

66810354

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

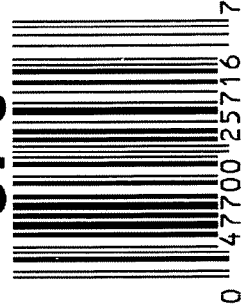
24"

CAPACITY

6

G6810354

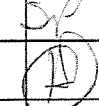
UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6810354

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RZ
430	ASSEMBLE TO STOCK		3-6-09	RTK
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/13/09	
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)		3/24	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-26-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

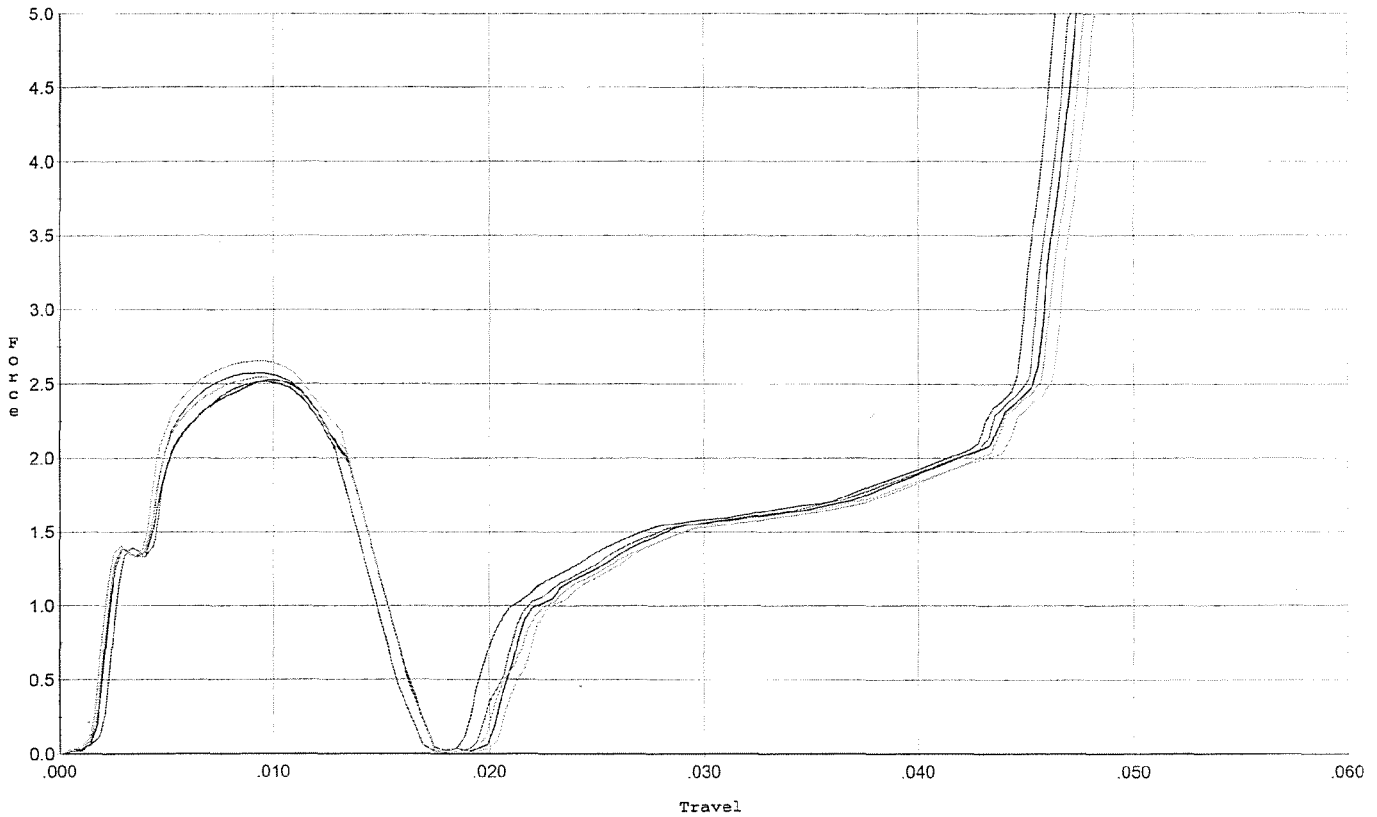
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>30</u>	3-30-09	R.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>60</u>	3-30-09	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-30-09	R.N.
	J) ASSEMBLE STOCK		3-26-09	R.N.
	K) ASSEMBLE SWIVEL STUDS		3-30-09	R.N.
	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	3-27-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	W.W.
670	FINAL INSPECTION A) HEADSPACE		3-30-09	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.41</u> <u>2.42</u> <u>2.41</u> <u>2.37</u> <u>2.37</u>	3-28-09	TL
	C) FUNCTION		3-30-09	R.N.
690	PACK		4/13/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



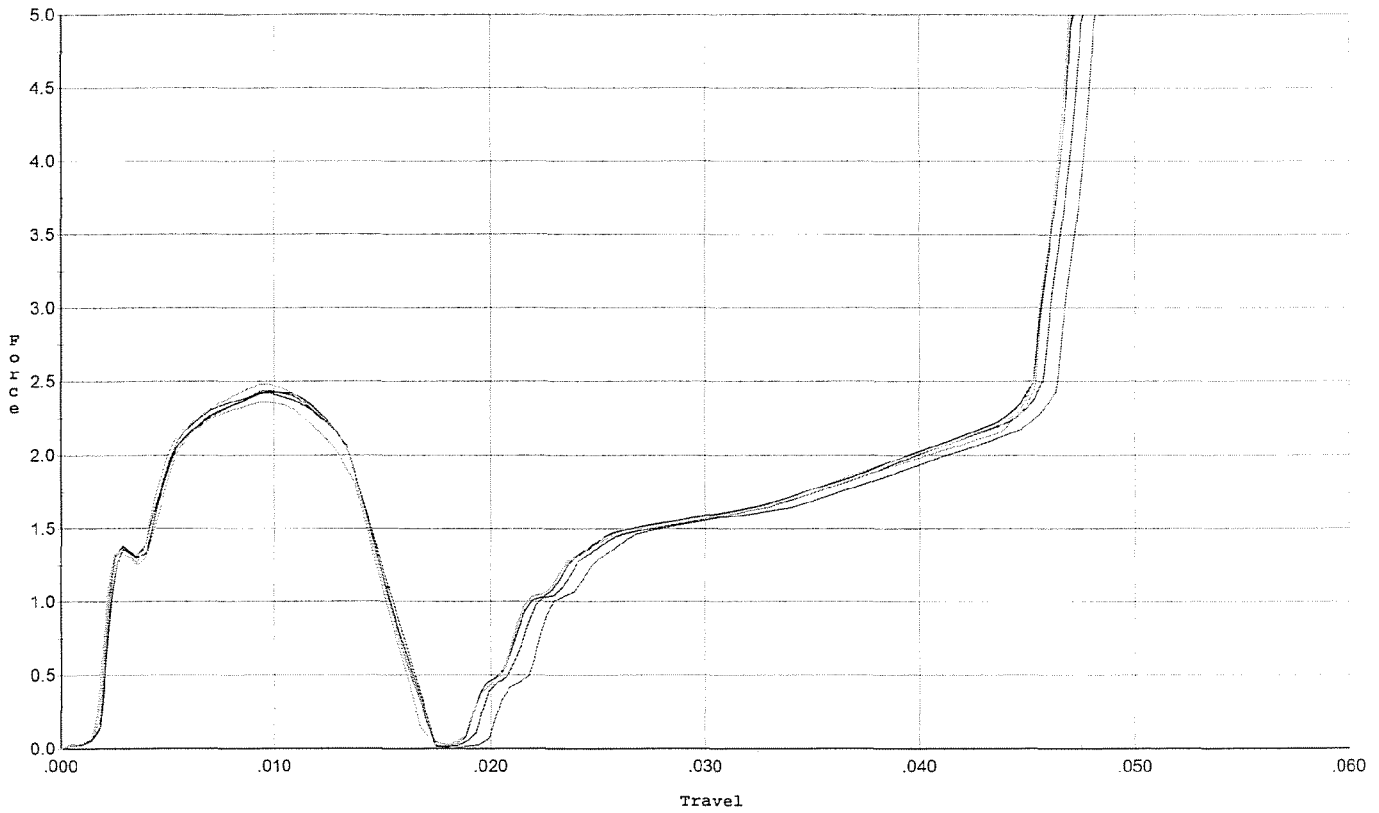
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.514	0.013	0.00	0.037	0.021		Set Trigger
2	2.526	0.013	0.004	0.038	0.023		Set Trigger
3	2.571	0.014	0.00	0.038	0.023		Set Trigger
4	2.544	0.013	0.00	0.039	0.023		Set Trigger
5	2.655	0.013	0.00	0.038	0.024		Set Trigger

A-2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



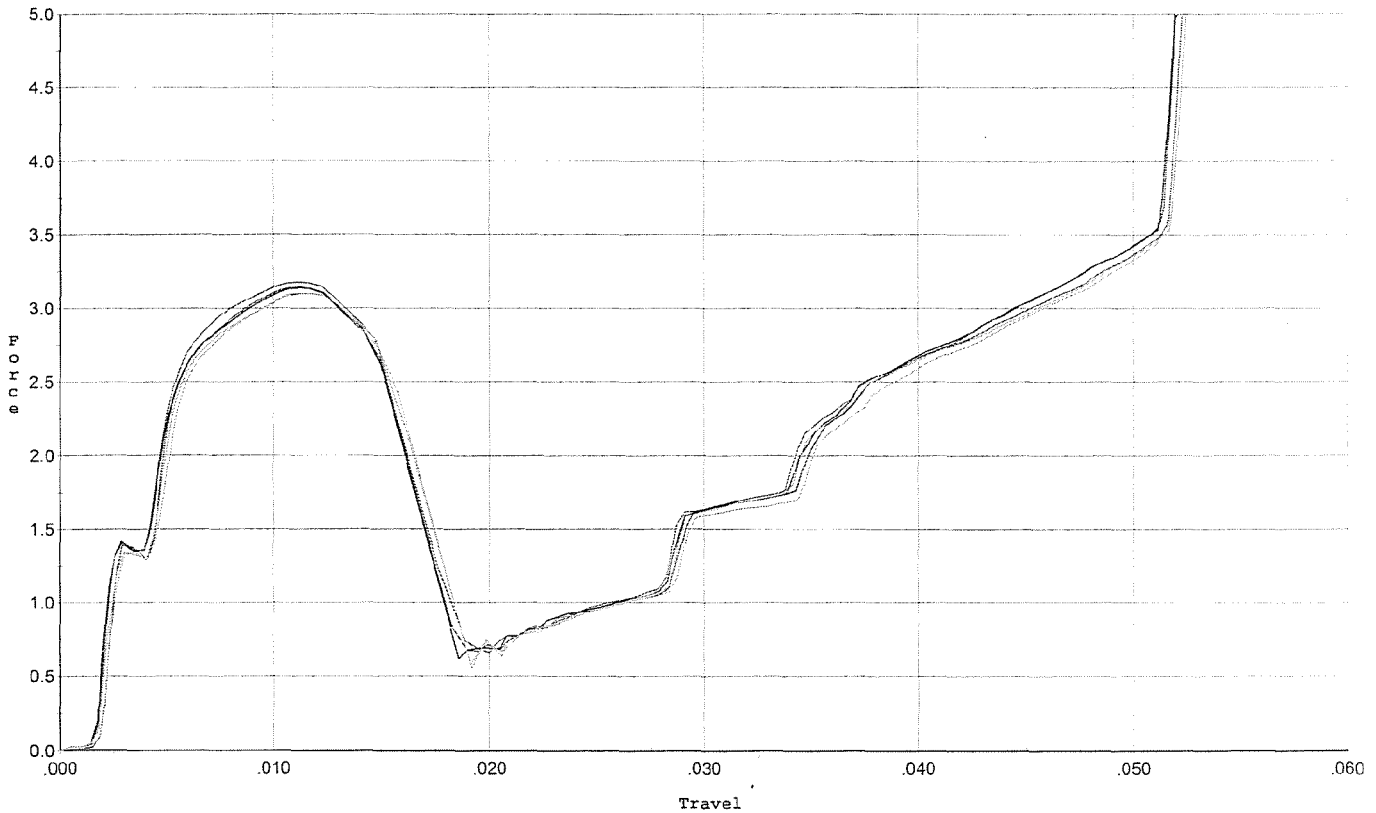
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.013	0.00	0.038	0.022		Set Trigger
2	2.428	0.013	0.00	0.038	0.022		Set Trigger
3	2.438	0.015	0.00	0.038	0.025		Set Trigger
4	2.484	0.013	0.00	0.037	0.023		Set Trigger
5	2.361	0.014	0.00	0.038	0.022		Set Trigger

A-2.42

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



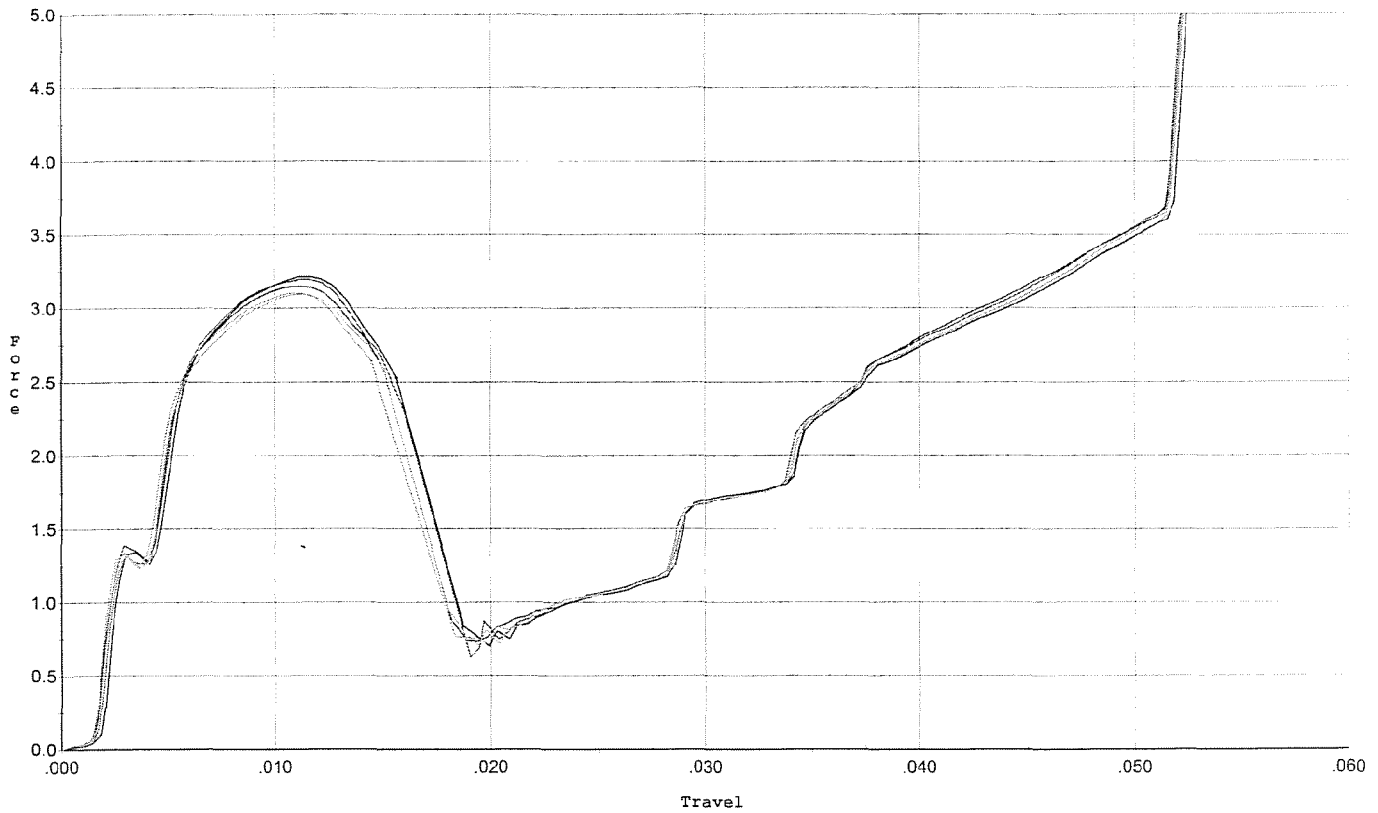
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.146	0.015	0.004	0.039	0.031		Set Trigger
2	3.139	0.015	0.004	0.039	0.031		Set Trigger
3	3.176	0.015	0.00	0.039	0.031		Set Trigger
4	3.099	0.016	0.00	0.039	0.032		Set Trigger
5	3.101	0.016	0.004	0.039	0.033		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



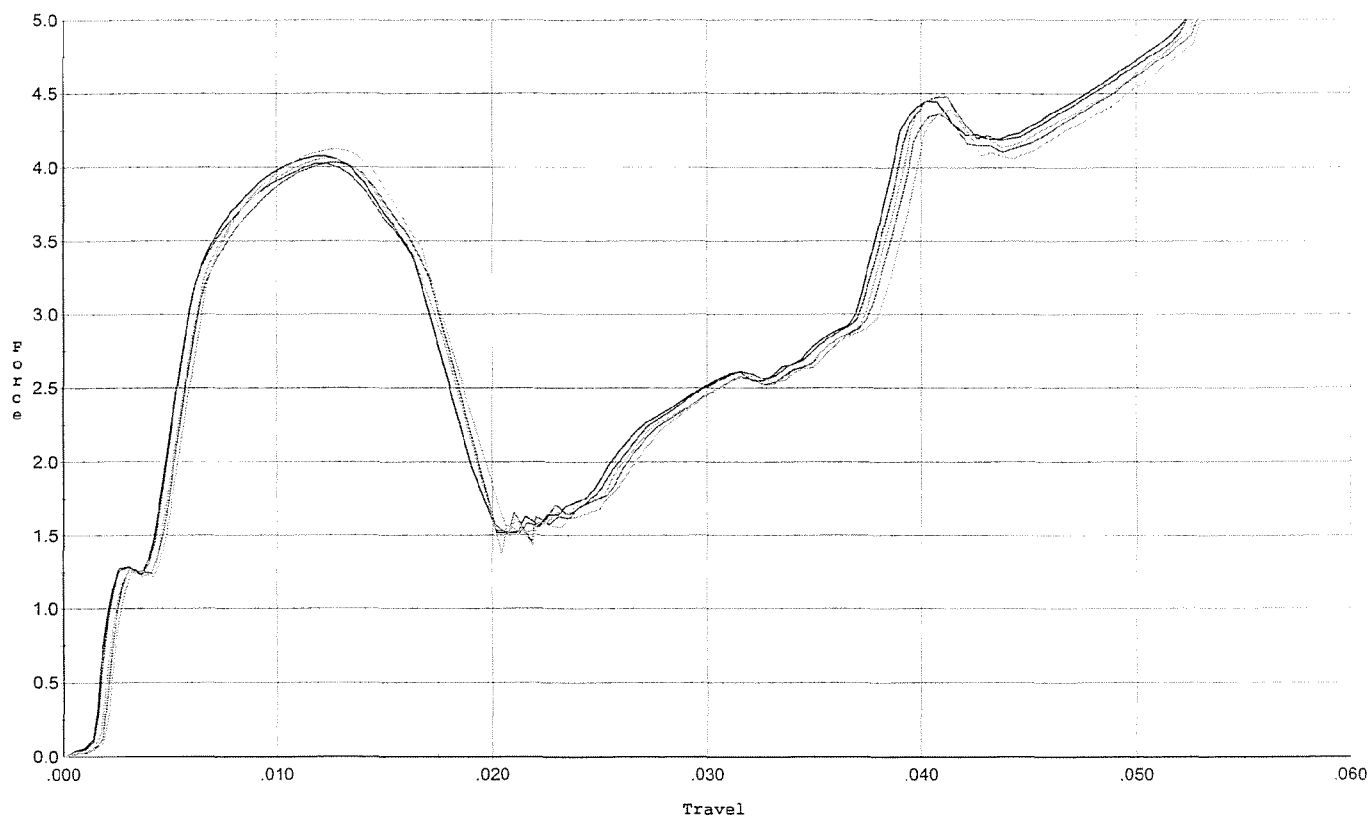
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.147	0.015	0.004	0.039	0.031		Set Trigger
2	3.214	0.016	0.00	0.038	0.032		Set Trigger
3	3.192	0.016	0.004	0.038	0.033		Set Trigger
4	3.095	0.015	0.00	0.039	0.031		Set Trigger
5	3.101	0.014	0.00	0.039	0.030		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

Model: M/24
Serial No: Form #F005
Trigger: 04.0 lbs ini +/- 1.0 lb



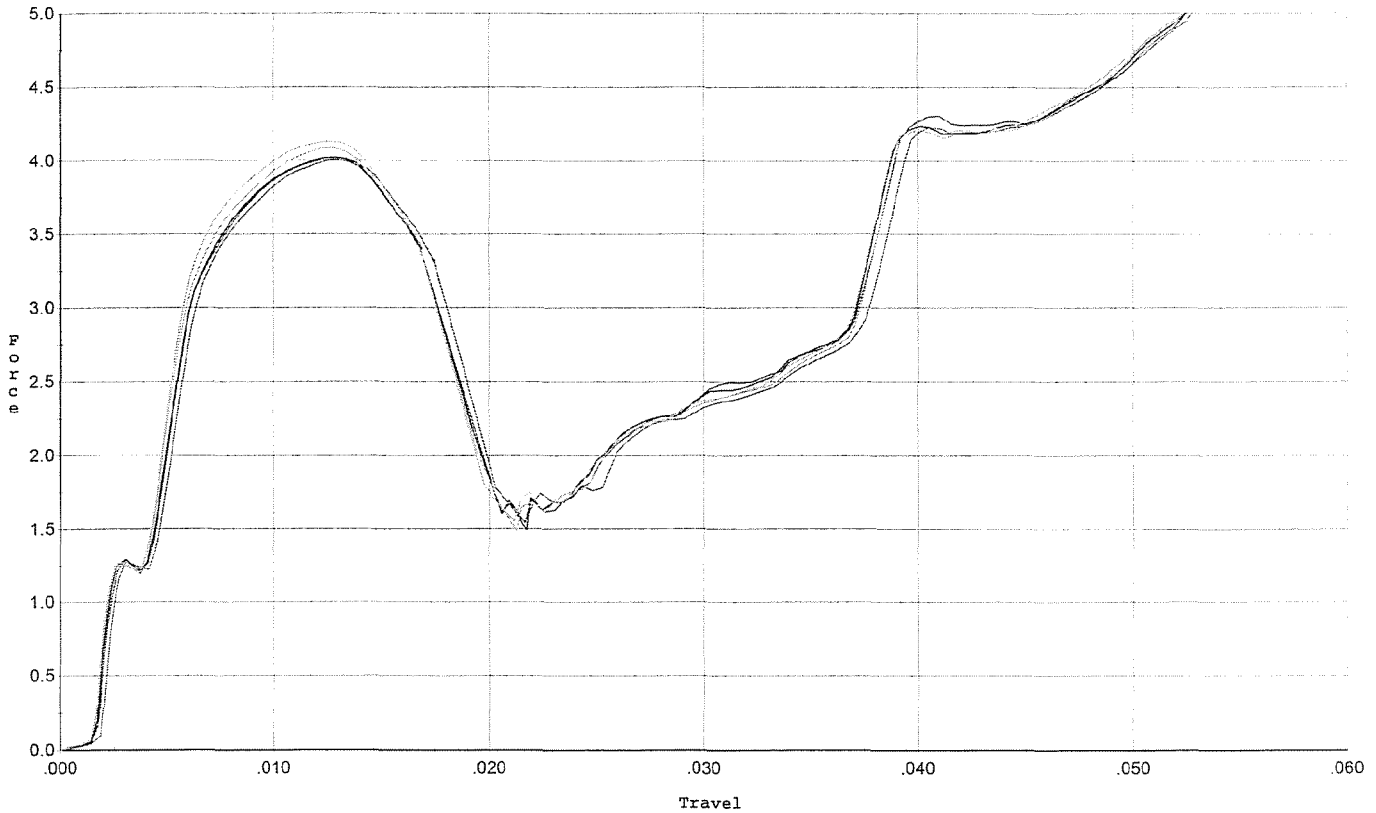
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.027	0.016	0.00	0.036	0.042		Set Trigger
2	4.072	0.016	0.00	0.036	0.043		Set Trigger
3	4.032	0.017	0.004	0.036	0.043		Set Trigger
4	4.125	0.017	0.00	0.037	0.043		Set Trigger
5	4.061	0.018	0.00	0.036	0.045		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

Model: M/24
Serial No: Form #F005
Trigger: 04.0 lbs after 20 cycles+/- 1.0 lb



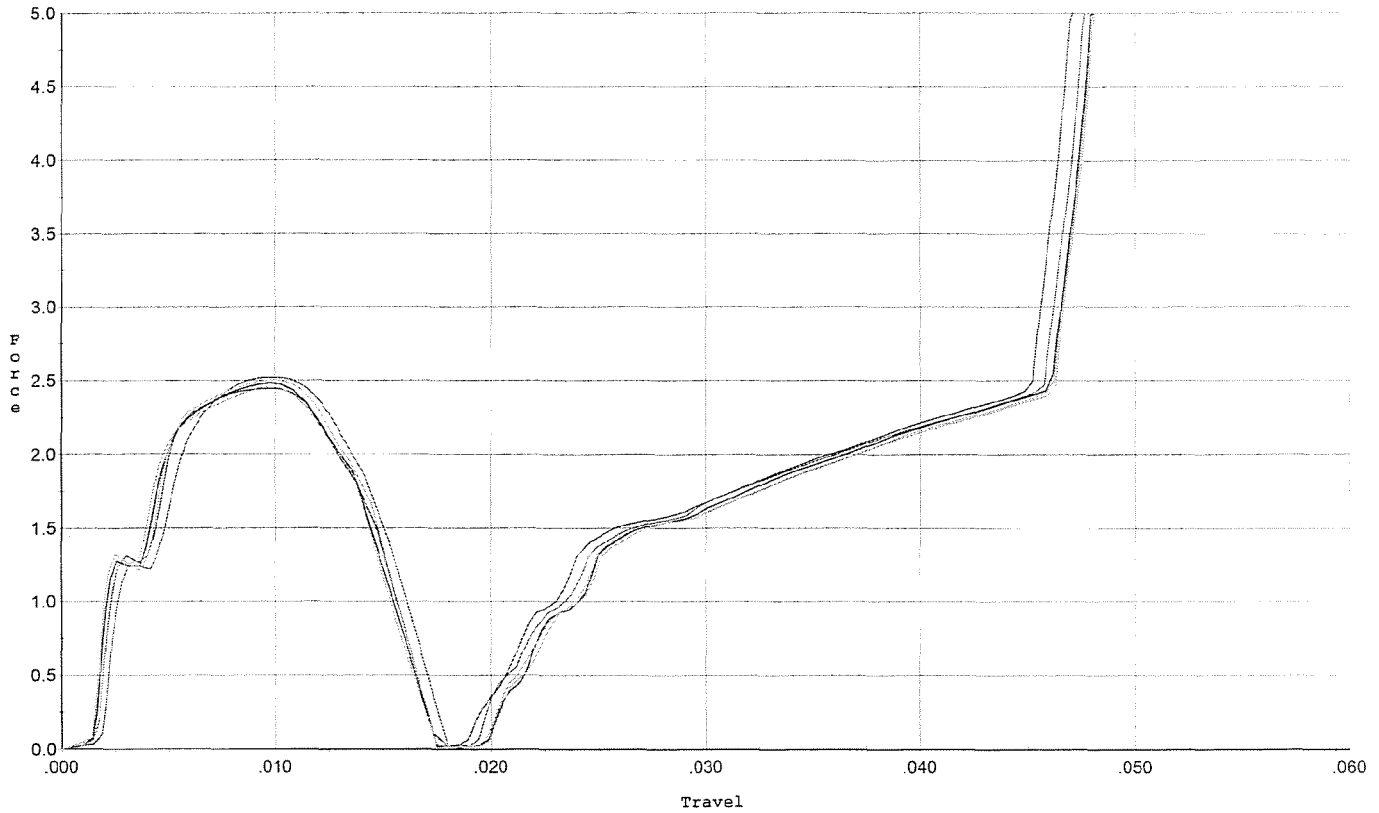
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.008	0.017	0.00	0.036	0.043		Set Trigger
2	4.020	0.017	0.00	0.036	0.044		Set Trigger
3	4.004	0.017	0.004	0.036	0.045		Set Trigger
4	4.085	0.017	0.00	0.036	0.044		Set Trigger
5	4.128	0.017	0.004	0.036	0.045		Set Trigger

A-4.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



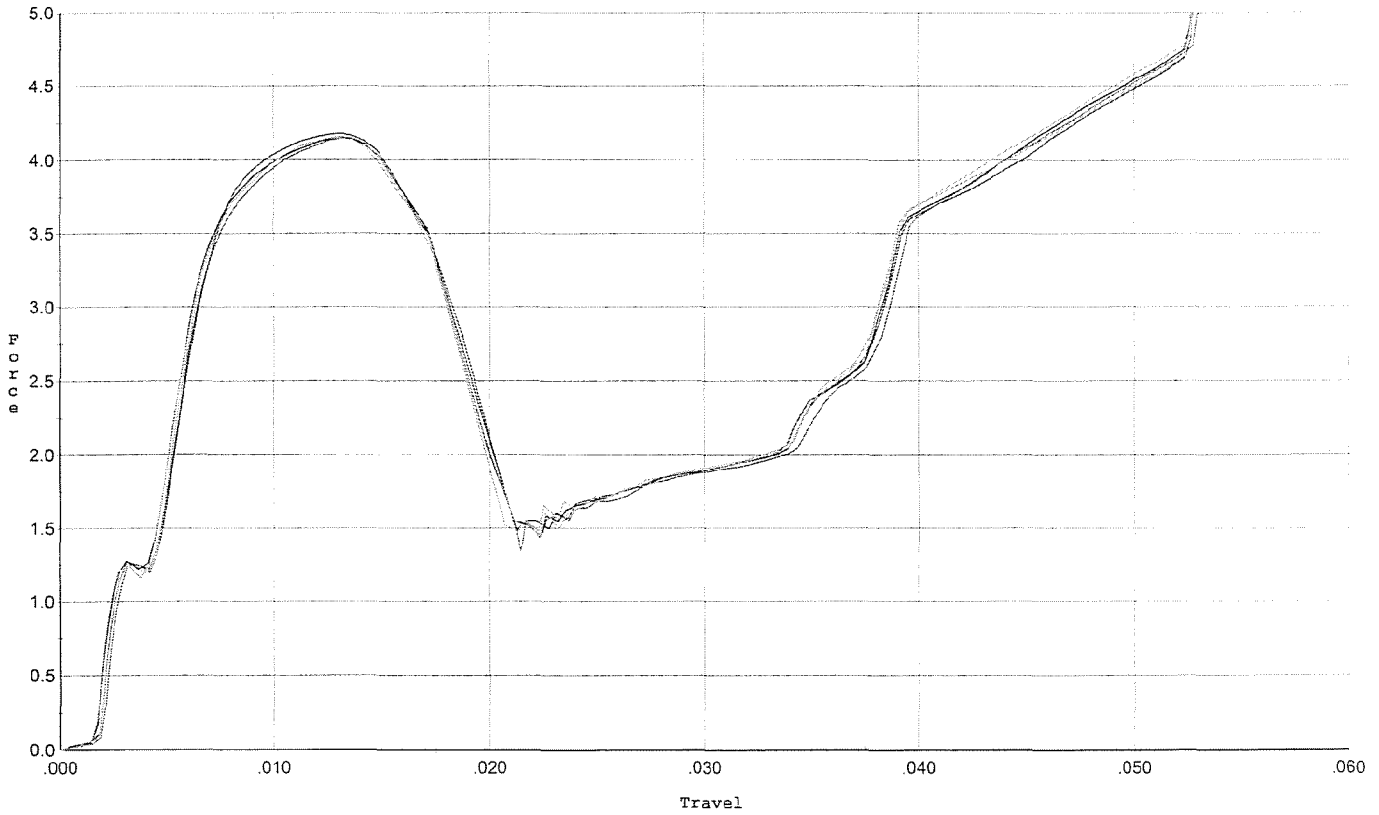
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.446	0.015	0.00	0.037	0.024		Set Trigger
2	2.483	0.015	0.004	0.037	0.026		Set Trigger
3	2.520	0.015	0.004	0.037	0.025		Set Trigger
4	2.504	0.014	0.00	0.038	0.024		Set Trigger
5	2.459	0.014	0.00	0.038	0.023		Set Trigger

A-2-48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.177	0.017	0.004	0.036	0.045		Set Trigger
2	4.148	0.017	0.00	0.036	0.045		Set Trigger
3	4.142	0.019	0.005	0.036	0.049		Set Trigger
4	4.154	0.017	0.004	0.036	0.045		Set Trigger
5	4.147	0.017	0.00	0.036	0.046		Set Trigger

A-4.15