

G6784576

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

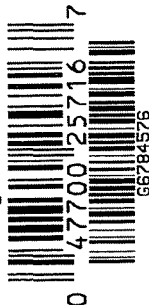
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



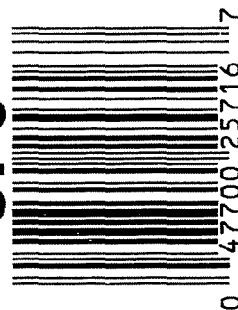
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6784576

UPC



GUN SERIAL # G 6784576

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-27-08	SP
430	ASSEMBLE TO STOCK		9-27-08	SP
440	PROOF		9-27-08	SP
460	CHECK HEADSPACE		9-29-08	SP
470	DIS-ASSEMBLE ACTION		9-29-08	SP
472	SERIALIZE BOLT HANDLE		9-30-08	RT
475	DRILL AND TAP SIGHT HOLES	MAGNA FLUX OCT 02 2008 OPERATOR 45	10/1/08	FM
480	MAGNAFLUX BBL ACTION		10/2/08	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/3/08	DS
542	APPLY COATINGS (BARREL ACTION)		10 9	e
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	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		10-31-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

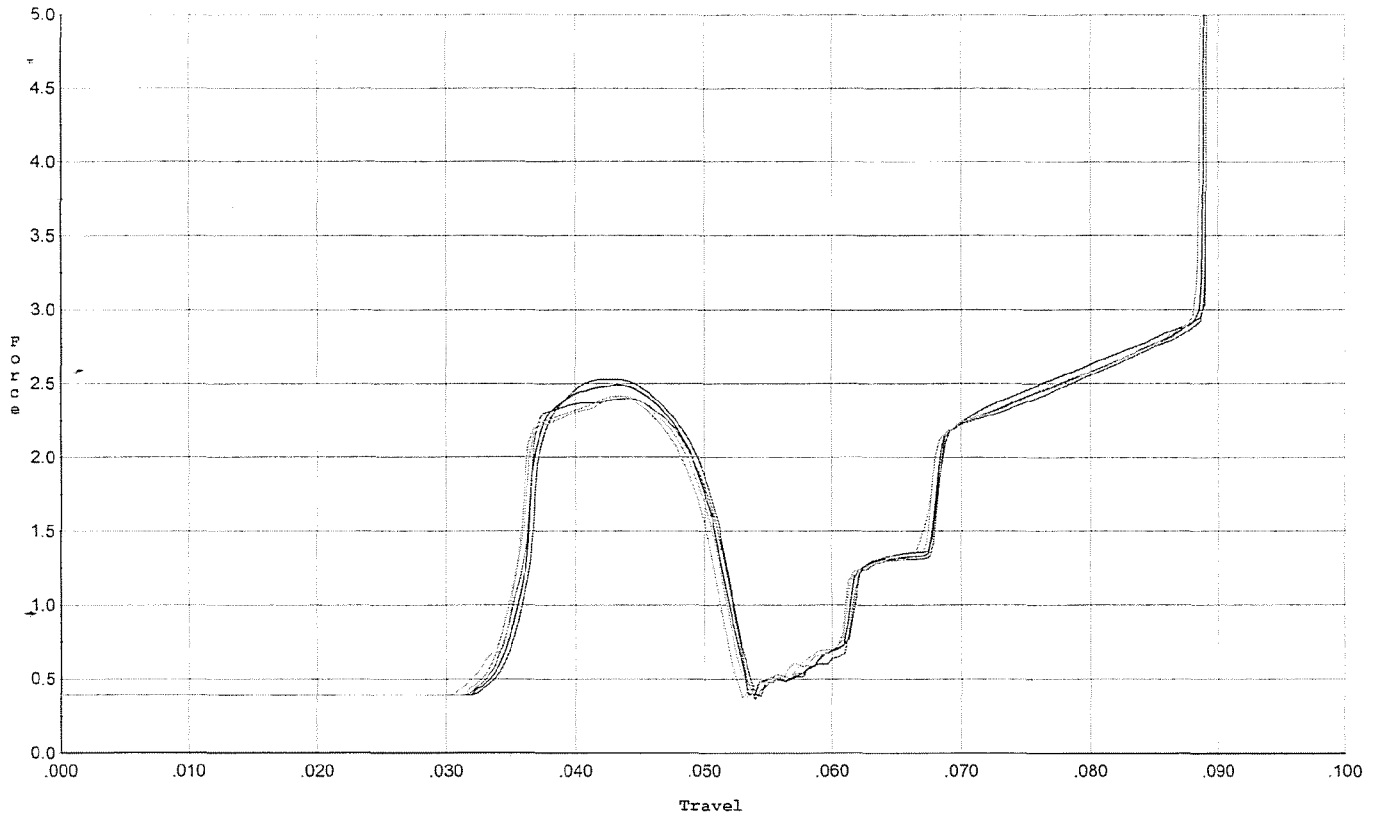
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-6-08	L.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-6-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-6-08	L.N.
	J) ASSEMBLE STOCK		10-31-08	L.N.
	K) ASSEMBLE SWIVEL STUDS		11-6-08	L.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	11-3-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	L.N.
670	FINAL INSPECTION A) HEADSPACE		11-6-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.55</u> <u>2.68</u> <u>2.57</u> <u>2.66</u>	11-5-08	Fm
	C) FUNCTION		11-5-08	L.N.
690	PACK		11/7/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



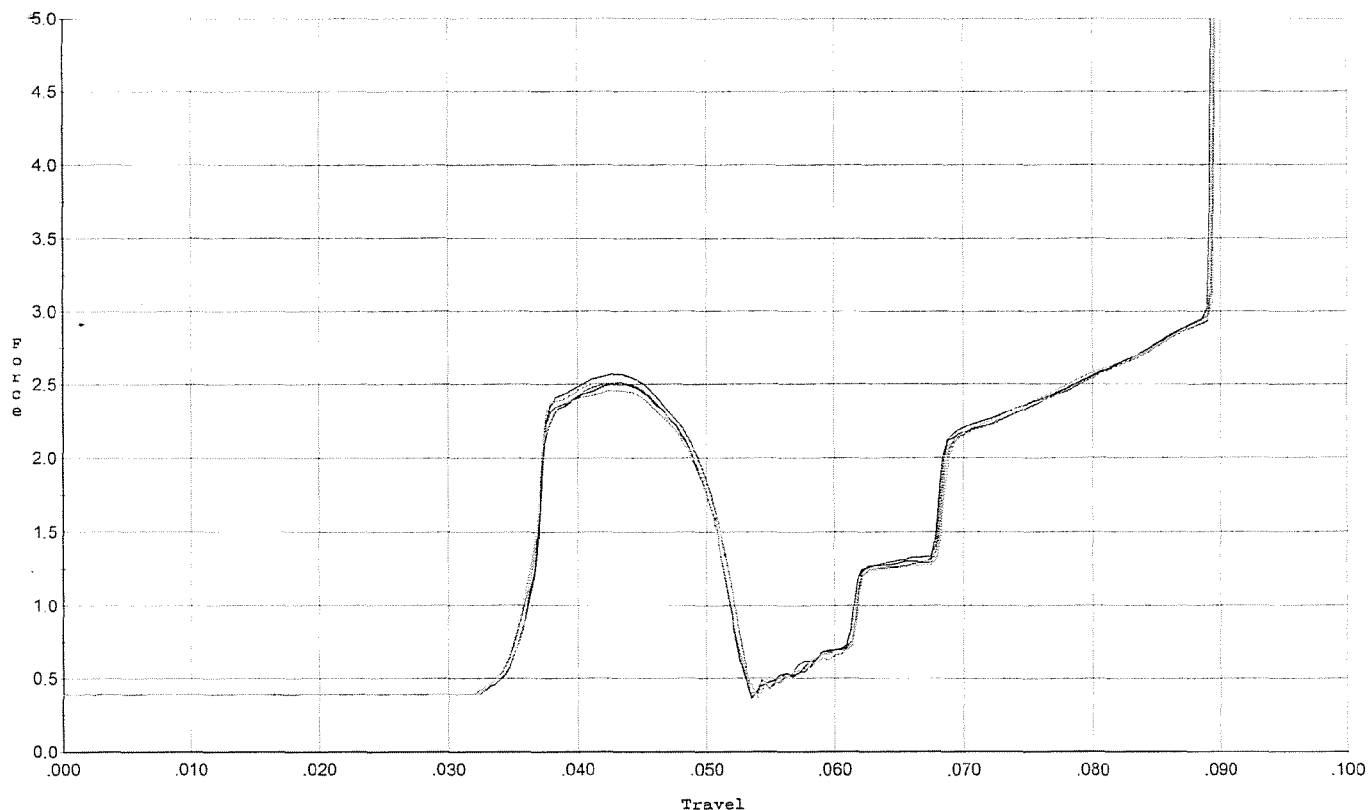
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.530	0.051	0.035	0.041	0.049		Set Trigger
2	2.491	0.051	0.034	0.042	0.048		Set Trigger
3	2.397	0.051	0.034	0.041	0.049		Set Trigger
4	2.414	0.051	0.033	0.041	0.048		Set Trigger
5	2.413	0.050	0.034	0.042	0.047		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



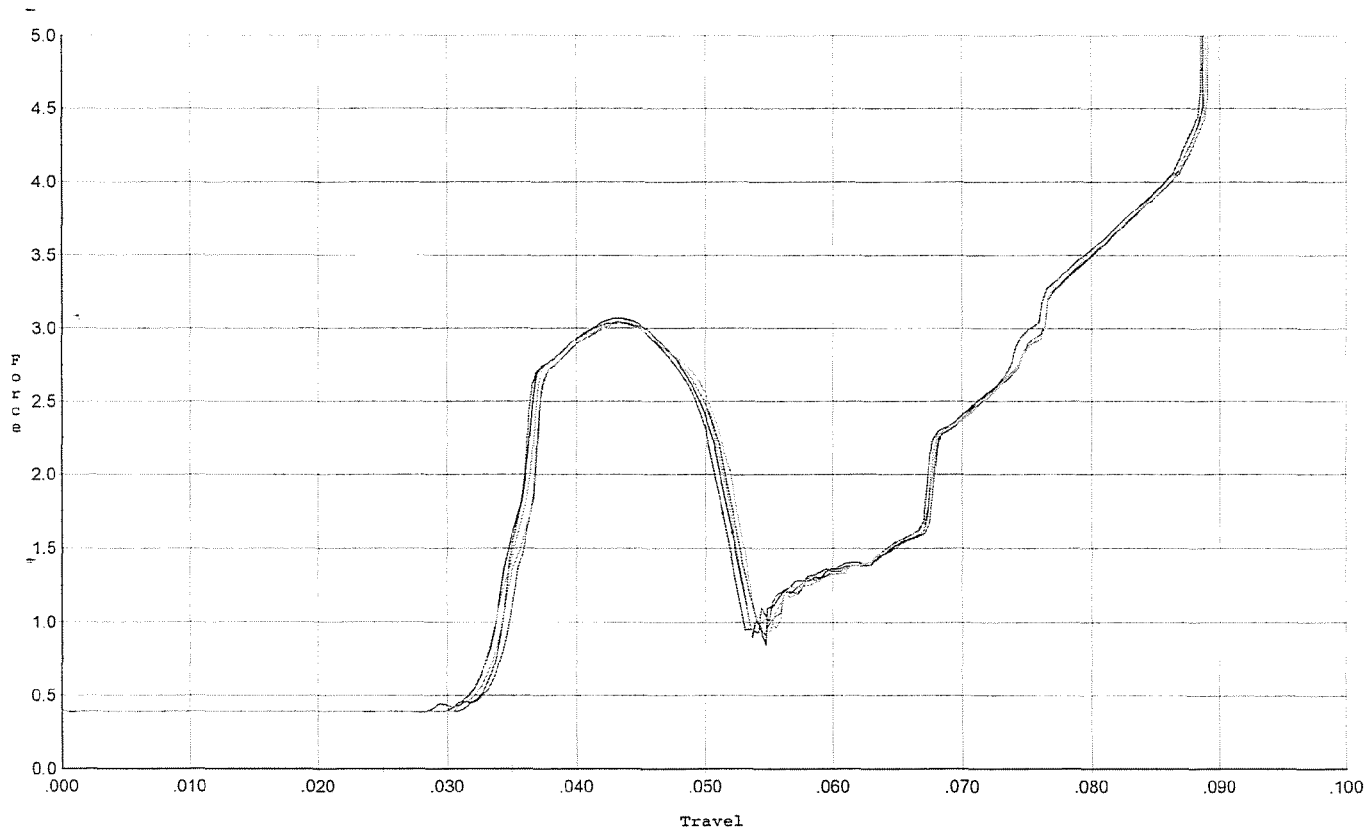
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.571	0.051	0.035	0.042	0.049		Set Trigger
2	2.499	0.051	0.035	0.042	0.047		Set Trigger
3	2.509	0.051	0.035	0.042	0.047		Set Trigger
4	2.507	0.051	0.035	0.042	0.048		Set Trigger
5	2.458	0.051	0.035	0.042	0.048		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



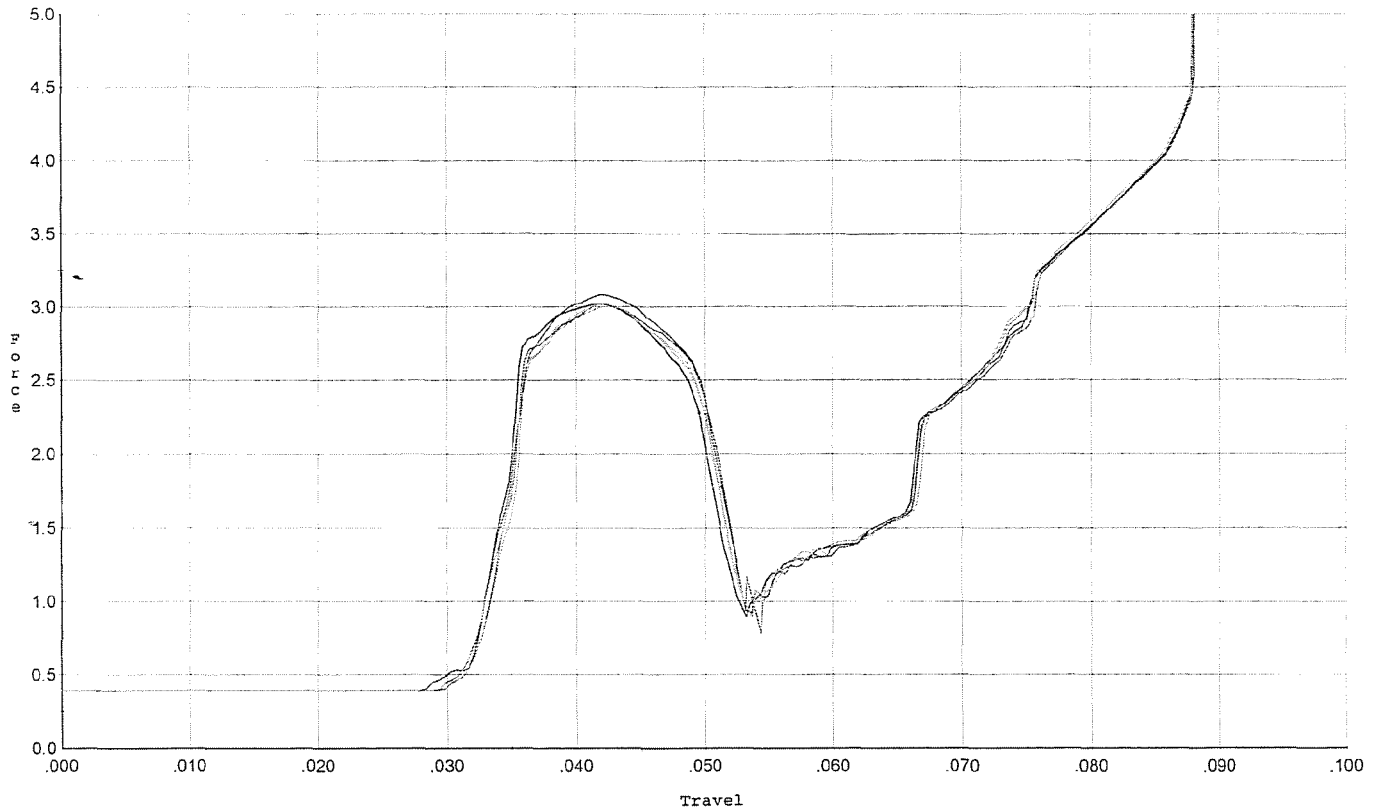
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.041	0.051	0.033	0.040	0.059		Set Trigger
2	3.069	0.052	0.033	0.039	0.061		Set Trigger
3	3.040	0.051	0.034	0.040	0.058		Set Trigger
4	3.033	0.052	0.033	0.039	0.061		Set Trigger
5	3.054	0.052	0.033	0.040	0.059		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



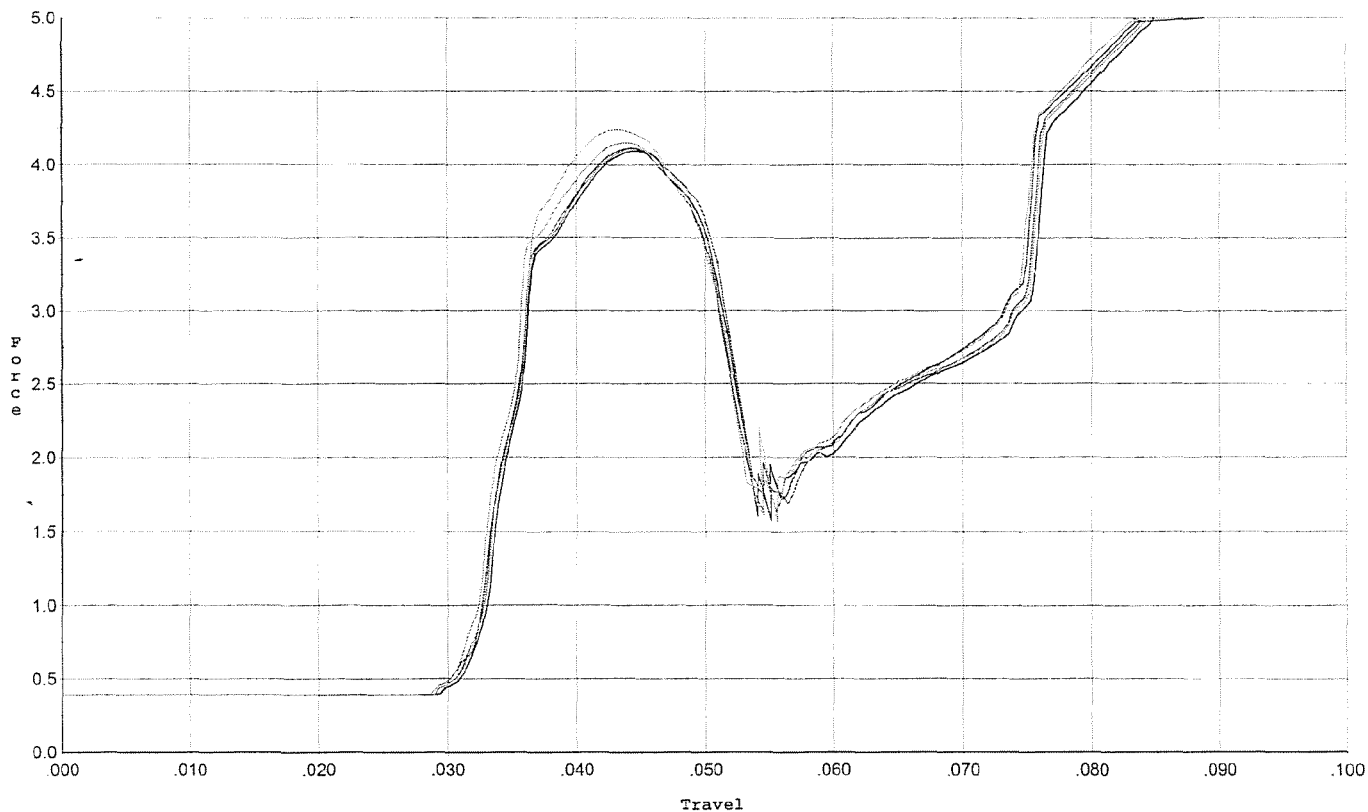
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.081	0.051	0.032	0.039	0.062		Set Trigger
2	3.019	0.050	0.032	0.040	0.058		Set Trigger
3	3.015	0.051	0.032	0.039	0.060		Set Trigger
4	3.014	0.050	0.032	0.040	0.059		Set Trigger
5	3.003	0.050	0.032	0.040	0.058		Set Trigger

Aug 3.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



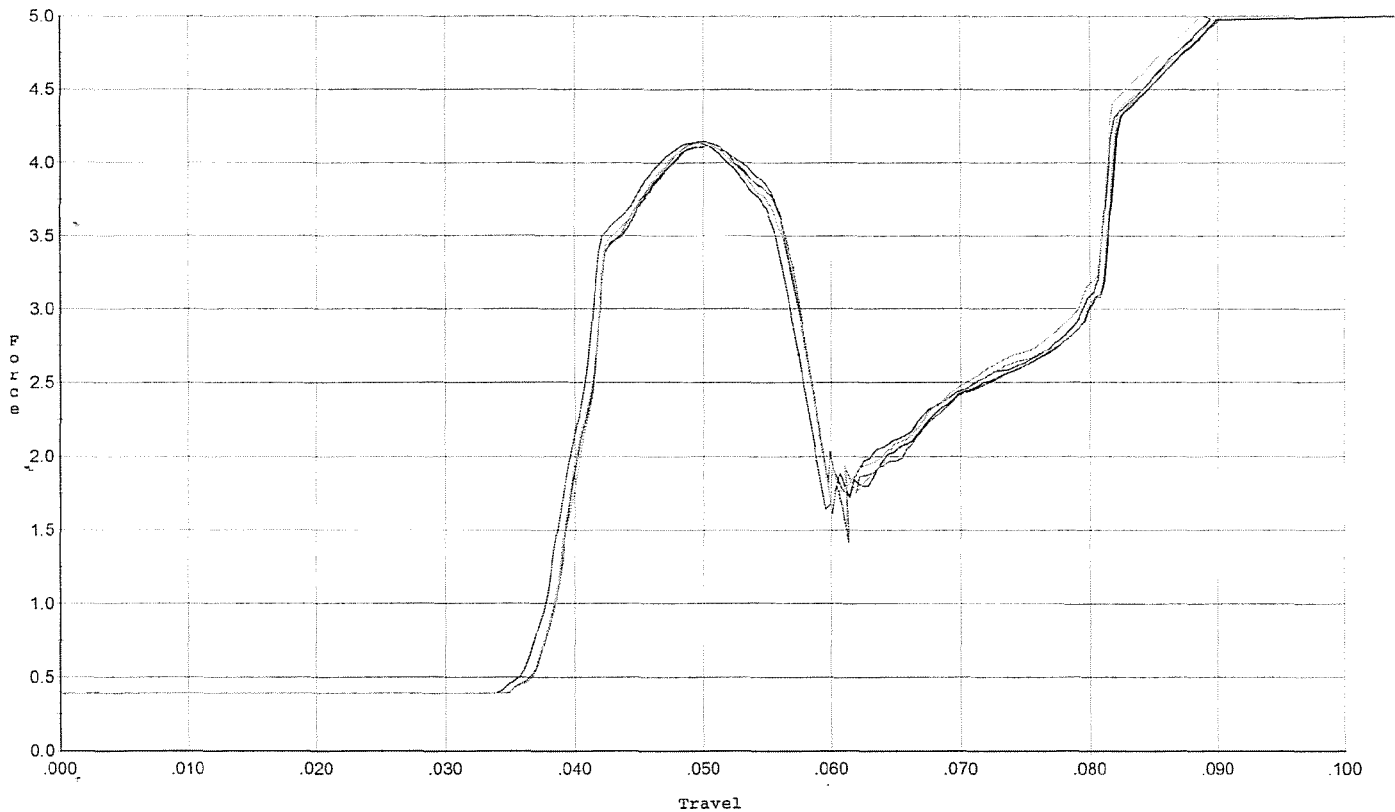
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.113	0.050	0.031	0.037	0.077		Set Trigger
2	4.092	0.052	0.032	0.037	0.078		Set Trigger
3	4.118	0.051	0.031	0.036	0.078		Set Trigger
4	4.241	0.050	0.031	0.037	0.078		Set Trigger
5	4.147	0.051	0.031	0.036	0.078		Set Trigger

Avg 4.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



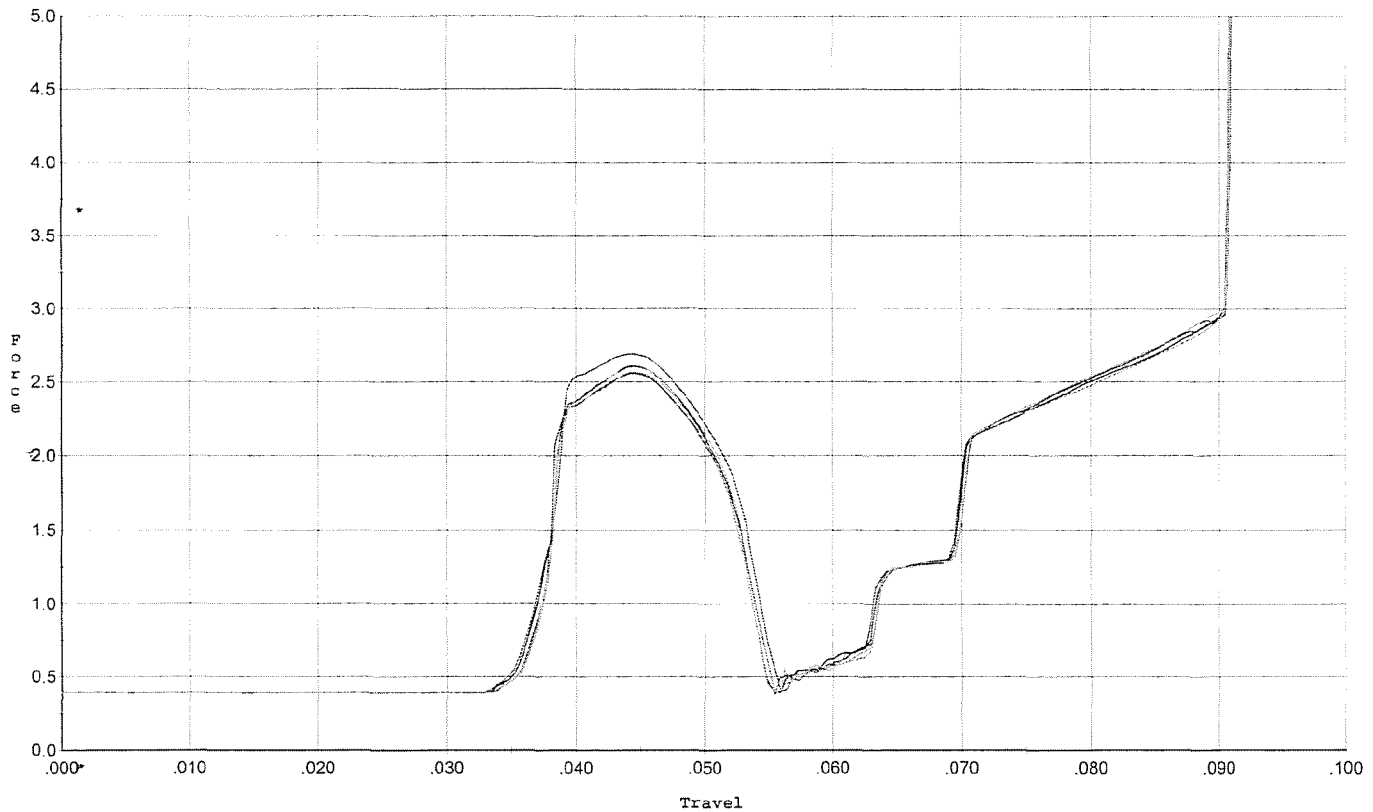
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.136	0.057	0.036	0.039	0.083		Set Trigger
2	4.114	0.058	0.037	0.039	0.083		Set Trigger
3	4.143	0.057	0.037	0.039	0.082		Set Trigger
4	4.135	0.057	0.037	0.039	0.083		Set Trigger
5	4.115	0.058	0.037	0.039	0.082		Set Trigger

Aug 4.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



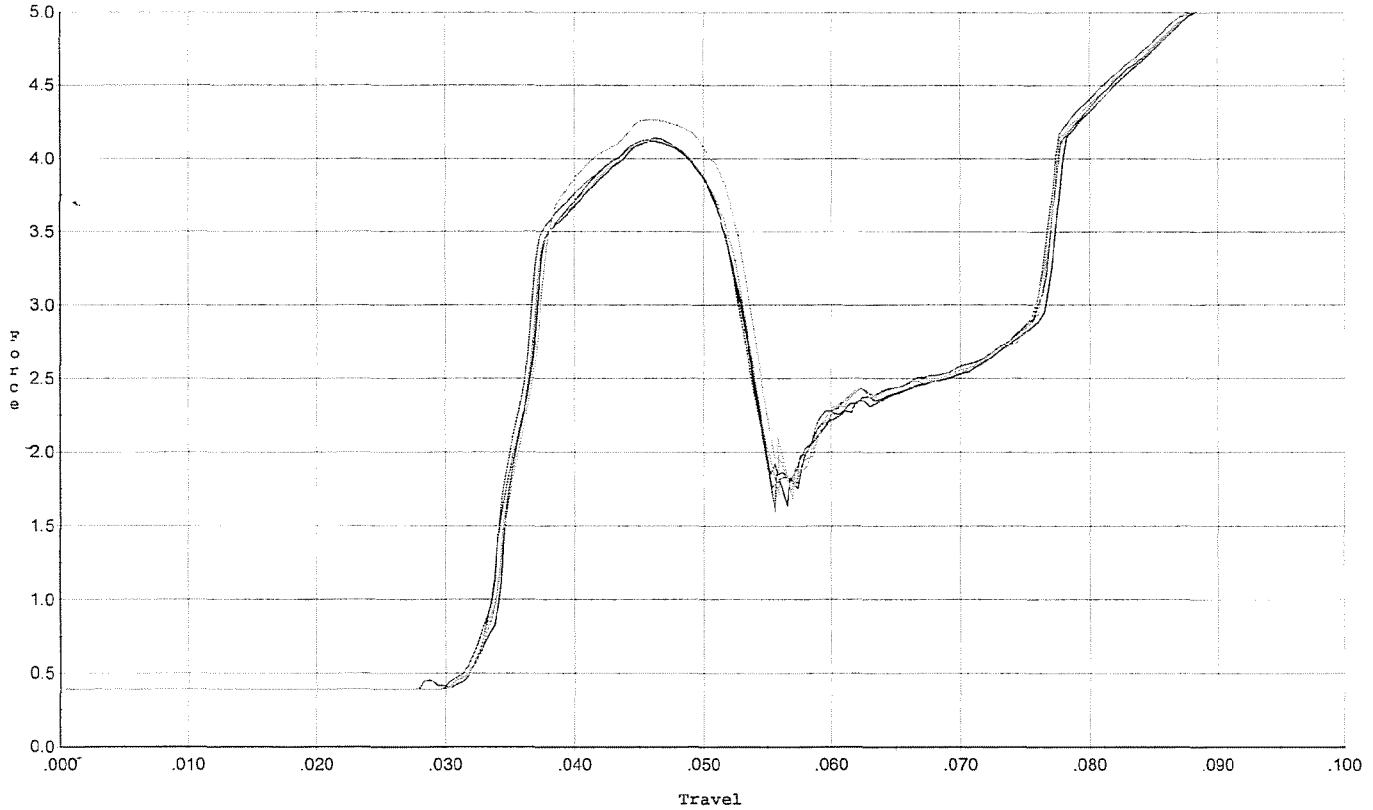
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.556	0.053	0.036	0.042	0.050		Set Trigger
2	2.606	0.053	0.036	0.042	0.050		Set Trigger
3	2.691	0.053	0.036	0.041	0.052		Set Trigger
4	2.602	0.053	0.036	0.042	0.050		Set Trigger
5	2.567	0.053	0.036	0.042	0.050		Set Trigger

Aug 2.60

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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	4.118	0.053	0.032	0.037	0.082		Set Trigger
2	4.139	0.053	0.033	0.037	0.081		Set Trigger
3	4.130	0.052	0.032	0.037	0.080		Set Trigger
4	4.133	0.052	0.032	0.037	0.081		Set Trigger
5	4.261	0.053	0.033	0.037	0.084		Set Trigger

Avg 4.15