

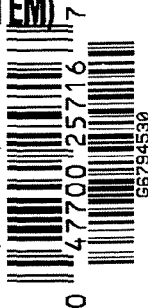
56794530

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



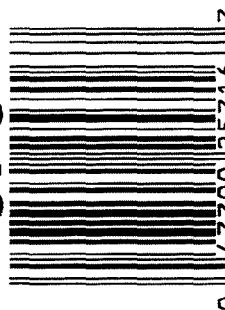
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794530

UPC



GUN SERIAL #

G 6794530

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-30-08	SPD
430	ASSEMBLE TO STOCK		9-30-08	SP
440	PROOF		9-30-08	SPD
460	CHECK HEADSPACE		9-30-08	SPD
470	DIS-ASSEMBLE ACTION		9-30-08	SPD
472	SERIALIZE BOLT HANDLE		10-1-08	Rsn
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	(HA)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	Rt
520	GOFF BLAST BBL / REC		10-3-08	DG
	APPLY COATINGS			
542	(BARREL ACTION)		10-8	
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		10-29-08	Rsn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

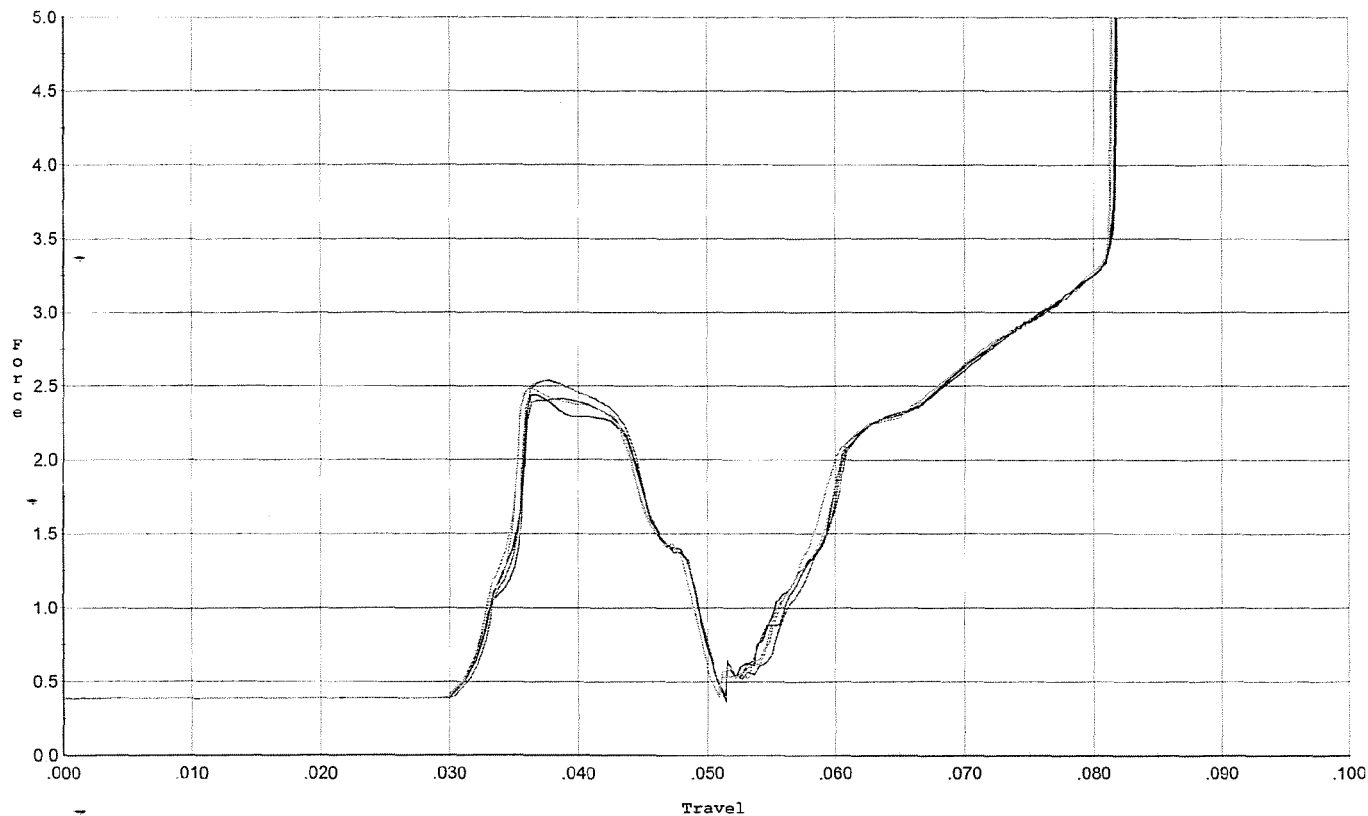
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-11-08	L. D
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-11-08	L. D
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-11-08	L. D
	J) ASSEMBLE STOCK		10-29-08	Rgn
	K) ASSEMBLE SWIVEL STUDS		11-11-08	L. D
	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> <u>PASS</u> FAIL FAIL	10-30-08	Rgn
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-11-08	L. D
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.28</u> <u>2.21</u> <u>2.26</u> <u>2.27</u> <u>2.23</u>	11-5-08	Fm
	C) FUNCTION		11-11-08	L. D
690	PACK		11/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

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



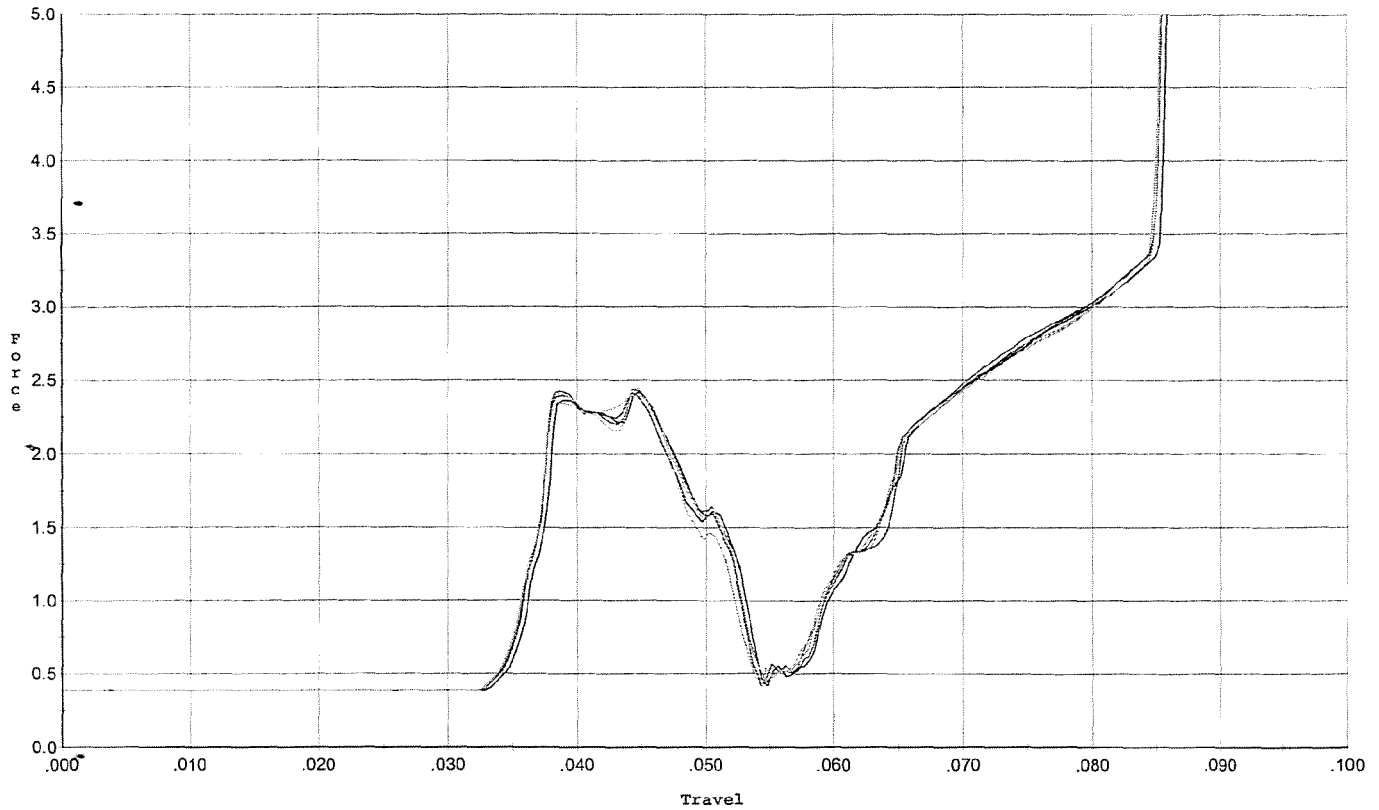
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.049	0.032	0.037	0.043		Set Trigger
2	2.439	0.049	0.032	0.037	0.043		Set Trigger
3	2.540	0.048	0.032	0.037	0.044		Set Trigger
4	2.534	0.049	0.032	0.037	0.045		Set Trigger
5	2.482	0.049	0.032	0.037	0.044		Set Trigger

Avg 2.48

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

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



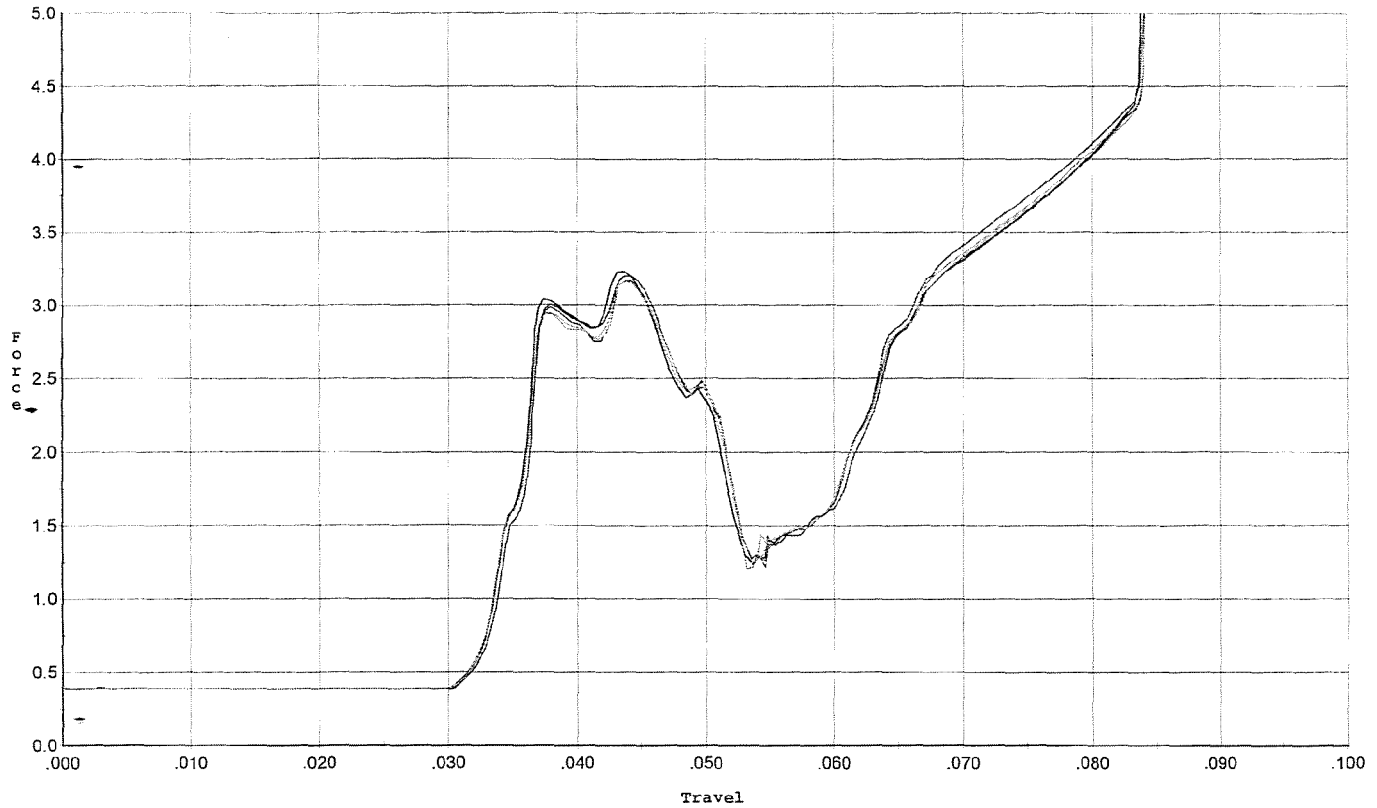
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.414	0.052	0.035	0.038	0.046		Set Trigger
2	2.421	0.053	0.035	0.038	0.047		Set Trigger
3	2.433	0.052	0.035	0.038	0.047		Set Trigger
4	2.444	0.052	0.035	0.038	0.047		Set Trigger
5	2.399	0.052	0.034	0.038	0.046		Set Trigger

Aug 2.42

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/21/08

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



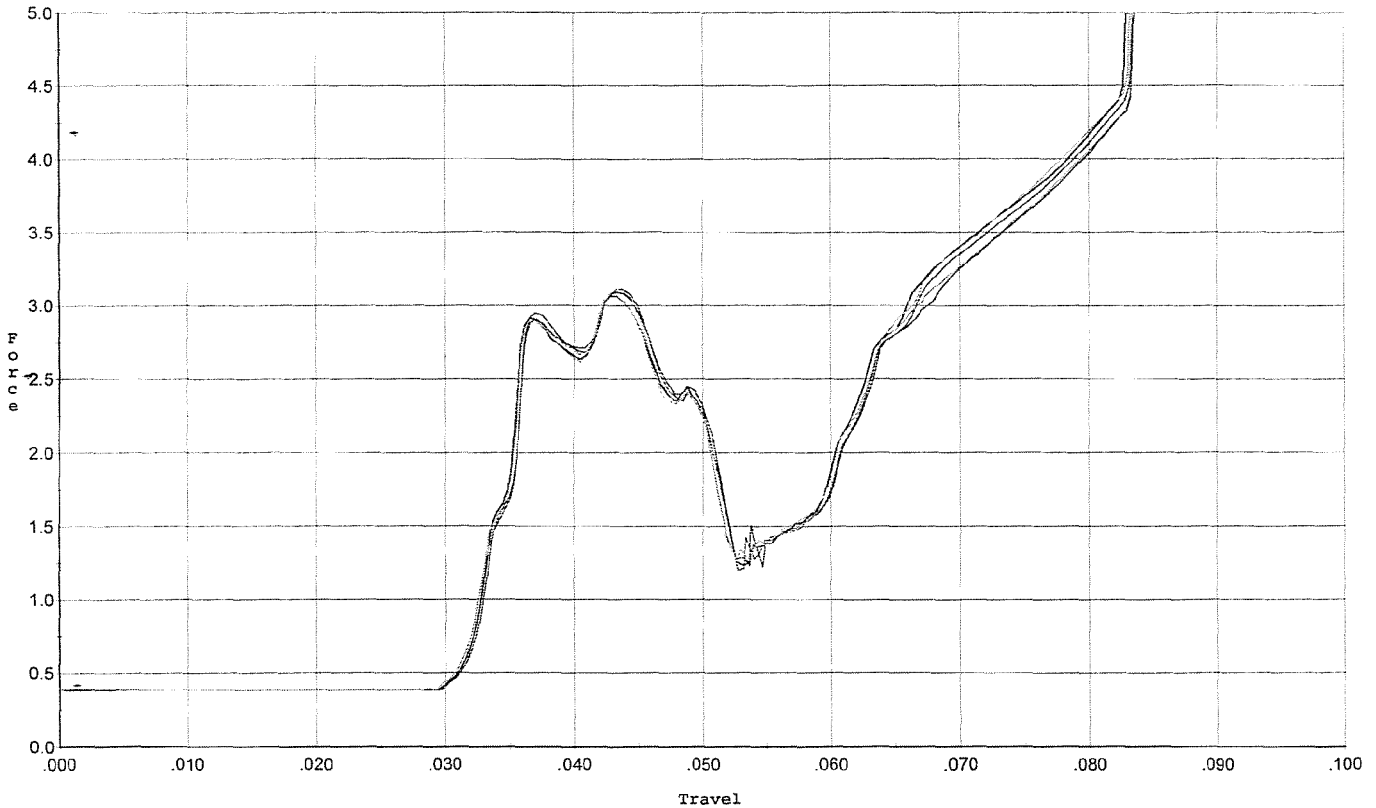
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.198	0.051	0.033	0.036	0.059		Set Trigger
2	3.231	0.051	0.032	0.036	0.059		Set Trigger
3	3.172	0.051	0.032	0.036	0.059		Set Trigger
4	3.171	0.051	0.032	0.036	0.060		Set Trigger
5	3.168	0.051	0.032	0.036	0.060		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/21/08

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



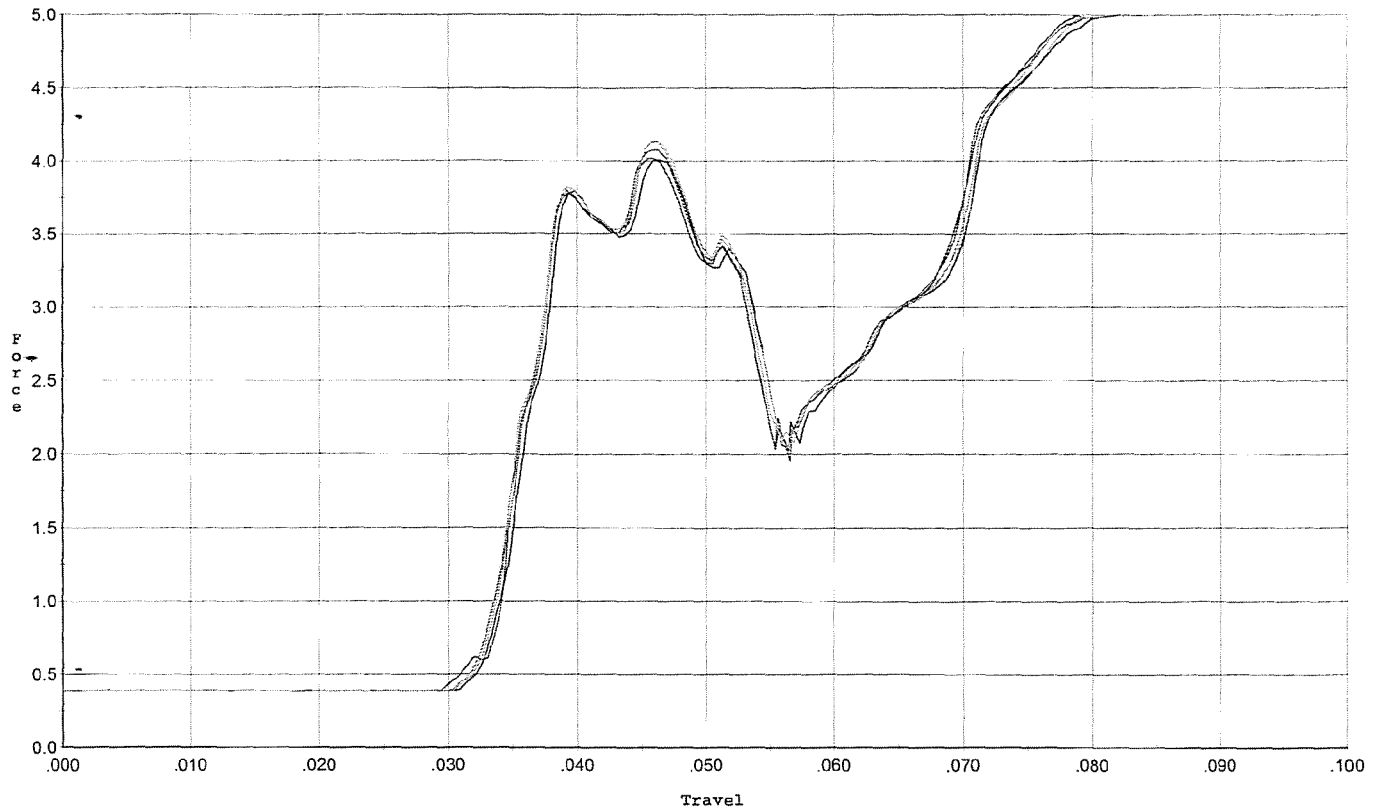
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.094	0.051	0.032	0.036	0.059		Set Trigger
2	3.065	0.050	0.032	0.035	0.058		Set Trigger
3	3.112	0.051	0.032	0.036	0.059		Set Trigger
4	3.112	0.050	0.031	0.036	0.058		Set Trigger
5	3.064	0.050	0.031	0.036	0.058		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

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



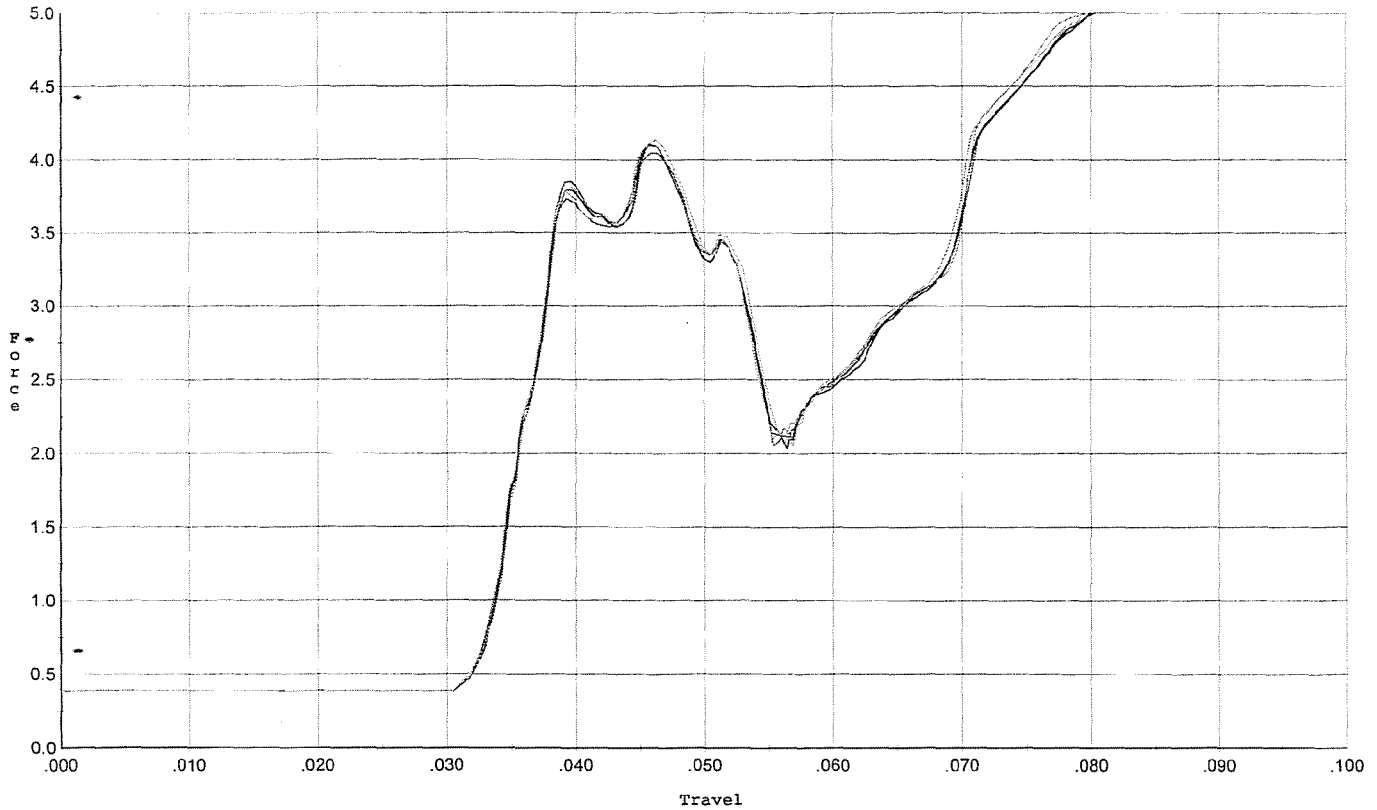
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.016	0.053	0.033	0.035	0.077		Set Trigger
2	4.011	0.054	0.033	0.035	0.080		Set Trigger
3	4.078	0.053	0.032	0.035	0.078		Set Trigger
4	4.132	0.054	0.032	0.035	0.081		Set Trigger
5	4.134	0.054	0.032	0.034	0.082		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/21/08

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



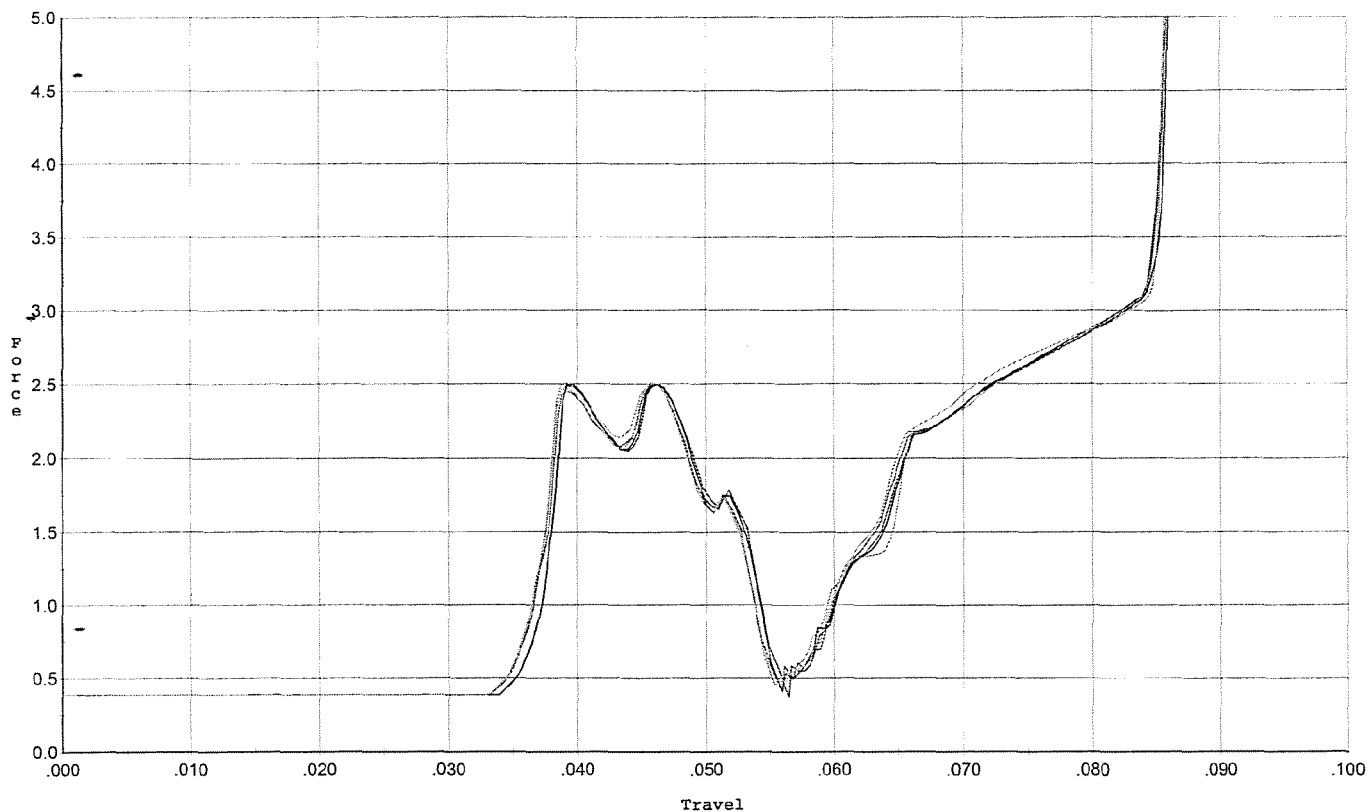
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.112	0.054	0.032	0.034	0.080		Set Trigger
2	4.101	0.054	0.032	0.034	0.080		Set Trigger
3	4.043	0.054	0.032	0.035	0.080		Set Trigger
4	4.134	0.053	0.032	0.035	0.079		Set Trigger
5	4.110	0.053	0.032	0.035	0.078		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/21/08

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



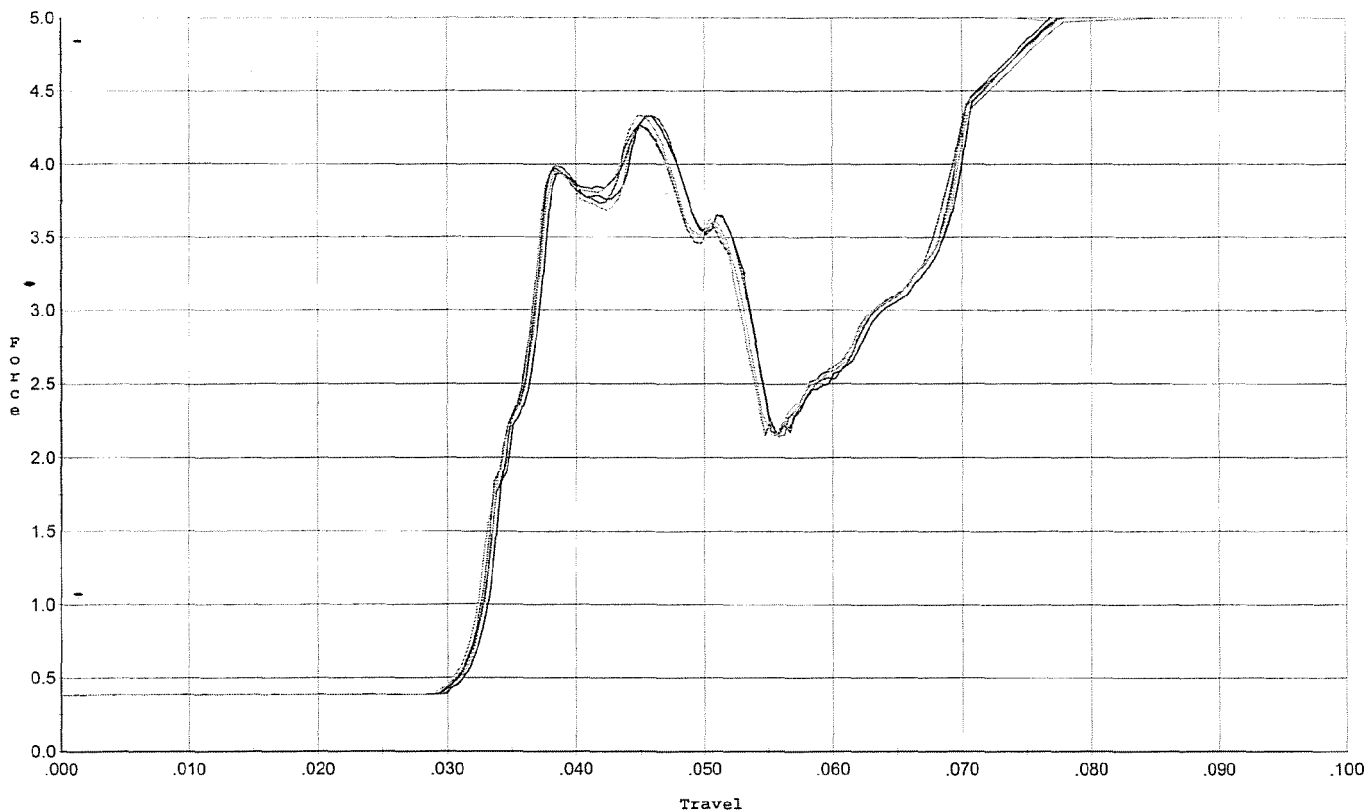
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.500	0.053	0.036	0.038	0.048		Set Trigger
2	2.497	0.053	0.036	0.038	0.048		Set Trigger
3	2.498	0.053	0.035	0.038	0.048		Set Trigger
4	2.511	0.053	0.035	0.038	0.048		Set Trigger
5	2.507	0.053	0.035	0.038	0.049		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/21/08

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	4.327	0.053	0.032	0.034	0.086		Set Trigger
2	4.326	0.053	0.032	0.034	0.084		Set Trigger
3	4.263	0.052	0.031	0.034	0.081		Set Trigger
4	4.334	0.052	0.031	0.034	0.082		Set Trigger
5	4.253	0.053	0.032	0.034	0.082		Set Trigger

Aug 4.30