

G6784673

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



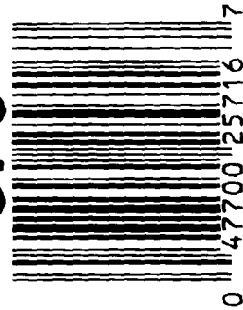
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6784673

UPC



GUN SERIAL # G 6784673

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-27-08	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		9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		9-30-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	RB
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 9	
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

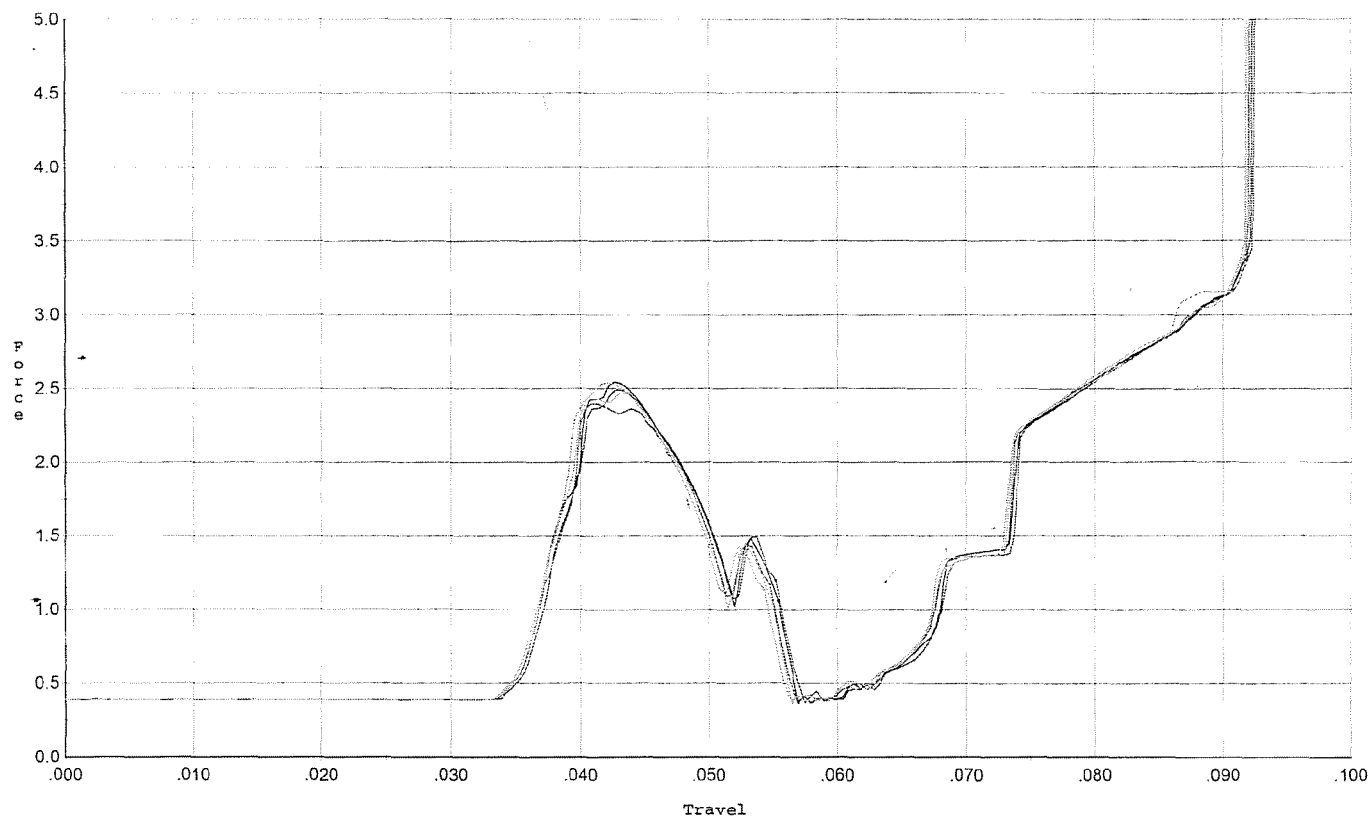
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-6-08	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-6-08	R. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-6-08	R. J.
	J) ASSEMBLE STOCK		10-30-08	L. J.
	K) ASSEMBLE SWIVEL STUDS		11-5-08	L. J.
	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. J.
670	FINAL INSPECTION A) HEADSPACE		11-6-08	R. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u> <u>2.22</u> <u>2.31</u> <u>2.20</u> <u>2.16</u>	11-5-08	FM
	C) FUNCTION		11-6-08	R. J.
690	PACK		11/7/08	FM

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.



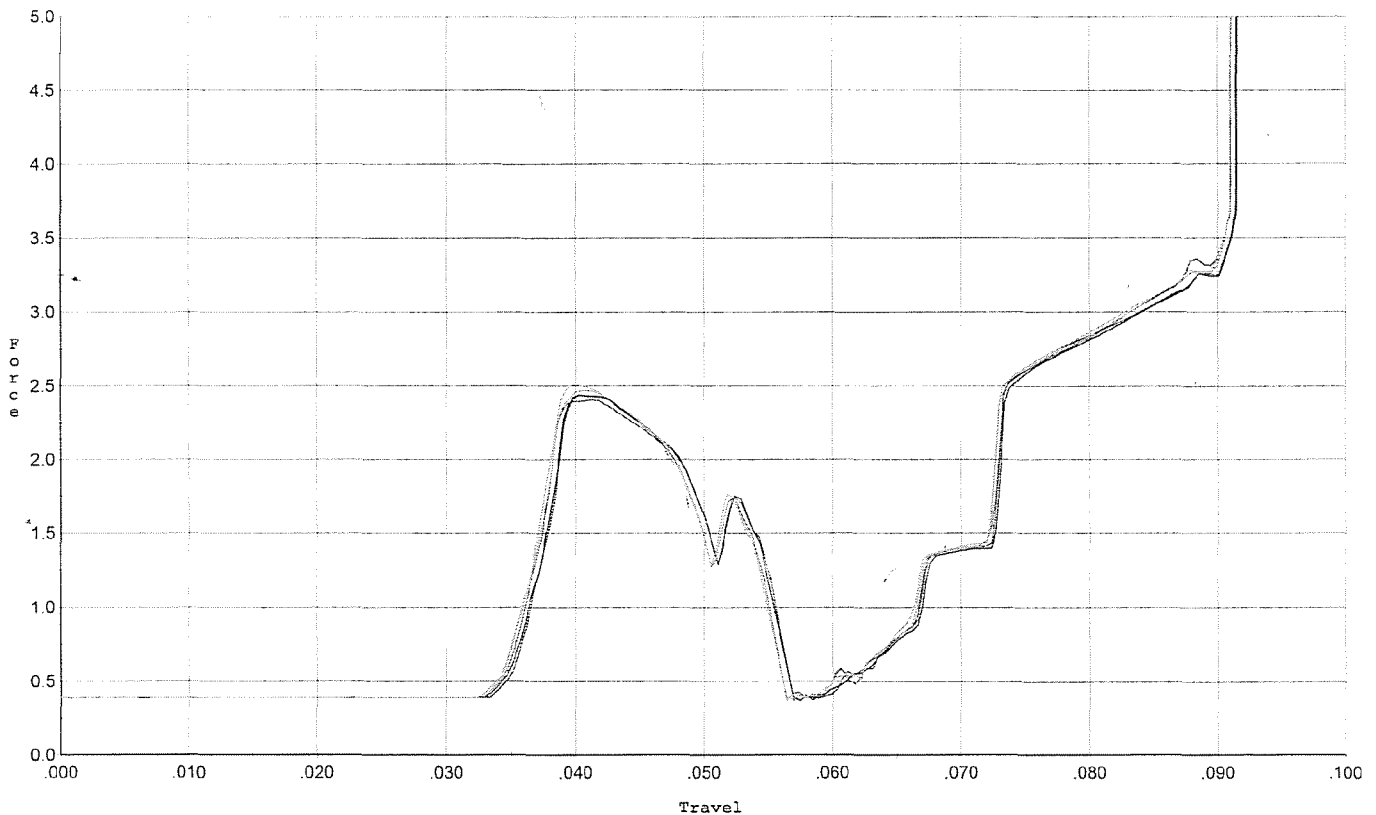
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.055	0.036	0.041	0.048		Set Trigger
2	2.549	0.055	0.036	0.041	0.049		Set Trigger
3	2.397	0.055	0.036	0.041	0.047		Set Trigger
4	2.480	0.055	0.035	0.041	0.048		Set Trigger
5	2.542	0.054	0.036	0.042	0.048		Set Trigger

Avg 2.49

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.



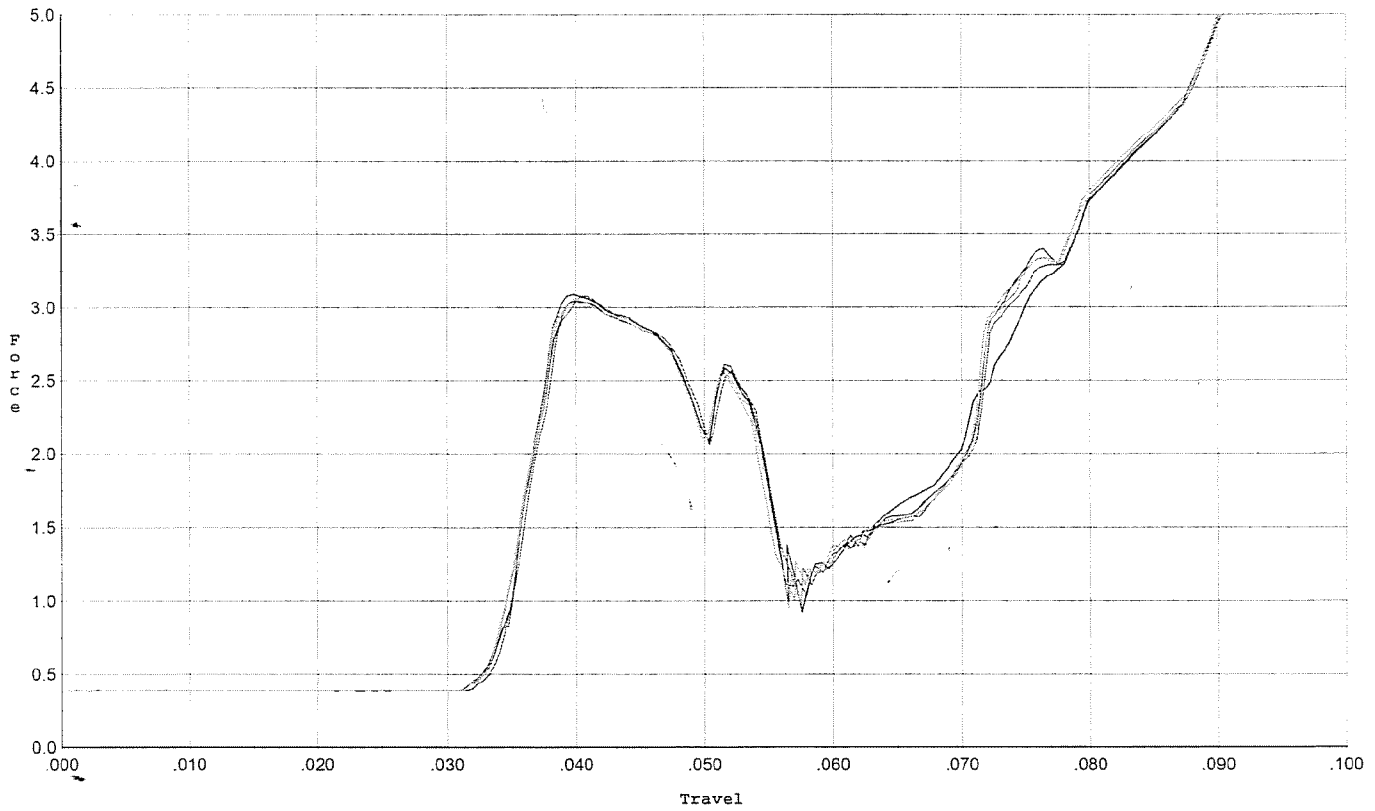
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.439	0.055	0.035	0.040	0.051		Set Trigger
2	2.440	0.056	0.035	0.040	0.051		Set Trigger
3	2.406	0.055	0.035	0.040	0.050		Set Trigger
4	2.507	0.055	0.035	0.040	0.051		Set Trigger
5	2.471	0.055	0.035	0.040	0.051		Set Trigger

Avg 2.45

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.



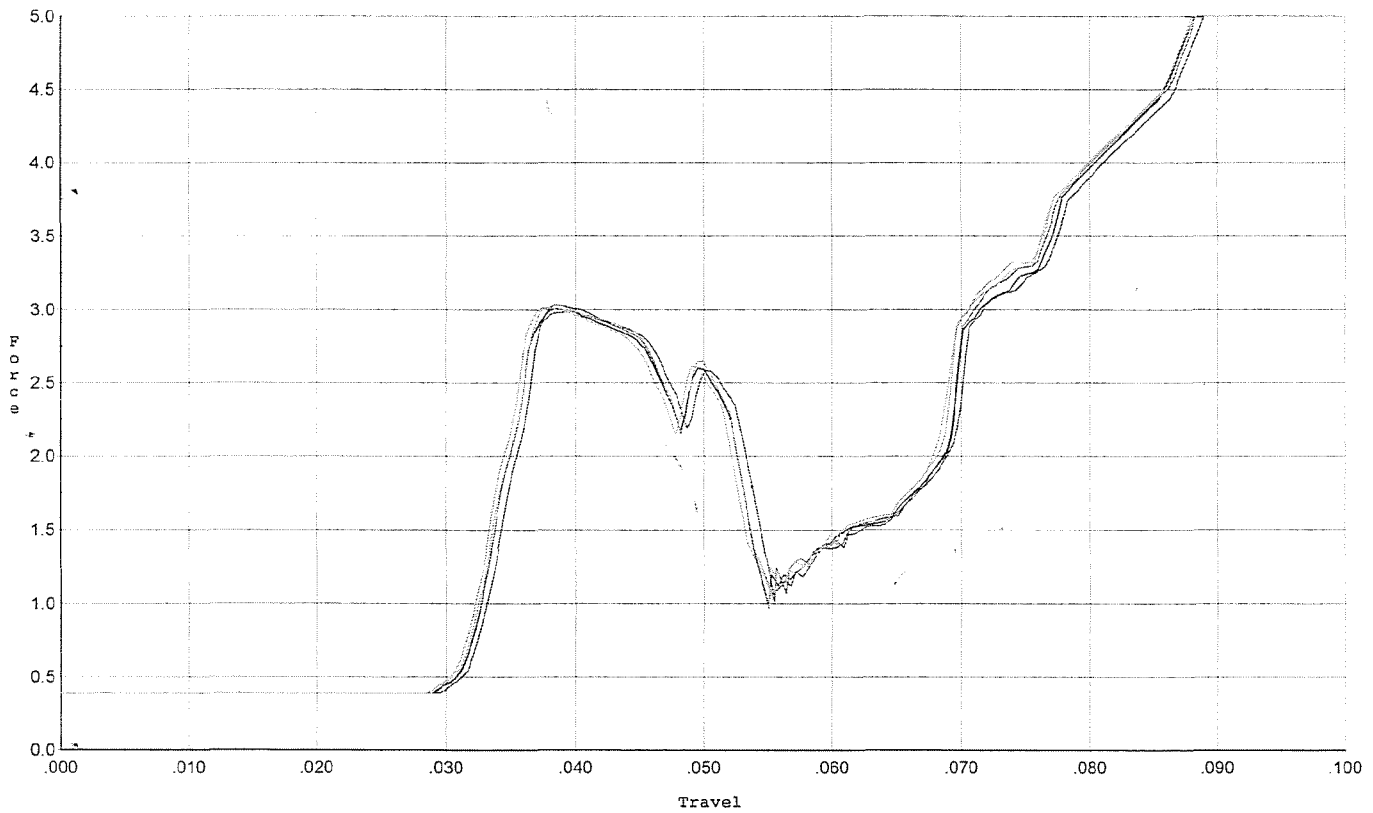
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.091	0.054	0.033	0.038	0.065		Set Trigger
2	3.043	0.054	0.034	0.038	0.064		Set Trigger
3	3.075	0.054	0.034	0.038	0.064		Set Trigger
4	3.055	0.055	0.034	0.038	0.064		Set Trigger
5	3.050	0.054	0.033	0.038	0.063		Set Trigger

Avg 3.06

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.



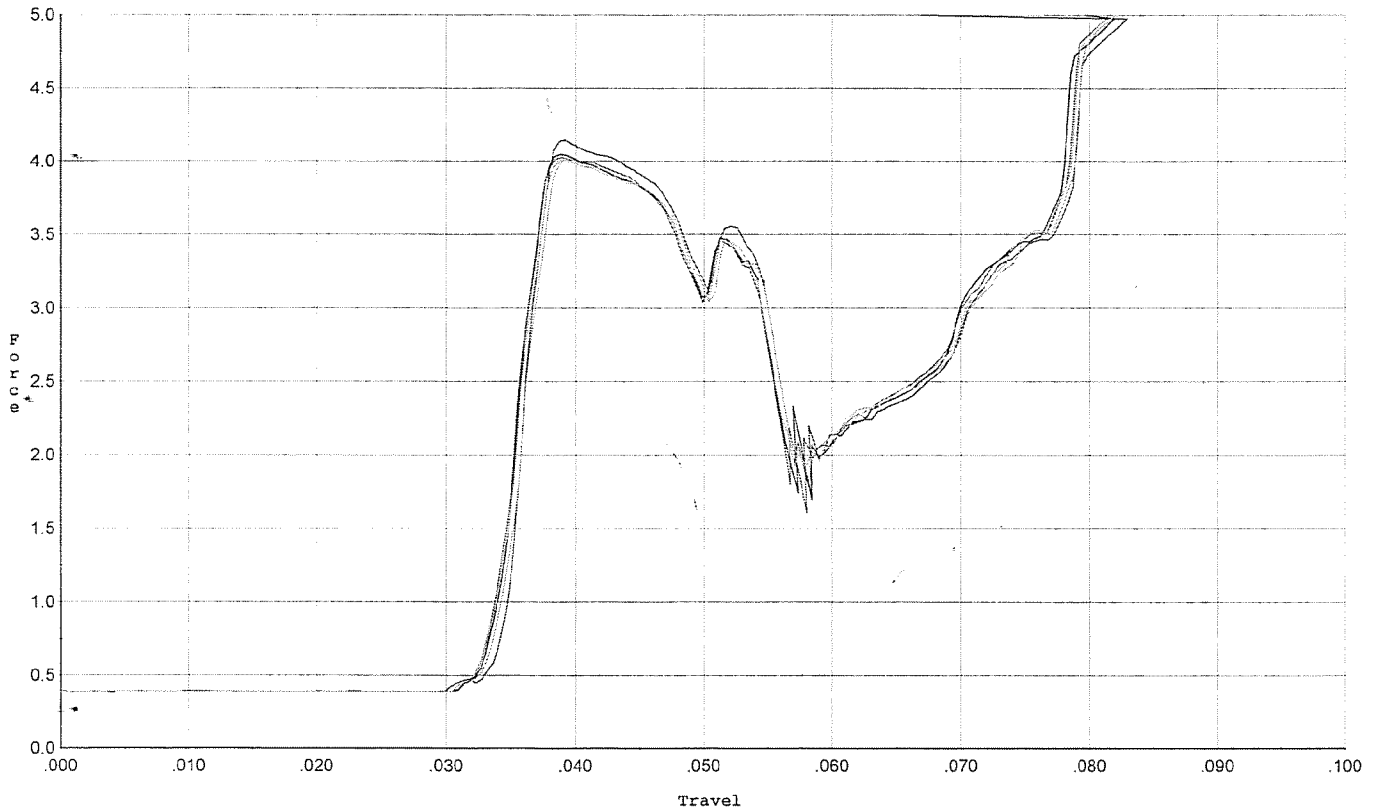
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.034	0.054	0.032	0.038	0.065		Set Trigger
2	3.006	0.052	0.032	0.038	0.063		Set Trigger
3	2.993	0.052	0.032	0.038	0.063		Set Trigger
4	3.013	0.052	0.031	0.038	0.064		Set Trigger
5	3.009	0.051	0.031	0.038	0.063		Set Trigger

Avg 3.01

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.



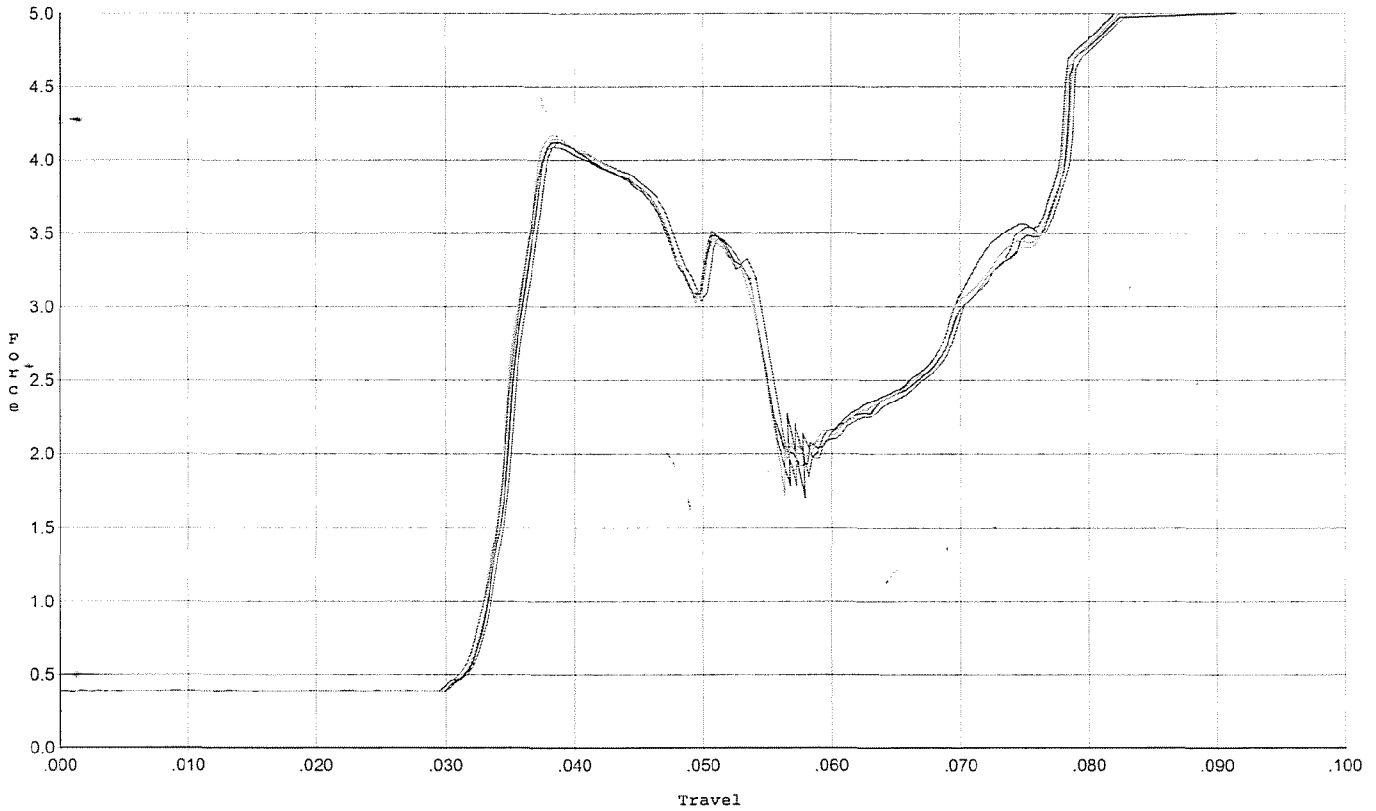
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.147	0.055	0.033	0.036	0.086		Set Trigger
2	4.048	0.054	0.033	0.036	0.084		Set Trigger
3	4.024	0.054	0.033	0.036	0.085		Set Trigger
4	4.010	0.054	0.033	0.036	0.084		Set Trigger
5	4.007	0.055	0.033	0.036	0.085		Set Trigger

Aug 4.04

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.



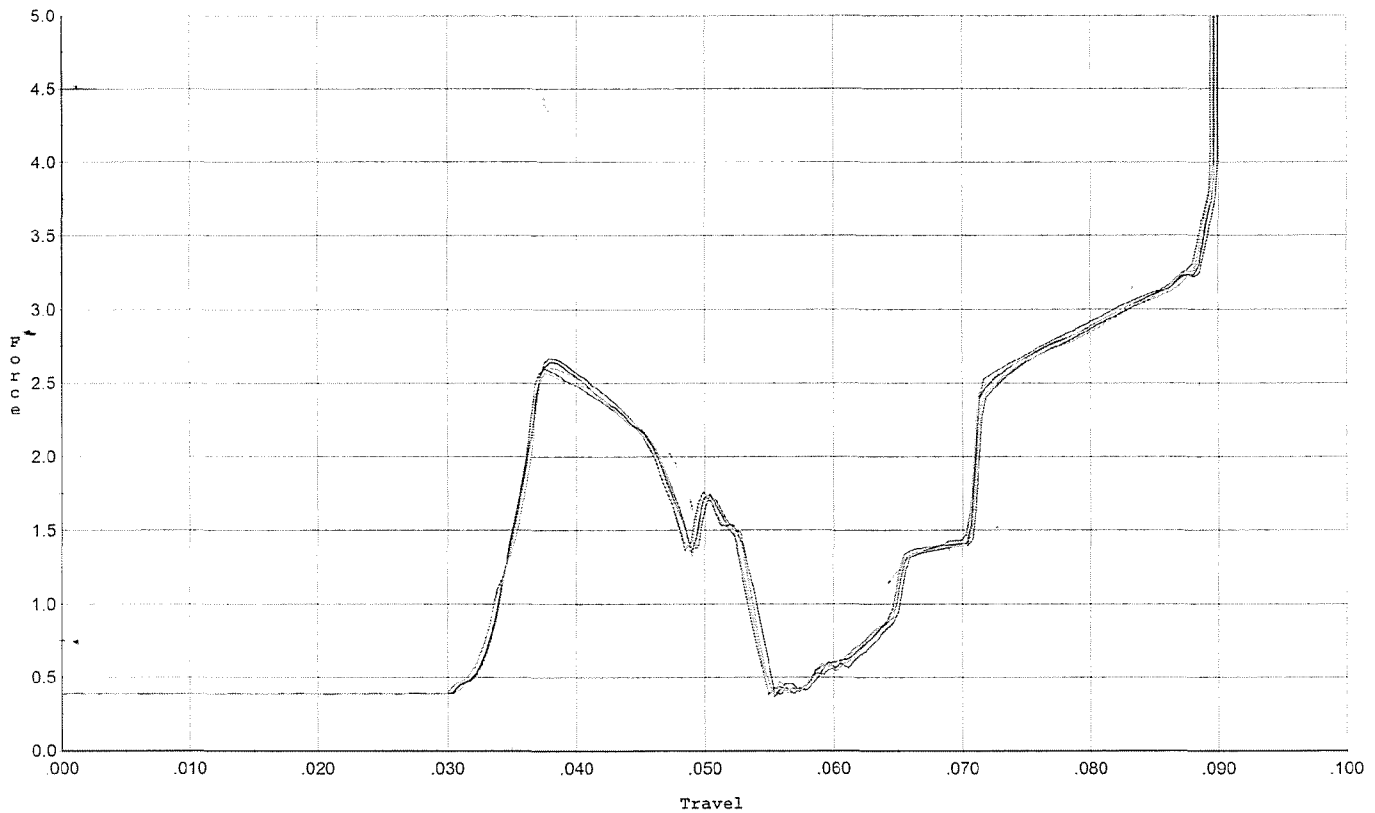
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.054	0.032	0.036	0.085		Set Trigger
2	4.123	0.054	0.032	0.036	0.084		Set Trigger
3	4.120	0.054	0.032	0.036	0.085		Set Trigger
4	4.142	0.054	0.032	0.036	0.085		Set Trigger
5	4.170	0.054	0.032	0.036	0.086		Set Trigger

Aug 4.12

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



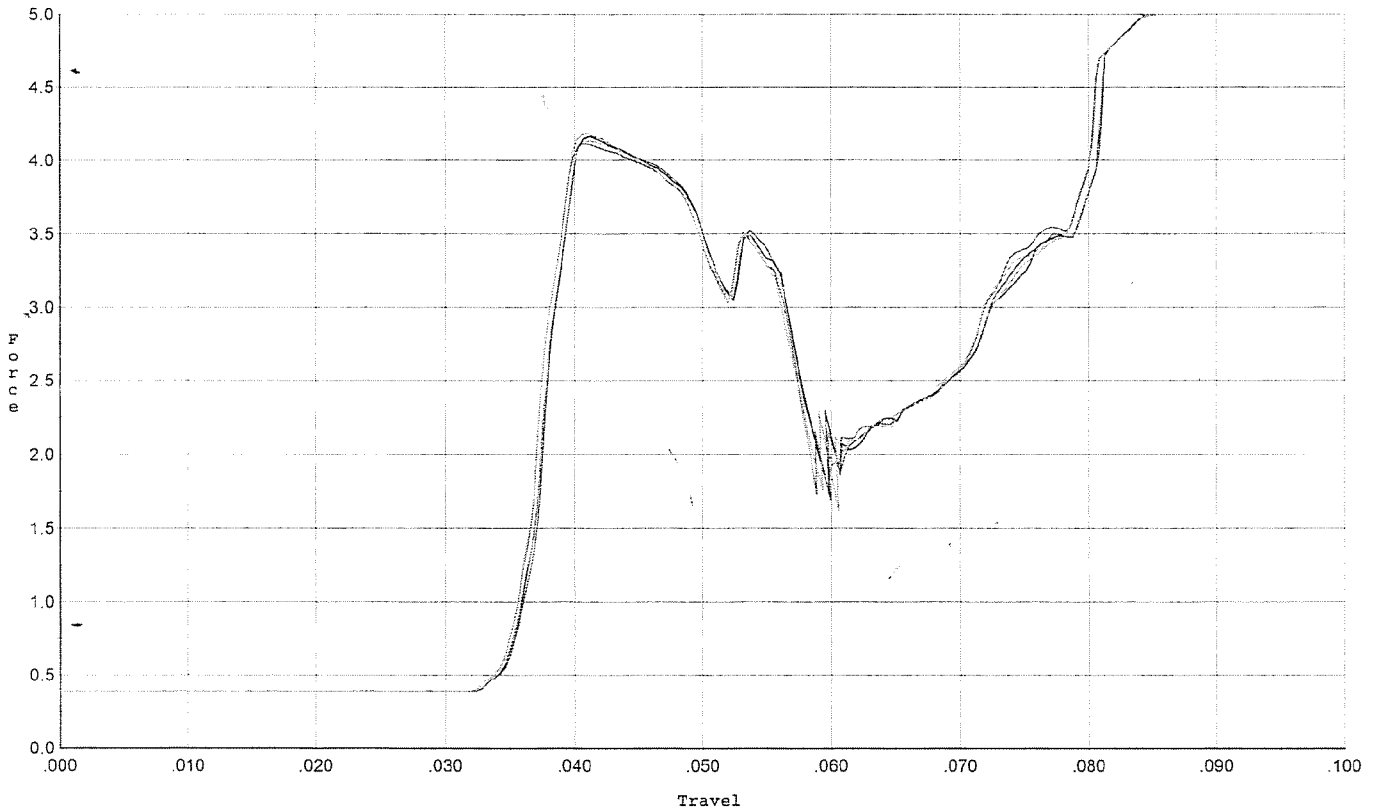
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.669	0.054	0.033	0.040	0.053		Set Trigger
2	2.642	0.053	0.033	0.040	0.052		Set Trigger
3	2.599	0.052	0.033	0.041	0.051		Set Trigger
4	2.566	0.053	0.033	0.040	0.052		Set Trigger
5	2.603	0.053	0.033	0.040	0.051		Set Trigger

AVG 2.61

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	4.166	0.056	0.035	0.037	0.086		Set Trigger
2	4.164	0.056	0.035	0.037	0.086		Set Trigger
3	4.115	0.056	0.035	0.037	0.087		Set Trigger
4	4.179	0.057	0.035	0.037	0.088		Set Trigger
5	4.133	0.056	0.035	0.037	0.086		Set Trigger

Avg 4.15