

G6794550

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



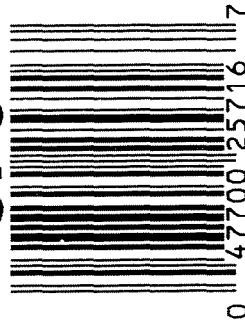
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794550

UPC



GUN SERIAL #

G 6794550

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SPJ
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SPJ
460	CHECK HEADSPACE		10-7-08	SPJ
470	DIS-ASSEMBLE ACTION		10-7-08	SPJ
472	SERIALIZE BOLT HANDLE		10-8-08	R&N
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION		10/11/08	(18)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10/15	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-15-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-15-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-15-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-7-08	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

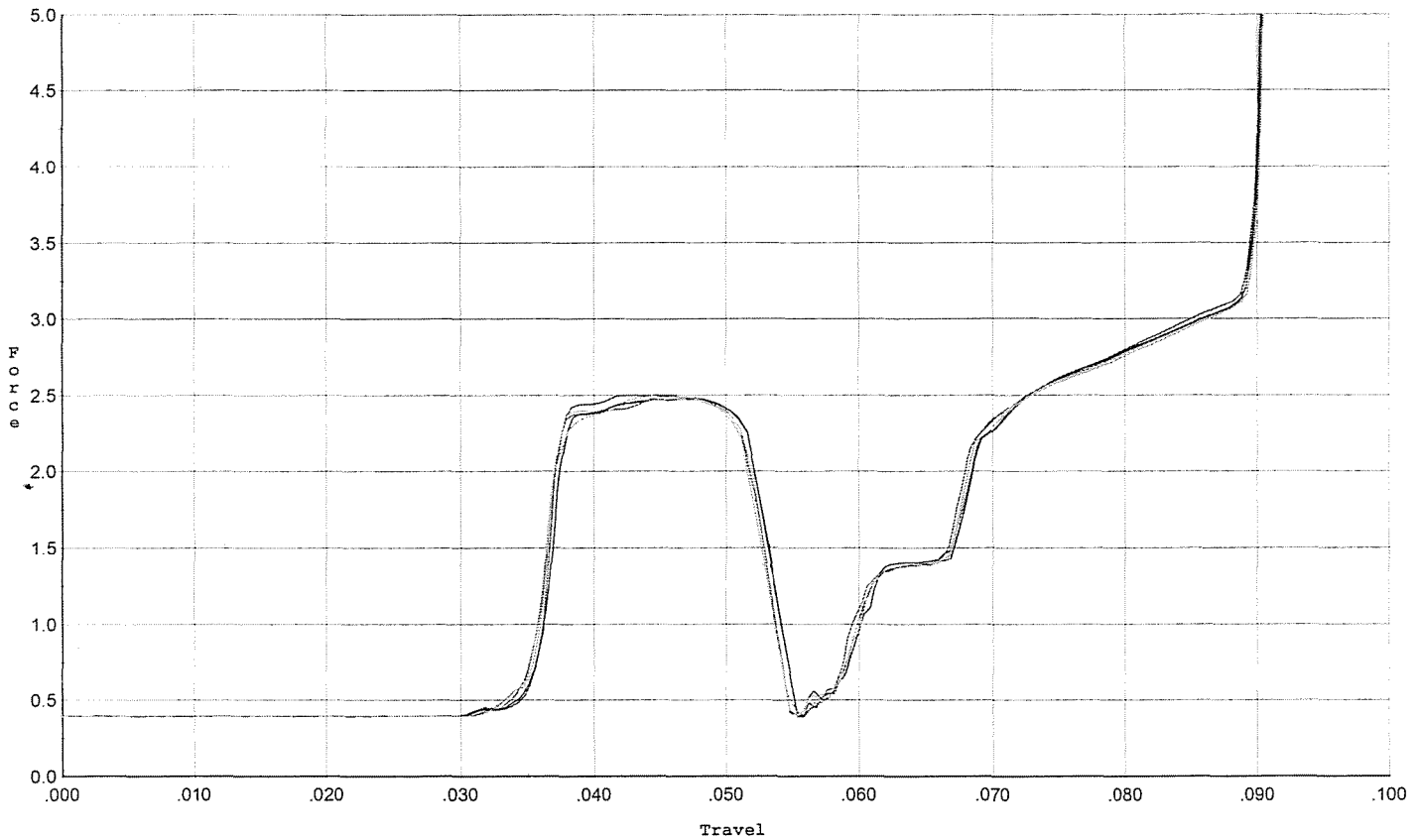
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	11-13-08	R 90
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>60</u>	11-13-08	R 90
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-13-08	R 90
	J) ASSEMBLE STOCK		11-7-08	R 90
	K) ASSEMBLE SWIVEL STUDS		11-13-08	R 90
	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	PASS FAIL PASS FAIL	11-10-08	R 90
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-10-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-13-08	R 90
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.53</u> <u>2.55</u> <u>2.57</u> <u>2.52</u>	11-10-08	TC
	C) FUNCTION		11-13-08	R 90
690	PACK		11/17/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



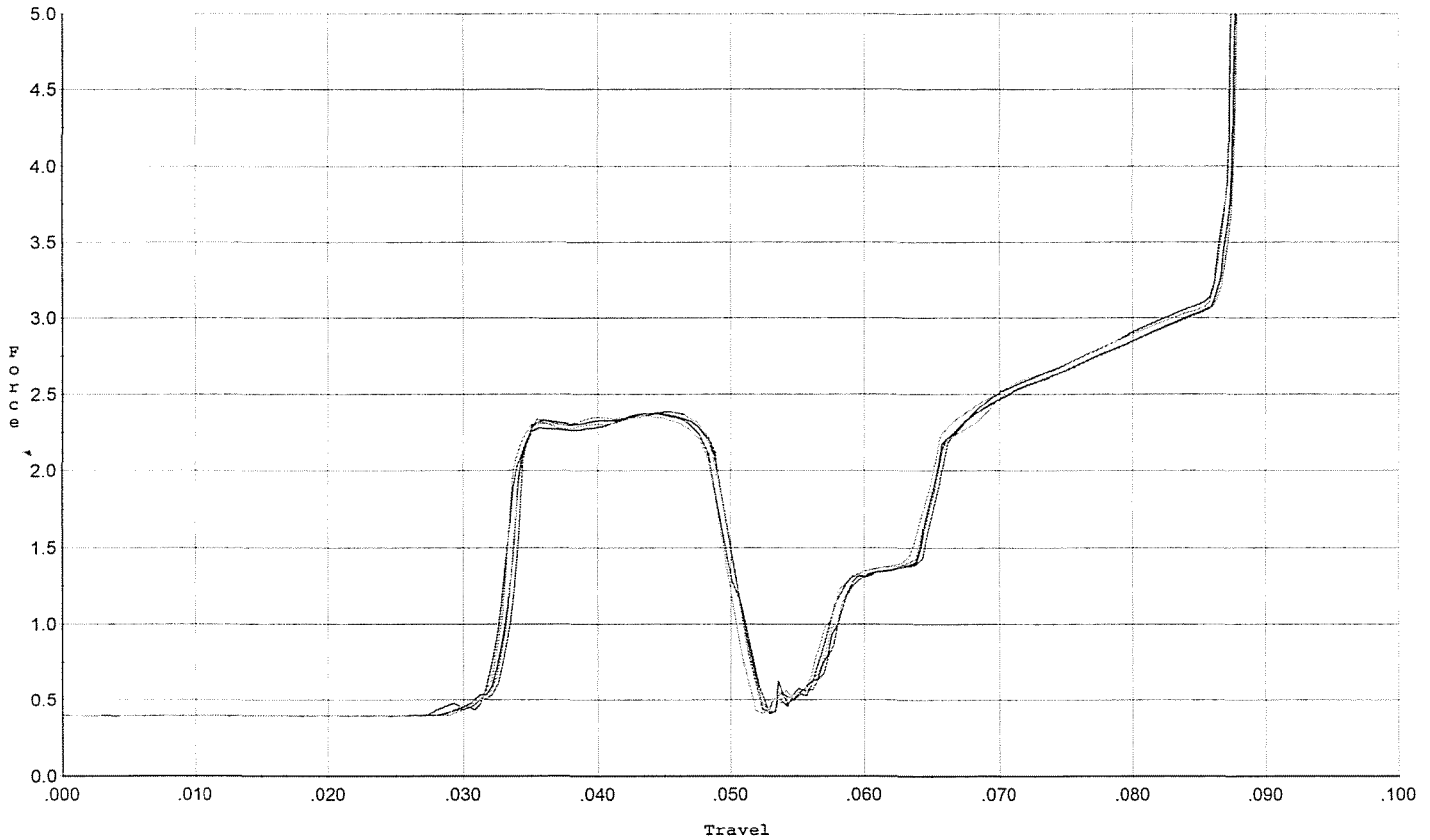
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.053	0.035	0.041	0.055		Set Trigger
2	2.474	0.053	0.035	0.041	0.054		Set Trigger
3	2.485	0.052	0.035	0.041	0.053		Set Trigger
4	2.501	0.052	0.035	0.041	0.053		Set Trigger
5	2.477	0.053	0.035	0.041	0.053		Set Trigger

AVG 2.48

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



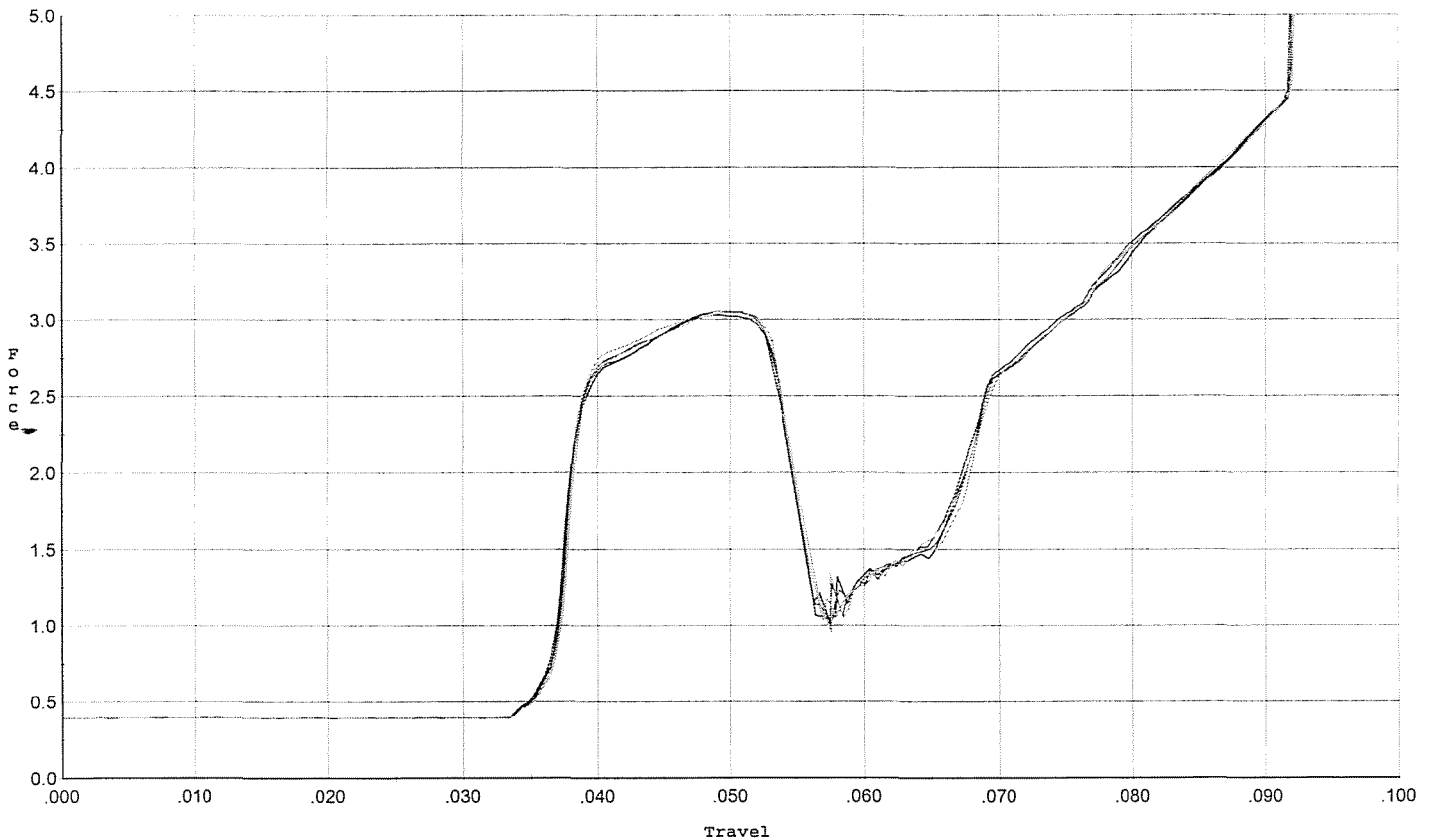
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.378	0.048	0.032	0.042	0.049		Set Trigger
2	2.374	0.049	0.032	0.042	0.050		Set Trigger
3	2.385	0.049	0.033	0.042	0.049		Set Trigger
4	2.391	0.049	0.032	0.042	0.050		Set Trigger
5	2.355	0.048	0.032	0.042	0.049		Set Trigger

Avg 2.37

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



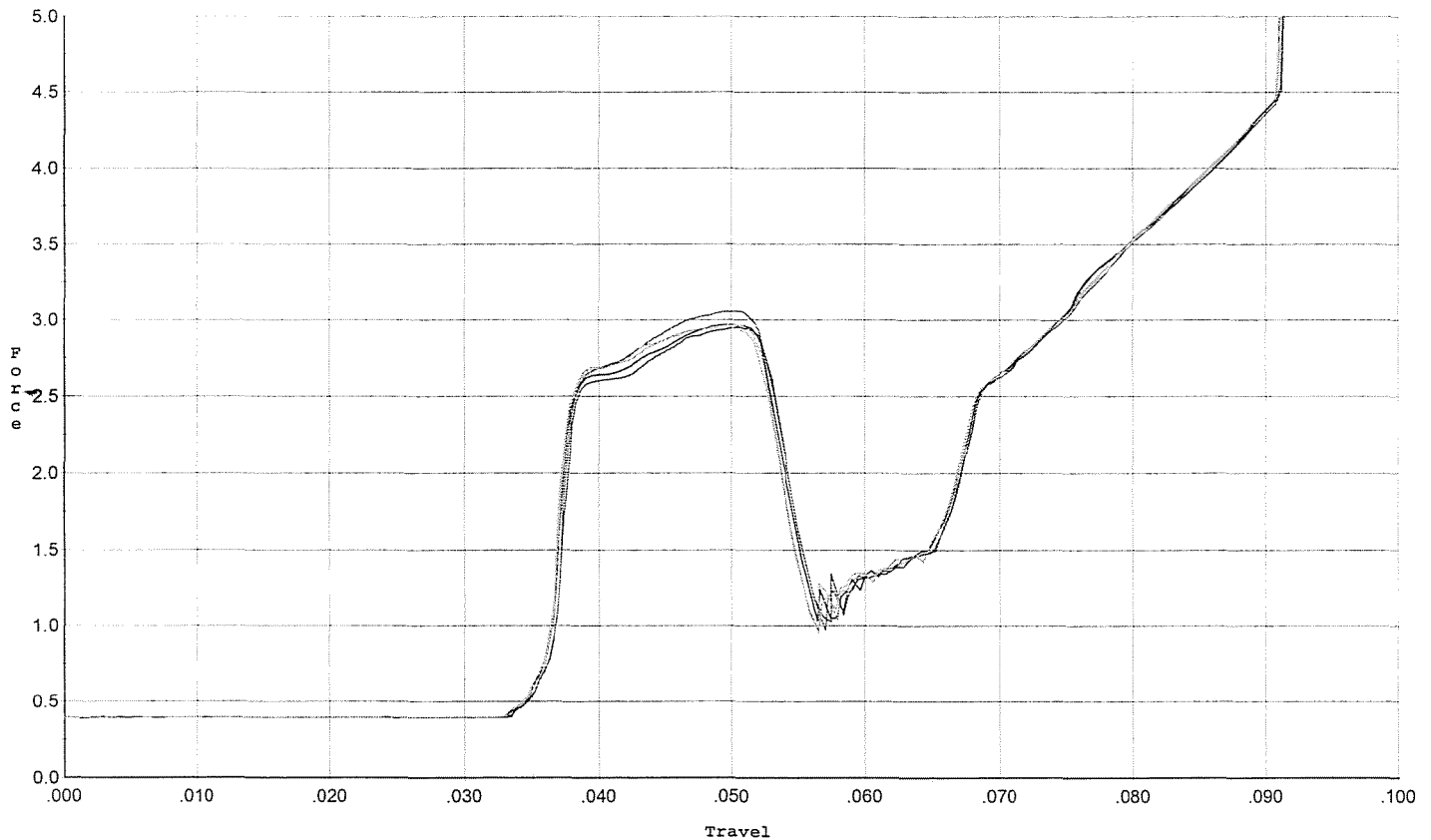
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.030	0.054	0.036	0.040	0.063		Set Trigger
2	3.053	0.053	0.036	0.040	0.062		Set Trigger
3	3.054	0.054	0.036	0.040	0.062		Set Trigger
4	3.050	0.053	0.036	0.040	0.062		Set Trigger
5	3.045	0.053	0.036	0.040	0.062		Set Trigger

Avg 3.04

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



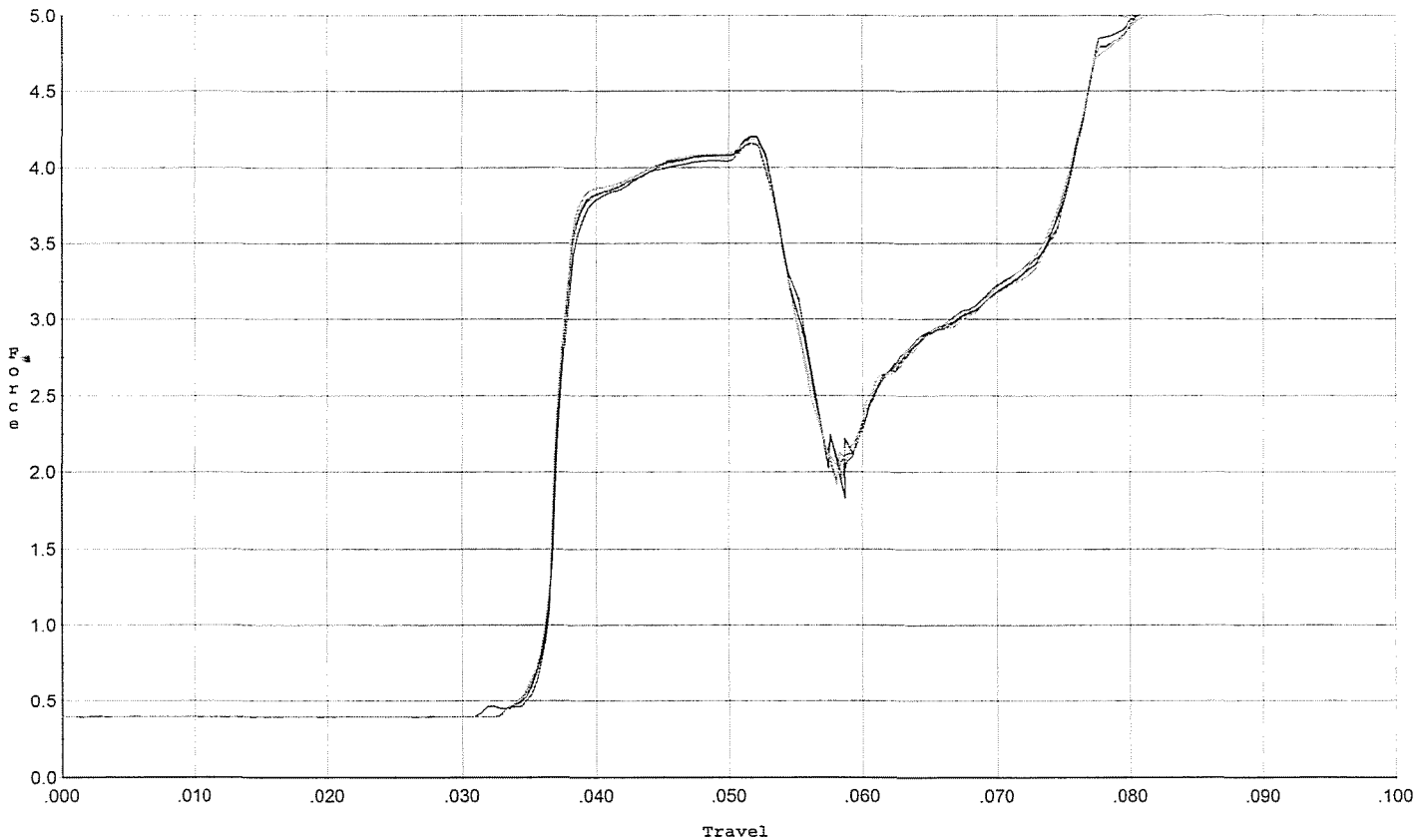
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.954	0.053	0.036	0.040	0.060		Set Trigger
2	2.969	0.052	0.035	0.040	0.059		Set Trigger
3	3.054	0.053	0.035	0.040	0.062		Set Trigger
4	2.953	0.053	0.035	0.040	0.061		Set Trigger
5	2.970	0.052	0.035	0.040	0.060		Set Trigger

Aug 2, 98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



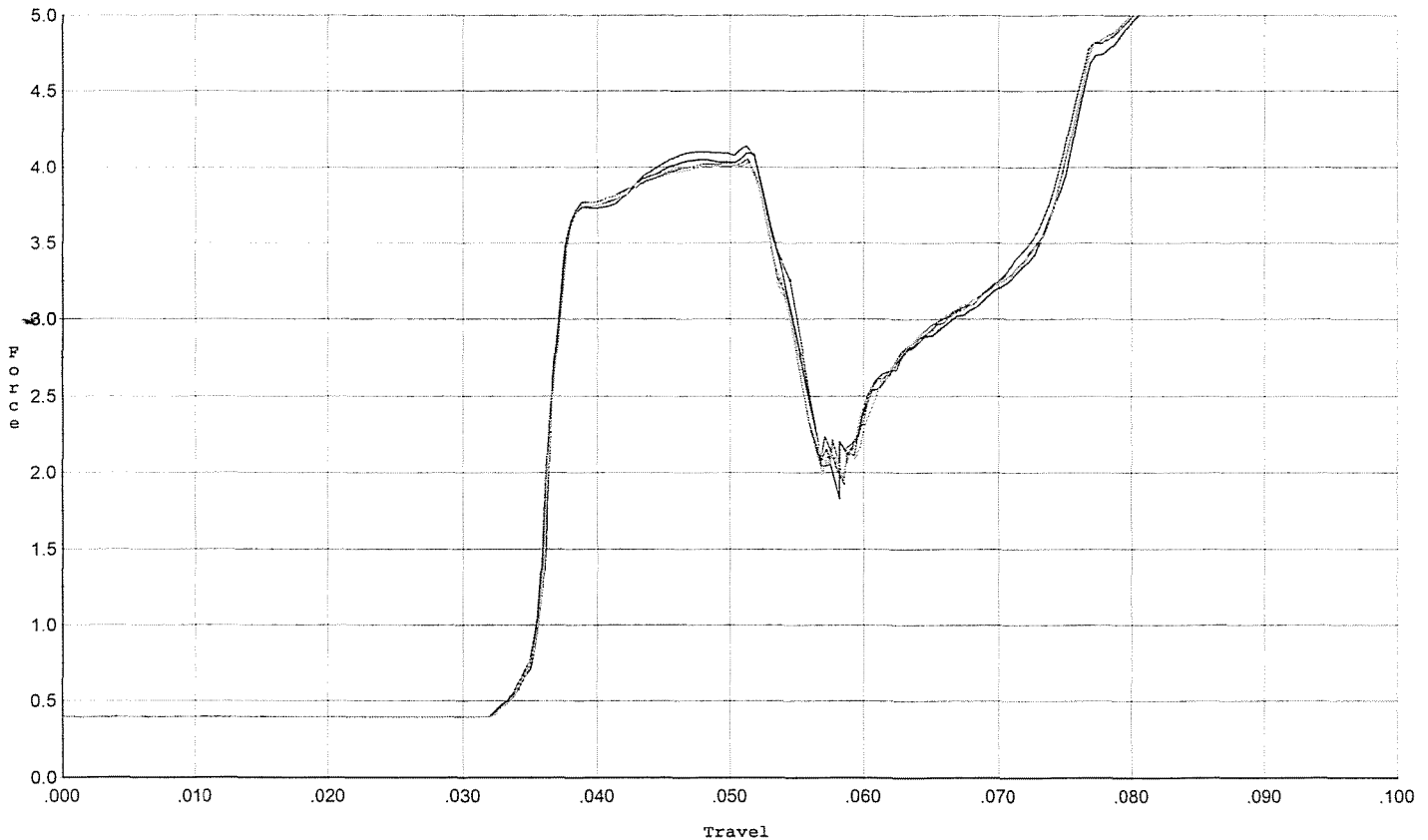
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.196	0.055	0.036	0.037	0.087		Set Trigger
2	4.203	0.056	0.035	0.037	0.087		Set Trigger
3	4.160	0.053	0.035	0.037	0.082		Set Trigger
4	4.159	0.053	0.035	0.037	0.082		Set Trigger
5	4.186	0.053	0.035	0.037	0.083		Set Trigger

Aug 4.18

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



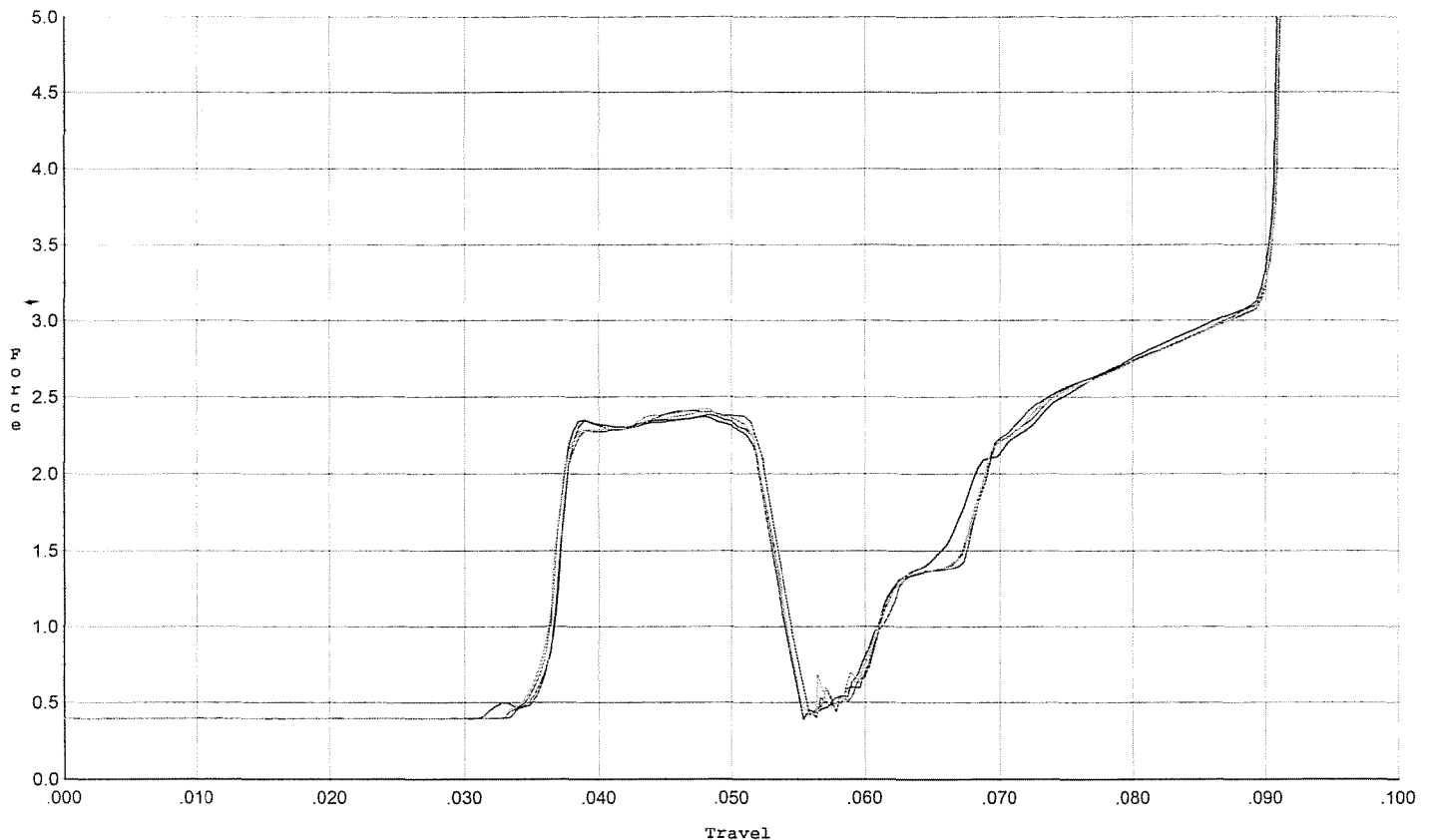
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.139	0.055	0.034	0.037	0.087		Set Trigger
2	4.095	0.055	0.034	0.037	0.087		Set Trigger
3	4.055	0.054	0.034	0.037	0.084		Set Trigger
4	4.031	0.052	0.035	0.037	0.079		Set Trigger
5	4.031	0.054	0.034	0.037	0.084		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



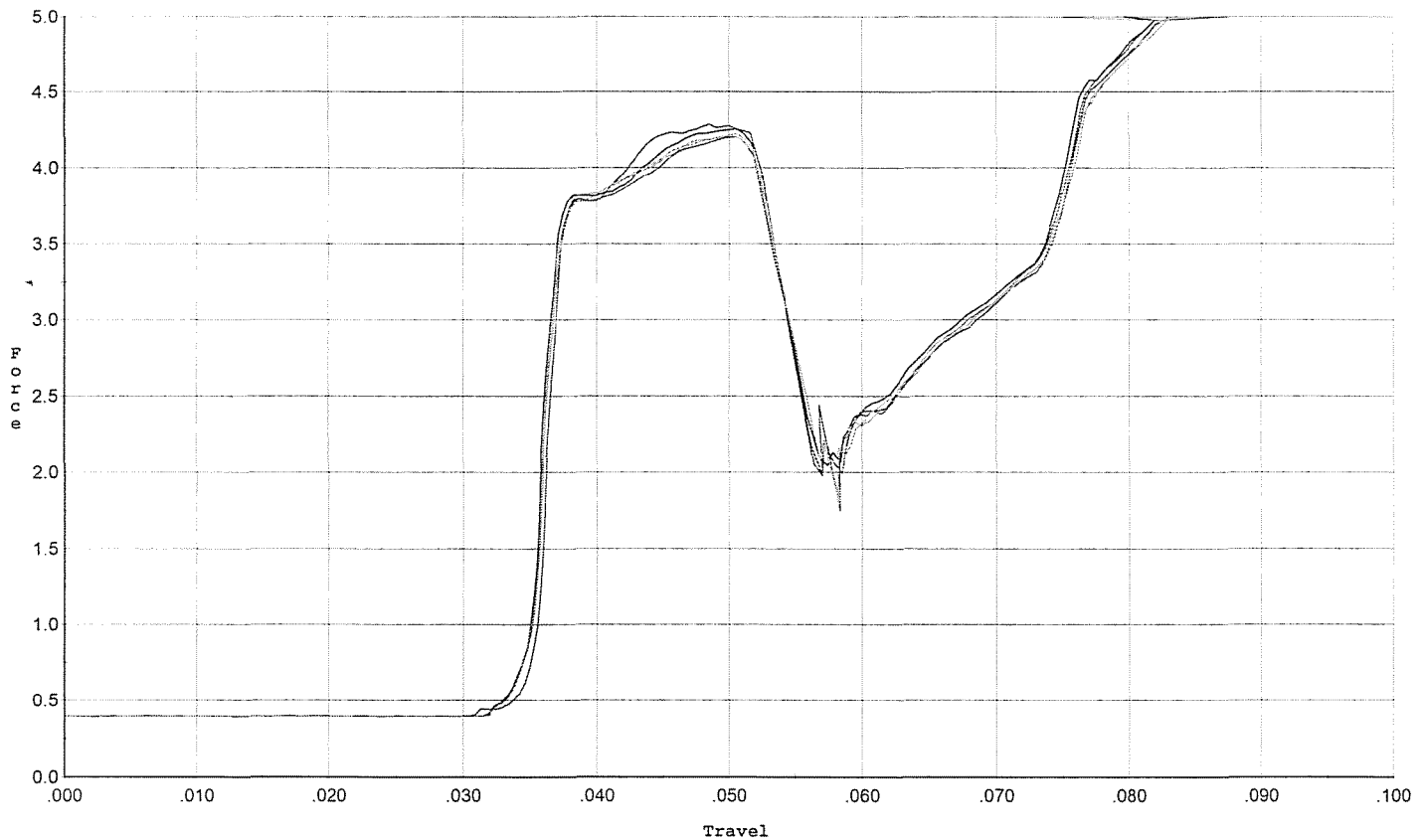
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.382	0.053	0.036	0.042	0.052		Set Trigger
2	2.372	0.052	0.035	0.042	0.051		Set Trigger
3	2.410	0.052	0.035	0.042	0.051		Set Trigger
4	2.404	0.052	0.035	0.042	0.051		Set Trigger
5	2.421	0.053	0.035	0.042	0.053		Set Trigger

Avg 2.39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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	4.285	0.053	0.035	0.037	0.084		Set Trigger
2	4.257	0.054	0.034	0.036	0.088		Set Trigger
3	4.199	0.054	0.034	0.037	0.087		Set Trigger
4	4.207	0.055	0.034	0.036	0.090		Set Trigger
5	4.222	0.053	0.034	0.037	0.084		Set Trigger

Avg 4.23