

G6785035

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



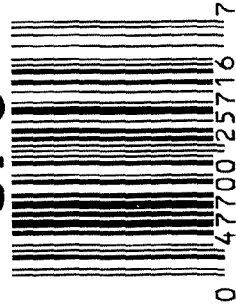
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6785035

UPC



GUN SERIAL #

G6785035

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	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES	ULI 2008	9-30-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (X)	10/2/08	(X)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/03/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-31-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

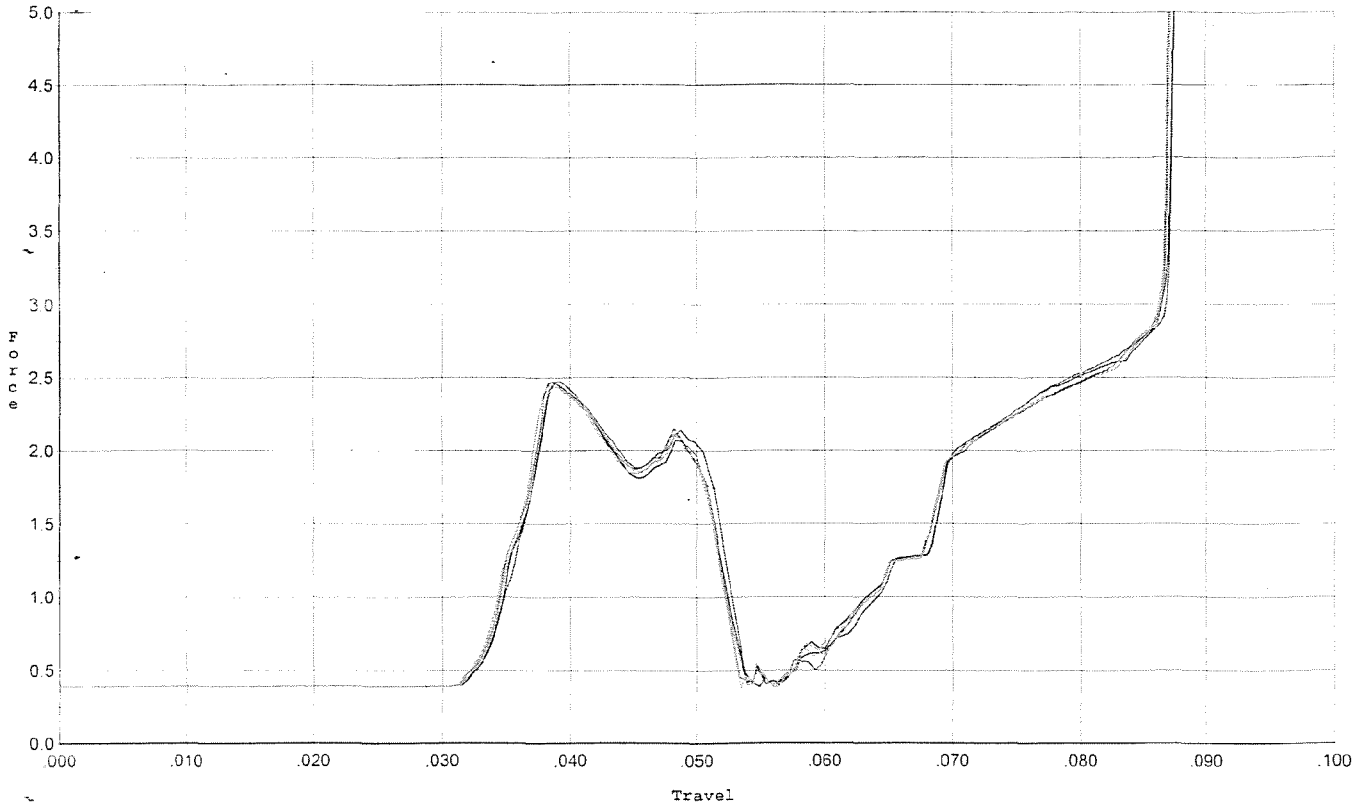
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.0</u> <u>5.0</u>	<u>11/7/08</u>	DW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2</u> <u>2</u> <u>2</u>	<u>11/7/08</u>	DW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	<u>11/7/08</u>	DW
	J) ASSEMBLE STOCK		<u>10-31-08</u>	RPD
	K) ASSEMBLE SWIVEL STUDS			
	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	<u>11-3-08</u>	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>11-3-08</u>	RPD
670	FINAL INSPECTION A) HEADSPACE		<u>11/07/08</u>	DW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.51</u> <u>2.31</u> <u>2.60</u> <u>2.61</u>	<u>11-5-08</u>	Fm
	C) FUNCTION		<u>11/7/08</u>	DW
690	PACK		<u>11/11/08</u>	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.



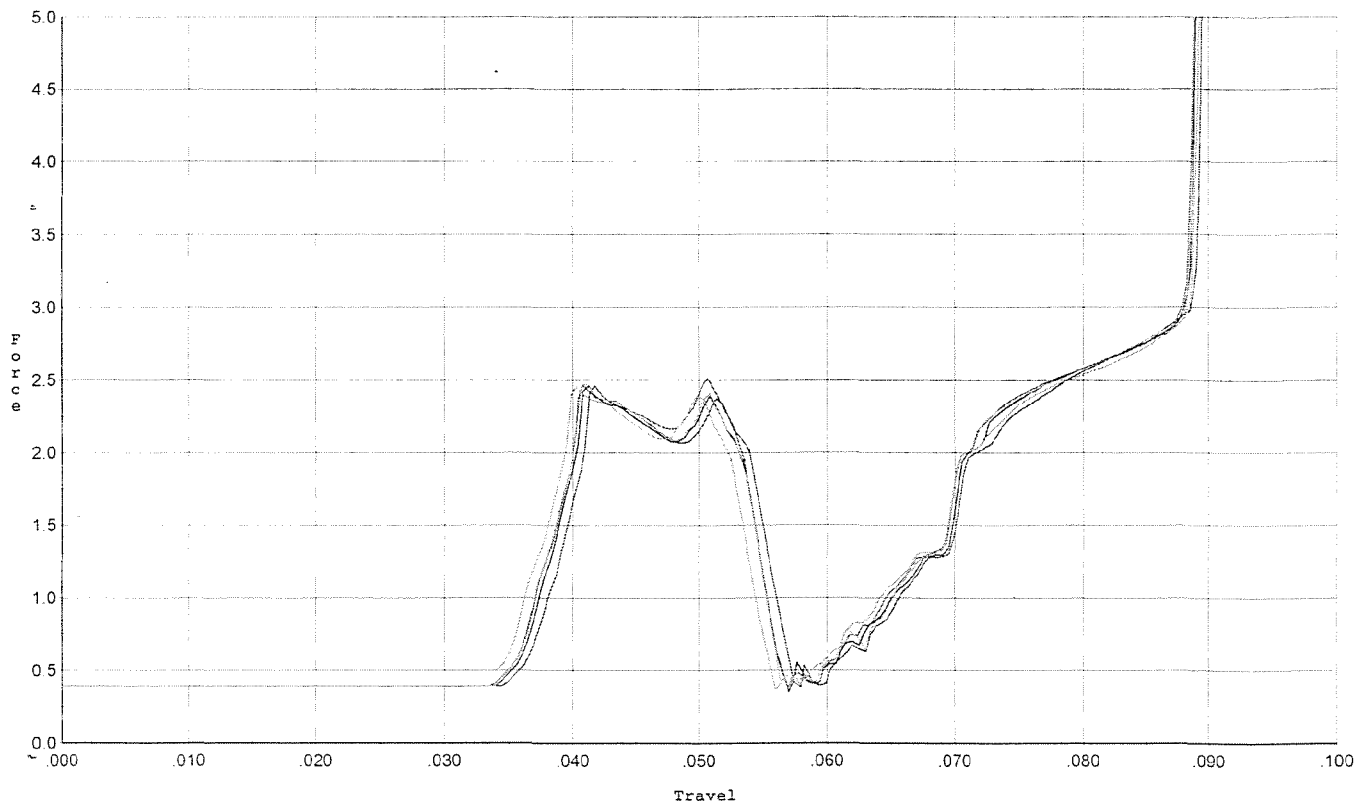
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.473	0.051	0.034	0.039	0.048		Set Trigger
2	2.466	0.051	0.034	0.040	0.046		Set Trigger
3	2.476	0.051	0.032	0.039	0.047		Set Trigger
4	2.442	0.051	0.033	0.040	0.047		Set Trigger
5	2.448	0.051	0.032	0.039	0.047		Set Trigger

Aug 2.46

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.



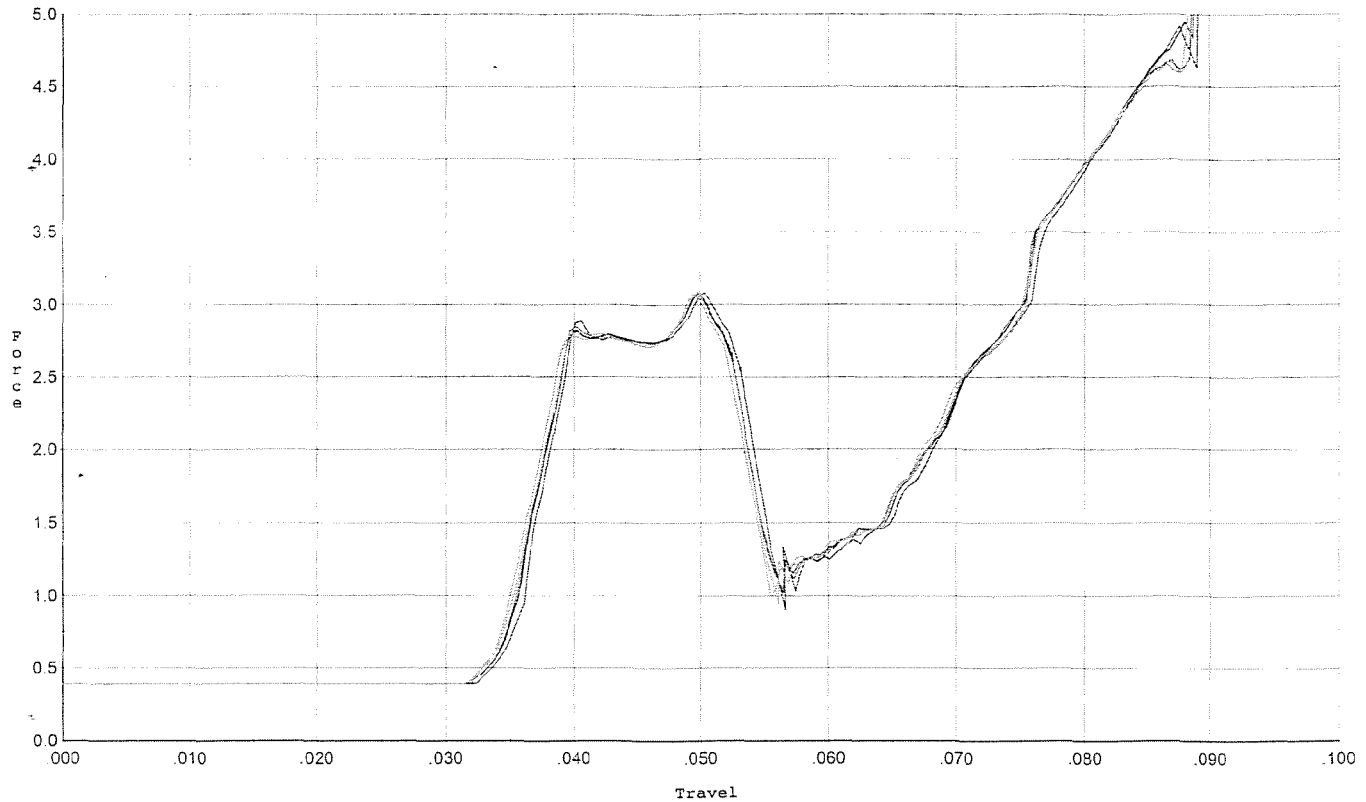
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.460	0.054	0.037	0.040	0.050		Set Trigger
2	2.461	0.054	0.036	0.039	0.050		Set Trigger
3	2.514	0.054	0.036	0.039	0.051		Set Trigger
4	2.472	0.054	0.036	0.040	0.051		Set Trigger
5	2.458	0.053	0.035	0.040	0.050		Set Trigger

Avg 2.47

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.



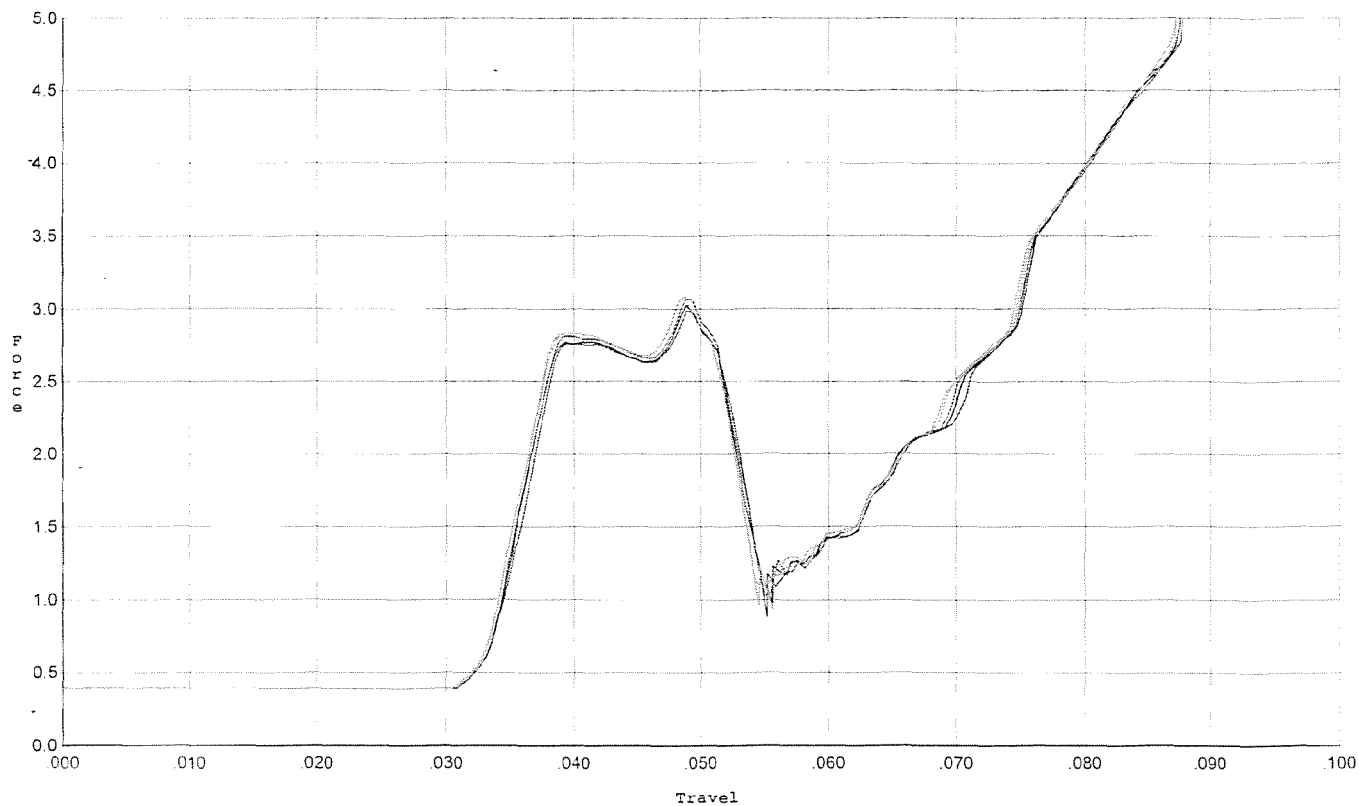
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.053	0.035	0.038	0.061		Set Trigger
2	3.081	0.053	0.034	0.038	0.060		Set Trigger
3	3.090	0.052	0.034	0.038	0.060		Set Trigger
4	3.091	0.053	0.034	0.038	0.060		Set Trigger
5	3.071	0.053	0.034	0.038	0.062		Set Trigger

Aug 3.08

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.



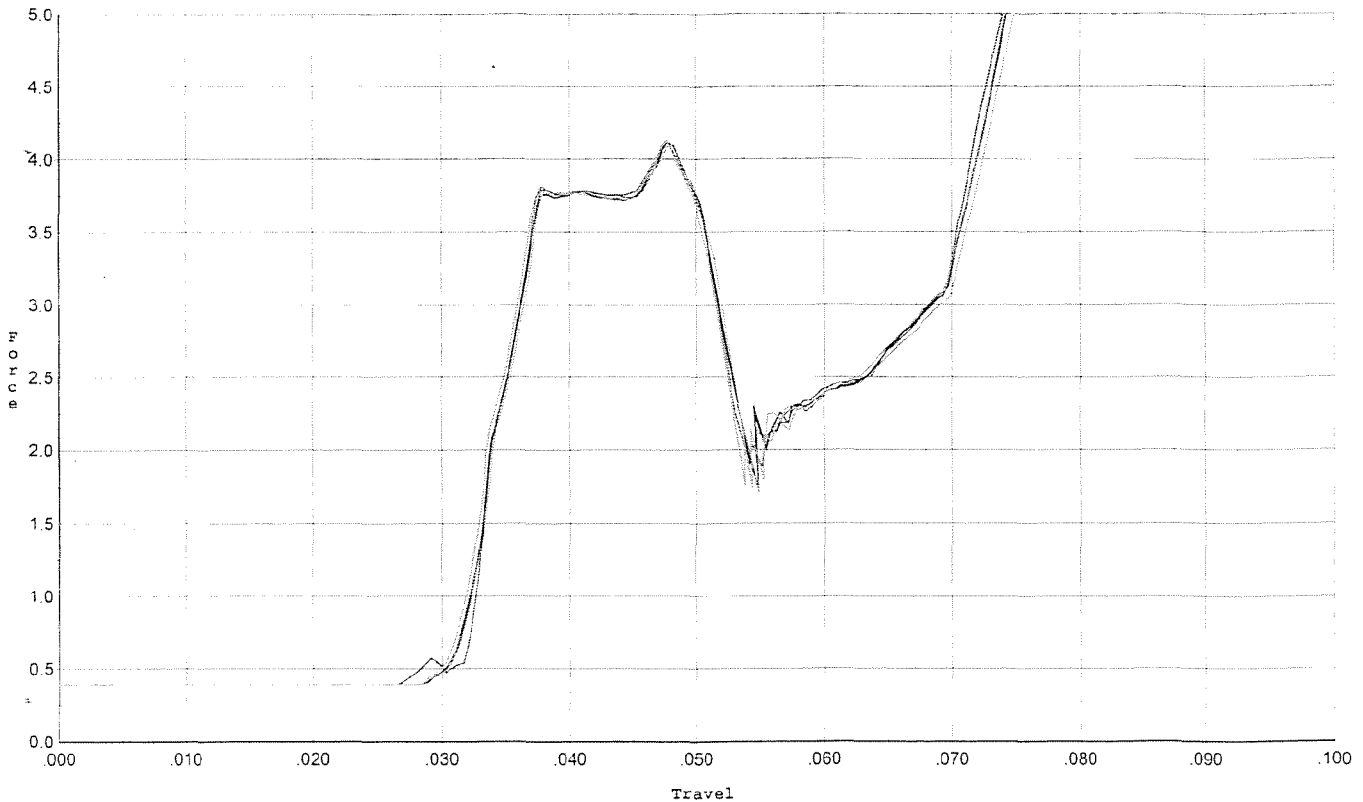
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.990	0.053	0.033	0.038	0.060		Set Trigger
2	3.026	0.051	0.033	0.038	0.059		Set Trigger
3	3.067	0.053	0.033	0.037	0.062		Set Trigger
4	3.082	0.052	0.033	0.037	0.061		Set Trigger
5	3.085	0.052	0.033	0.038	0.061		Set Trigger

Aug 3.05

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.



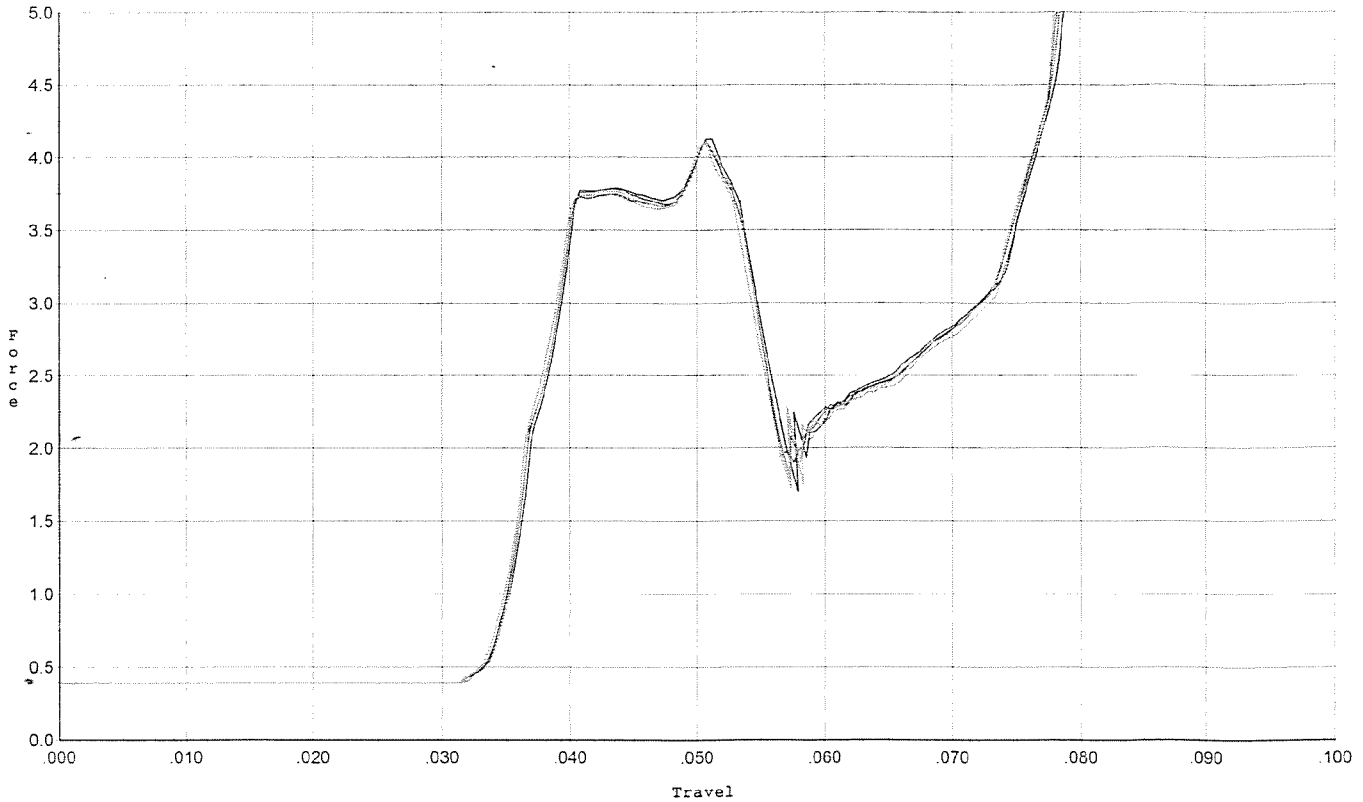
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.121	0.050	0.032	0.028	0.078		Set Trigger
2	4.115	0.050	0.031	0.028	0.078		Set Trigger
3	4.120	0.051	0.031	0.028	0.078		Set Trigger
4	4.104	0.051	0.031	0.028	0.080		Set Trigger
5	4.130	0.051	0.031	0.028	0.079		Set Trigger

Aug 4.11

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.



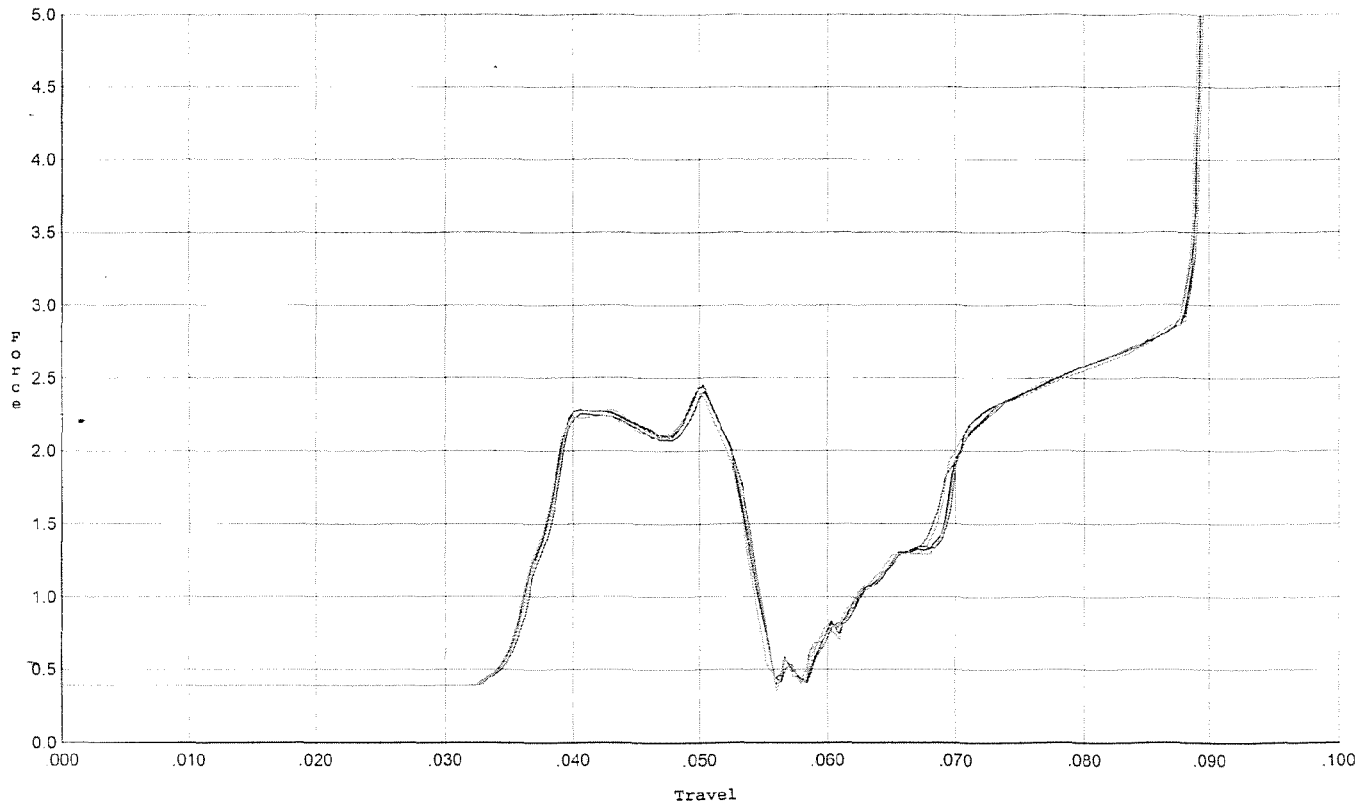
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.120	0.054	0.034	0.030	0.080		Set Trigger
2	4.128	0.053	0.034	0.030	0.079		Set Trigger
3	4.107	0.054	0.034	0.030	0.079		Set Trigger
4	4.115	0.054	0.034	0.030	0.079		Set Trigger
5	4.085	0.053	0.034	0.030	0.078		Set Trigger

Aug 4.11

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



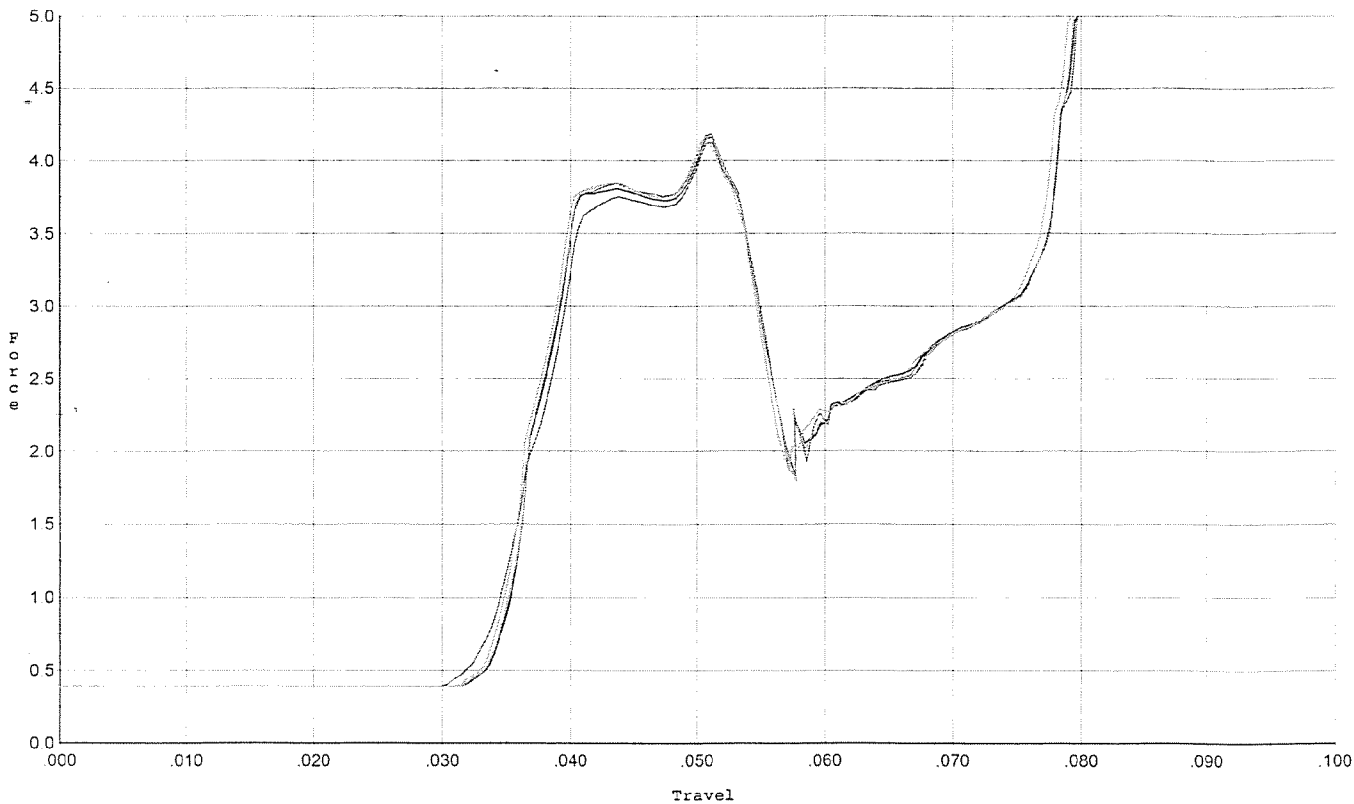
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.407	0.053	0.035	0.040	0.050		Set Trigger
2	2.453	0.052	0.035	0.040	0.050		Set Trigger
3	2.445	0.054	0.035	0.040	0.051		Set Trigger
4	2.428	0.053	0.035	0.040	0.049		Set Trigger
5	2.462	0.054	0.035	0.040	0.051		Set Trigger

Aug 2.43

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	4.123	0.053	0.033	0.030	0.079		Set Trigger
2	4.163	0.055	0.034	0.029	0.083		Set Trigger
3	4.189	0.055	0.034	0.029	0.083		Set Trigger
4	4.170	0.054	0.034	0.029	0.081		Set Trigger
5	4.171	0.053	0.034	0.030	0.080		Set Trigger

AUG 4.16