

66794510

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



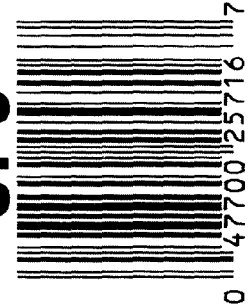
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794510

UPC



GUN SERIAL #

G 6794510

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SP
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SP
460	CHECK HEADSPACE		11-3-08	SP
470	DIS-ASSEMBLE ACTION		11-3-08	SP
472	SERIALIZE BOLT HANDLE		11-4-08	BSR
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION	MAGNA-FLUX 2008 OPERATOR 	11/6/08	KB
490	MAGNAFLUX BOLT		11/3/08	MR
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		11-8	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-13-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

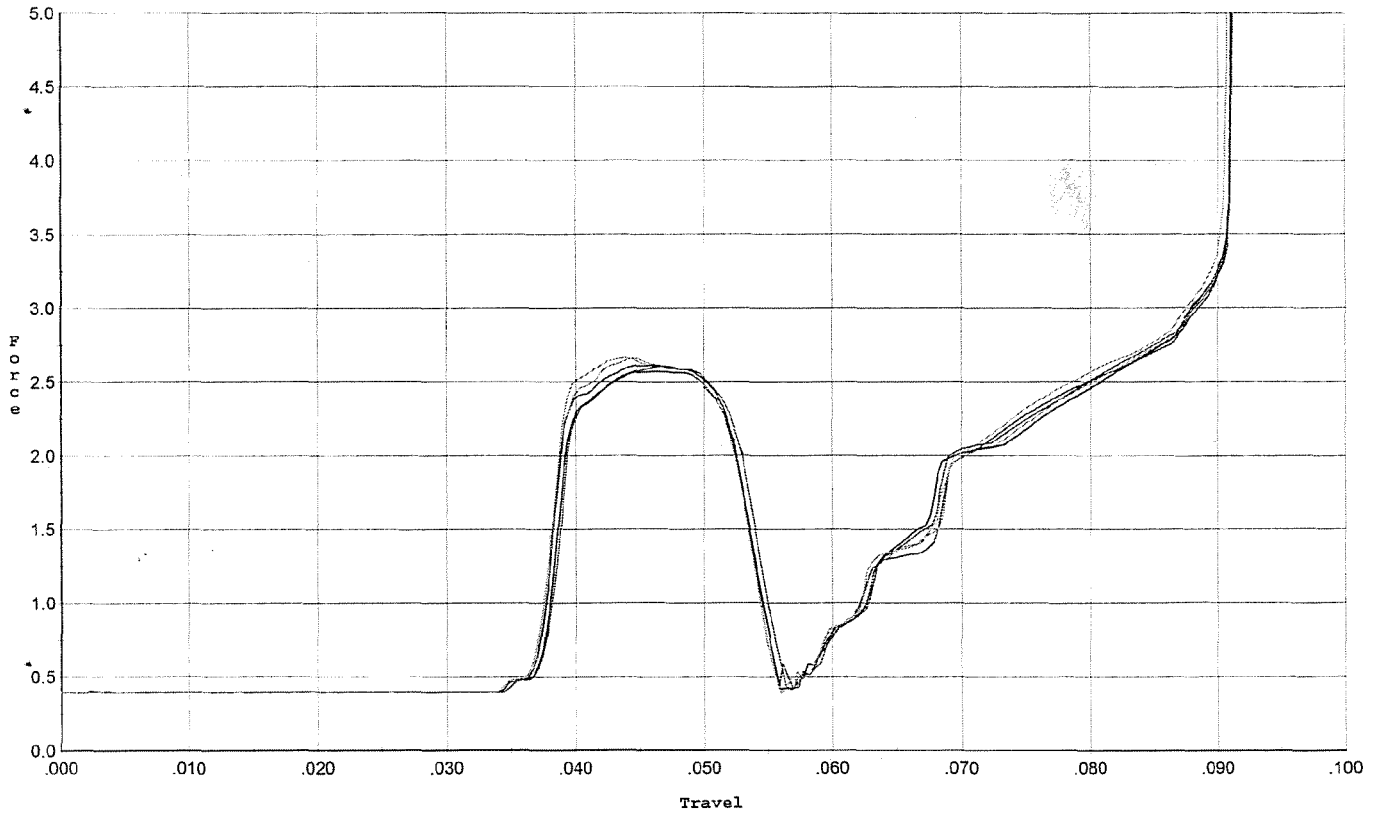
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>3.0</u> <u>3.0</u>	11-20-08	L.P.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.0</u> <u>4.0</u>	11-20-08	L.H.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-20-08	L.P.
	J) ASSEMBLE STOCK		11-23-08	LT
	K) ASSEMBLE SWIVEL STUDS		11-20-08	L.H.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-20-08	L.H.
	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	11-14-08	L.P.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-14-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-20-08	L.P.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.61</u> <u>2.66</u> <u>2.60</u> <u>2.56</u>	11-20-08	TC
	C) FUNCTION		11-20-08	L.P.
690	PACK		12-2-08	TC

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.



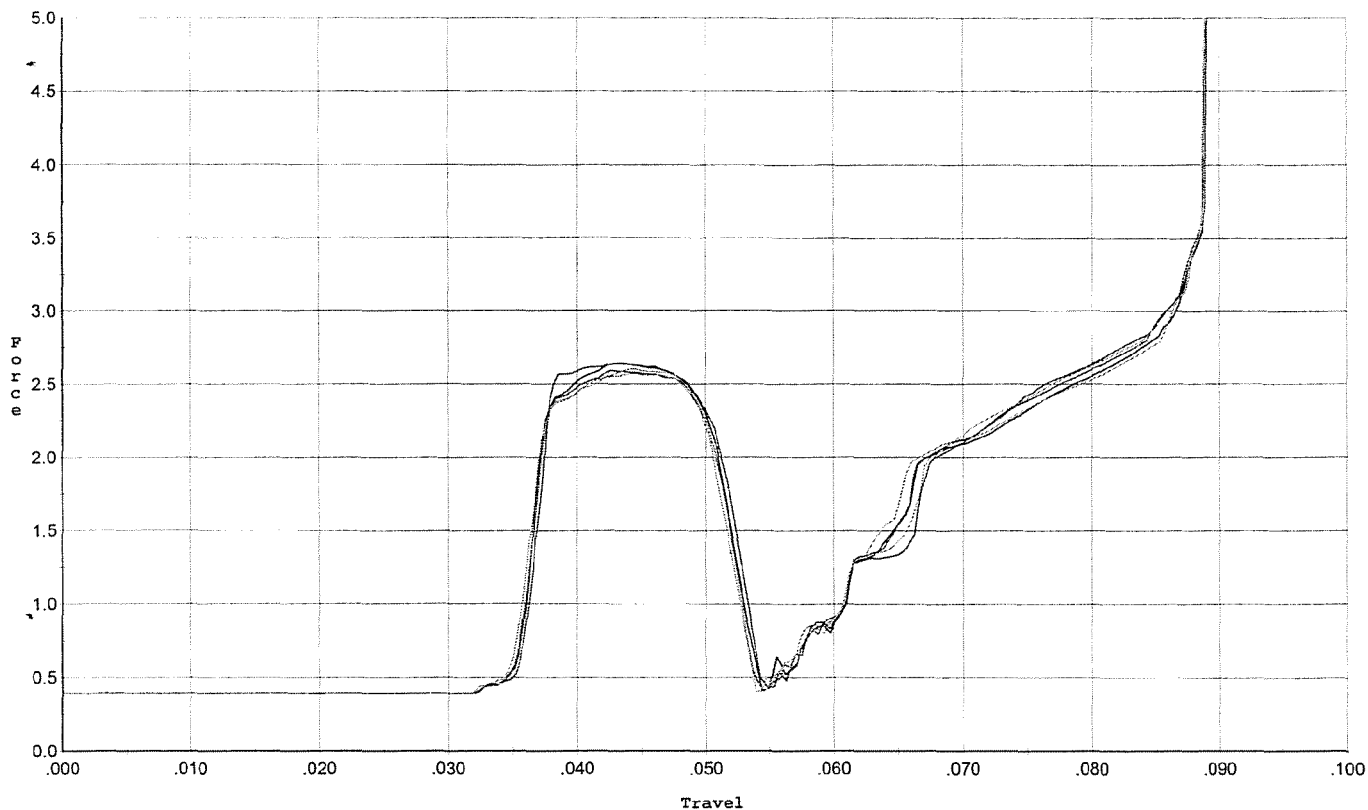
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.610	0.052	0.037	0.041	0.051		Set Trigger
2	2.571	0.052	0.037	0.041	0.050		Set Trigger
3	2.605	0.053	0.038	0.041	0.051		Set Trigger
4	2.662	0.053	0.037	0.041	0.052		Set Trigger
5	2.661	0.052	0.037	0.042	0.052		Set Trigger

Avg 2.62

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.



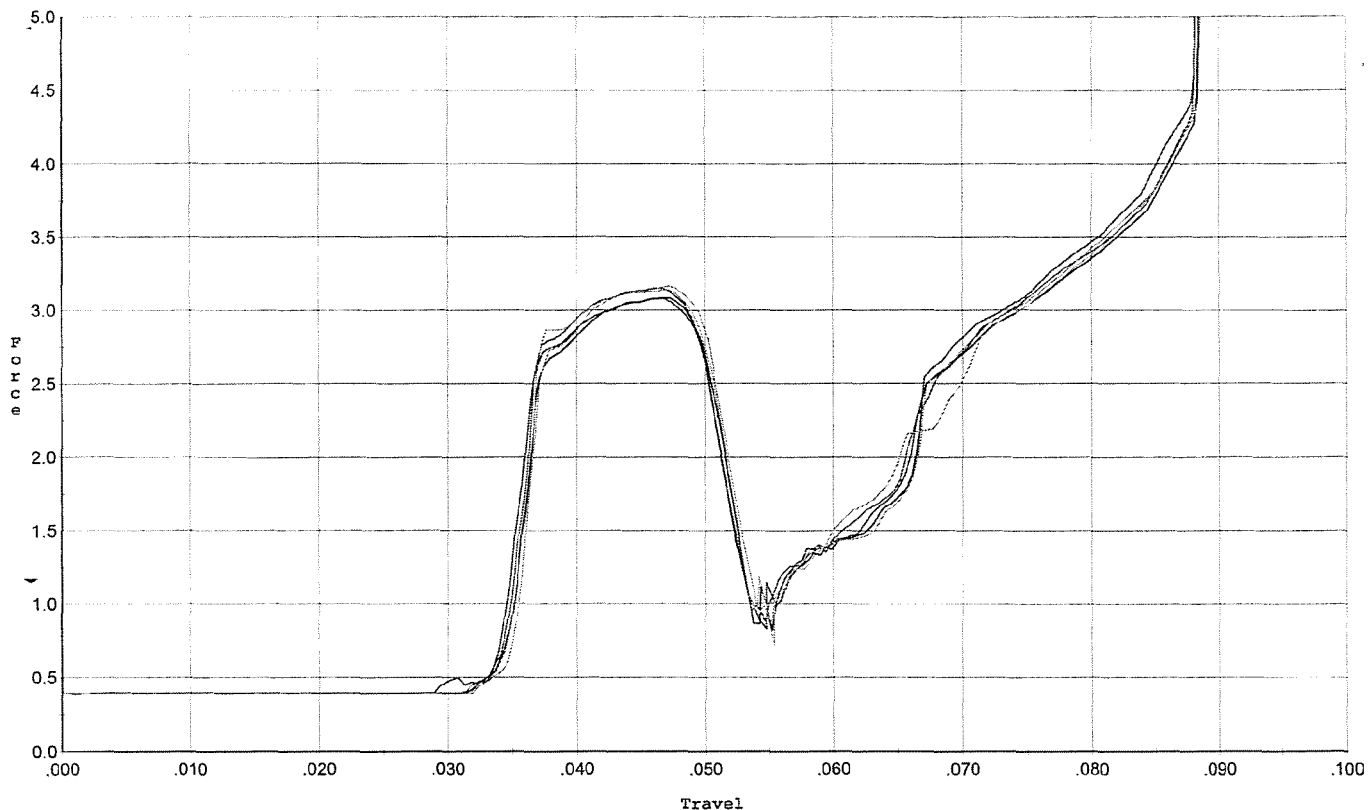
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.052	0.036	0.040	0.053		Set Trigger
2	2.642	0.051	0.035	0.041	0.051		Set Trigger
3	2.593	0.051	0.035	0.041	0.051		Set Trigger
4	2.571	0.052	0.035	0.041	0.052		Set Trigger
5	2.602	0.051	0.035	0.041	0.051		Set Trigger

Avg 2.61

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.



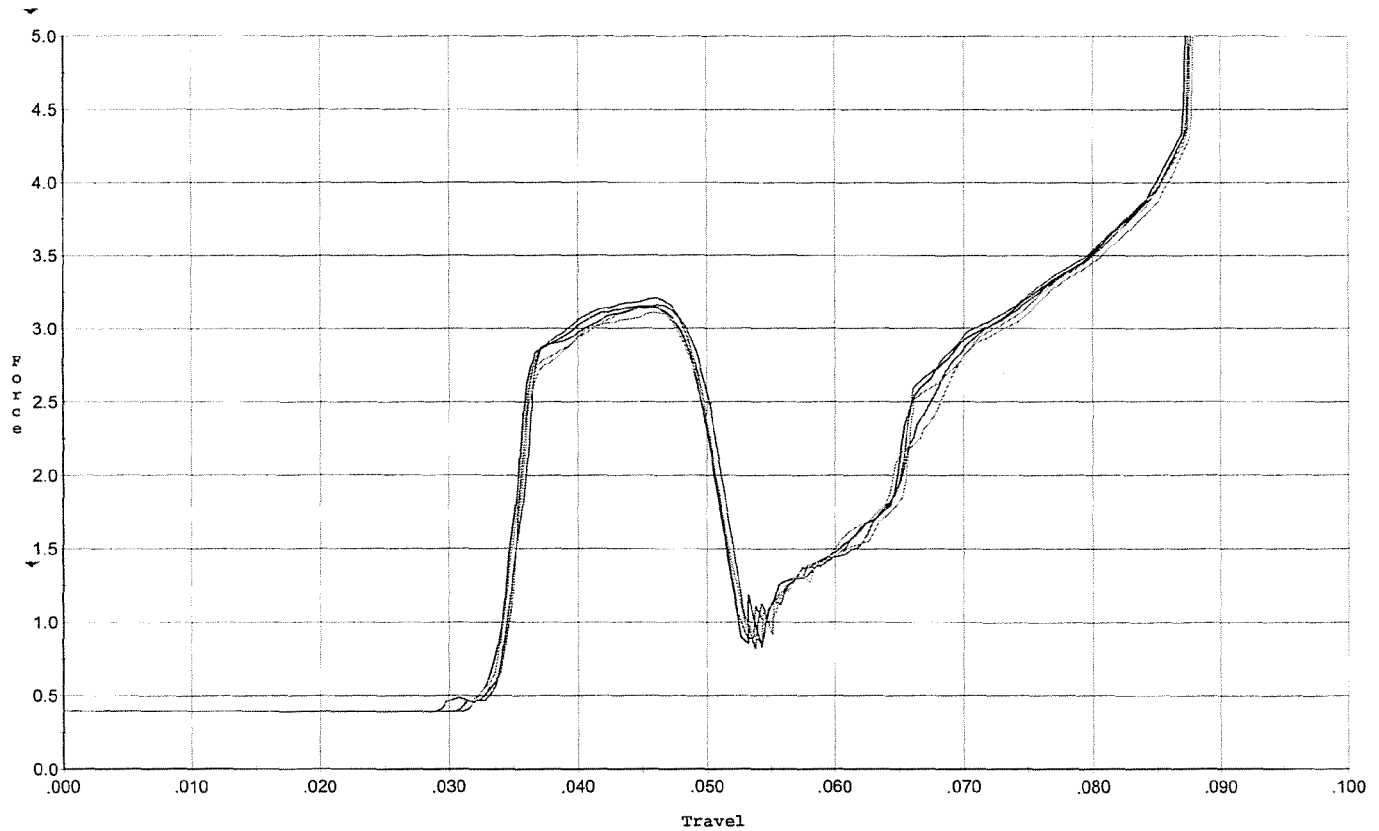
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.080	0.050	0.034	0.039	0.058		Set Trigger
2	3.082	0.051	0.034	0.039	0.059		Set Trigger
3	3.150	0.050	0.034	0.039	0.058		Set Trigger
4	3.137	0.051	0.034	0.039	0.059		Set Trigger
5	3.163	0.050	0.035	0.039	0.058		Set Trigger

Avg 3.12

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.



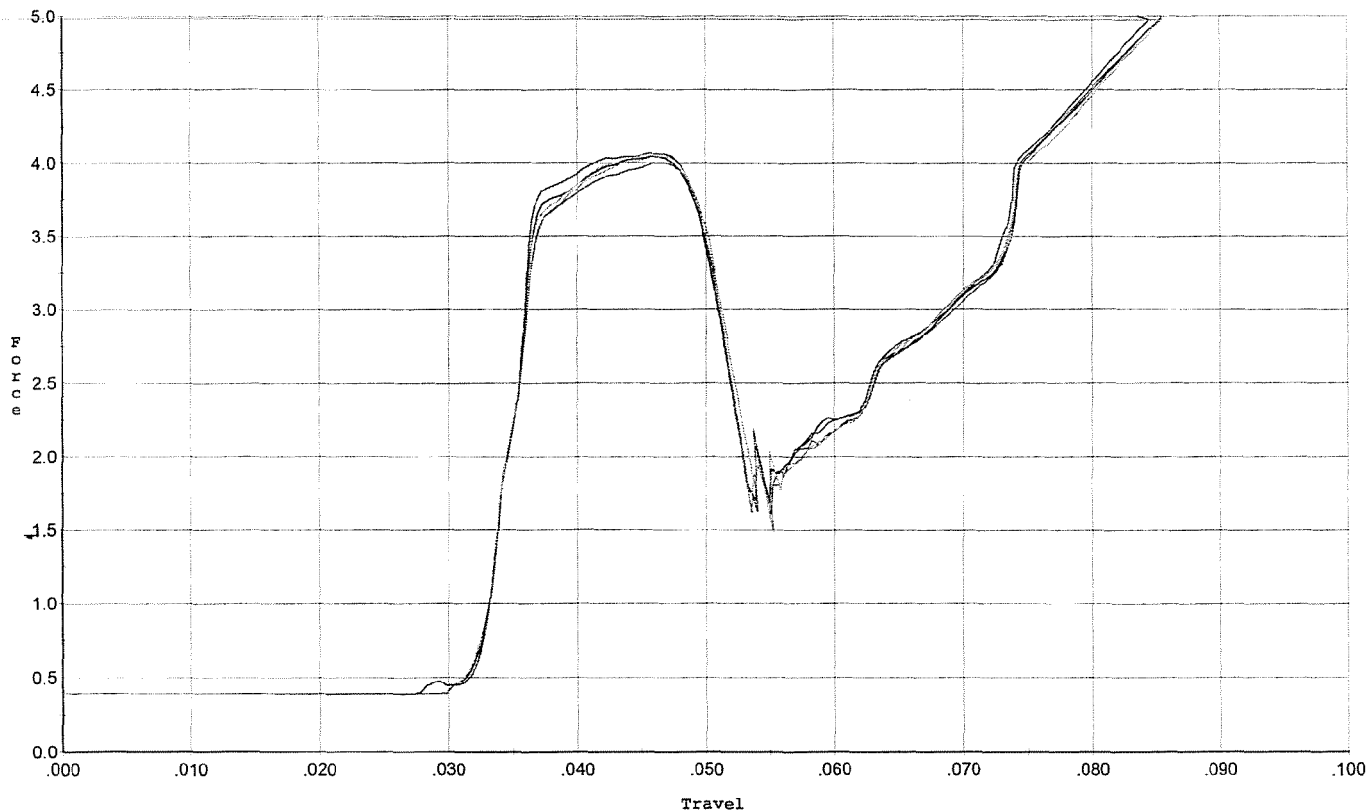
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.050	0.034	0.039	0.060		Set Trigger
2	3.150	0.050	0.033	0.039	0.060		Set Trigger
3	3.206	0.050	0.034	0.039	0.059		Set Trigger
4	3.106	0.049	0.033	0.040	0.057		Set Trigger
5	3.142	0.050	0.034	0.040	0.058		Set Trigger

Avg 3.15

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. ini. +/- 1.0 lbs.



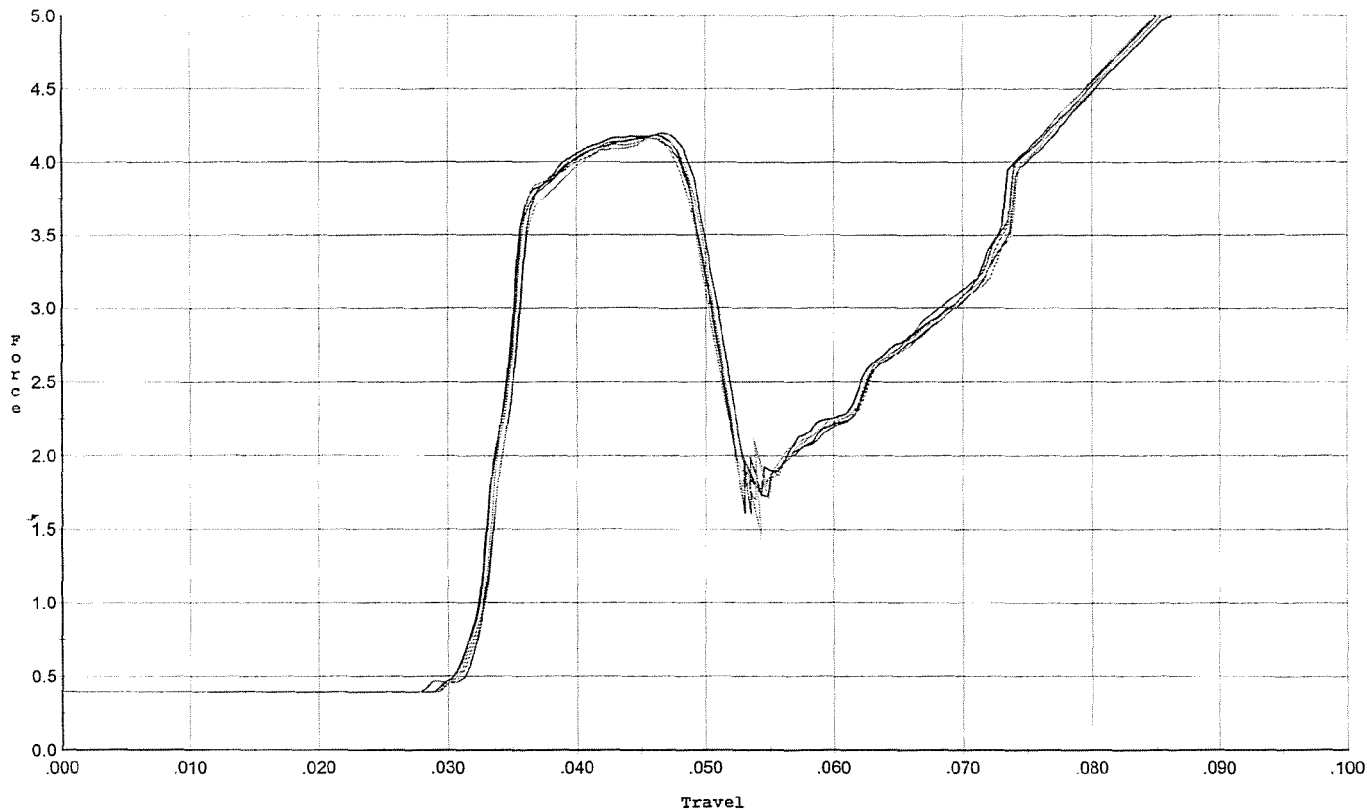
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.066	0.051	0.032	0.036	0.077		Set Trigger
2	4.045	0.051	0.032	0.036	0.077		Set Trigger
3	4.002	0.051	0.032	0.036	0.076		Set Trigger
4	4.041	0.051	0.032	0.036	0.077		Set Trigger
5	4.066	0.050	0.032	0.036	0.076		Set Trigger

Avg 4.04

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.



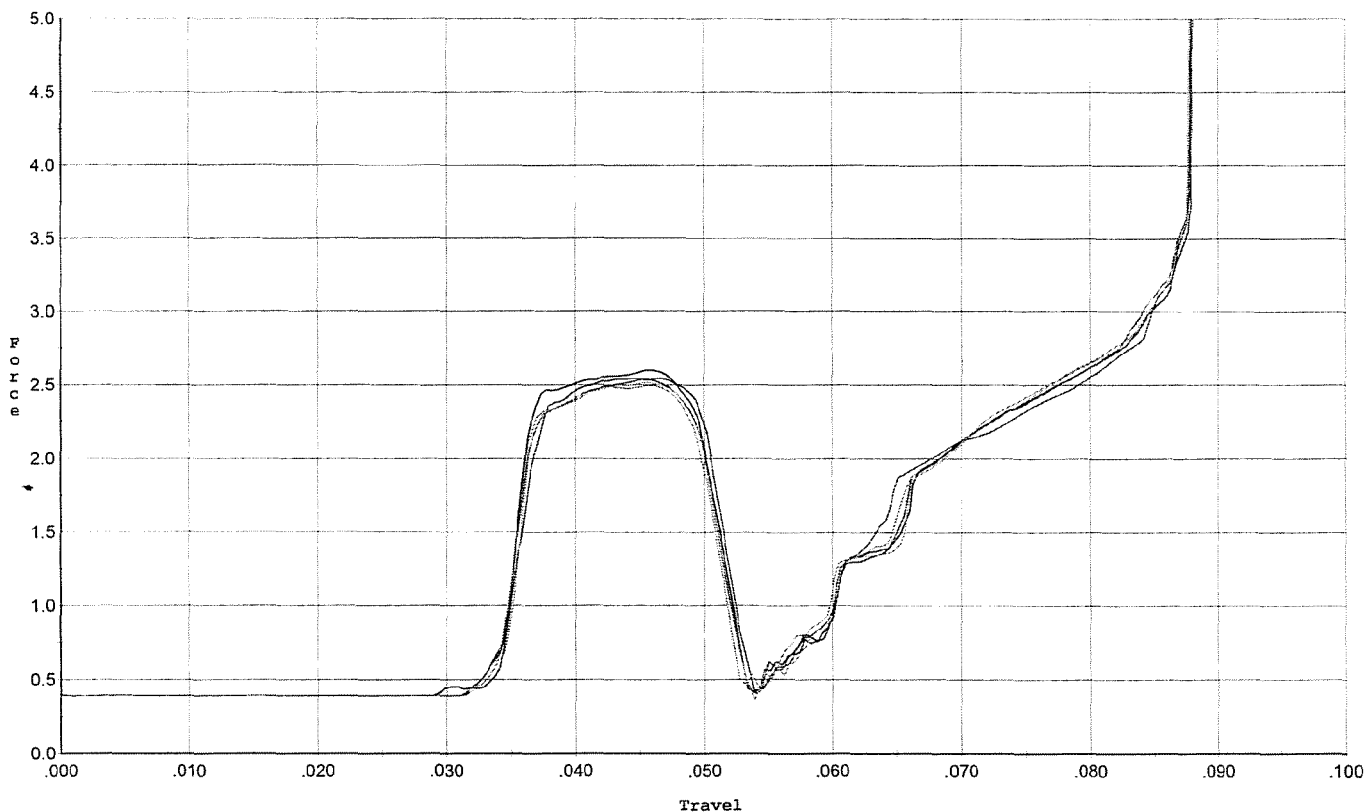
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.198	0.051	0.032	0.036	0.080		Set Trigger
2	4.183	0.050	0.031	0.036	0.080		Set Trigger
3	4.163	0.050	0.031	0.036	0.079		Set Trigger
4	4.163	0.050	0.032	0.037	0.076		Set Trigger
5	4.158	0.049	0.031	0.036	0.075		Set Trigger

Aug 4.17

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



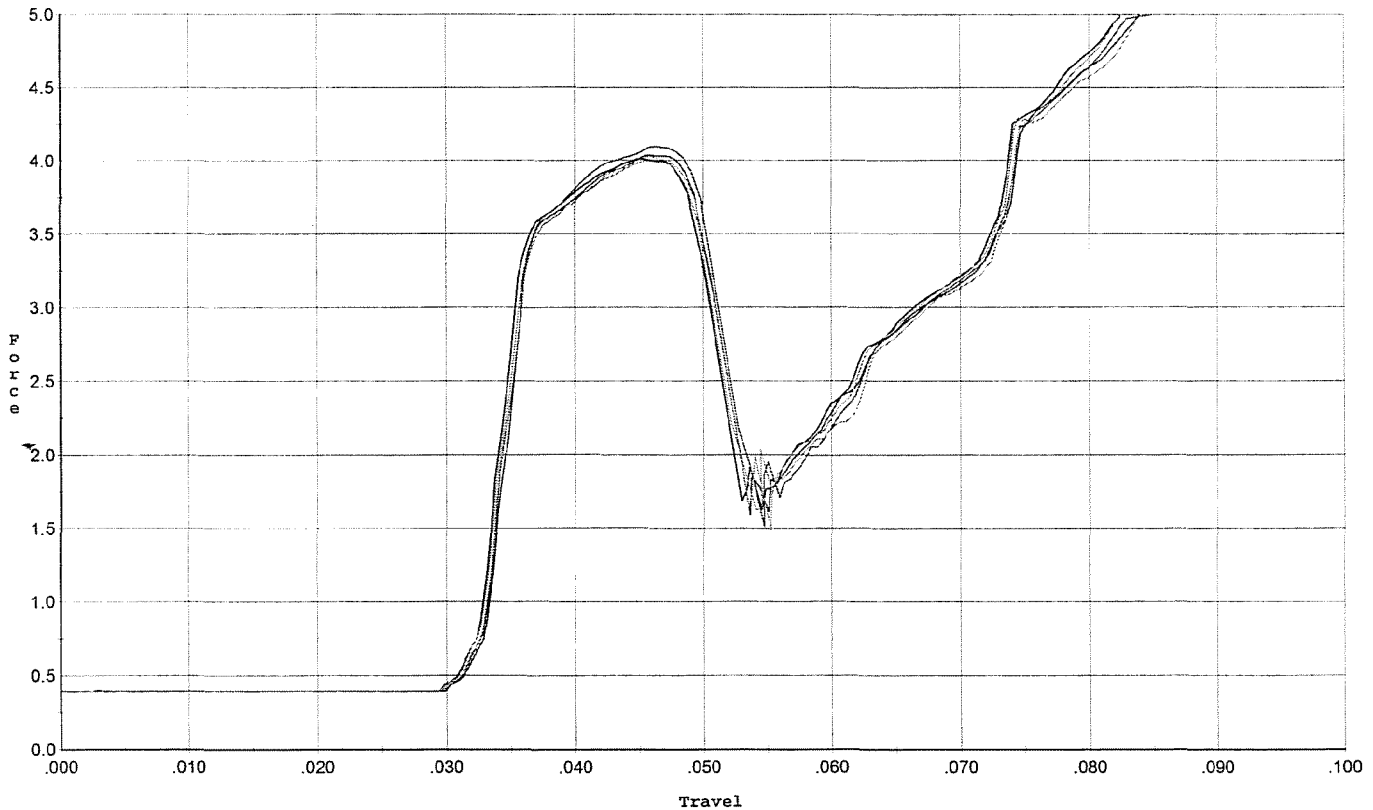
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.545	0.050	0.034	0.040	0.051		Set Trigger
2	2.601	0.051	0.034	0.040	0.053		Set Trigger
3 →	2.539	0.050	0.033	0.041	0.050		Set Trigger
4	2.516	0.050	0.034	0.041	0.049		Set Trigger
5	2.496	0.050	0.034	0.041	0.050		Set Trigger

Aug 2.53

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 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	4.036	0.051	0.032	0.037	0.076		Set Trigger
2	4.010	0.050	0.031	0.036	0.076		Set Trigger
3	4.094	0.050	0.032	0.037	0.076		Set Trigger
4	4.024	0.051	0.032	0.036	0.076		Set Trigger
5	3.996	0.050	0.031	0.037	0.074		Set Trigger

Avg 4.03