

56794642

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



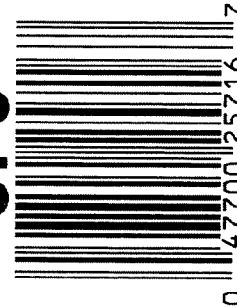
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794642

UPC



GUN SERIAL #

G 679 4642

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD
460	CHECK HEADSPACE		9-30-08	SPD
470	DIS-ASSEMBLE ACTION		9-30-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-1-08	RSN
475	DRILL AND TAP SIGHT HOLES	NOV 10 2008	10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (B)	10/2/08	(B)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (BARREL ACTION)		10-8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-7-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-28-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

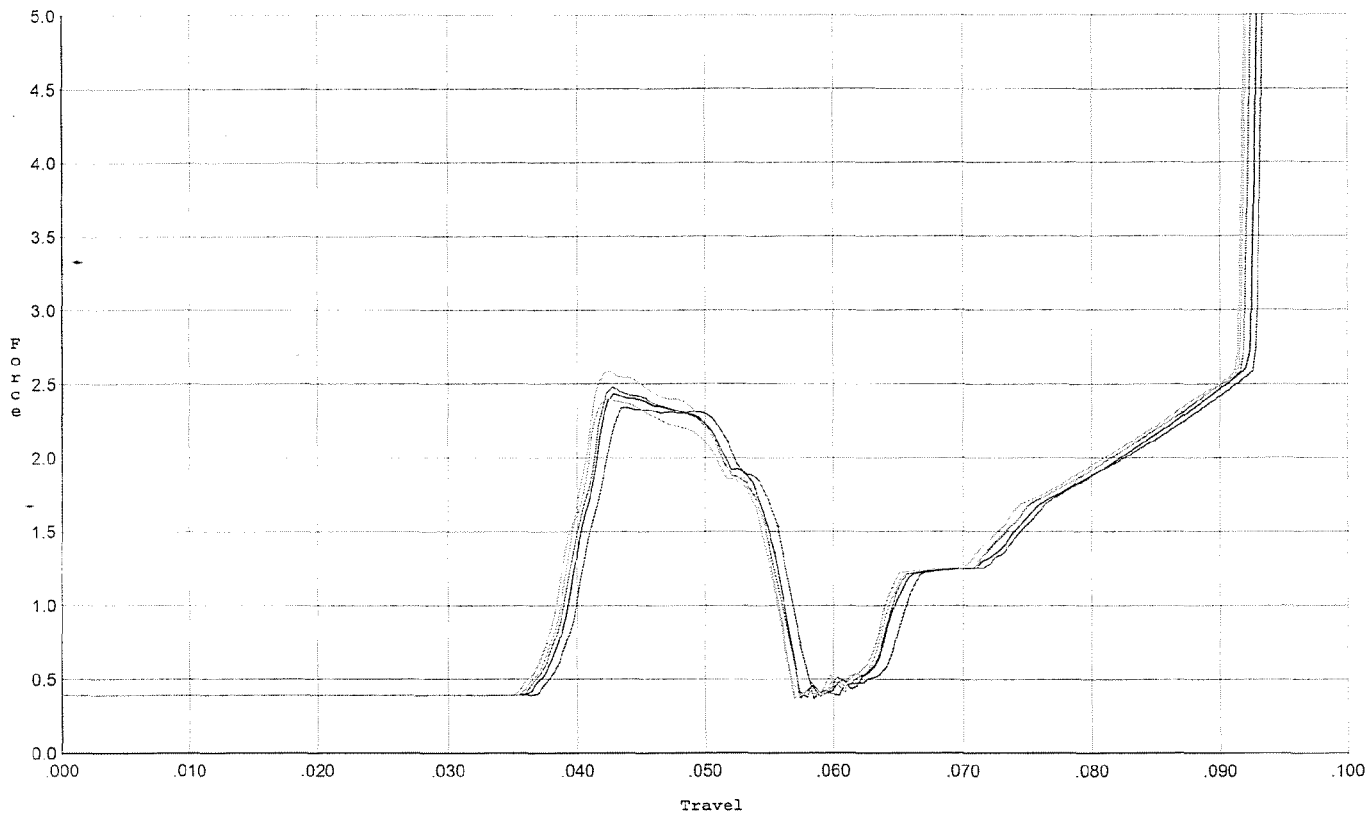
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.0</u> <u>3.0</u> <u>3.0</u>	10-30-08	L. D
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>3.5</u>	10-30-08	L. D
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-30-08	L. D
	J) ASSEMBLE STOCK		10-28-08	ESV
	K) ASSEMBLE SWIVEL STUDS		10-30-08	L. D
	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	10-29-08	L. D
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-29-08	TAE
670	FINAL INSPECTION A) HEADSPACE		10-30-08	L. D
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.43</u> <u>2.43</u> <u>2.43</u> <u>2.47</u>	10-30-08	L. D
	C) FUNCTION		10-30-08	L. D
690	PACK		10/31/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



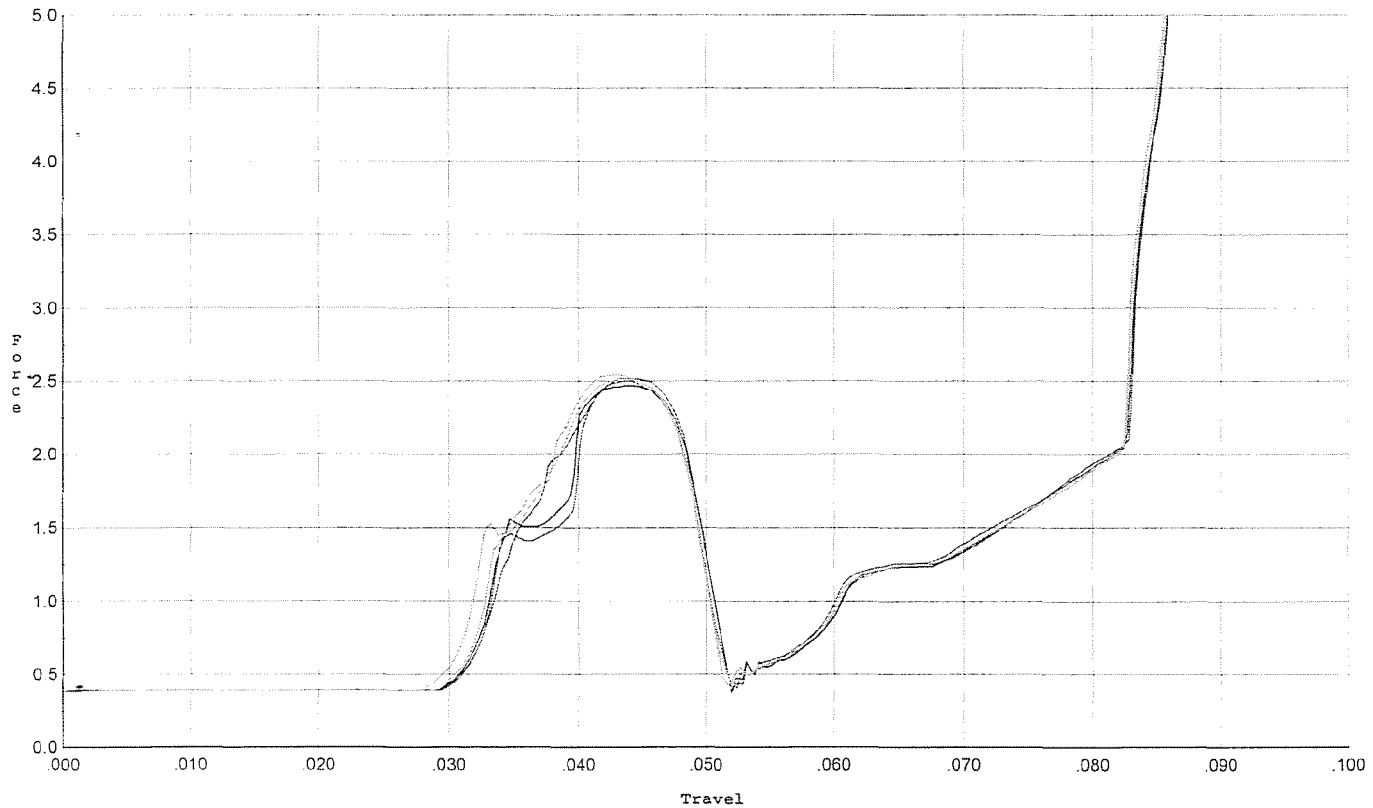
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.339	0.056	0.037	0.042	0.049		Set Trigger
2	2.435	0.055	0.038	0.042	0.049		Set Trigger
3	2.478	0.055	0.036	0.042	0.049		Set Trigger
4	2.588	0.055	0.037	0.041	0.050		Set Trigger
5	2.399	0.055	0.036	0.041	0.049		Set Trigger

Avg 2.43 RP
 2.44

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



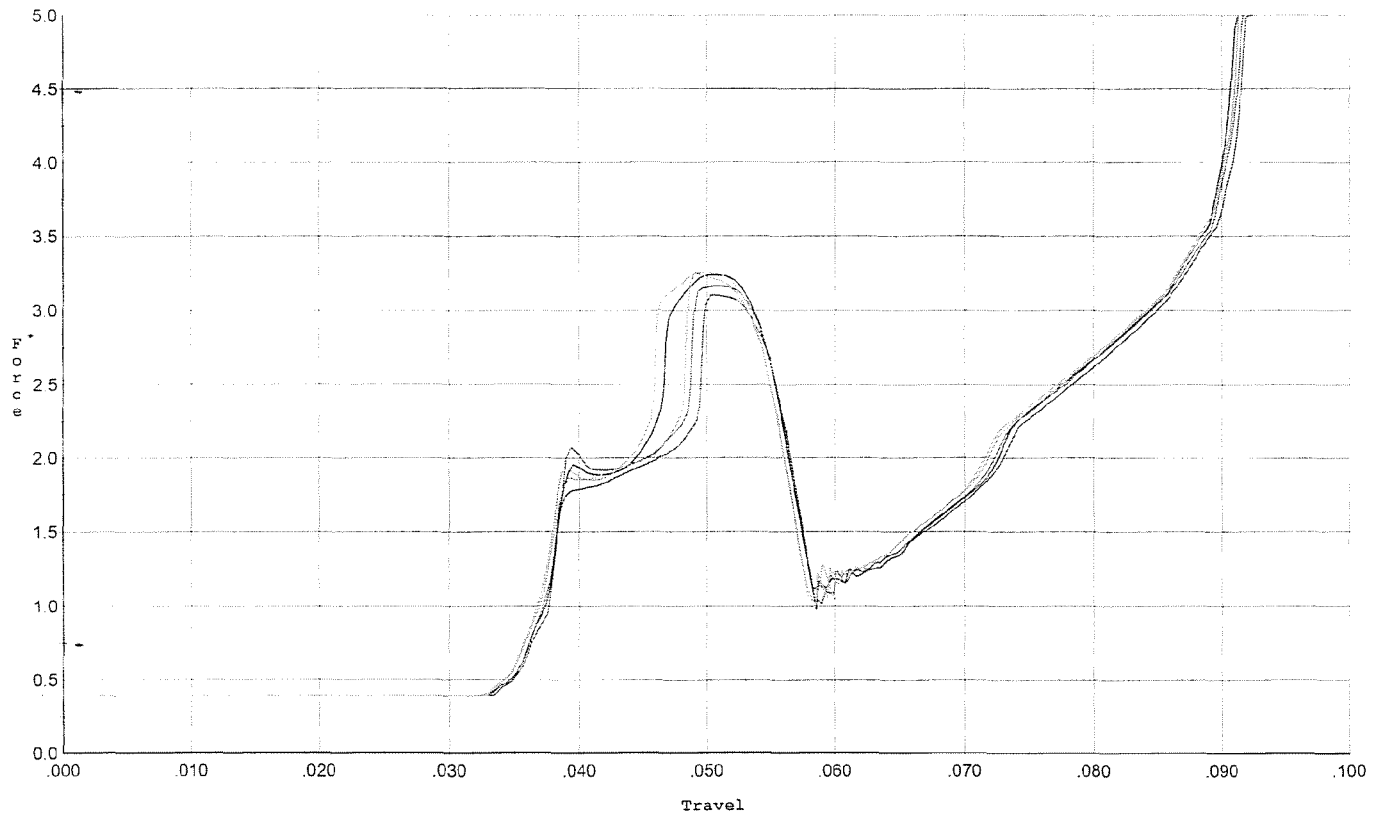
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.050	0.032	0.041	0.048		Set Trigger
2	2.468	0.050	0.032	0.040	0.047		Set Trigger
3	2.501	0.049	0.032	0.041	0.044		Set Trigger
4	2.515	0.049	0.032	0.041	0.047		Set Trigger
5	2.545	0.049	0.031	0.040	0.048		Set Trigger

Aug 2.50

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



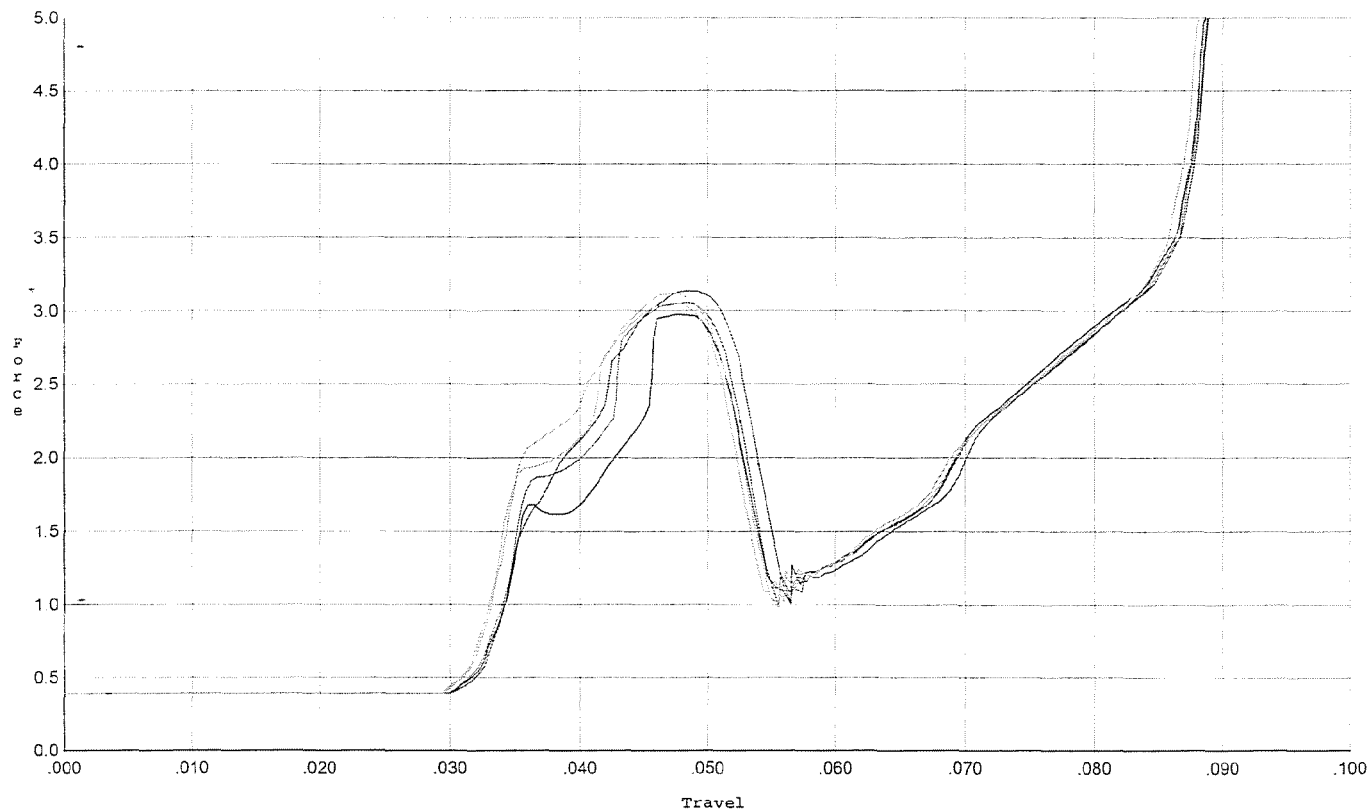
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.104	0.056	0.036	0.040	0.058		Set Trigger
2	3.241	0.055	0.036	0.039	0.060		Set Trigger
3	3.165	0.056	0.036	0.039	0.061		Set Trigger
4	3.255	0.056	0.035	0.039	0.062		Set Trigger
5	3.254	0.056	0.035	0.039	0.059		Set Trigger

Aug 3.20

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



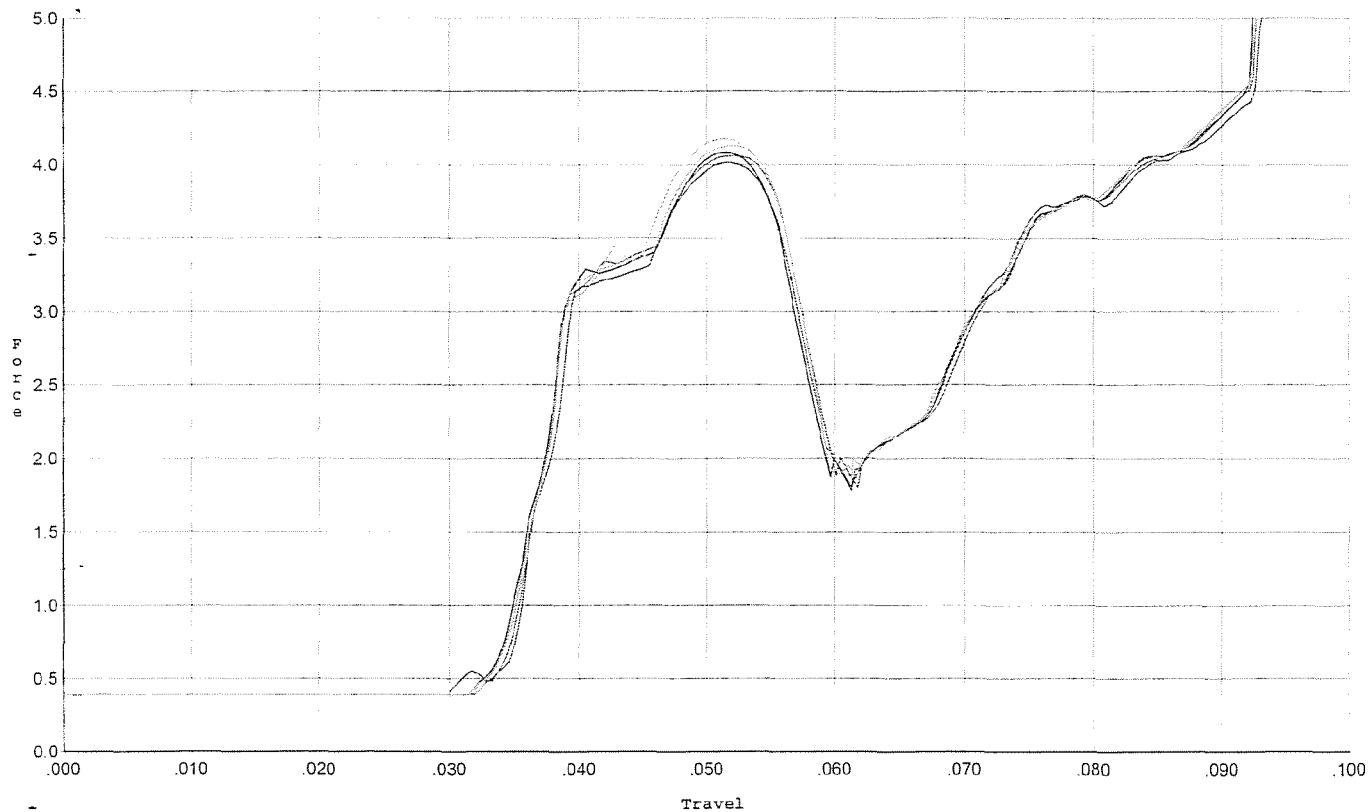
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.054	0.033	0.039	0.063		Set Trigger
2	2.975	0.052	0.033	0.040	0.054		Set Trigger
3	3.057	0.053	0.033	0.040	0.059		Set Trigger
4	3.053	0.051	0.032	0.040	0.059		Set Trigger
5	3.123	0.052	0.032	0.040	0.062		Set Trigger

Aug 3.06

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



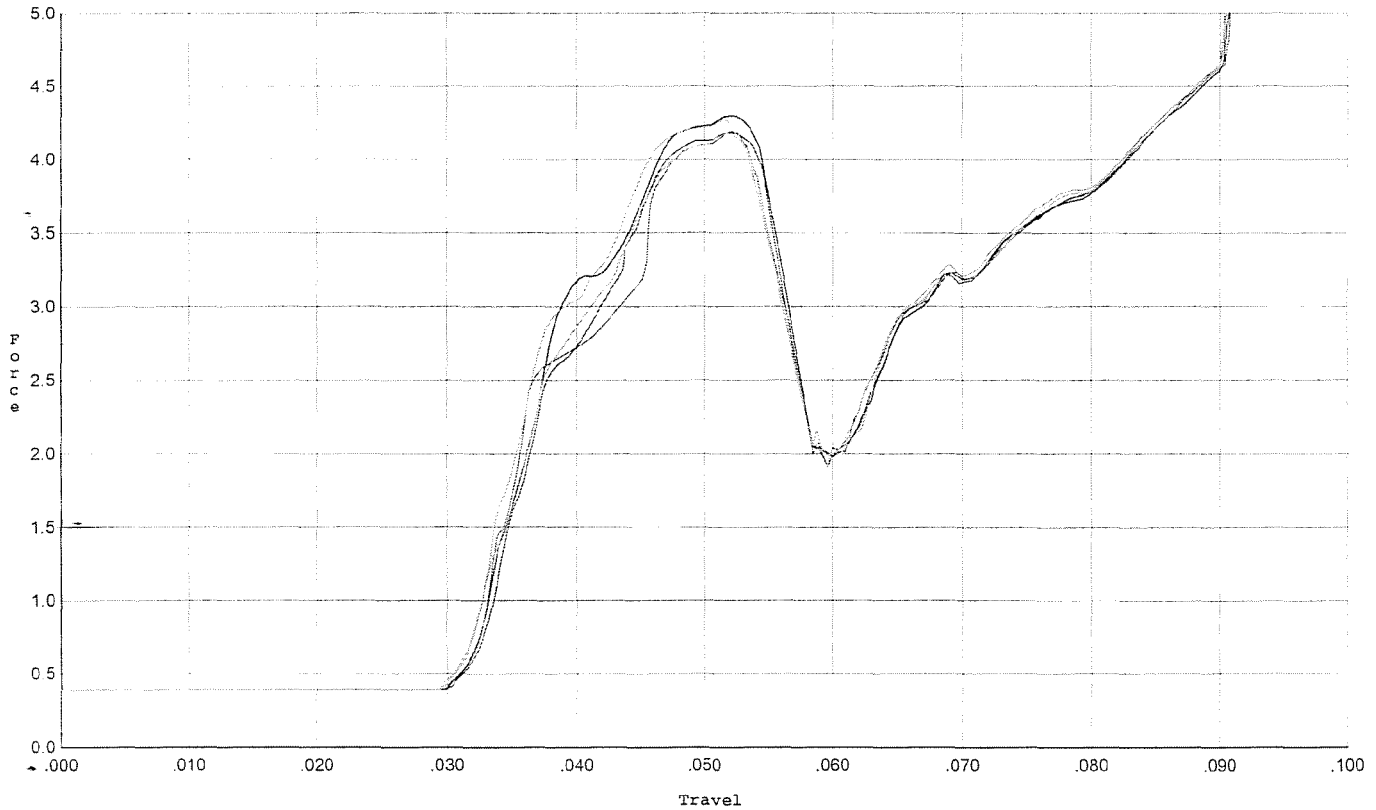
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.015	0.057	0.034	0.038	0.085		Set Trigger
2	4.082	0.056	0.034	0.038	0.085		Set Trigger
3	4.057	0.057	0.034	0.037	0.089		Set Trigger
4	4.176	0.057	0.032	0.037	0.090		Set Trigger
5	4.124	0.057	0.034	0.037	0.090		Set Trigger

Aug 4.09

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



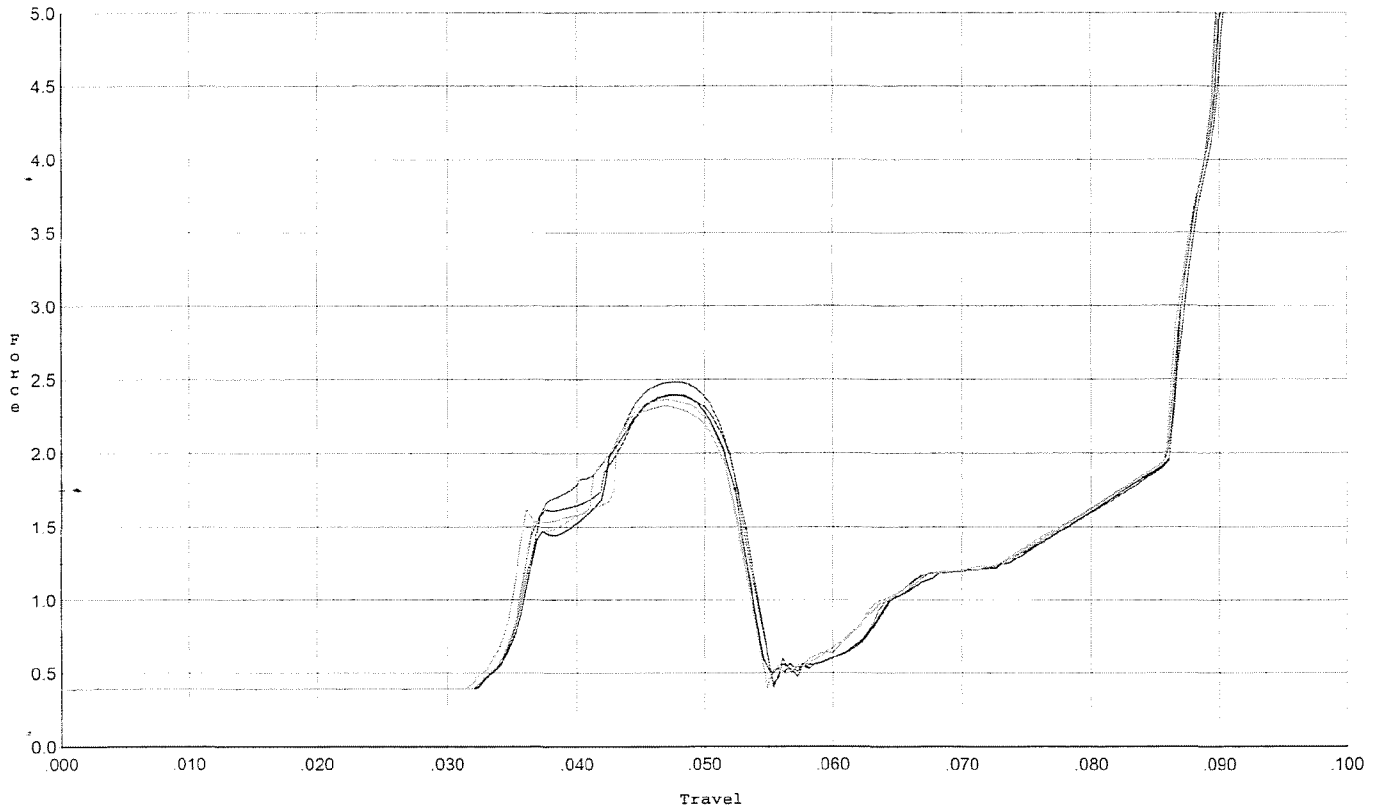
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.181	0.055	0.031	0.037	0.085		Set Trigger
2	4.297	0.056	0.032	0.036	0.091		Set Trigger
3	4.192	0.057	0.032	0.036	0.088		Set Trigger
4	4.270	0.056	0.031	0.036	0.091		Set Trigger
5	4.175	0.054	0.031	0.037	0.084		Set Trigger

Aug 422

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/23/08

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



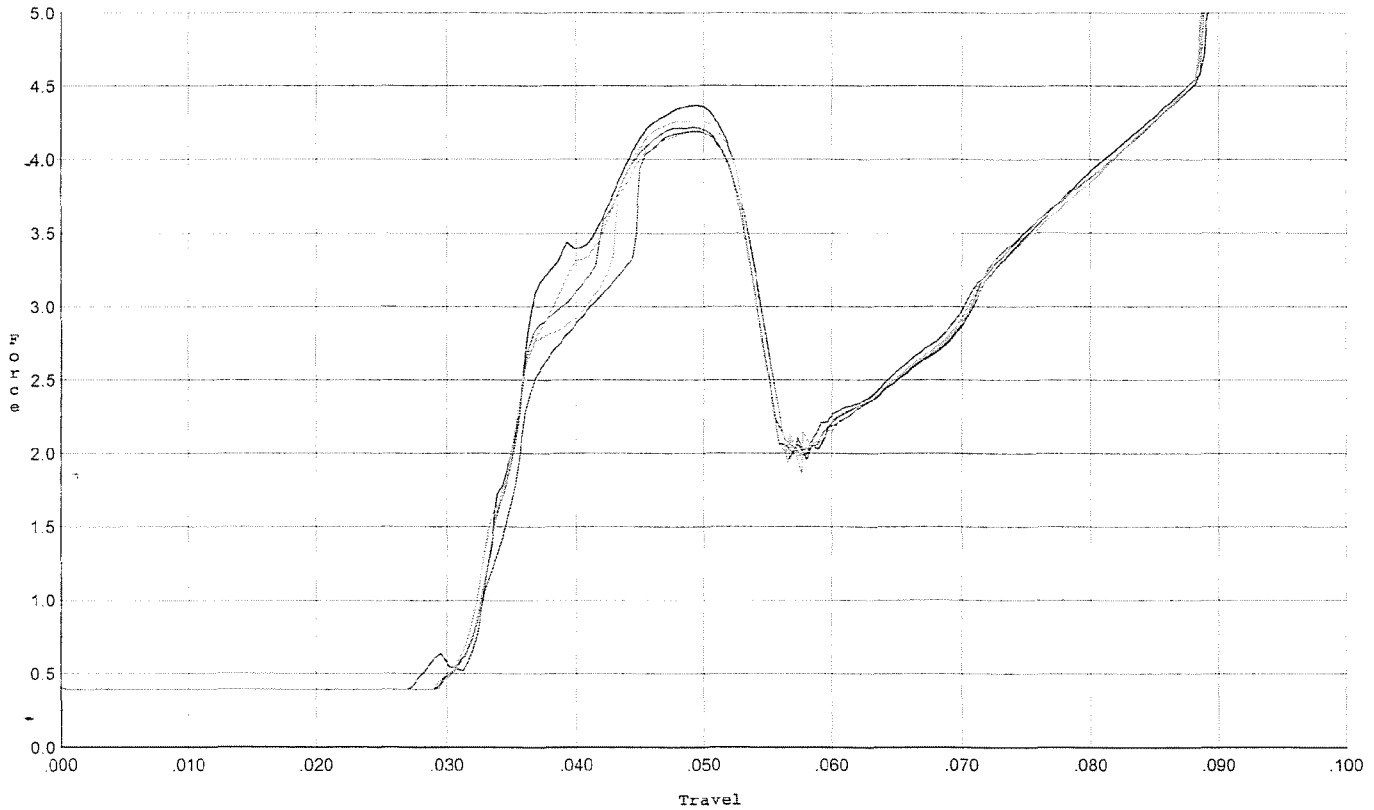
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.400	0.053	0.033	0.042	0.049		Set Trigger
2	2.395	0.052	0.035	0.042	0.047		Set Trigger
3	2.485	0.052	0.034	0.042	0.049		Set Trigger
4	2.364	0.053	0.034	0.042	0.048		Set Trigger
5	2.324	0.053	0.032	0.042	0.049		Set Trigger

Aug 2.39

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/23/08

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.192	0.053	0.028	0.037	0.081		Set Trigger
2	4.369	0.054	0.030	0.036	0.090		Set Trigger
3	4.218	0.053	0.030	0.036	0.084		Set Trigger
4	4.187	0.053	0.031	0.036	0.083		Set Trigger
5	4.261	0.054	0.030	0.036	0.088		Set Trigger

Aug 4.24