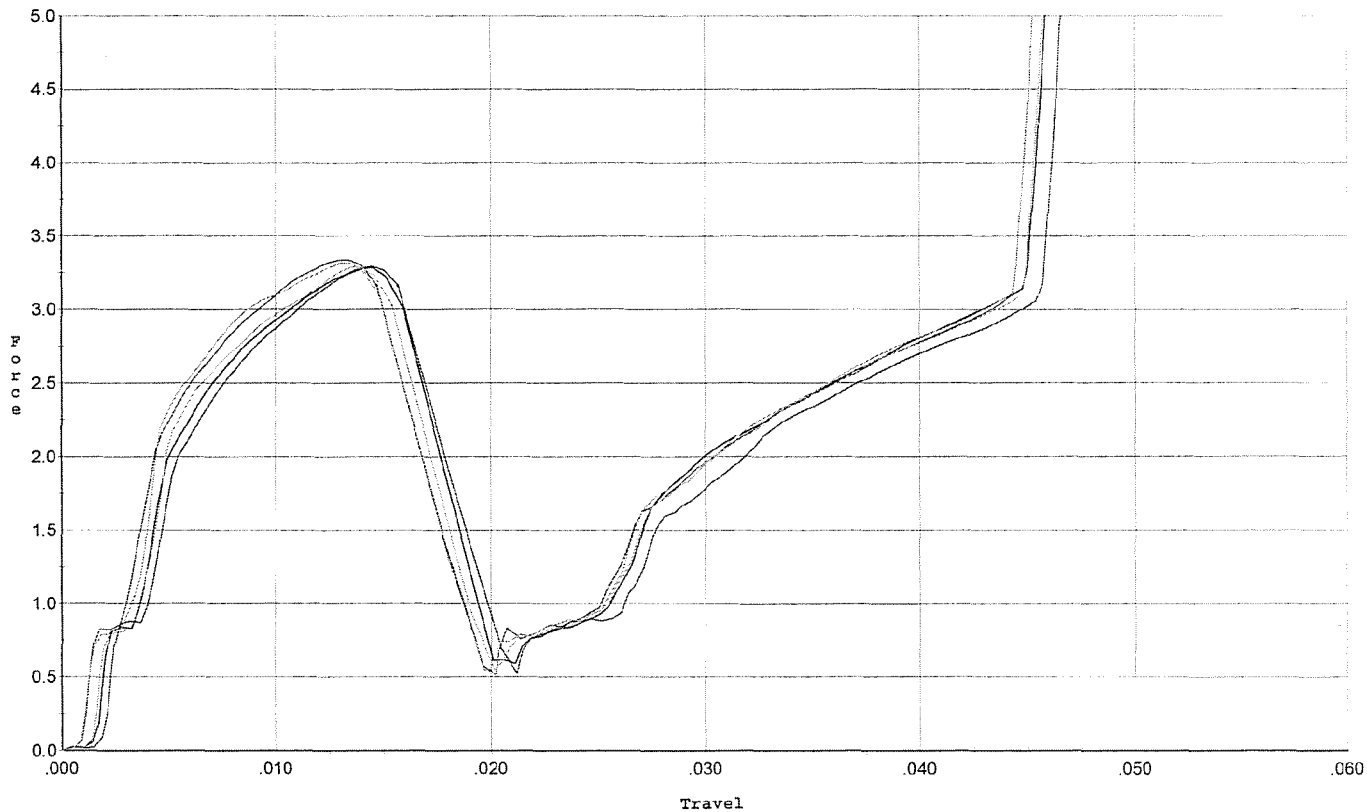
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.743	0.015	0.00	0.034	0.027		Set Trigger
2	2.766	0.014	0.00	0.034	0.025		Set Trigger
3	2.563	0.014	0.00	0.034	0.023		Set Trigger
4	2.620	0.015	0.00	0.034	0.025		Set Trigger
5	2.799	0.015	0.00	0.033	0.028		Set Trigger

A-2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



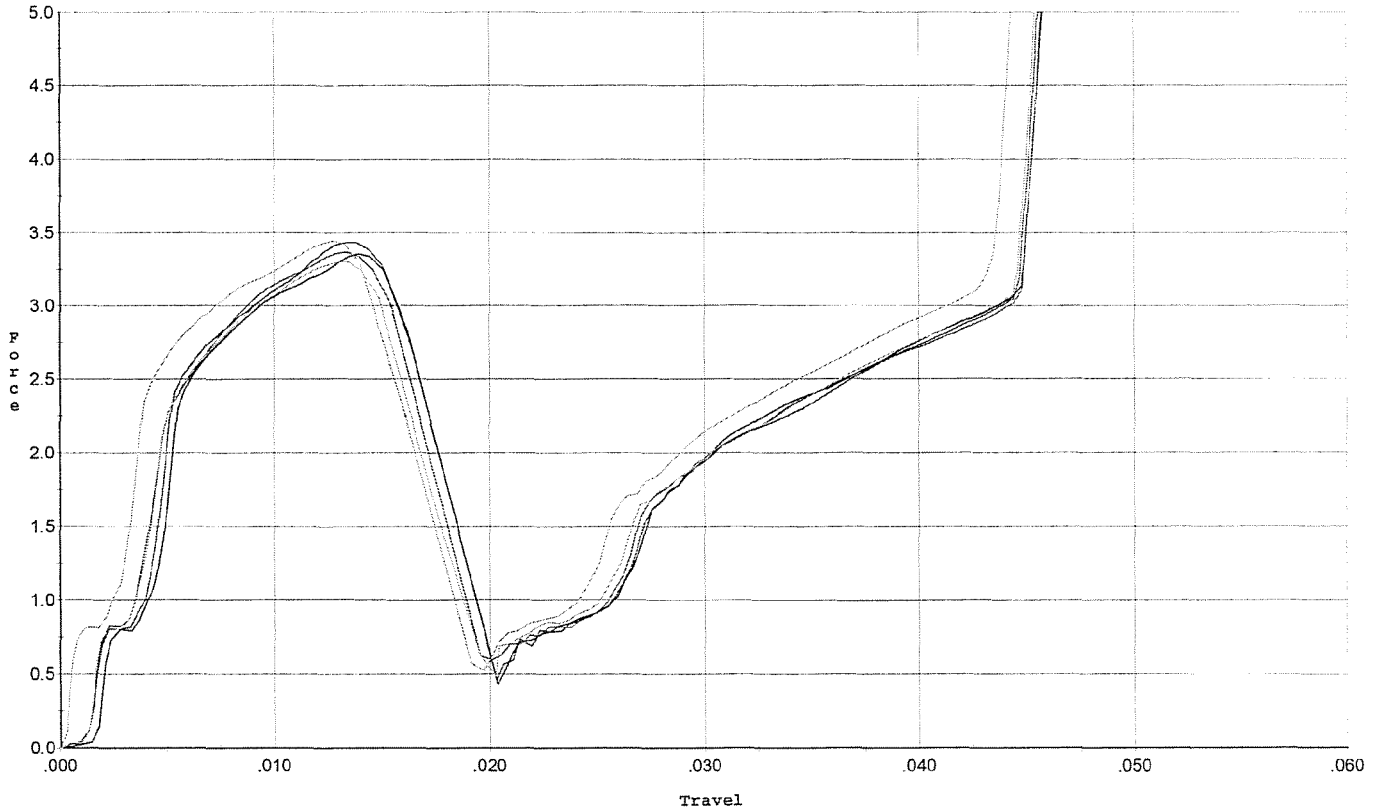
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.291	0.016	0.002	0.033	0.032		Set Trigger
2	3.284	0.016	0.00	0.032	0.033		Set Trigger
3	3.334	0.015	0.00	0.032	0.032		Set Trigger
4	3.288	0.015	0.00	0.032	0.032		Set Trigger
5	3.313	0.015	0.00	0.032	0.032		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



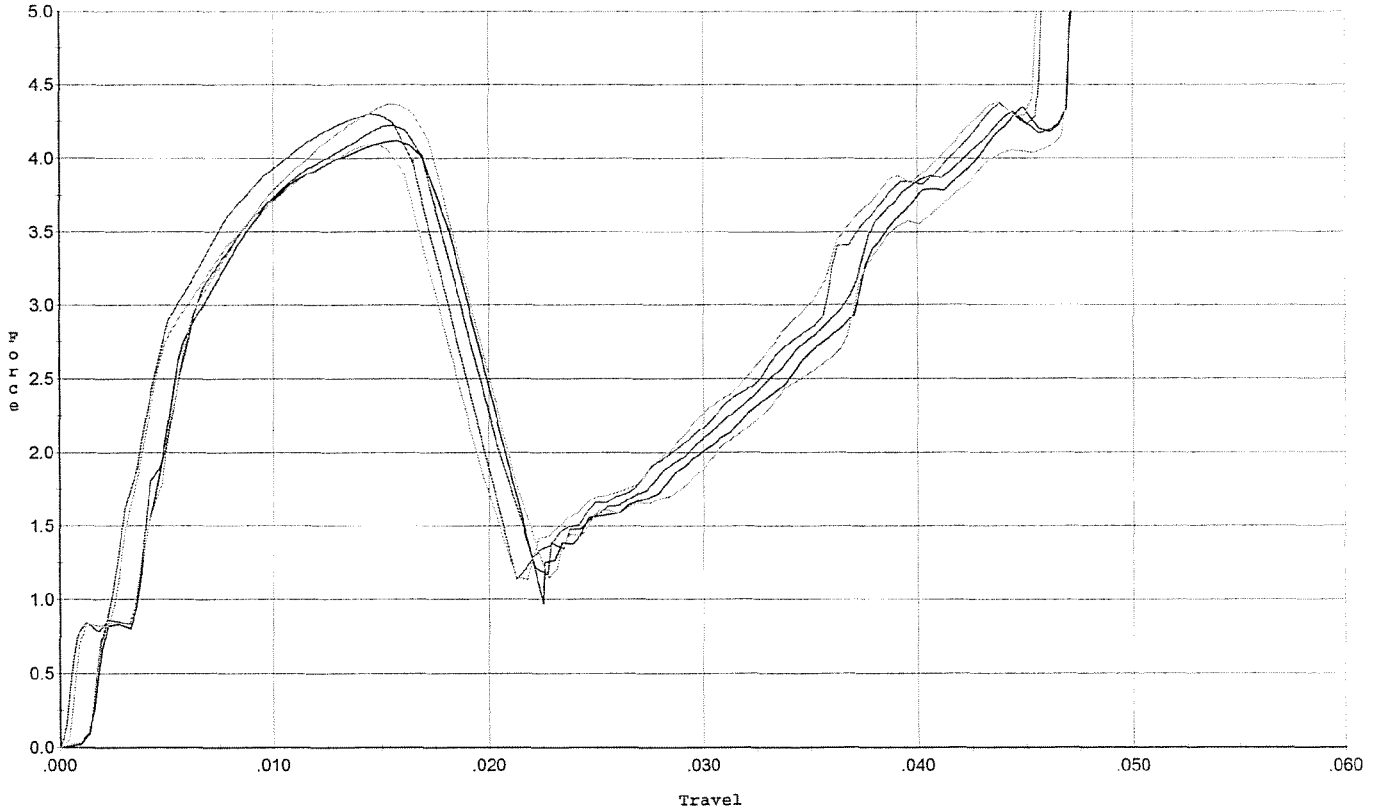
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.434	0.016	0.00	0.032	0.035		Set Trigger
2	3.355	0.016	0.00	0.032	0.034		Set Trigger
3	3.368	0.015	0.00	0.032	0.033		Set Trigger
4	3.301	0.015	0.00	0.032	0.031		Set Trigger
5	3.446	0.016	0.00	0.031	0.037		Set Trigger

A-3.38

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



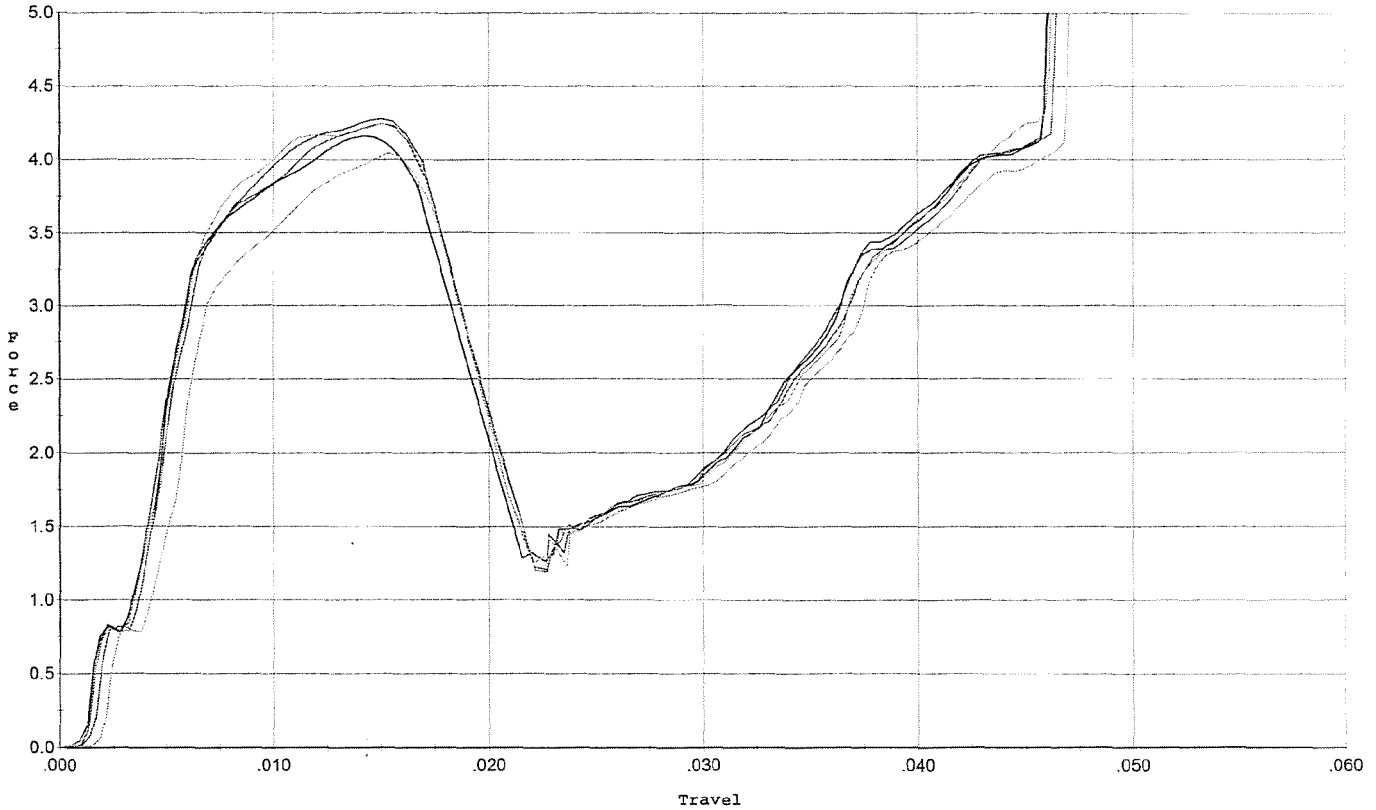
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.223	0.017	0.004	0.031	0.045		Set Trigger
2	4.118	0.018	0.00	0.030	0.048		Set Trigger
3	4.302	0.016	0.00	0.030	0.047		Set Trigger
4	4.099	0.016	0.003	0.030	0.043		Set Trigger
5	4.364	0.017	0.004	0.030	0.047		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



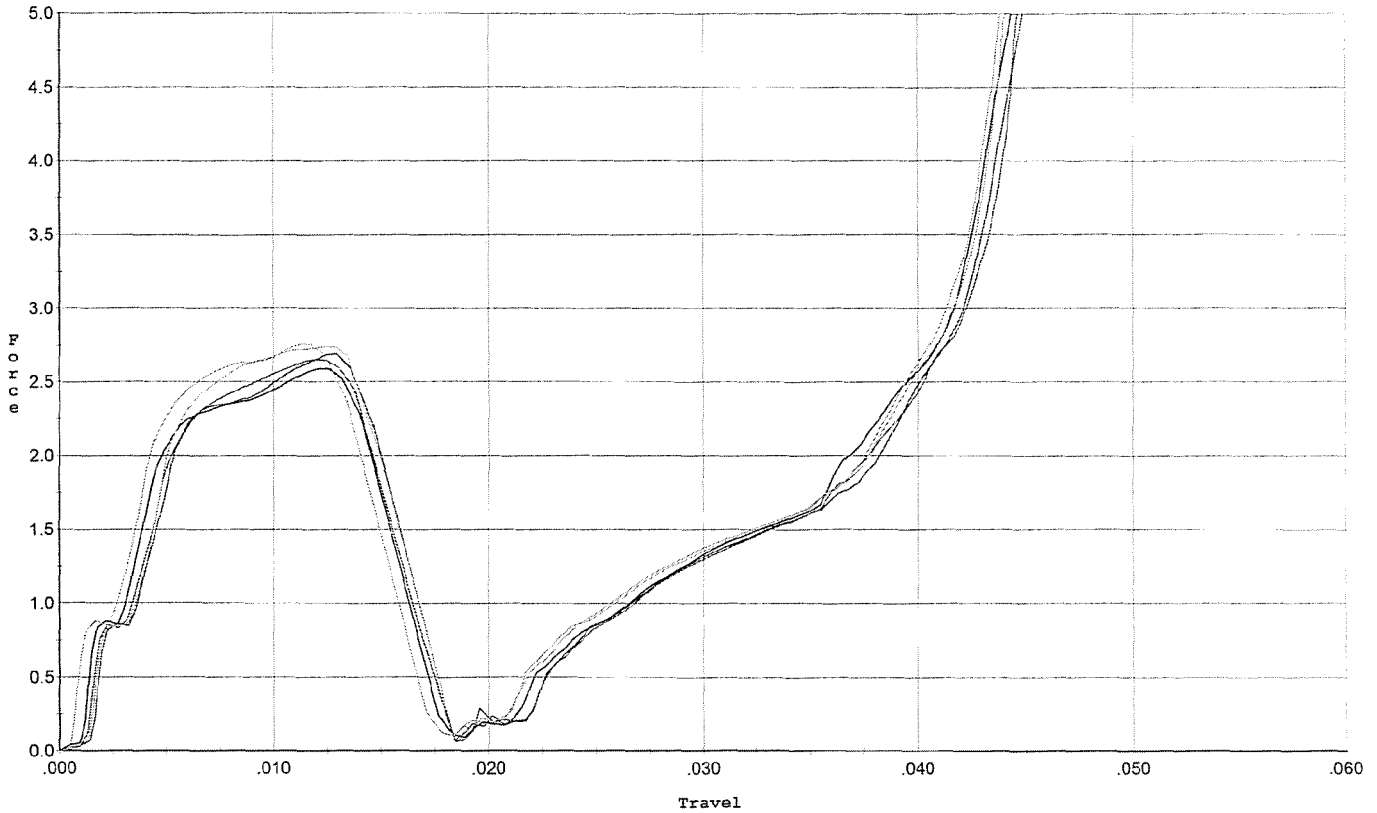
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.275	0.017	0.00	0.030	0.047		Set Trigger
2	4.160	0.017	0.00	0.030	0.045		Set Trigger
3	4.244	0.017	0.00	0.030	0.046		Set Trigger
4	4.043	0.017	0.002	0.031	0.043		Set Trigger
5	4.244	0.017	0.00	0.030	0.047		Set Trigger

A. 4.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



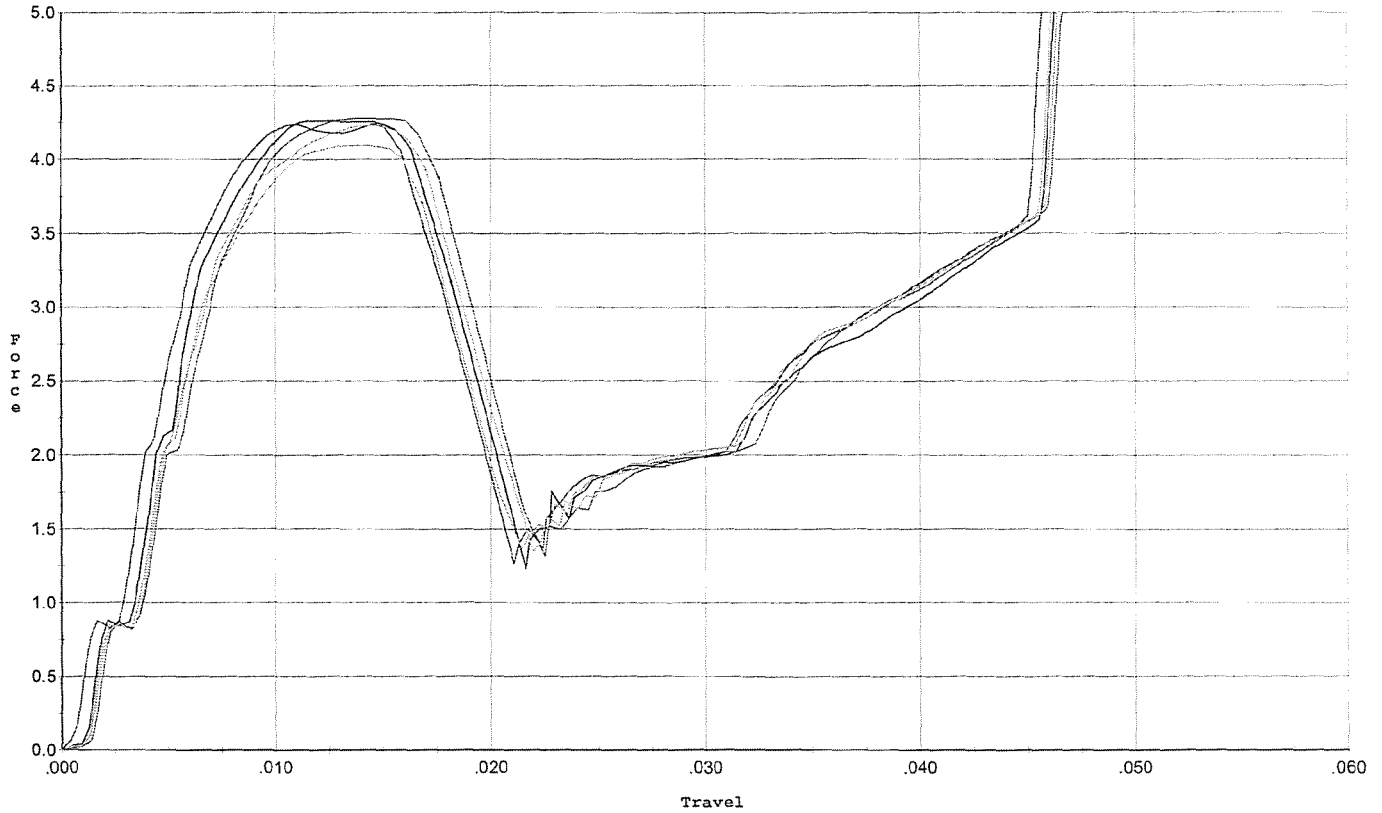
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.690	0.015	0.00	0.034	0.025		Set Trigger
2	2.590	0.014	0.00	0.034	0.025		Set Trigger
3	2.651	0.014	0.00	0.035	0.024		Set Trigger
4	2.742	0.015	0.00	0.034	0.027		Set Trigger
5	2.761	0.013	0.00	0.034	0.025		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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	4.236	0.018	0.00	0.030	0.050		Set Trigger
2	4.260	0.018	0.00	0.030	0.050		Set Trigger
3	4.277	0.018	0.00	0.030	0.048		Set Trigger
4	4.226	0.017	0.00	0.030	0.046		Set Trigger
5	4.095	0.017	0.004	0.030	0.044		Set Trigger

A-4.21