

G6794544

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

G6794544

UPC



GUN SERIAL #

6794544

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	SP
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/5	
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	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

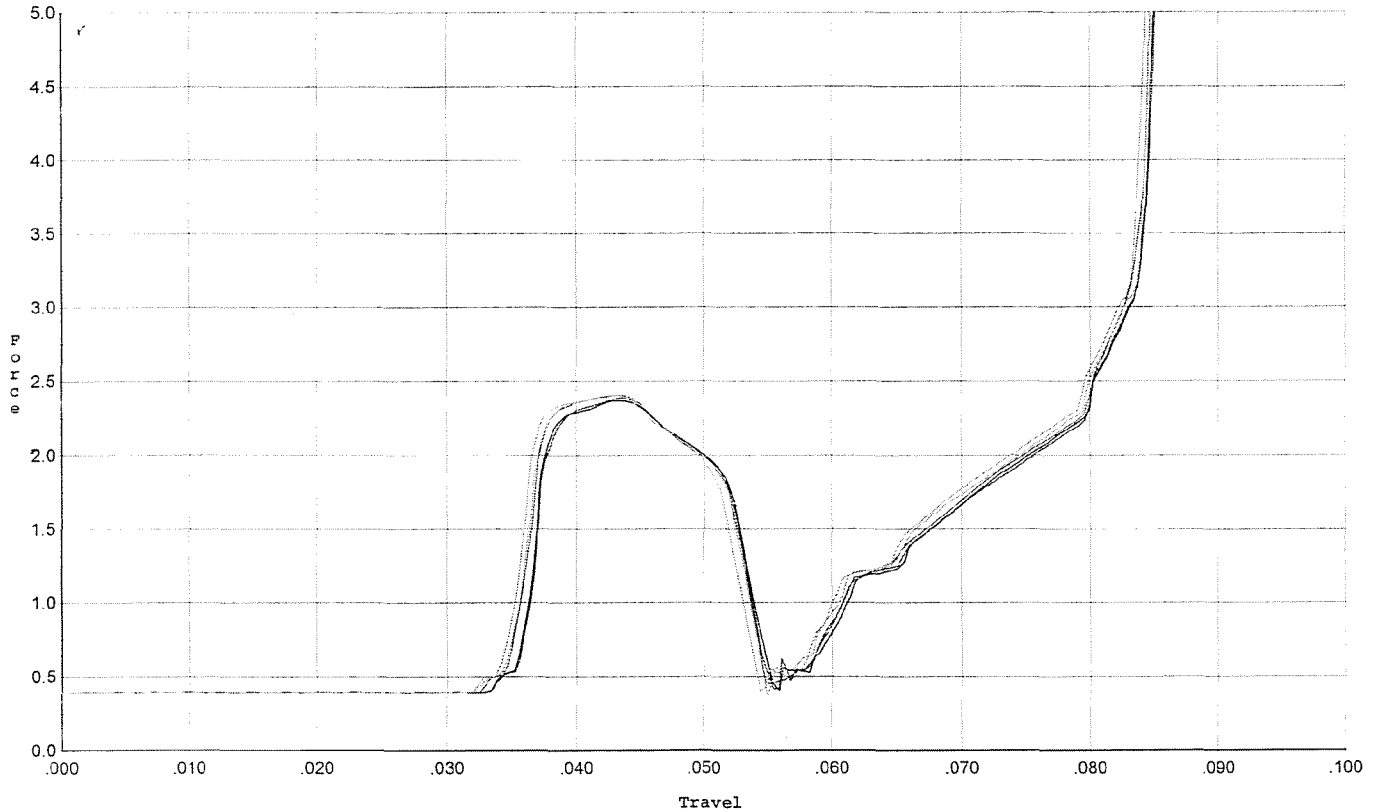
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-20-08	L.N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-20-08	L.N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.024</u>	11-20-08	L.N
	J) ASSEMBLE STOCK		11-18-08	RJZ
	K) ASSEMBLE SWIVEL STUDS		11-20-08	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	11-19-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	L.N
670	FINAL INSPECTION A) HEADSPACE		11-20-08	L.N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.55</u> <u>2.58</u> <u>2.49</u> <u>2.44</u>	11-20-08	TL
	C) FUNCTION		11-20-08	L.N
690	PACK		12-2-08	TL

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.



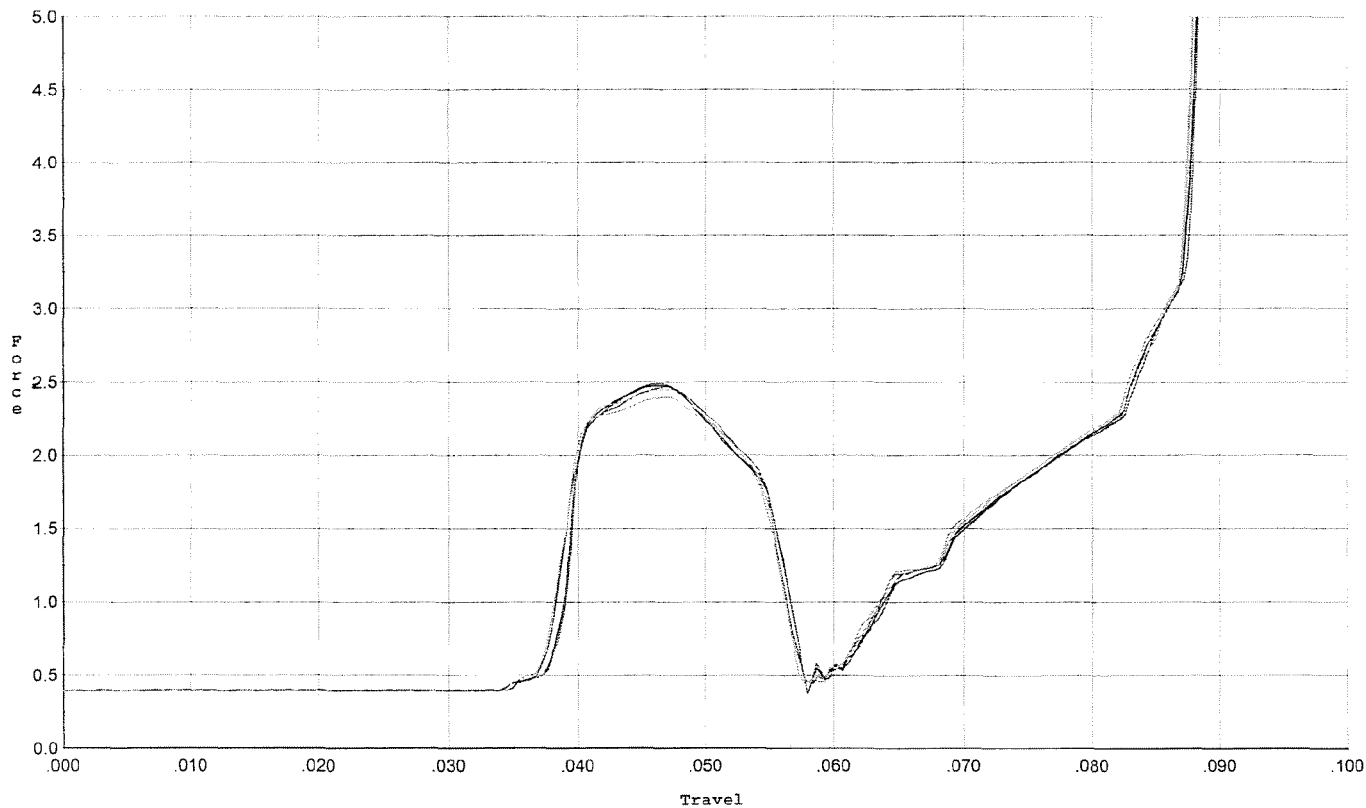
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.386	0.053	0.034	0.037	0.049		Set Trigger
2	2.368	0.052	0.034	0.037	0.050		Set Trigger
3	2.405	0.053	0.033	0.037	0.051		Set Trigger
4	2.403	0.053	0.035	0.037	0.051		Set Trigger
5	2.403	0.053	0.034	0.036	0.051		Set Trigger

Avg 2.39

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.



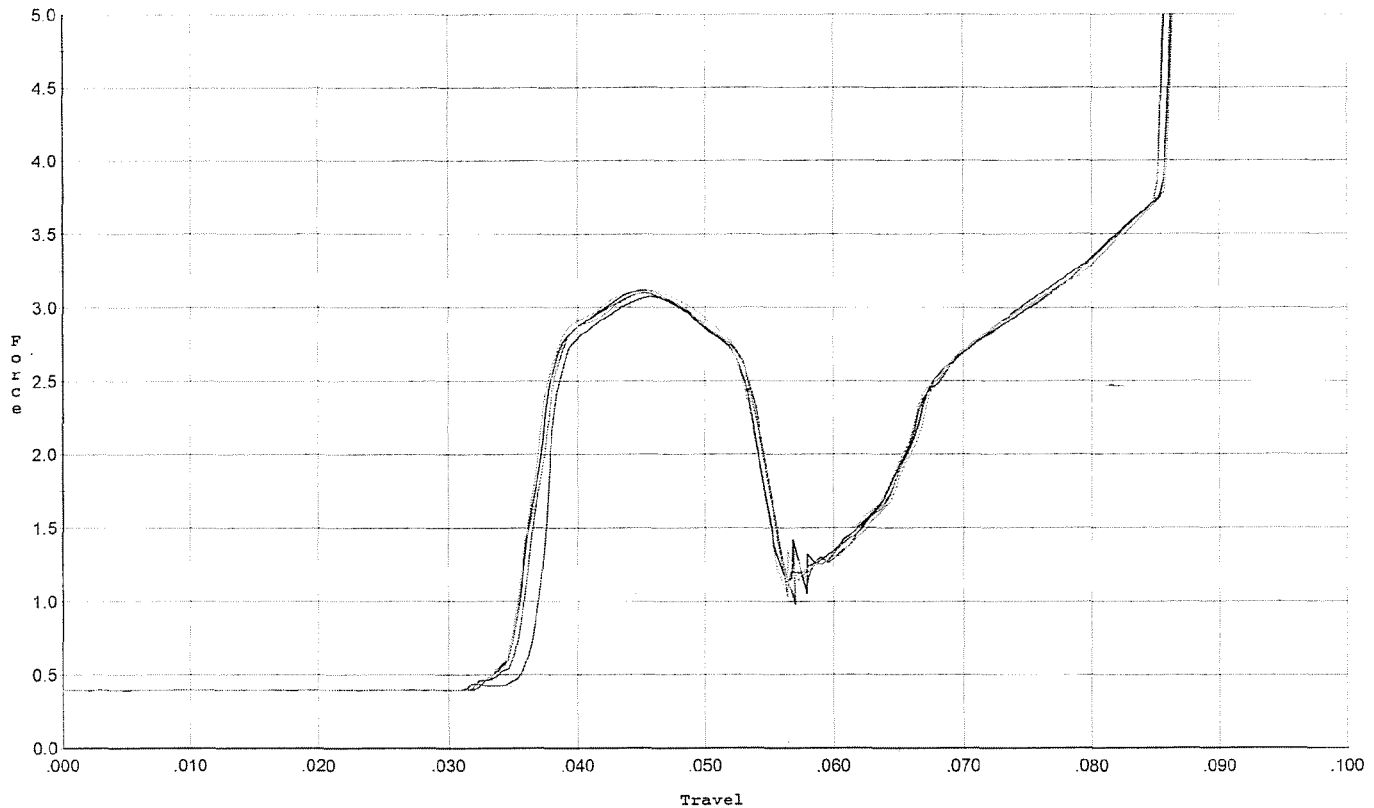
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.486	0.055	0.037	0.039	0.052		Set Trigger
2	2.472	0.056	0.038	0.039	0.053		Set Trigger
3	2.463	0.056	0.038	0.038	0.053		Set Trigger
4	2.453	0.055	0.038	0.039	0.051		Set Trigger
5	2.401	0.055	0.037	0.038	0.052		Set Trigger

Avg 2.45

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.



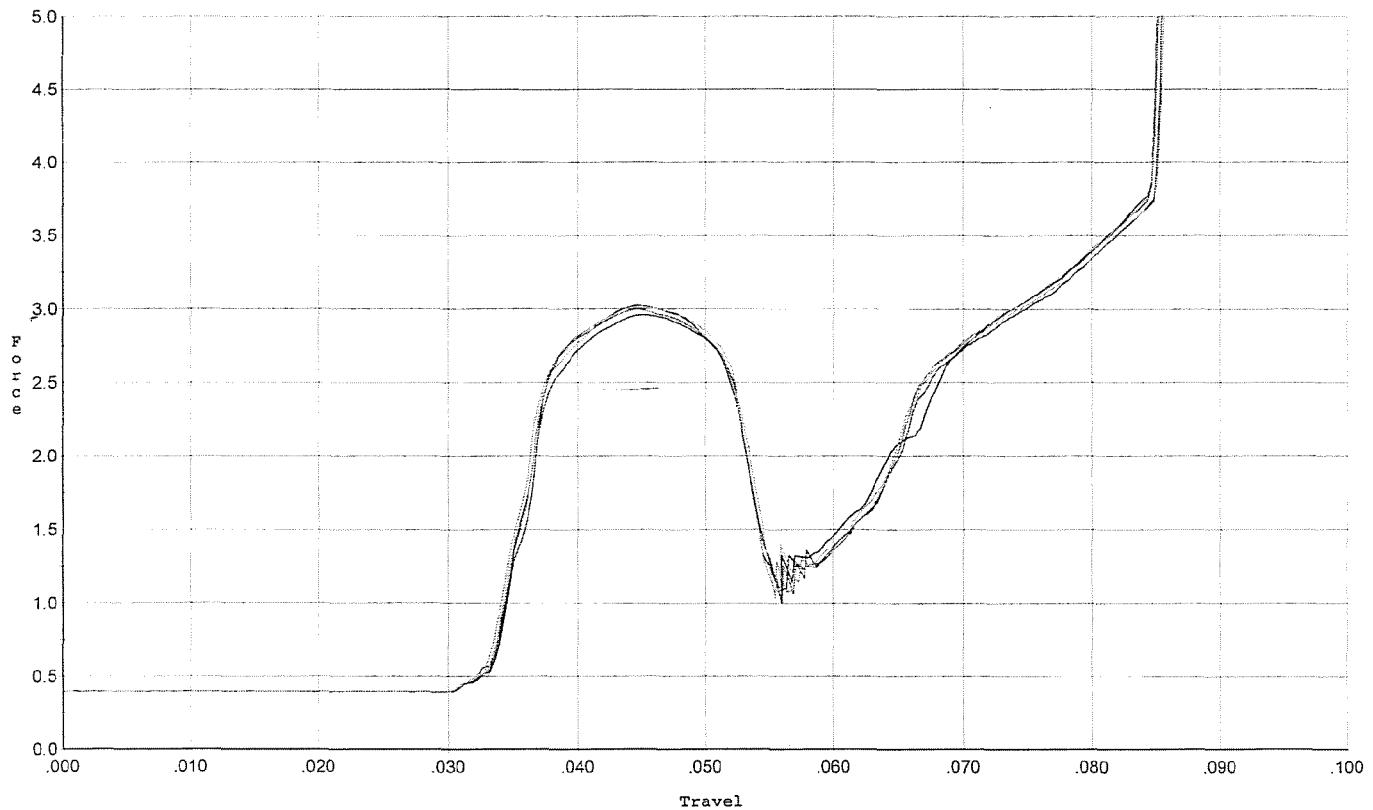
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.074	0.054	0.036	0.037	0.063		Set Trigger
2	3.121	0.053	0.035	0.036	0.065		Set Trigger
3	3.099	0.054	0.035	0.036	0.065		Set Trigger
4	3.118	0.054	0.035	0.036	0.066		Set Trigger
5	3.125	0.054	0.035	0.036	0.065		Set Trigger

Avg 3.10

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.



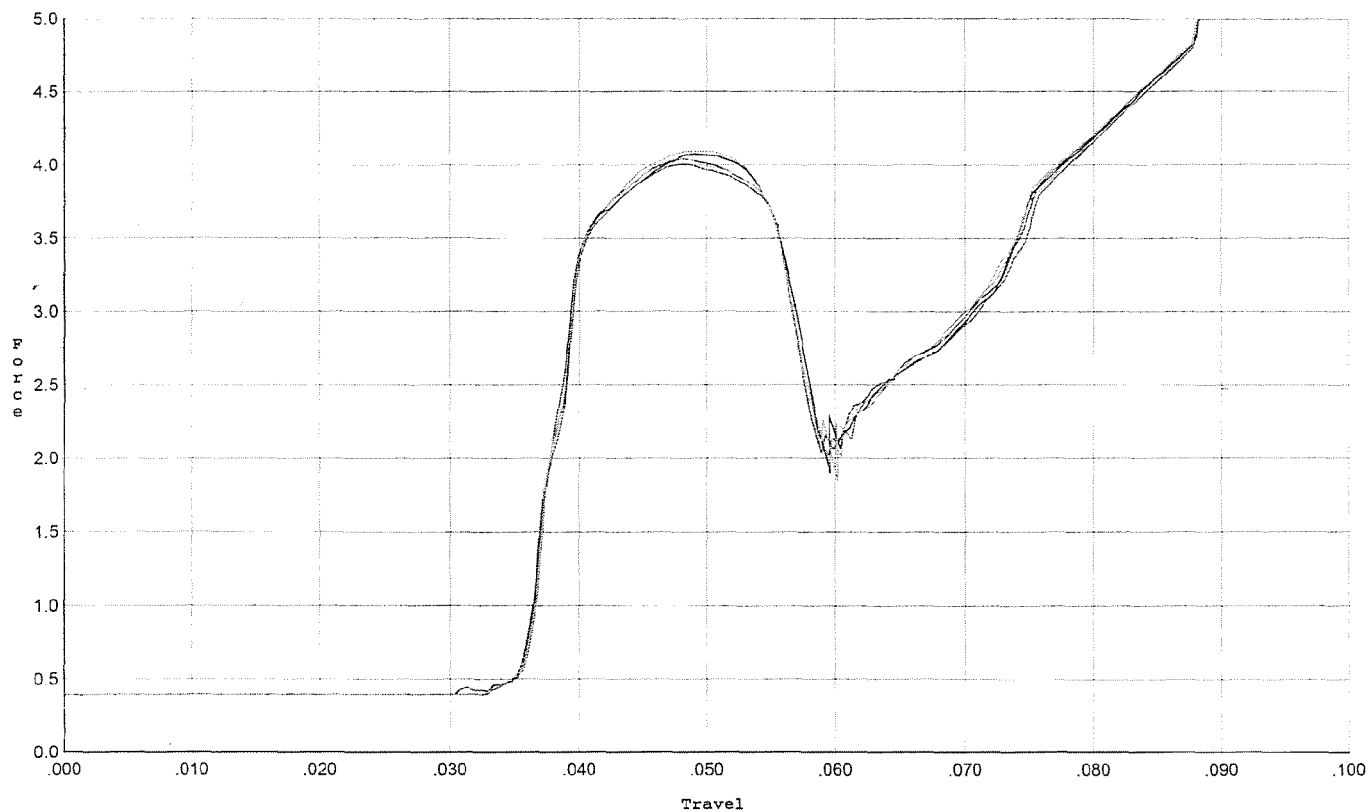
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.958	0.052	0.034	0.036	0.061		Set Trigger
2	3.023	0.052	0.034	0.036	0.063		Set Trigger
3	3.001	0.052	0.034	0.036	0.062		Set Trigger
4	2.993	0.052	0.033	0.036	0.063		Set Trigger
5	3.023	0.053	0.033	0.036	0.065		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: 4.0 lbs. ini. +/- 1.0 lbs.



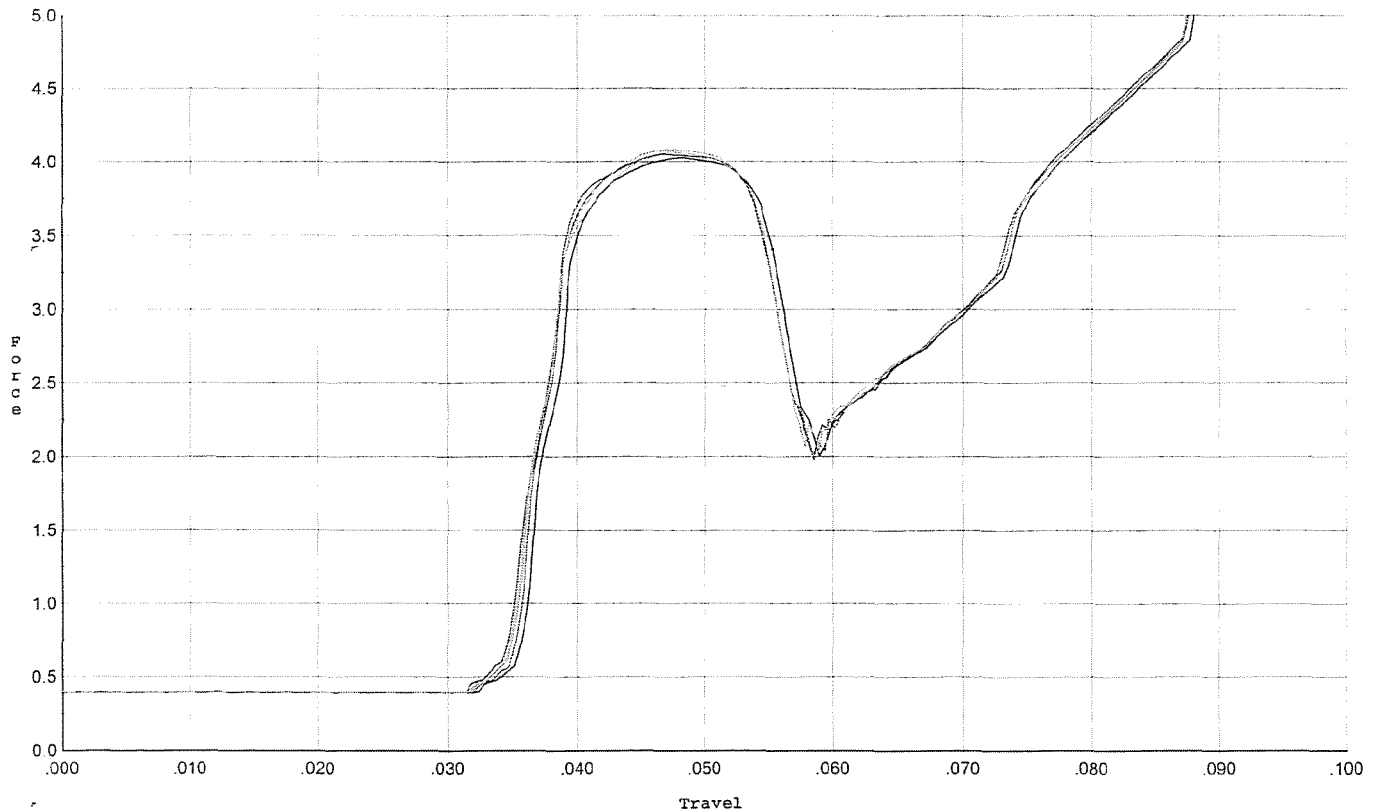
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.039	0.056	0.036	0.036	0.086		Set Trigger
2	4.072	0.057	0.036	0.036	0.088		Set Trigger
3	4.007	0.056	0.036	0.036	0.085		Set Trigger
4	4.042	0.056	0.036	0.036	0.085		Set Trigger
5	4.092	0.056	0.036	0.036	0.086		Set Trigger

Aug 4.05

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.



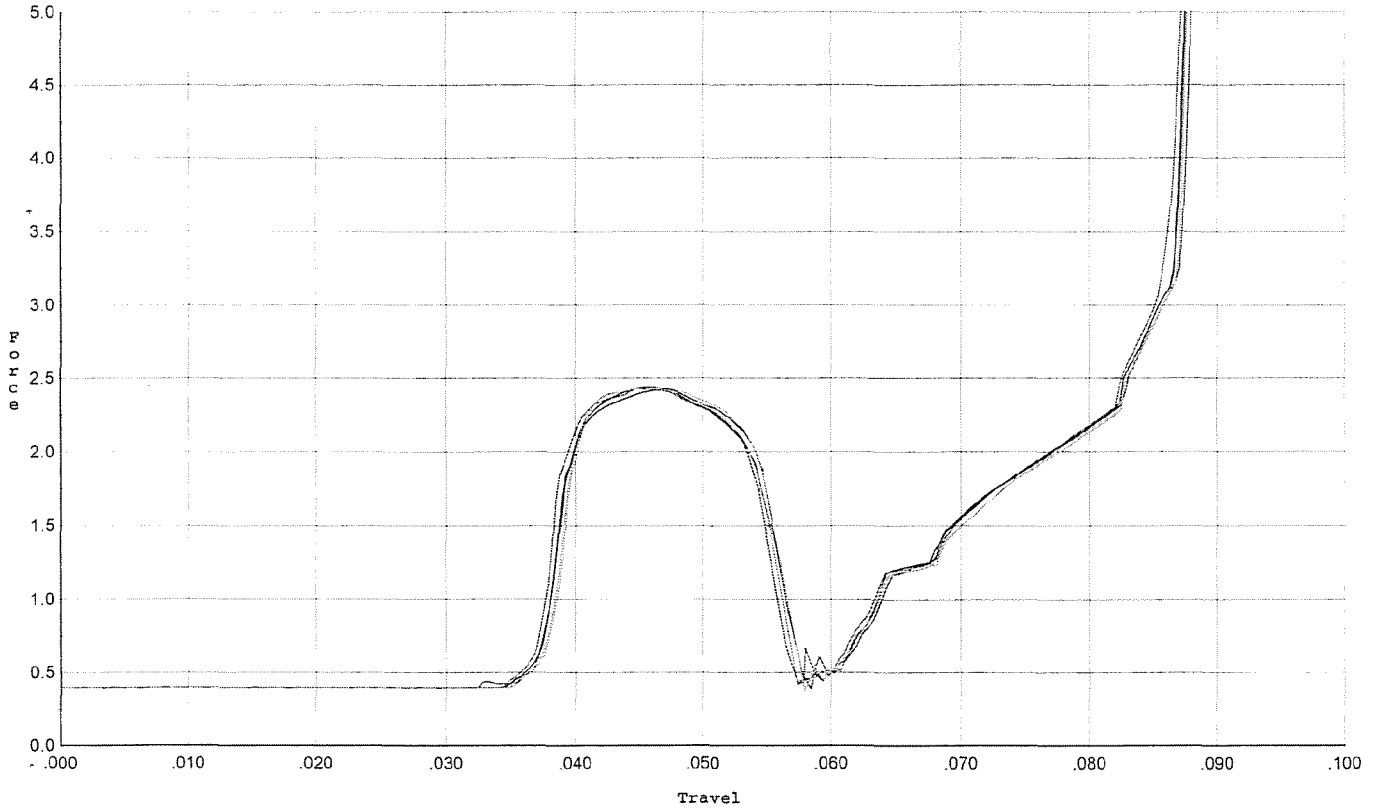
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.050	0.055	0.032	0.035	0.087		Set Trigger
2	4.026	0.055	0.035	0.036	0.085		Set Trigger
3	4.051	0.055	0.035	0.036	0.085		Set Trigger
4	4.066	0.055	0.035	0.035	0.086		Set Trigger
5	4.081	0.055	0.035	0.035	0.086		Set Trigger

Aug 4.05

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



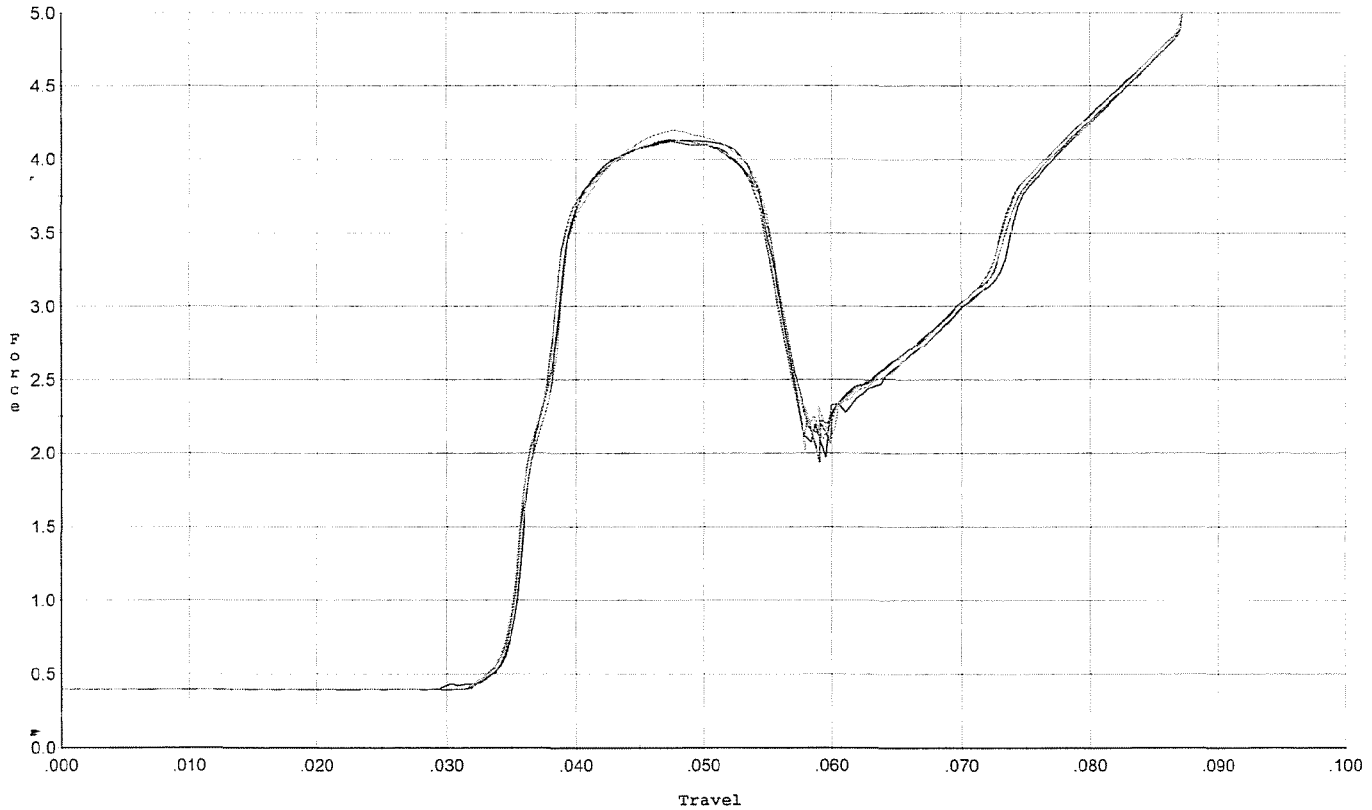
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.428	0.055	0.037	0.038	0.053		Set Trigger
2	2.439	0.055	0.037	0.038	0.053		Set Trigger
3	2.428	0.054	0.037	0.038	0.053		Set Trigger
4	2.437	0.056	0.038	0.038	0.054		Set Trigger
5	2.433	0.055	0.038	0.038	0.053		Set Trigger

Aug 2.43

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	4.126	0.055	0.034	0.035	0.089		Set Trigger
2	4.128	0.056	0.035	0.035	0.089		Set Trigger
3	4.115	0.054	0.034	0.035	0.087		Set Trigger
4	4.136	0.056	0.034	0.035	0.090		Set Trigger
5	4.196	0.055	0.034	0.035	0.088		Set Trigger

Avg 4.14