

56774414

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



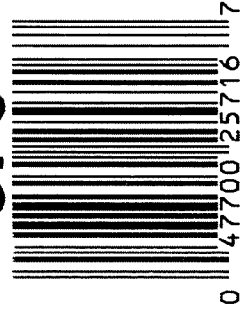
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6774414

UPC



GUN SERIAL #

G6774414

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		7-30-08	SP
430	ASSEMBLE TO STOCK		7-30-08	SP
440	PROOF		7-30-08	SP
460	CHECK HEADSPACE	MAGNA - FLUX	7-30-08	SP
470	DIS-ASSEMBLE ACTION	AUG 05 2008	7-30-08	SP
472	SERIALIZE BOLT HANDLE		7-31-08	KJL
475	DRILL AND TAP SIGHT HOLES	OPERATOR DM	7-31-08	SP
480	MAGNAFLUX BBL ACTION		8/5	DM
490	MAGNAFLUX BOLT		7/31	MR
500	ROLLMARK CALIBER		8/6/08	RT
520	GOFF BLAST BBL / REC		8/5/08	DG
542	APPLY COATINGS (BARREL ACTION)		8/12	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-16-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-16-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-16-08	SP
	D) OIL FIRING PIN ASSEMBLY		8-25-08	KJL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

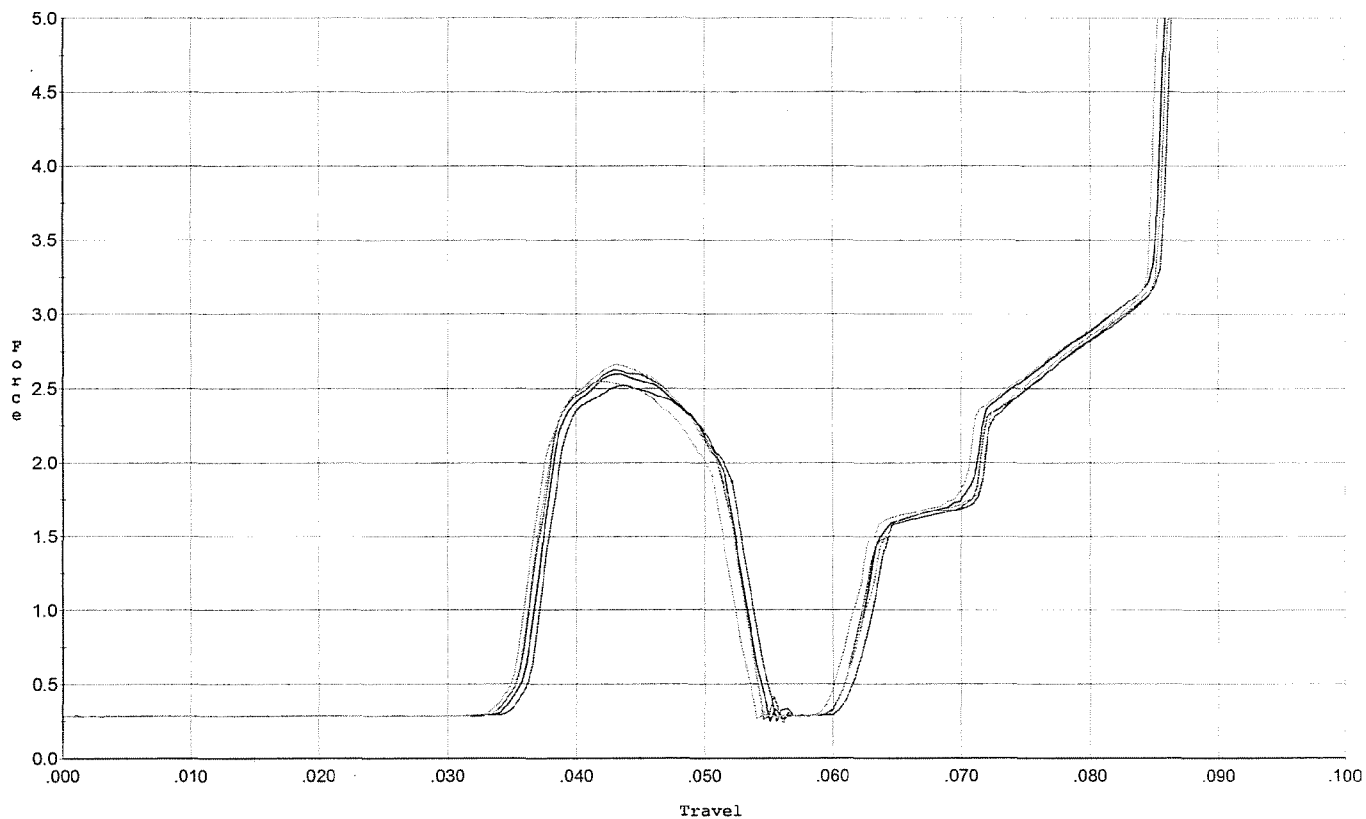
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 00566122 LBS MIN F) SAFETY ON FORCE 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>3.0</u>	9-4-08	Rgn
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	9-4-08	Rgn
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.020</u> <u>.023</u> <u>.023</u>	9-4-08	Rgn
	J) ASSEMBLE STOCK		8-25-08	TR
	K) ASSEMBLE SWIVEL STUDS		9-4-08	Rgn
	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	8-27-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	8-27-08	Fm
660	INSPECT FOR LIVE AMMO		8-27-08	Fm
670	FINAL INSPECTION A) HEADSPACE		9-4-08	Rgn
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.72</u> <u>2.66</u> <u>2.64</u> <u>2.75</u>	9-3-08	B.S.H.
	C) FUNCTION		9-4-08	Rgn
690	PACK		12-3-08	TR

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/18/08

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



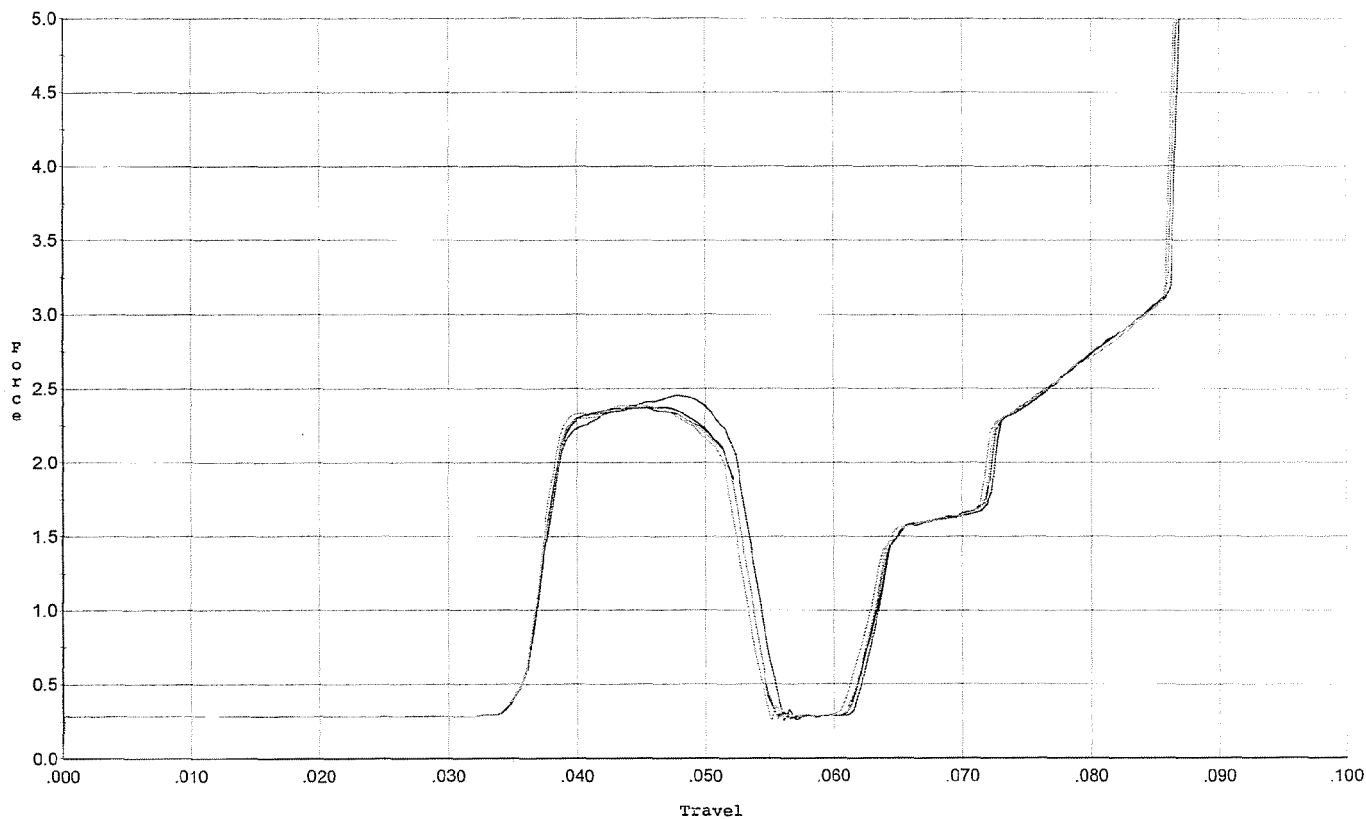
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.520	0.052	0.035	0.039	0.046		Set Trigger
2	2.597	0.052	0.036	0.038	0.046		Set Trigger
3	2.625	0.052	0.035	0.038	0.047		Set Trigger
4	2.663	0.052	0.035	0.038	0.048		Set Trigger
5	2.548	0.051	0.035	0.038	0.045		Set Trigger

Avg 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/18/08

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



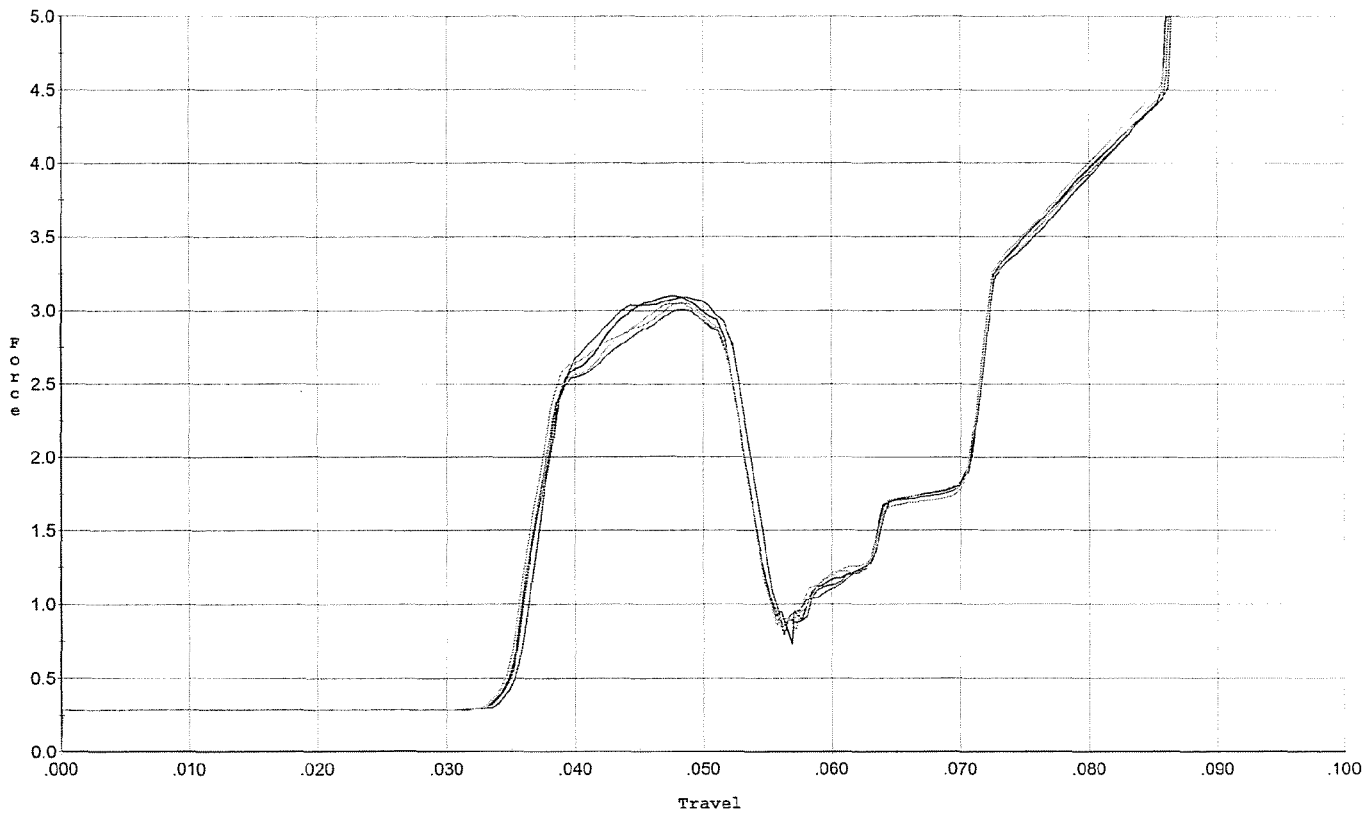
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.455	0.052	0.036	0.039	0.047		Set Trigger
2	2.380	0.052	0.036	0.038	0.046		Set Trigger
3	2.372	0.052	0.036	0.038	0.046		Set Trigger
4	2.382	0.052	0.036	0.038	0.045		Set Trigger
5	2.395	0.051	0.036	0.039	0.045		Set Trigger

Avg 2.39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/18/08

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



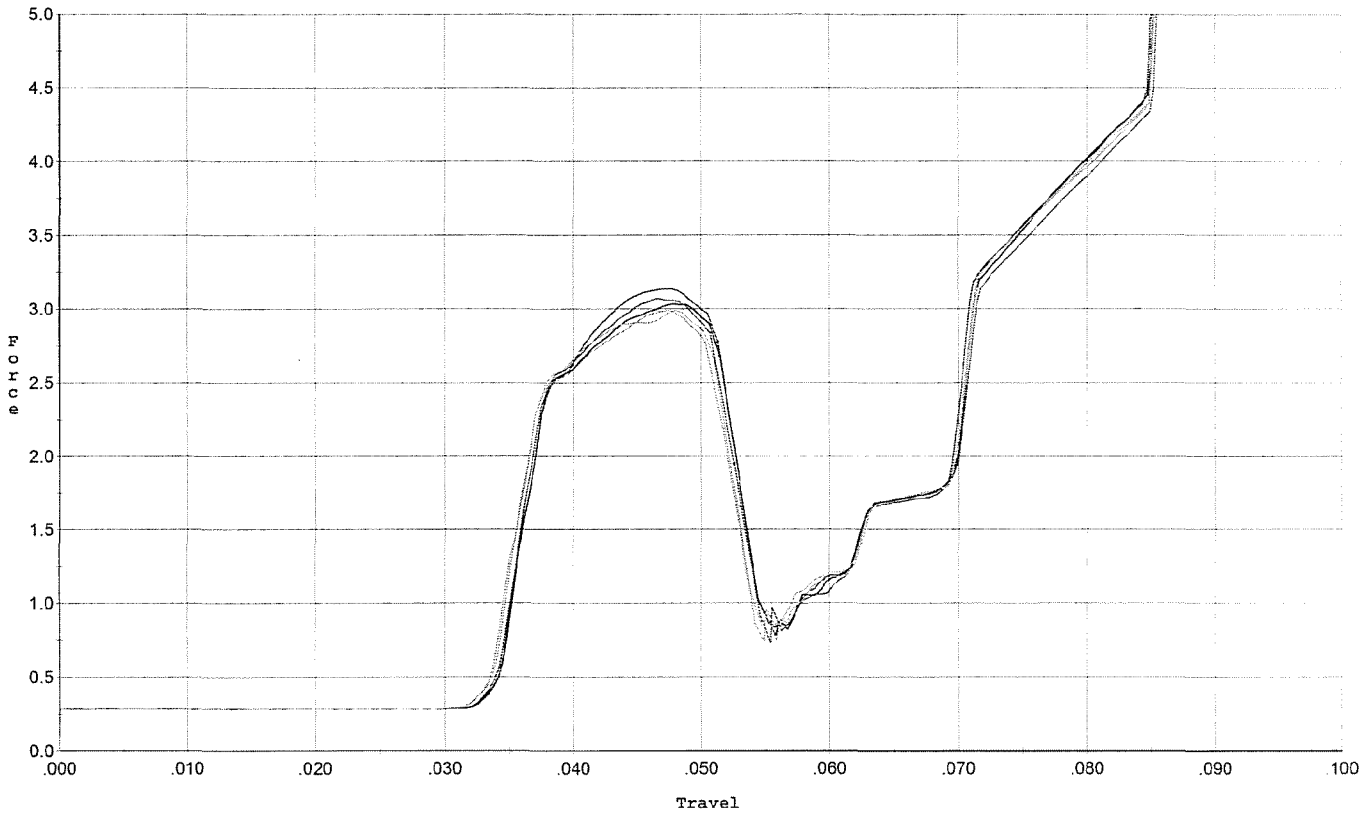
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.088	0.052	0.035	0.037	0.057		Set Trigger
2	3.099	0.052	0.035	0.037	0.056		Set Trigger
3	3.008	0.052	0.035	0.037	0.054		Set Trigger
4	3.052	0.052	0.034	0.037	0.056		Set Trigger
5	3.047	0.052	0.035	0.037	0.055		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/18/08

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



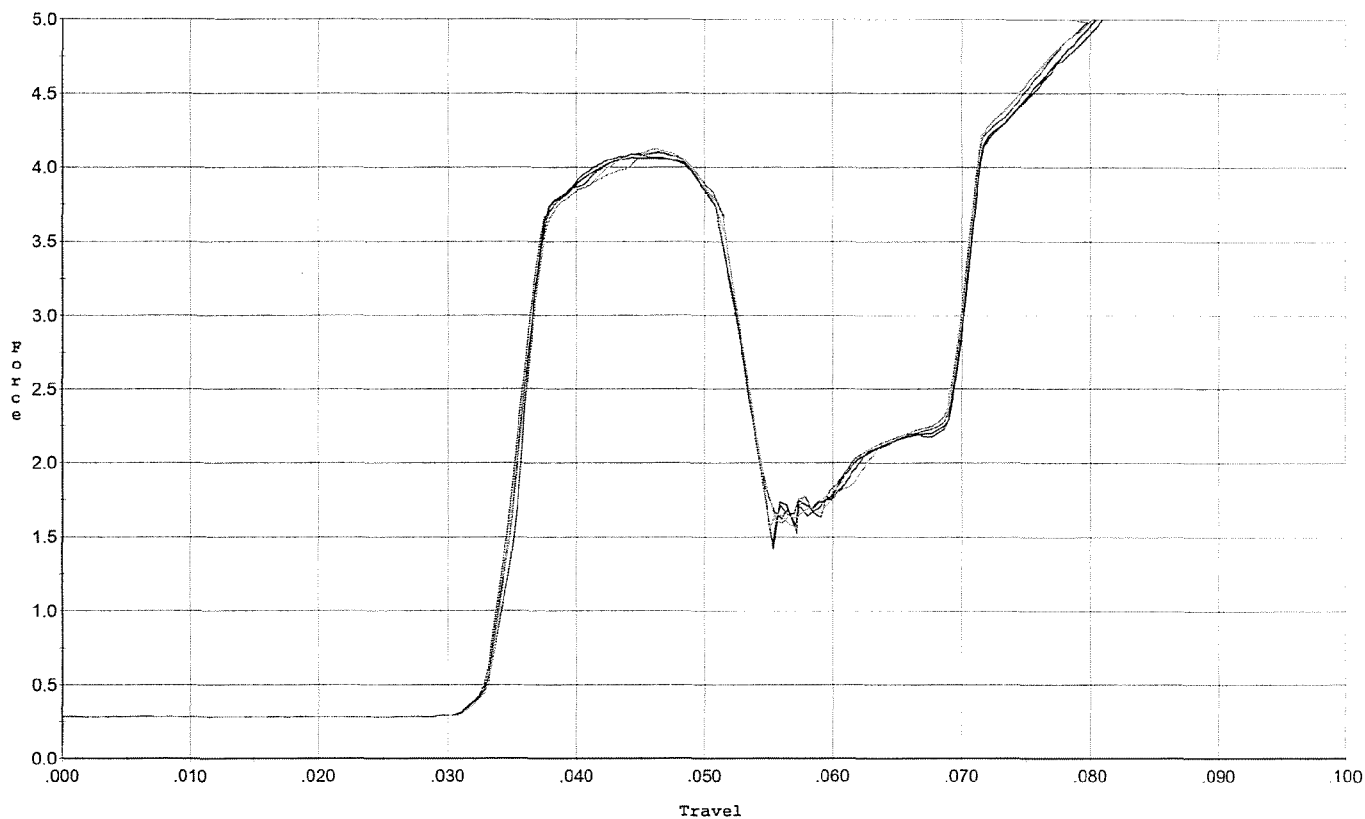
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.051	0.034	0.037	0.057		Set Trigger
2	3.034	0.051	0.034	0.037	0.055		Set Trigger
3	3.068	0.053	0.034	0.037	0.057		Set Trigger
4	2.989	0.051	0.034	0.037	0.055		Set Trigger
5	2.987	0.052	0.033	0.037	0.055		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/18/08

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



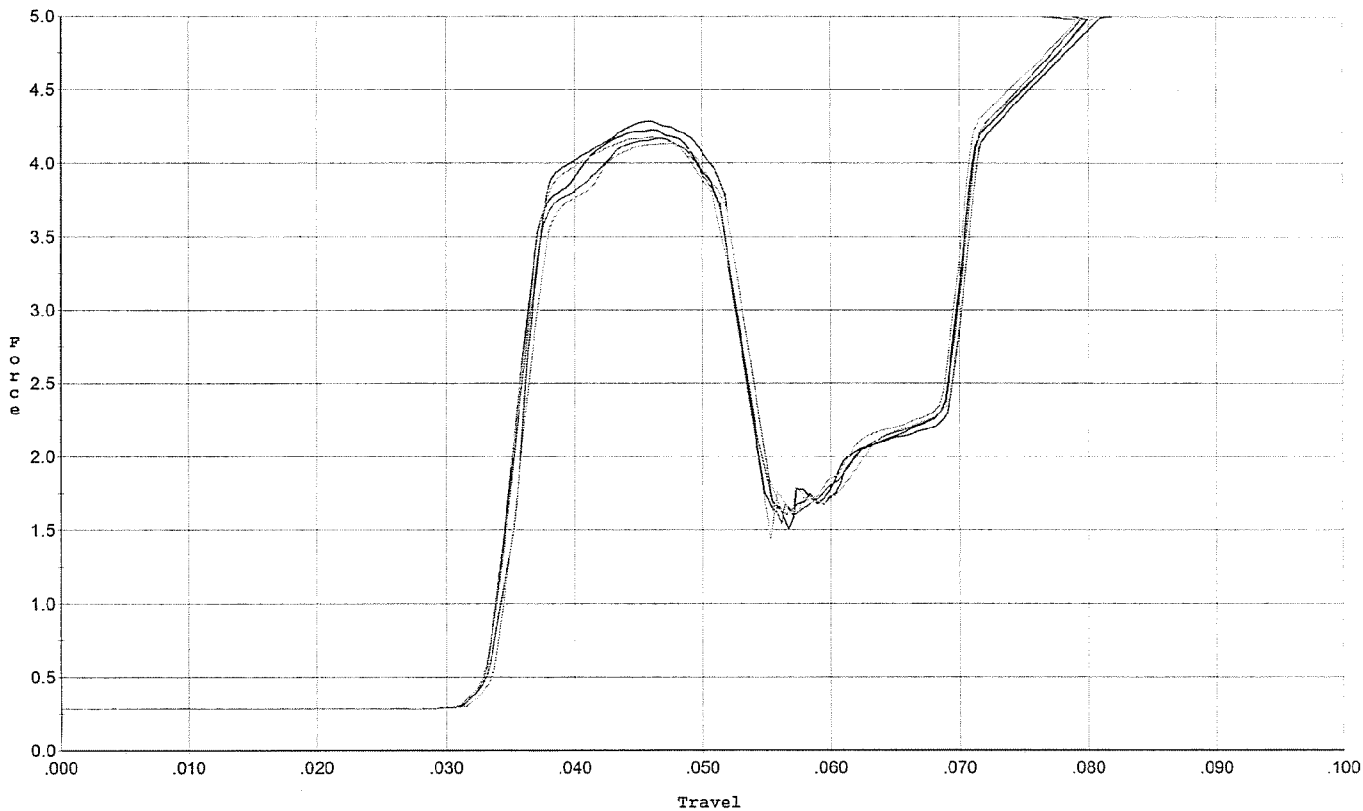
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.051	0.033	0.034	0.076		Set Trigger
2	4.066	0.052	0.033	0.034	0.077		Set Trigger
3	4.099	0.052	0.033	0.034	0.078		Set Trigger
4	4.105	0.052	0.033	0.034	0.076		Set Trigger
5	4.123	0.051	0.033	0.034	0.076		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/18/08

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



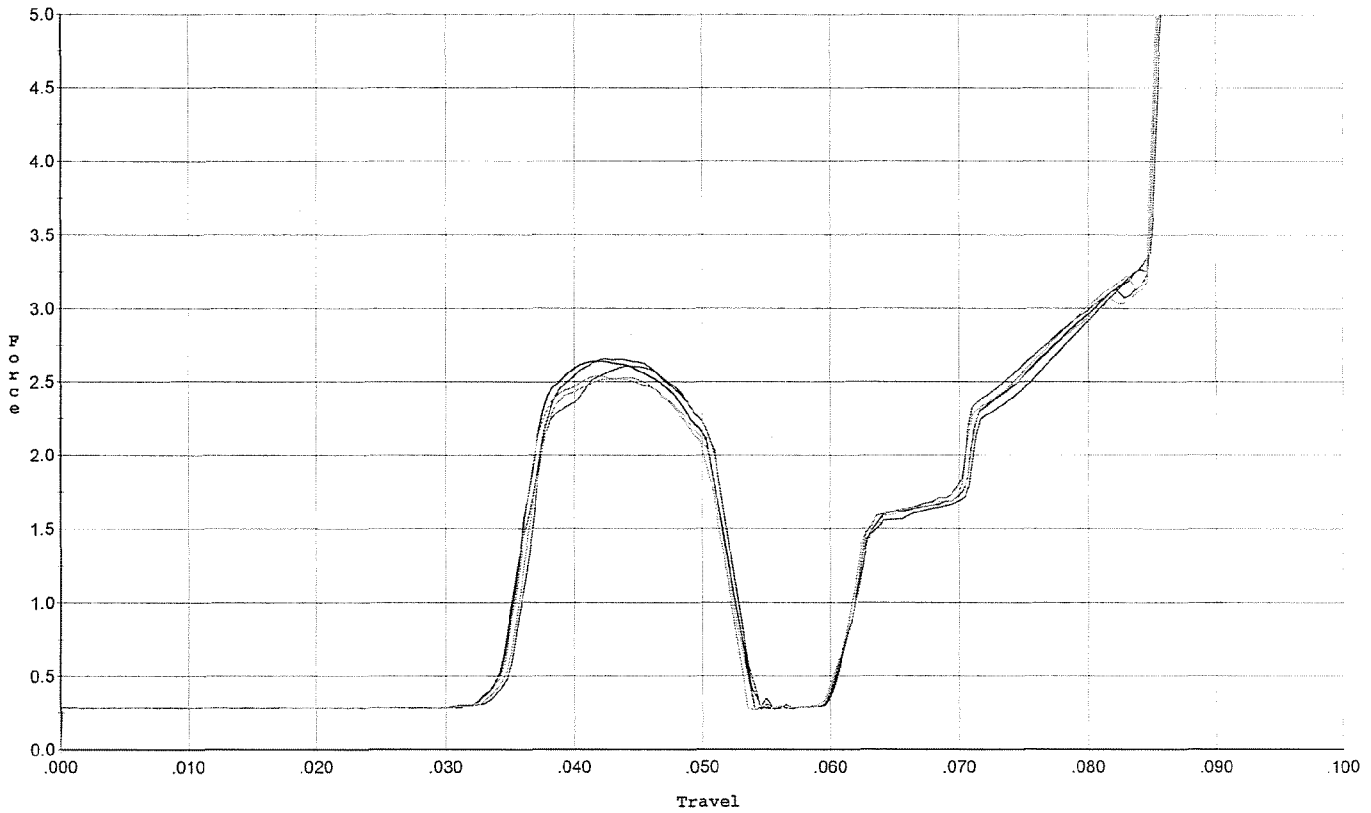
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.287	0.052	0.033	0.034	0.079		Set Trigger
2	4.226	0.051	0.033	0.034	0.078		Set Trigger
3	4.171	0.051	0.033	0.034	0.077		Set Trigger
4	4.134	0.052	0.033	0.034	0.077		Set Trigger
5	4.176	0.052	0.033	0.034	0.078		Set Trigger

Avg 4.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 8/18/08

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



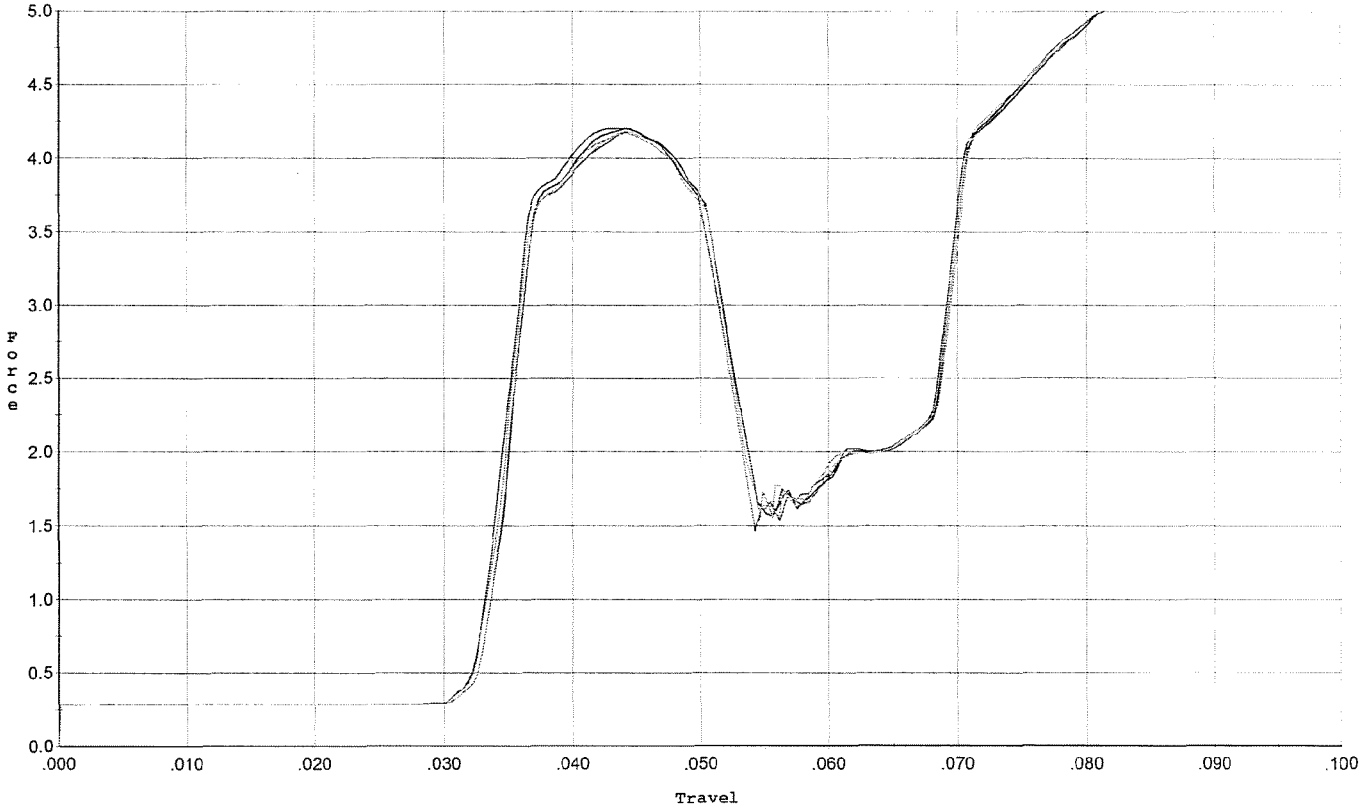
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.653	0.051	0.035	0.038	0.047		Set Trigger
2	2.637	0.050	0.034	0.038	0.047		Set Trigger
3	2.604	0.051	0.034	0.038	0.048		Set Trigger
4	2.517	0.050	0.034	0.038	0.045		Set Trigger
5	2.538	0.051	0.034	0.038	0.047		Set Trigger

Avg 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 8/18/08

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	4.202	0.051	0.032	0.035	0.077		Set Trigger
2	4.201	0.050	0.033	0.035	0.075		Set Trigger
3	4.175	0.050	0.033	0.035	0.074		Set Trigger
4	4.182	0.050	0.033	0.035	0.074		Set Trigger
5	4.171	0.052	0.032	0.035	0.076		Set Trigger

Avg 4.18