

66794566

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

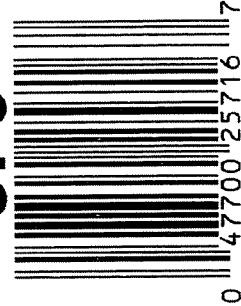
24"

CAPACITY

6

G6794566

UPC



GUN SERIAL #

G 6794566

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	RBN
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/11/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-4-08	RBN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

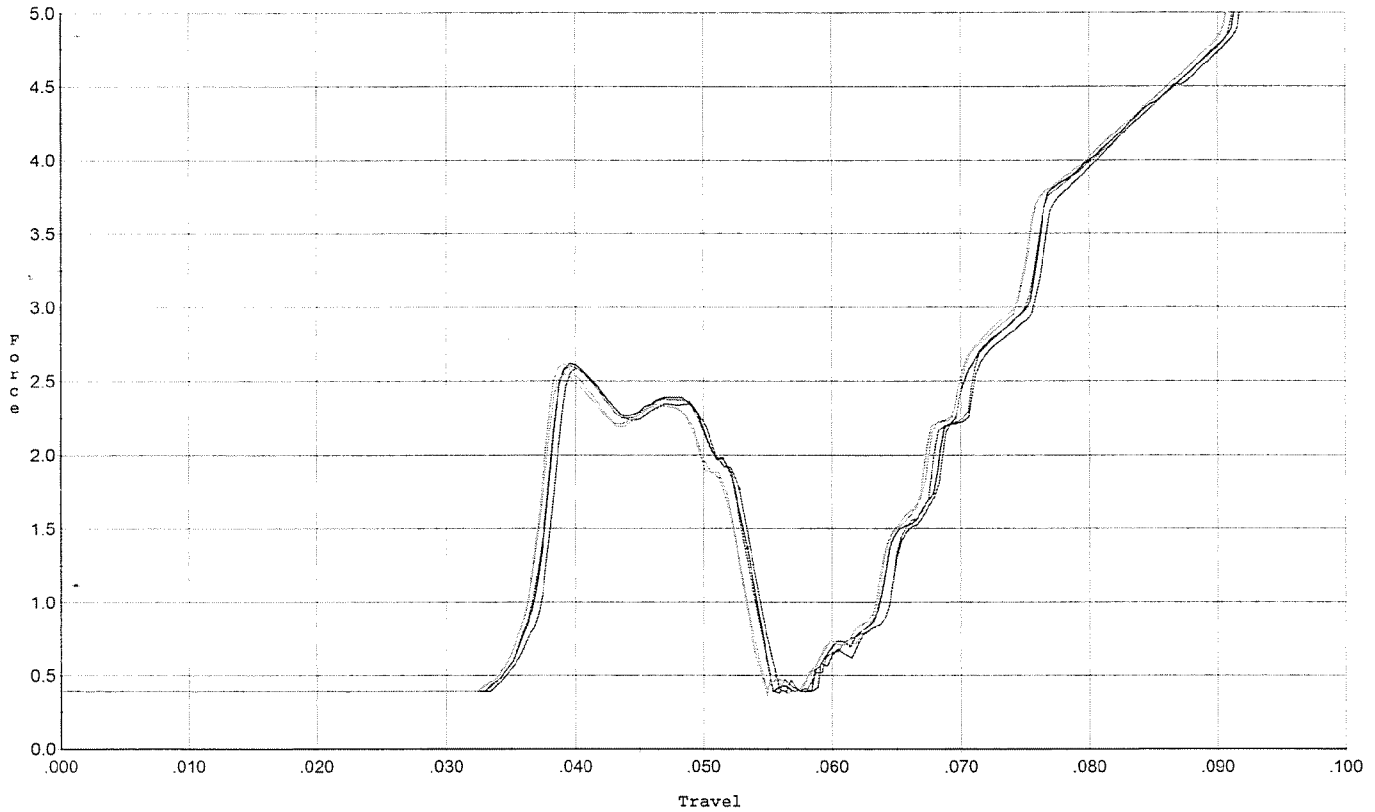
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-12-08	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>4.5</u>	11-12-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-12-08	L.N.
	J) ASSEMBLE STOCK		11-4-08	RSW
	K) ASSEMBLE SWIVEL STUDS		11-12-08	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	11-5-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	RSW
670	FINAL INSPECTION A) HEADSPACE		11-12-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.46</u> <u>2.43</u> <u>2.41</u> <u>2.38</u>	11-5-08	TC
	C) FUNCTION		11-12-08	L.N.
690	PACK		11/13/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



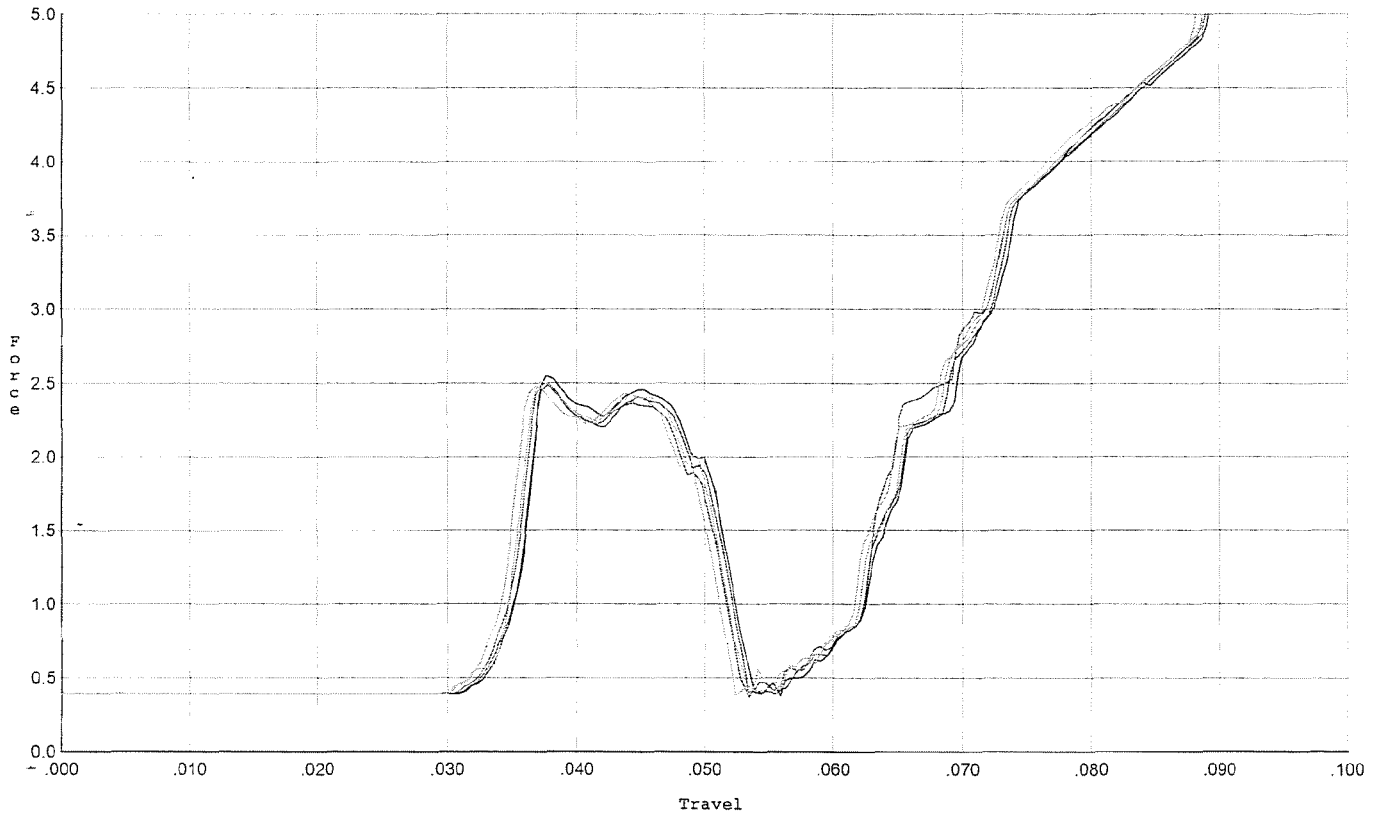
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.585	0.053	0.036	0.042	0.050		Set Trigger
2	2.619	0.053	0.035	0.042	0.052		Set Trigger
3	2.602	0.052	0.035	0.042	0.050		Set Trigger
4	2.546	0.052	0.035	0.043	0.049		Set Trigger
5	2.615	0.052	0.034	0.042	0.050		Set Trigger

AVG 2.59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



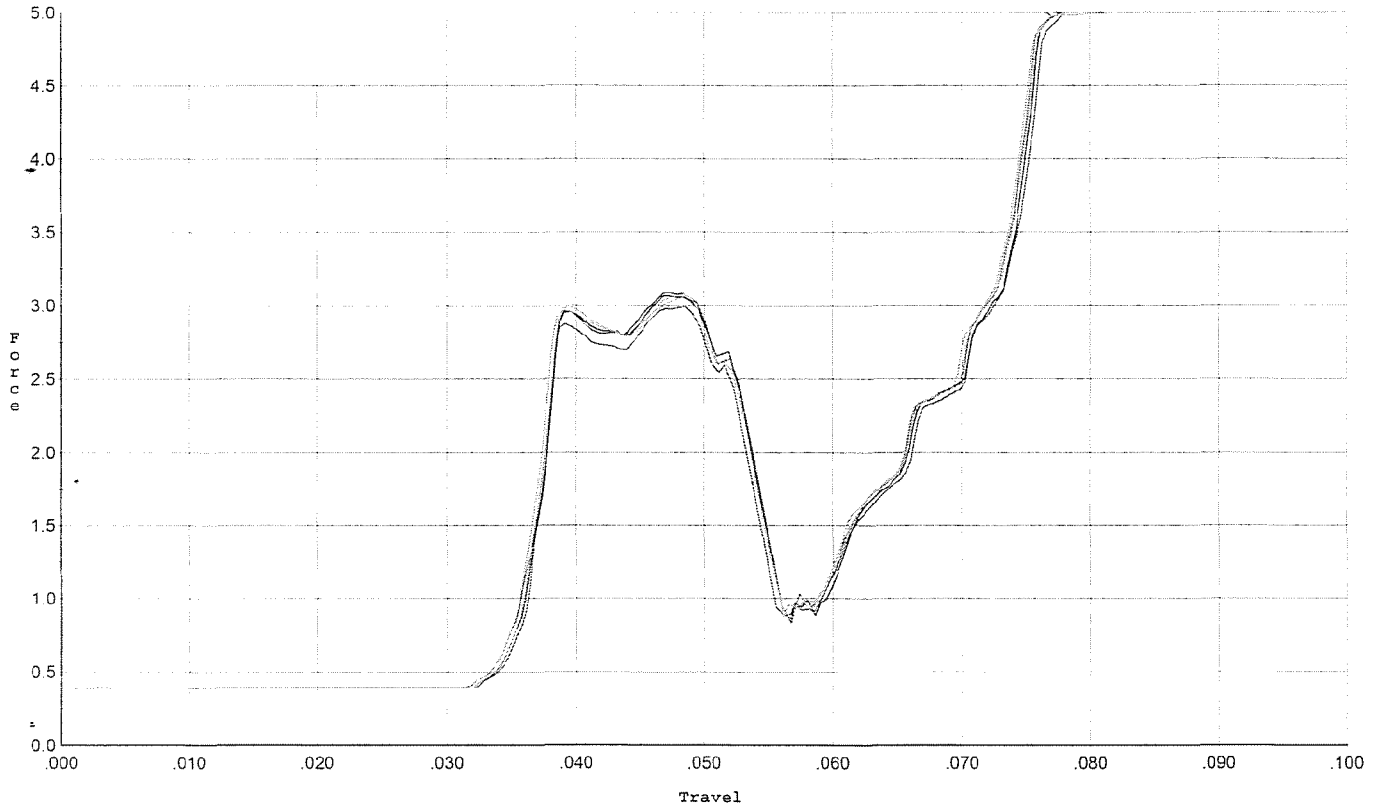
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.490	0.051	0.034	0.042	0.049		Set Trigger
2	2.547	0.051	0.034	0.041	0.050		Set Trigger
3	2.503	0.051	0.033	0.042	0.049		Set Trigger
4	2.509	0.050	0.034	0.042	0.049		Set Trigger
5	2.478	0.050	0.033	0.042	0.049		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/28/08

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



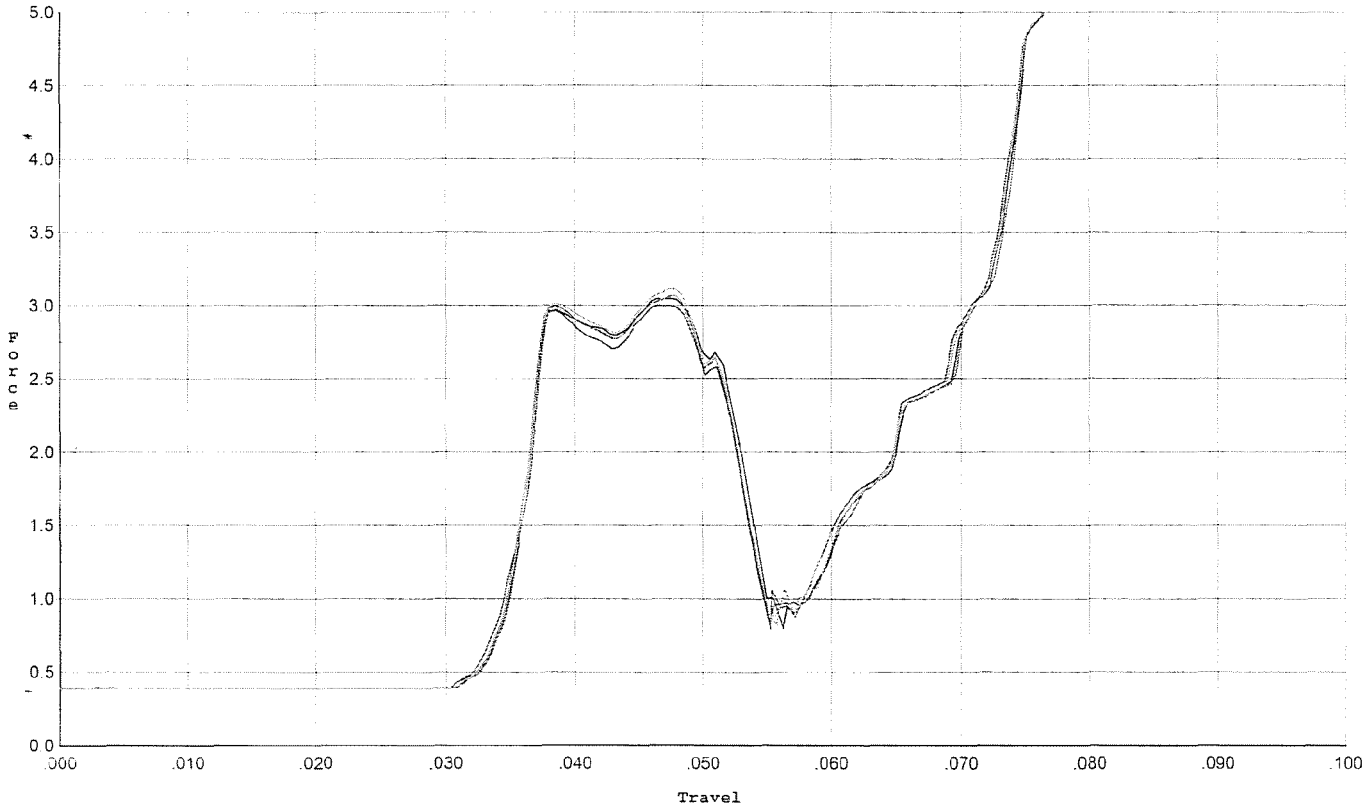
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.088	0.054	0.035	0.037	0.063		Set Trigger
2	3.066	0.053	0.034	0.037	0.061		Set Trigger
3	2.994	0.054	0.034	0.036	0.061		Set Trigger
4	3.078	0.053	0.034	0.036	0.062		Set Trigger
5	3.057	0.054	0.035	0.036	0.063		Set Trigger

Aug 3.05

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/28/08

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



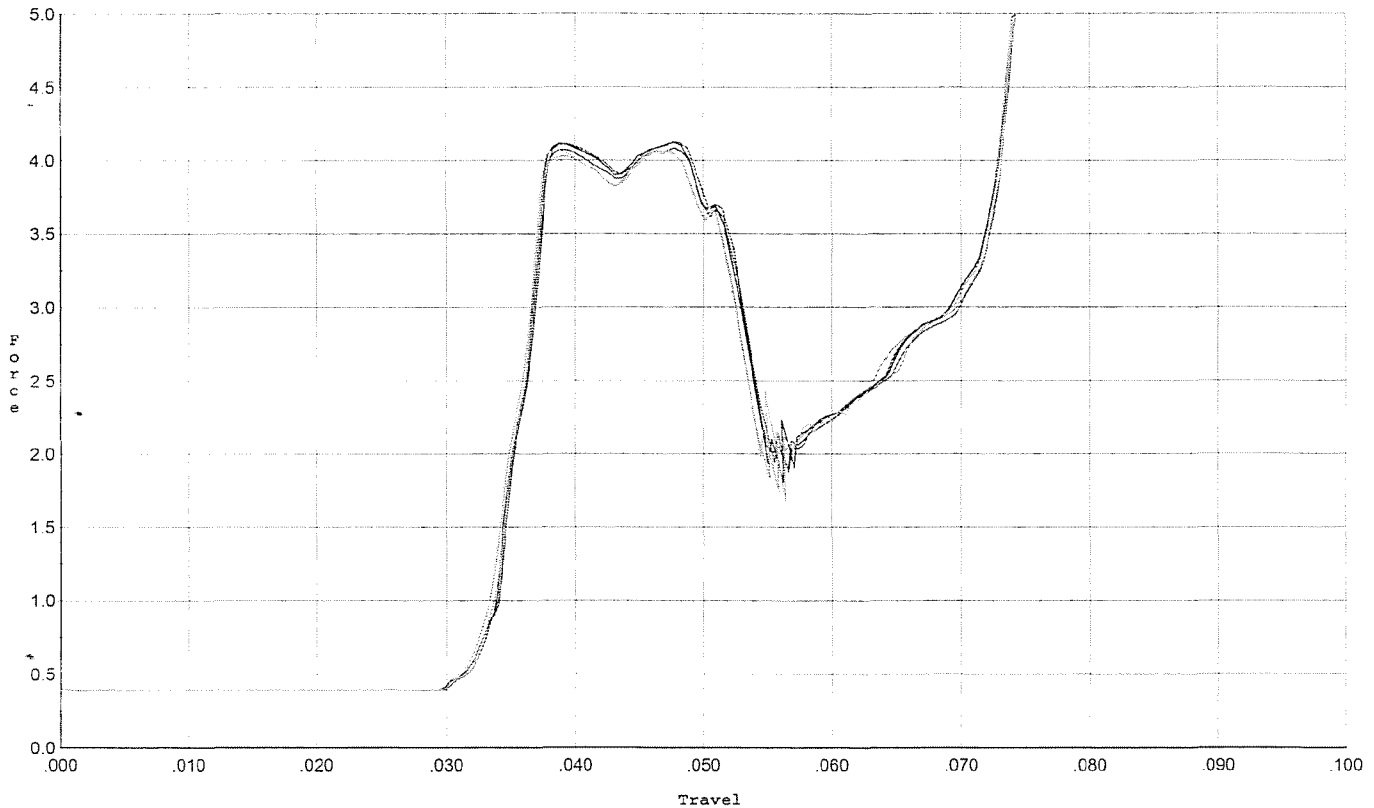
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.001	0.052	0.033	0.036	0.061		Set Trigger
2	3.047	0.053	0.034	0.036	0.063		Set Trigger
3	3.066	0.052	0.033	0.036	0.062		Set Trigger
4	3.071	0.052	0.034	0.036	0.061		Set Trigger
5	3.118	0.052	0.033	0.036	0.062		Set Trigger

Aug 3.06

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/28/08

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



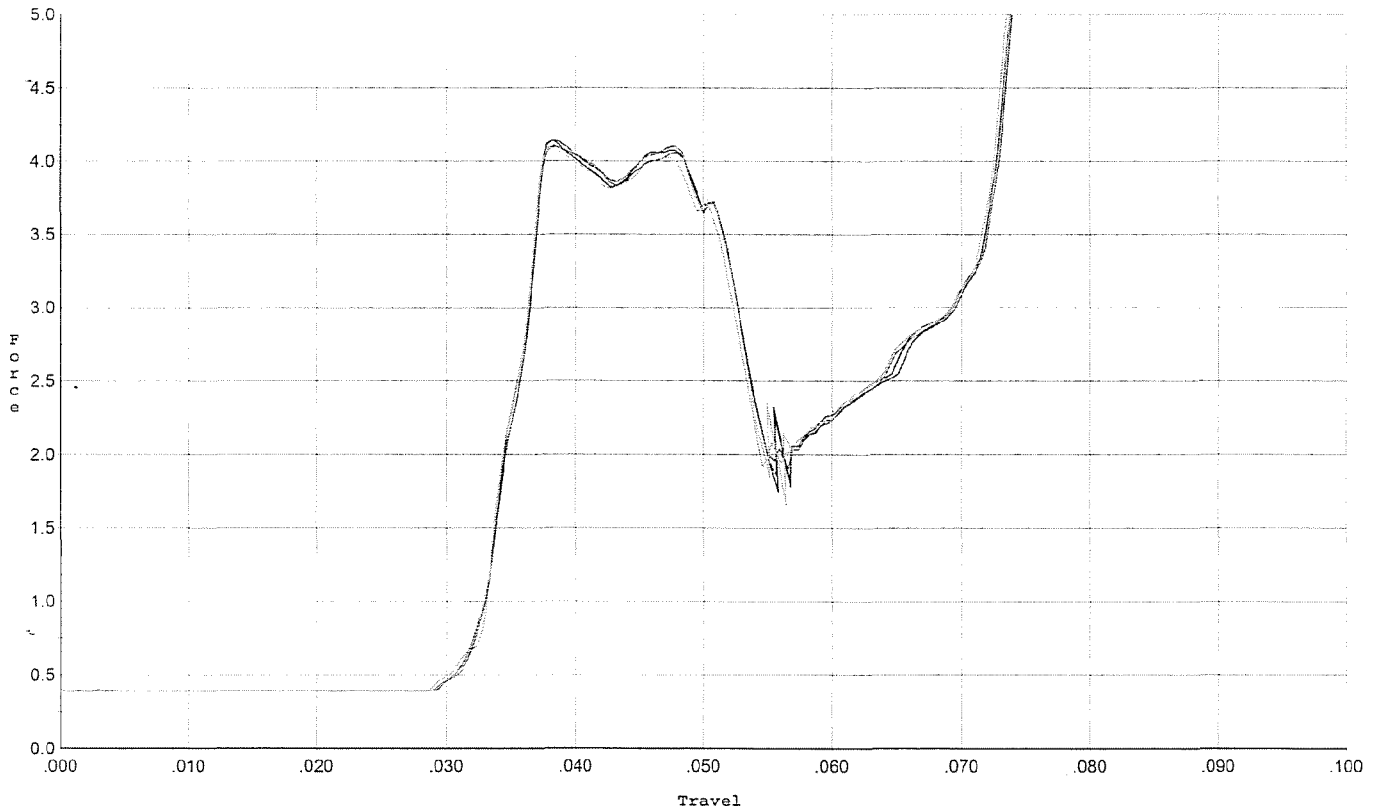
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.085	0.053	0.032	0.027	0.083		Set Trigger
2	4.124	0.053	0.032	0.027	0.084		Set Trigger
3	4.130	0.052	0.033	0.027	0.082		Set Trigger
4	4.074	0.052	0.032	0.027	0.082		Set Trigger
5	4.057	0.052	0.032	0.028	0.081		Set Trigger

Aug 4.09

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



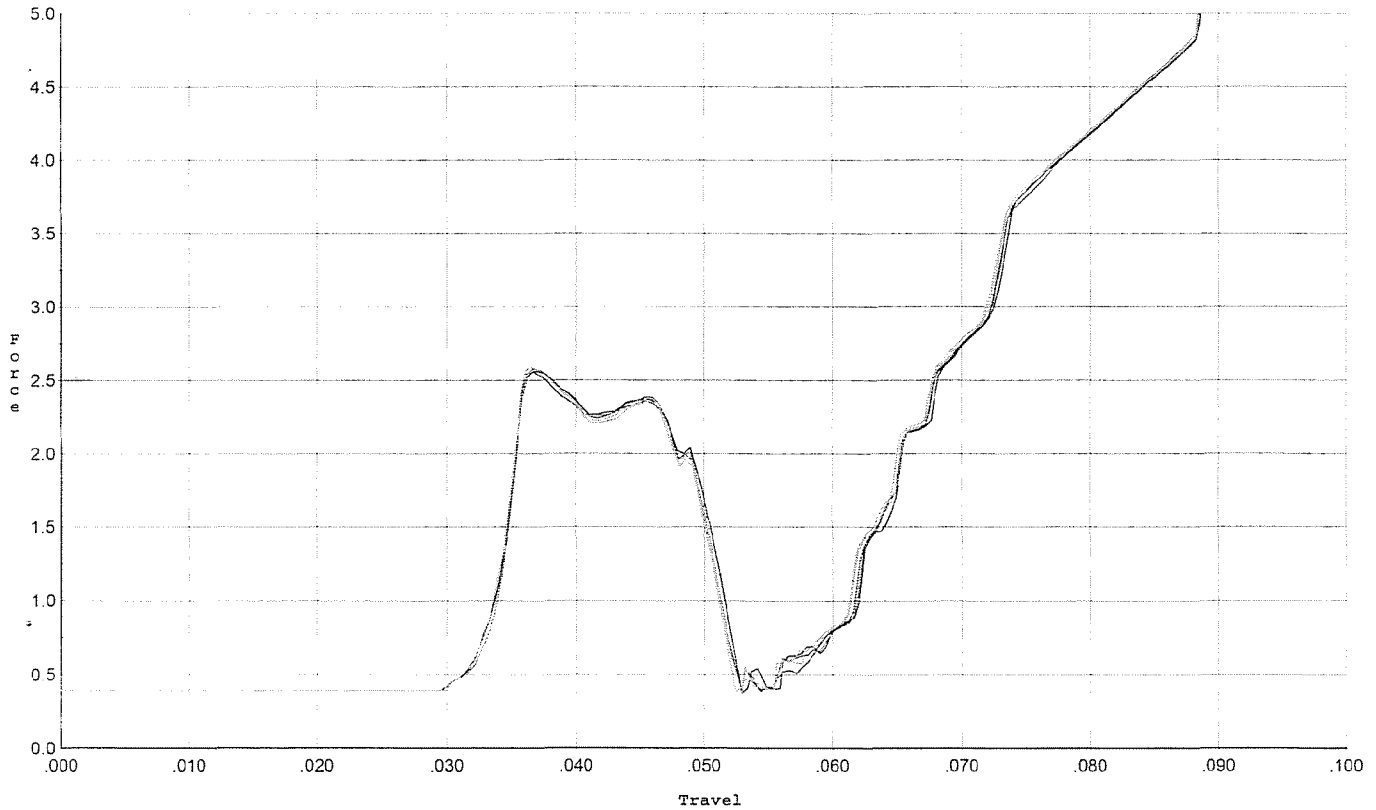
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.052	0.032	0.028	0.082		Set Trigger
2	4.142	0.052	0.032	0.027	0.082		Set Trigger
3	4.101	0.052	0.032	0.027	0.082		Set Trigger
4	4.110	0.052	0.032	0.027	0.083		Set Trigger
5	4.091	0.053	0.031	0.027	0.083		Set Trigger

Avg 4.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



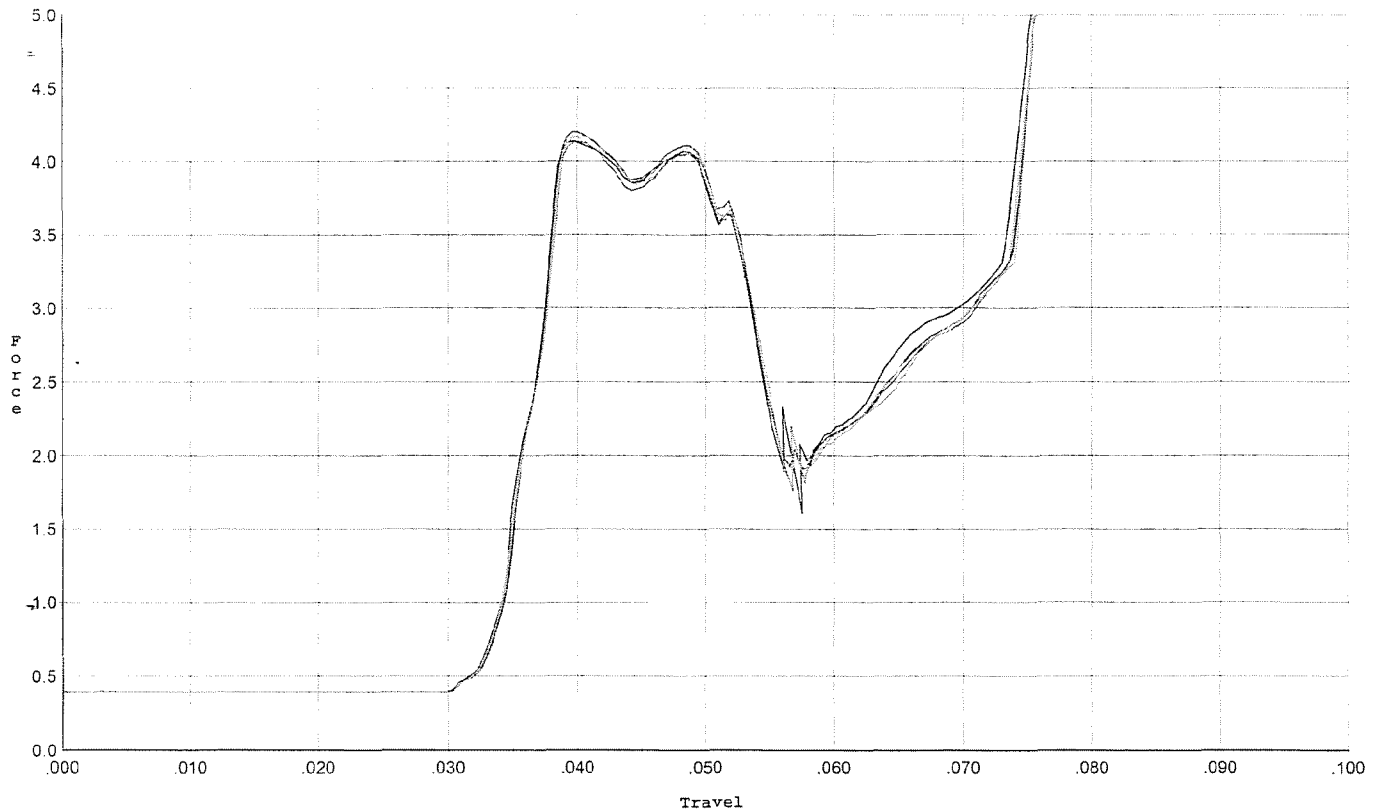
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.552	0.050	0.032	0.042	0.050		Set Trigger
2	2.555	0.051	0.032	0.042	0.051		Set Trigger
3	2.577	0.050	0.033	0.042	0.050		Set Trigger
4	2.591	0.050	0.032	0.042	0.050		Set Trigger
5	2.572	0.051	0.033	0.042	0.050		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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	4.202	0.053	0.033	0.028	0.083		Set Trigger
2	4.138	0.053	0.033	0.028	0.083		Set Trigger
3	4.132	0.053	0.033	0.028	0.082		Set Trigger
4	4.175	0.054	0.031	0.028	0.085		Set Trigger
5	4.174	0.054	0.033	0.028	0.085		Set Trigger

Avg 4.16