

G 6794809

 **Oxford.**

ESSELTE

NO. 752 1/3

10%



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



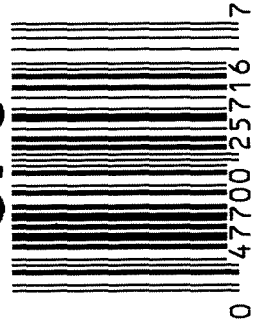
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794809

UPC



GUN SERIAL # G 6794809

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	RT
460	CHECK HEADSPACE		3-6-09	RT
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES	MARK 10 2005	3-9-09	JF
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	3/13/09	(H)
490	MAGNAFLUX BOLT		3/13/09	RT
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	JF
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	JF
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	JF
	D) OIL FIRING PIN ASSEMBLY		3-25-09	PR
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

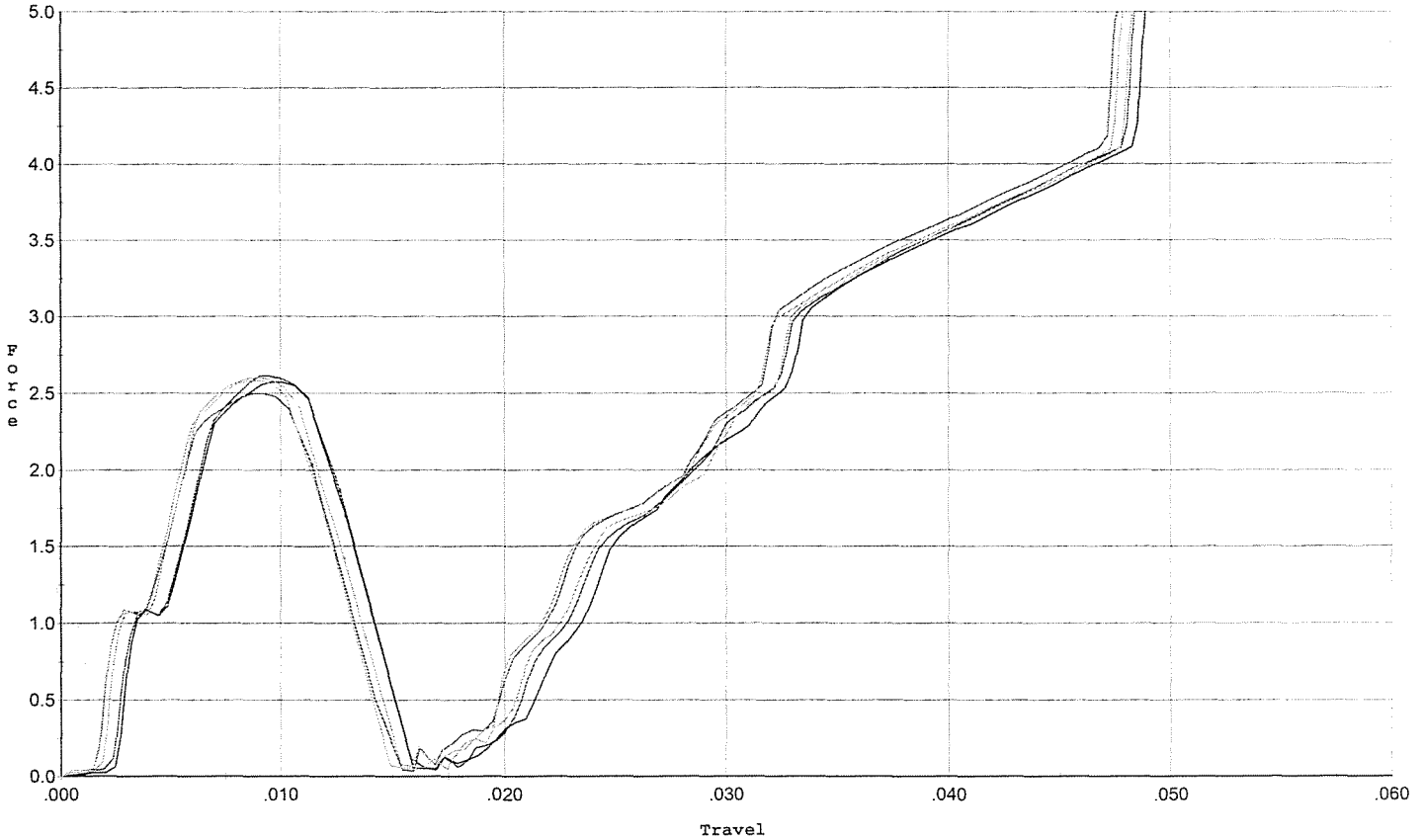
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	3-30-09	LW		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>60</u>	<u>50</u>	<u>50</u>	3-30-09	LW		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.022</u>	<u>.023</u>	3-30-09	LW		
	J) ASSEMBLE STOCK					3-25-09	LW		
	K) ASSEMBLE SWIVEL STUDS					3-31-09	LW		
	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		3-27-09	TL		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION CORRECTION CORRECTION CORRECTION N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					3-27-09	NW		
670	FINAL INSPECTION A) HEADSPACE					3-31-09	LW		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u>	<u>2.29</u>	<u>2.33</u>	<u>2.37</u>	<u>2.40</u>	3-30-09	TL
	C) FUNCTION					3-31-09	LW		
690	PACK					4/13/09	FM		

Trigger Profile [lbs,inch]

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

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



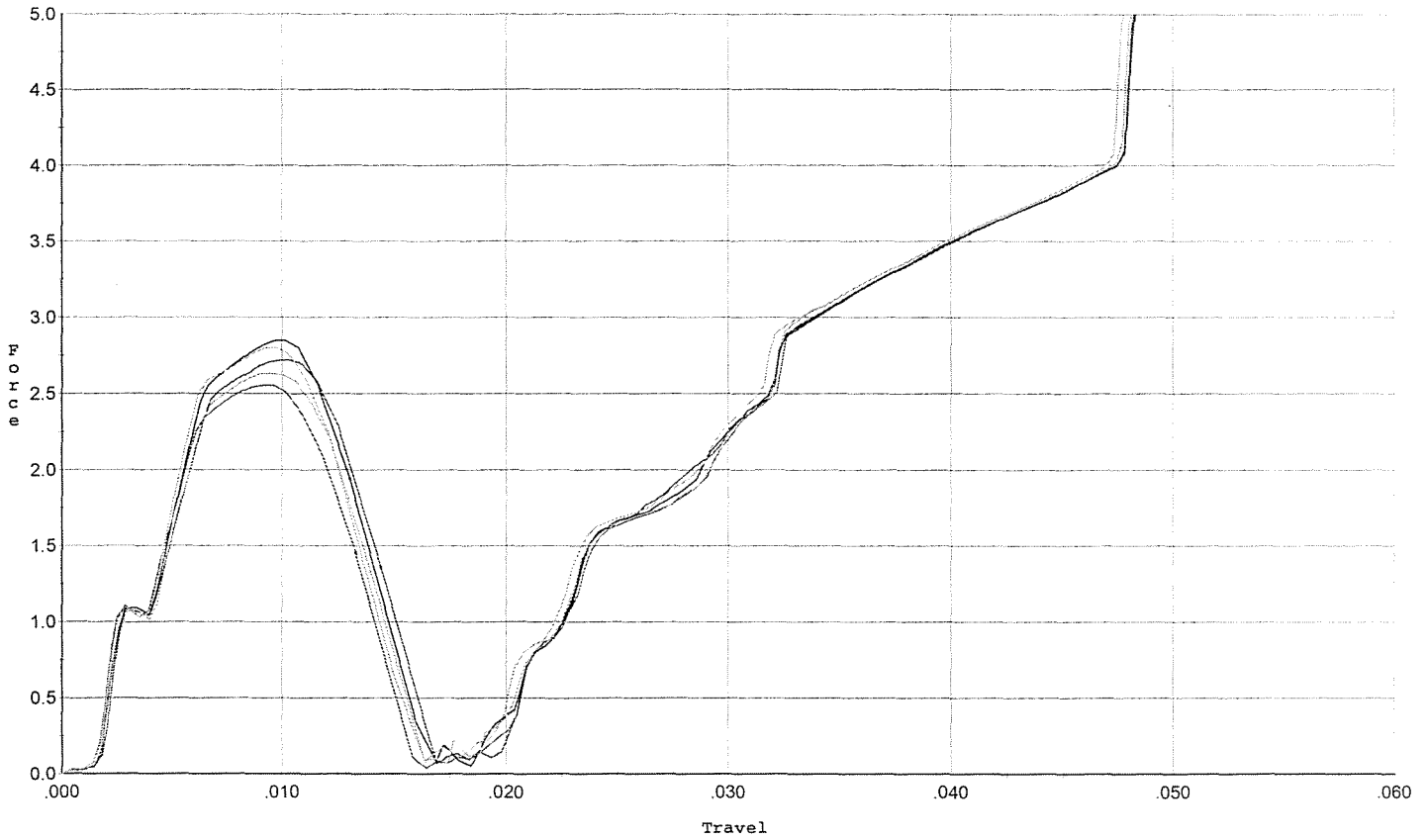
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.611	0.013	0.00	0.038	0.019		Set Trigger
2	2.572	0.013	0.00	0.038	0.019		Set Trigger
3	2.499	0.011	0.00	0.038	0.017		Set Trigger
4	2.582	0.012	0.00	0.038	0.018		Set Trigger
5	2.600	0.013	0.00	0.037	0.020		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

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

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



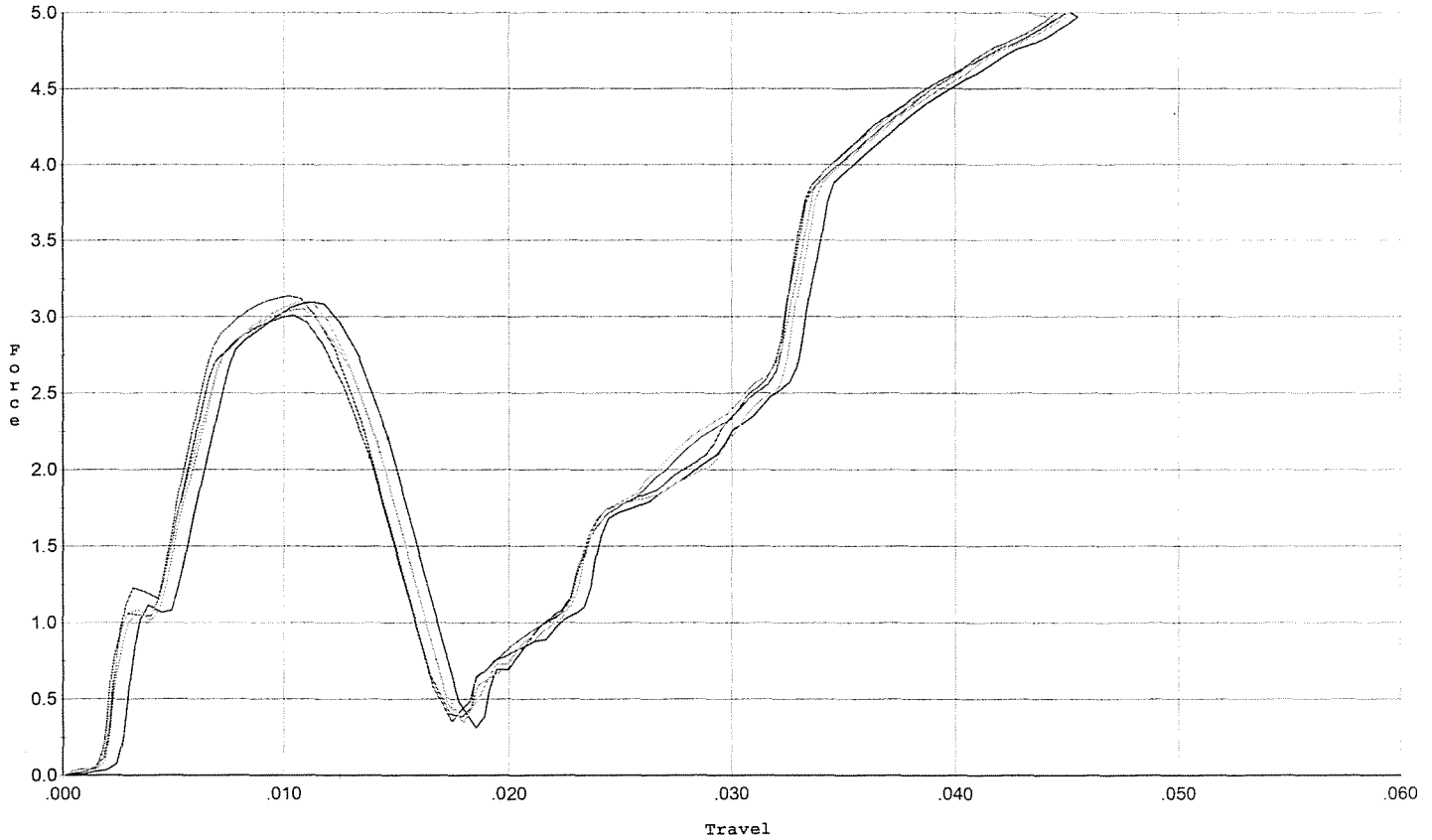
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.717	0.014	0.004	0.037	0.024		Set Trigger
2	2.847	0.013	0.004	0.037	0.022		Set Trigger
3	2.554	0.013	0.00	0.037	0.021		Set Trigger
4	2.802	0.012	0.00	0.037	0.020		Set Trigger
5	2.630	0.014	0.00	0.037	0.022		Set Trigger

A-2.71

Trigger Profile [lbs,inch]

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

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



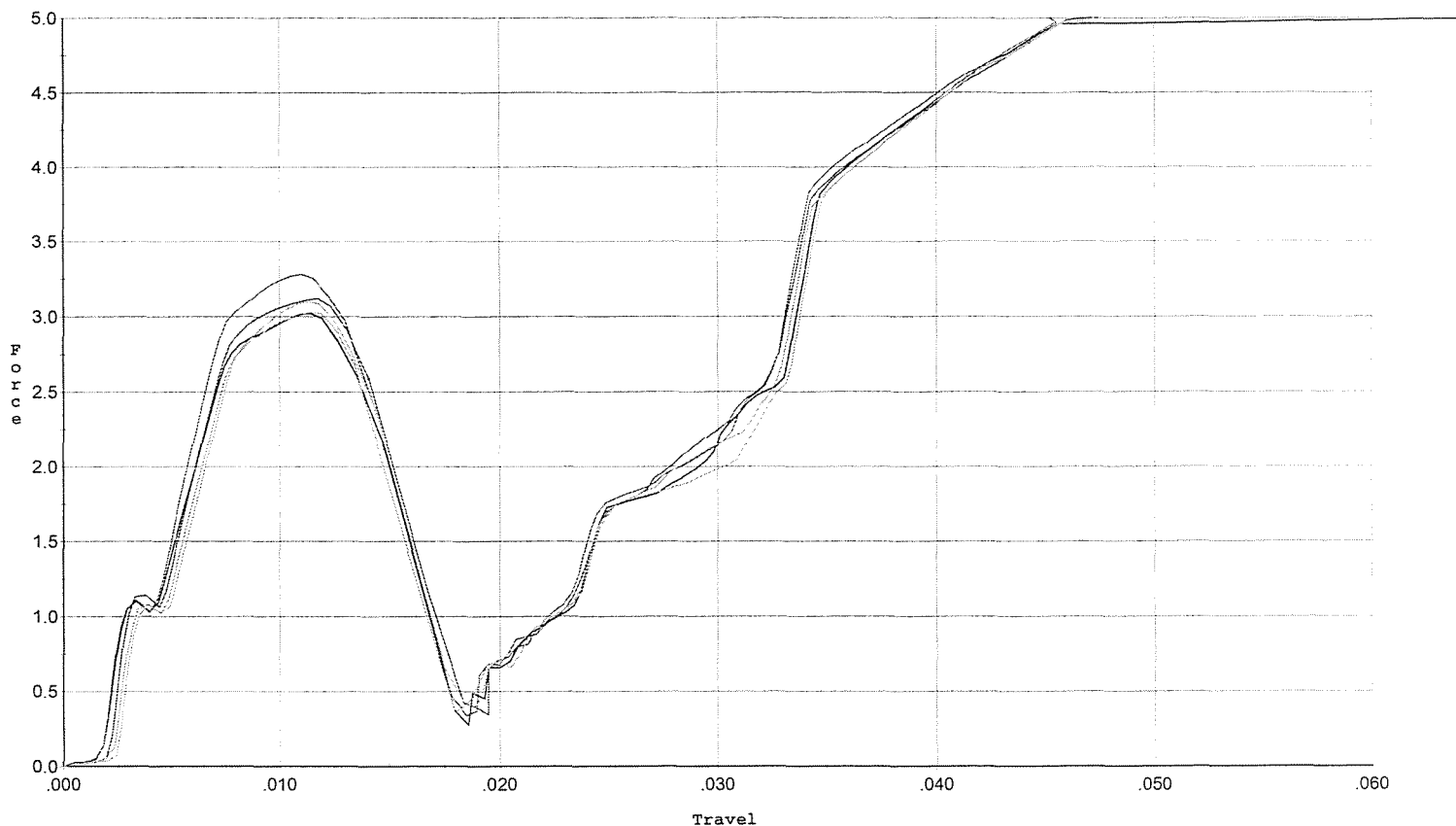
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.008	0.014	0.005	0.035	0.025		Set Trigger
2	3.093	0.015	0.00	0.035	0.026		Set Trigger
3	3.134	0.014	0.004	0.035	0.025		Set Trigger
4	3.101	0.014	0.00	0.035	0.026		Set Trigger
5	3.051	0.014	0.00	0.034	0.026		Set Trigger

A-3-07

Trigger Profile [lbs,inch]

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

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



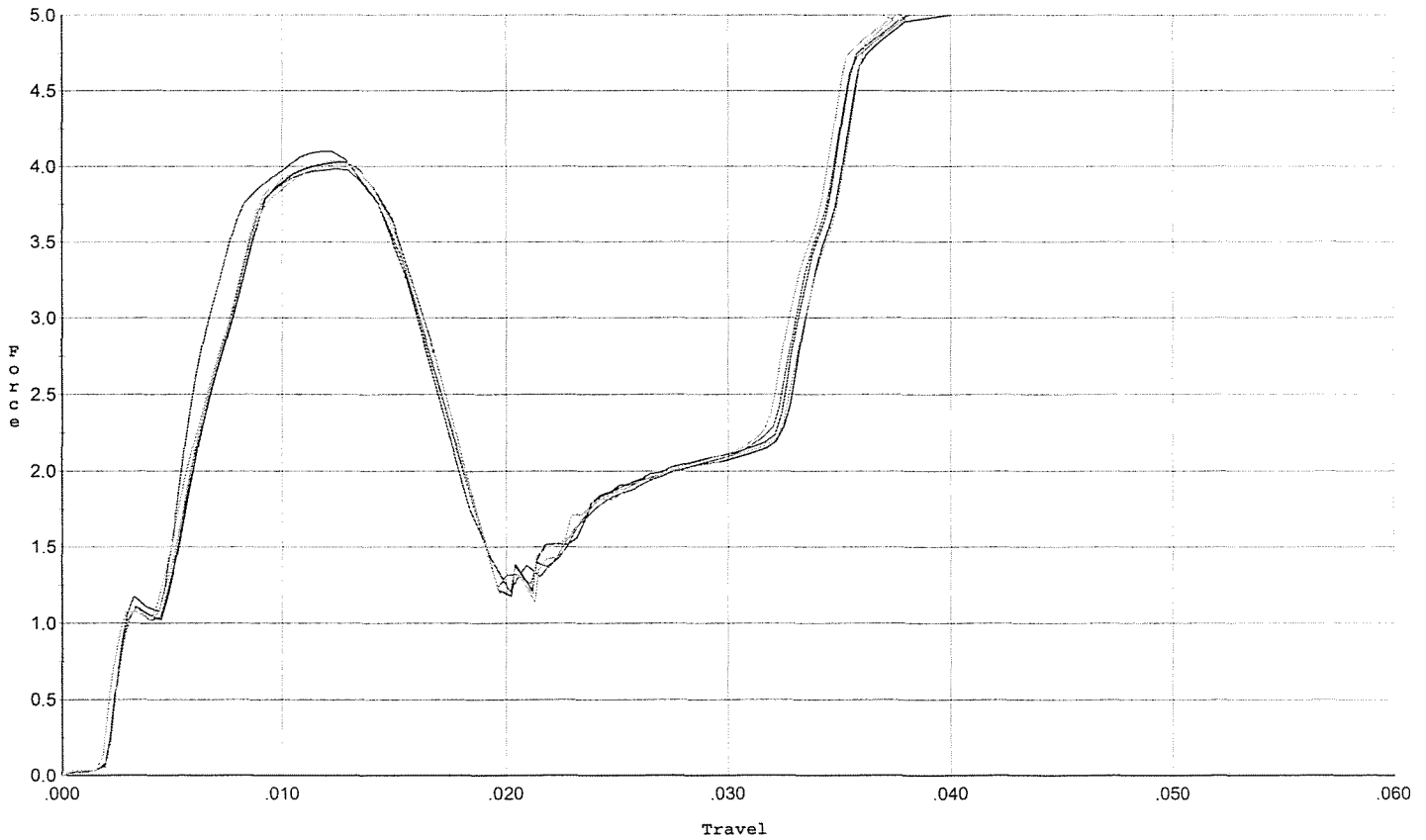
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.120	0.014	0.00	0.035	0.026		Set Trigger
2	3.023	0.015	0.00	0.035	0.027		Set Trigger
3	3.282	0.014	0.00	0.035	0.028		Set Trigger
4	3.097	0.014	0.00	0.035	0.025		Set Trigger
5	3.029	0.013	0.00	0.035	0.023		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

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

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



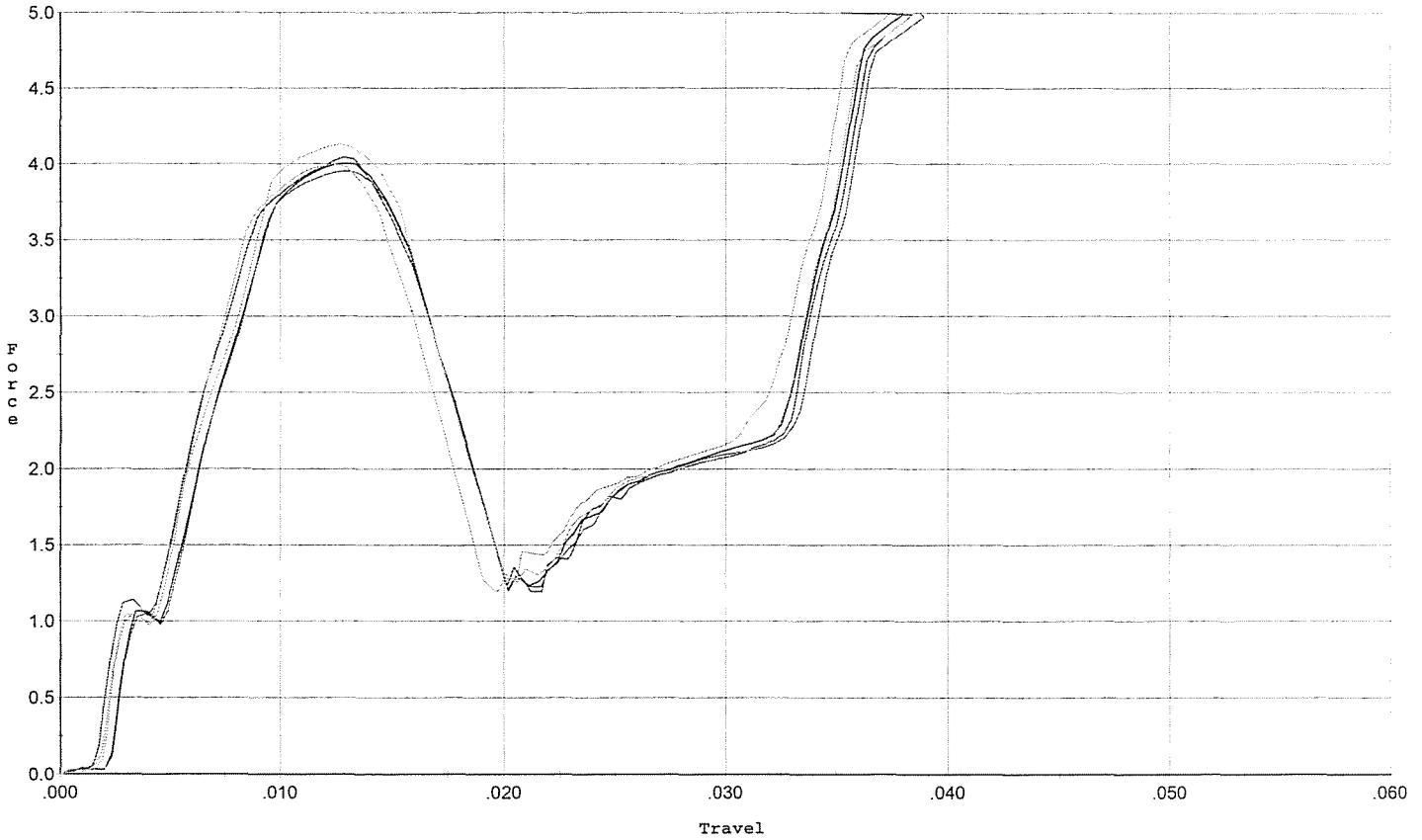
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.016	0.005	0.033	0.038		Set Trigger
2	4.029	0.017	0.005	0.033	0.039		Set Trigger
3	3.986	0.015	0.002	0.033	0.035		Set Trigger
4	4.042	0.015	0.002	0.033	0.036		Set Trigger
5	4.016	0.017	0.00	0.033	0.039		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

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

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



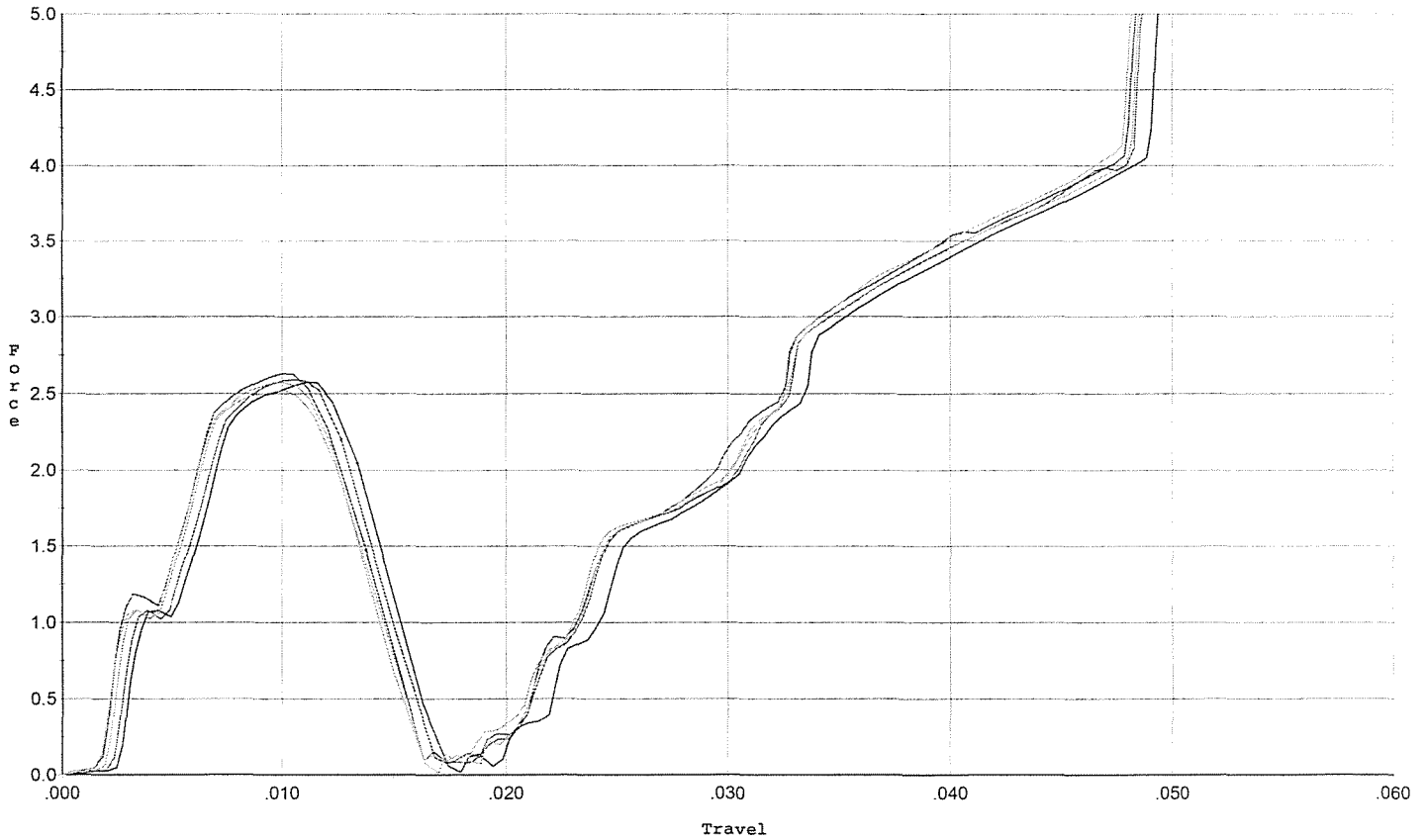
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.044	0.018	0.00	0.033	0.042		Set Trigger
2	4.002	0.018	0.002	0.033	0.041		Set Trigger
3	3.951	0.016	0.002	0.033	0.036		Set Trigger
4	4.131	0.015	0.004	0.033	0.037		Set Trigger
5	3.998	0.016	0.002	0.032	0.037		Set Trigger

A. 4.02

Trigger Profile [lbs,inch]

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

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



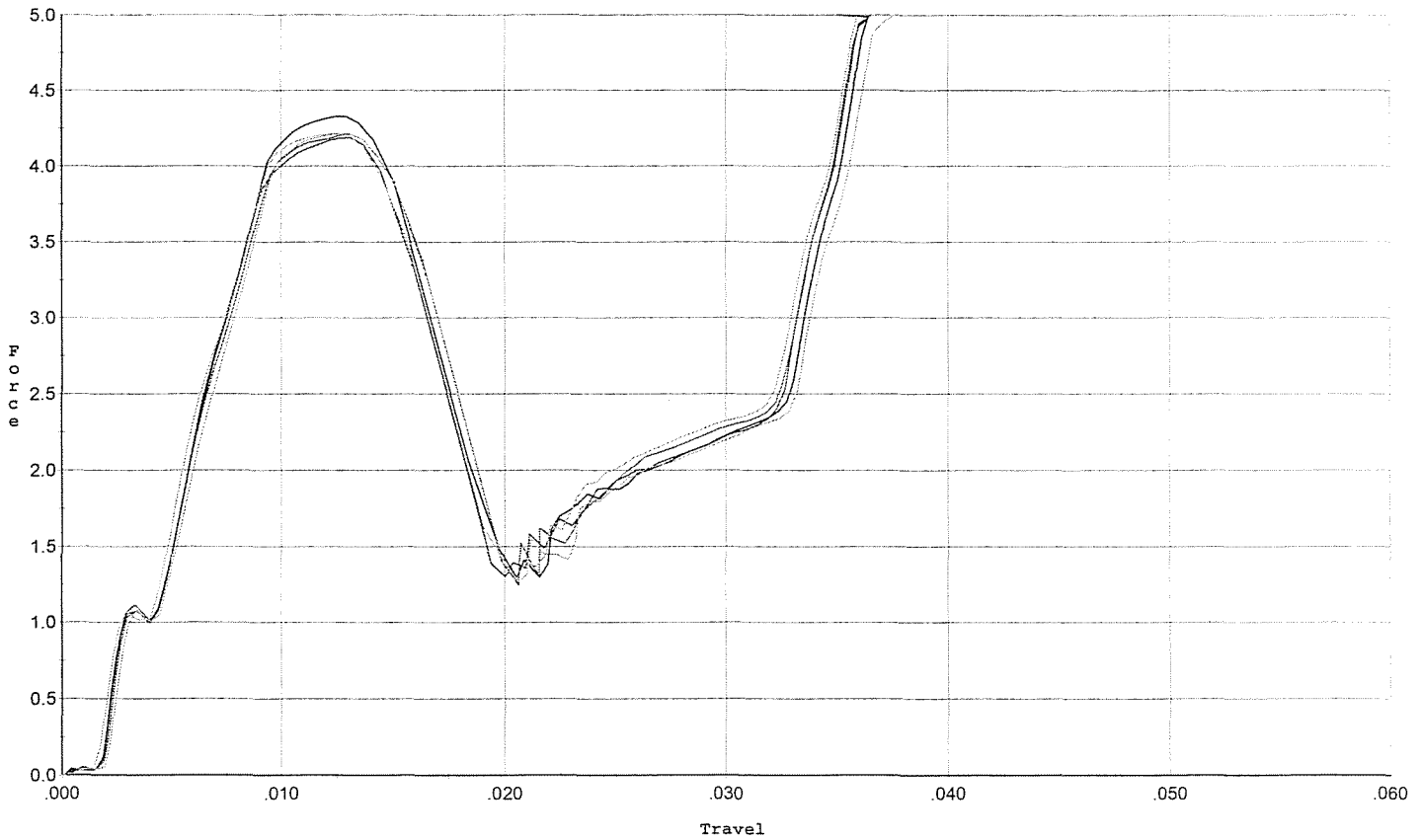
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.631	0.014	0.005	0.037	0.022		Set Trigger
2	2.576	0.013	0.00	0.038	0.020		Set Trigger
3	2.591	0.013	0.002	0.038	0.019		Set Trigger
4	2.570	0.012	0.00	0.038	0.019		Set Trigger
5	2.519	0.014	0.00	0.037	0.021		Set Trigger

A-257

Trigger Profile [lbs,inch]

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

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	4.188	0.016	0.00	0.032	0.039		Set Trigger
2	4.328	0.015	0.002	0.031	0.037		Set Trigger
3	4.211	0.016	0.00	0.031	0.040		Set Trigger
4	4.219	0.016	0.004	0.031	0.039		Set Trigger
5	4.214	0.016	0.00	0.032	0.040		Set Trigger

A-4.23