

56784725

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

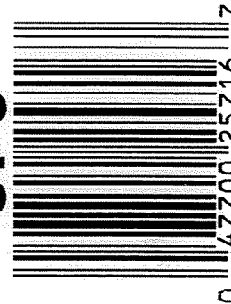
24"

CAPACITY

6

G6784725

UPC



GUN SERIAL #

G 6784725

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		9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		10/1/08	FM
480	MAGNAFLUX BBL ACTION		10/2/08	SP
490	MAGNAFLUX BOLT		10/2/08	MR
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

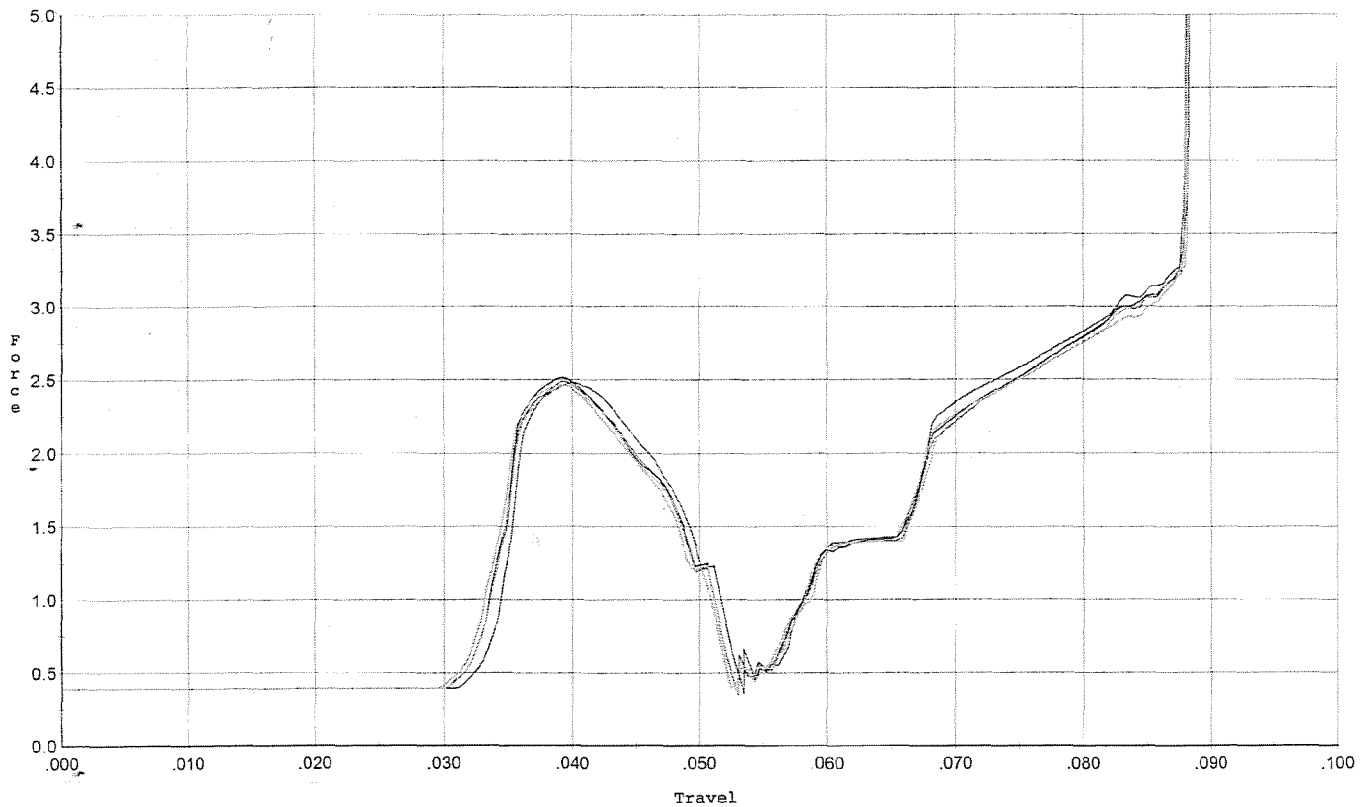
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>3.0</u>	11-13-08	L, D
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	11-13-08	L, D
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	L, D
	J) ASSEMBLE STOCK		11-13-08	L, D
	K) ASSEMBLE SWIVEL STUDS		11-13-08	L, D
	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	L, D
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-13-08	L, D
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.40</u> <u>2.43</u> <u>2.46</u> <u>2.42</u>	11-6-08	TC
	C) FUNCTION		11-13-08	L, D
690	PACK		11/14/08	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.



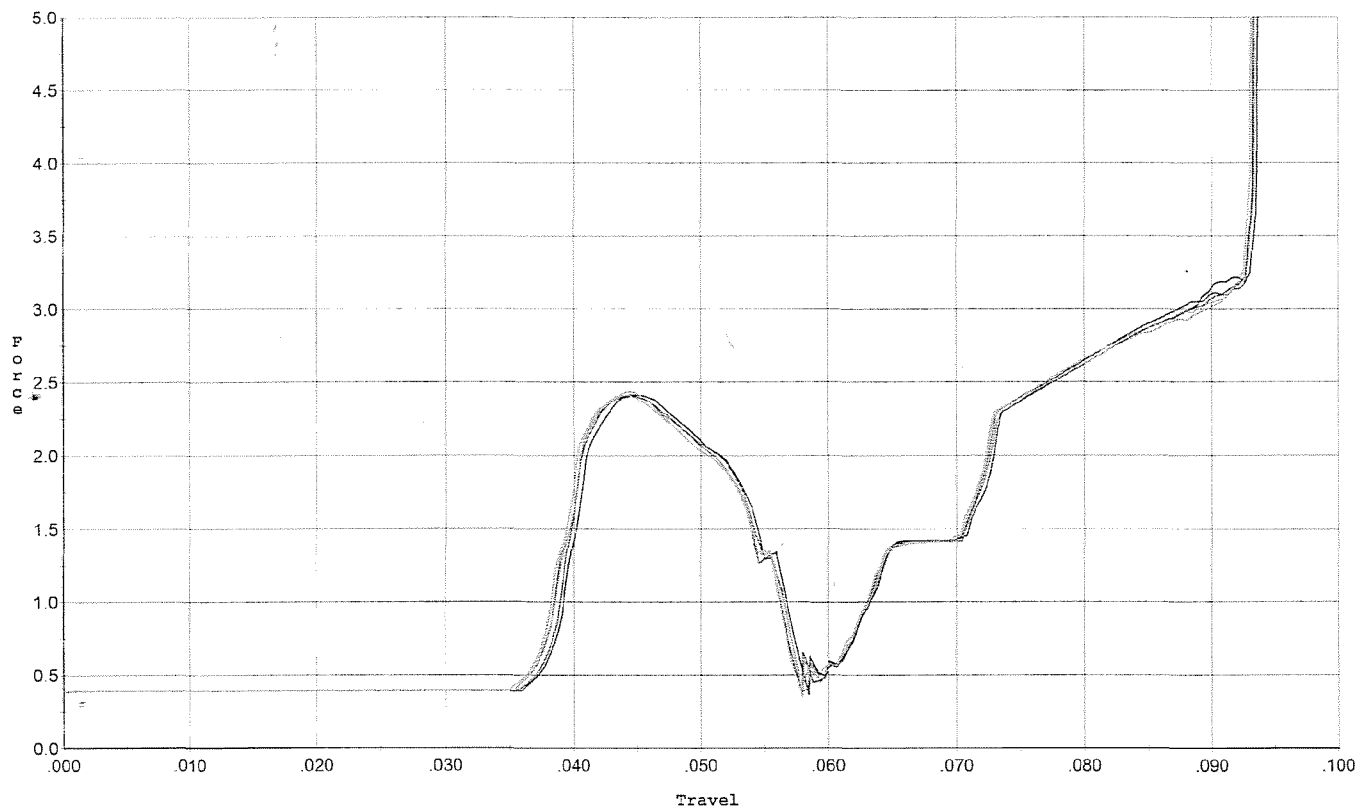
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.482	0.051	0.033	0.041	0.048		Set Trigger
2	2.516	0.051	0.032	0.041	0.048		Set Trigger
3	2.488	0.051	0.032	0.041	0.047		Set Trigger
4	2.464	0.051	0.032	0.042	0.047		Set Trigger
5	2.469	0.051	0.032	0.041	0.048		Set Trigger

Aug 2.48

Trigger Profile [lbs,inch]

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

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



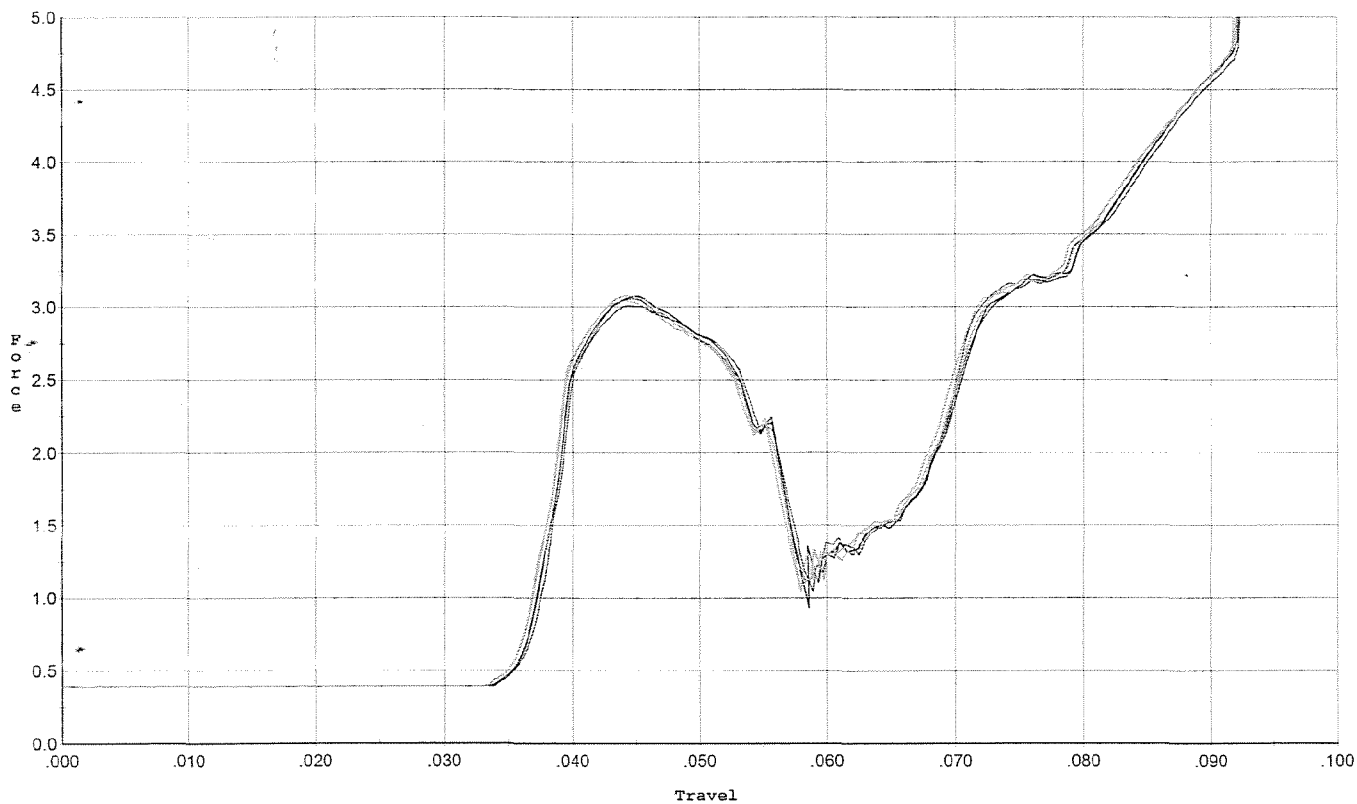
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.401	0.056	0.038	0.042	0.049		Set Trigger
2	2.411	0.056	0.038	0.042	0.050		Set Trigger
3	2.414	0.056	0.037	0.042	0.051		Set Trigger
4	2.410	0.055	0.037	0.042	0.050		Set Trigger
5	2.435	0.056	0.037	0.042	0.050		Set Trigger

Avg 2.41

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.



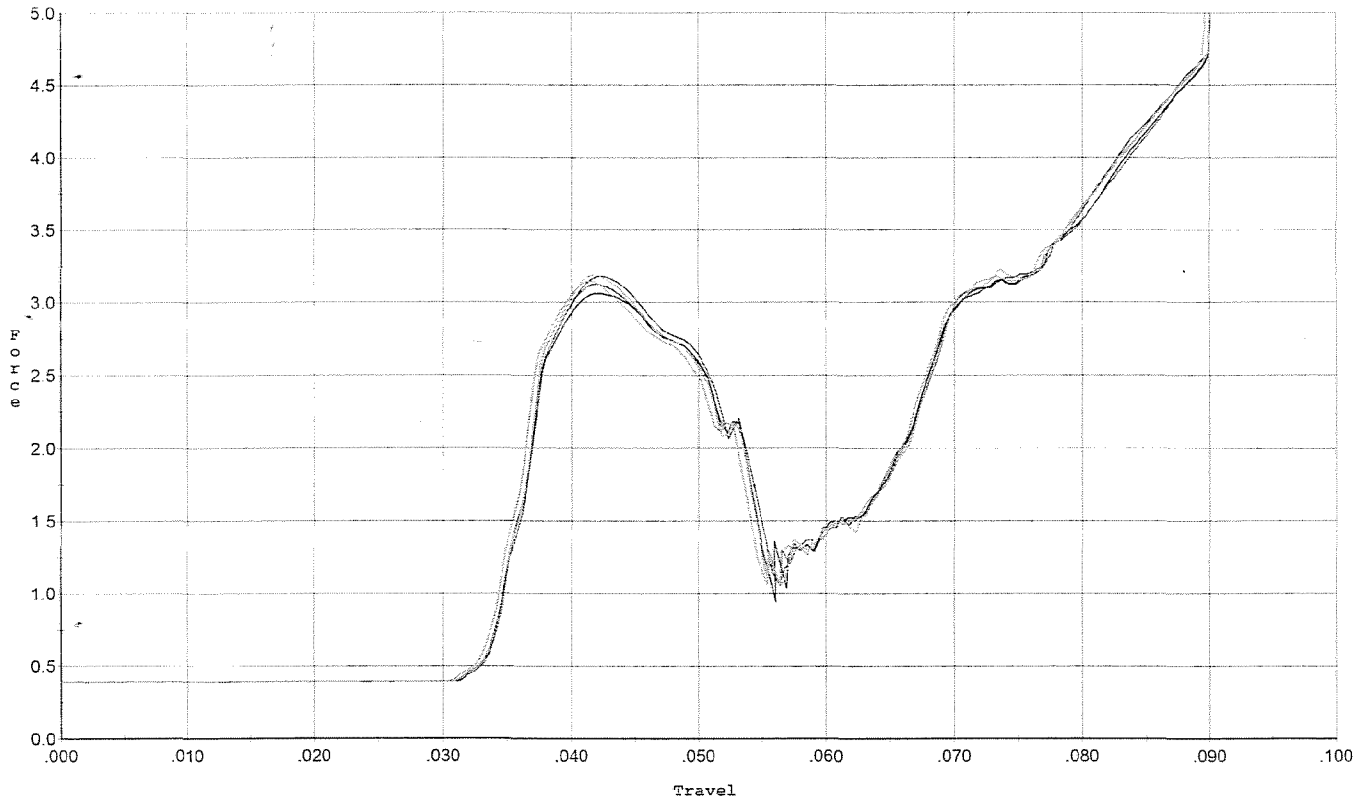
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.009	0.056	0.036	0.040	0.063		Set Trigger
2	3.074	0.056	0.036	0.039	0.064		Set Trigger
3	3.058	0.056	0.036	0.039	0.064		Set Trigger
4	3.040	0.055	0.036	0.039	0.063		Set Trigger
5	3.080	0.056	0.036	0.039	0.065		Set Trigger

Aug. 3.05

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.



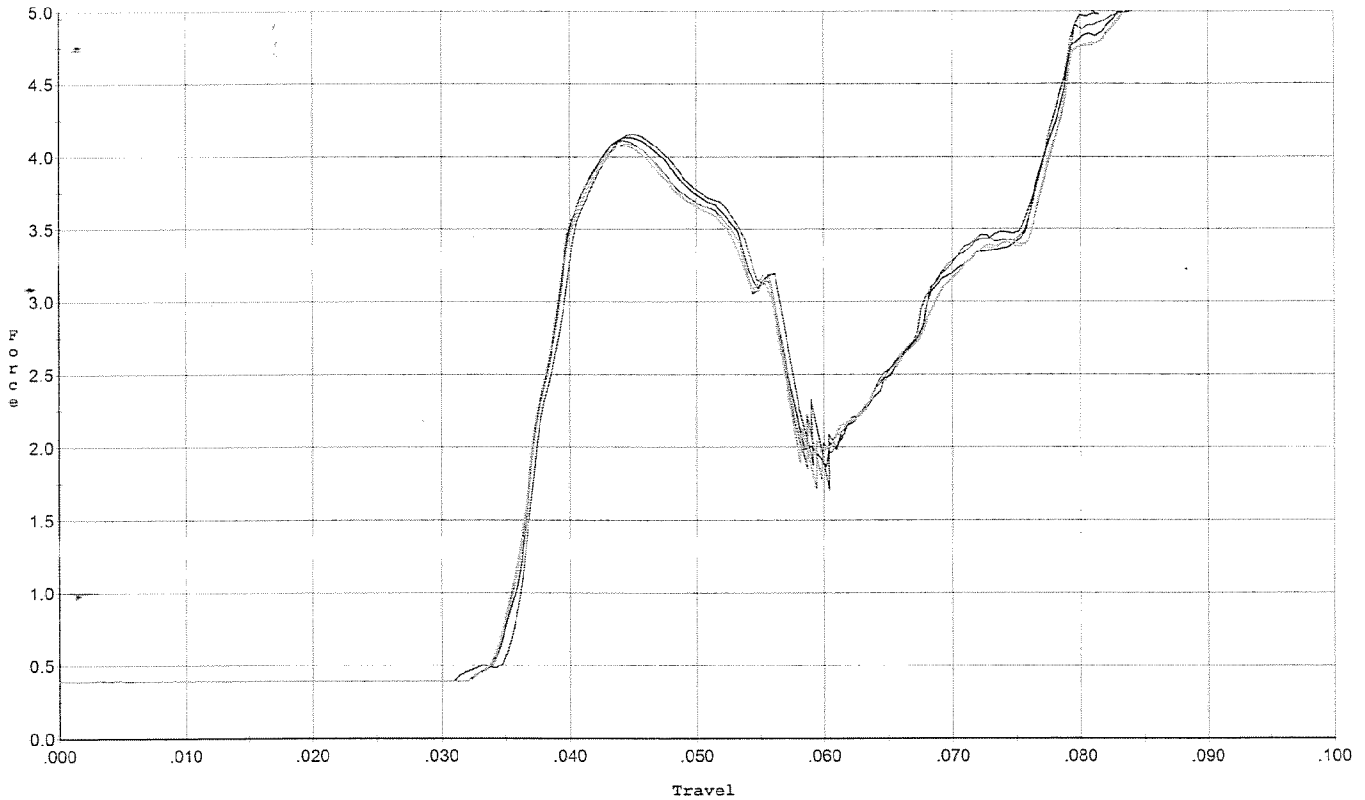
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.180	0.054	0.034	0.038	0.065		Set Trigger
2	3.062	0.053	0.034	0.039	0.062		Set Trigger
3	3.124	0.053	0.034	0.039	0.063		Set Trigger
4	3.188	0.053	0.034	0.039	0.063		Set Trigger
5	3.145	0.053	0.033	0.039	0.062		Set Trigger

Aug. 3.14

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.



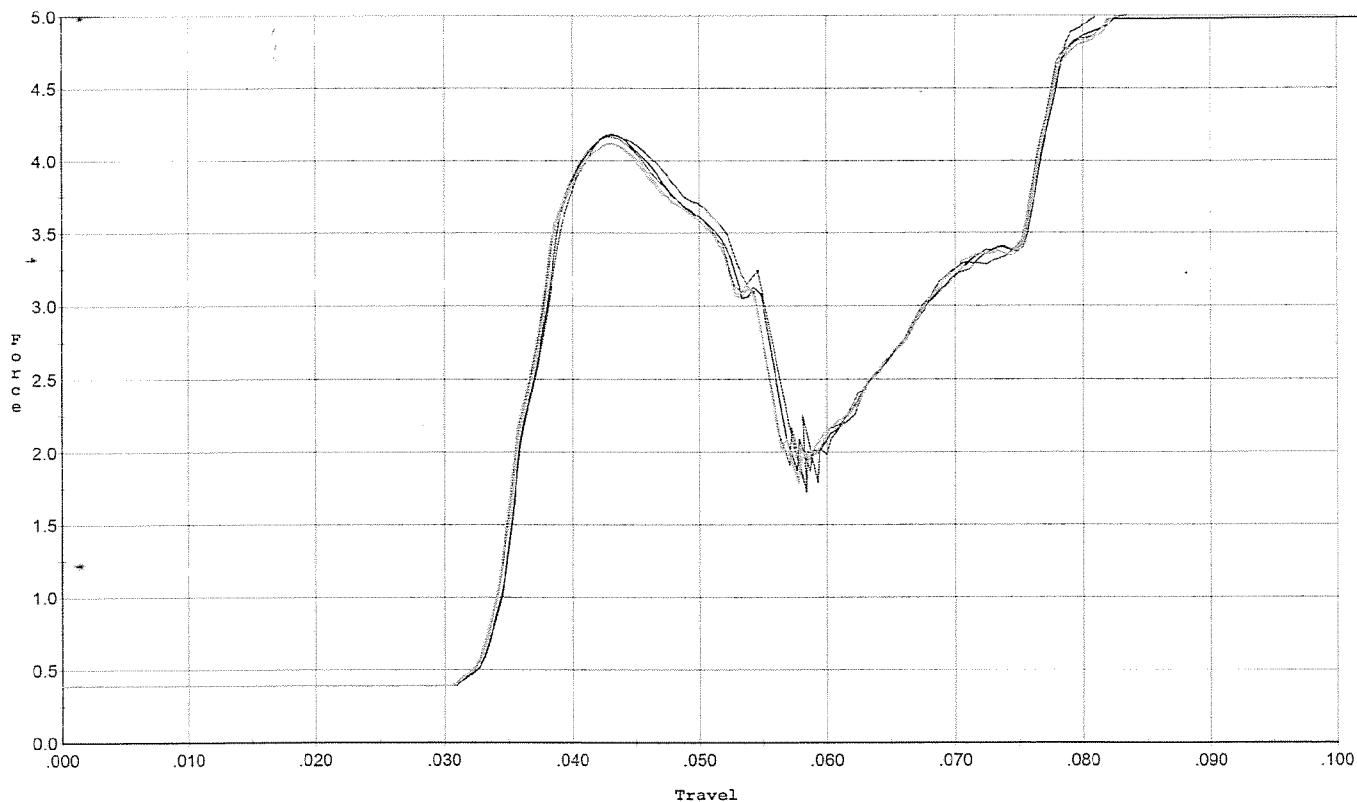
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.056	0.035	0.037	0.085		Set Trigger
2	4.131	0.056	0.035	0.038	0.085		Set Trigger
3	4.111	0.056	0.034	0.038	0.084		Set Trigger
4	4.088	0.056	0.035	0.038	0.084		Set Trigger
5	4.077	0.056	0.034	0.038	0.084		Set Trigger

Aug 4.11

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.



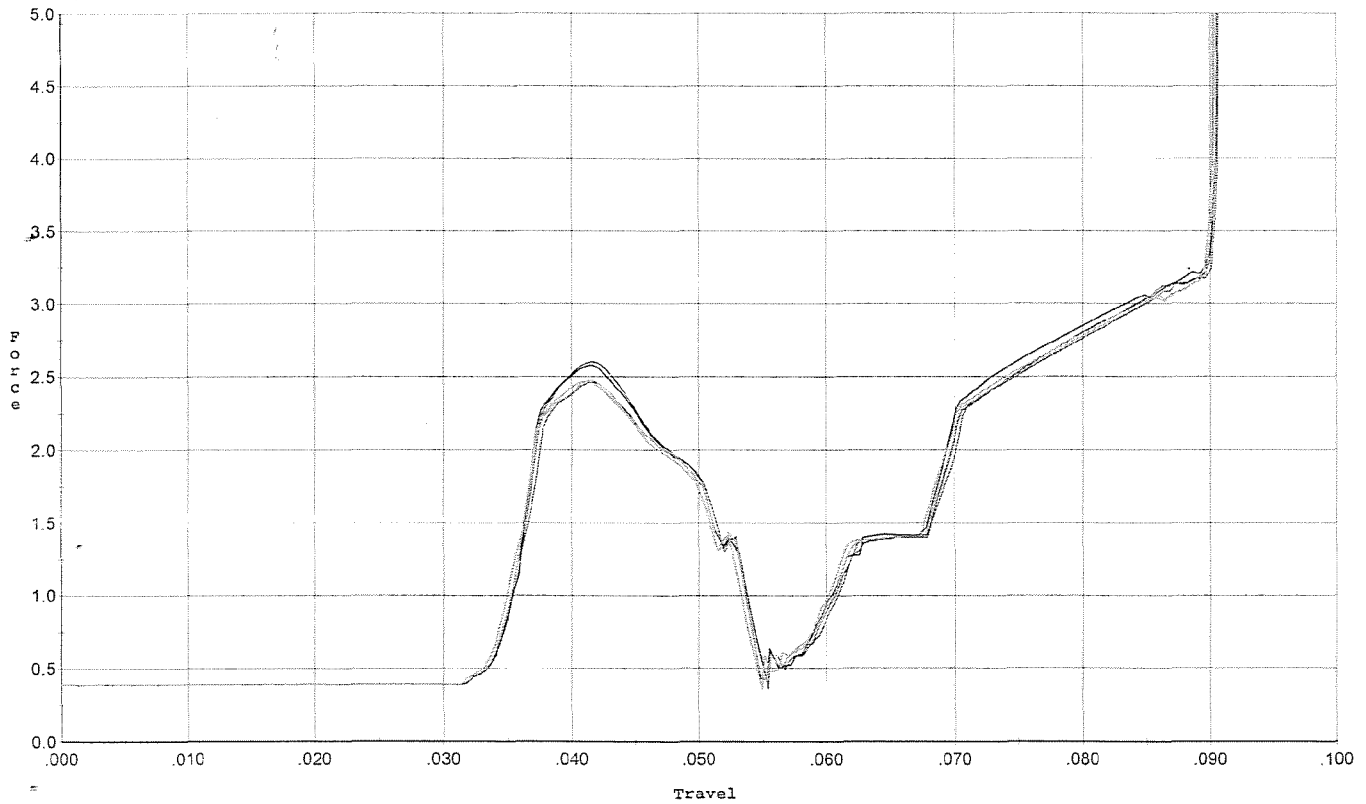
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.185	0.055	0.033	0.037	0.085		Set Trigger
2	4.177	0.055	0.033	0.037	0.085		Set Trigger
3	4.164	0.054	0.033	0.037	0.084		Set Trigger
4	4.121	0.054	0.033	0.037	0.084		Set Trigger
5	4.118	0.054	0.033	0.037	0.083		Set Trigger

Avg 4.15

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



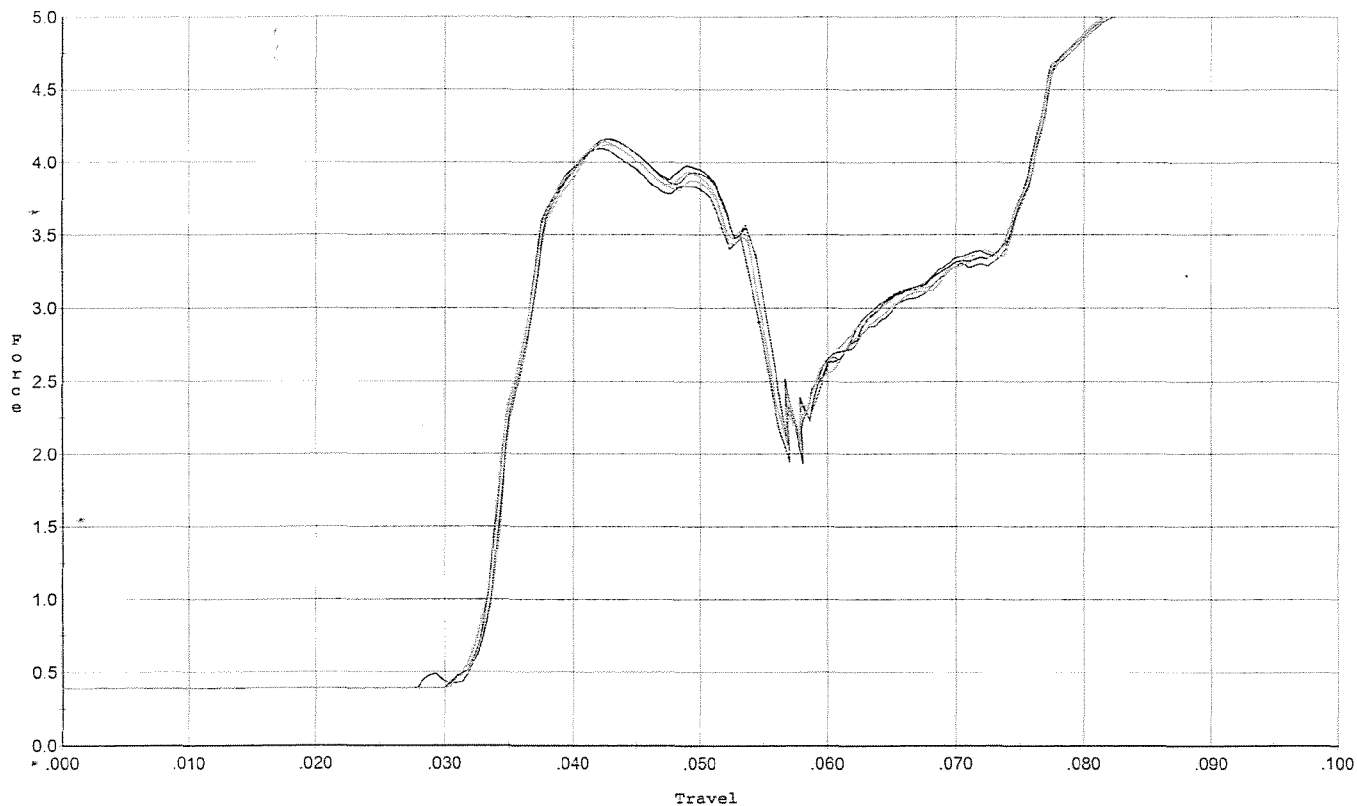
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.601	0.053	0.034	0.041	0.051		Set Trigger
2	2.579	0.053	0.034	0.041	0.051		Set Trigger
3	2.463	0.053	0.034	0.041	0.049		Set Trigger
4	2.472	0.053	0.034	0.041	0.050		Set Trigger
5	2.466	0.052	0.034	0.041	0.049		Set Trigger

Aug 2.51

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	4.095	0.055	0.032	0.035	0.089		Set Trigger
2	4.161	0.054	0.032	0.035	0.090		Set Trigger
3	4.151	0.054	0.032	0.035	0.090		Set Trigger
4	4.120	0.054	0.032	0.035	0.087		Set Trigger
5	4.136	0.054	0.032	0.035	0.088		Set Trigger

Avg 4.13