

56784668

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



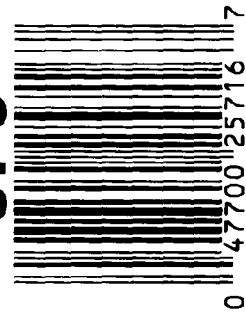
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6784668

UPC



GUN SERIAL # G 6784668

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA FLUX OCT 01 2008 OPERATOR 	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		9-30-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	
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 2	
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		10-30-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

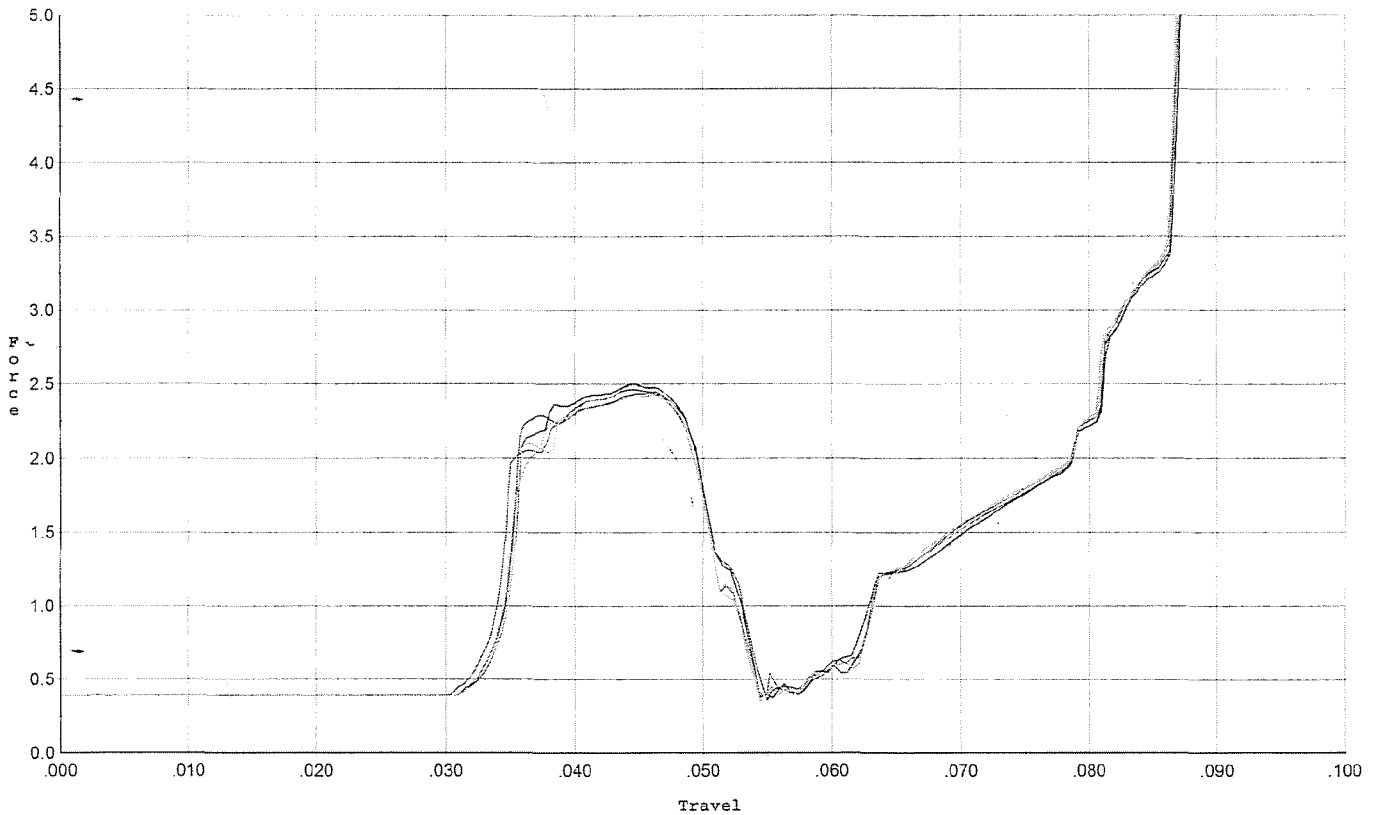
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-13-08	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.5</u>	11-13-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	L.N.
	J) ASSEMBLE STOCK		10-30-08	L.N.
	K) ASSEMBLE SWIVEL STUDS		11-13-08	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		11-13-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u> <u>2.33</u> <u>2.37</u> <u>2.47</u> <u>2.46</u>	11-6-08	TC
	C) FUNCTION		11-13-08	L.N.
690	PACK		11/14/08	F.N.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/28/08

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



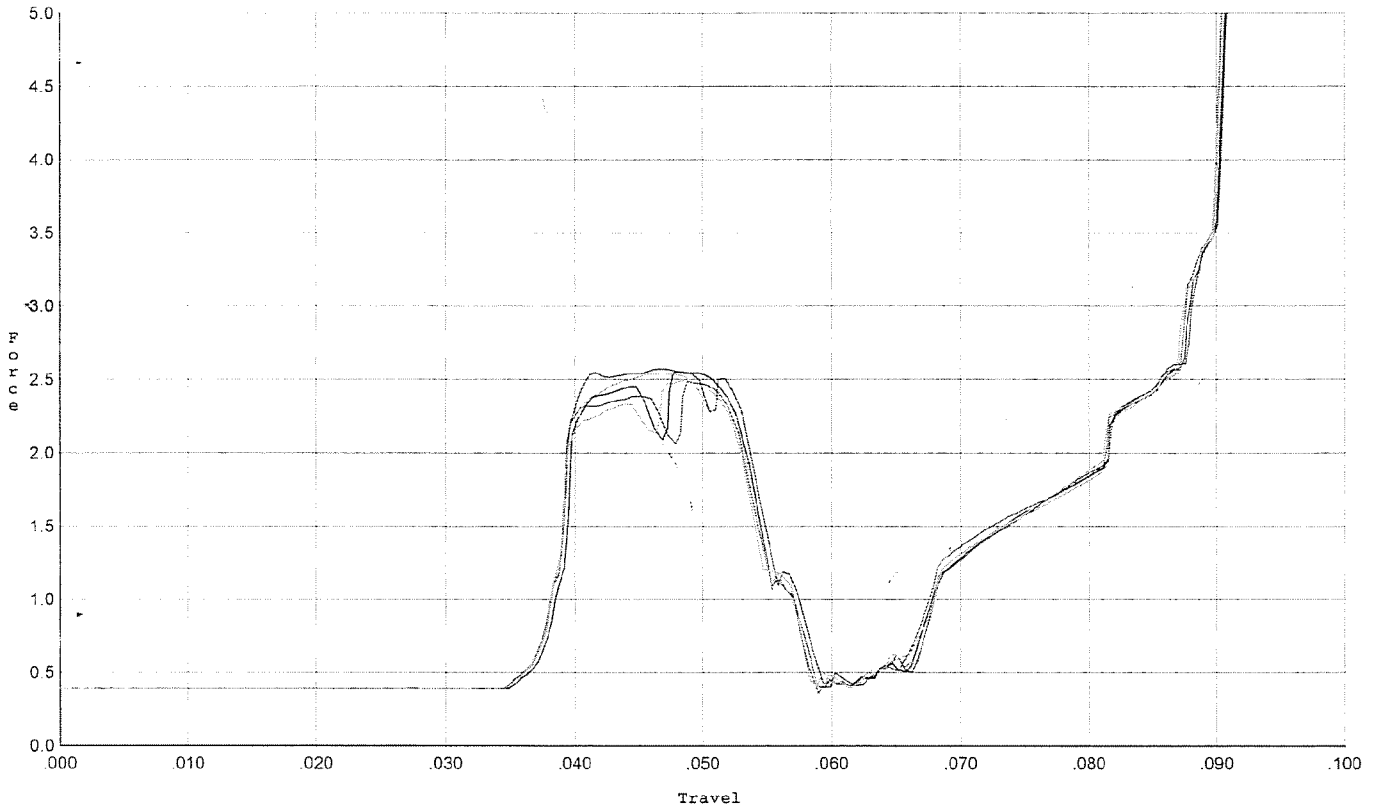
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.463	0.049	0.033	0.041	0.049		Set Trigger
2	2.499	0.049	0.033	0.041	0.049		Set Trigger
3	2.441	0.050	0.033	0.041	0.049		Set Trigger
4	2.488	0.050	0.033	0.040	0.049		Set Trigger
5	2.423	0.050	0.033	0.041	0.048		Set Trigger

Avg. 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/28/08

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



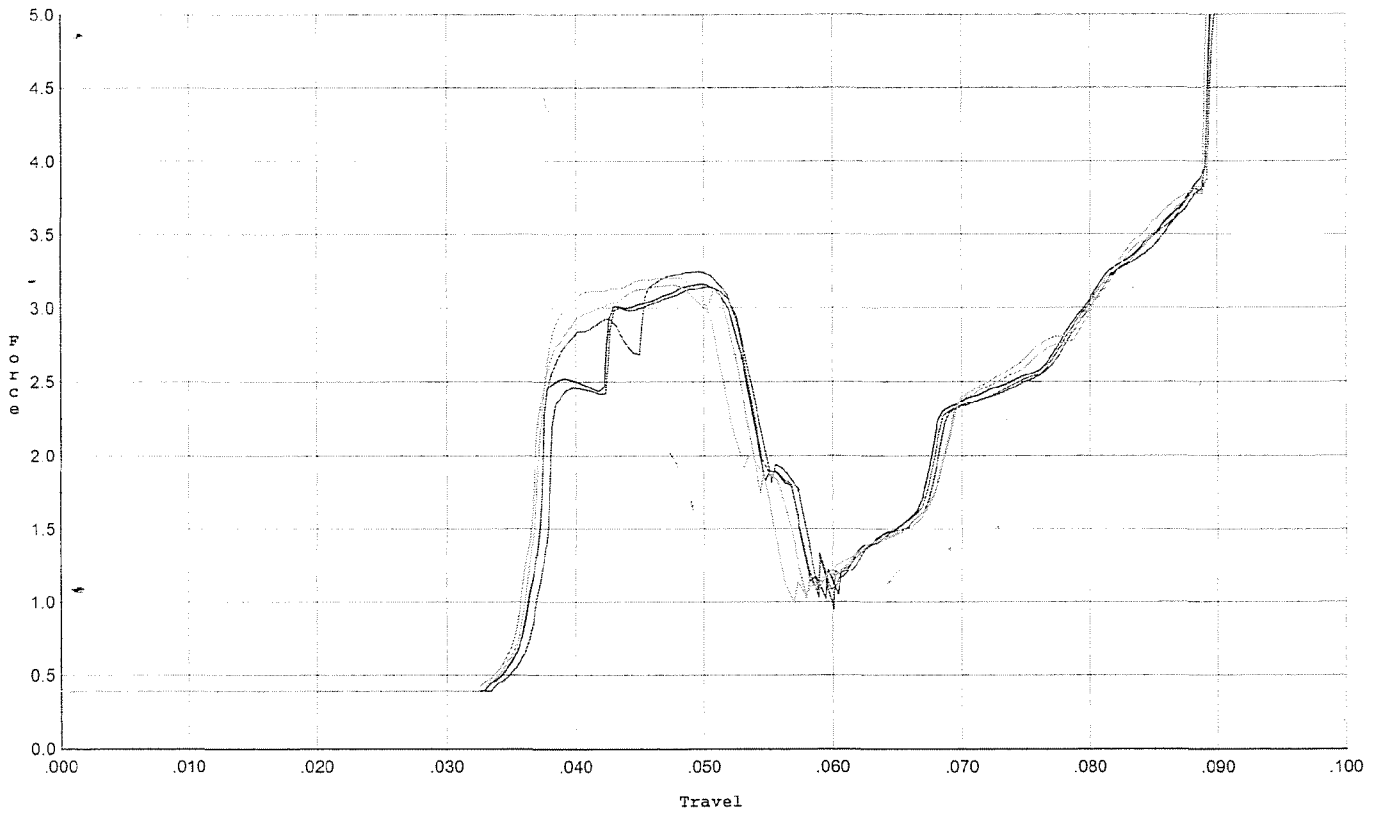
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.053	0.037	0.040	0.052		Set Trigger
2	2.553	0.054	0.038	0.041	0.051		Set Trigger
3	2.484	0.053	0.037	0.040	0.049		Set Trigger
4	2.493	0.053	0.037	0.041	0.049		Set Trigger
5	2.539	0.054	0.037	0.040	0.052		Set Trigger

Aug 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



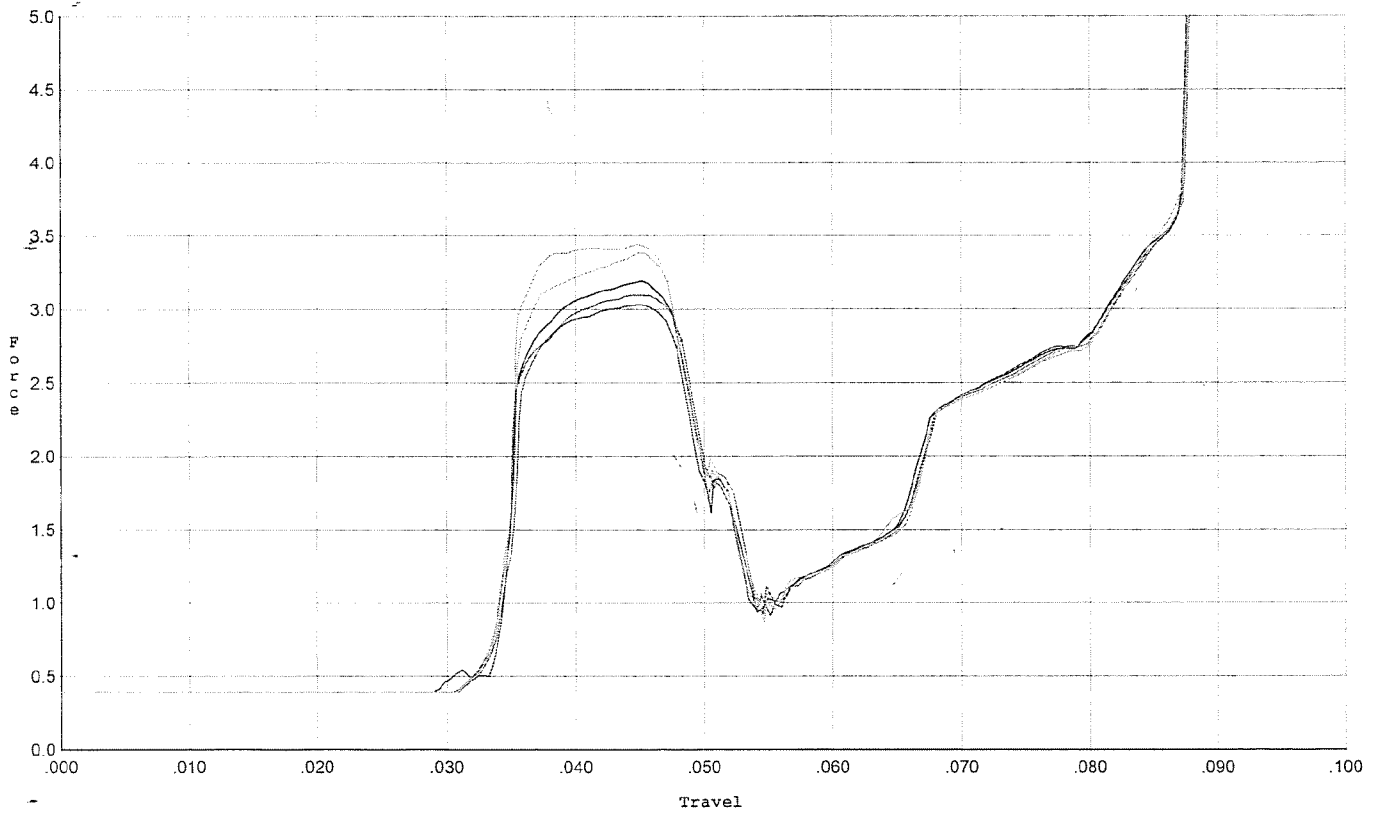
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.143	0.057	0.036	0.038	0.068		Set Trigger
2	3.162	0.053	0.035	0.039	0.062		Set Trigger
3	3.247	0.053	0.035	0.038	0.063		Set Trigger
4	3.202	0.055	0.035	0.038	0.066		Set Trigger
5	3.155	0.052	0.035	0.038	0.064		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



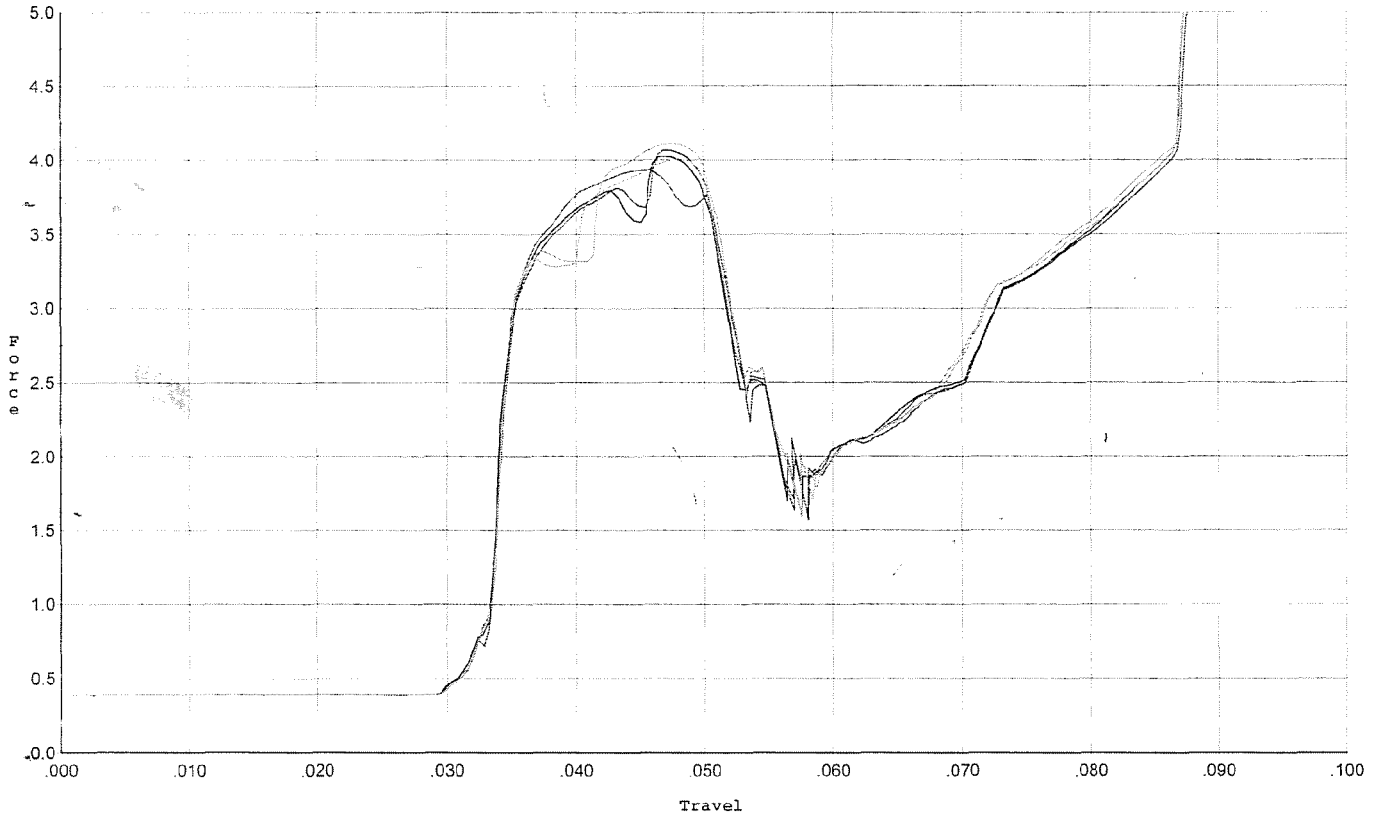
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.032	0.048	0.034	0.041	0.054		Set Trigger
2	3.192	0.049	0.033	0.040	0.057		Set Trigger
3	3.095	0.048	0.033	0.040	0.055		Set Trigger
4	3.386	0.049	0.033	0.040	0.059		Set Trigger
5	3.441	0.047	0.033	0.040	0.058		Set Trigger

Aug 3.22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



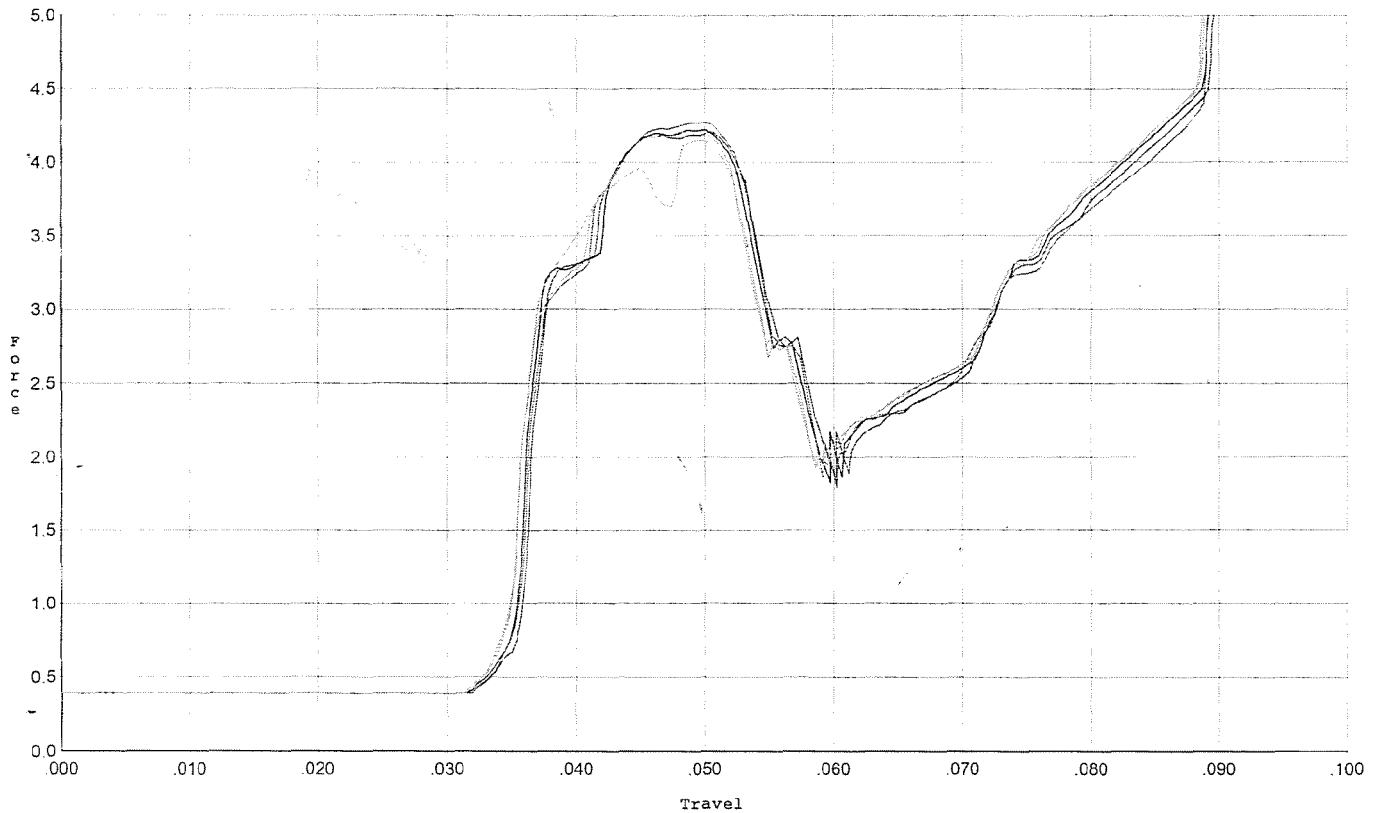
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.069	0.052	0.032	0.036	0.079		Set Trigger
2	4.024	0.050	0.032	0.036	0.077		Set Trigger
3	3.939	0.050	0.032	0.036	0.077		Set Trigger
4	4.011	0.050	0.032	0.036	0.076		Set Trigger
5	4.109	0.051	0.032	0.036	0.079		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/28/08

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



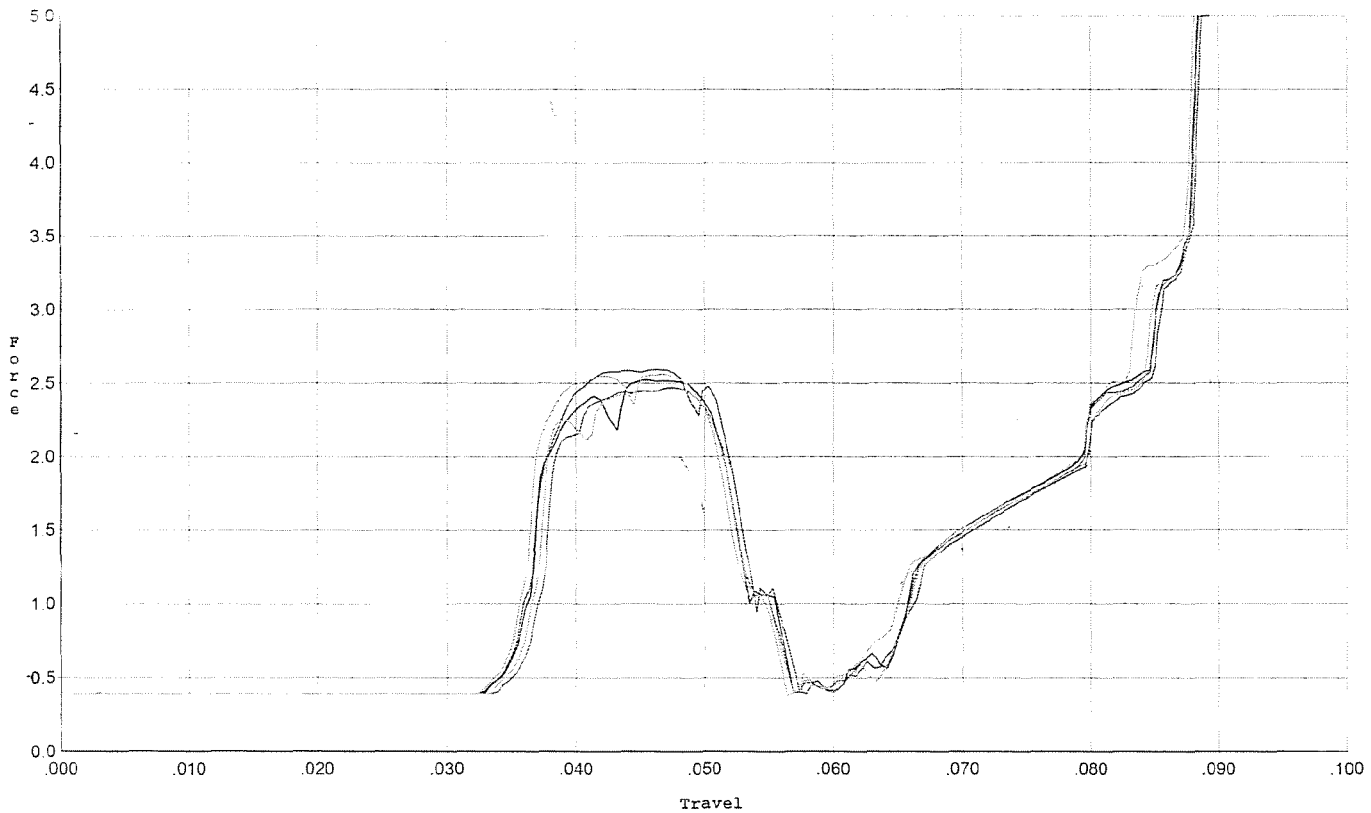
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.207	0.053	0.034	0.037	0.082		Set Trigger
2	4.219	0.053	0.034	0.037	0.081		Set Trigger
3	4.269	0.053	0.034	0.037	0.083		Set Trigger
4	4.150	0.052	0.034	0.036	0.079		Set Trigger
5	4.214	0.053	0.034	0.036	0.083		Set Trigger

AUG 4.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/28/08

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



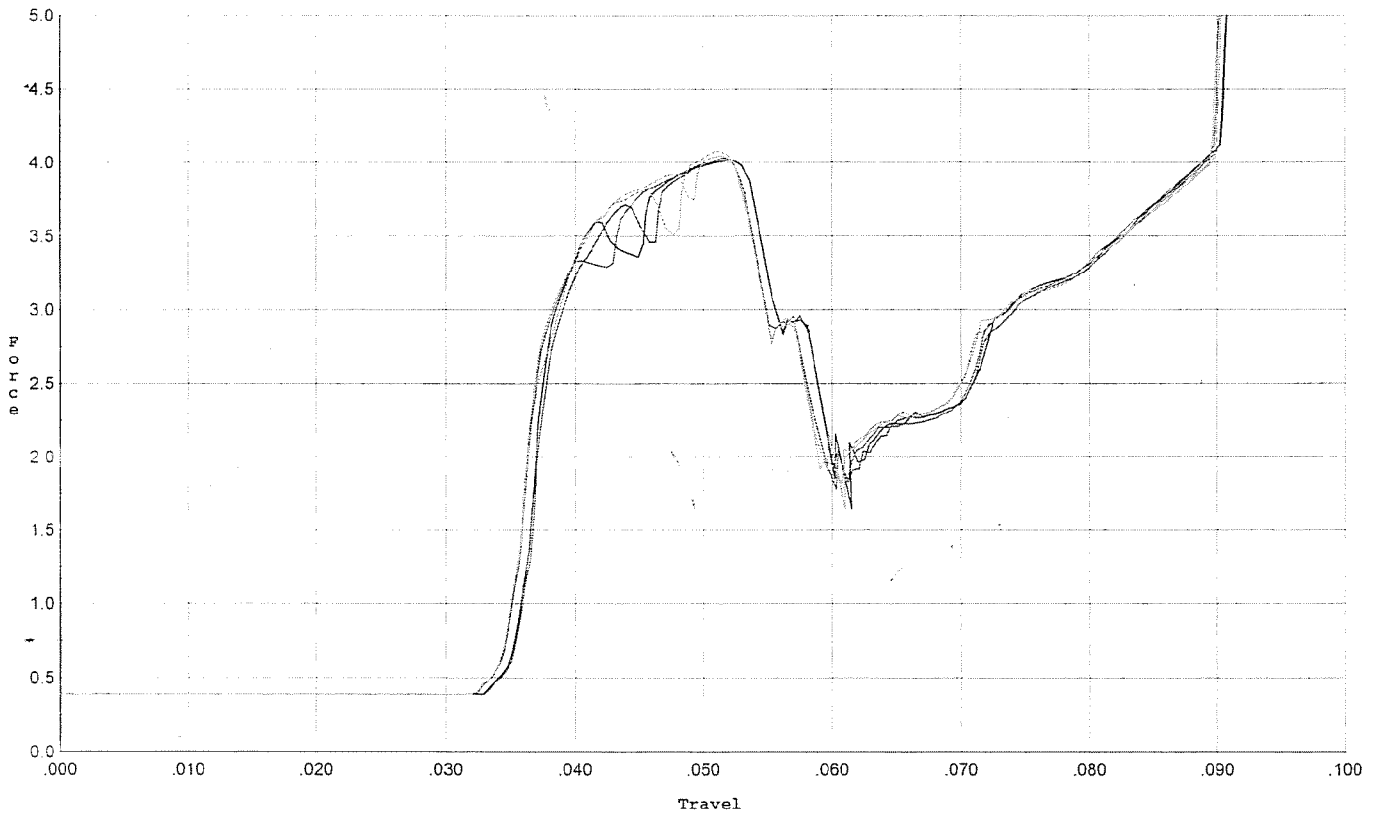
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.052	0.035	0.040	0.053		Set Trigger
2	2.520	0.051	0.035	0.040	0.050		Set Trigger
3	2.473	0.051	0.036	0.041	0.048		Set Trigger
4	2.464	0.051	0.036	0.041	0.049		Set Trigger
5	2.563	0.051	0.035	0.040	0.051		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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	4.018	0.058	0.035	0.036	0.090		Set Trigger
2	4.018	0.058	0.035	0.036	0.090		Set Trigger
3	4.026	0.053	0.034	0.037	0.079		Set Trigger
4	4.043	0.057	0.034	0.036	0.089		Set Trigger
5	4.072	0.053	0.034	0.037	0.080		Set Trigger

Aug 4.03