

66784596

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

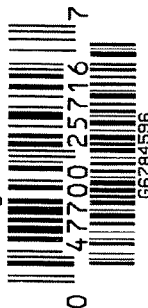
- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



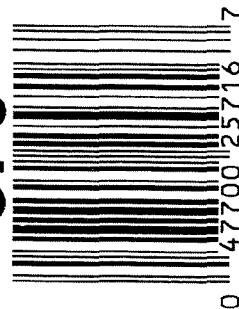
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6784596

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6784596

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-9-08	SP
430	ASSEMBLE TO STOCK		9-9-08	SP
440	PROOF		9-9-08	SP
460	CHECK HEADSPACE		9-9-08	SP
470	DIS-ASSEMBLE ACTION		9-9-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	9-10-08	RT
475	DRILL AND TAP SIGHT HOLES	SEP 12 2008	9-11-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR B/T	9-12-08	BA
490	MAGNAFLUX BOLT		9/14/08	MR
500	ROLLMARK CALIBER		9/12/08	RT
520	GOFF BLAST BBL / REC		9/13/08	DG
542	APPLY COATINGS (BARREL ACTION)		9/6	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-13-08	RSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

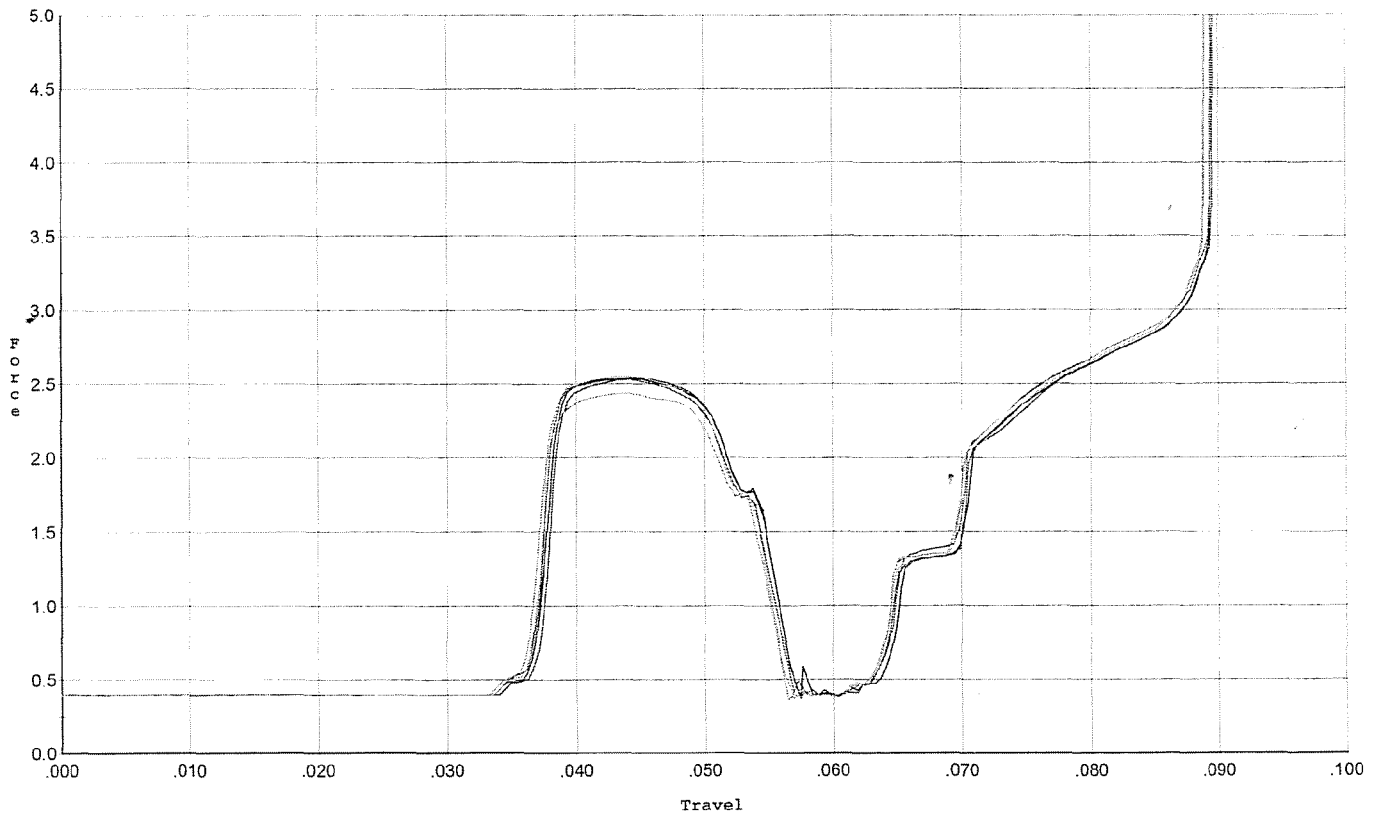
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	11-18-08	L.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	11-18-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-18-08	L.N.
	J) ASSEMBLE STOCK		11-13-08	R.N.
	K) ASSEMBLE SWIVEL STUDS		11-18-08	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	11-14-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-14-08	L.N.
670	FINAL INSPECTION A) HEADSPACE		11-18-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>258</u> <u>260</u> <u>267</u> <u>266</u> <u>264</u>	11-18-08	L.N.
	C) FUNCTION		11-18-08	L.N.
690	PACK		12-2-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



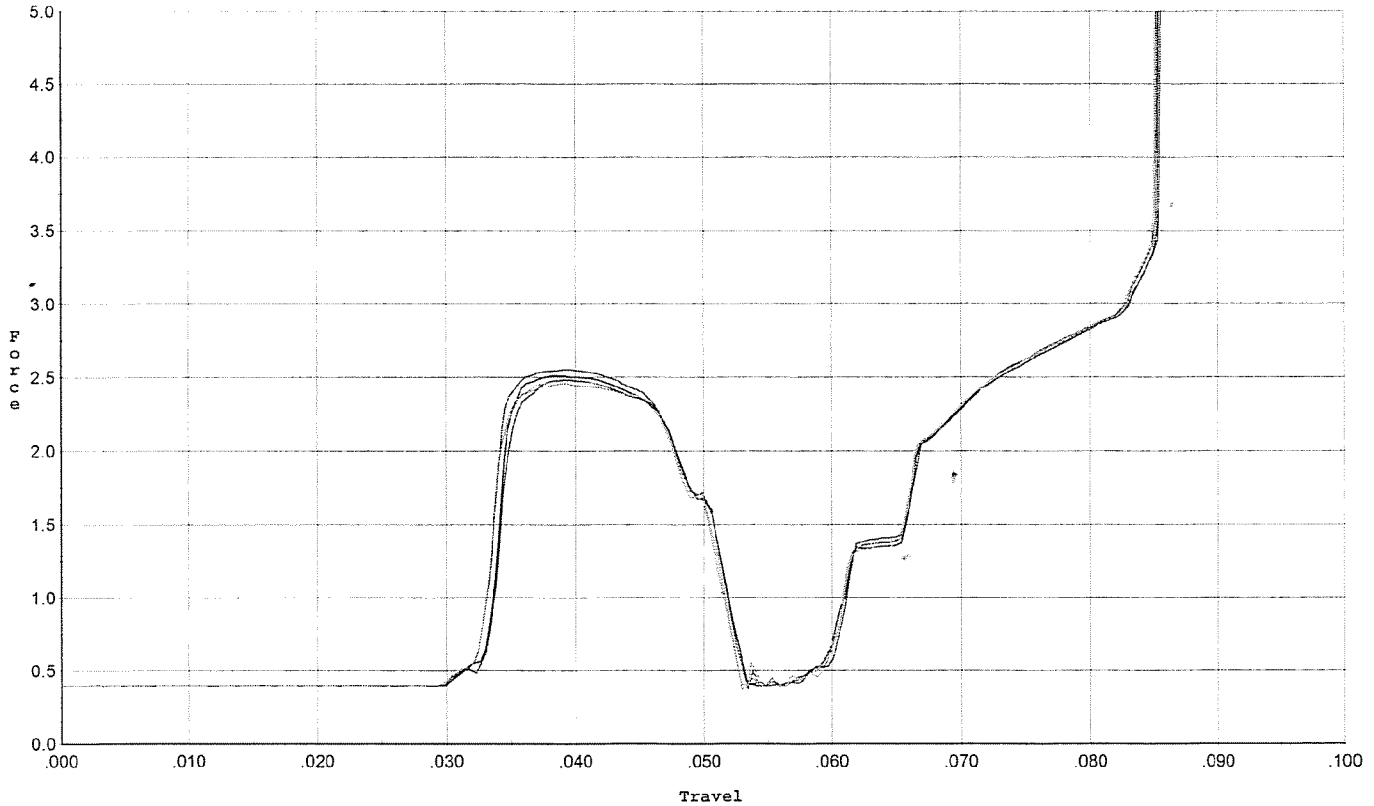
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.539	0.054	0.037	0.039	0.054		Set Trigger
2	2.535	0.055	0.036	0.039	0.055		Set Trigger
3	2.531	0.054	0.036	0.039	0.054		Set Trigger
4	2.549	0.054	0.036	0.038	0.054		Set Trigger
5	2.435	0.055	0.036	0.039	0.054		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



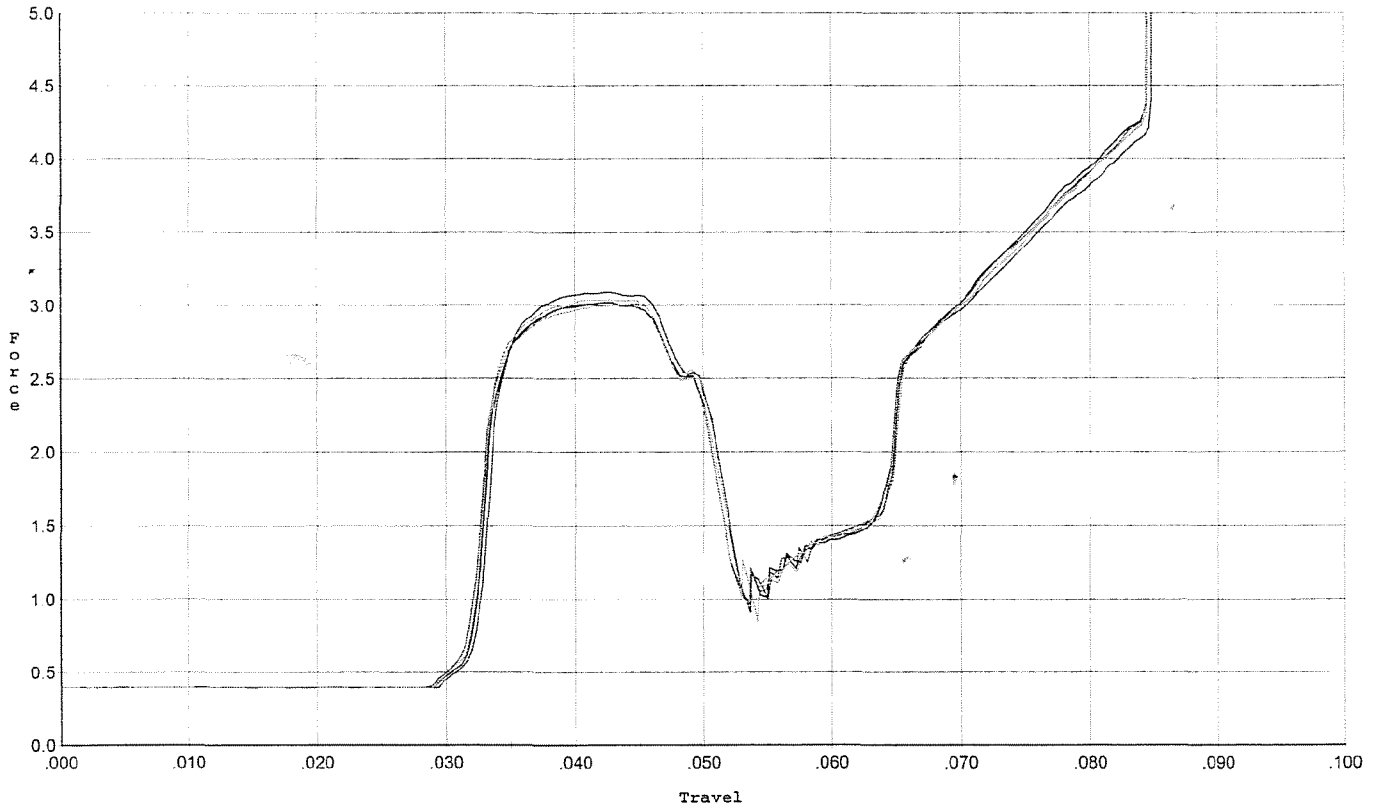
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.483	0.051	0.033	0.038	0.051		Set Trigger
2	2.509	0.051	0.033	0.038	0.052		Set Trigger
3	2.553	0.051	0.033	0.038	0.053		Set Trigger
4	2.475	0.051	0.032	0.038	0.053		Set Trigger
5	2.458	0.051	0.032	0.038	0.052		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



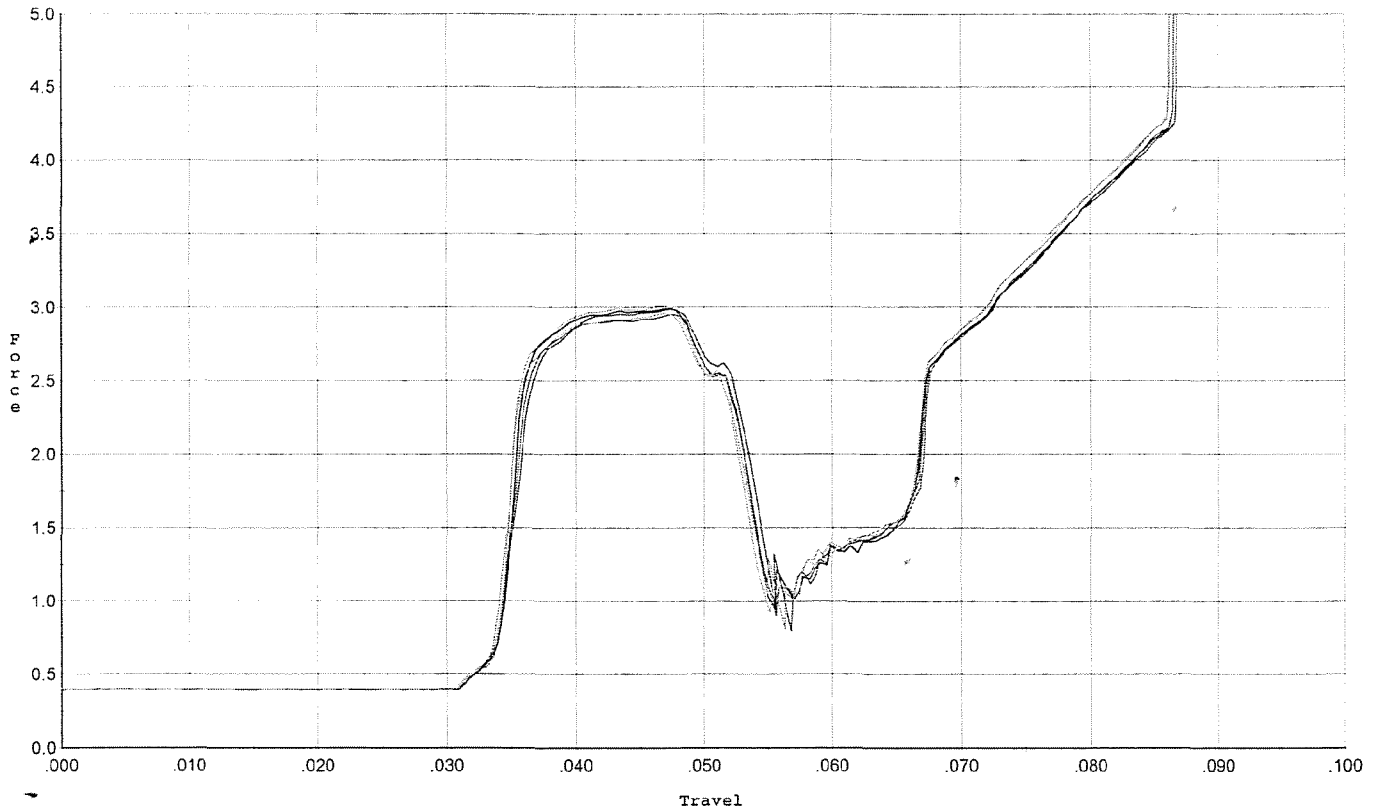
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.089	0.051	0.032	0.036	0.064		Set Trigger
2	3.020	0.050	0.032	0.036	0.062		Set Trigger
3	3.014	0.050	0.031	0.036	0.062		Set Trigger
4	3.038	0.051	0.032	0.036	0.065		Set Trigger
5	3.007	0.050	0.032	0.036	0.062		Set Trigger

Avg 3.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



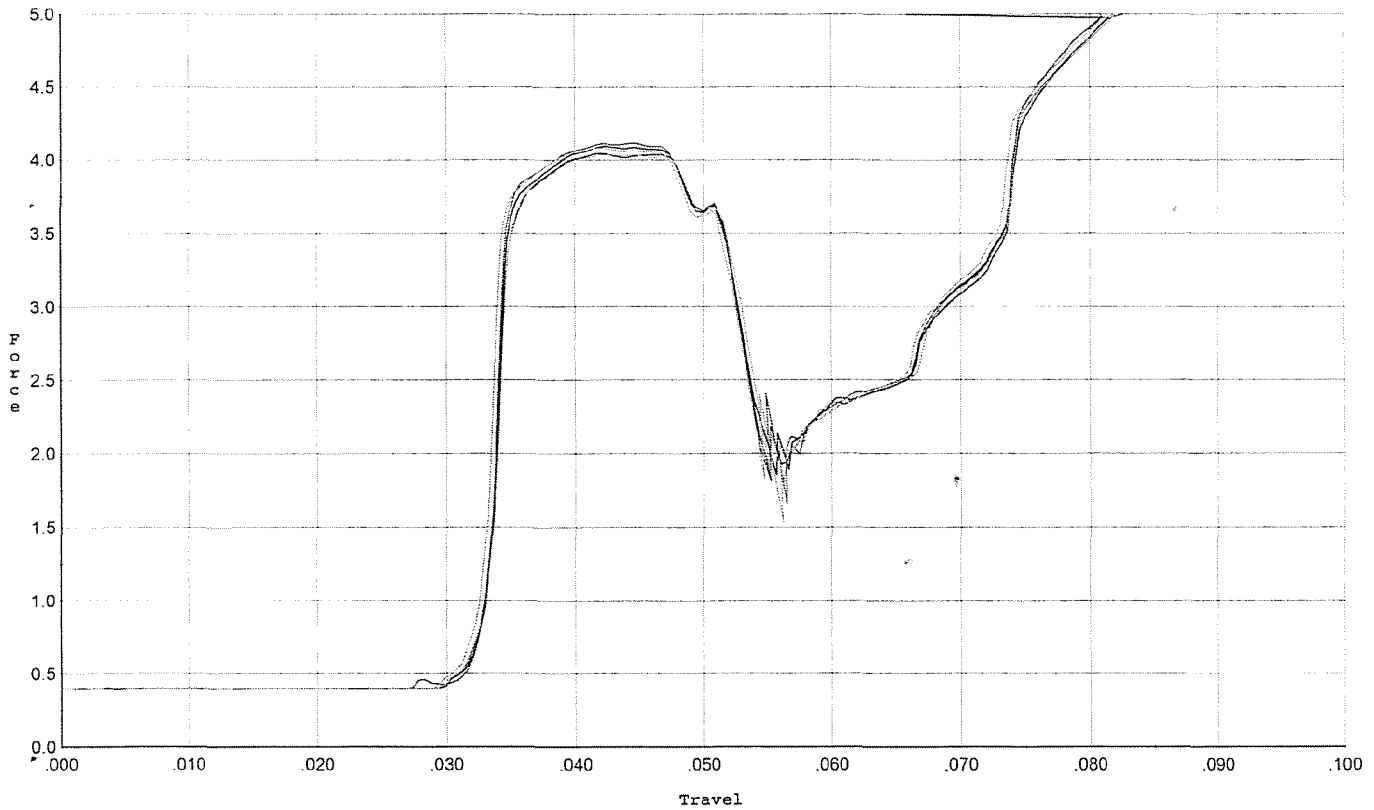
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.988	0.053	0.034	0.036	0.065		Set Trigger
2	2.990	0.053	0.034	0.036	0.064		Set Trigger
3	2.951	0.053	0.031	0.036	0.063		Set Trigger
4	2.961	0.052	0.033	0.036	0.063		Set Trigger
5	3.009	0.053	0.031	0.036	0.065		Set Trigger

Avg 2.98

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



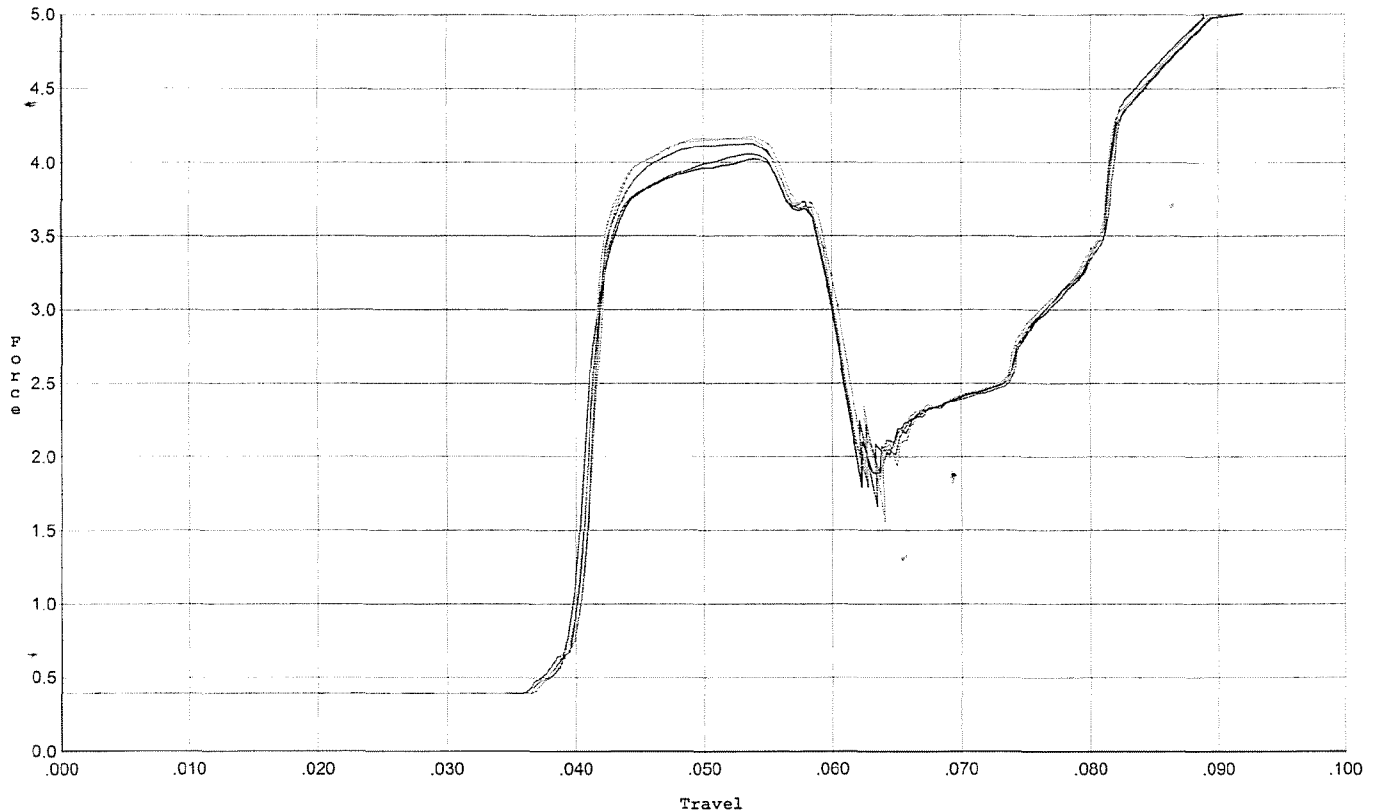
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.046	0.052	0.032	0.034	0.085		Set Trigger
2	4.093	0.052	0.032	0.034	0.085		Set Trigger
3	4.114	0.052	0.032	0.034	0.086		Set Trigger
4	4.036	0.053	0.032	0.034	0.087		Set Trigger
5	4.081	0.052	0.032	0.034	0.087		Set Trigger

Aug 4.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



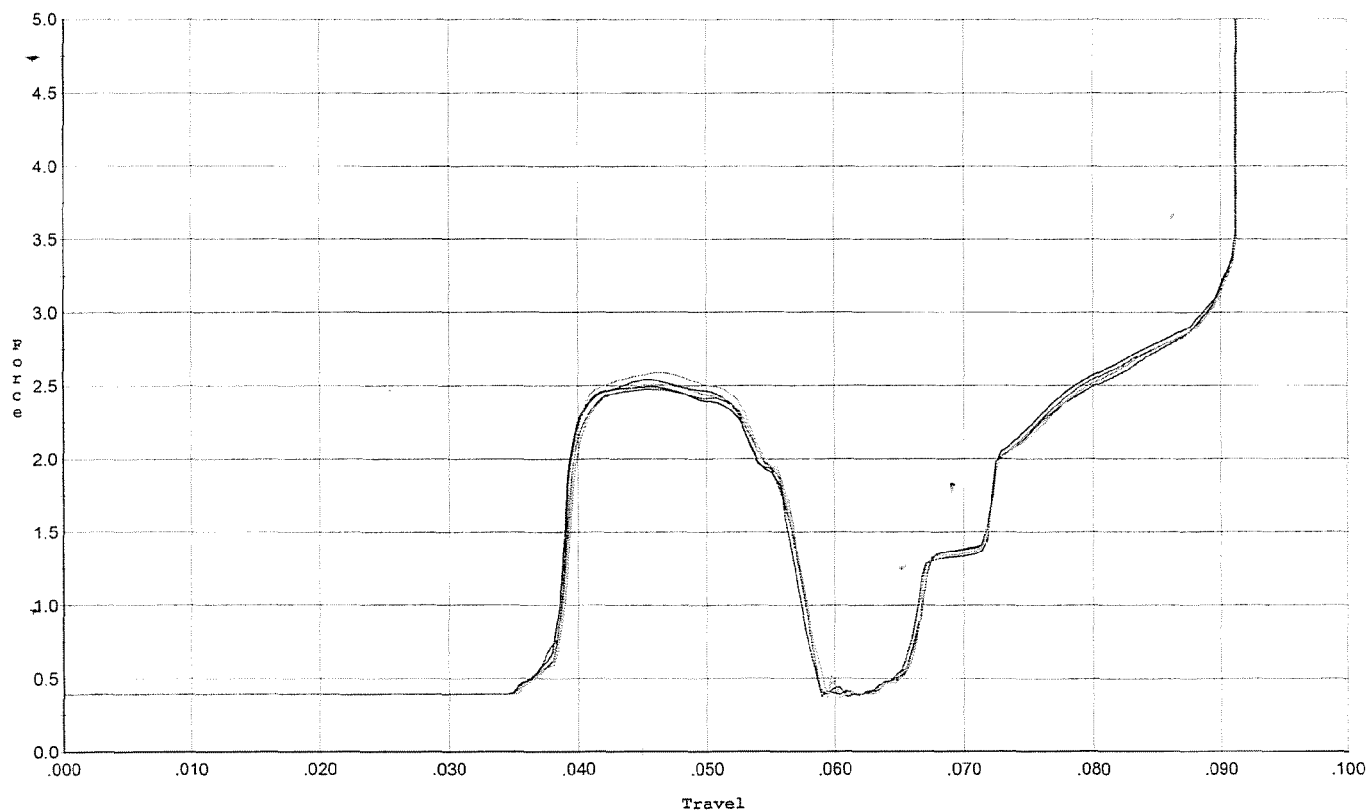
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.059	0.060	0.039	0.037	0.090		Set Trigger
2	4.023	0.060	0.039	0.037	0.089		Set Trigger
3	4.127	0.059	0.039	0.037	0.090		Set Trigger
4	4.161	0.059	0.037	0.037	0.091		Set Trigger
5	4.177	0.060	0.039	0.037	0.093		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



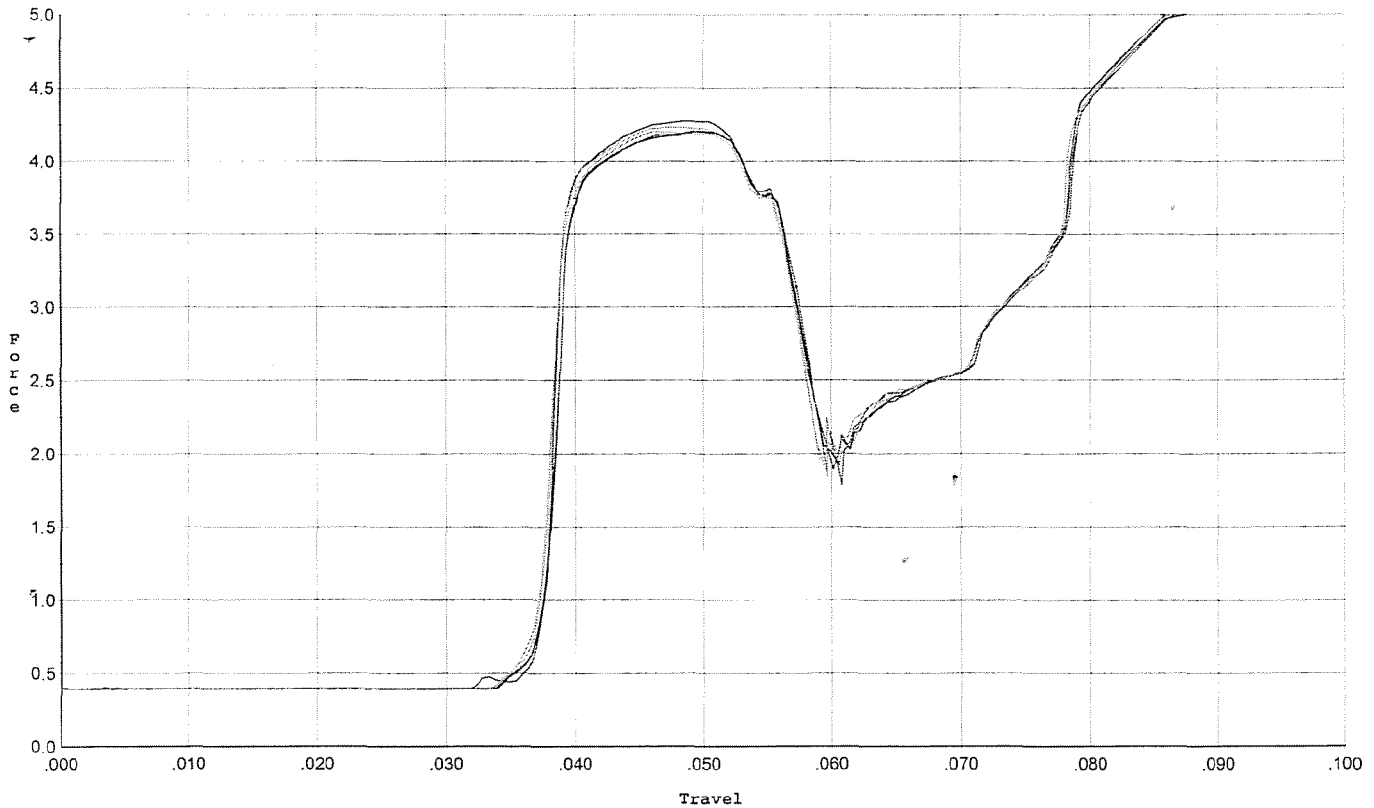
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.542	0.056	0.037	0.039	0.056		Set Trigger
2	2.493	0.057	0.038	0.039	0.057		Set Trigger
3	2.475	0.057	0.038	0.039	0.056		Set Trigger
4	2.592	0.056	0.038	0.039	0.057		Set Trigger
5	2.512	0.057	0.038	0.039	0.056		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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	4.273	0.056	0.037	0.037	0.090		Set Trigger
2	4.204	0.056	0.037	0.037	0.088		Set Trigger
3	4.200	0.057	0.037	0.037	0.091		Set Trigger
4	4.231	0.056	0.034	0.037	0.090		Set Trigger
5	4.199	0.056	0.036	0.037	0.090		Set Trigger

Avg 4.22