

6679 4775

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



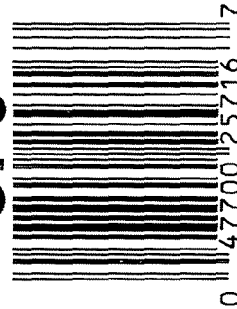
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794775

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794775

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RR
430	ASSEMBLE TO STOCK		3-6-09	RR
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-7-09	RR
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	3/13/09	(H)
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3-21	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-24-09	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SPD
	D) OIL FIRING PIN ASSEMBLY		3-24-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

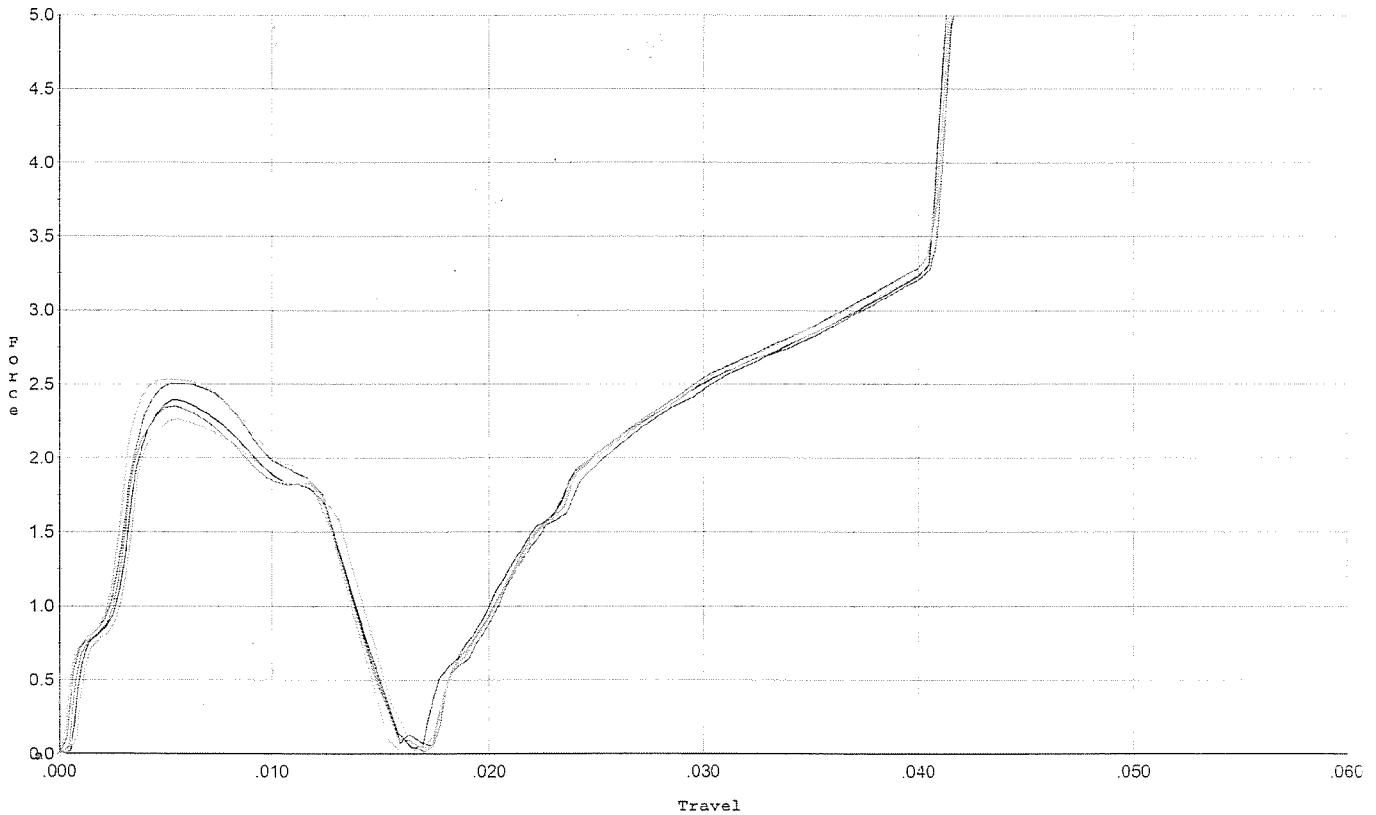
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-26-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-26-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	3-26-09	WV
	J) ASSEMBLE STOCK		3-24-09	APD
	K) ASSEMBLE SWIVEL STUDS		3-27-09	LN
	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	3-25-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-26-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.37</u> <u>2.42</u> <u>2.40</u> <u>2.39</u>	3-25-09	TL
	C) FUNCTION		3-26-09	WV
690	PACK		3-28-09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



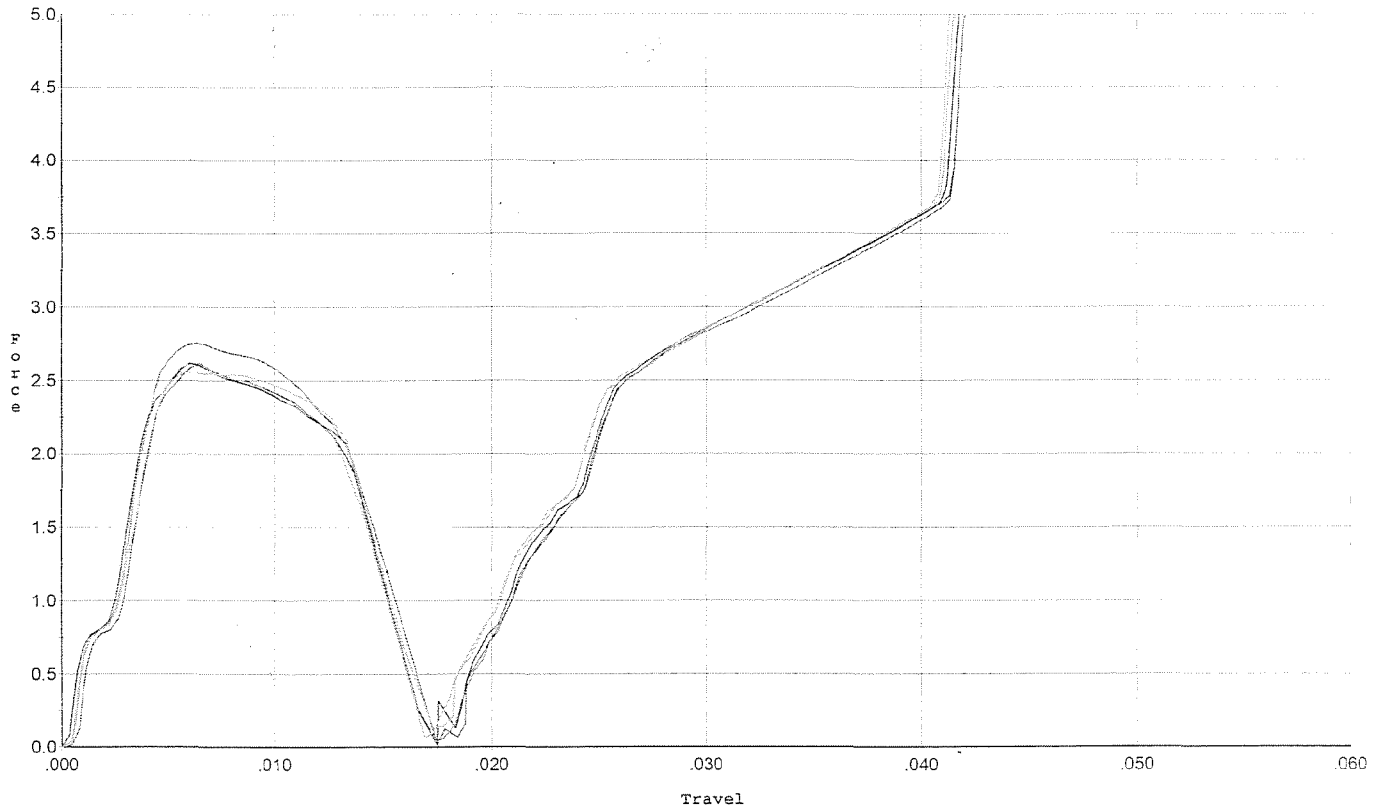
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.012	0.00	0.032	0.021		Set Trigger
2	2.396	0.012	0.00	0.032	0.020		Set Trigger
3	2.353	0.012	0.00	0.032	0.020		Set Trigger
4	2.535	0.013	0.00	0.032	0.022		Set Trigger
5	2.266	0.013	0.00	0.031	0.020		Set Trigger

A-2-41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



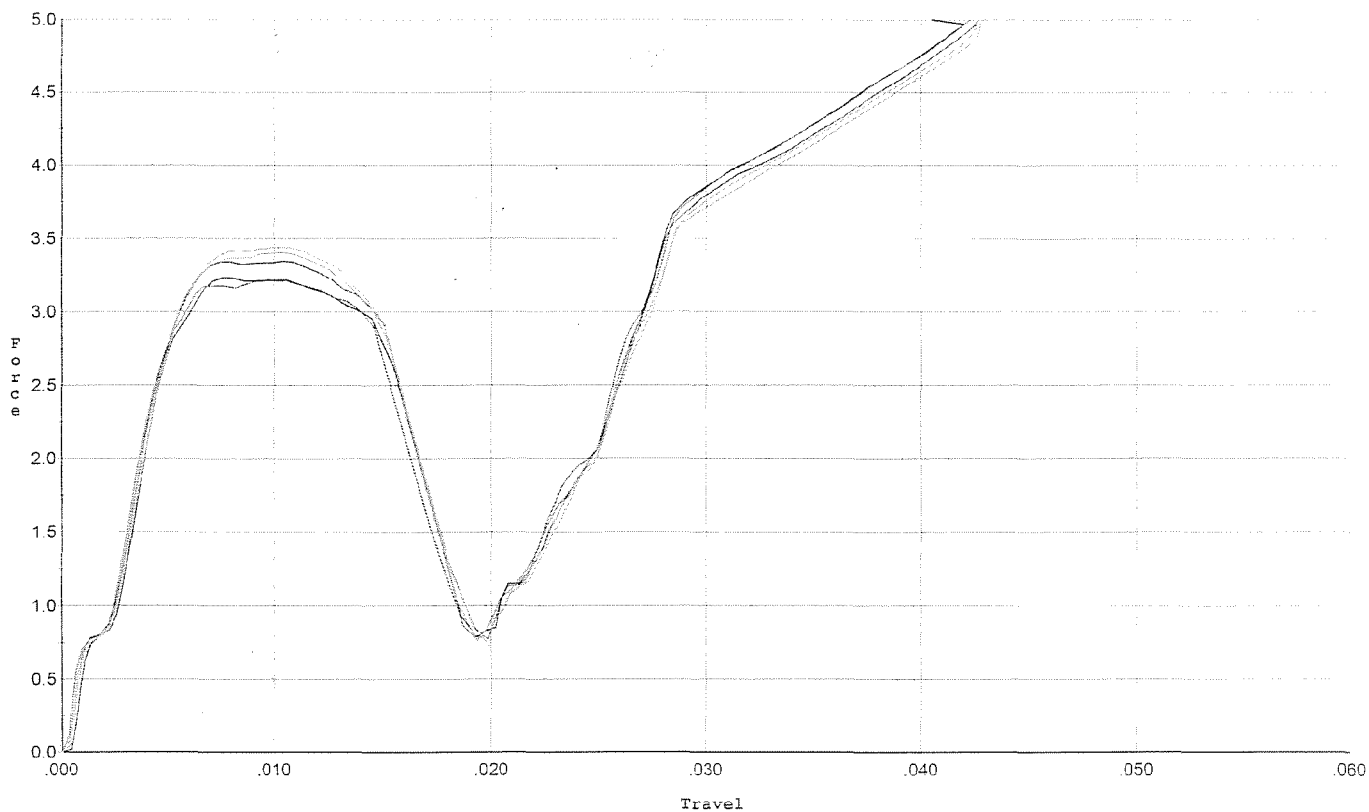
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.015	0.00	0.031	0.027		Set Trigger
2	2.618	0.014	0.00	0.031	0.025		Set Trigger
3	2.755	0.013	0.00	0.031	0.025		Set Trigger
4	2.608	0.014	0.00	0.030	0.025		Set Trigger
5	2.558	0.013	0.00	0.031	0.024		Set Trigger

A-2-65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



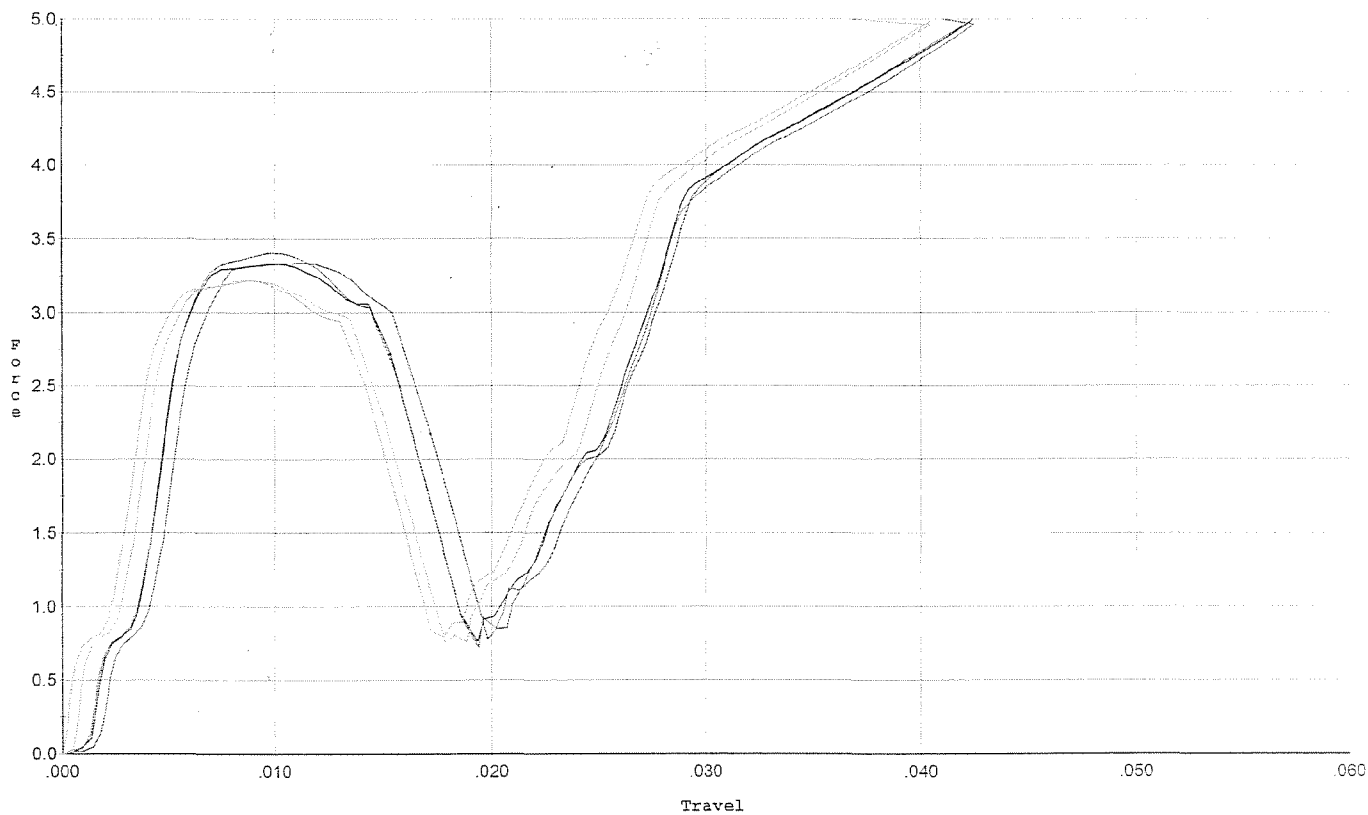
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.347	0.015	0.00	0.028	0.036		Set Trigger
2	3.234	0.016	0.00	0.028	0.035		Set Trigger
3	3.213	0.015	0.00	0.028	0.034		Set Trigger
4	3.407	0.015	0.00	0.028	0.036		Set Trigger
5	3.436	0.015	0.00	0.028	0.036		Set Trigger

A 3.32

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



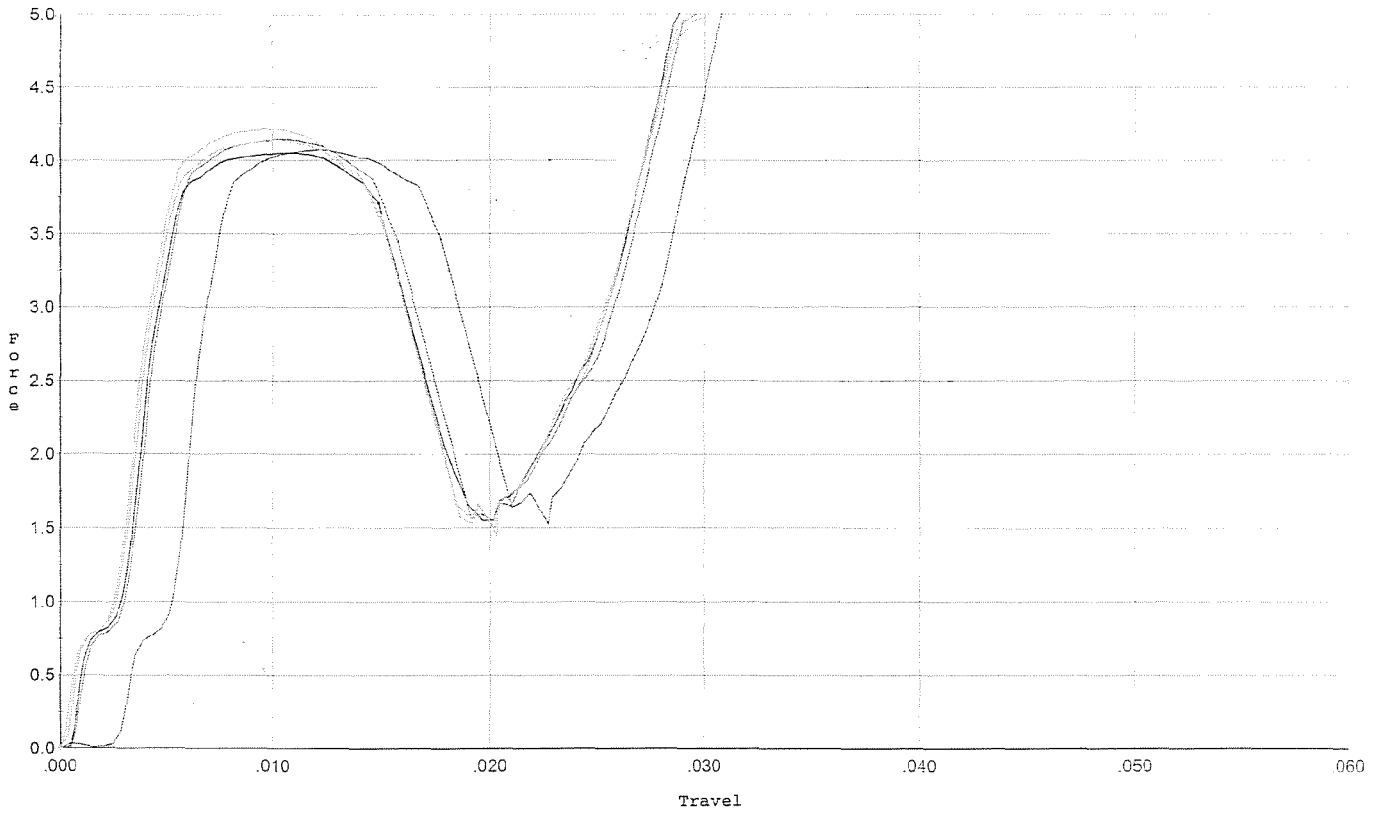
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.336	0.017	0.00	0.028	0.037		Set Trigger
2	3.336	0.015	0.00	0.028	0.034		Set Trigger
3	3.405	0.016	0.00	0.028	0.034		Set Trigger
4	3.216	0.015	0.00	0.028	0.033		Set Trigger
5	3.222	0.014	0.00	0.027	0.032		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



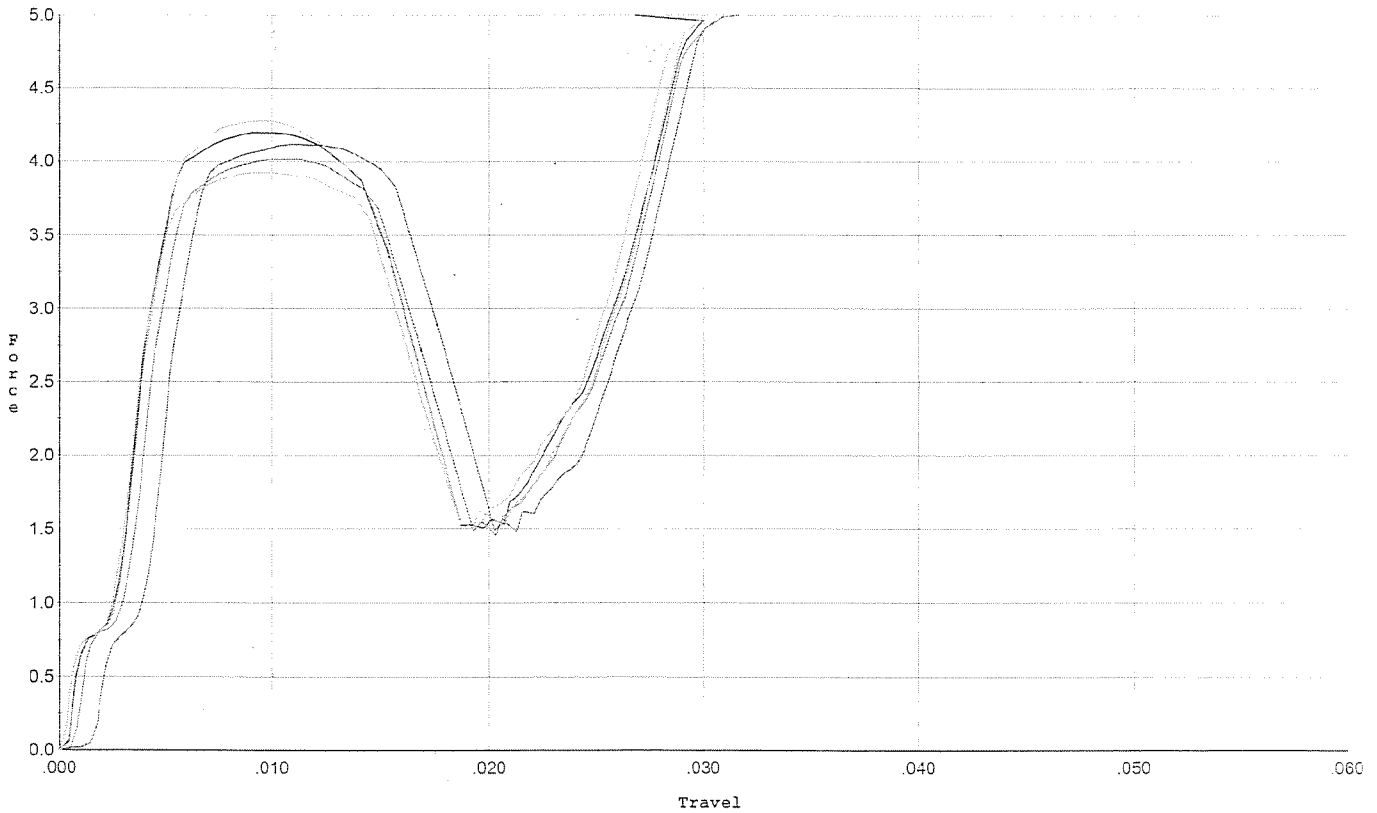
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.074	0.018	0.003	0.027	0.044		Set Trigger
2	4.052	0.015	0.00	0.026	0.041		Set Trigger
3	4.148	0.016	0.00	0.026	0.044		Set Trigger
4	4.219	0.015	0.00	0.026	0.043		Set Trigger
5	4.143	0.015	0.00	0.026	0.043		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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



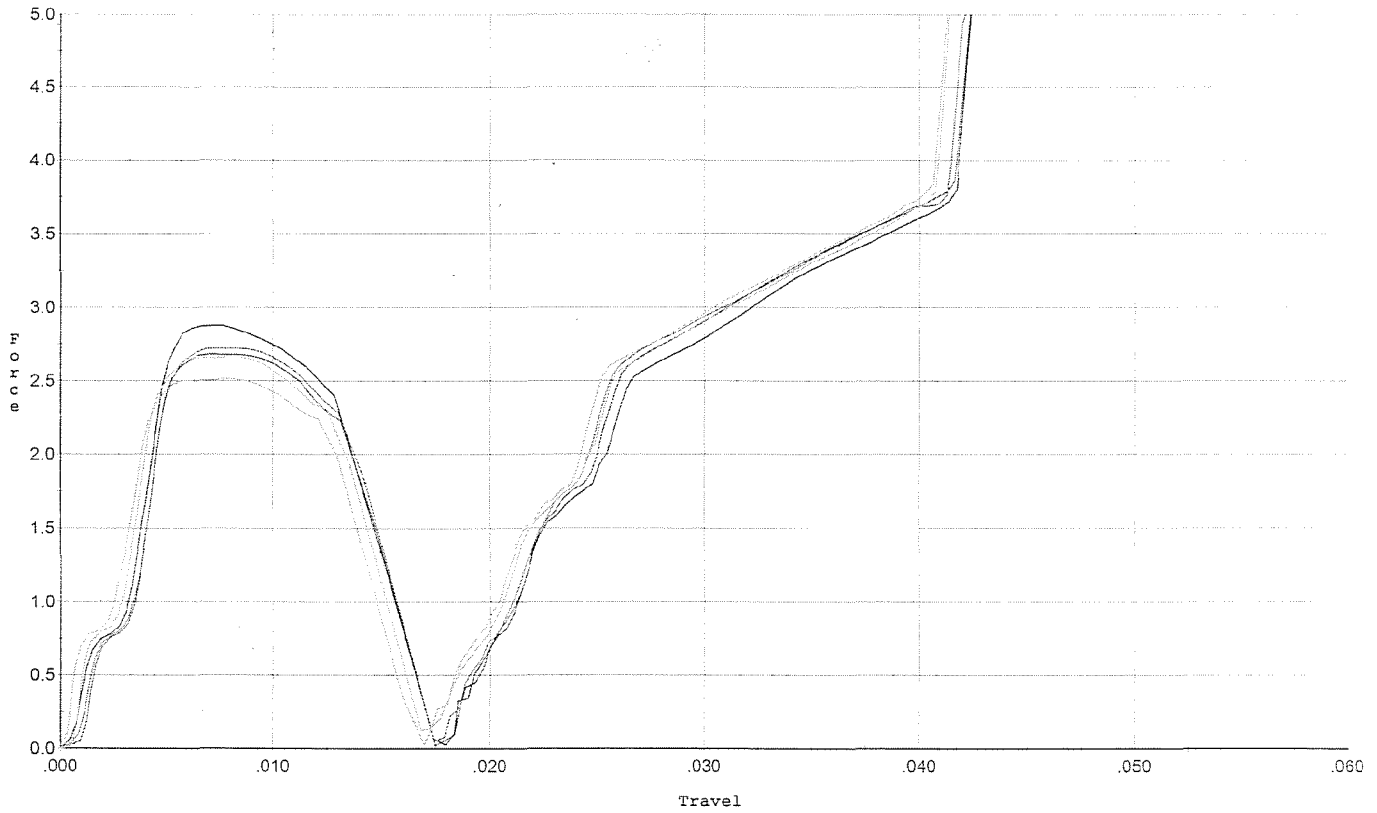
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.115	0.018	0.00	0.027	0.047		Set Trigger
2	4.195	0.015	0.00	0.026	0.044		Set Trigger
3	4.014	0.017	0.00	0.026	0.046		Set Trigger
4	4.274	0.015	0.00	0.027	0.044		Set Trigger
5	3.923	0.015	0.00	0.026	0.040		Set Trigger

A-4.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



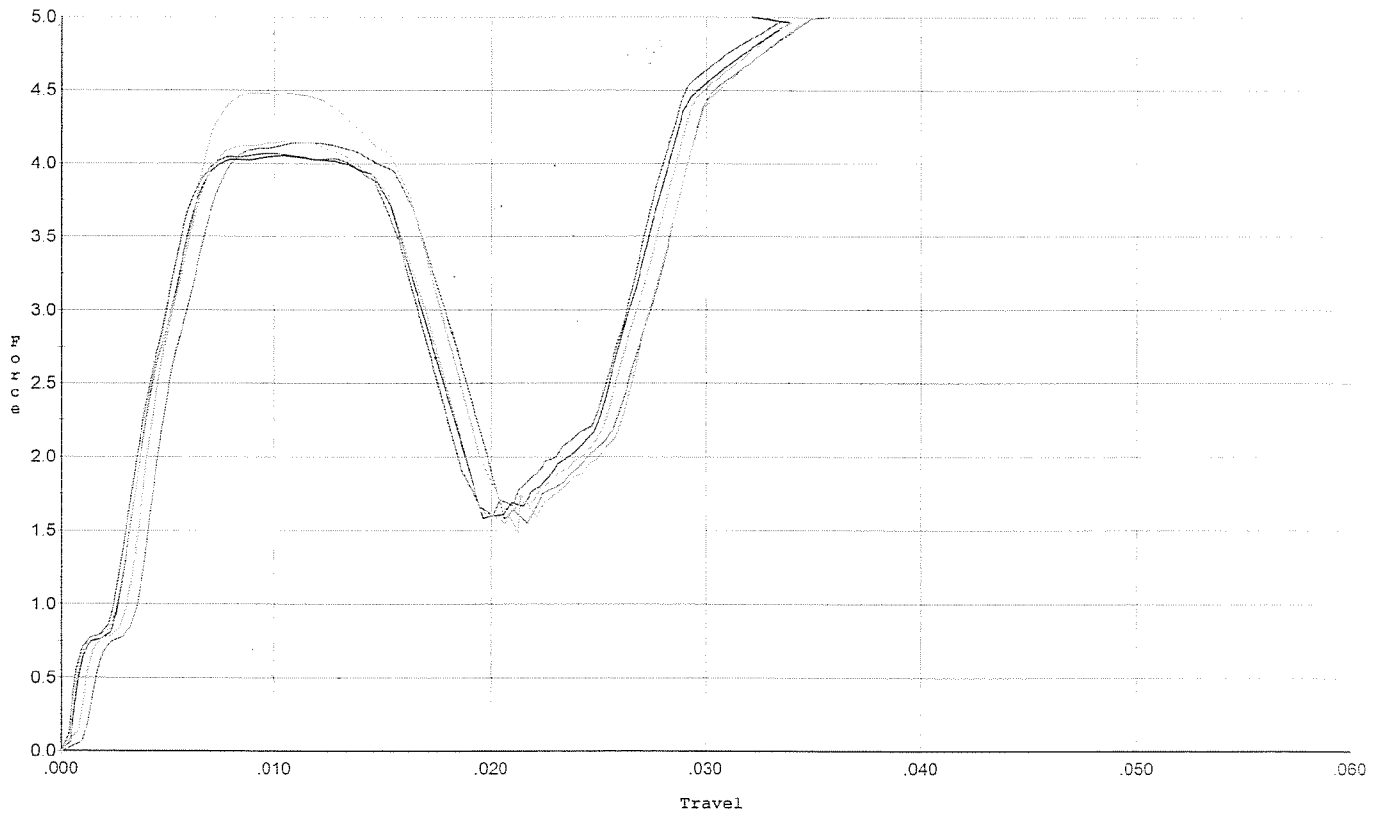
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.680	0.015	0.00	0.031	0.026		Set Trigger
2	2.877	0.015	0.00	0.031	0.028		Set Trigger
3	2.720	0.014	0.00	0.030	0.026		Set Trigger
4	2.663	0.014	0.00	0.030	0.025		Set Trigger
5	2.515	0.013	0.00	0.031	0.023		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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	4.066	0.016	0.00	0.024	0.044		Set Trigger
2	4.051	0.017	0.00	0.024	0.048		Set Trigger
3	4.140	0.018	0.00	0.024	0.049		Set Trigger
4	4.145	0.017	0.00	0.024	0.047		Set Trigger
5	4.485	0.016	0.00	0.025	0.048		Set Trigger

A. 4.07