

66794531

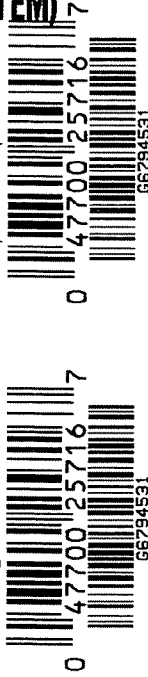
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 351B

BM FORM

proof of purchase

owner registration sticker



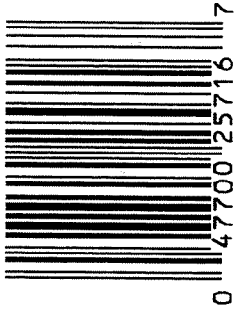
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794531

UPC



GUN SERIAL #

G 6794531

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	ESU
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	(B)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10-3-08	DG
542	APPLY COATINGS (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		10-30-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

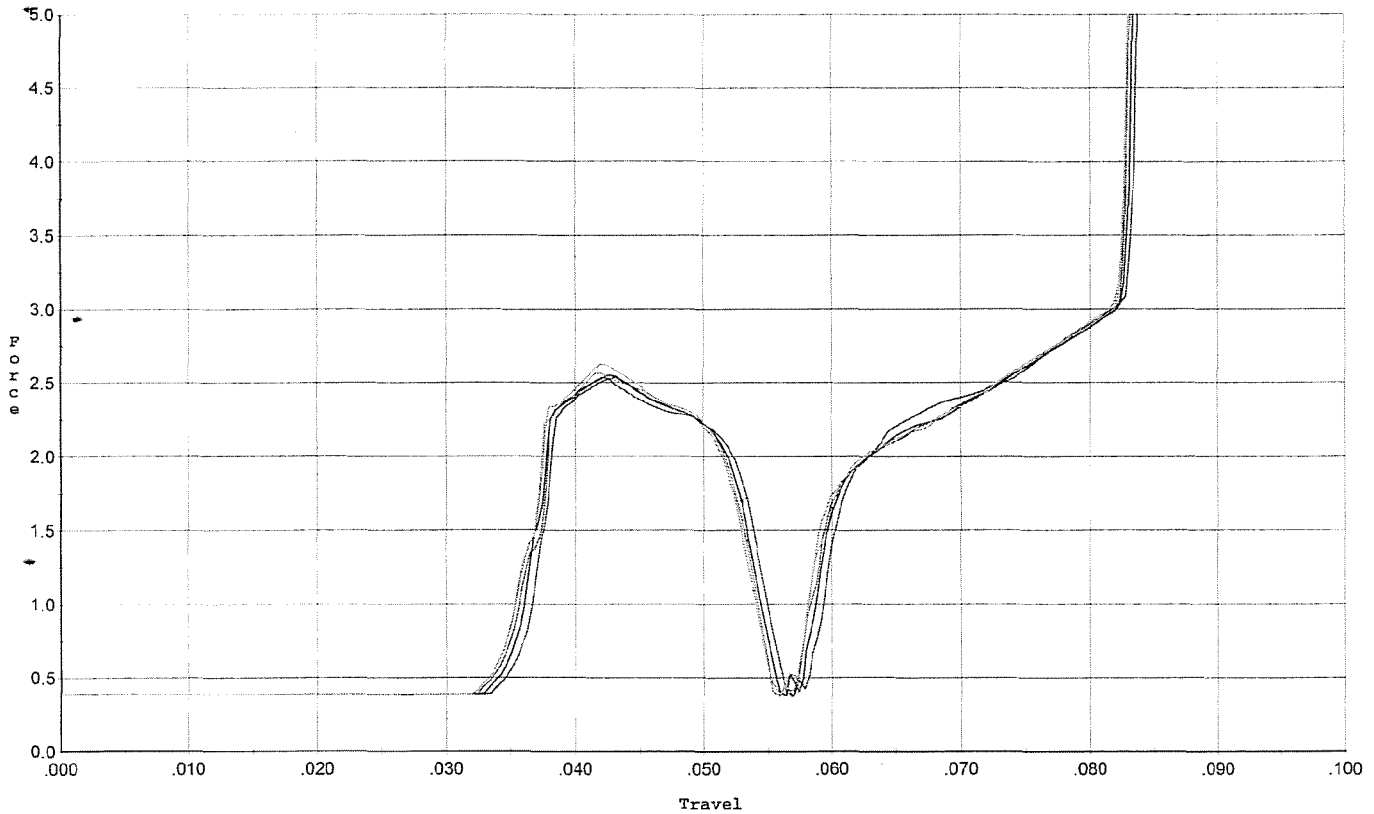
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>4.0</u>	11-11-08	LJ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-11-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-11-08	LJ
	J) ASSEMBLE STOCK		10-30-08	LJ
	K) ASSEMBLE SWIVEL STUDS		11-11-08	LJ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	11-3-08	LJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TL
670	FINAL INSPECTION A) HEADSPACE		11-11-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.35</u> <u>2.32</u> <u>2.37</u> <u>2.42</u>	11-5-08	Fm
	C) FUNCTION		11-11-08	LJ
690	PACK		11/2/08	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.



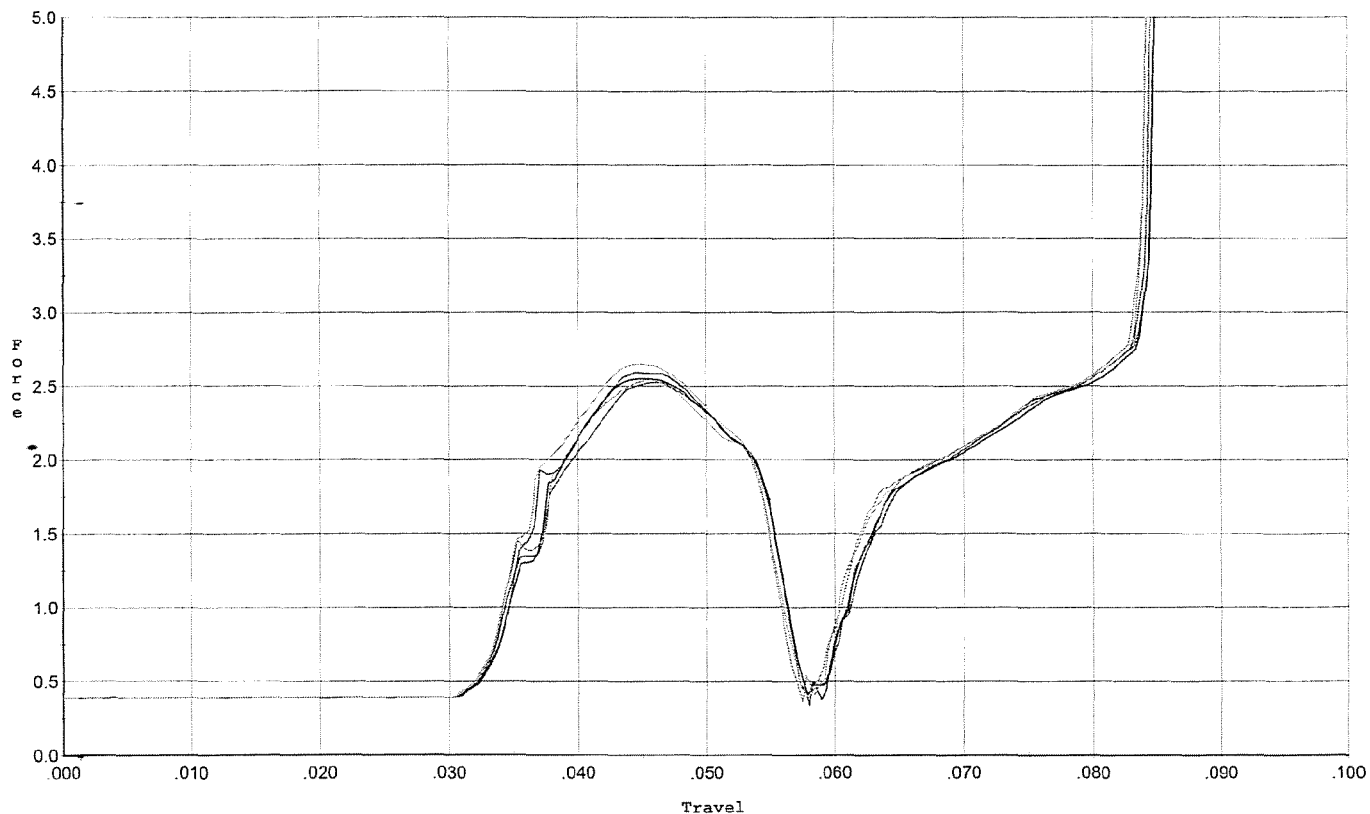
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.535	0.053	0.036	0.036	0.052		Set Trigger
2	2.552	0.053	0.035	0.036	0.052		Set Trigger
3	2.538	0.053	0.034	0.036	0.053		Set Trigger
4	2.627	0.053	0.034	0.035	0.054		Set Trigger
5	2.564	0.054	0.034	0.036	0.054		Set Trigger

Avg 2.56

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.



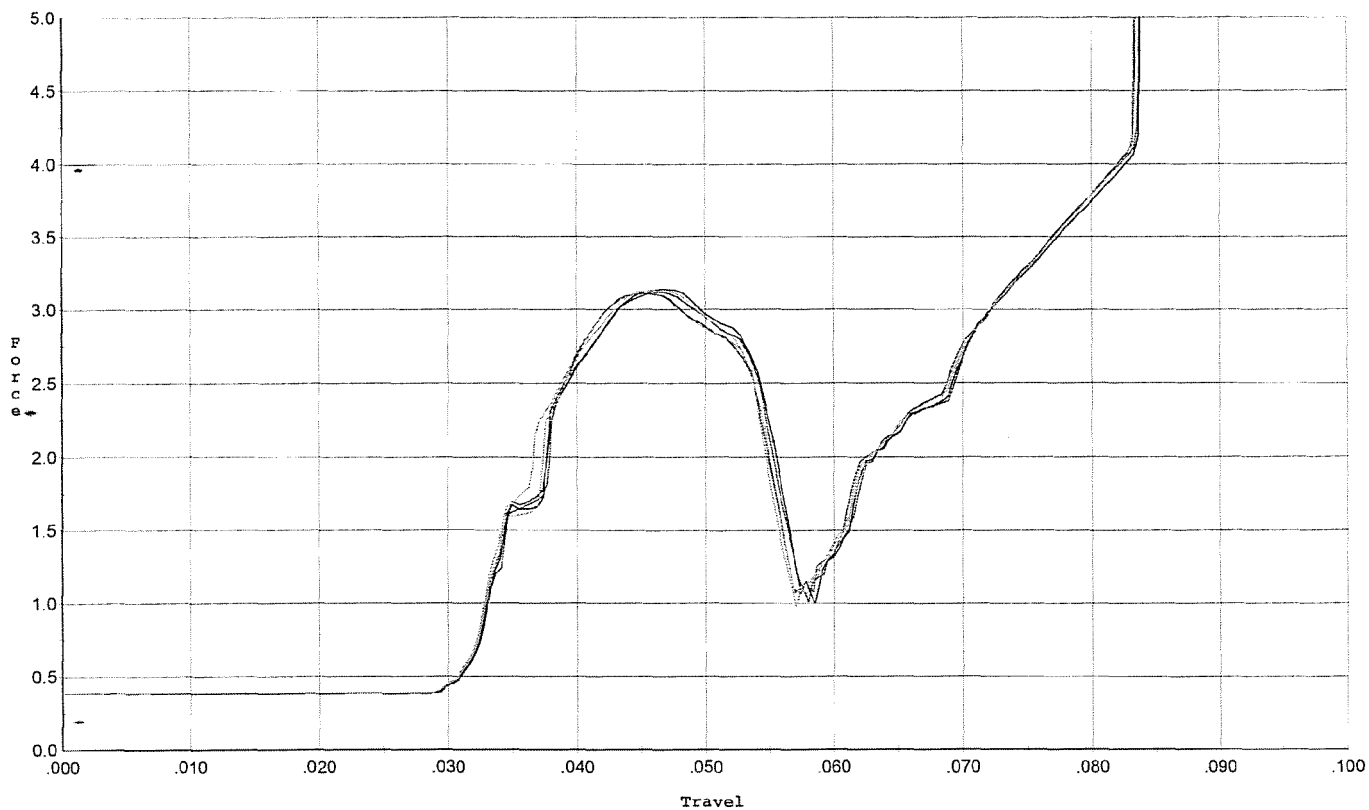
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.055	0.033	0.035	0.059		Set Trigger
2	2.549	0.055	0.033	0.035	0.058		Set Trigger
3	2.526	0.055	0.033	0.035	0.057		Set Trigger
4	2.648	0.054	0.033	0.035	0.059		Set Trigger
5	2.543	0.054	0.033	0.035	0.057		Set Trigger

Aug 2.57

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.



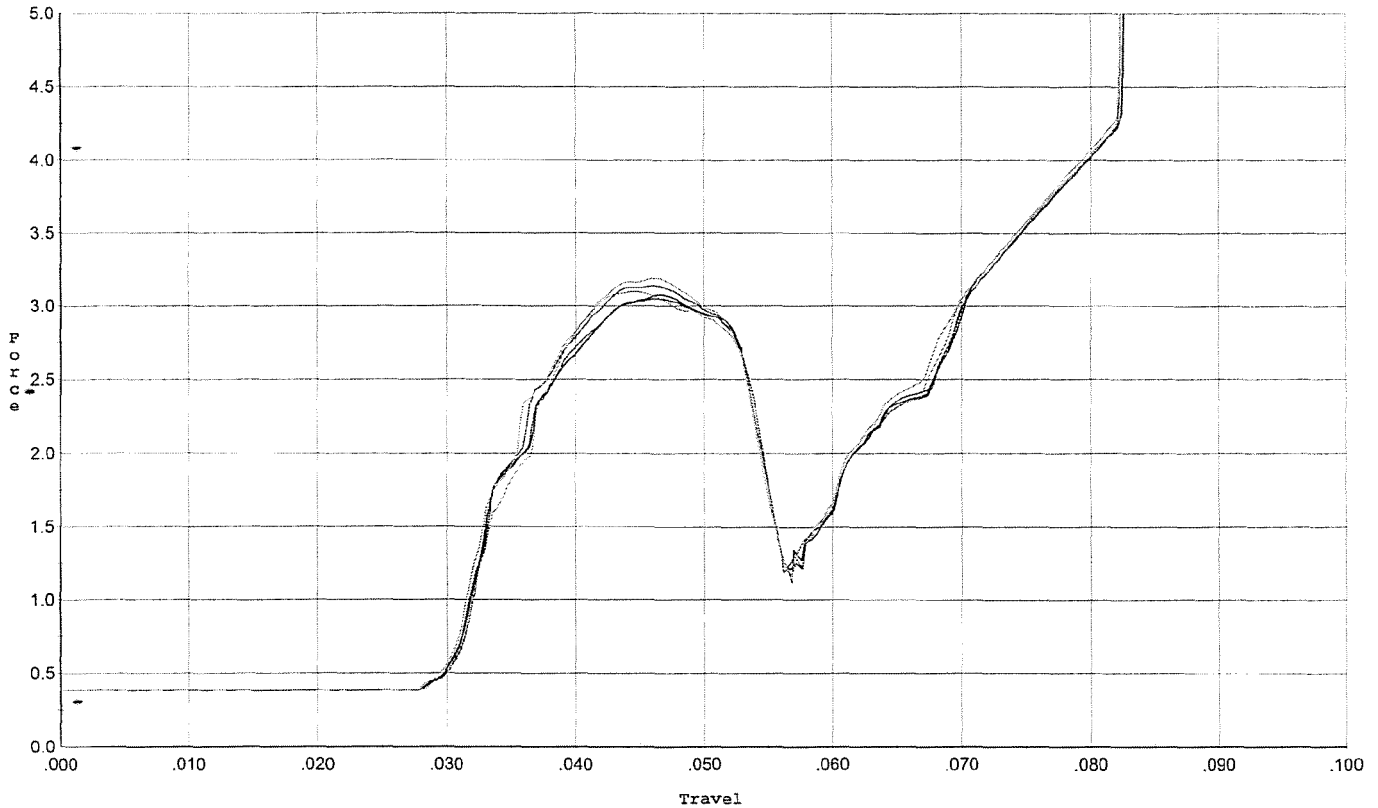
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.120	0.054	0.032	0.034	0.068		Set Trigger
2	3.141	0.055	0.032	0.033	0.070		Set Trigger
3	3.107	0.055	0.031	0.033	0.069		Set Trigger
4	3.131	0.055	0.031	0.033	0.069		Set Trigger
5	3.121	0.054	0.031	0.034	0.068		Set Trigger

Aug 3.12

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.



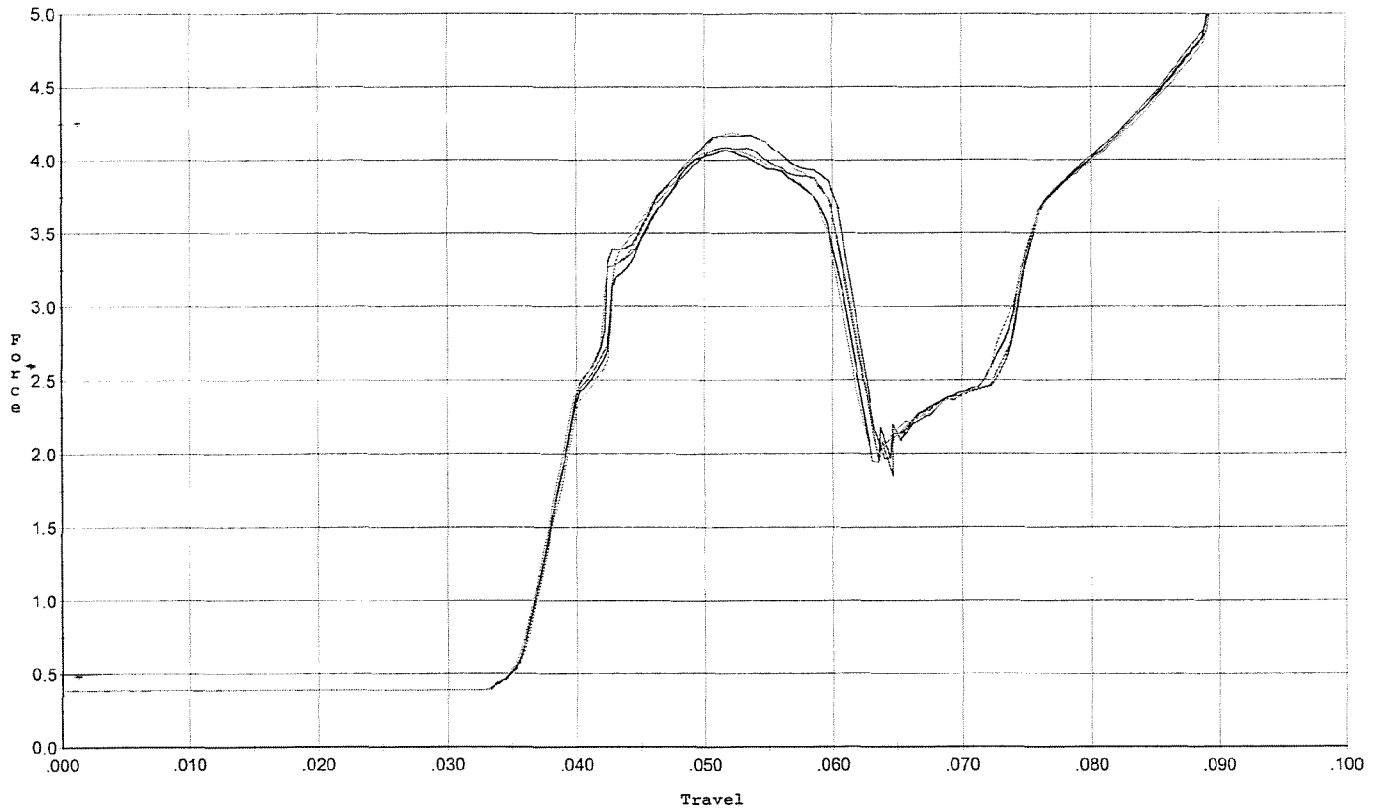
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.053	0.054	0.031	0.033	0.071		Set Trigger
2	3.078	0.053	0.030	0.033	0.069		Set Trigger
3	3.141	0.054	0.030	0.033	0.072		Set Trigger
4	3.193	0.053	0.030	0.033	0.071		Set Trigger
5	3.099	0.053	0.031	0.033	0.068		Set Trigger

Aug 3.11

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.



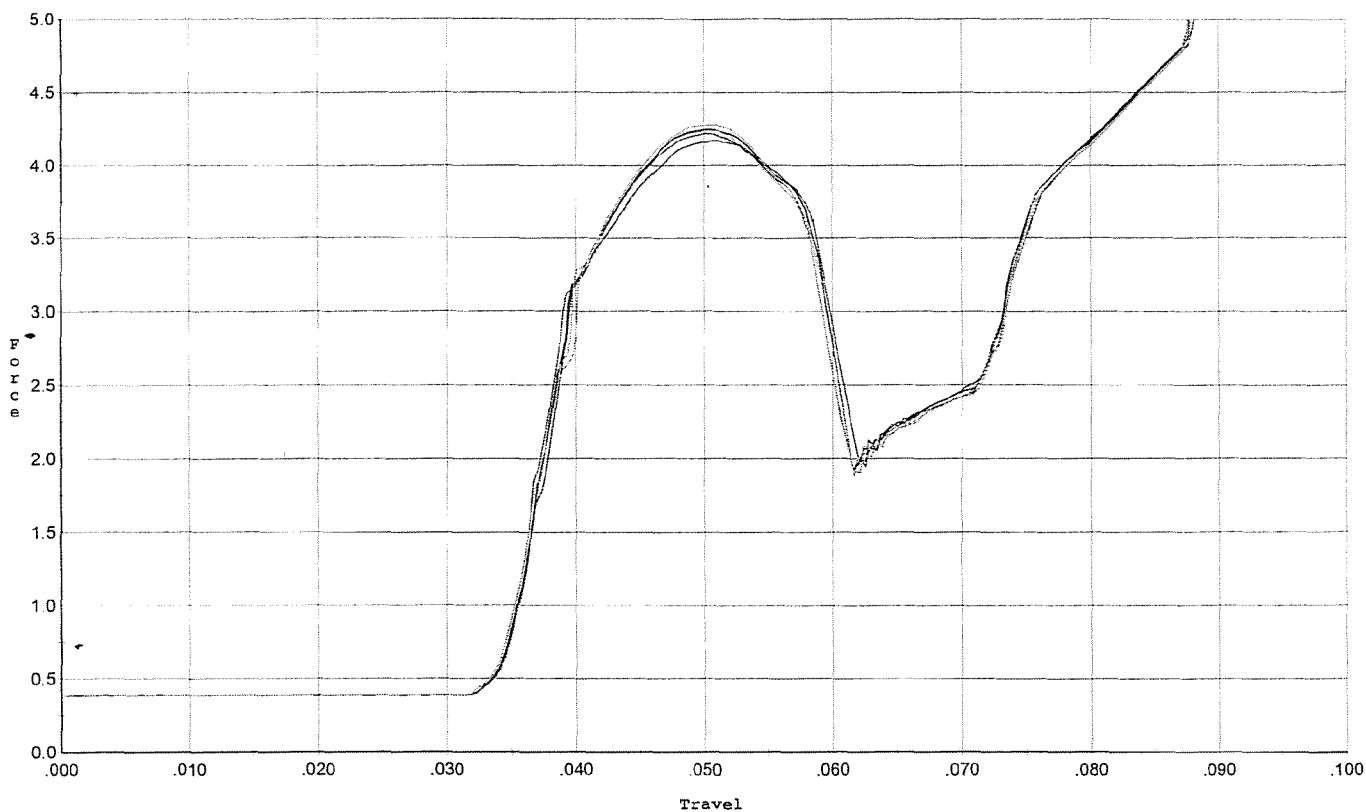
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.060	0.036	0.032	0.099		Set Trigger
2	4.069	0.061	0.036	0.032	0.096		Set Trigger
3	4.086	0.060	0.036	0.033	0.095		Set Trigger
4	4.188	0.061	0.036	0.032	0.099		Set Trigger
5	4.070	0.060	0.035	0.033	0.095		Set Trigger

Avg 4.11

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.



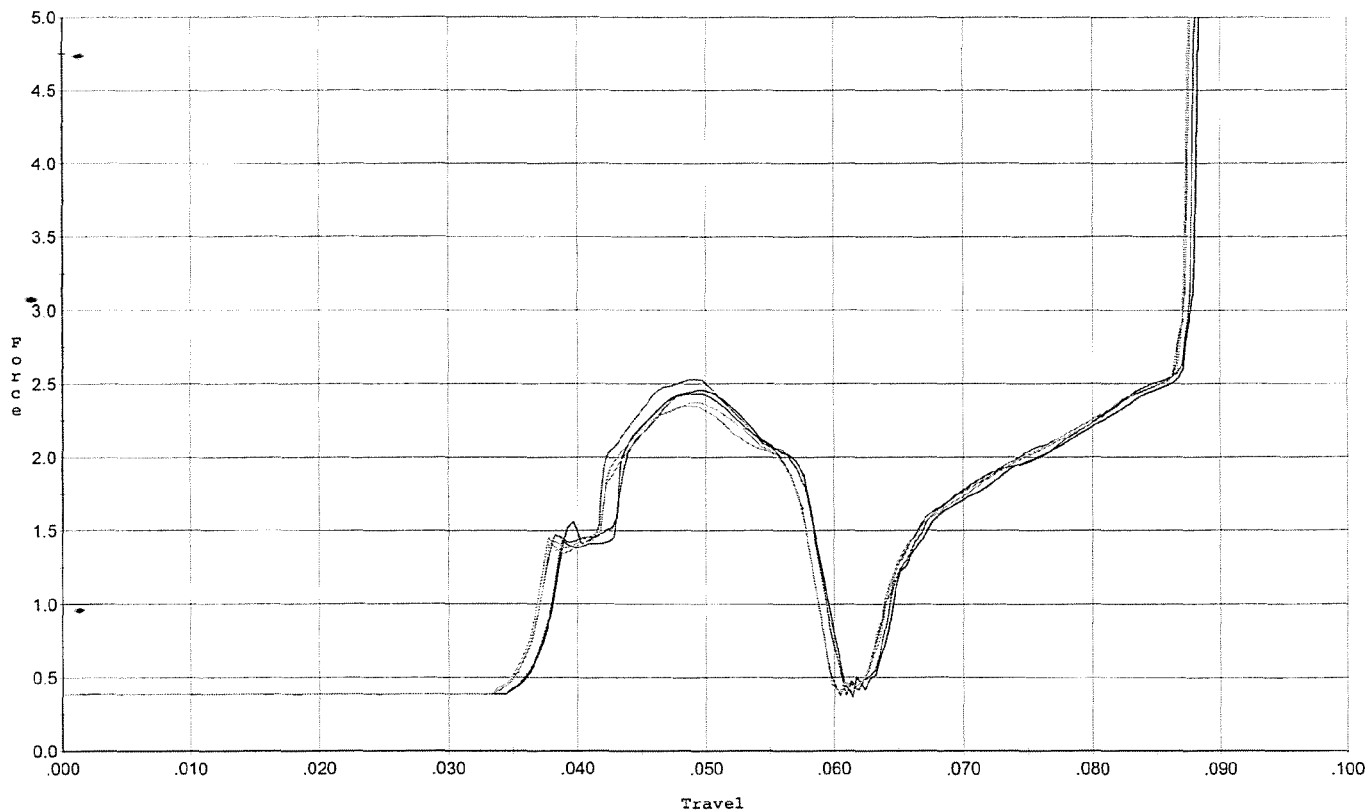
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.169	0.058	0.034	0.033	0.097		Set Trigger
2	4.242	0.059	0.034	0.033	0.099		Set Trigger
3	4.219	0.058	0.034	0.033	0.097		Set Trigger
4	4.252	0.058	0.034	0.033	0.097		Set Trigger
5	4.277	0.059	0.034	0.033	0.099		Set Trigger

Avg 4.23

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



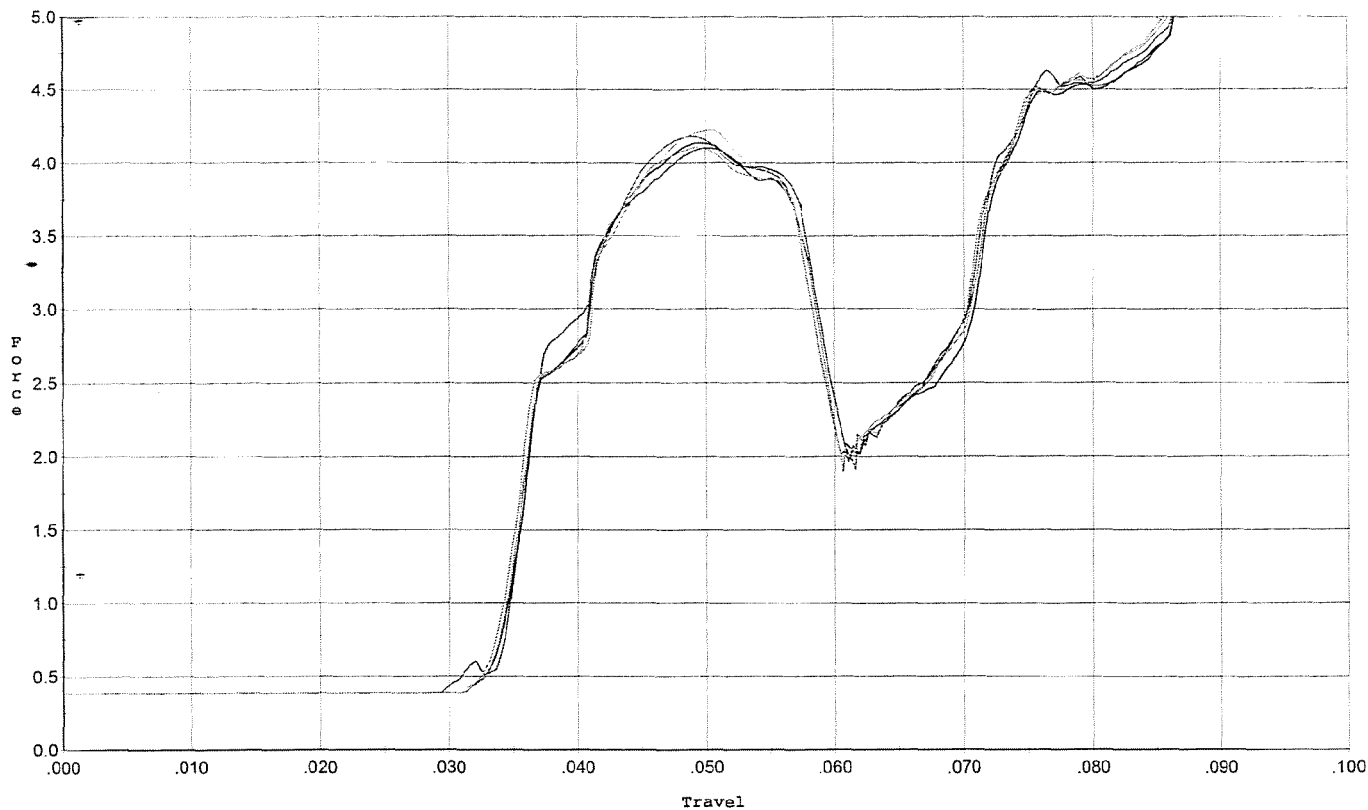
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.431	0.058	0.037	0.036	0.055		Set Trigger
2	2.458	0.058	0.037	0.037	0.056		Set Trigger
3	2.526	0.057	0.036	0.036	0.057		Set Trigger
4	2.377	0.058	0.035	0.036	0.055		Set Trigger
5	2.353	0.057	0.036	0.036	0.055		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: 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	4.101	0.057	0.034	0.032	0.095		Set Trigger
2	4.136	0.058	0.033	0.032	0.095		Set Trigger
3	4.183	0.057	0.033	0.033	0.094		Set Trigger
4	4.226	0.058	0.033	0.032	0.096		Set Trigger
5	4.106	0.057	0.033	0.032	0.093		Set Trigger

Avg 4.15