

G6785097

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



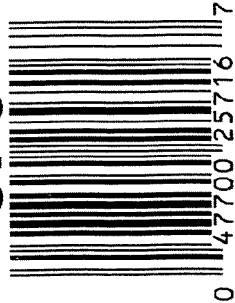
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6785097

UPC



GUN SERIAL #

G 6785097

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		7-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		9-30-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	HB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/23/08	DC
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

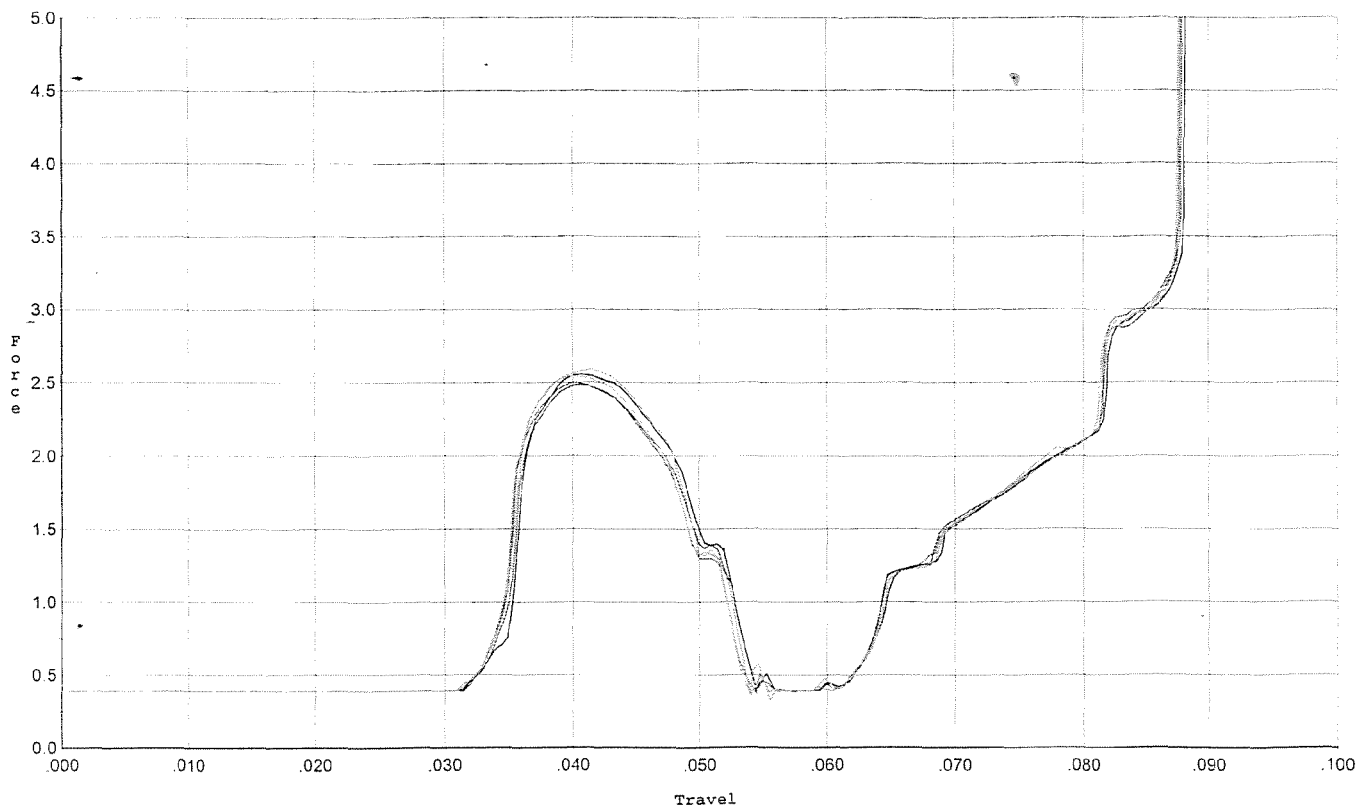
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.5</u>	11-6-08	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	11-6-08	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	11-6-08	LN
	J) ASSEMBLE STOCK		10-30-08	SLP
	K) ASSEMBLE SWIVEL STUDS		11-6-08	LN
	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	LN
670	FINAL INSPECTION A) HEADSPACE		11-6-08	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.27</u> <u>2.30</u> <u>2.23</u> <u>2.26</u> <u>2.32</u>	11-6-08	Fm
	C) FUNCTION		11-6-08	LN
690	PACK		11/6/08	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.



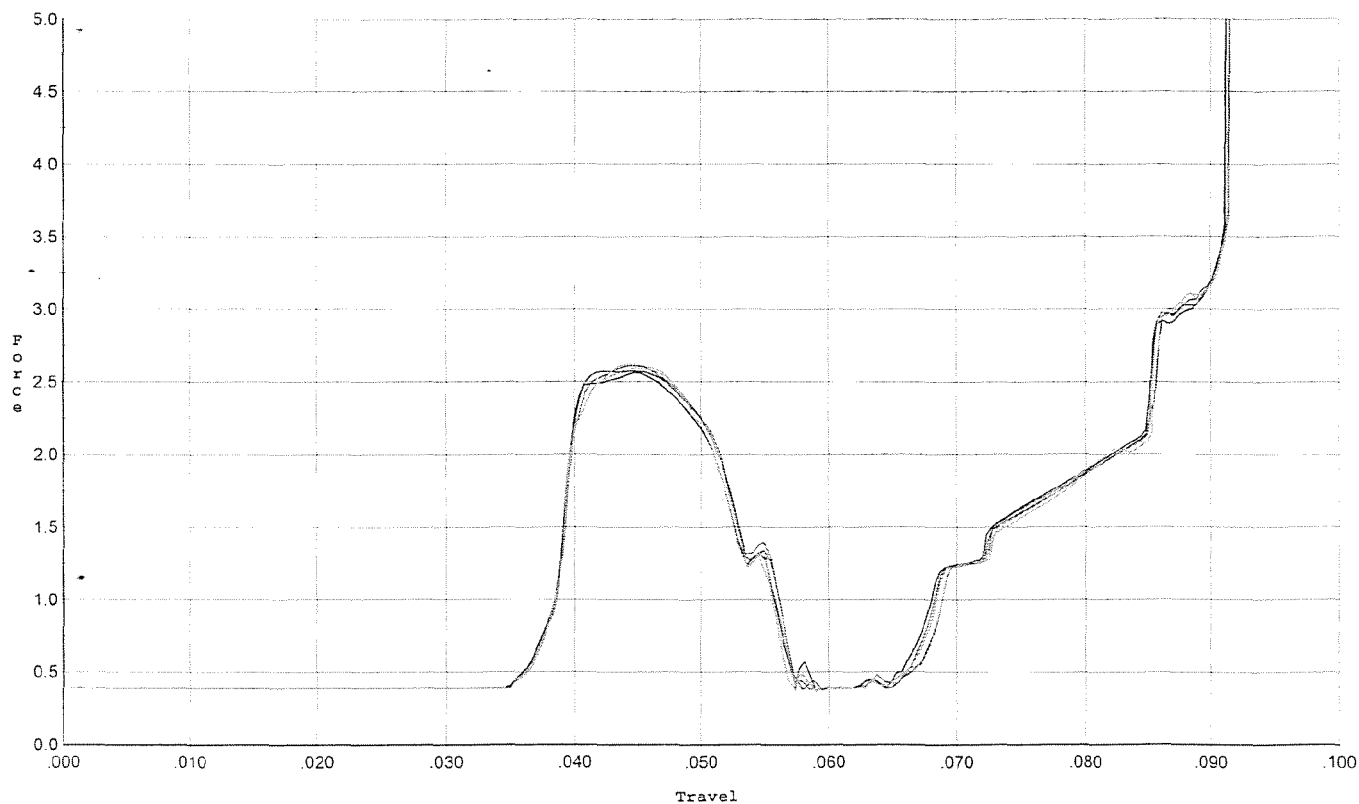
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.485	0.052	0.034	0.040	0.049		Set Trigger
2	2.556	0.052	0.034	0.040	0.050		Set Trigger
3	2.499	0.052	0.033	0.040	0.049		Set Trigger
4	2.545	0.052	0.033	0.040	0.050		Set Trigger
5	2.589	0.052	0.033	0.040	0.051		Set Trigger

Aug 2.53

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.



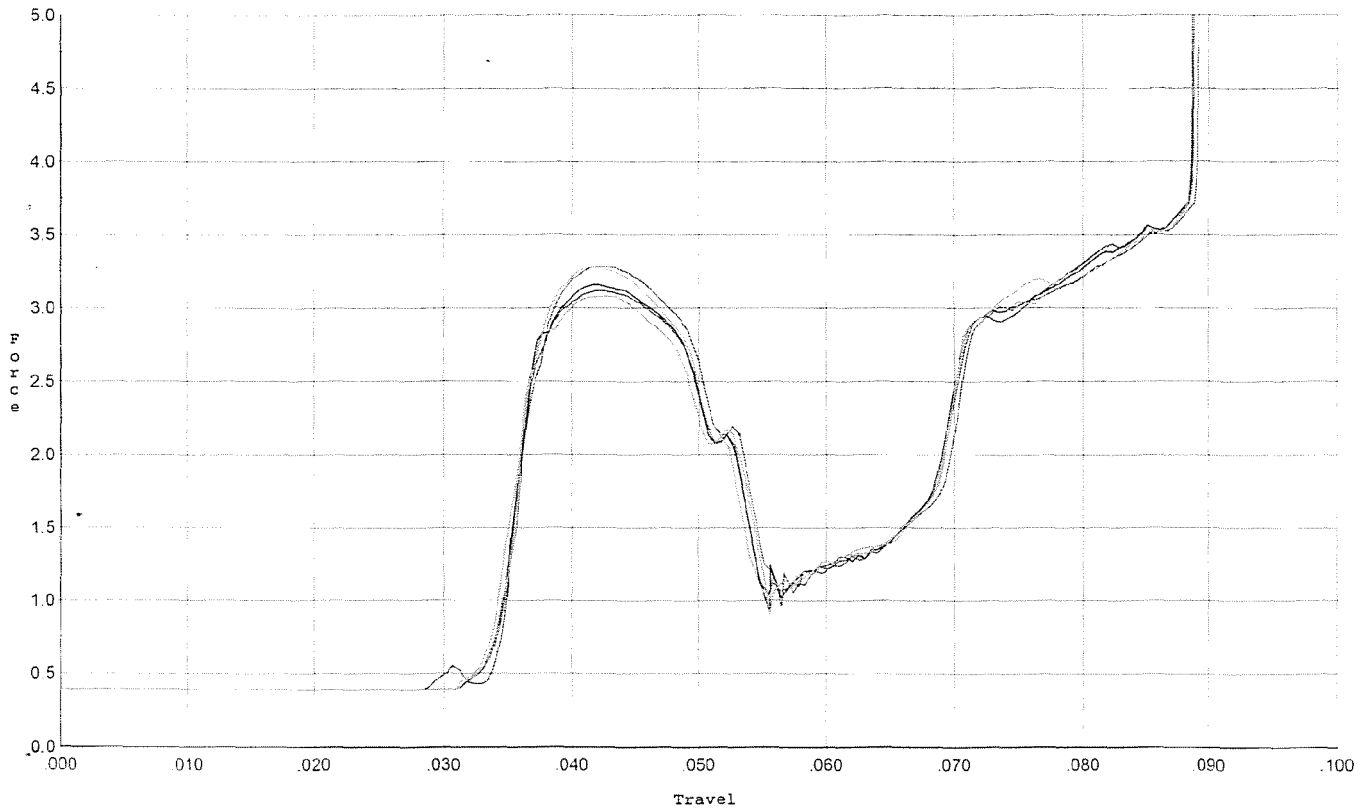
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.056	0.037	0.040	0.052		Set Trigger
2	2.564	0.055	0.037	0.040	0.051		Set Trigger
3	2.612	0.056	0.037	0.040	0.052		Set Trigger
4	2.596	0.056	0.037	0.040	0.052		Set Trigger
5	2.626	0.055	0.037	0.041	0.051		Set Trigger

Aug 2.59

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.



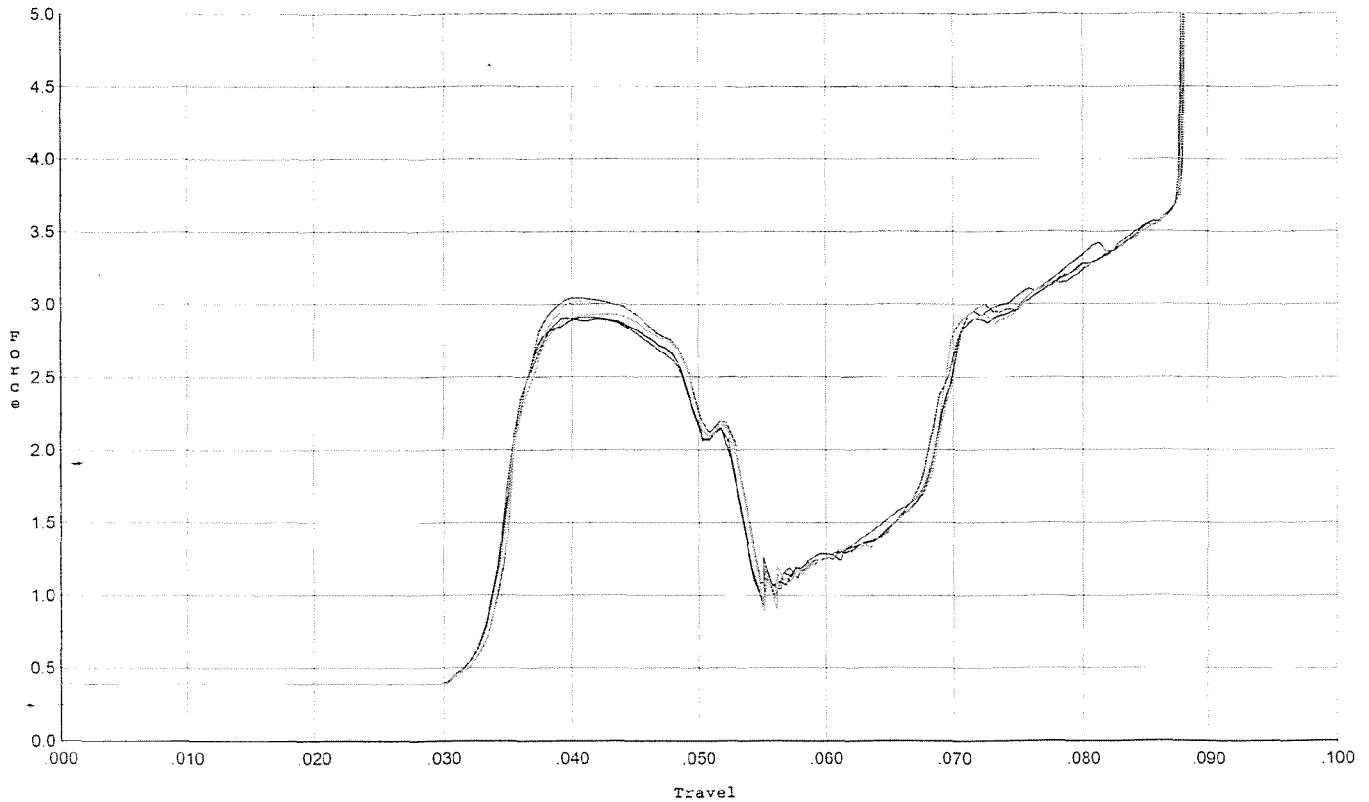
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.053	0.034	0.038	0.063		Set Trigger
2	3.158	0.053	0.034	0.038	0.064		Set Trigger
3	3.283	0.053	0.034	0.038	0.066		Set Trigger
4	3.275	0.054	0.034	0.038	0.066		Set Trigger
5	3.080	0.052	0.033	0.038	0.062		Set Trigger

Aug 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.



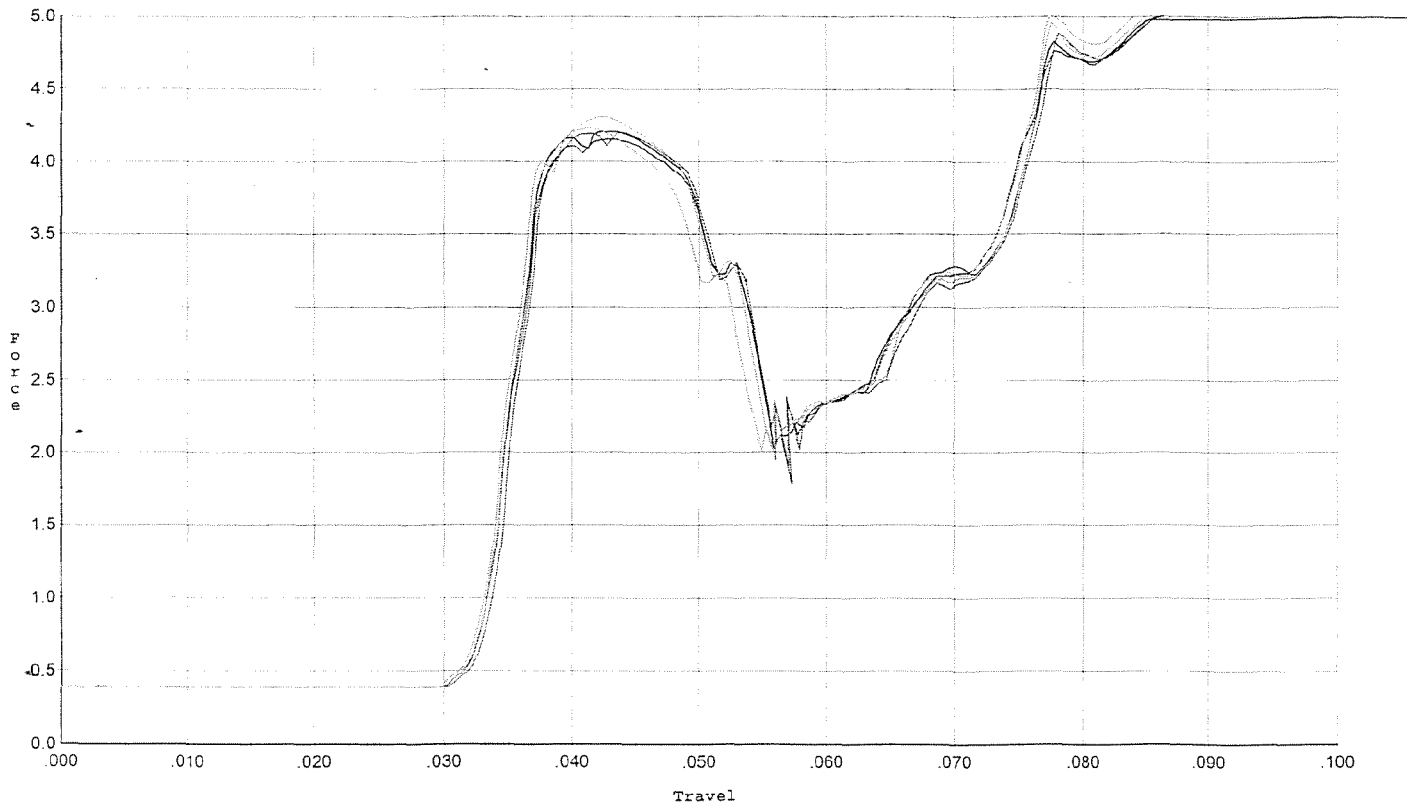
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.902	0.052	0.033	0.038	0.061		Set Trigger
2	2.907	0.053	0.033	0.038	0.061		Set Trigger
3	3.042	0.053	0.033	0.037	0.063		Set Trigger
4	3.019	0.053	0.033	0.037	0.063		Set Trigger
5	2.933	0.053	0.033	0.037	0.062		Set Trigger

Aug 2.96

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.



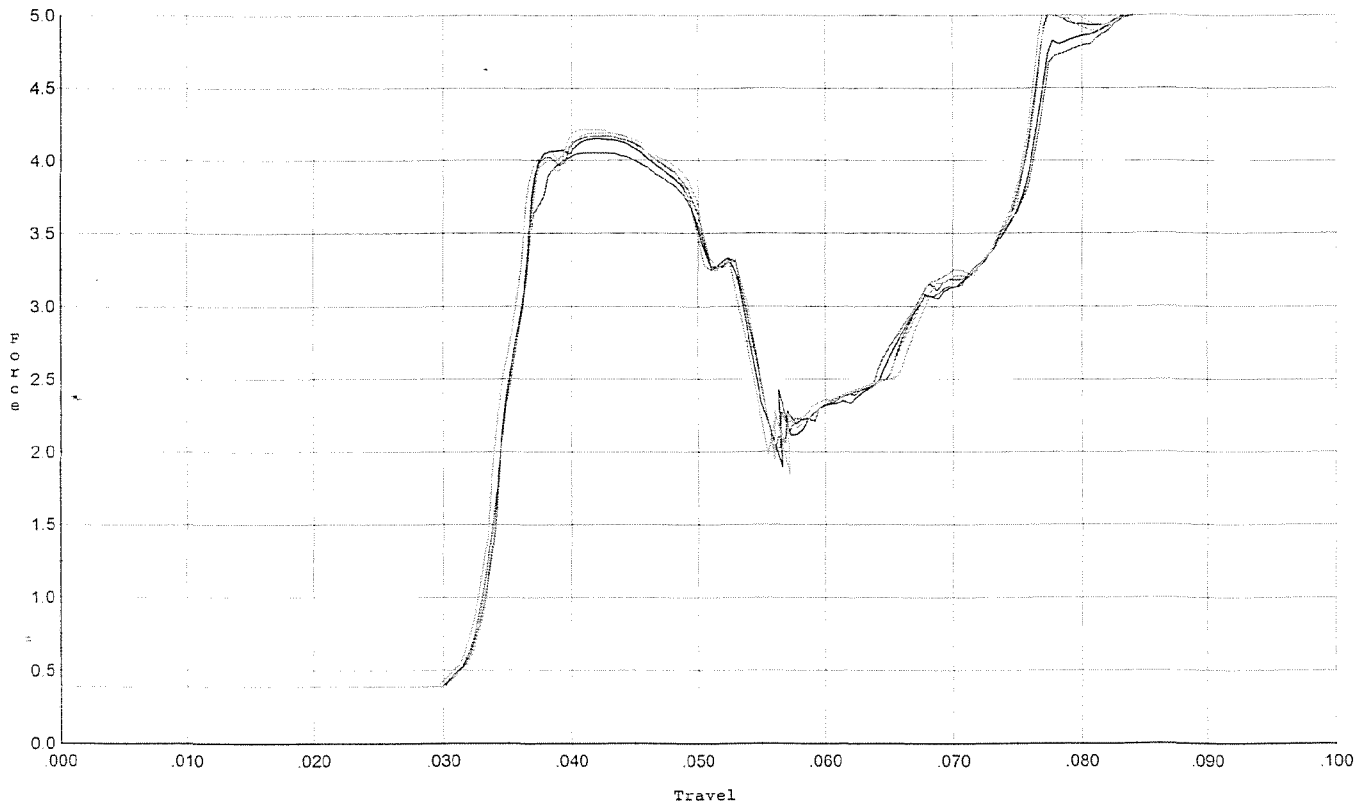
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.154	0.054	0.032	0.036	0.088		Set Trigger
2	4.209	0.054	0.032	0.036	0.088		Set Trigger
3	4.200	0.054	0.033	0.036	0.087		Set Trigger
4	4.228	0.052	0.032	0.037	0.082		Set Trigger
5	4.308	0.053	0.032	0.036	0.087		Set Trigger

Aug 4.22

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. after 20 cycles +/- 1.0 lbs.



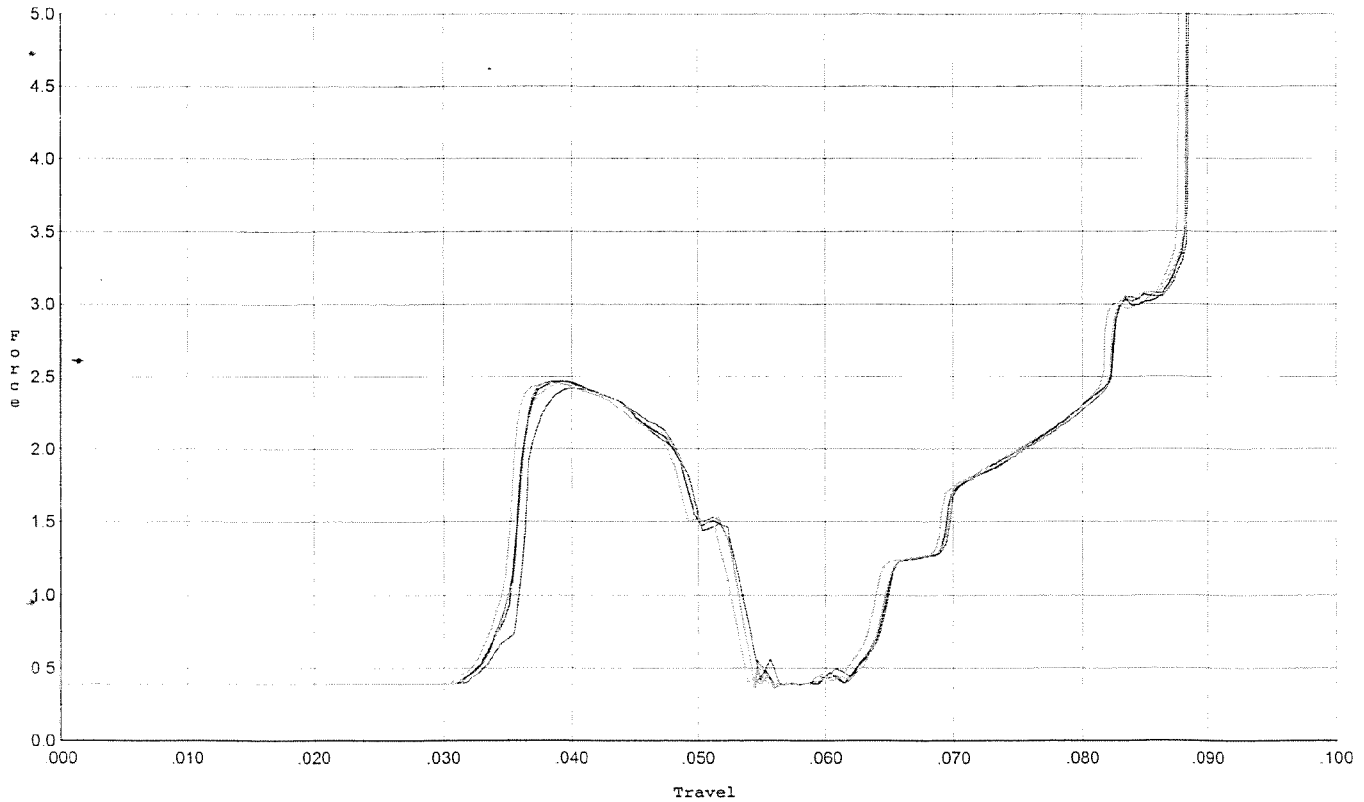
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.055	0.054	0.032	0.035	0.087		Set Trigger
2	4.151	0.053	0.032	0.036	0.086		Set Trigger
3	4.173	0.054	0.032	0.035	0.089		Set Trigger
4	4.191	0.054	0.032	0.035	0.088		Set Trigger
5	4.216	0.054	0.032	0.035	0.089		Set Trigger

Aug 4.15

Trigger Profile [lbs,inch]

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

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



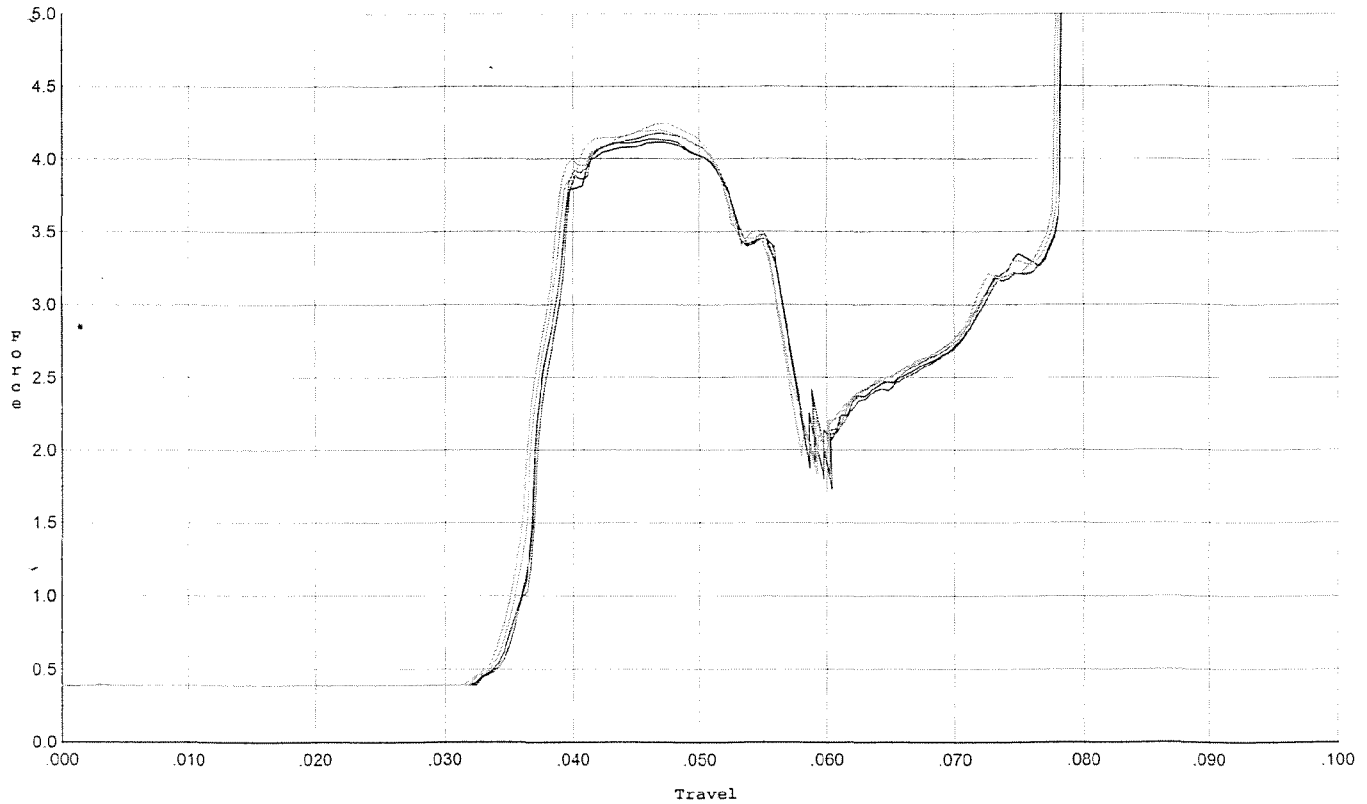
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.419	0.053	0.034	0.039	0.050		Set Trigger
2	2.466	0.052	0.033	0.040	0.050		Set Trigger
3	2.469	0.052	0.033	0.040	0.051		Set Trigger
4	2.455	0.052	0.034	0.040	0.050		Set Trigger
5	2.455	0.052	0.033	0.040	0.051		Set Trigger

Aug 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: 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	4.134	0.056	0.035	0.026	0.088		Set Trigger
2	4.117	0.056	0.035	0.026	0.089		Set Trigger
3	4.177	0.056	0.035	0.026	0.089		Set Trigger
4	4.196	0.055	0.034	0.026	0.089		Set Trigger
5	4.244	0.055	0.034	0.026	0.090		Set Trigger

avg 4.17