

56778939

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



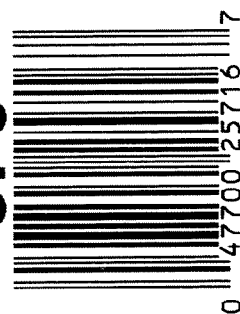
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6778939

UPC



GUN SERIAL #

G 6778939

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	J.P.D.
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	J.P.D.
460	CHECK HEADSPACE		8-20-08	J.P.D.
470	DIS-ASSEMBLE ACTION		8-20-08	J.P.D.
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8-21-08	RT
475	DRILL AND TAP SIGHT HOLES	AUG 22 2008	8-21-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR BA	8-22-08	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-27-08	RSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

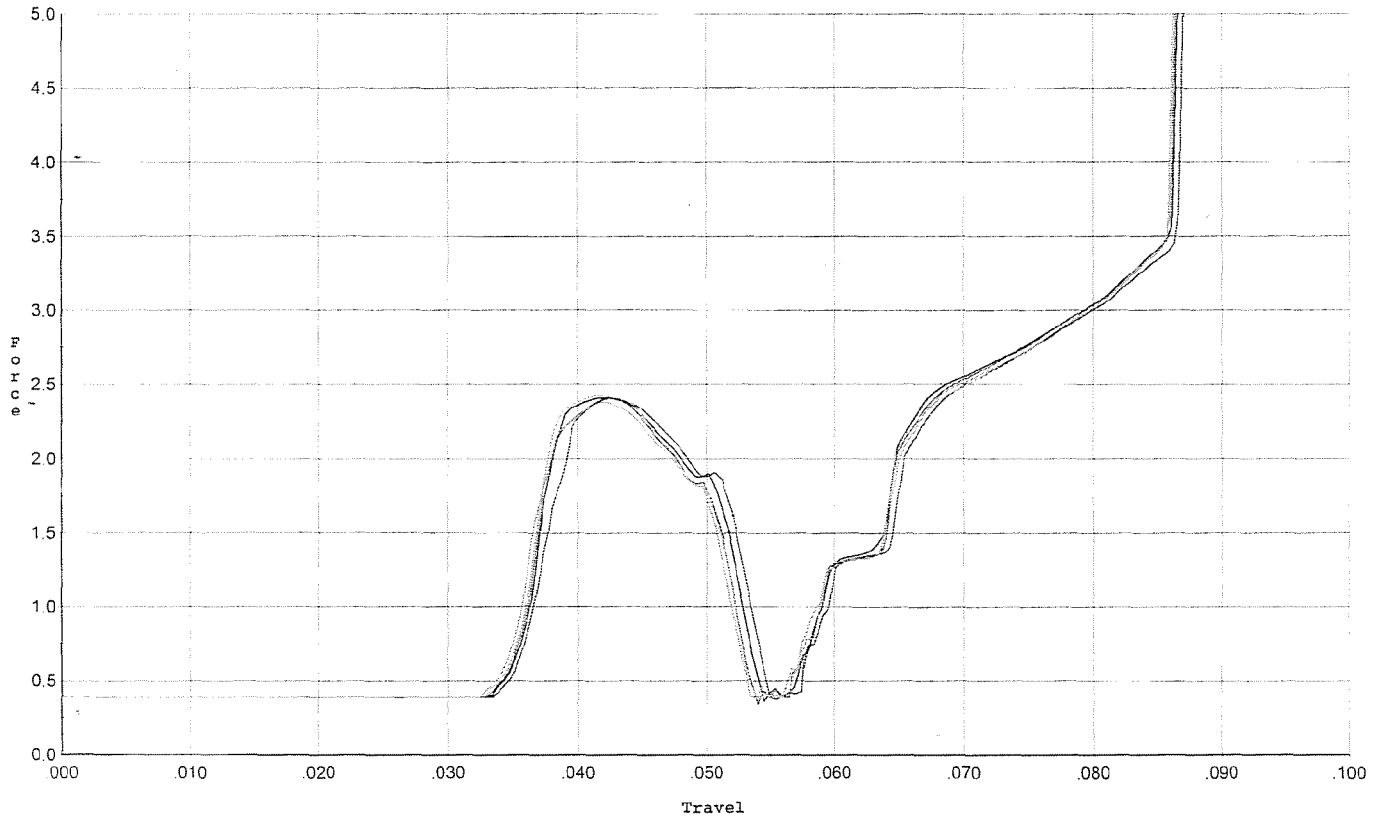
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	11-5-08	X 90
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4°</u> <u>4°</u> <u>5°</u>	11-5-08	X 90
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-5-08	X 90
	J) ASSEMBLE STOCK		10-27-08	RSN
	K) ASSEMBLE SWIVEL STUDS		11-5-08	X 90
	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	10-30-08	RSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TL
670	FINAL INSPECTION A) HEADSPACE		11-5-08	X 90
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.54</u> <u>2.60</u> <u>2.58</u> <u>2.51</u>	11-3-08	TL
	C) FUNCTION		11-5-08	X 90
690	PACK		11/10/08	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.



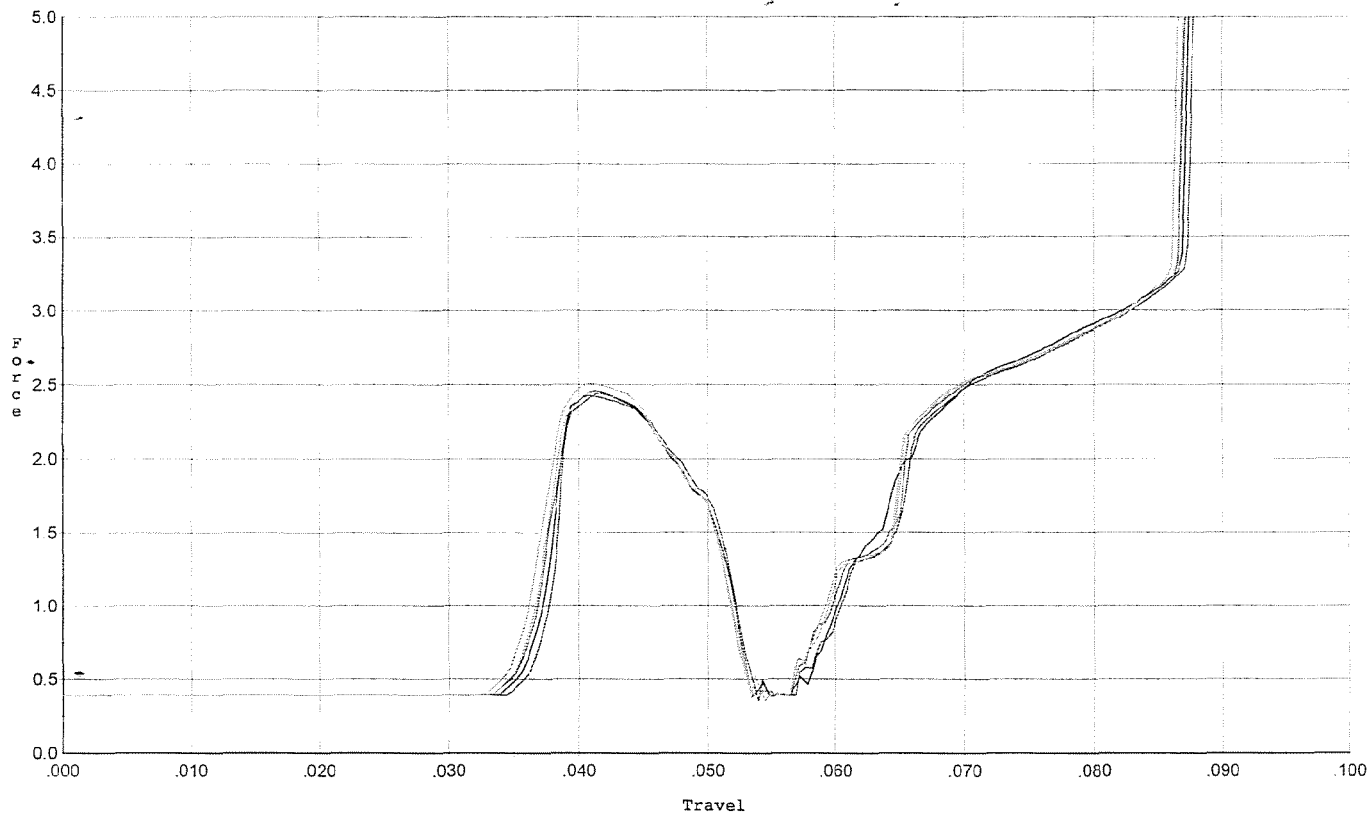
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.408	0.052	0.035	0.039	0.047		Set Trigger
2	2.409	0.052	0.034	0.039	0.047		Set Trigger
3	2.405	0.051	0.034	0.039	0.046		Set Trigger
4	2.425	0.051	0.035	0.039	0.047		Set Trigger
5	2.380	0.051	0.035	0.040	0.046		Set Trigger

Avg 2.40

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.



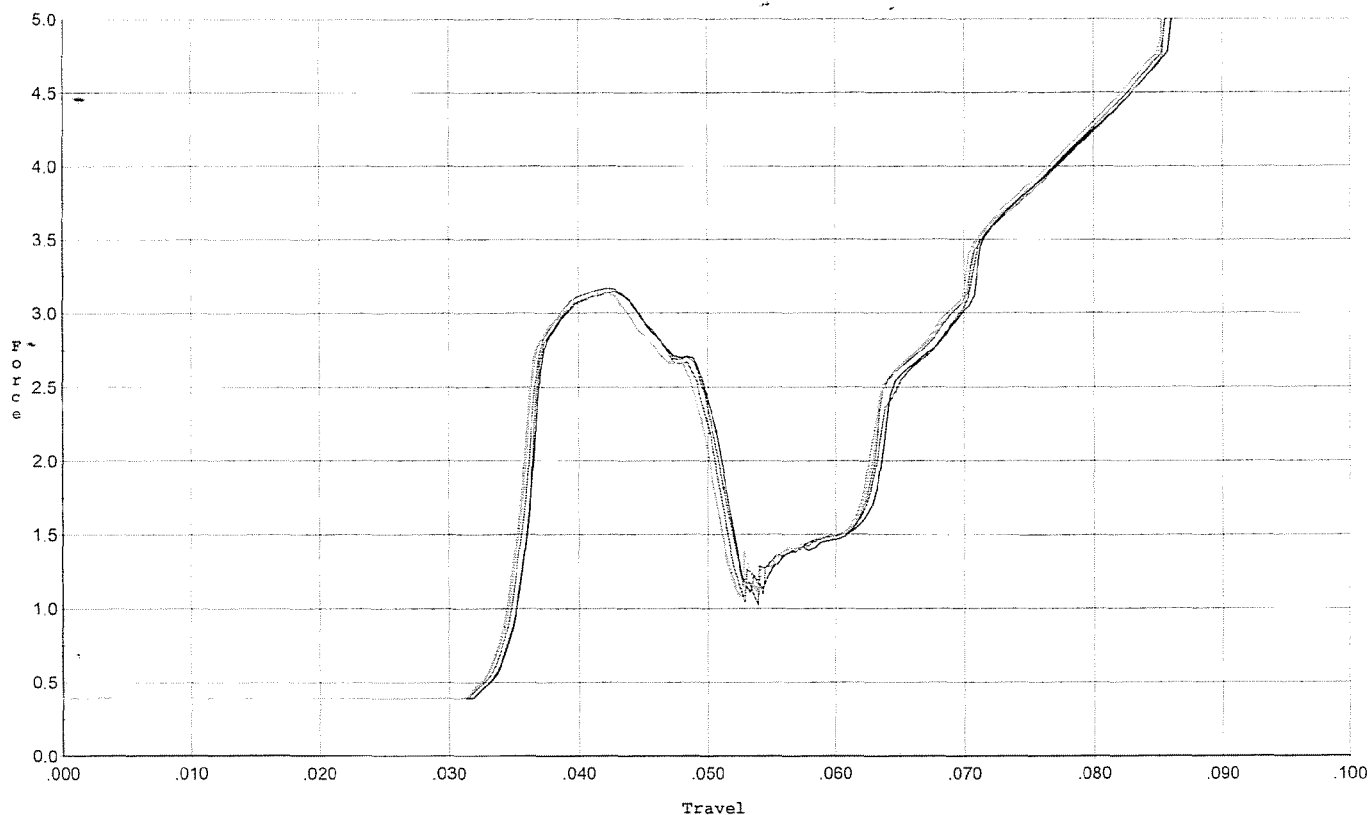
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.443	0.051	0.037	0.040	0.044		Set Trigger
2	2.458	0.052	0.036	0.040	0.045		Set Trigger
3	2.428	0.052	0.036	0.039	0.045		Set Trigger
4	2.447	0.051	0.036	0.040	0.045		Set Trigger
5	2.508	0.051	0.035	0.039	0.046		Set Trigger

AVG 2.45

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.



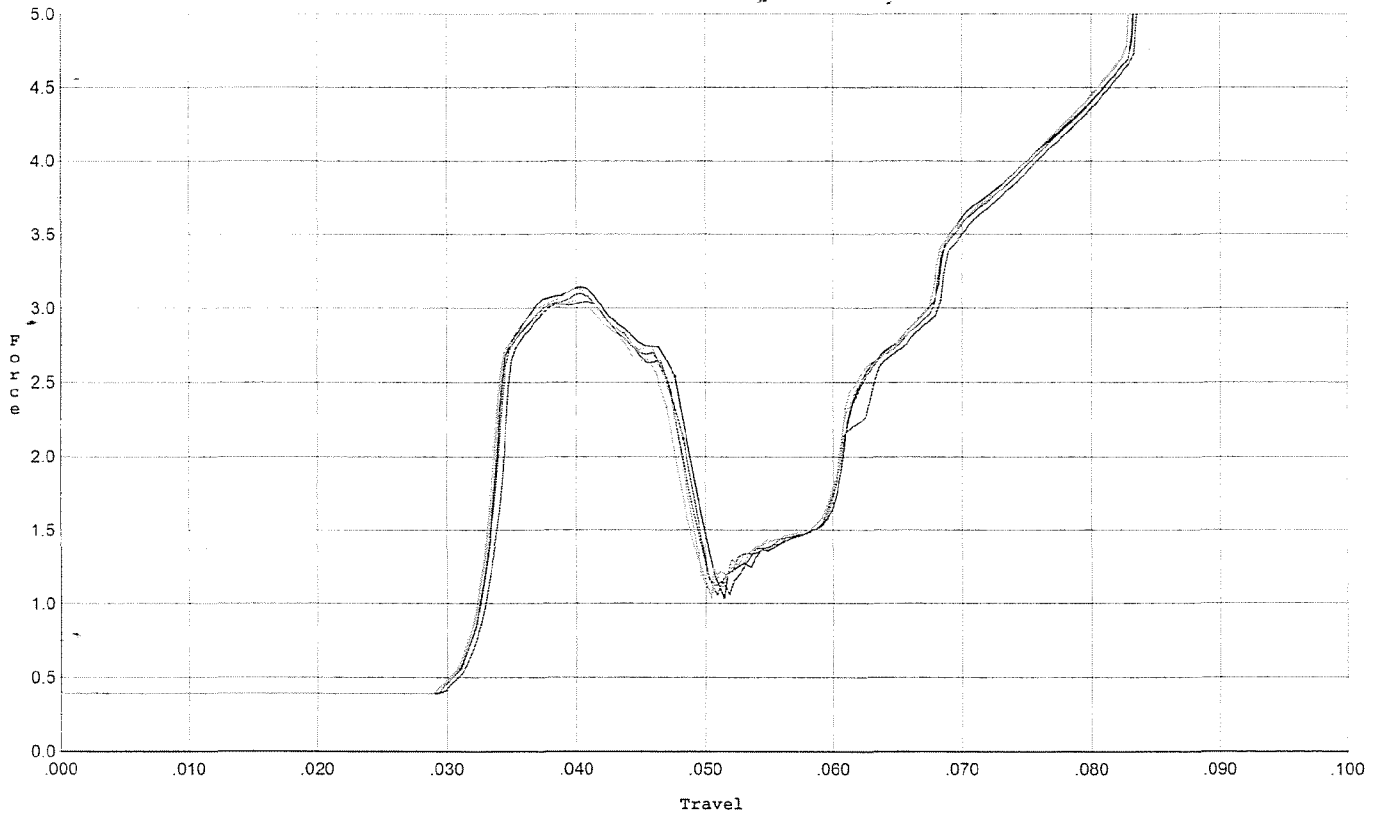
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.142	0.051	0.034	0.037	0.058		Set Trigger
2	3.143	0.051	0.034	0.037	0.057		Set Trigger
3	3.166	0.050	0.034	0.037	0.057		Set Trigger
4	3.131	0.050	0.033	0.038	0.056		Set Trigger
5	3.143	0.050	0.033	0.038	0.056		Set Trigger

Avg. 3.14

Trigger Profile [lbs,inch]

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

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



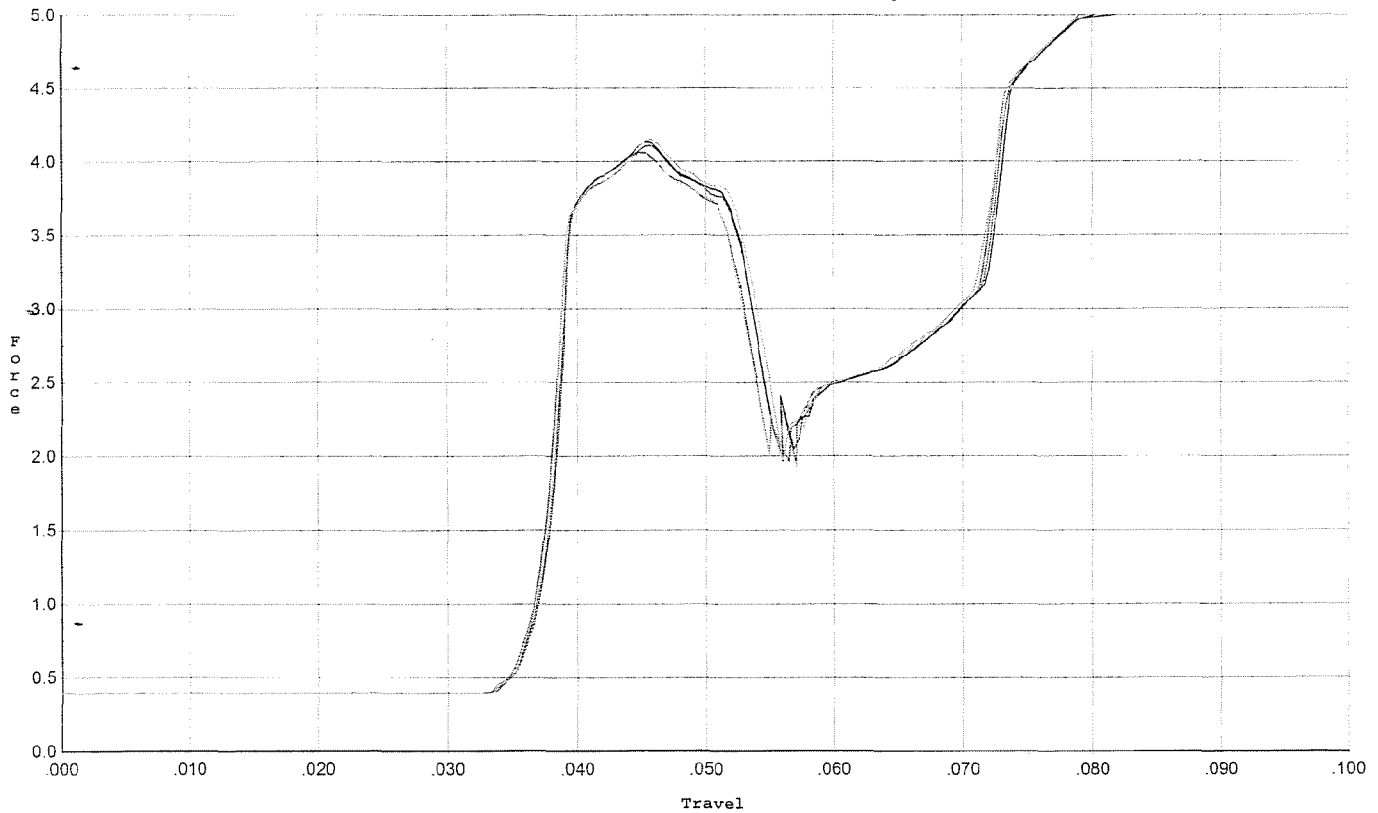
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.044	0.048	0.032	0.037	0.055		Set Trigger
2	3.145	0.048	0.031	0.037	0.056		Set Trigger
3	3.097	0.047	0.031	0.037	0.054		Set Trigger
4	3.048	0.047	0.031	0.037	0.053		Set Trigger
5	3.134	0.047	0.031	0.037	0.055		Set Trigger

Avg-3.09

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. ini. +/- 1.0 lbs.



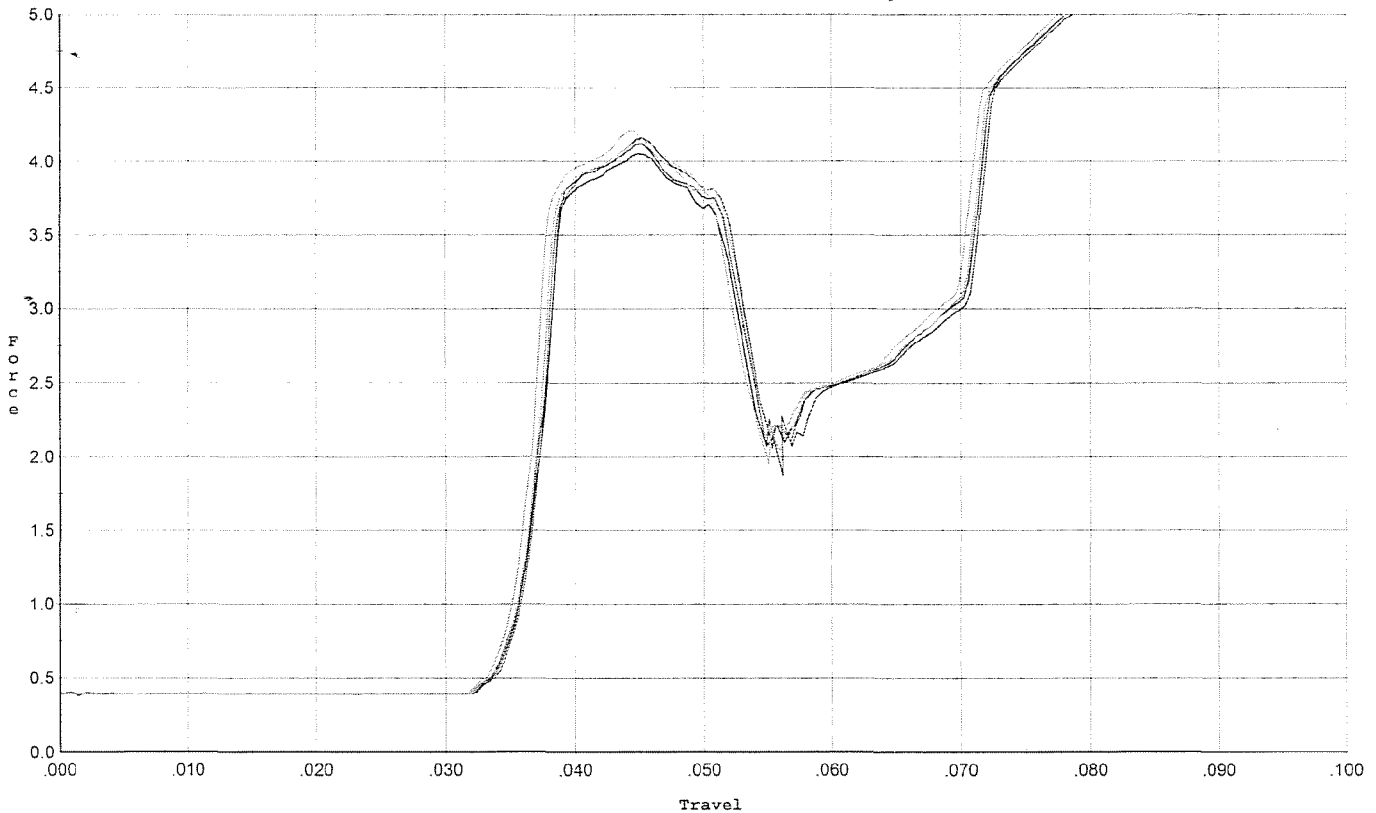
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.053	0.036	0.038	0.074		Set Trigger
2	4.134	0.053	0.036	0.038	0.075		Set Trigger
3	4.061	0.053	0.035	0.038	0.074		Set Trigger
4	4.057	0.053	0.036	0.038	0.074		Set Trigger
5	4.152	0.054	0.036	0.037	0.077		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

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

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



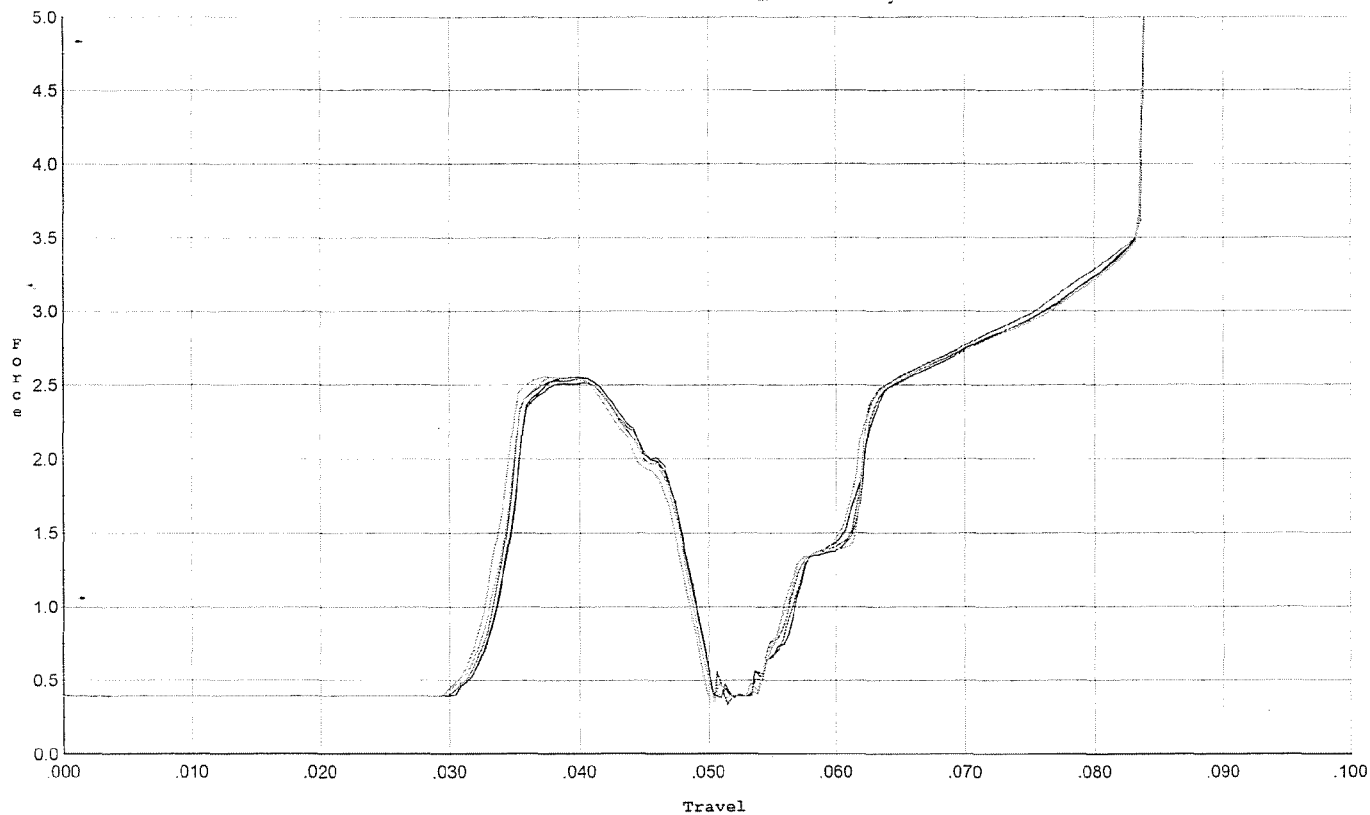
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.120	0.053	0.034	0.037	0.077		Set Trigger
2	4.052	0.052	0.034	0.037	0.074		Set Trigger
3	4.164	0.052	0.035	0.037	0.076		Set Trigger
4	4.152	0.052	0.034	0.036	0.078		Set Trigger
5	4.207	0.051	0.034	0.037	0.075		Set Trigger

Avg 4.13

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



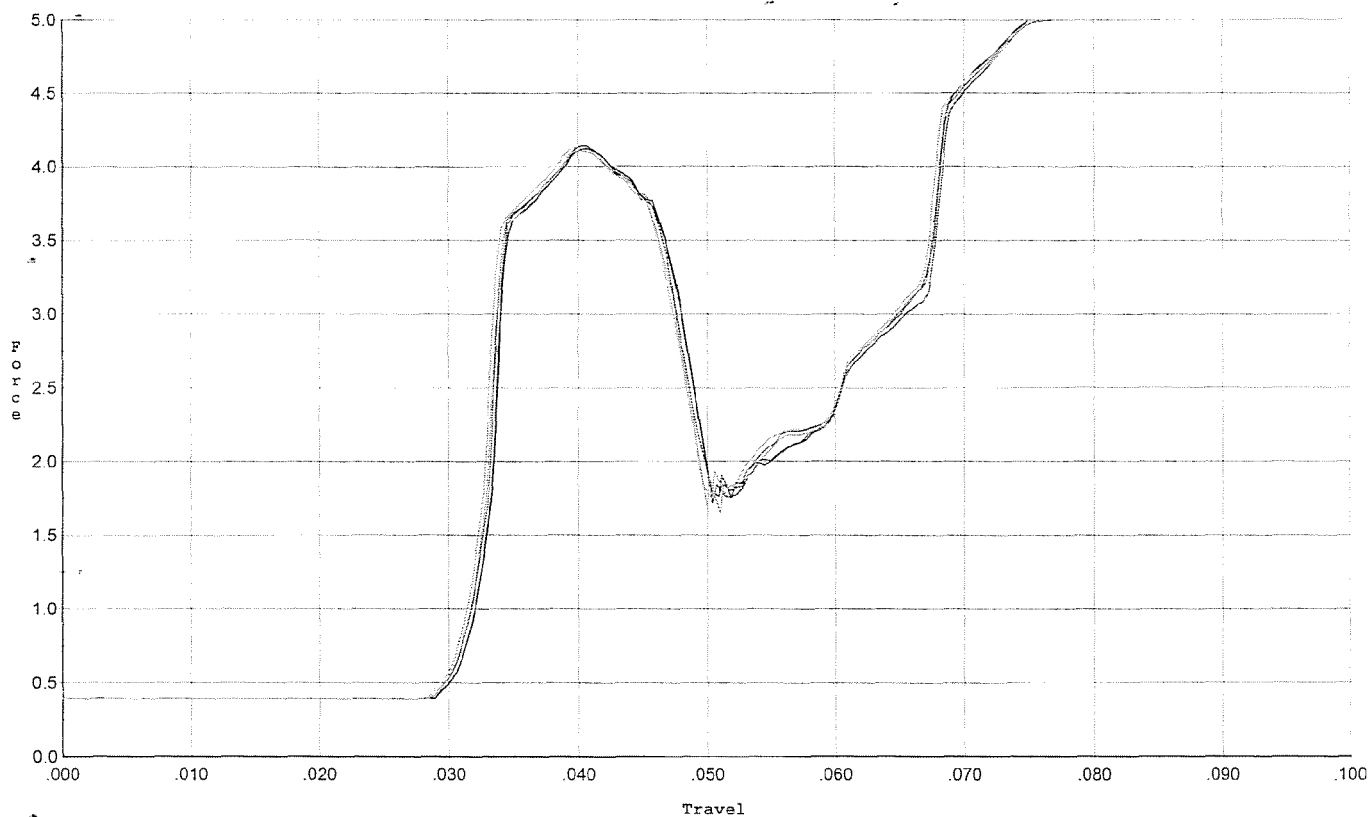
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.049	0.031	0.039	0.046		Set Trigger
2	2.548	0.047	0.031	0.040	0.045		Set Trigger
3	2.536	0.048	0.032	0.040	0.045		Set Trigger
4	2.548	0.048	0.030	0.040	0.045		Set Trigger
5	2.552	0.048	0.031	0.040	0.046		Set Trigger

Aug 254

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 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	4.142	0.048	0.029	0.035	0.071		Set Trigger
2	4.124	0.048	0.031	0.035	0.070		Set Trigger
3	4.112	0.047	0.031	0.035	0.069		Set Trigger
4	4.134	0.048	0.030	0.035	0.071		Set Trigger
5	4.115	0.047	0.031	0.035	0.070		Set Trigger

Aug 4.12