

676814687

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



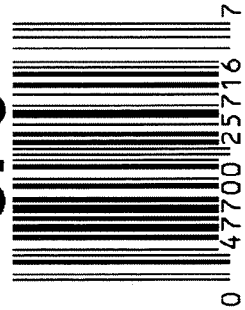
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6814687

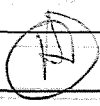
UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6814687

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RZ
430	ASSEMBLE TO STOCK		3-6-09	RZ
440	PROOF		3-6-09	TR
460	CHECK HEADSPACE		3-6-09	TR
470	DIS-ASSEMBLE ACTION		3-6-09	RZ
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-6-09	RZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	JF
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/9/09	
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	non
542	APPLY COATINGS (BARREL ACTION)		3-20	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	JF
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	JF
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	JF
	D) OIL FIRING PIN ASSEMBLY		3-24-09	LD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

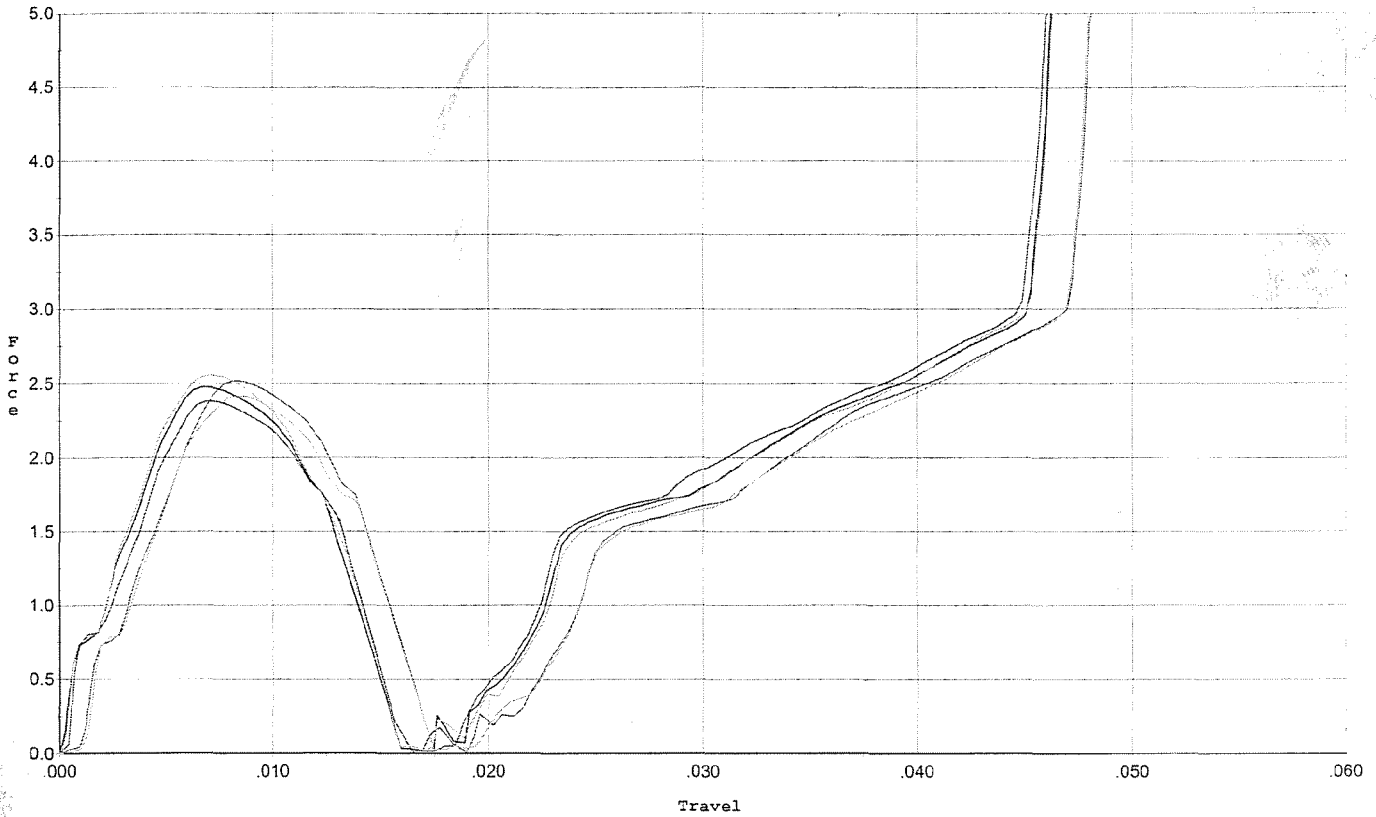
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	3-25-09	RN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	3-25-09	RN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-25-09	RN
	J) ASSEMBLE STOCK		3-24-09	RN
	K) ASSEMBLE SWIVEL STUDS		3-25-09	RN
	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	3-26-09	RN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TC
670	FINAL INSPECTION A) HEADSPACE		3-28-09	RN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u> <u>2.53</u> <u>2.53</u> <u>2.45</u> <u>2.60</u>	3-27-09	TC
	C) FUNCTION		3-28-09	RN
690	PACK		3/30/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C.Schults 3/17/2009

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



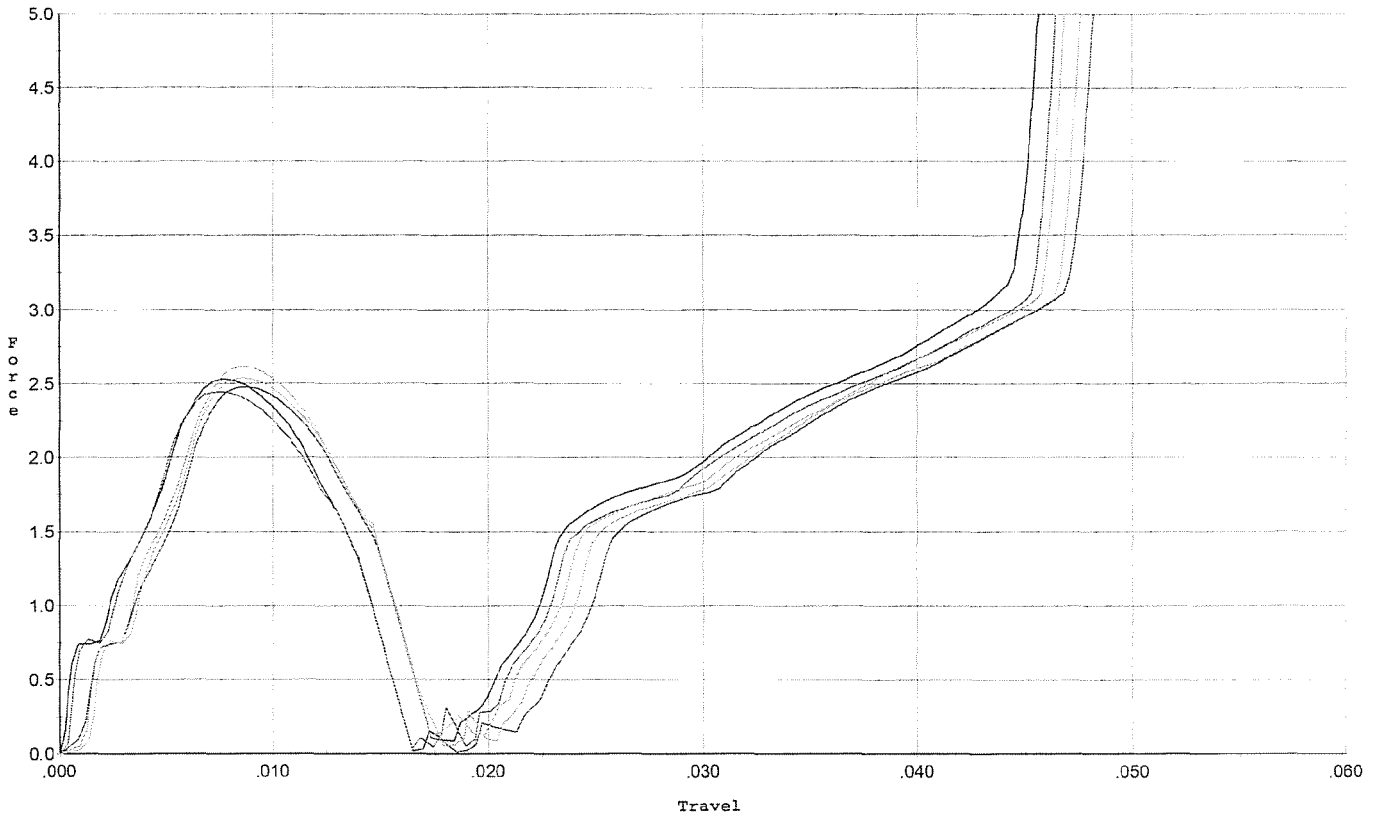
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.385	0.013	0.00	0.036	0.021		Set Trigger
2	2.477	0.014	0.00	0.037	0.023		Set Trigger
3	2.518	0.016	0.00	0.037	0.025		Set Trigger
4	2.418	0.014	0.00	0.038	0.021		Set Trigger
5	2.556	0.013	0.00	0.037	0.023		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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



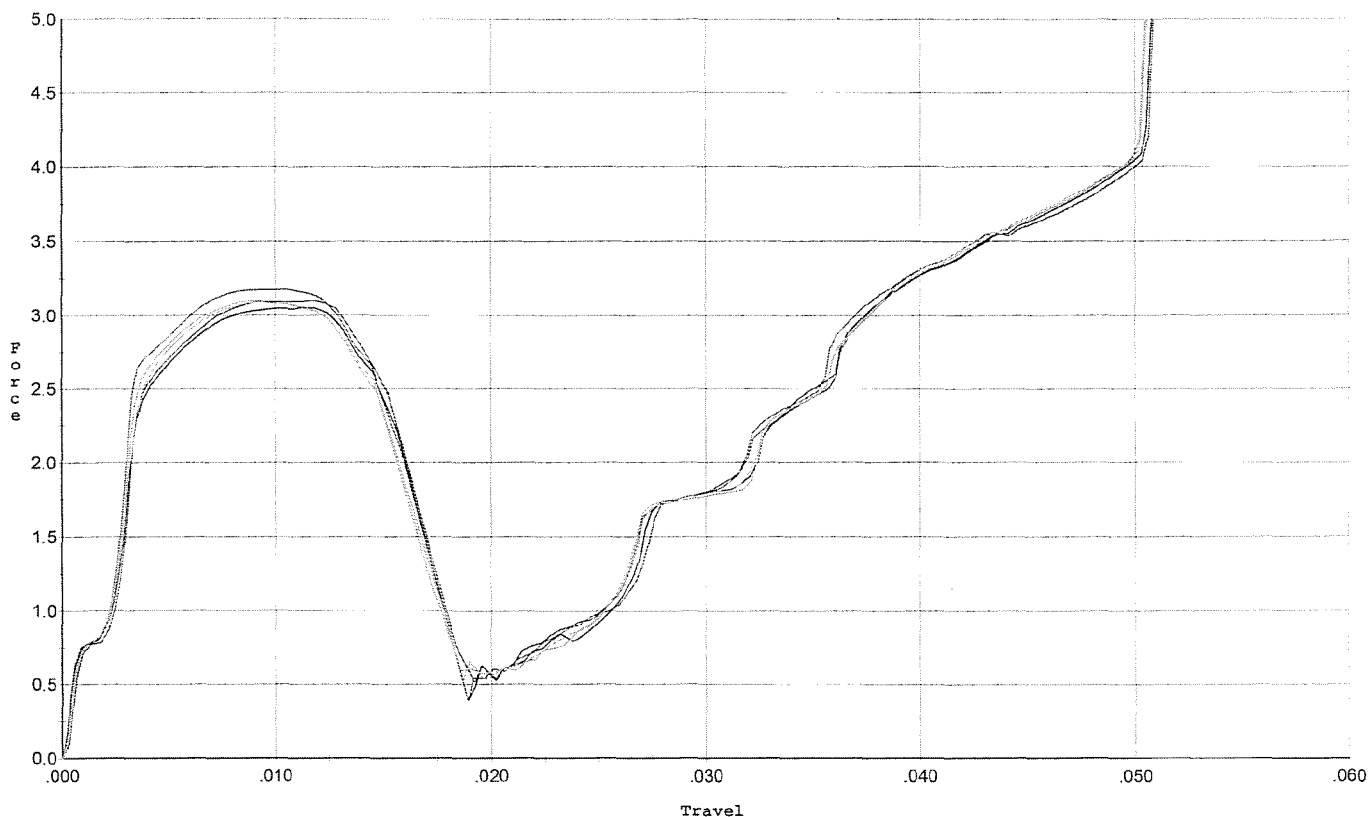
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.477	0.015	0.00	0.037	0.023		Set Trigger
2	2.531	0.014	0.00	0.036	0.023		Set Trigger
3	2.443	0.014	0.00	0.036	0.023		Set Trigger
4	2.537	0.015	0.00	0.037	0.023		Set Trigger
5	2.617	0.015	0.00	0.036	0.024		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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



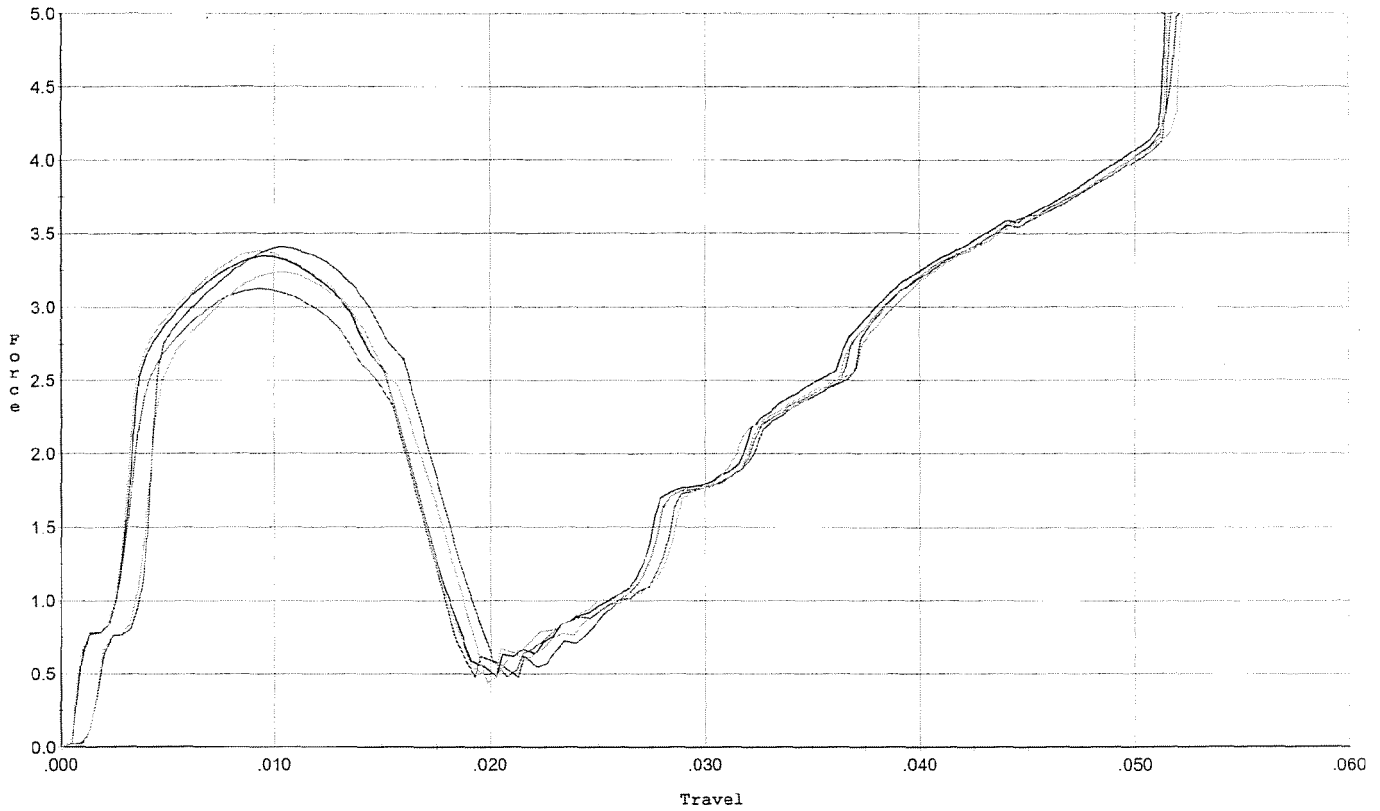
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.015	0.00	0.037	0.034		Set Trigger
2	3.054	0.016	0.00	0.037	0.035		Set Trigger
3	3.176	0.016	0.00	0.037	0.037		Set Trigger
4	3.091	0.017	0.00	0.037	0.037		Set Trigger
5	3.096	0.015	0.00	0.037	0.033		Set Trigger

A-3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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



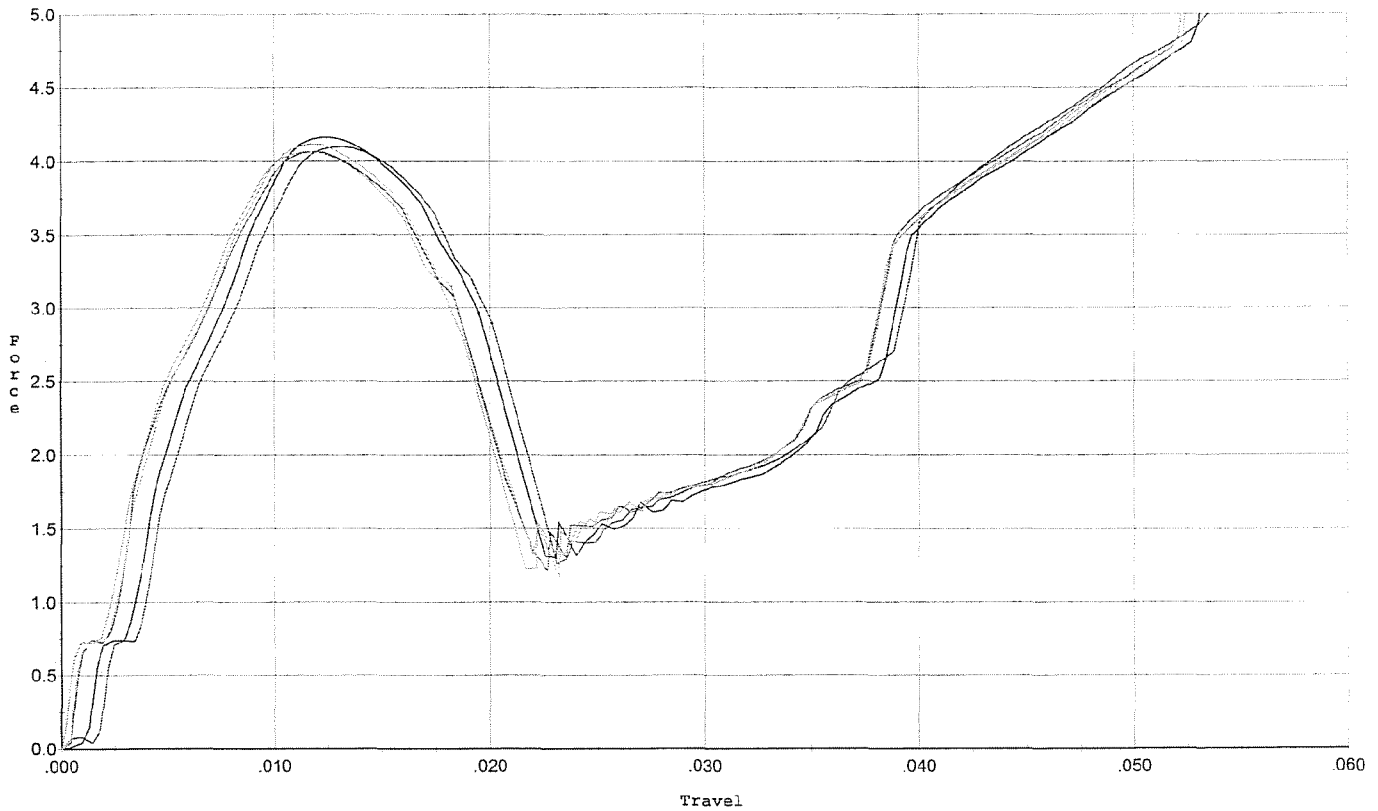
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.409	0.016	0.00	0.038	0.036		Set Trigger
2	3.347	0.015	0.00	0.038	0.035		Set Trigger
3	3.127	0.015	0.00	0.038	0.034		Set Trigger
4	3.385	0.015	0.00	0.038	0.036		Set Trigger
5	3.236	0.017	0.00	0.038	0.037		Set Trigger

A. 3.30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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



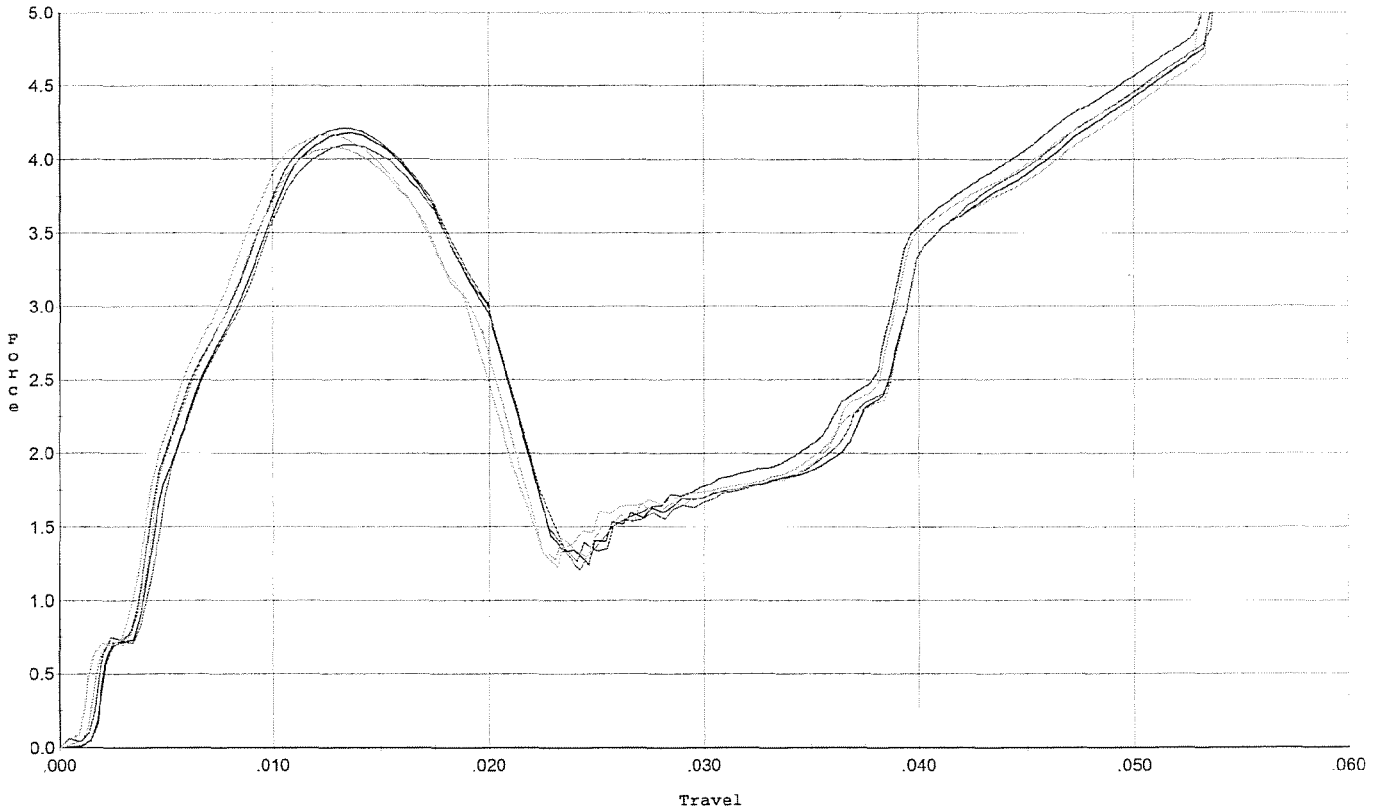
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.020	0.00	0.035	0.051		Set Trigger
2	4.162	0.019	0.00	0.035	0.051		Set Trigger
3	4.065	0.018	0.00	0.035	0.049		Set Trigger
4	4.117	0.018	0.00	0.035	0.049		Set Trigger
5	4.065	0.019	0.00	0.035	0.051		Set Trigger

A-4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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



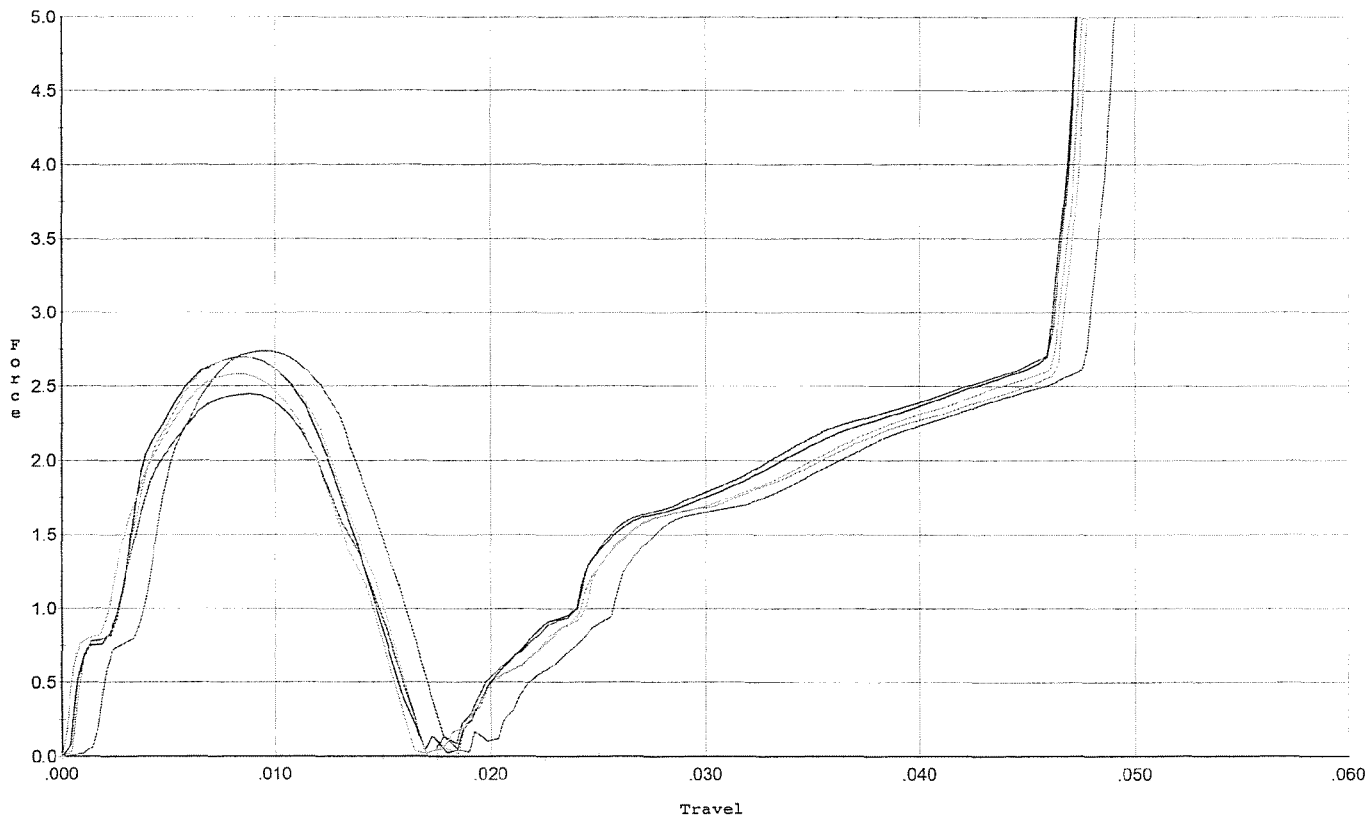
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.210	0.020	0.00	0.035	0.052		Set Trigger
2	4.178	0.020	0.00	0.036	0.051		Set Trigger
3	4.096	0.020	0.00	0.036	0.050		Set Trigger
4	4.165	0.019	0.00	0.036	0.049		Set Trigger
5	4.079	0.020	0.00	0.036	0.050		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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



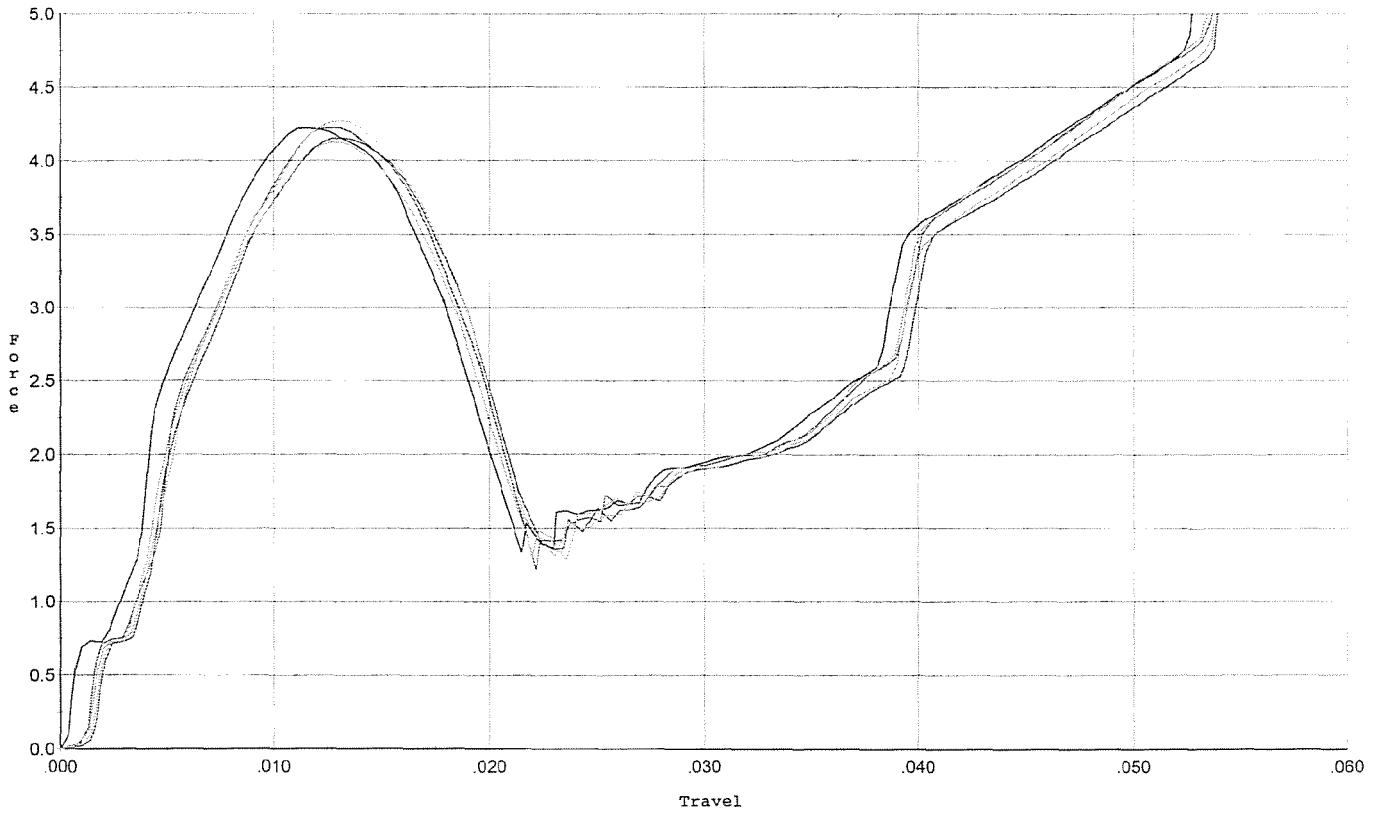
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.449	0.015	0.00	0.037	0.025		Set Trigger
2	2.696	0.014	0.00	0.038	0.025		Set Trigger
3	2.738	0.016	0.00	0.038	0.027		Set Trigger
4	2.693	0.015	0.00	0.037	0.026		Set Trigger
5	2.580	0.014	0.00	0.038	0.025		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/17/2009

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	4.155	0.019	0.00	0.037	0.048		Set Trigger
2	4.220	0.018	0.00	0.036	0.049		Set Trigger
3	4.226	0.020	0.00	0.036	0.051		Set Trigger
4	4.273	0.019	0.00	0.036	0.049		Set Trigger
5	4.128	0.019	0.00	0.036	0.047		Set Trigger

A. 4.20