

66794761

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



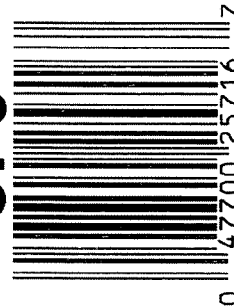
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794761

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794761

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-8-08	RSW
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (K)	10/11/08	(K)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-21-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

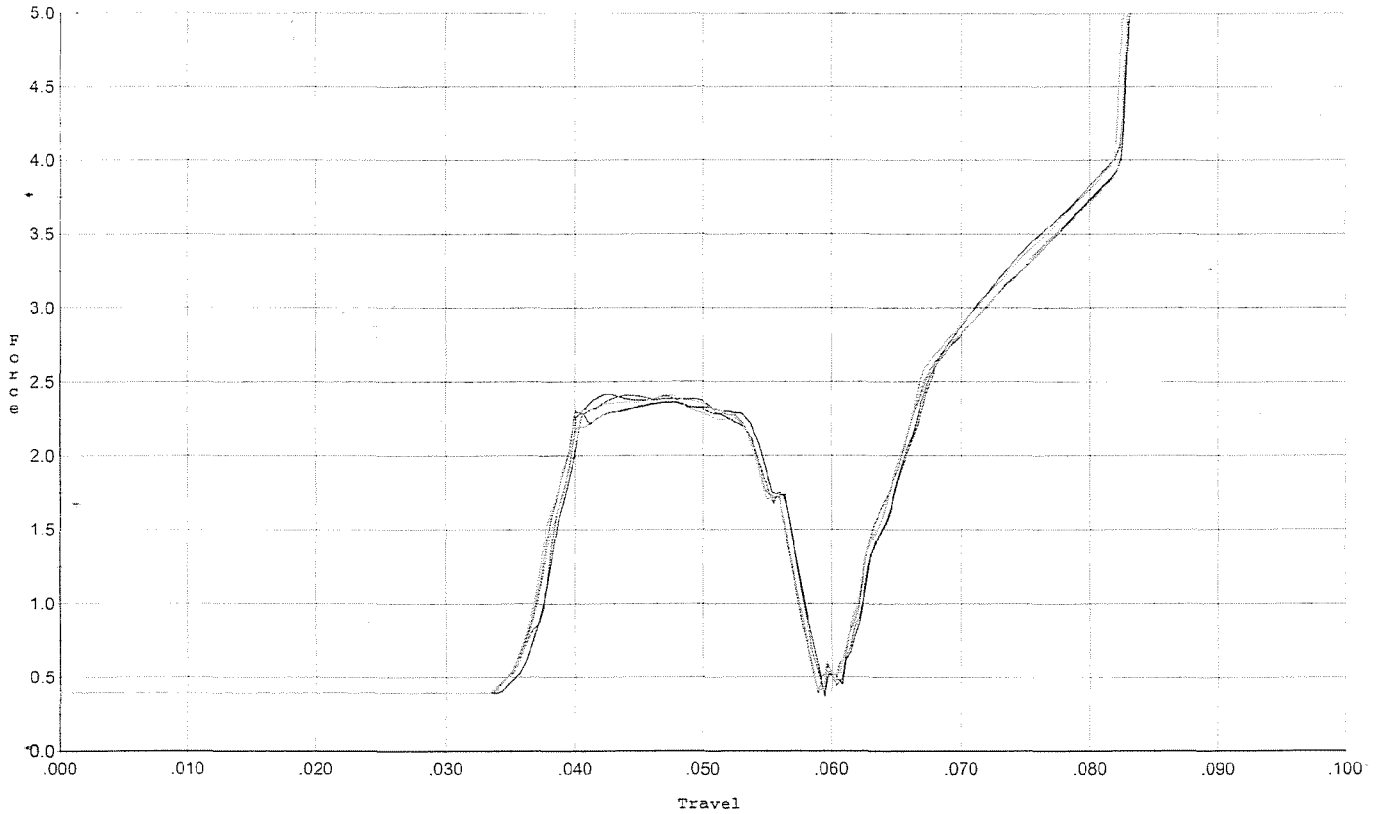
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>4.0</u>	11-11-08	X PD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.5</u>	11-11-08	X PD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.093</u> <u>.093</u> <u>.093</u>	11-11-08	X PD
	J) ASSEMBLE STOCK		10-21-08	RTL
	K) ASSEMBLE SWIVEL STUDS		11-11-08	X PD
	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	10-30-08	RSA
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TL
670	FINAL INSPECTION A) HEADSPACE		11-11-08	X PD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.14</u> <u>2.06</u> <u>2.13</u> <u>2.08</u> <u>2.10</u>	11/5/08	F.77
	C) FUNCTION		11-11-08	X PD
690	PACK			

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



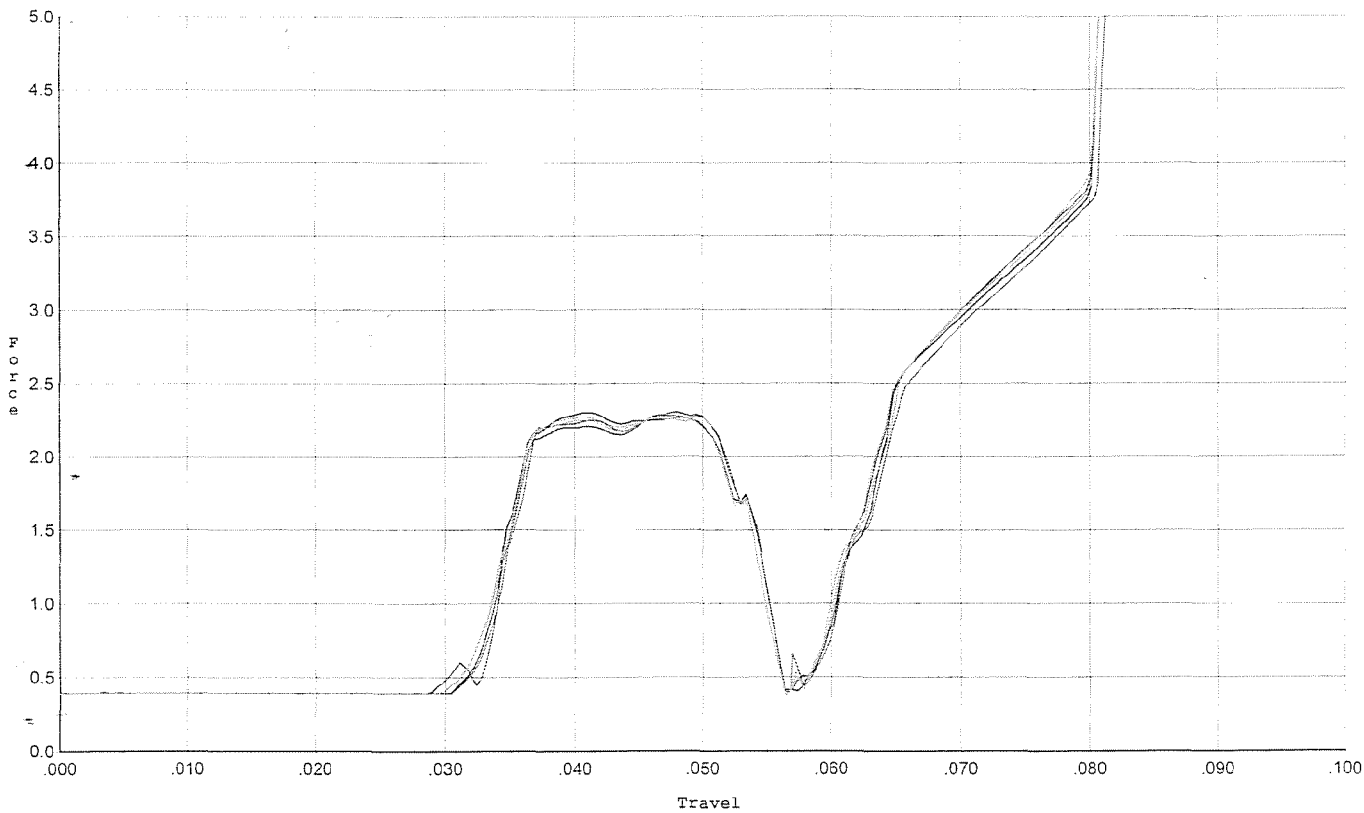
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.414	0.056	0.036	0.033	0.057		Set Trigger
2	2.363	0.056	0.036	0.033	0.056		Set Trigger
3	2.407	0.056	0.036	0.034	0.056		Set Trigger
4	2.413	0.056	0.036	0.034	0.056		Set Trigger
5	2.375	0.057	0.036	0.033	0.057		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



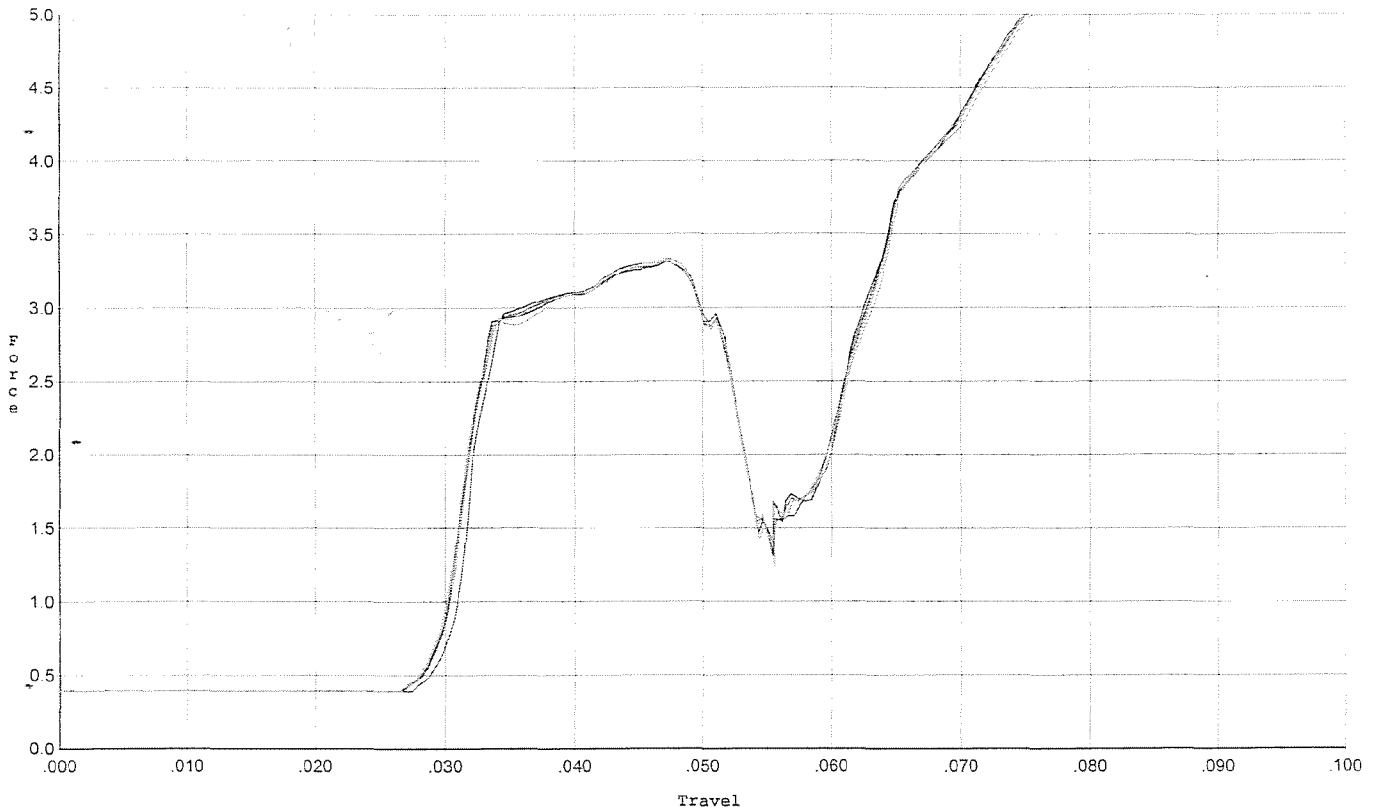
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.304	0.054	0.033	0.033	0.056		Set Trigger
2	2.300	0.054	0.033	0.033	0.056		Set Trigger
3	2.278	0.054	0.033	0.033	0.056		Set Trigger
4	2.260	0.053	0.032	0.033	0.055		Set Trigger
5	2.275	0.053	0.032	0.033	0.055		Set Trigger

A-2-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



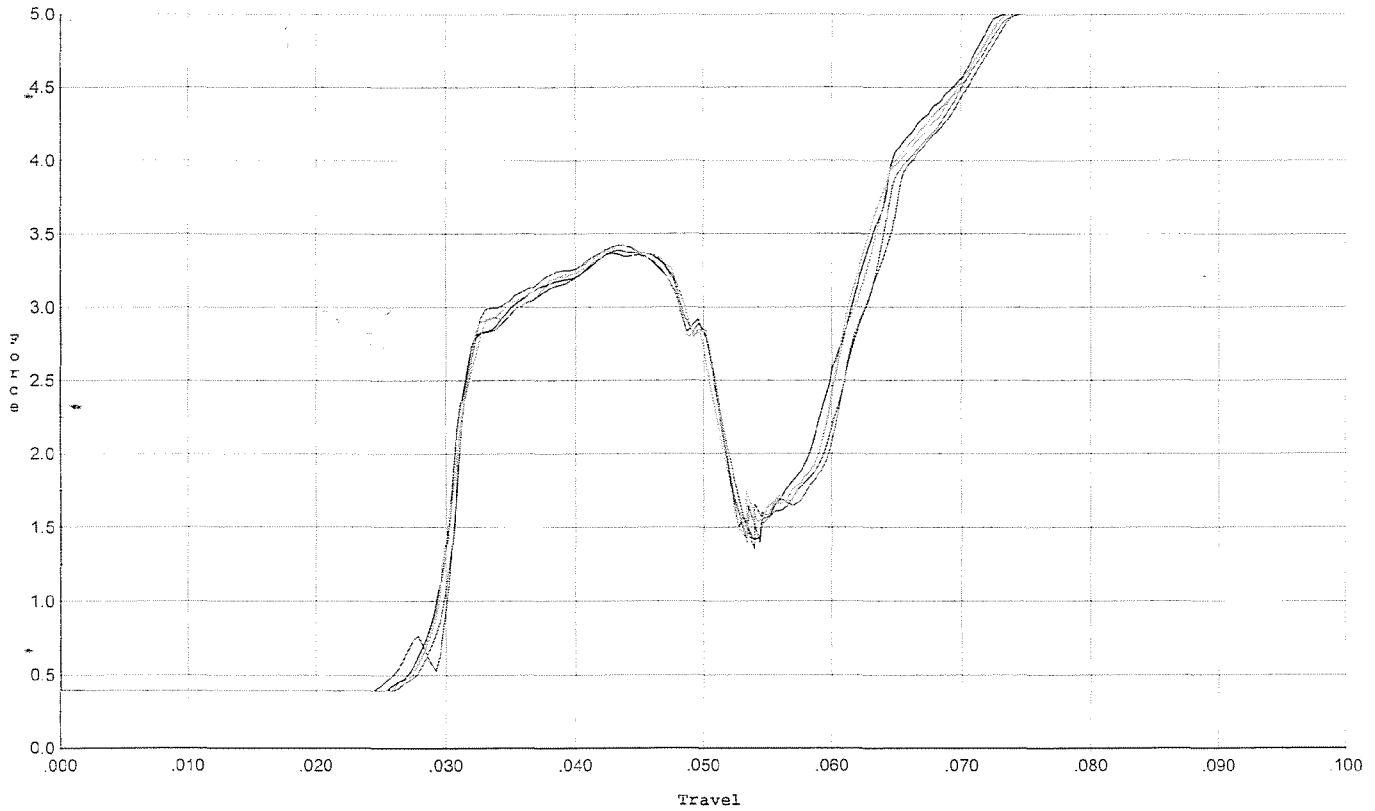
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.315	0.052	0.029	0.031	0.075		Set Trigger
2	3.307	0.052	0.029	0.031	0.076		Set Trigger
3	3.331	0.052	0.029	0.031	0.076		Set Trigger
4	3.312	0.052	0.029	0.031	0.076		Set Trigger
5	3.330	0.052	0.028	0.031	0.077		Set Trigger

A-3-31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



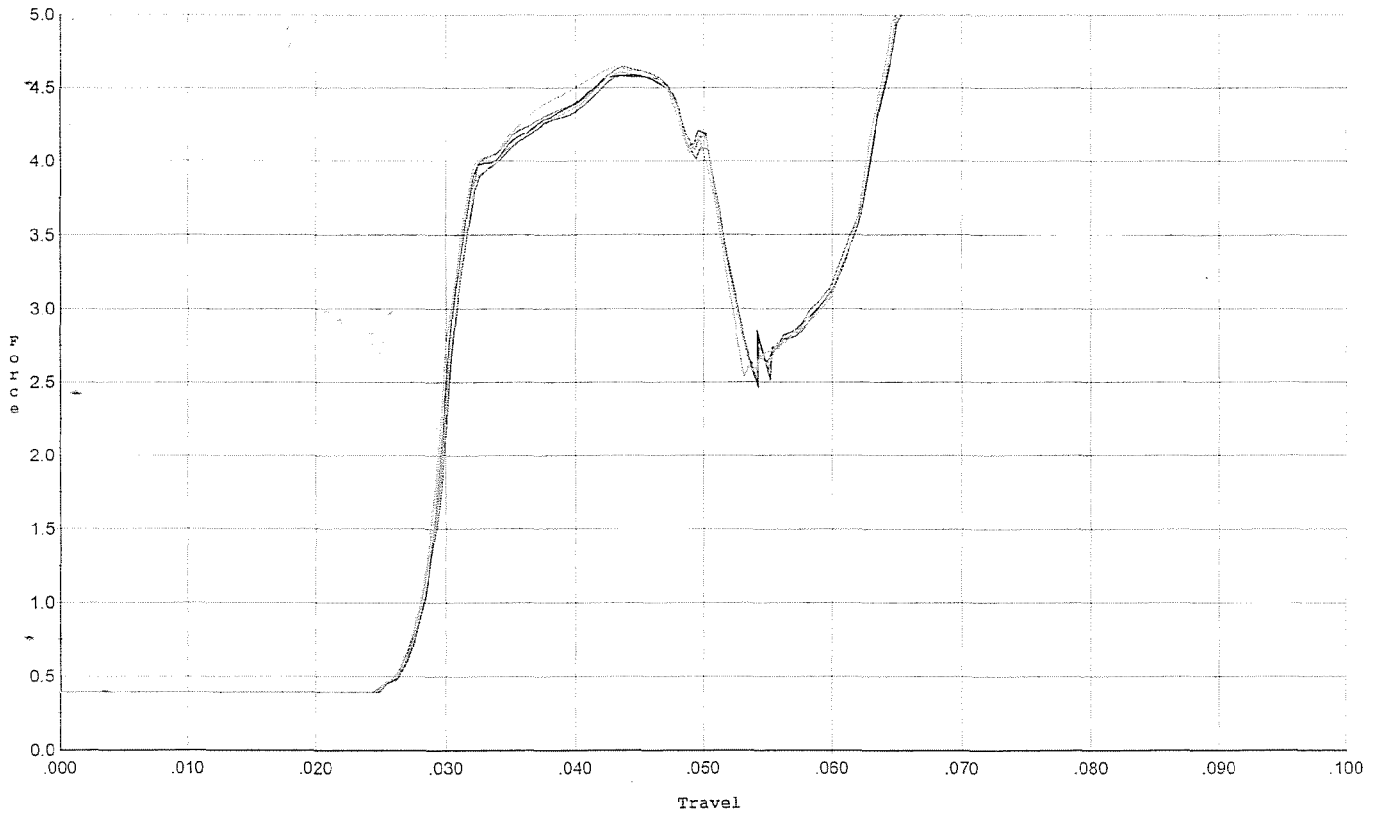
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.388	0.050	0.027	0.031	0.074		Set Trigger
2	3.371	0.050	0.028	0.030	0.075		Set Trigger
3	3.425	0.050	0.028	0.031	0.075		Set Trigger
4	3.400	0.051	0.028	0.030	0.076		Set Trigger
5	3.423	0.050	0.028	0.031	0.075		Set Trigger

A-3.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



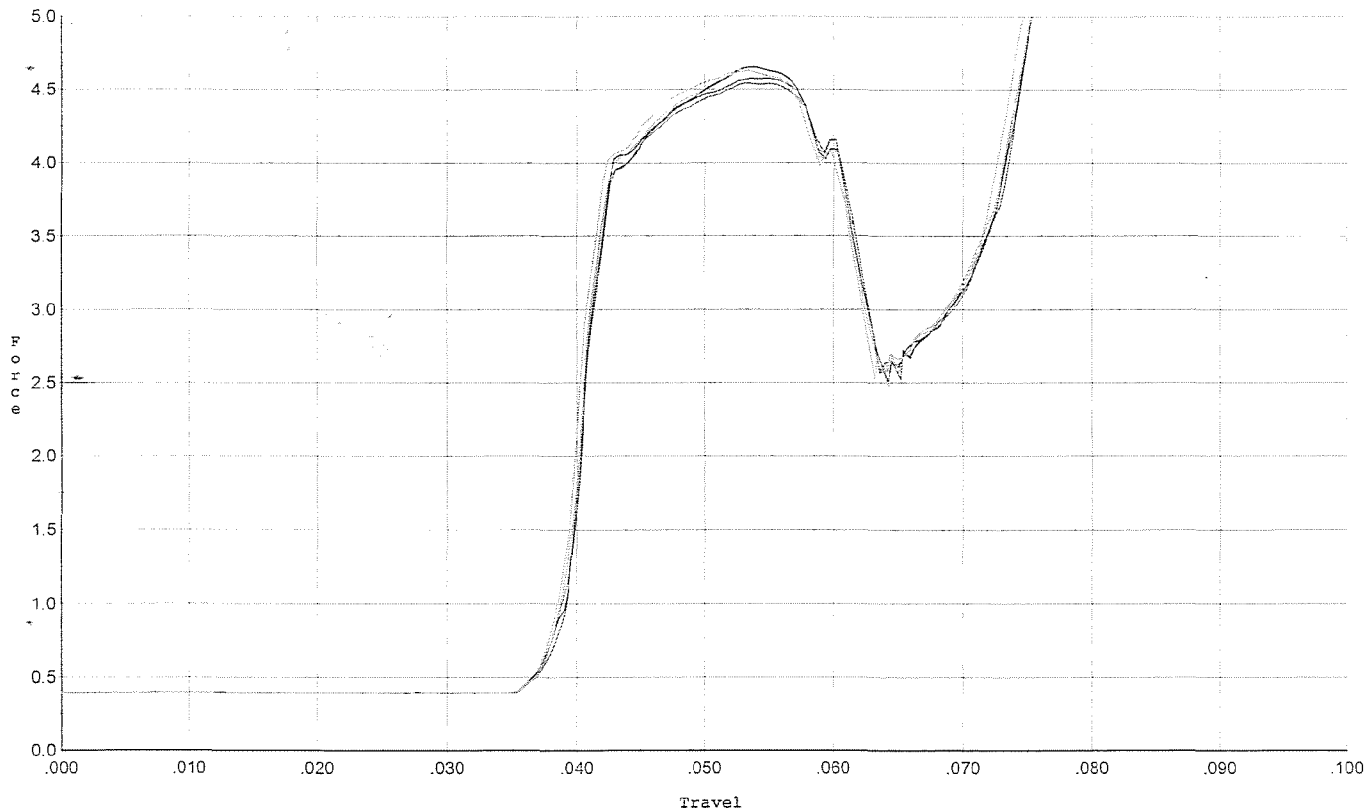
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.582	0.050	0.027	0.023	0.100		Set Trigger
2	4.585	0.050	0.027	0.023	0.101		Set Trigger
3	4.640	0.050	0.027	0.024	0.101		Set Trigger
4	4.604	0.050	0.027	0.024	0.101		Set Trigger
5	4.641	0.051	0.027	0.023	0.104		Set Trigger

A 4.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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



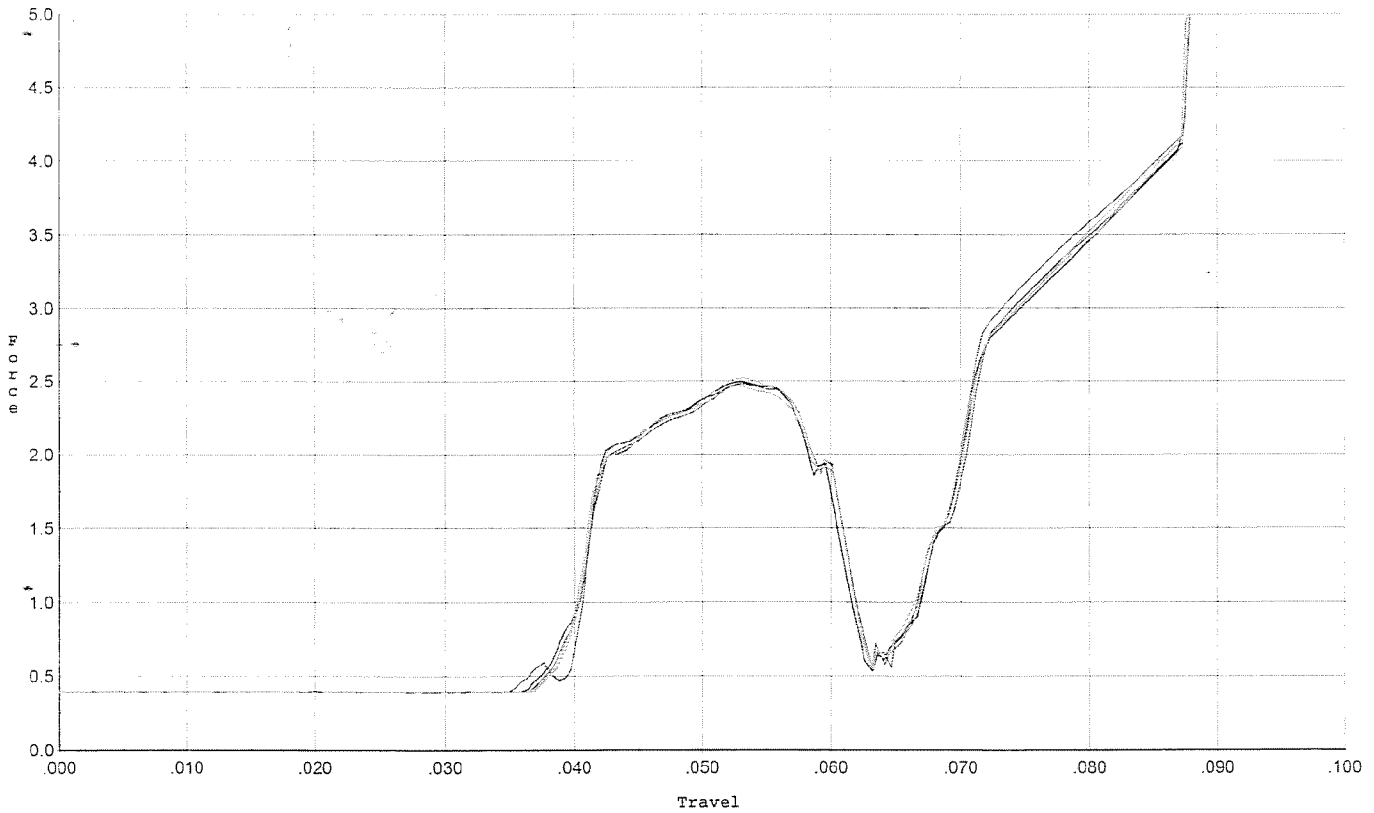
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.575	0.062	0.038	0.024	0.108		Set Trigger
2	4.652	0.060	0.038	0.025	0.106		Set Trigger
3	4.541	0.062	0.038	0.024	0.108		Set Trigger
4	4.634	0.061	0.037	0.024	0.108		Set Trigger
5	4.628	0.060	0.038	0.024	0.106		Set Trigger

A-4-60

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/23/2008

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



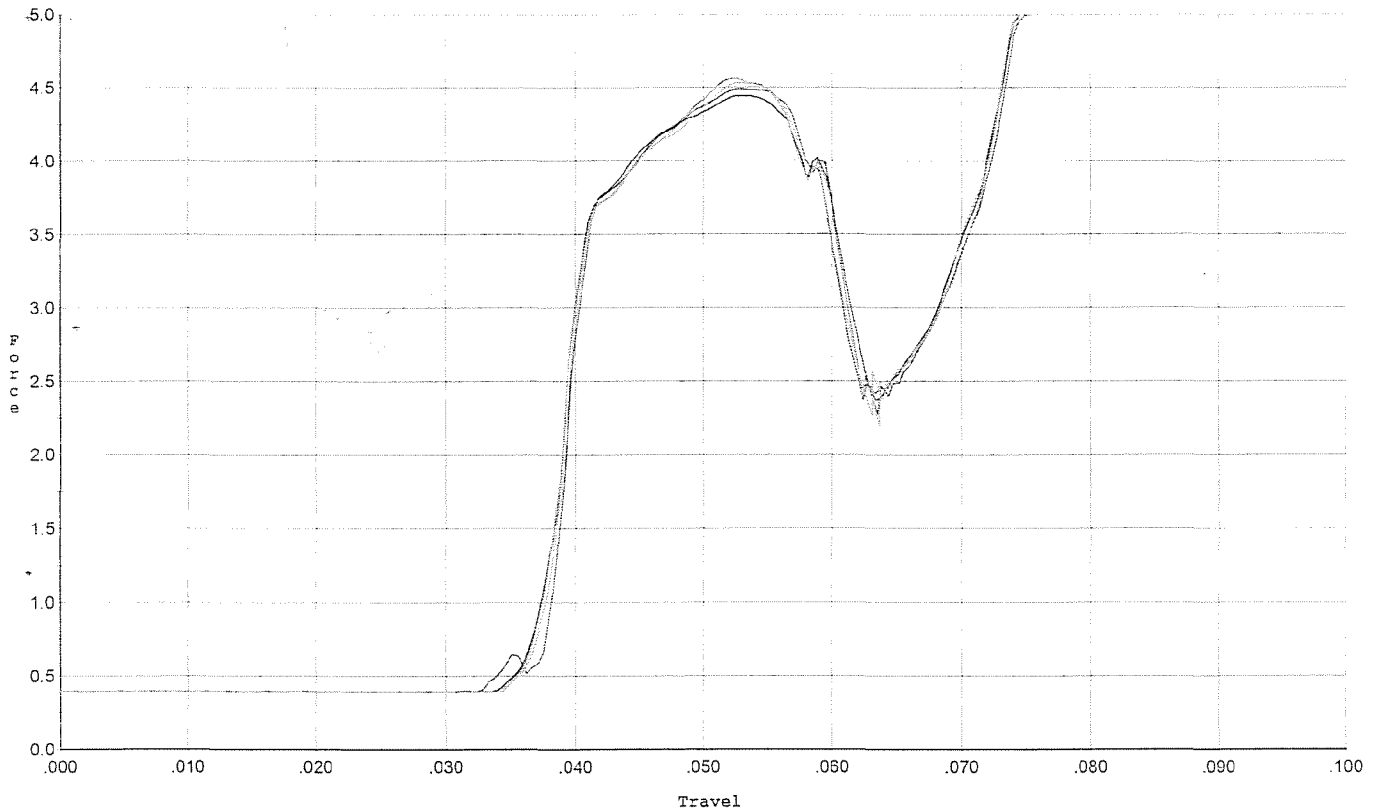
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.481	0.060	0.040	0.034	0.060		Set Trigger
2	2.494	0.060	0.039	0.034	0.060		Set Trigger
3	2.482	0.060	0.039	0.034	0.060		Set Trigger
4	2.521	0.060	0.039	0.034	0.061		Set Trigger
5	2.469	0.060	0.039	0.034	0.060		Set Trigger

A 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/23/2008

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	4.491	0.059	0.035	0.030	0.103		Set Trigger
2	4.443	0.060	0.036	0.029	0.103		Set Trigger
3	4.562	0.059	0.036	0.030	0.102		Set Trigger
4	4.560	0.059	0.036	0.029	0.102		Set Trigger
5	4.533	0.060	0.037	0.029	0.103		Set Trigger

A 4.51