

56794511

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

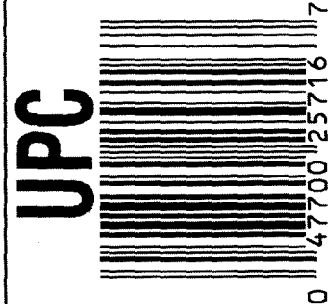


owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794511



GUN SERIAL #

G6794511

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	RT
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION		11/6/08	MR
490	MAGNAFLUX BOLT		11/6/08	RT
500	ROLLMARK CALIBER			
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		11/15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-18-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

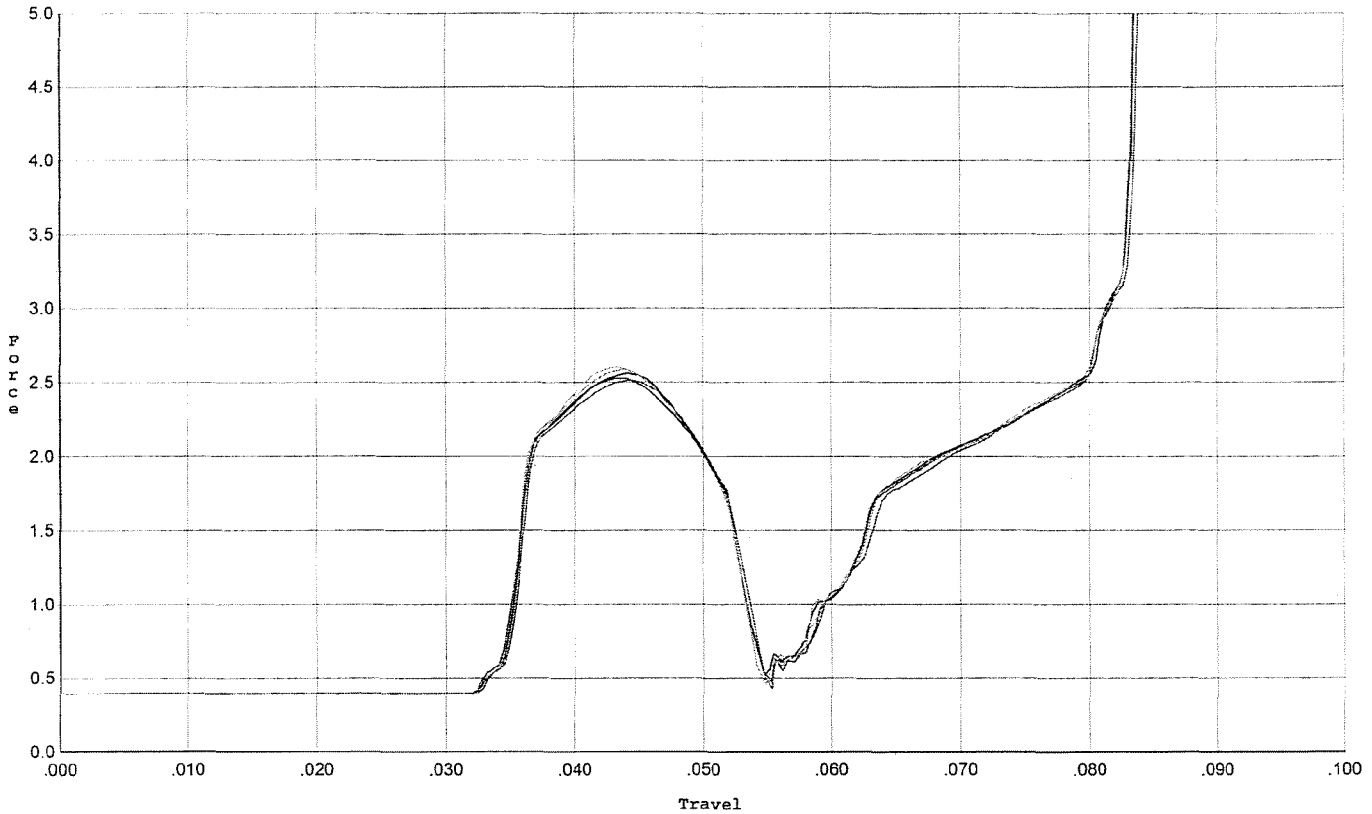
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-20-08	LD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7.0</u> <u>7.0</u> <u>7.0</u>	11-20-08	LD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	11-20-08	LD
	J) ASSEMBLE STOCK		11-18-08	LD
	K) ASSEMBLE SWIVEL STUDS		11-20-08	LD
	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	11-19-08	TC
	MALFUNCTION	CORRECTION	n/a	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	LD
670	FINAL INSPECTION A) HEADSPACE		11-20-08	LD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.76</u> <u>2.81</u> <u>2.82</u> <u>2.86</u>	11-20-08	TC
	C) FUNCTION		11-20-08	LD
690	PACK		12-1-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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



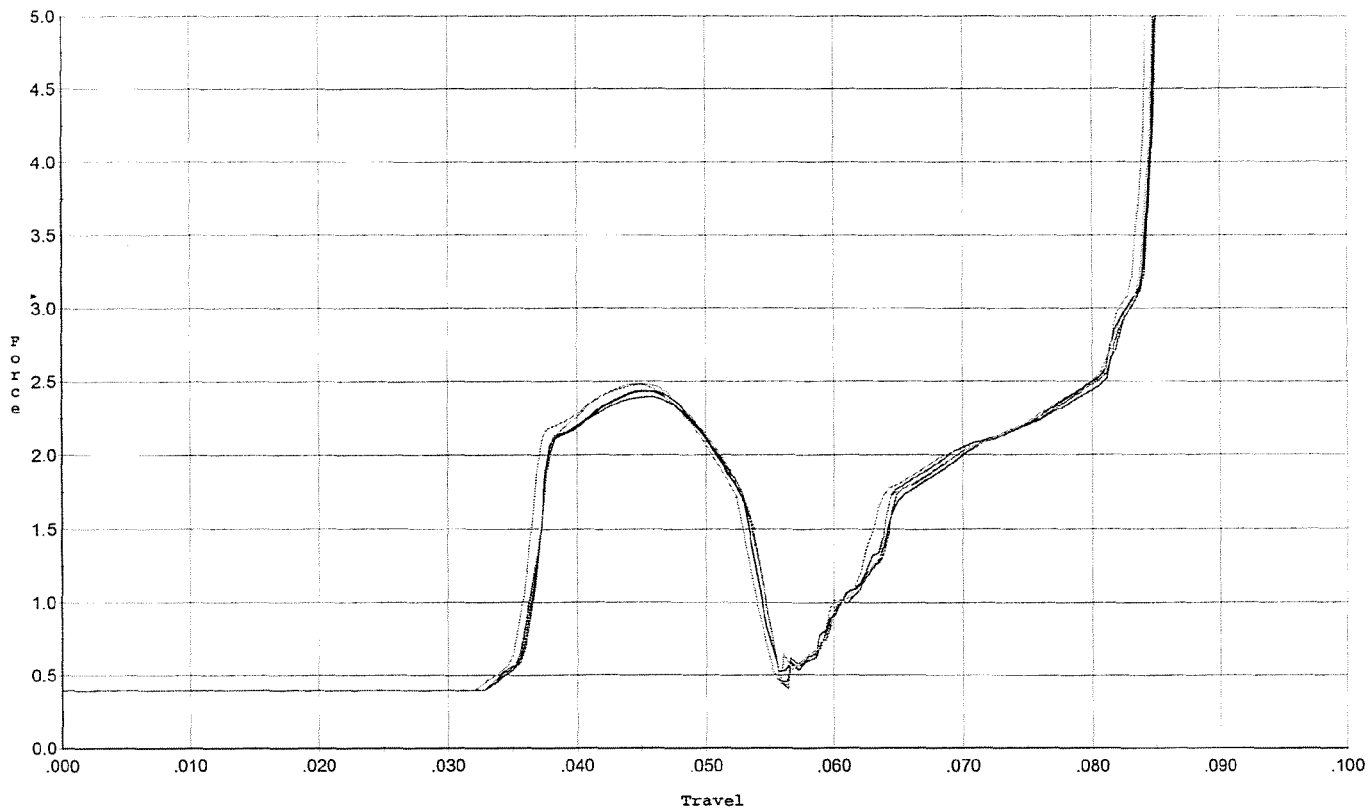
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.527	0.052	0.033	0.036	0.052		Set Trigger
2	2.560	0.052	0.033	0.036	0.052		Set Trigger
3	2.513	0.053	0.033	0.036	0.053		Set Trigger
4	2.601	0.052	0.033	0.036	0.052		Set Trigger
5	2.585	0.052	0.033	0.036	0.052		Set Trigger

Aug 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/13/08

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



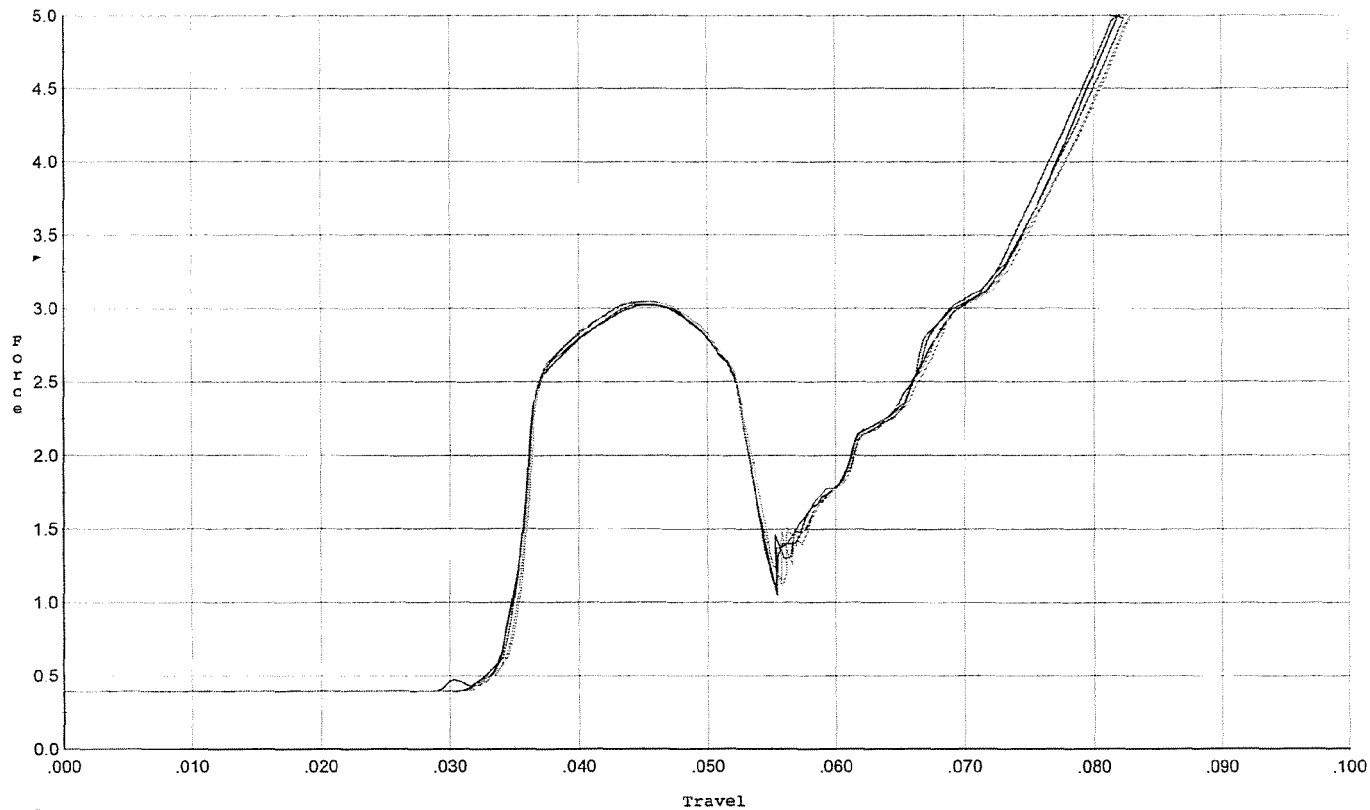
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.439	0.054	0.036	0.037	0.052		Set Trigger
2	2.430	0.053	0.036	0.037	0.051		Set Trigger
3	2.395	0.054	0.036	0.037	0.052		Set Trigger
4	2.485	0.054	0.036	0.037	0.053		Set Trigger
5	2.479	0.052	0.035	0.037	0.051		Set Trigger

Aug 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .50 lbs.



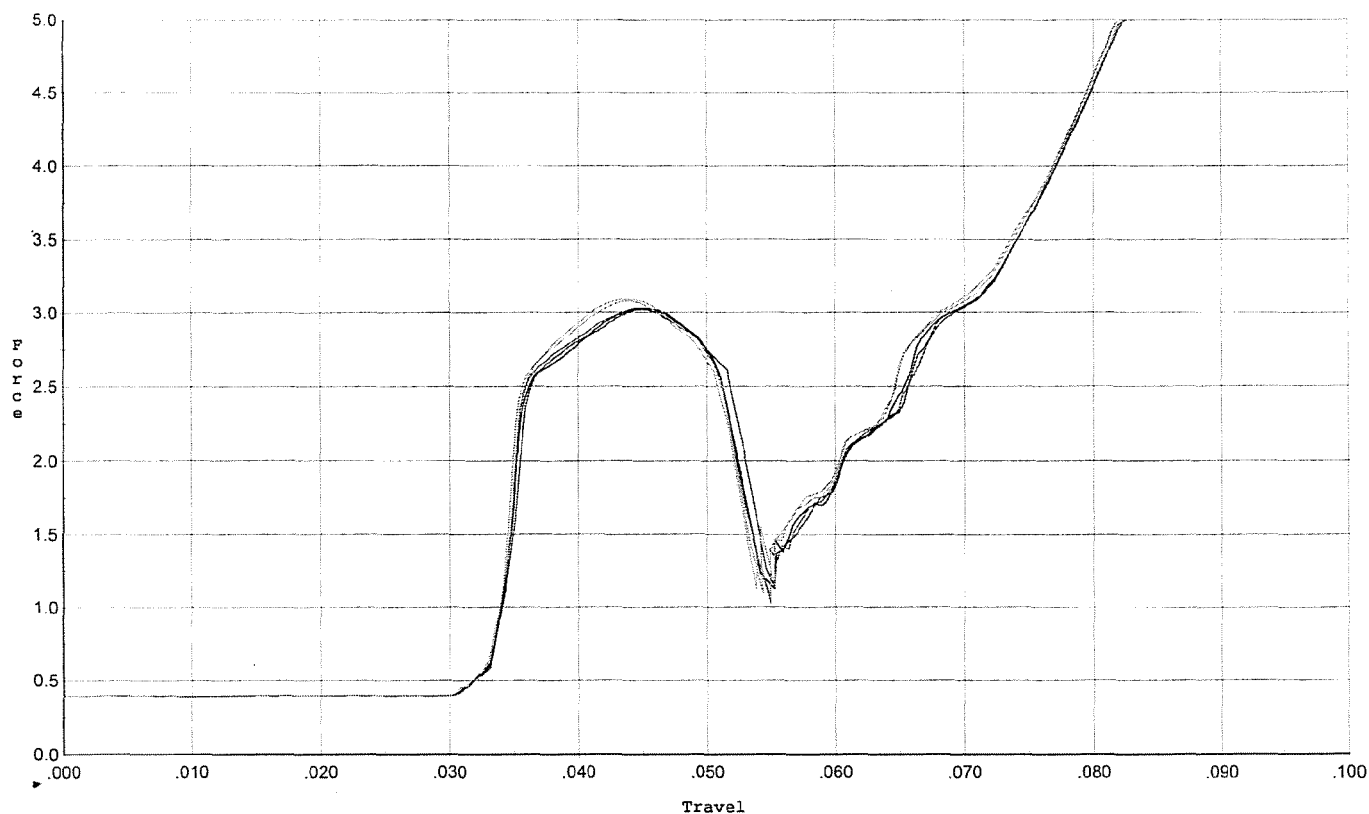
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.020	0.052	0.034	0.035	0.062		Set Trigger
2	3.048	0.052	0.034	0.035	0.063		Set Trigger
3	3.029	0.052	0.034	0.035	0.062		Set Trigger
4	3.050	0.054	0.034	0.035	0.064		Set Trigger
5	3.052	0.052	0.034	0.036	0.062		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/13/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .50 lbs.



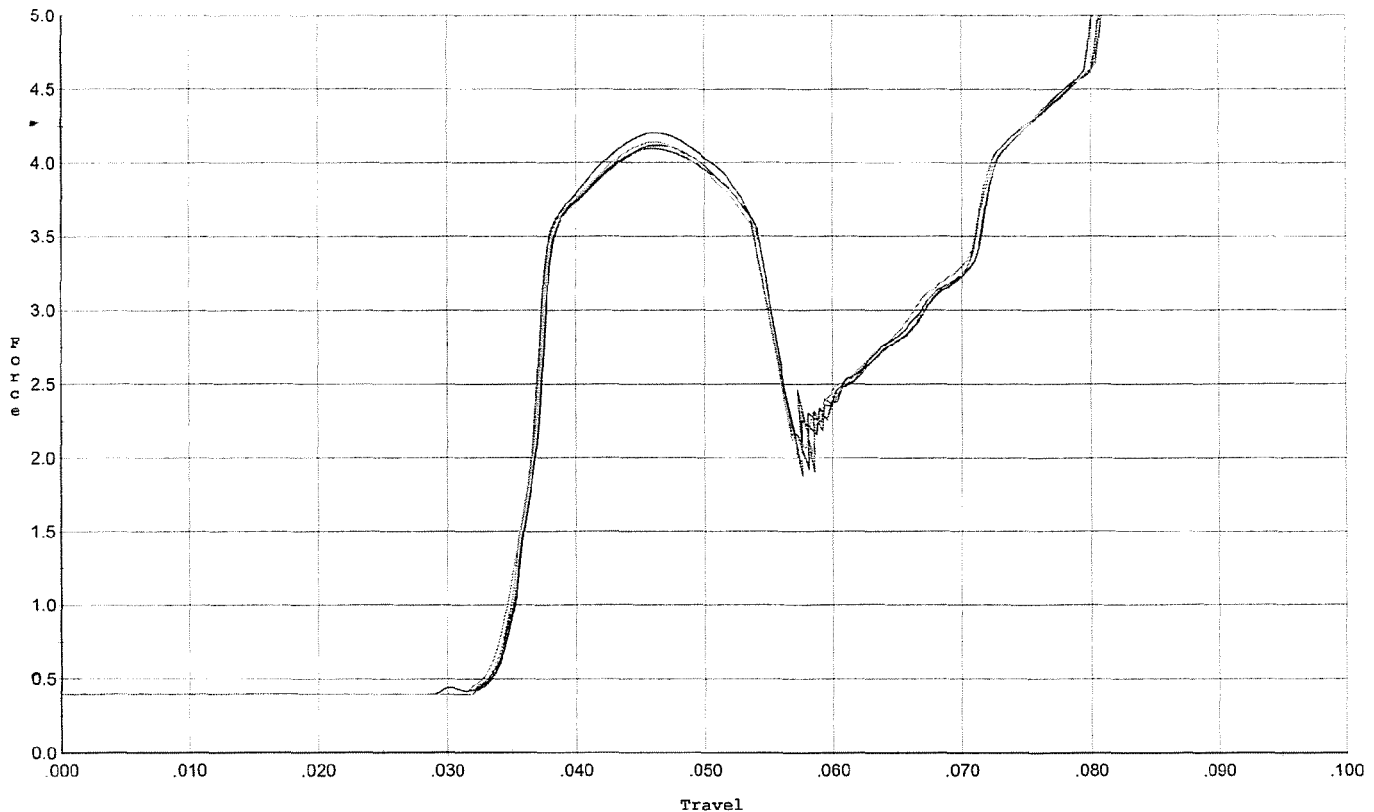
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.021	0.053	0.033	0.035	0.064		Set Trigger
2	3.032	0.053	0.033	0.035	0.064		Set Trigger
3	3.022	0.051	0.033	0.035	0.062		Set Trigger
4	3.082	0.052	0.033	0.035	0.063		Set Trigger
5	3.093	0.051	0.033	0.035	0.063		Set Trigger

Aug 3.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/13/08

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



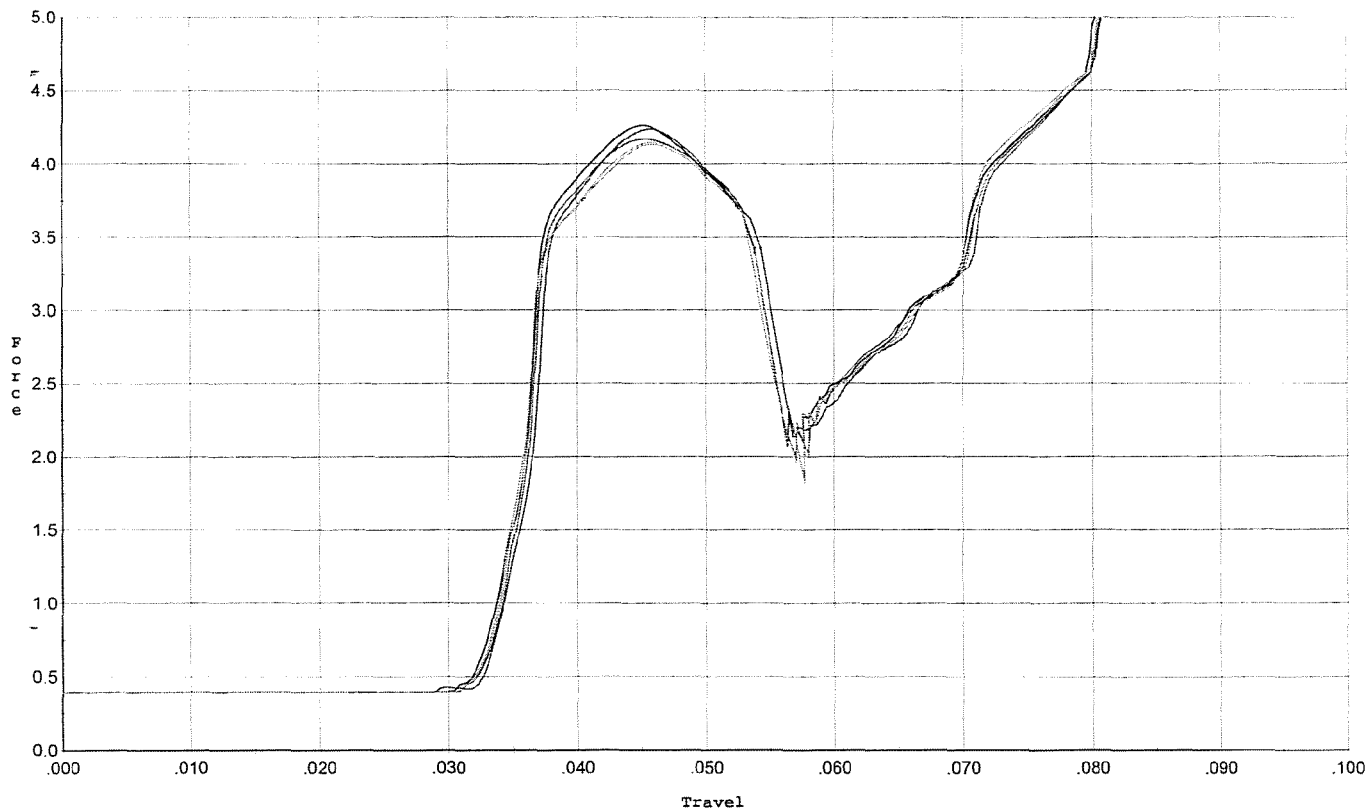
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.204	0.055	0.034	0.030	0.088		Set Trigger
2	4.120	0.054	0.034	0.031	0.085		Set Trigger
3	4.096	0.054	0.034	0.031	0.085		Set Trigger
4	4.142	0.055	0.034	0.031	0.087		Set Trigger
5	4.114	0.054	0.032	0.031	0.086		Set Trigger

Aug 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



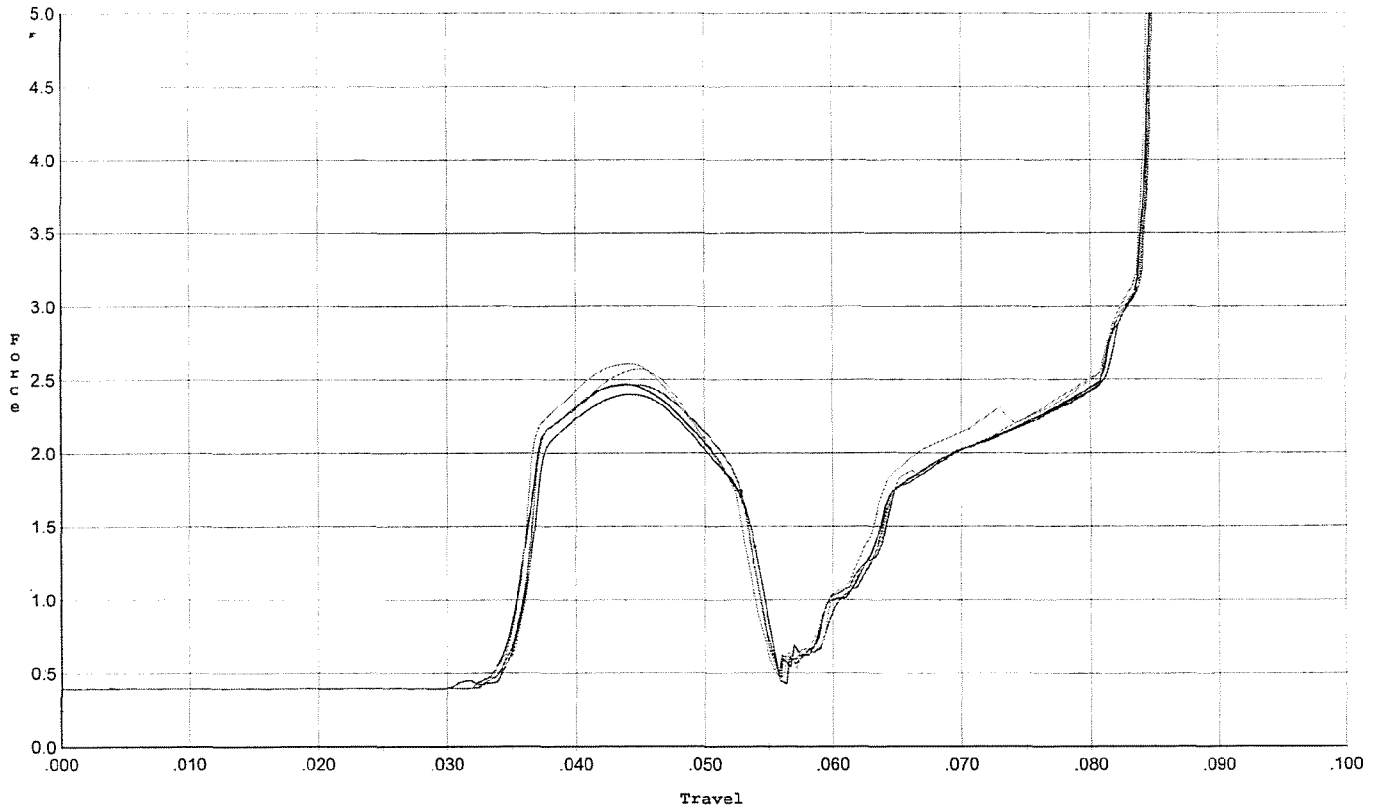
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.234	0.054	0.033	0.031	0.087		Set Trigger
2	4.259	0.054	0.032	0.031	0.088		Set Trigger
3	4.167	0.054	0.033	0.032	0.086		Set Trigger
4	4.129	0.054	0.033	0.031	0.086		Set Trigger
5	4.144	0.053	0.032	0.032	0.084		Set Trigger

Avg 4.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/13/08

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



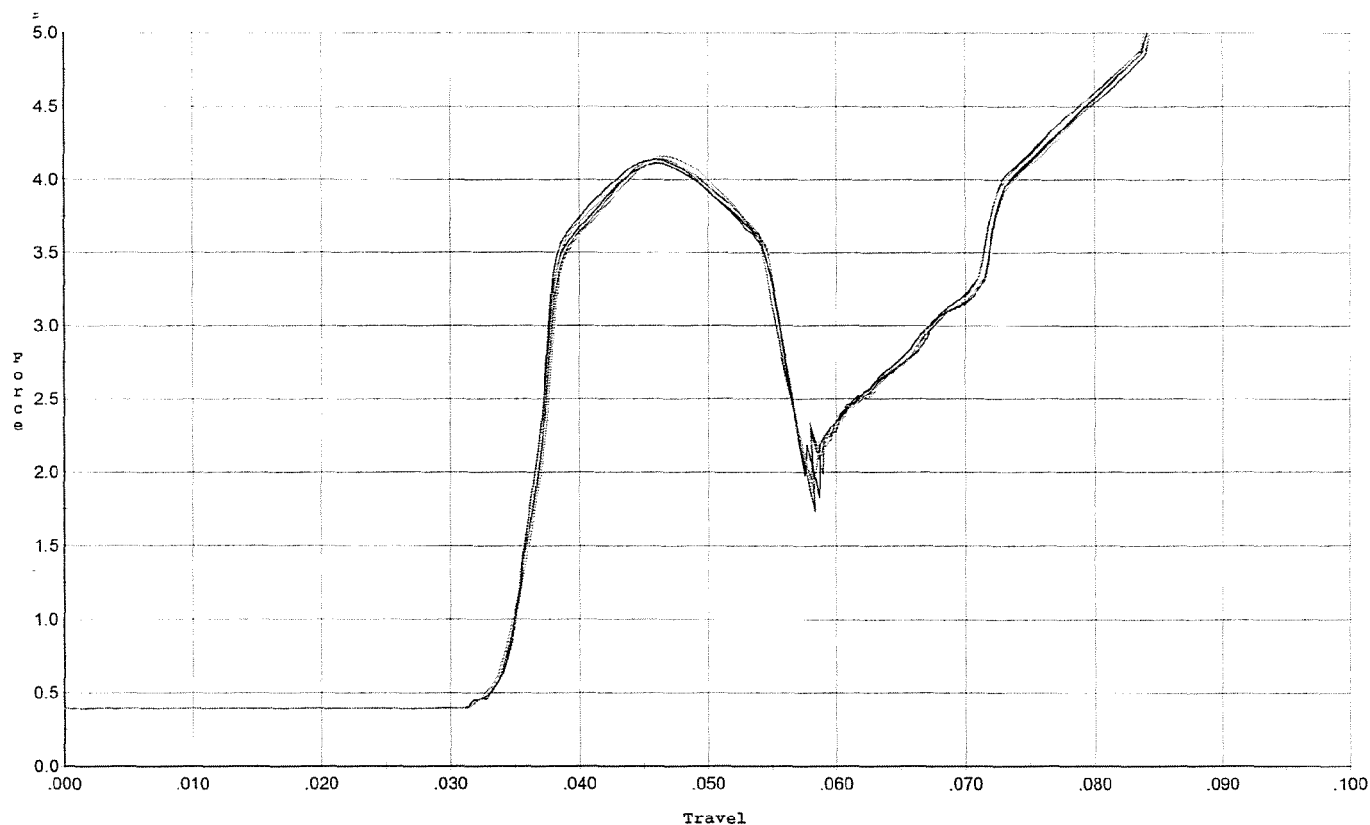
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.399	0.054	0.034	0.037	0.052		Set Trigger
2	2.469	0.053	0.034	0.036	0.053		Set Trigger
3	2.466	0.053	0.034	0.037	0.053		Set Trigger
4	2.572	0.053	0.035	0.037	0.053		Set Trigger
5	2.607	0.052	0.034	0.036	0.053		Set Trigger

Aug 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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	4.136	0.054	0.034	0.034	0.085		Set Trigger
2	4.112	0.055	0.034	0.034	0.087		Set Trigger
3	4.139	0.055	0.033	0.034	0.086		Set Trigger
4	4.131	0.055	0.034	0.034	0.086		Set Trigger
5	4.160	0.054	0.034	0.034	0.085		Set Trigger

Aug 4.13