

G6794575

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



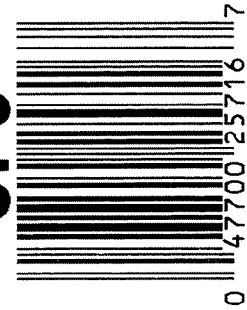
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794575

UPC



GUN SERIAL #

G 6794575

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 UL 2008 OPERATOR 124	10-1-08	RSu
475	DRILL AND TAP SIGHT HOLES		10-1-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	124
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		10-28-08	RSu
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

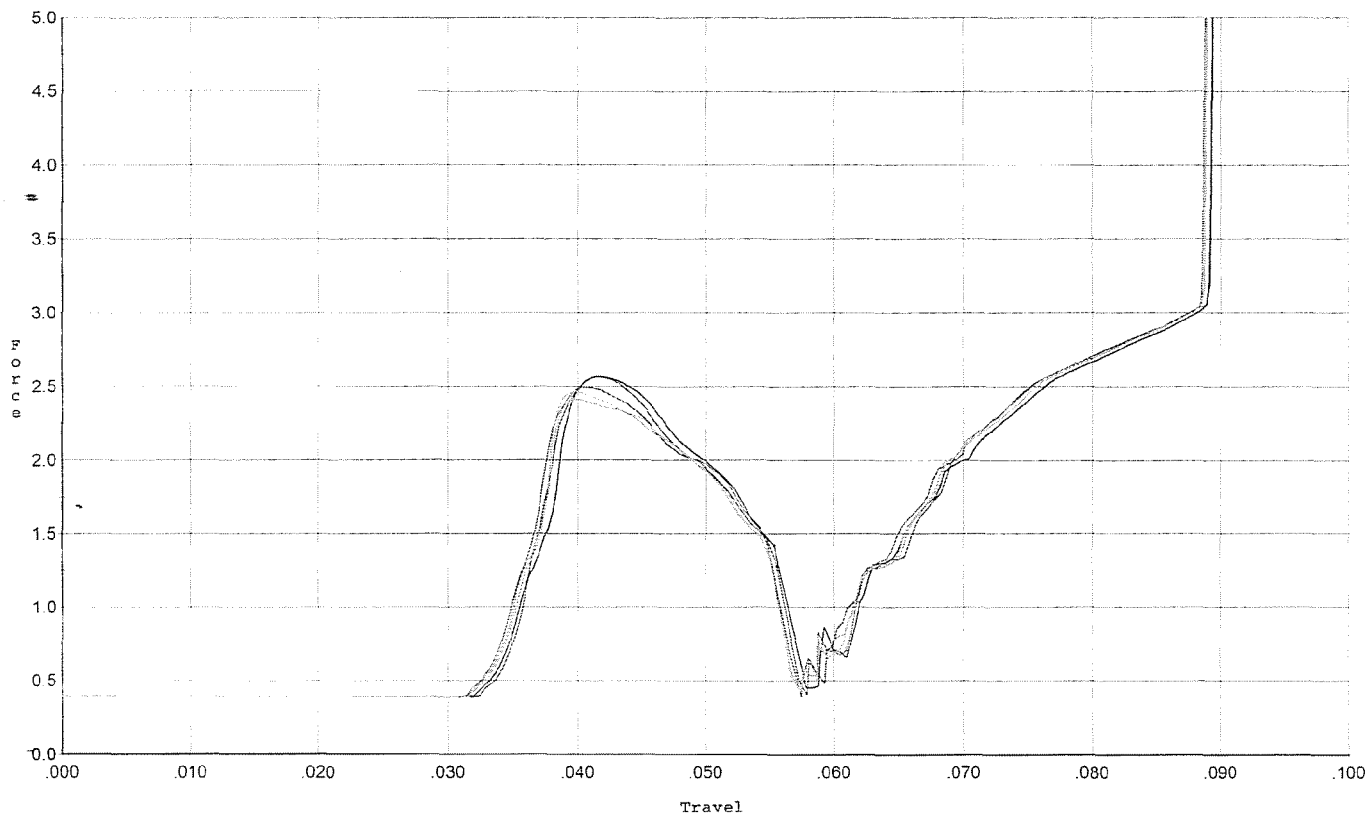
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.9</u> <u>4.5</u> <u>5.0</u>	11-4-08	R.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-4-08	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-4-08	R.N.
	J) ASSEMBLE STOCK		10-28-08	BSN
	K) ASSEMBLE SWIVEL STUDS		11-4-08	R.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	10-30-08	BSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-4-08	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.50</u> <u>2.47</u> <u>2.43</u> <u>2.61</u>	11-3-08	TC
	C) FUNCTION		11-4-08	R.N.
690	PACK		11/4/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



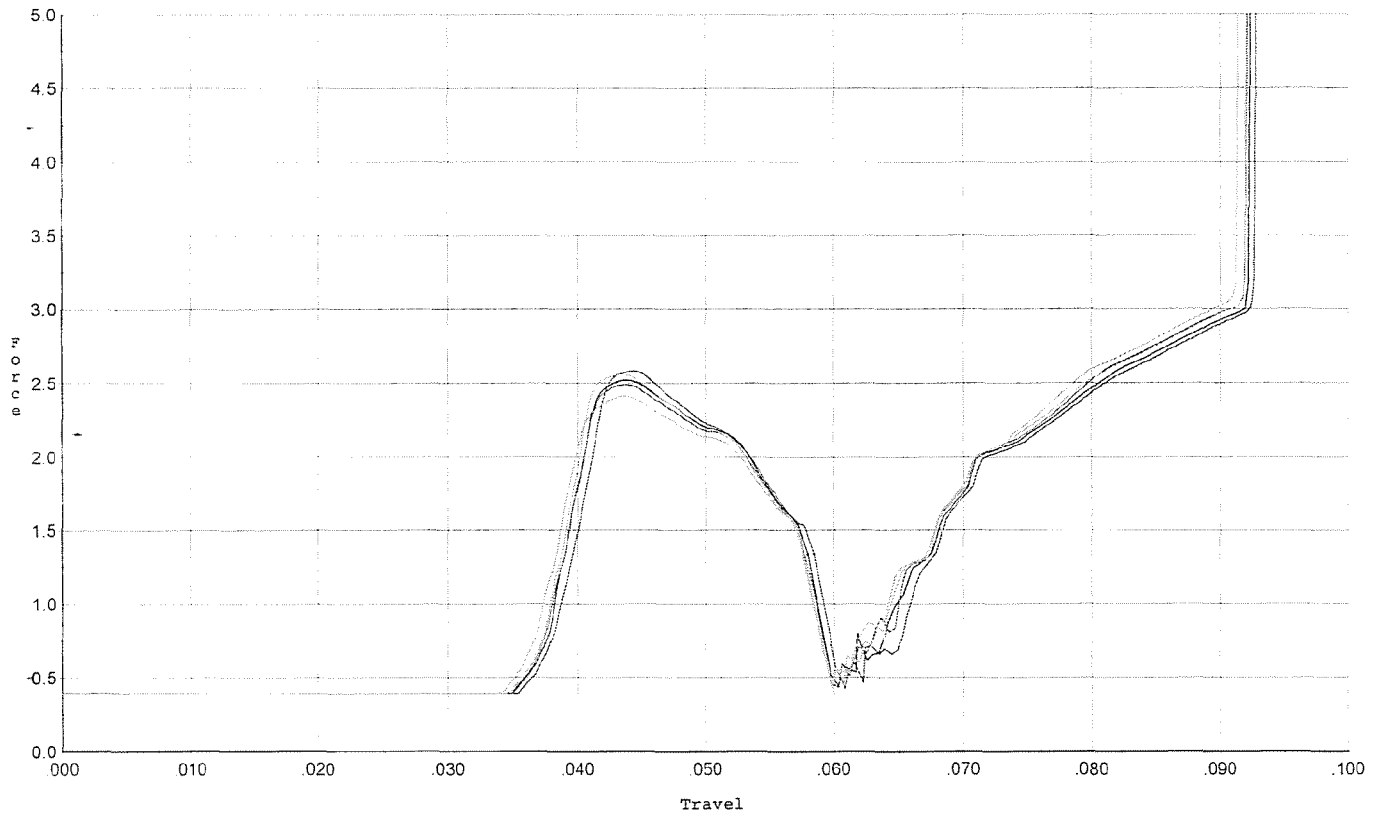
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.056	0.034	0.038	0.055		Set Trigger
2	2.566	0.055	0.034	0.039	0.055		Set Trigger
3	2.498	0.055	0.034	0.038	0.055		Set Trigger
4	2.466	0.055	0.034	0.038	0.054		Set Trigger
5	2.412	0.055	0.034	0.038	0.054		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



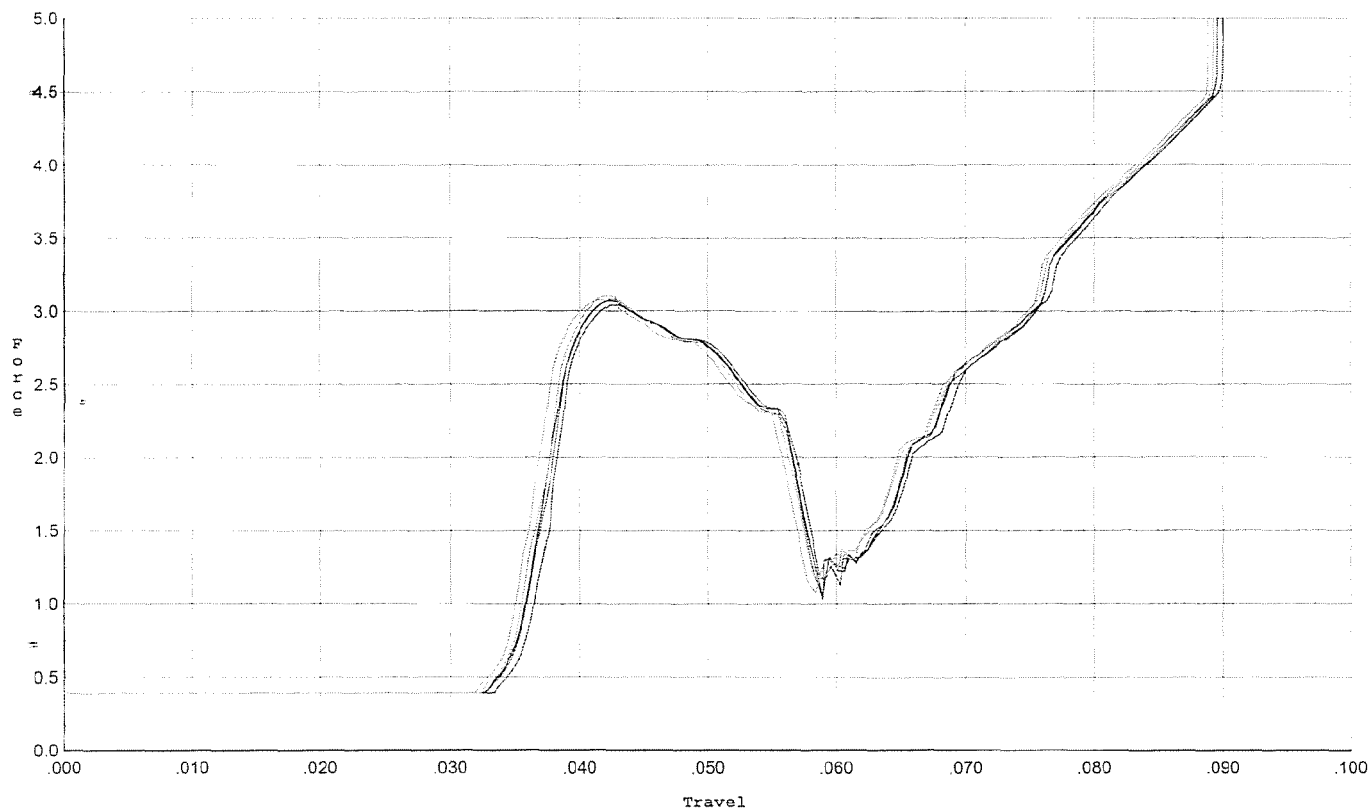
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.580	0.058	0.037	0.040	0.057		Set Trigger
2	2.520	0.058	0.037	0.040	0.057		Set Trigger
3	2.489	0.058	0.037	0.039	0.056		Set Trigger
4	2.557	0.057	0.037	0.039	0.056		Set Trigger
5	2.411	0.057	0.035	0.039	0.056		Set Trigger

AVG 2.51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



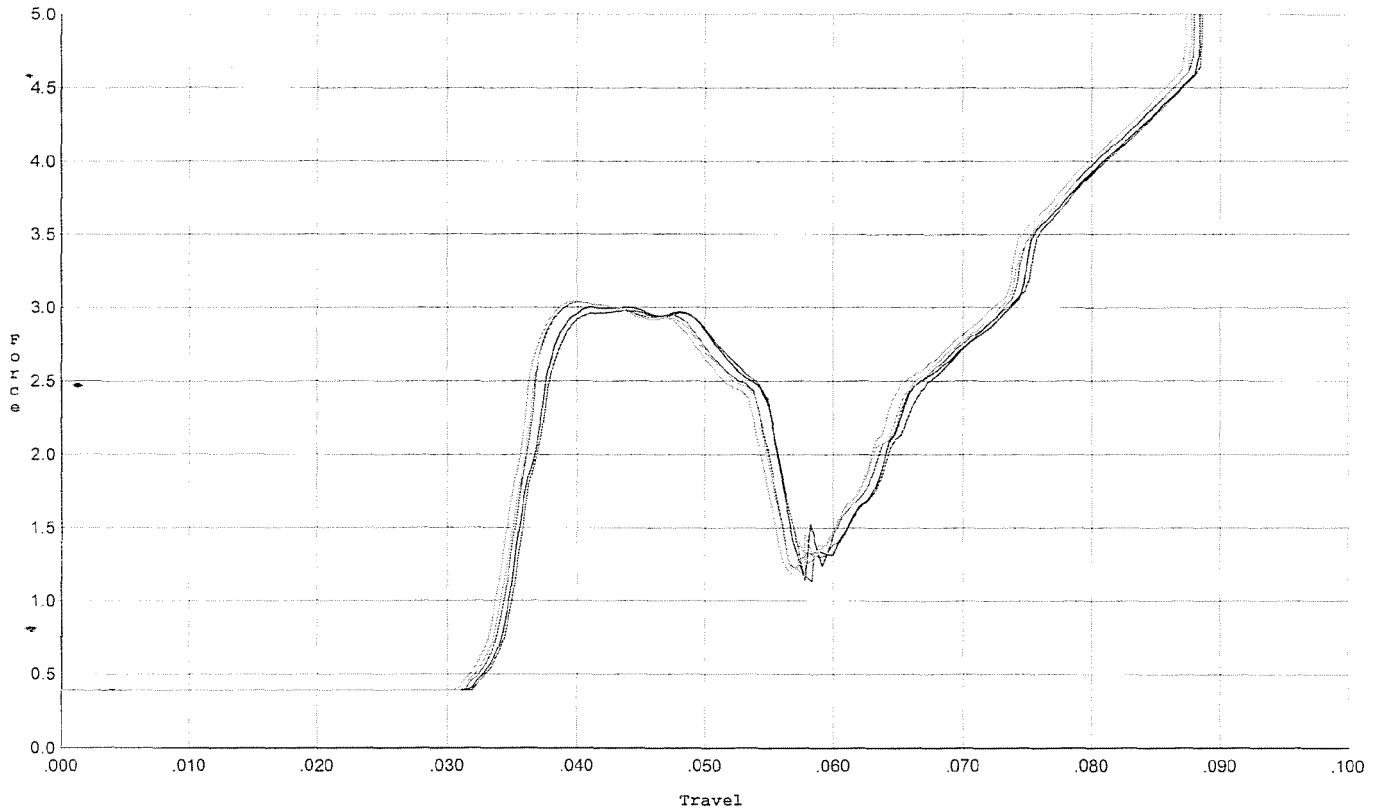
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.046	0.057	0.034	0.037	0.068		Set Trigger
2	3.069	0.056	0.033	0.037	0.068		Set Trigger
3	3.077	0.056	0.035	0.037	0.068		Set Trigger
4	3.108	0.057	0.033	0.037	0.069		Set Trigger
5	3.073	0.056	0.034	0.037	0.069		Set Trigger

Aug 3.07

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



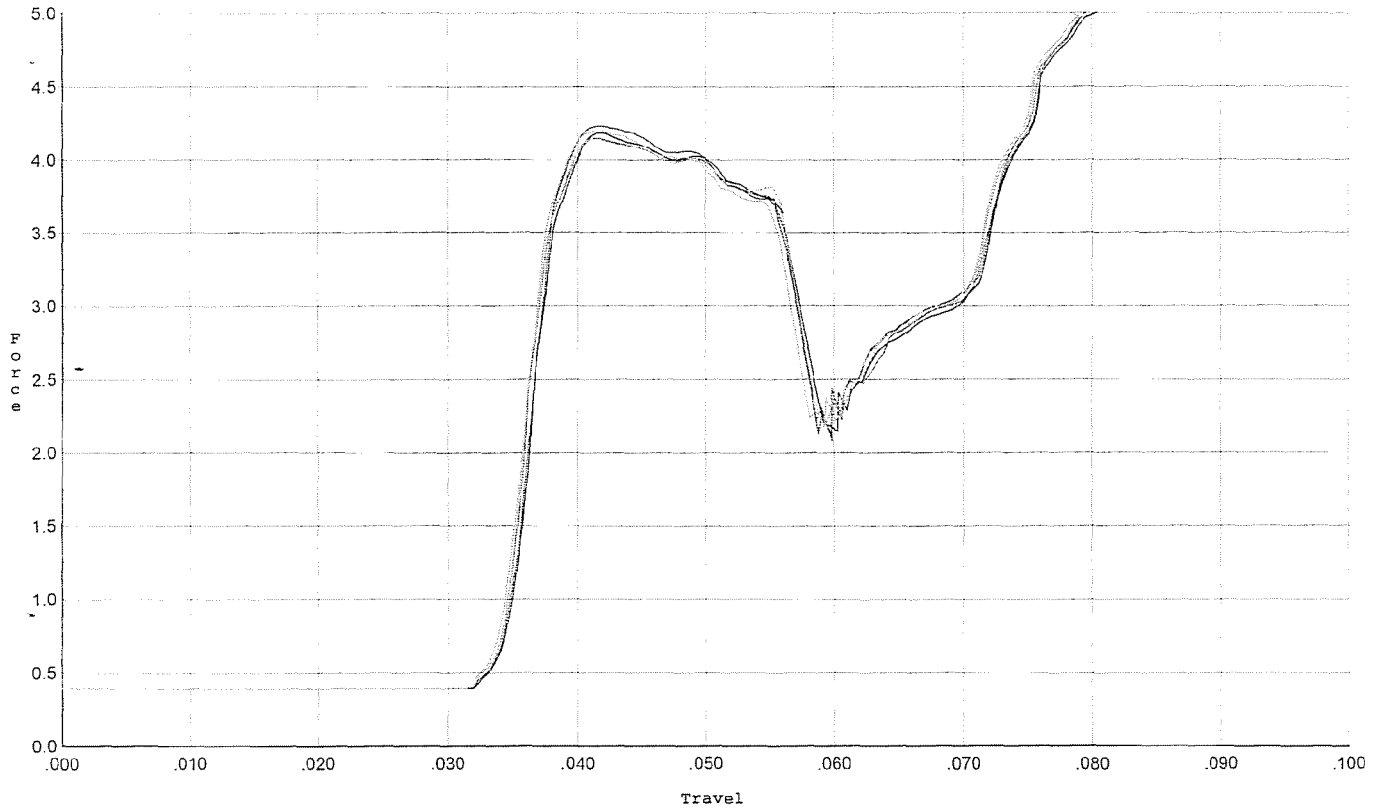
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.977	0.055	0.034	0.037	0.068		Set Trigger
2	3.002	0.055	0.033	0.037	0.069		Set Trigger
3	3.038	0.055	0.033	0.036	0.069		Set Trigger
4	3.031	0.055	0.033	0.036	0.070		Set Trigger
5	3.045	0.055	0.032	0.036	0.069		Set Trigger

Avg 3.01

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/23/08

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



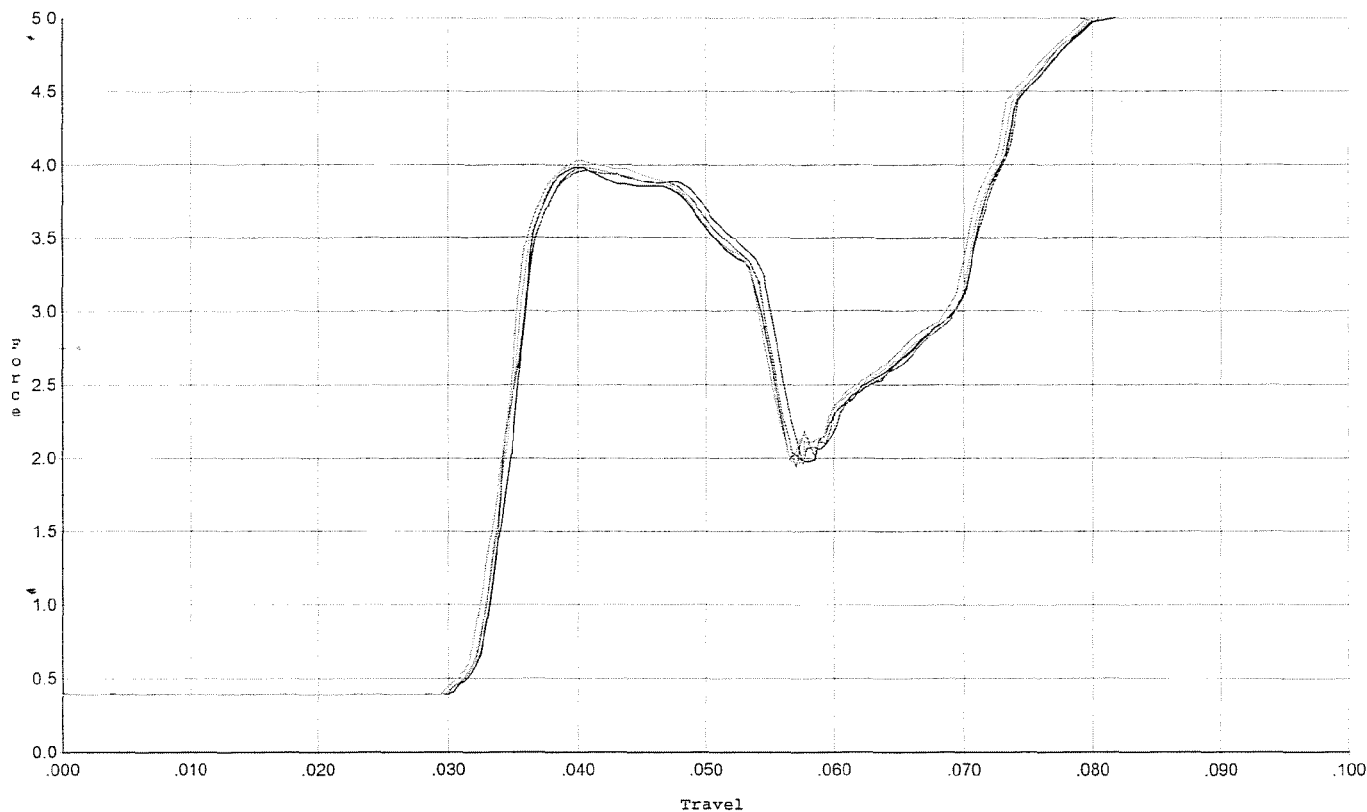
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.231	0.056	0.034	0.035	0.096		Set Trigger
2	4.187	0.056	0.034	0.035	0.094		Set Trigger
3	4.147	0.056	0.032	0.035	0.095		Set Trigger
4	4.195	0.056	0.033	0.035	0.094		Set Trigger
5	4.150	0.056	0.032	0.035	0.095		Set Trigger

Avg 4.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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



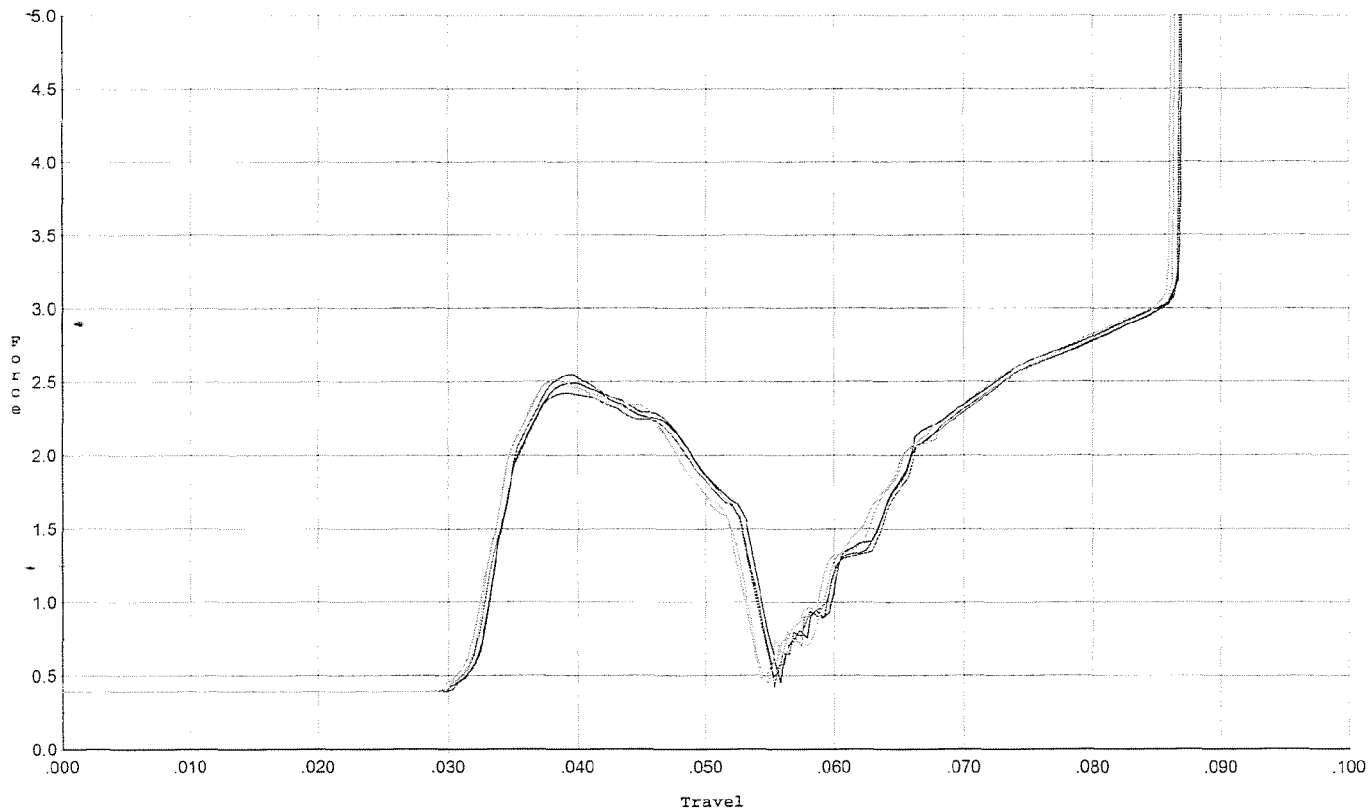
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.981	0.055	0.032	0.034	0.090		Set Trigger
2	3.983	0.055	0.032	0.035	0.088		Set Trigger
3	3.959	0.054	0.032	0.035	0.088		Set Trigger
4	4.029	0.054	0.032	0.035	0.087		Set Trigger
5	3.988	0.054	0.032	0.034	0.088		Set Trigger

Avg 3.98

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/23/08

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



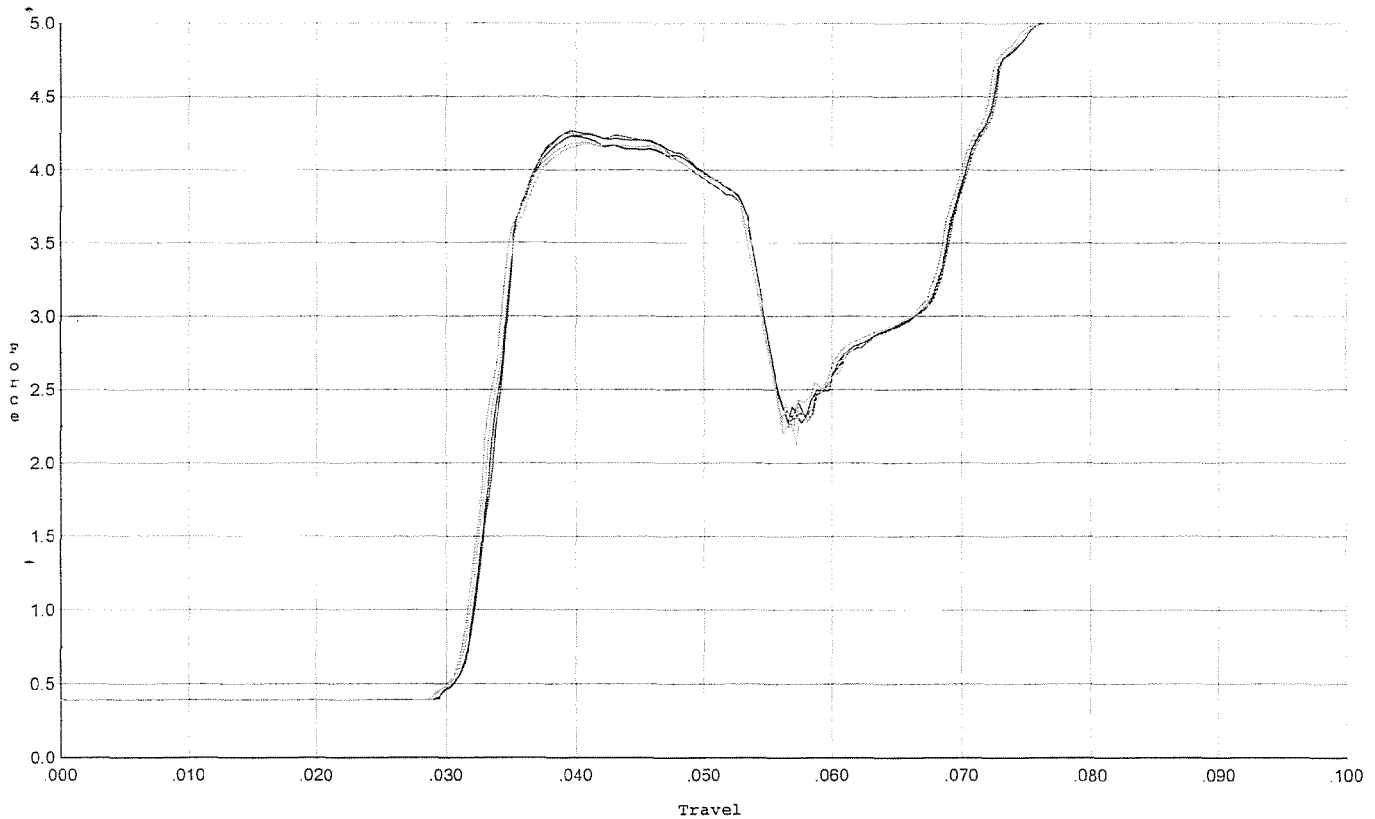
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.549	0.054	0.032	0.037	0.056		Set Trigger
2	2.492	0.053	0.032	0.037	0.056		Set Trigger
3	2.420	0.053	0.032	0.038	0.054		Set Trigger
4	2.506	0.052	0.032	0.038	0.055		Set Trigger
5	2.519	0.053	0.032	0.037	0.055		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/23/08

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	4.265	0.053	0.031	0.034	0.095		Set Trigger
2	4.232	0.053	0.031	0.033	0.095		Set Trigger
3	4.250	0.054	0.031	0.034	0.096		Set Trigger
4	4.175	0.054	0.031	0.033	0.096		Set Trigger
5	4.191	0.054	0.031	0.033	0.098		Set Trigger

Avg 4.22