

66794557

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

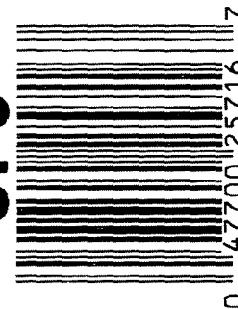
24"

CAPACITY

6

G6794557

UPC



GUN SERIAL #

G 6794557

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	MAGNA FLUX	10-1-08	Rsn
475	DRILL AND TAP SIGHT HOLES	2008	10-1-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (K)	10/2/08	(K)
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		10-29-08	Rsn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

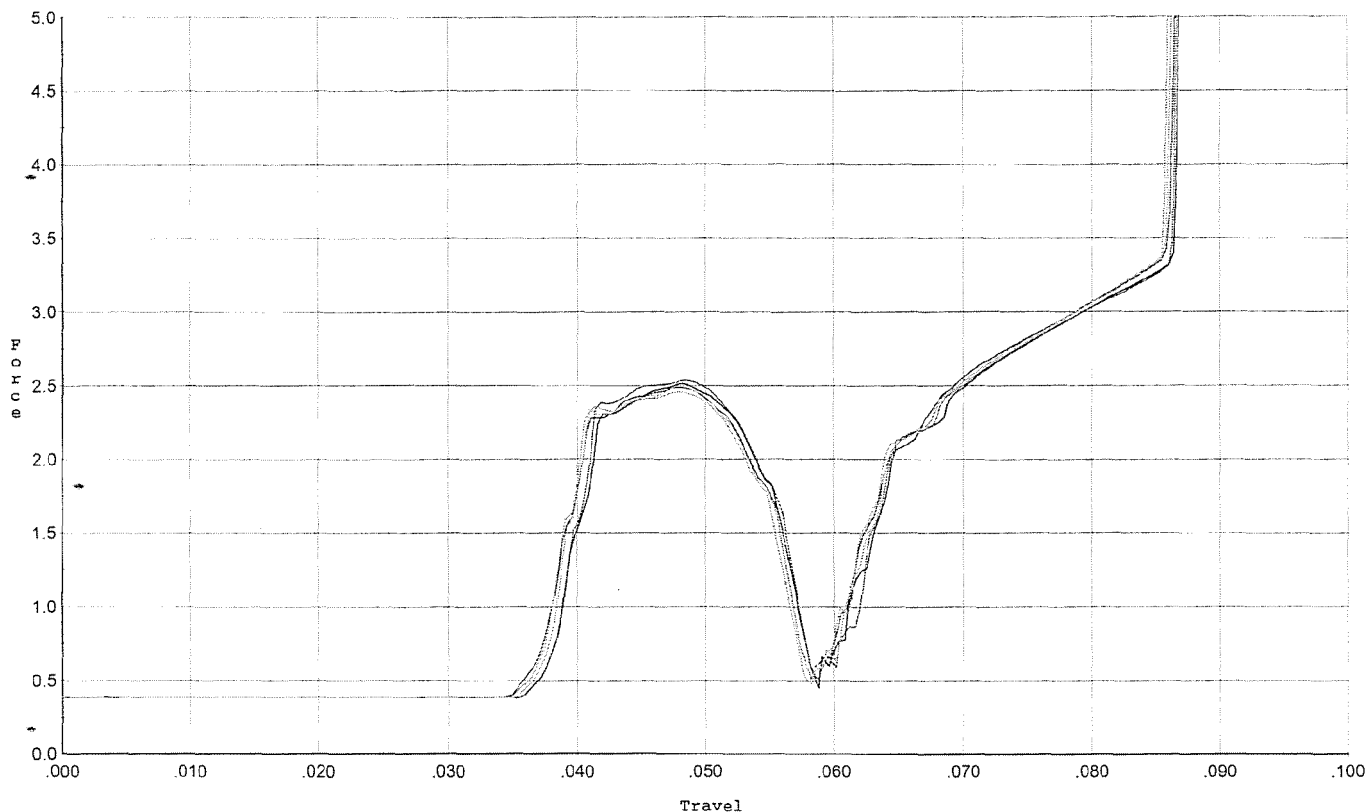
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-11-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-11-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-11-08	LJ
	J) ASSEMBLE STOCK		10-29-08	Ren
	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 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-30-08	Ren
	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	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.78</u> <u>2.83</u> <u>2.87</u> <u>2.70</u>	11/5/08	Fm
	C) FUNCTION		11-11-08	LJ
690	PACK		11/12/08	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.



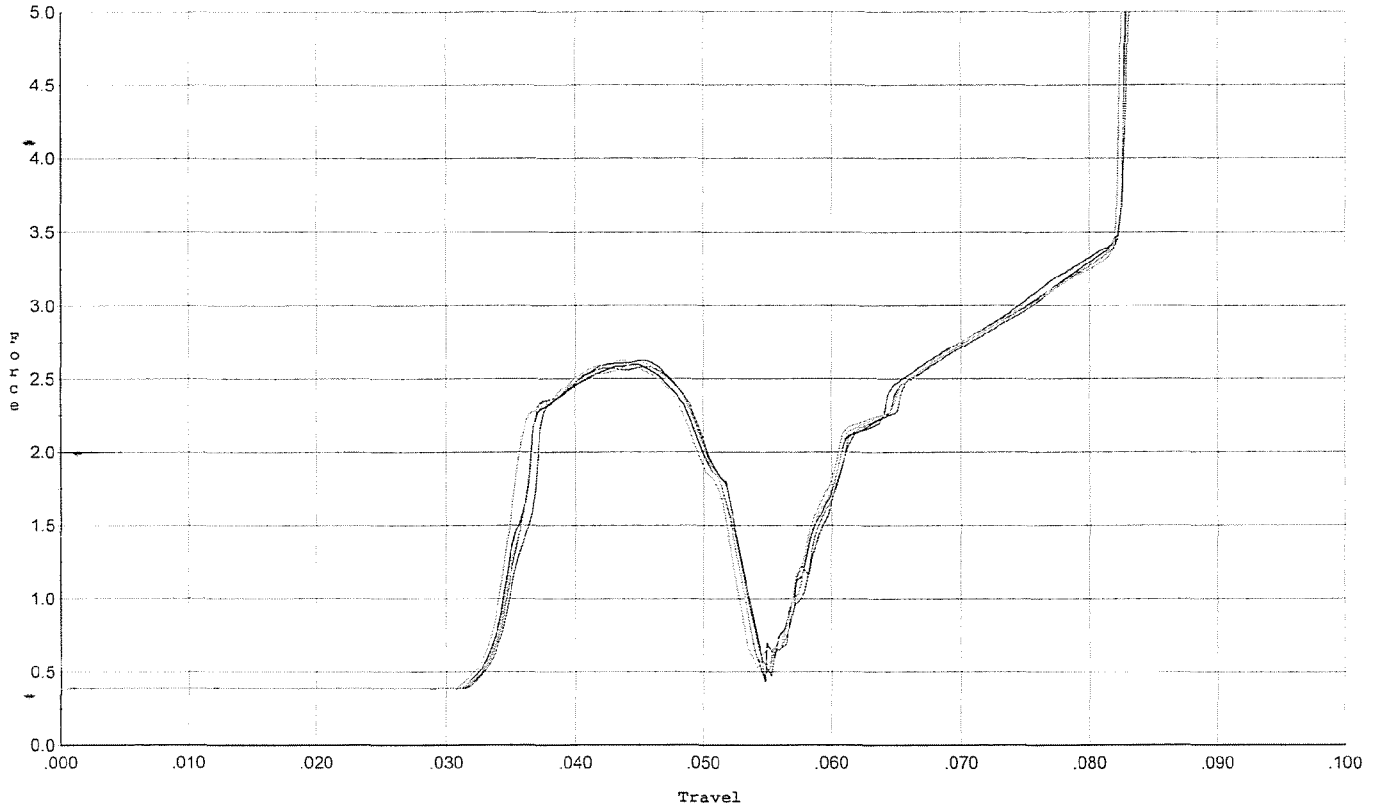
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.486	0.055	0.036	0.037	0.054		Set Trigger
2	2.517	0.056	0.038	0.037	0.054		Set Trigger
3	2.536	0.056	0.038	0.037	0.054		Set Trigger
4	2.488	0.055	0.037	0.037	0.053		Set Trigger
5	2.457	0.056	0.037	0.037	0.054		Set Trigger

Avg 2.49

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.



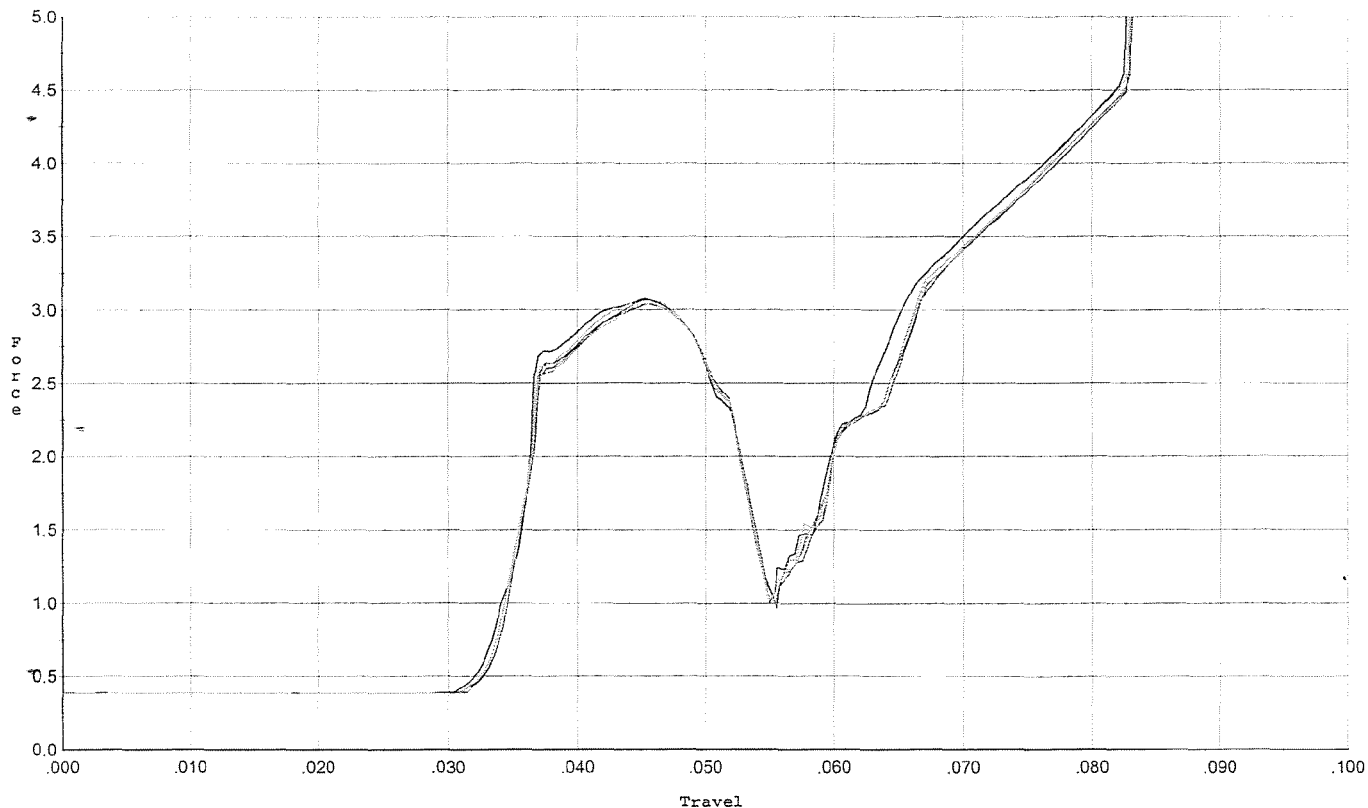
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.626	0.052	0.034	0.036	0.053		Set Trigger
2	2.598	0.052	0.033	0.036	0.054		Set Trigger
3	2.583	0.052	0.033	0.036	0.053		Set Trigger
4	2.629	0.052	0.033	0.035	0.054		Set Trigger
5	2.591	0.051	0.033	0.035	0.053		Set Trigger

Avg 2.60

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.



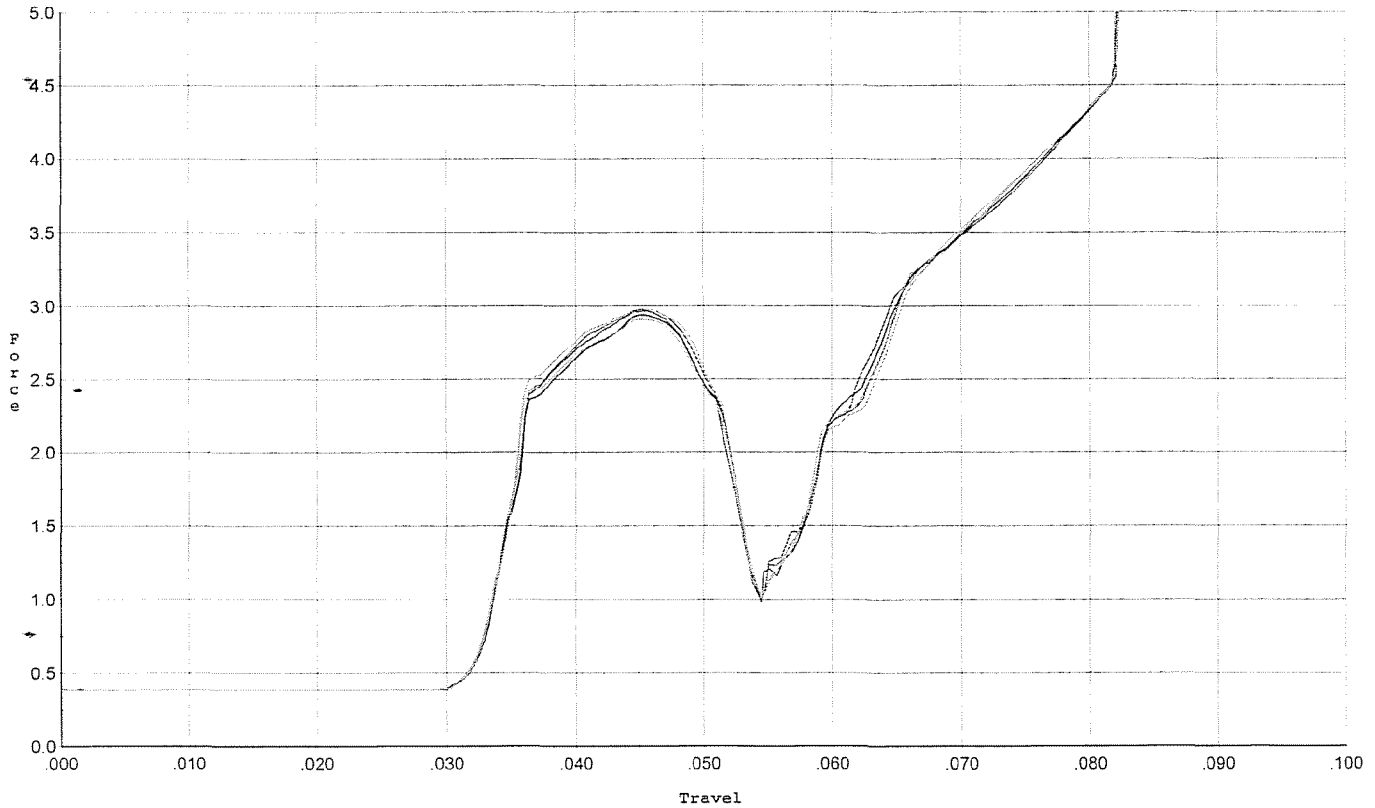
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.041	0.053	0.033	0.035	0.063		Set Trigger
2	3.077	0.052	0.033	0.035	0.062		Set Trigger
3	3.071	0.053	0.033	0.035	0.063		Set Trigger
4	3.084	0.052	0.033	0.035	0.061		Set Trigger
5	3.045	0.052	0.033	0.035	0.061		Set Trigger

Avg 3.06

Trigger Profile [lbs,inch]

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

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



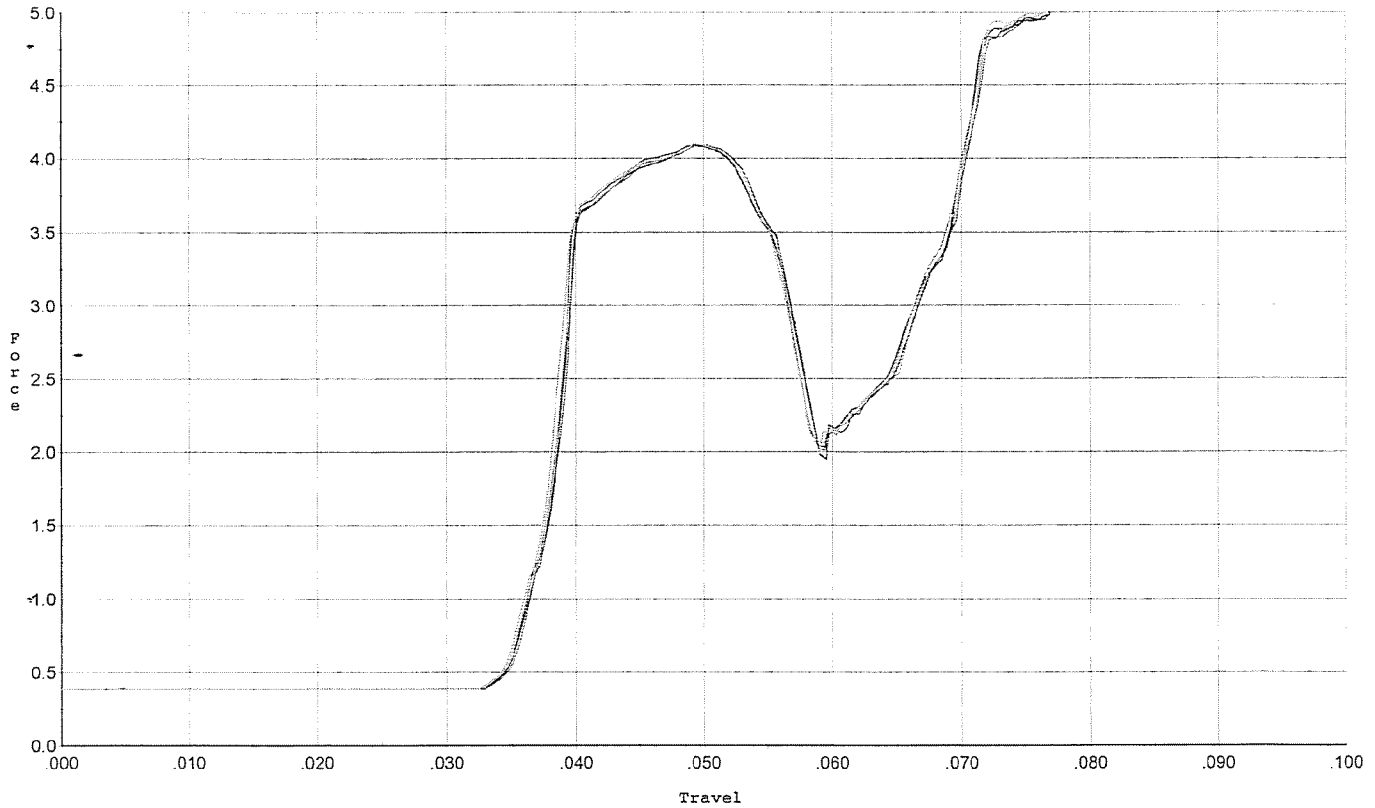
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.967	0.052	0.032	0.034	0.061		Set Trigger
2	2.940	0.052	0.032	0.035	0.060		Set Trigger
3	2.980	0.052	0.032	0.035	0.060		Set Trigger
4	2.909	0.052	0.032	0.035	0.060		Set Trigger
5	2.974	0.051	0.032	0.034	0.061		Set Trigger

Avg 2.95

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.



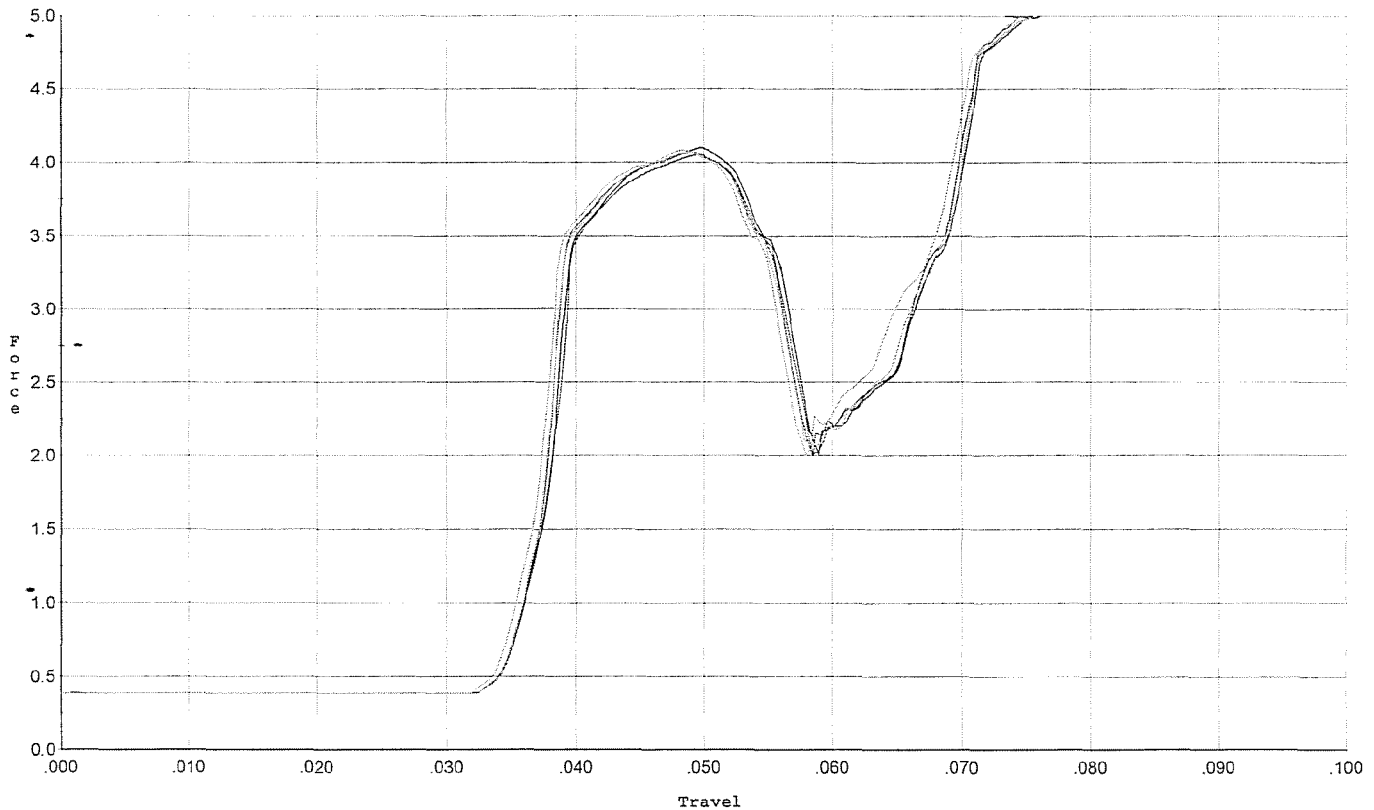
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.093	0.056	0.035	0.034	0.085		Set Trigger
2	4.089	0.056	0.035	0.034	0.086		Set Trigger
3	4.083	0.057	0.035	0.033	0.088		Set Trigger
4	4.099	0.056	0.035	0.034	0.086		Set Trigger
5	4.082	0.056	0.035	0.033	0.087		Set Trigger

Aug 4.08

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. after 20 cycles +/- 1.0 lbs.



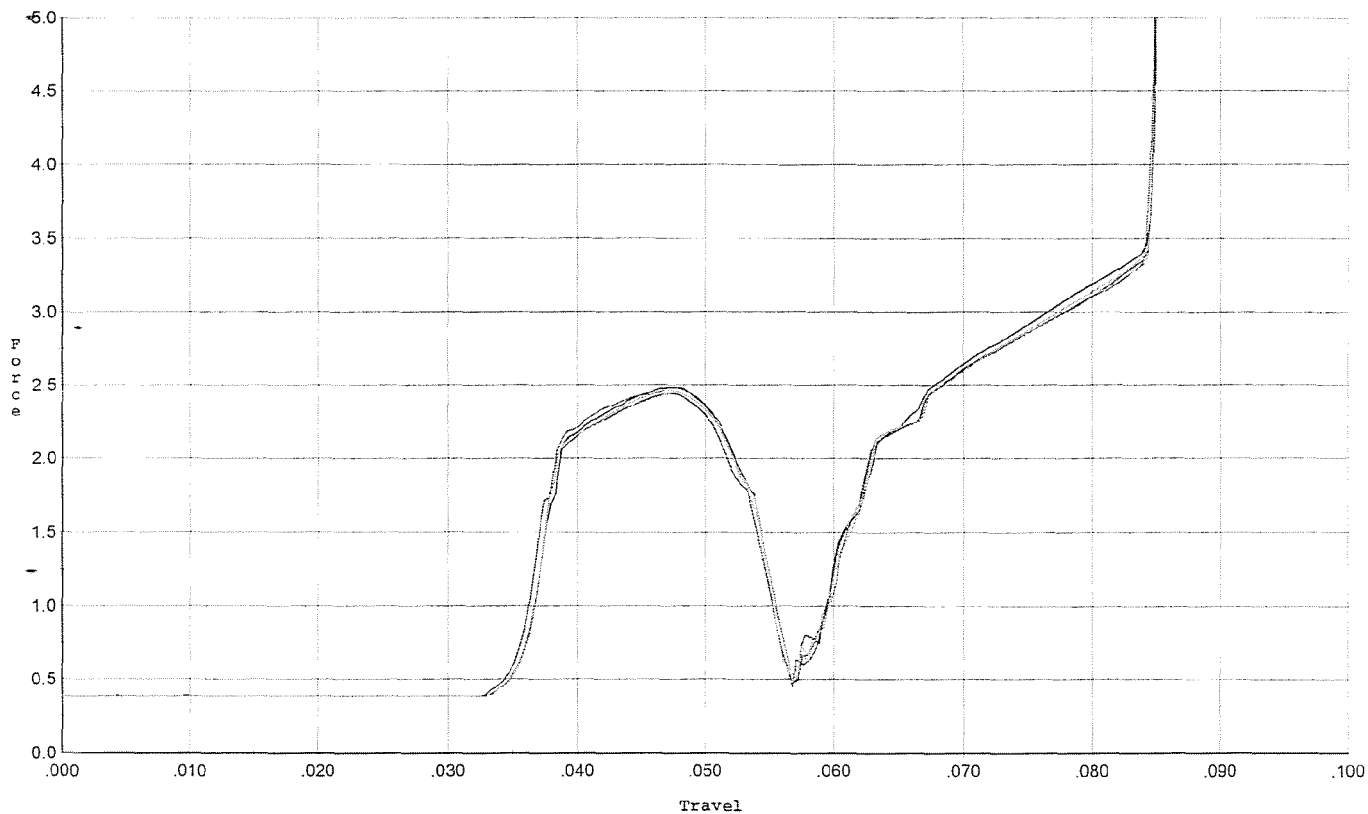
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.057	0.035	0.033	0.086		Set Trigger
2	4.101	0.056	0.035	0.033	0.086		Set Trigger
3	4.068	0.055	0.035	0.033	0.085		Set Trigger
4	4.070	0.056	0.035	0.033	0.085		Set Trigger
5	4.086	0.055	0.034	0.034	0.085		Set Trigger

Aug 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: reset to 2.5 lbs. +/- .50 lbs. for final test



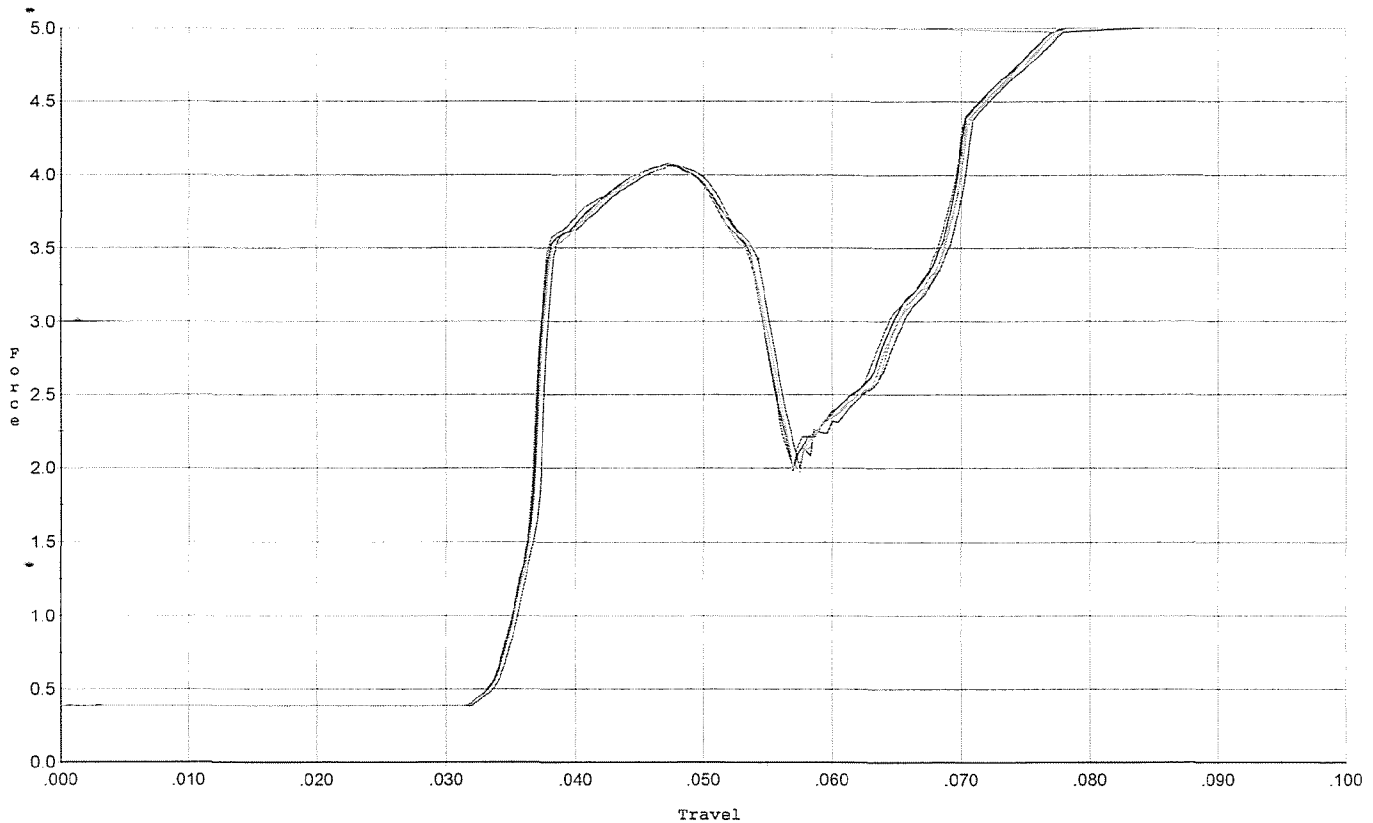
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.445	0.054	0.035	0.036	0.053		Set Trigger
2	2.483	0.054	0.035	0.037	0.053		Set Trigger
3	2.484	0.054	0.035	0.037	0.053		Set Trigger
4	2.451	0.054	0.035	0.037	0.052		Set Trigger
5	2.465	0.054	0.036	0.037	0.053		Set Trigger

Avg 2.46

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	4.069	0.054	0.034	0.034	0.083		Set Trigger
2	4.067	0.054	0.034	0.034	0.083		Set Trigger
3	4.079	0.054	0.034	0.034	0.083		Set Trigger
4	4.073	0.055	0.034	0.034	0.085		Set Trigger
5	4.058	0.054	0.034	0.034	0.082		Set Trigger

Avg 4.06