

G6794518

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



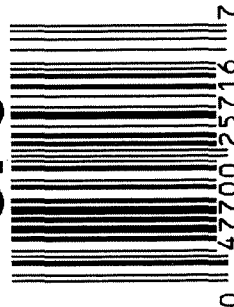
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794518

UPC



GUN SERIAL #

G6794518

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	SP
490	MAGNAFLUX BOLT		11/3/08	RT
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/2/08	DS
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	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

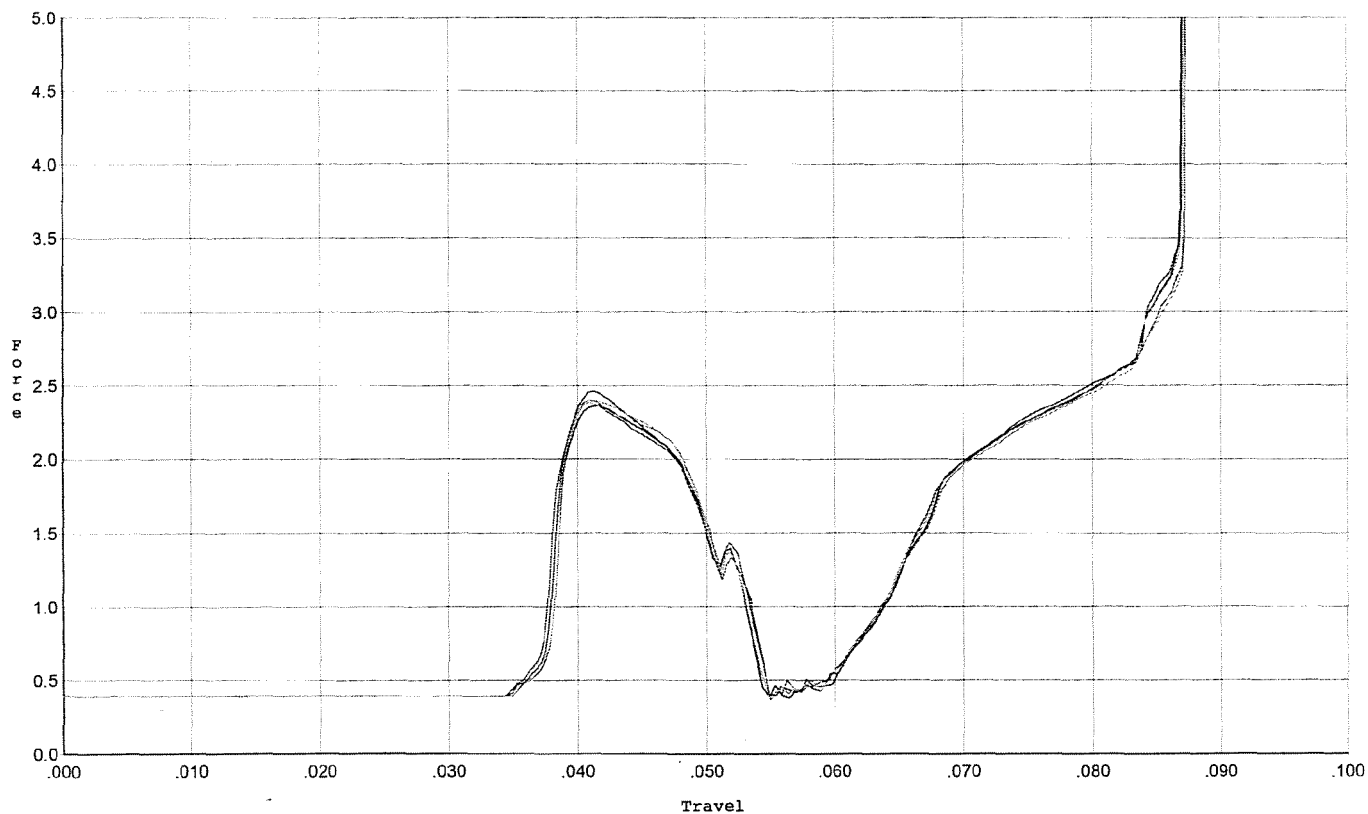
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>4.0</u> <u>4.0</u>	12-2-08	L. N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	12-2-08	L. N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.084</u> <u>.025</u> <u>.025</u>	12-2-08	L. N.
	J) ASSEMBLE STOCK		11-18-08	PSN
	K) ASSEMBLE SWIVEL STUDS		12-2-08	L. N.
	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	11-18-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	L. N.
670	FINAL INSPECTION A) HEADSPACE		12-2-08	L. N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u> <u>2.74</u> <u>2.68</u> <u>2.70</u> <u>2.71</u>	11-20-08	TC
	C) FUNCTION		12-2-08	L. N.
690	PACK		12-30-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

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



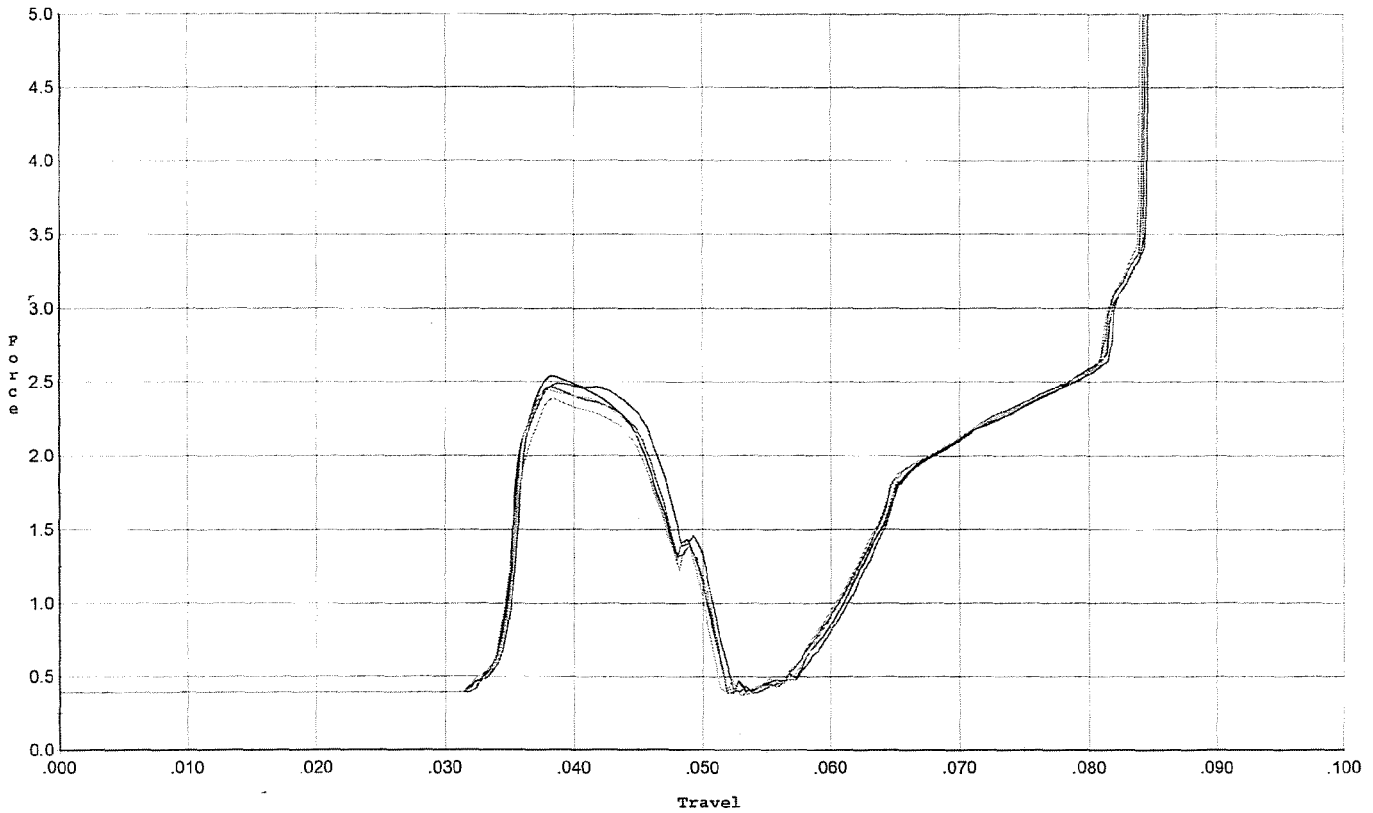
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.054	0.037	0.039	0.046		Set Trigger
2	2.360	0.053	0.038	0.039	0.044		Set Trigger
3	2.402	0.053	0.037	0.039	0.045		Set Trigger
4	2.381	0.053	0.038	0.039	0.044		Set Trigger
5	2.403	0.053	0.038	0.039	0.044		Set Trigger

Avg 2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



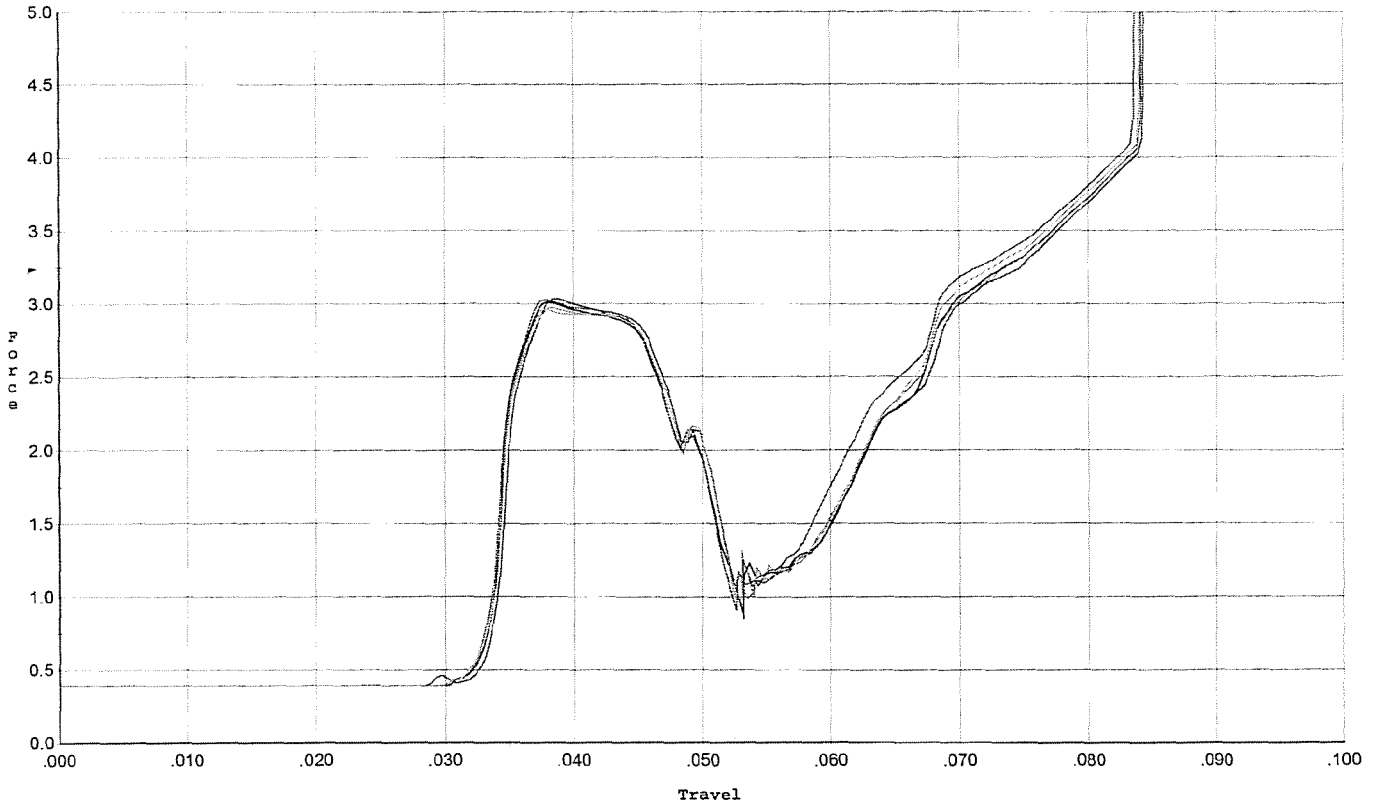
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.490	0.050	0.034	0.038	0.046		Set Trigger
2	2.542	0.051	0.034	0.038	0.046		Set Trigger
3	2.467	0.050	0.034	0.039	0.045		Set Trigger
4	2.445	0.050	0.034	0.038	0.045		Set Trigger
5	2.389	0.050	0.034	0.038	0.044		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. ini. +/- .75 lbs.



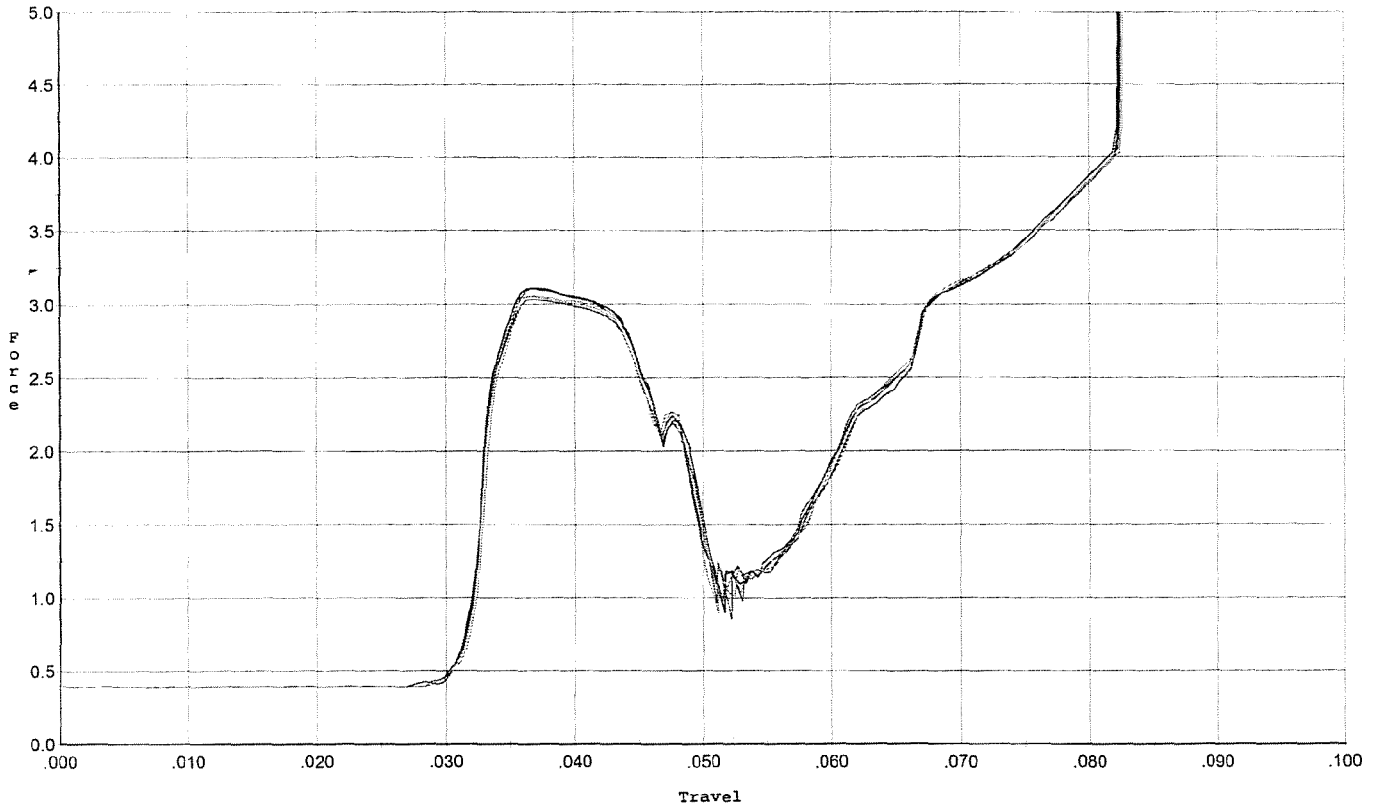
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.033	0.051	0.033	0.036	0.057		Set Trigger
2	3.014	0.050	0.033	0.036	0.056		Set Trigger
3	3.028	0.050	0.033	0.036	0.057		Set Trigger
4	2.962	0.051	0.033	0.036	0.058		Set Trigger
5	2.971	0.051	0.033	0.036	0.057		Set Trigger

Avg 3.00

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



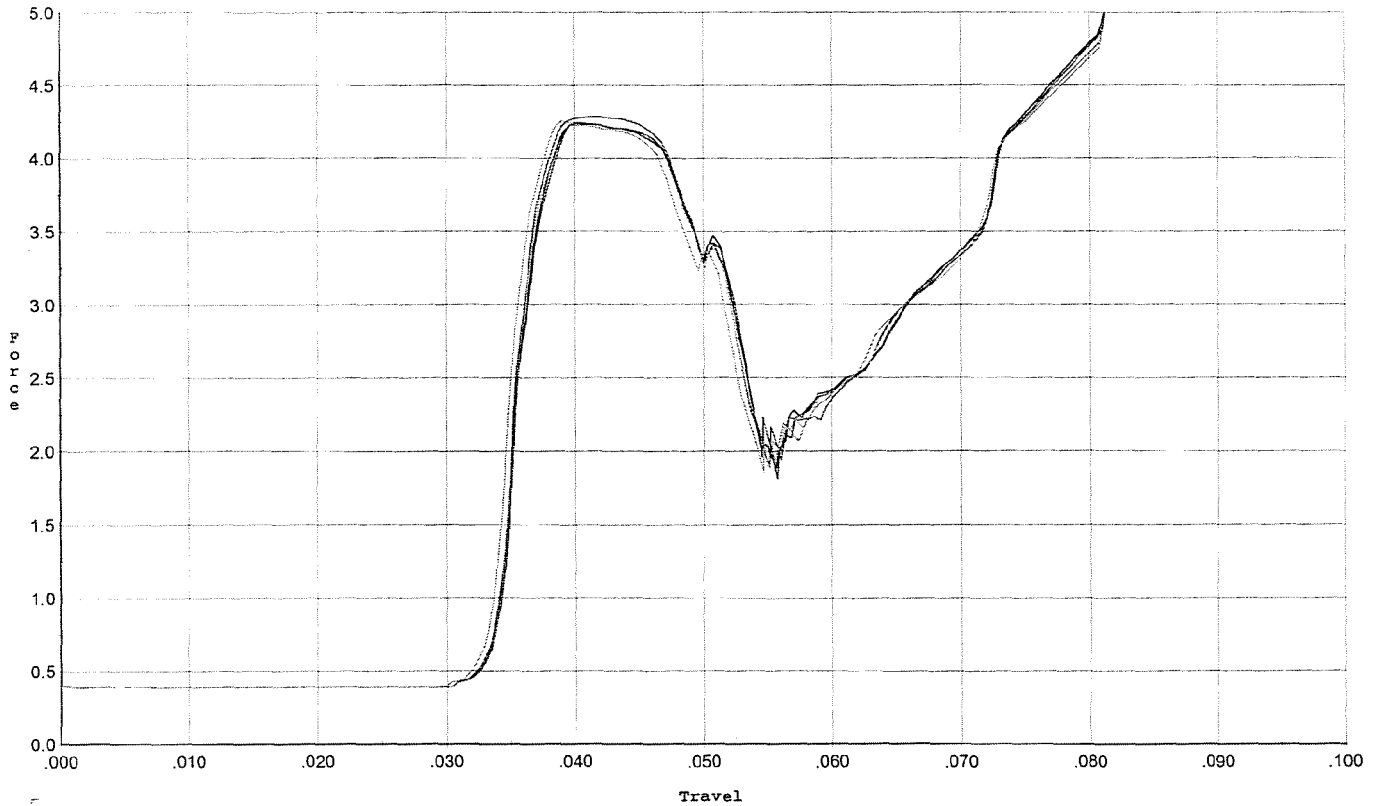
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.109	0.049	0.030	0.035	0.058		Set Trigger
2	3.107	0.048	0.031	0.036	0.057		Set Trigger
3	3.034	0.049	0.031	0.036	0.058		Set Trigger
4	3.060	0.048	0.032	0.036	0.056		Set Trigger
5	3.058	0.048	0.031	0.036	0.057		Set Trigger

Aug 3.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



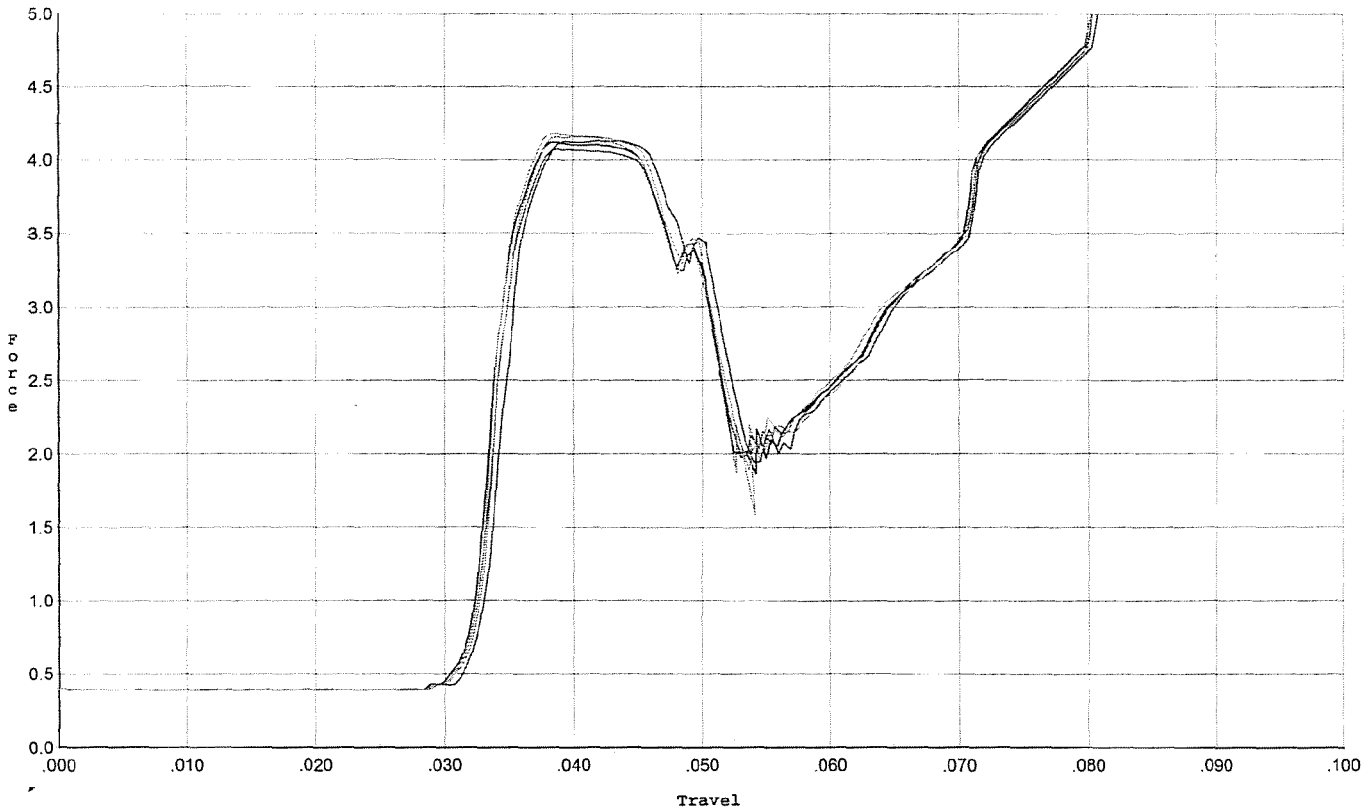
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.243	0.052	0.033	0.034	0.081		Set Trigger
2	4.236	0.053	0.033	0.033	0.082		Set Trigger
3	4.282	0.052	0.033	0.034	0.080		Set Trigger
4	4.227	0.052	0.033	0.034	0.080		Set Trigger
5	4.255	0.051	0.033	0.034	0.079		Set Trigger

Aug 4.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 11/14/08

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



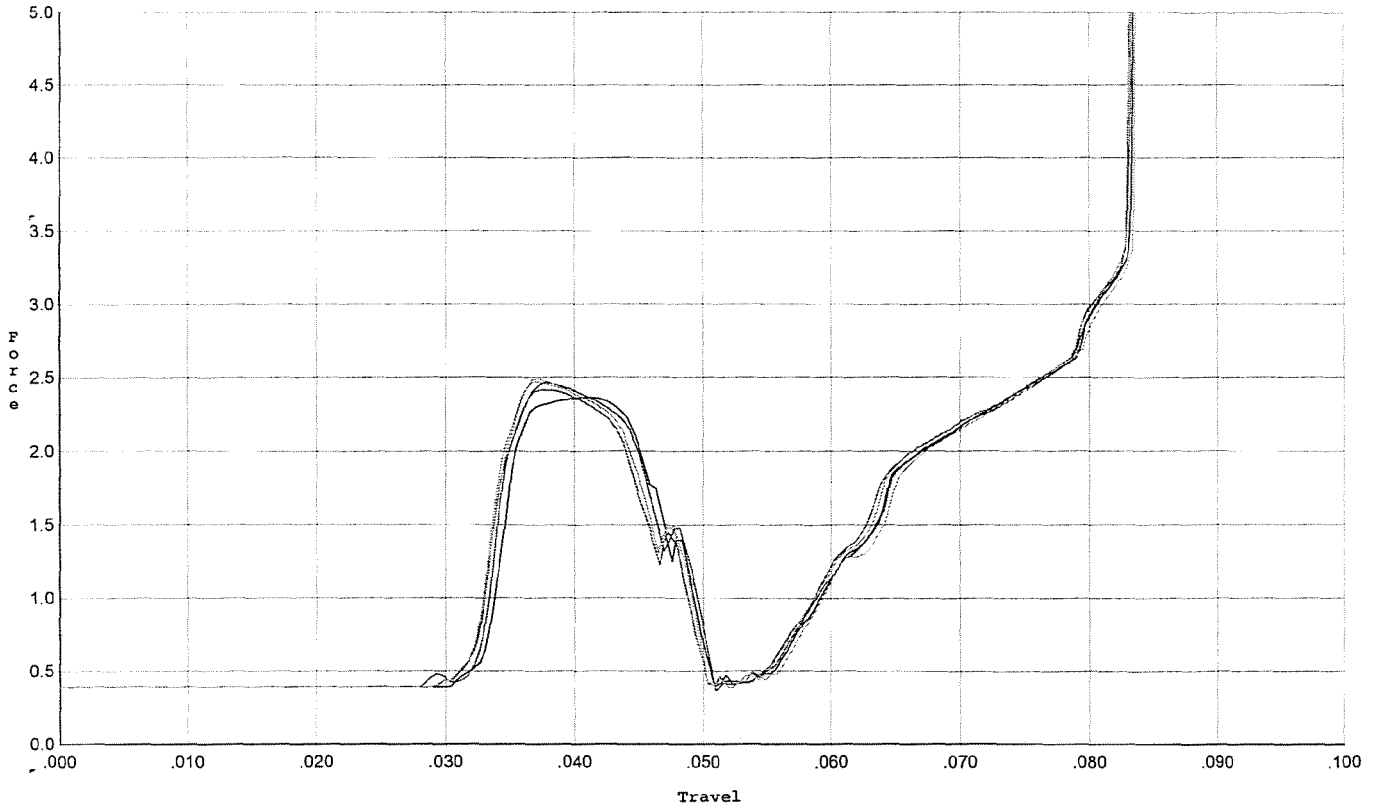
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.127	0.050	0.032	0.034	0.078		Set Trigger
2	4.118	0.050	0.031	0.033	0.079		Set Trigger
3	4.070	0.050	0.032	0.034	0.077		Set Trigger
4	4.158	0.050	0.032	0.034	0.078		Set Trigger
5	4.174	0.050	0.032	0.033	0.079		Set Trigger

Aug 4.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

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



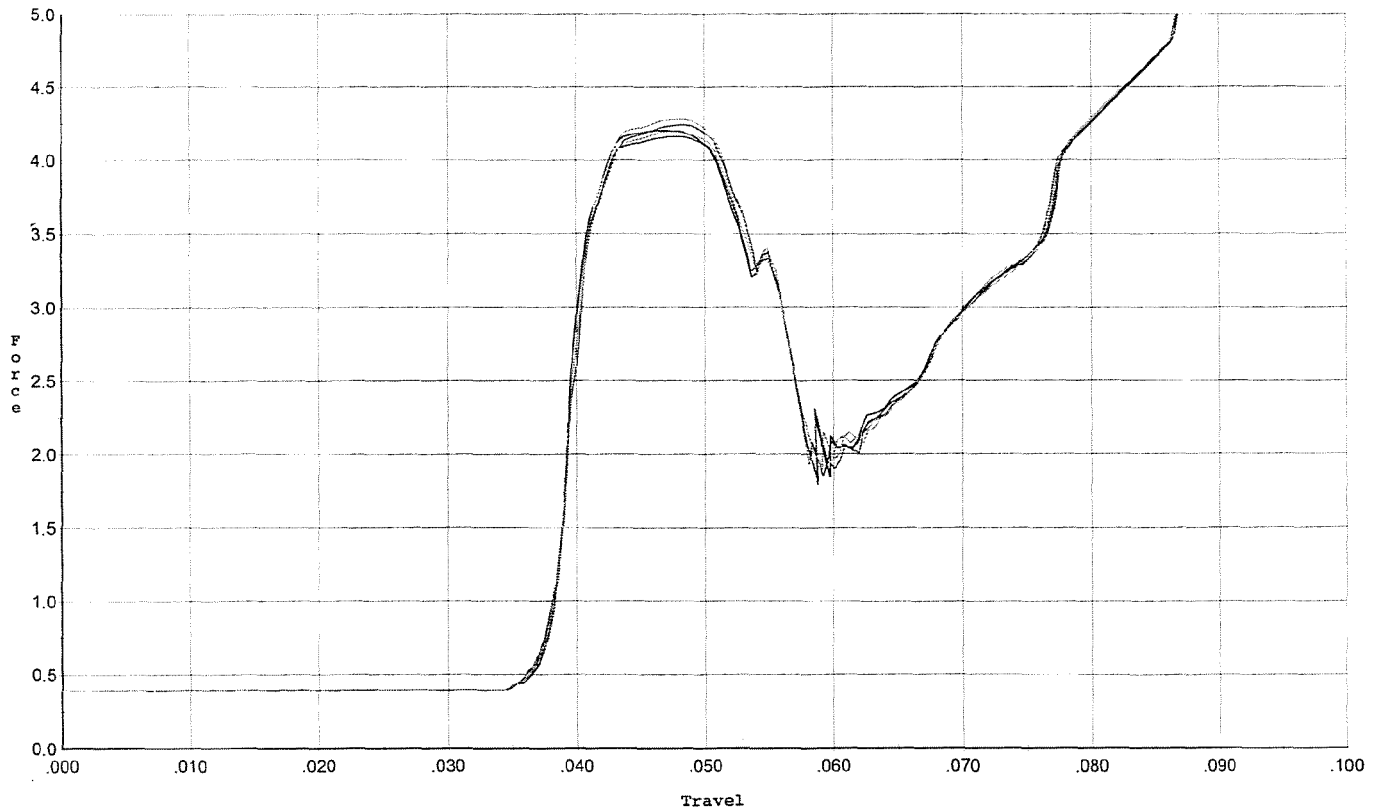
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.469	0.049	0.032	0.038	0.046		Set Trigger
2	2.364	0.048	0.033	0.039	0.044		Set Trigger
3	2.415	0.048	0.032	0.039	0.043		Set Trigger
4	2.491	0.049	0.032	0.039	0.045		Set Trigger
5	2.469	0.048	0.032	0.039	0.044		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 11/14/08

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	4.158	0.056	0.037	0.037	0.081		Set Trigger
2	4.199	0.056	0.037	0.037	0.081		Set Trigger
3	4.237	0.056	0.037	0.037	0.081		Set Trigger
4	4.193	0.056	0.037	0.037	0.081		Set Trigger
5	4.279	0.056	0.037	0.037	0.082		Set Trigger

Avg 4.21