

66785069

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



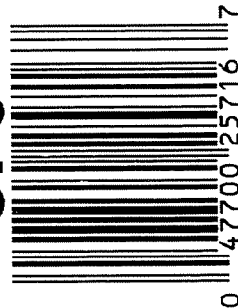
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785069

UPC



GUN SERIAL #

G 6785069

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-22-08	SPD
430	ASSEMBLE TO STOCK		9-22-08	SP
440	PROOF		9-22-08	SPD
460	CHECK HEADSPACE		9-22-08	SPD
470	DIS-ASSEMBLE ACTION		9-22-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX SEP 30 2008 OPERATOR (15)	9-23-08	ESV
475	DRILL AND TAP SIGHT HOLES		9-23-08	SP
480	MAGNAFLUX BBL ACTION		9/30/08	(15)
490	MAGNAFLUX BOLT		9/24/08	M/L
500	ROLLMARK CALIBER		9/30/08	RT
520	GOFF BLAST BBL / REC		9/30/08	SG
542	APPLY COATINGS (BARREL ACTION)		10-2	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-14-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-14-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-14-08	SO
	D) OIL FIRING PIN ASSEMBLY		11-13-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

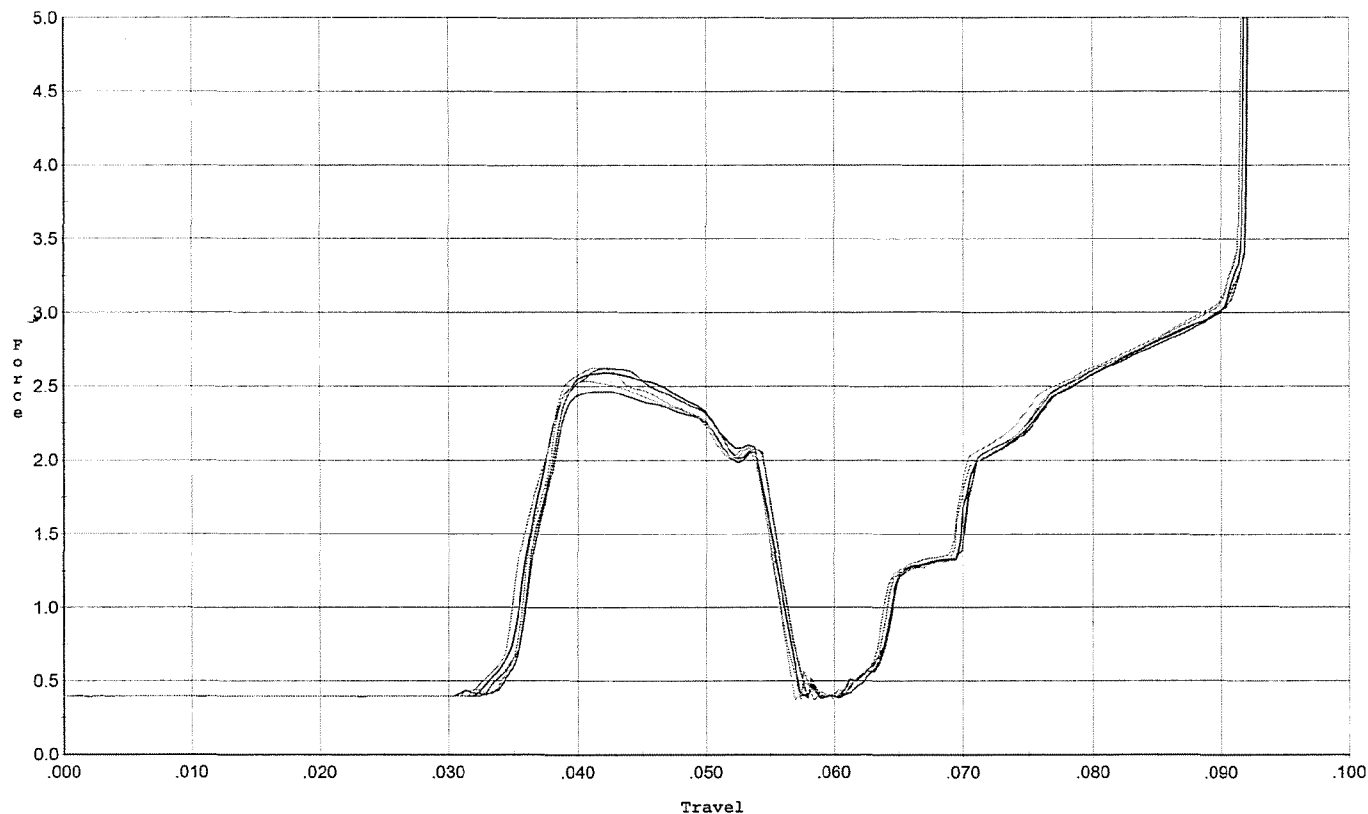
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.0</u>	2-11-09	LJN
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	2-11-09	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	2-11-09	LJN
	J) ASSEMBLE STOCK		11-13-08	RW
	K) ASSEMBLE SWIVEL STUDS		2-11-09	LJN
	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	PASS FAIL PASS FAIL	2-2-09 11-14-08	TC LJN
	MALFUNCTION <i>CTOG</i>	CORRECTION	2-2-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-14-08	TC
670	FINAL INSPECTION A) HEADSPACE		2-11-09	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.33</u> <u>2.30</u> <u>2.29</u> <u>2.33</u>	2-4-09	NW
	C) FUNCTION		2-11-09	LJN
690	PACK		3/17/09	Fm

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.



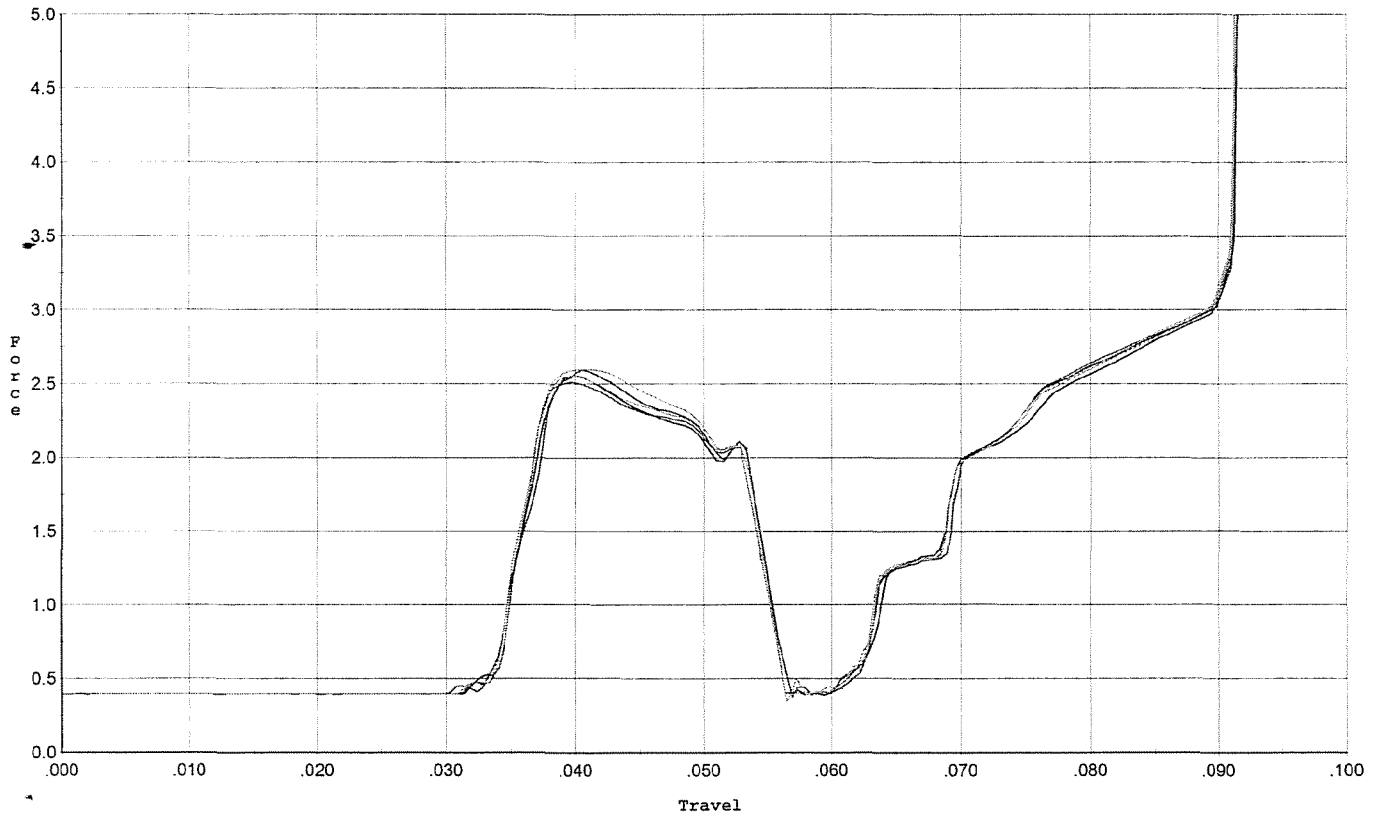
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.465	0.055	0.034	0.040	0.057		Set Trigger
2	2.592	0.056	0.035	0.040	0.059		Set Trigger
3	2.621	0.054	0.033	0.041	0.058		Set Trigger
4	2.535	0.054	0.034	0.040	0.056		Set Trigger
5	2.626	0.054	0.034	0.040	0.058		Set Trigger

Avg 2.56

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.



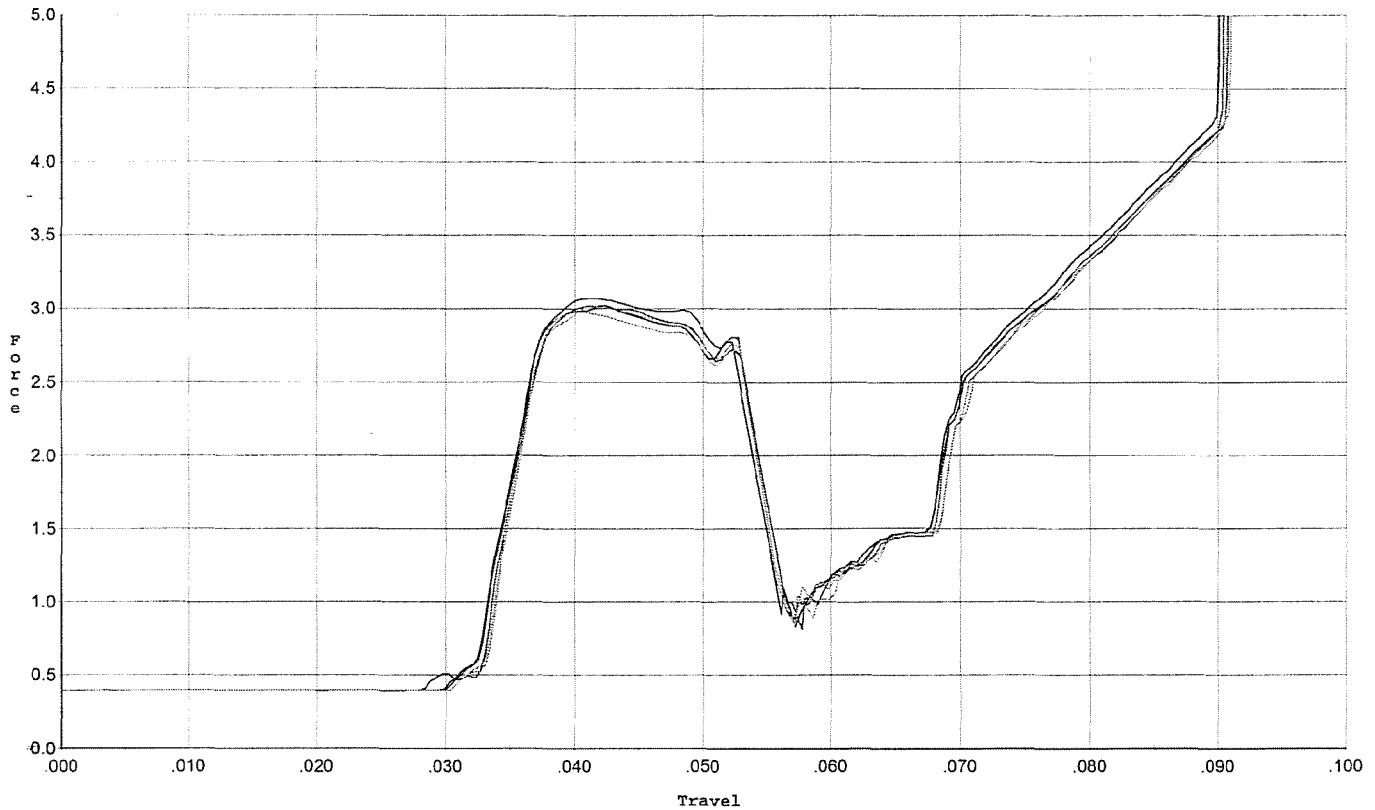
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.053	0.033	0.041	0.056		Set Trigger
2	2.558	0.054	0.034	0.041	0.056		Set Trigger
3	2.513	0.055	0.034	0.041	0.057		Set Trigger
4	2.555	0.054	0.034	0.041	0.057		Set Trigger
5	2.597	0.054	0.034	0.041	0.057		Set Trigger

Aug 2.56

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.



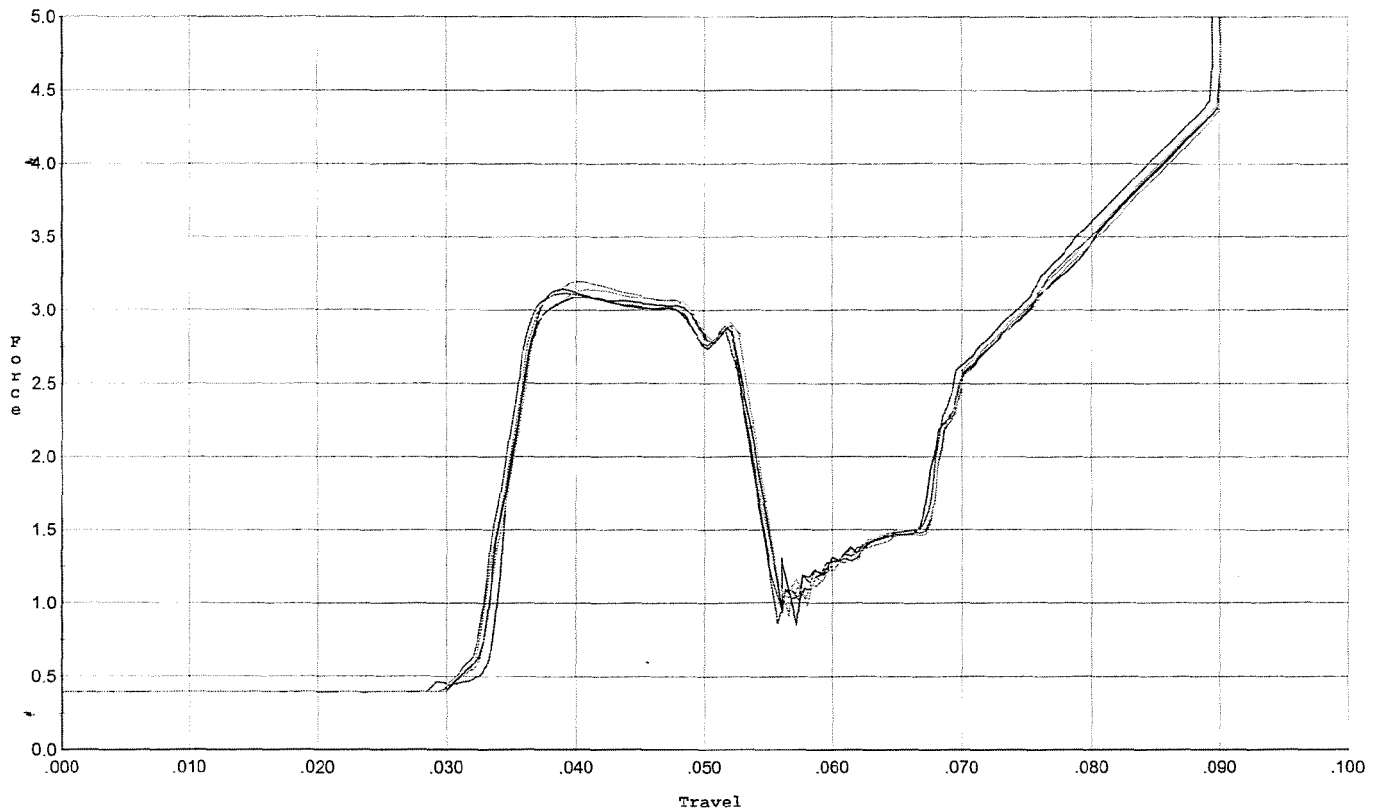
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.069	0.053	0.033	0.039	0.068		Set Trigger
2	3.020	0.054	0.033	0.038	0.069		Set Trigger
3	3.018	0.053	0.033	0.039	0.067		Set Trigger
4	2.982	0.053	0.033	0.039	0.066		Set Trigger
5	3.009	0.053	0.033	0.039	0.067		Set Trigger

Aug 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.



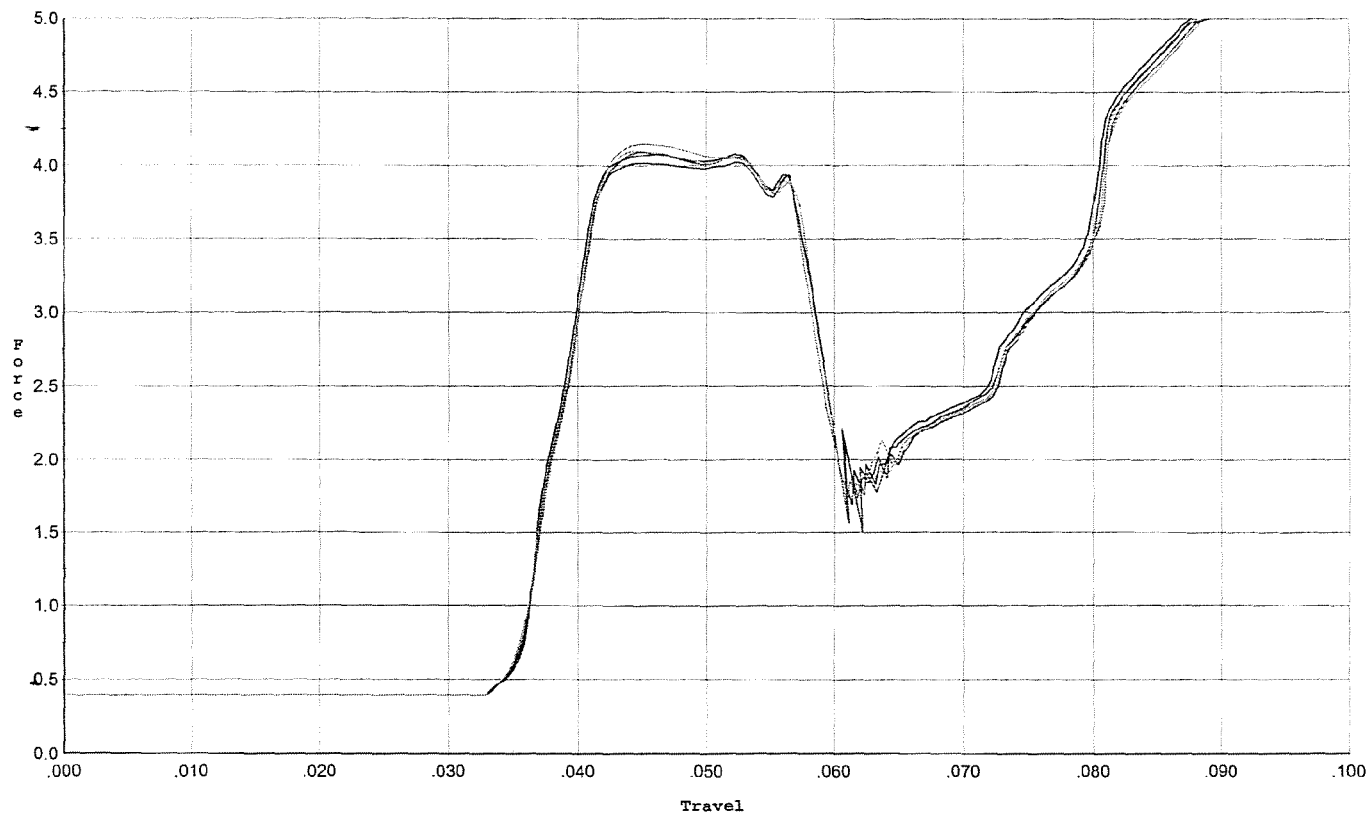
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.139	0.052	0.033	0.038	0.067		Set Trigger
2	3.085	0.054	0.033	0.038	0.071		Set Trigger
3	3.114	0.053	0.032	0.038	0.069		Set Trigger
4	3.137	0.053	0.033	0.038	0.070		Set Trigger
5	3.196	0.052	0.032	0.038	0.069		Set Trigger

Aug 3.13

Trigger Profile [lbs,inch]

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

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



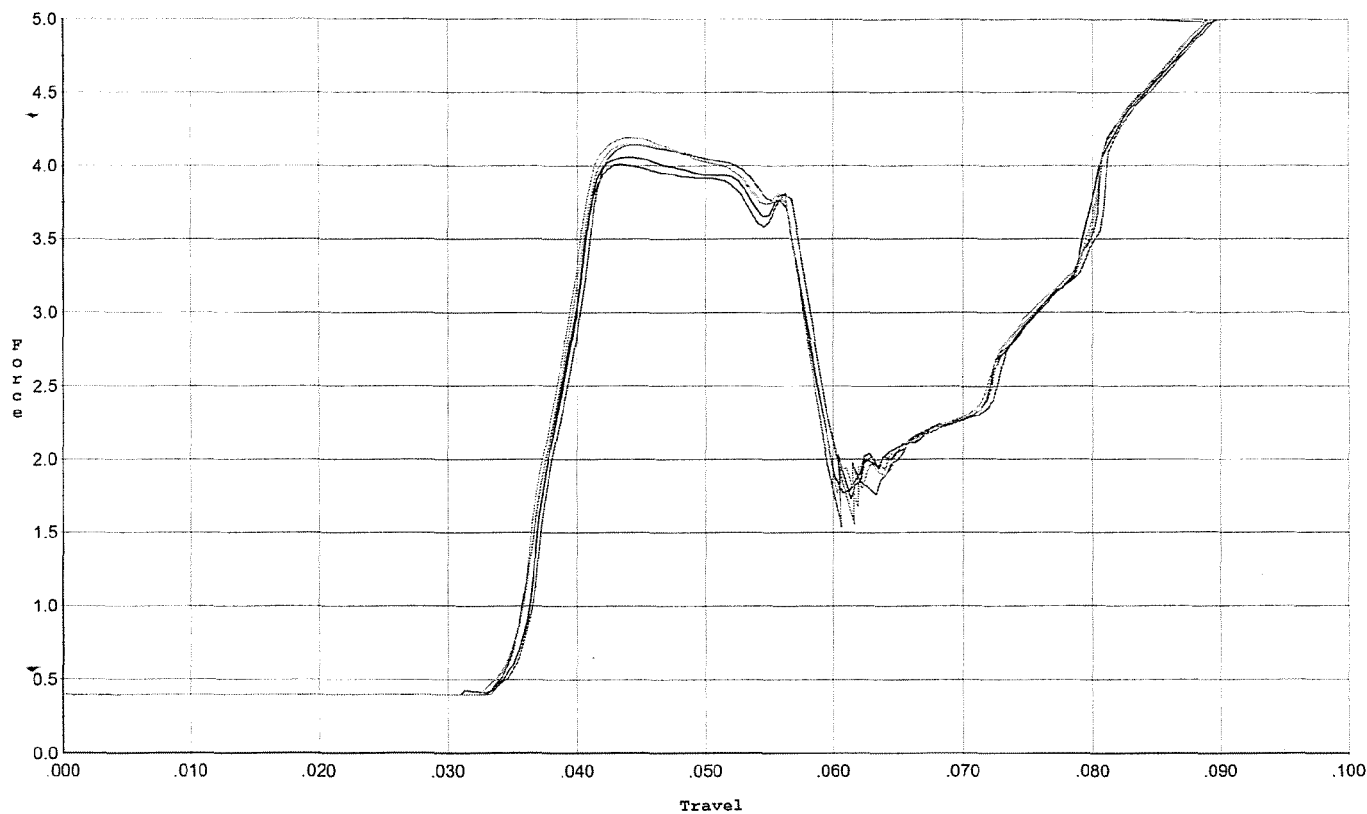
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.025	0.058	0.036	0.037	0.093		Set Trigger
2	4.080	0.057	0.035	0.038	0.092		Set Trigger
3	4.093	0.058	0.035	0.038	0.094		Set Trigger
4	4.100	0.057	0.035	0.038	0.091		Set Trigger
5	4.146	0.057	0.035	0.038	0.094		Set Trigger

Aug 4.08

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.



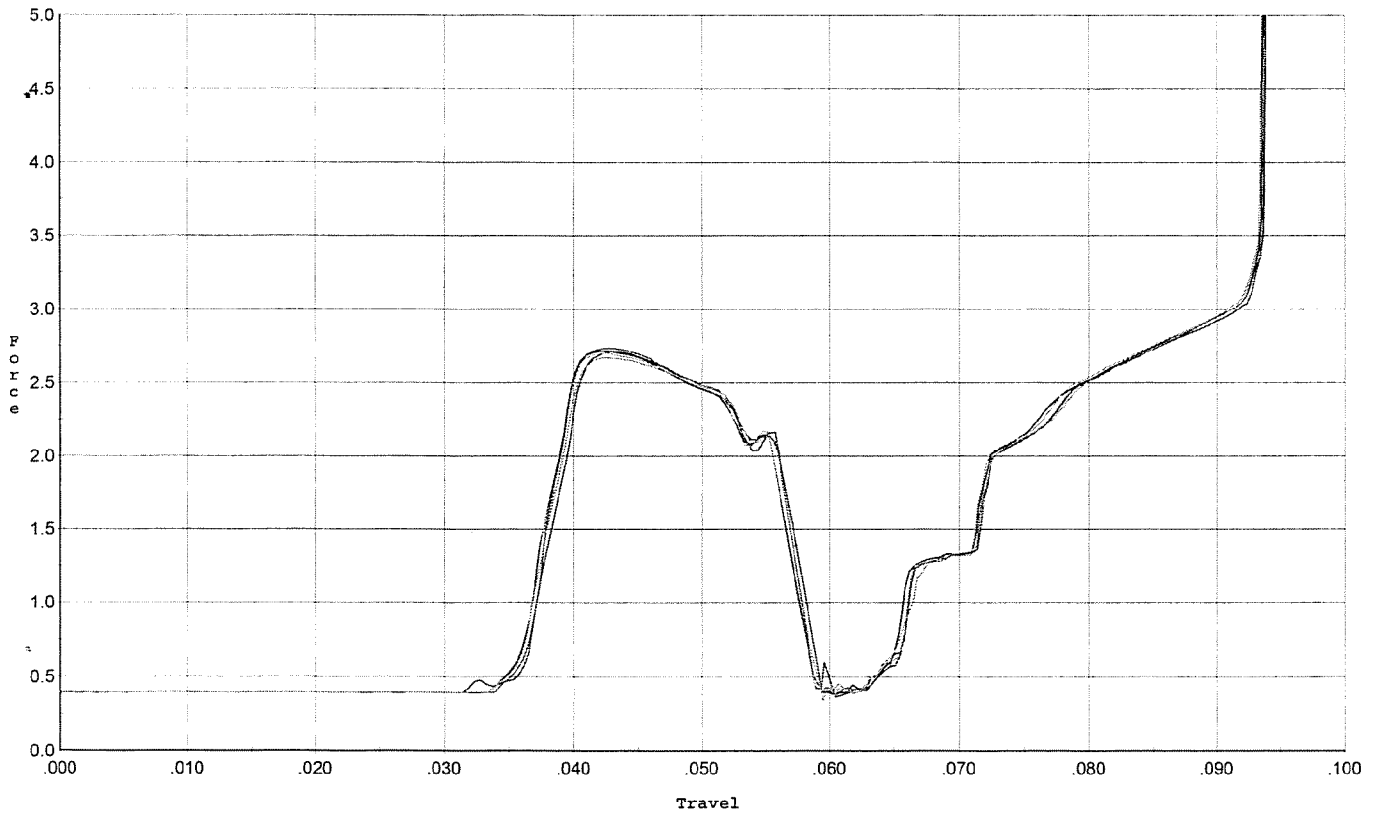
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.013	0.056	0.035	0.038	0.089		Set Trigger
2	4.059	0.056	0.035	0.038	0.089		Set Trigger
3	4.142	0.057	0.035	0.038	0.091		Set Trigger
4	4.153	0.058	0.035	0.038	0.095		Set Trigger
5	4.193	0.056	0.035	0.038	0.092		Set Trigger

Aug 4.11

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



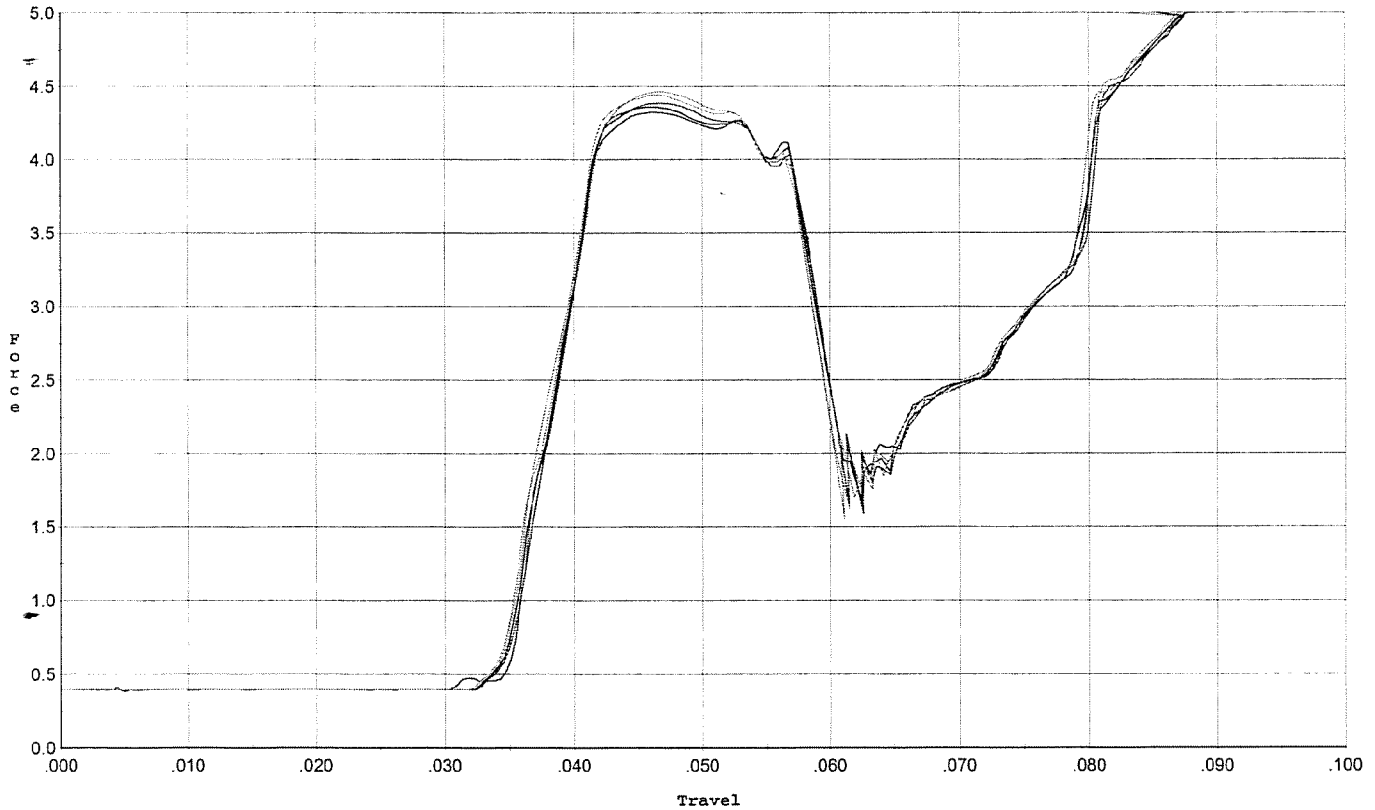
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.714	0.057	0.036	0.040	0.062		Set Trigger
2	2.718	0.055	0.036	0.040	0.060		Set Trigger
3	2.735	0.056	0.036	0.040	0.061		Set Trigger
4	2.704	0.055	0.036	0.040	0.059		Set Trigger
5	2.673	0.056	0.036	0.040	0.060		Set Trigger

Avg 2.70

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 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	4.324	0.058	0.035	0.037	0.100		Set Trigger
2	4.361	0.057	0.035	0.037	0.097		Set Trigger
3	4.388	0.059	0.035	0.037	0.101		Set Trigger
4	4.445	0.057	0.034	0.037	0.100		Set Trigger
5	4.466	0.057	0.035	0.037	0.099		Set Trigger

Aug 4.39