

G6794587

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



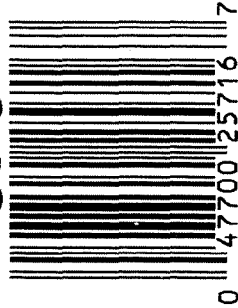
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794587

UPC



GUN SERIAL #

G6794587

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE		10-28-08	BSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/29/08	KB
490	MAGNAFLUX BOLT		10/27/08	MR
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC		10/30/08	DG
542	APPLY COATINGS (BARREL ACTION)		11-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-4-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-4-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-4-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

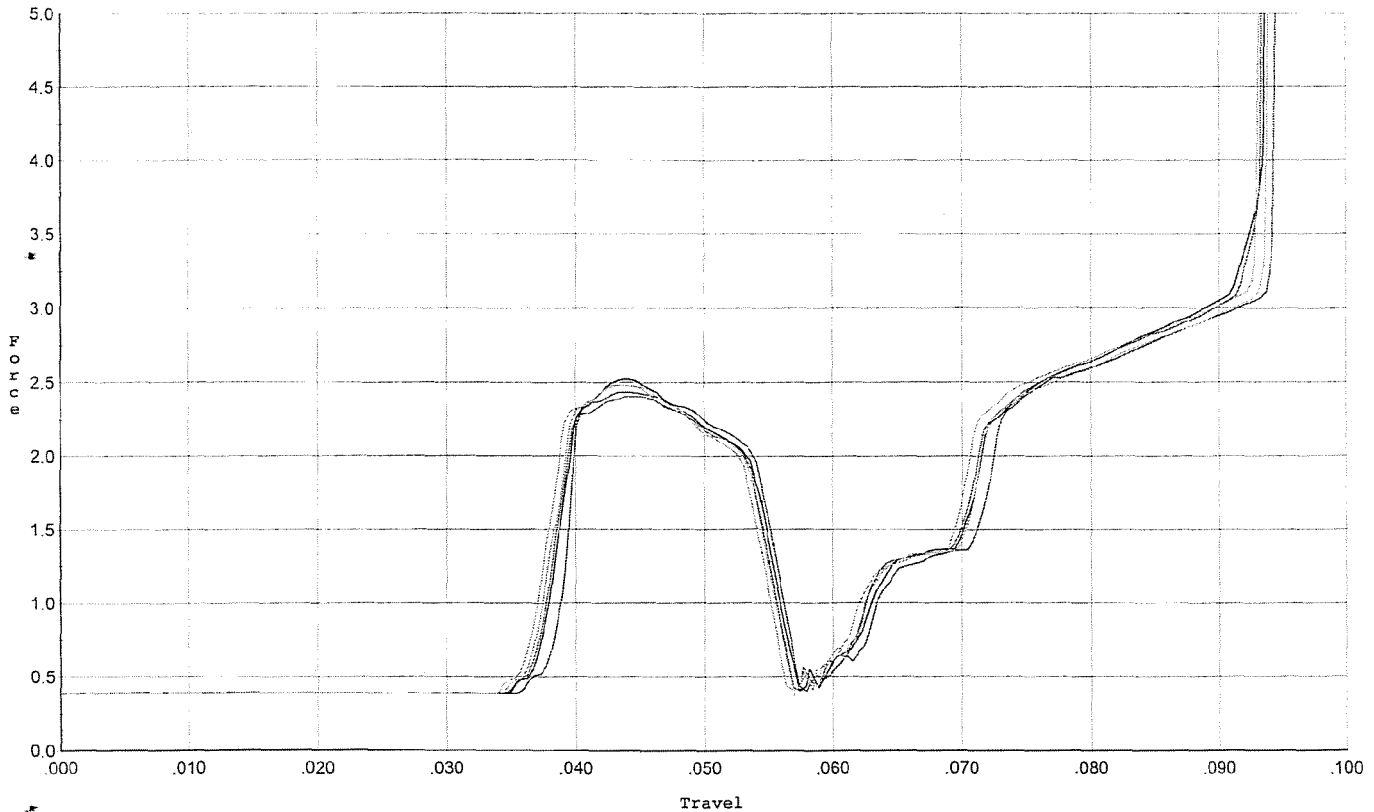
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	11-20-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-20-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	11-20-08	LJ
	J) ASSEMBLE STOCK		11-10-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		11-20-08	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	11-11-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-11-08	J
670	FINAL INSPECTION A) HEADSPACE		11-20-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.64</u> <u>2.54</u> <u>2.59</u> <u>2.64</u>	11-11-08	TC
	C) FUNCTION		11-20-08	LJ
690	PACK		12/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



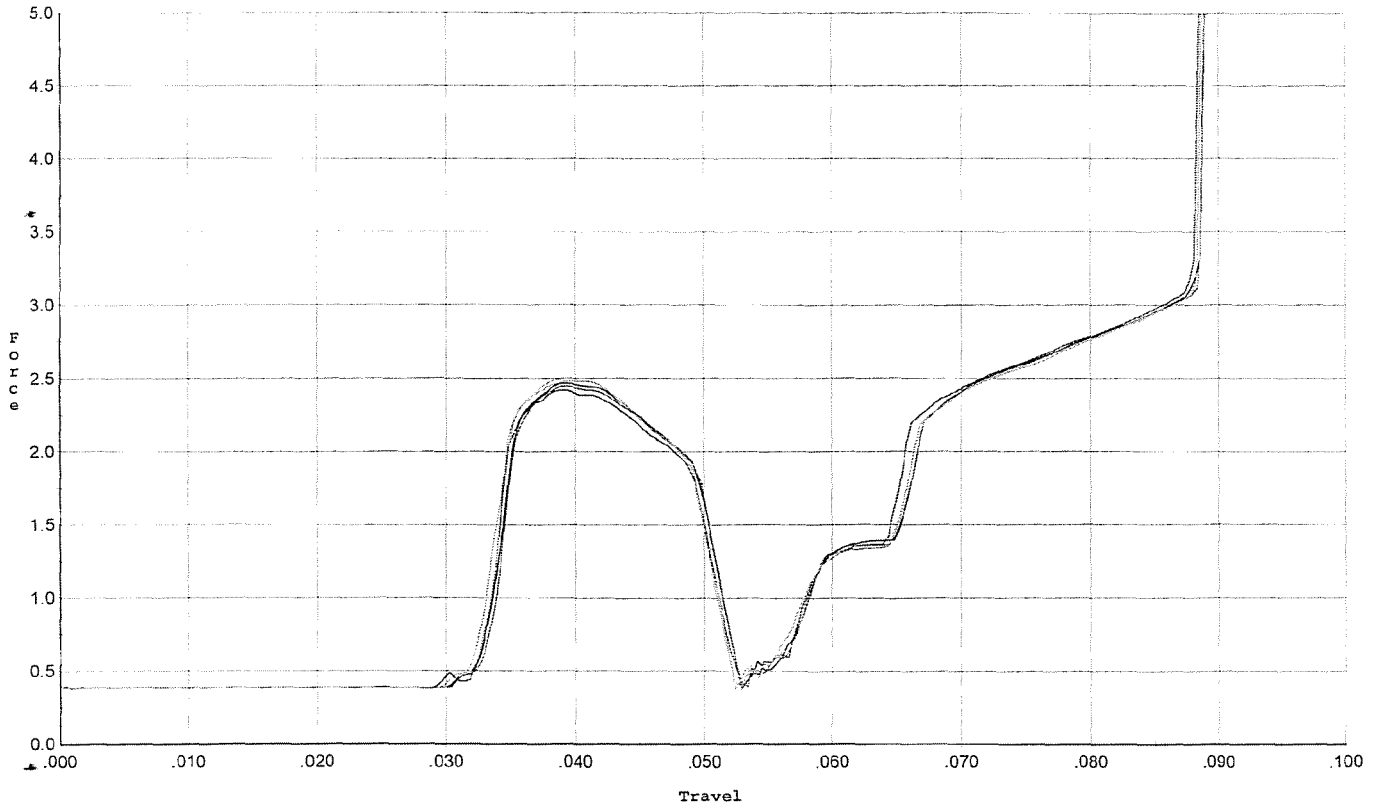
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.432	0.055	0.036	0.043	0.052		Set Trigger
2	2.522	0.054	0.035	0.042	0.052		Set Trigger
3	2.404	0.055	0.037	0.042	0.052		Set Trigger
4	2.481	0.054	0.035	0.043	0.051		Set Trigger
5	2.485	0.054	0.034	0.043	0.052		Set Trigger

Aug 2-46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



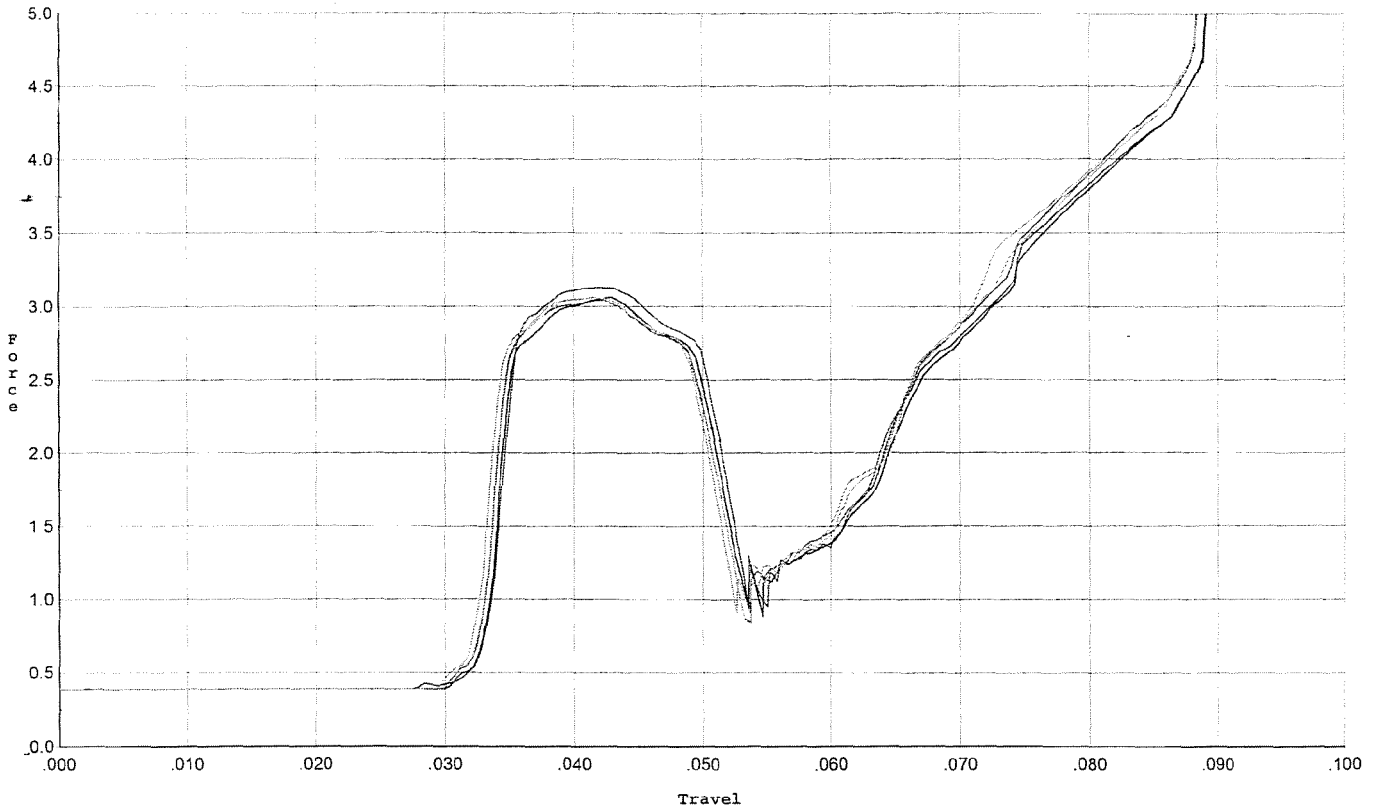
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.419	0.051	0.032	0.042	0.050		Set Trigger
2	2.469	0.050	0.033	0.042	0.049		Set Trigger
3	2.450	0.050	0.033	0.042	0.049		Set Trigger
4	2.494	0.050	0.032	0.042	0.050		Set Trigger
5	2.488	0.049	0.032	0.043	0.049		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/10/08

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



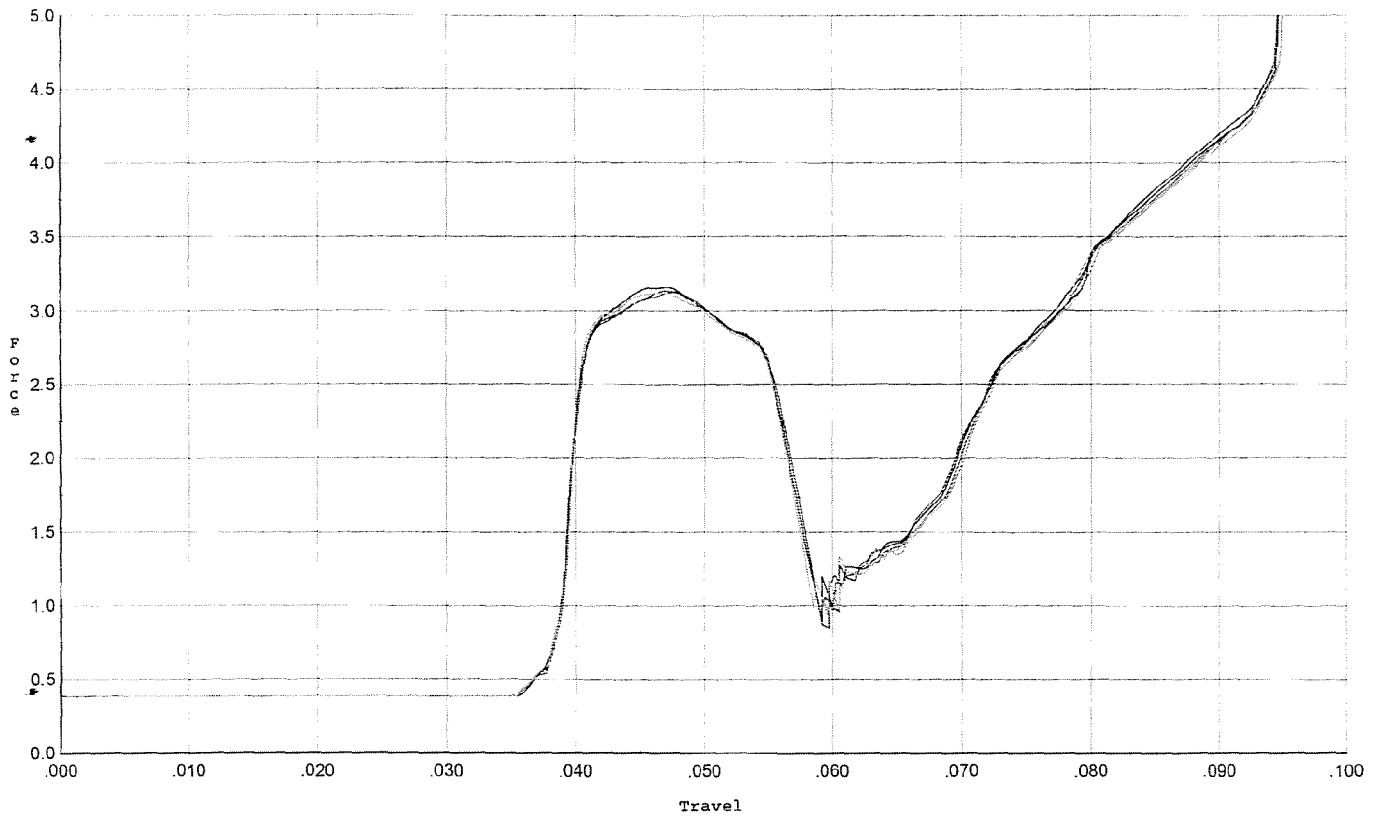
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.129	0.051	0.033	0.040	0.064		Set Trigger
2	3.061	0.051	0.033	0.040	0.061		Set Trigger
3	3.043	0.051	0.032	0.039	0.063		Set Trigger
4	3.061	0.051	0.032	0.039	0.063		Set Trigger
5	3.061	0.051	0.032	0.040	0.062		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



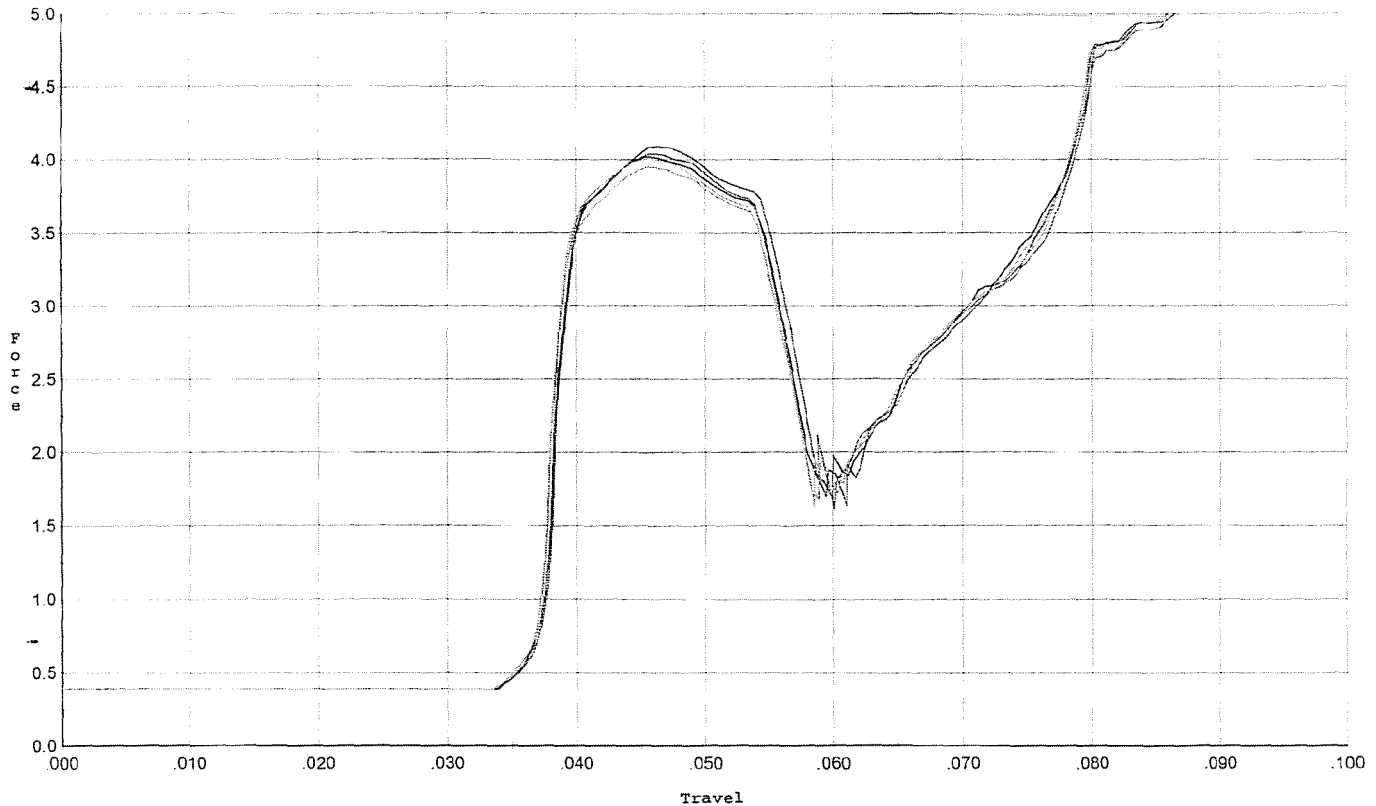
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.129	0.057	0.038	0.041	0.067		Set Trigger
2	3.158	0.056	0.038	0.041	0.065		Set Trigger
3	3.121	0.056	0.038	0.041	0.065		Set Trigger
4	3.118	0.056	0.038	0.041	0.065		Set Trigger
5	3.118	0.056	0.038	0.041	0.065		Set Trigger

Avg 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putrch 11/10/08

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



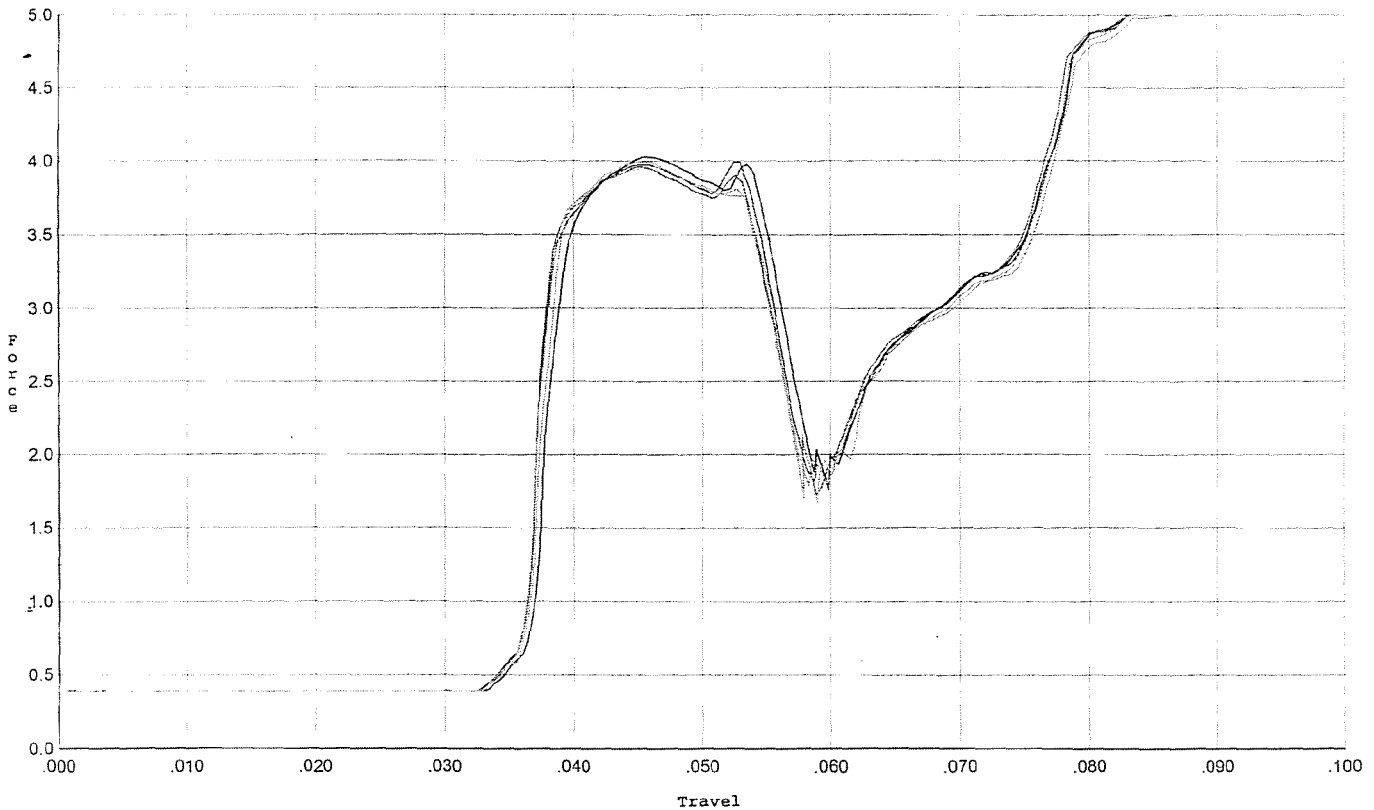
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.090	0.057	0.037	0.039	0.085		Set Trigger
2	4.018	0.056	0.036	0.039	0.083		Set Trigger
3	4.037	0.056	0.036	0.039	0.084		Set Trigger
4	4.003	0.057	0.036	0.039	0.084		Set Trigger
5	3.949	0.056	0.037	0.039	0.083		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putrch 11/10/08

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



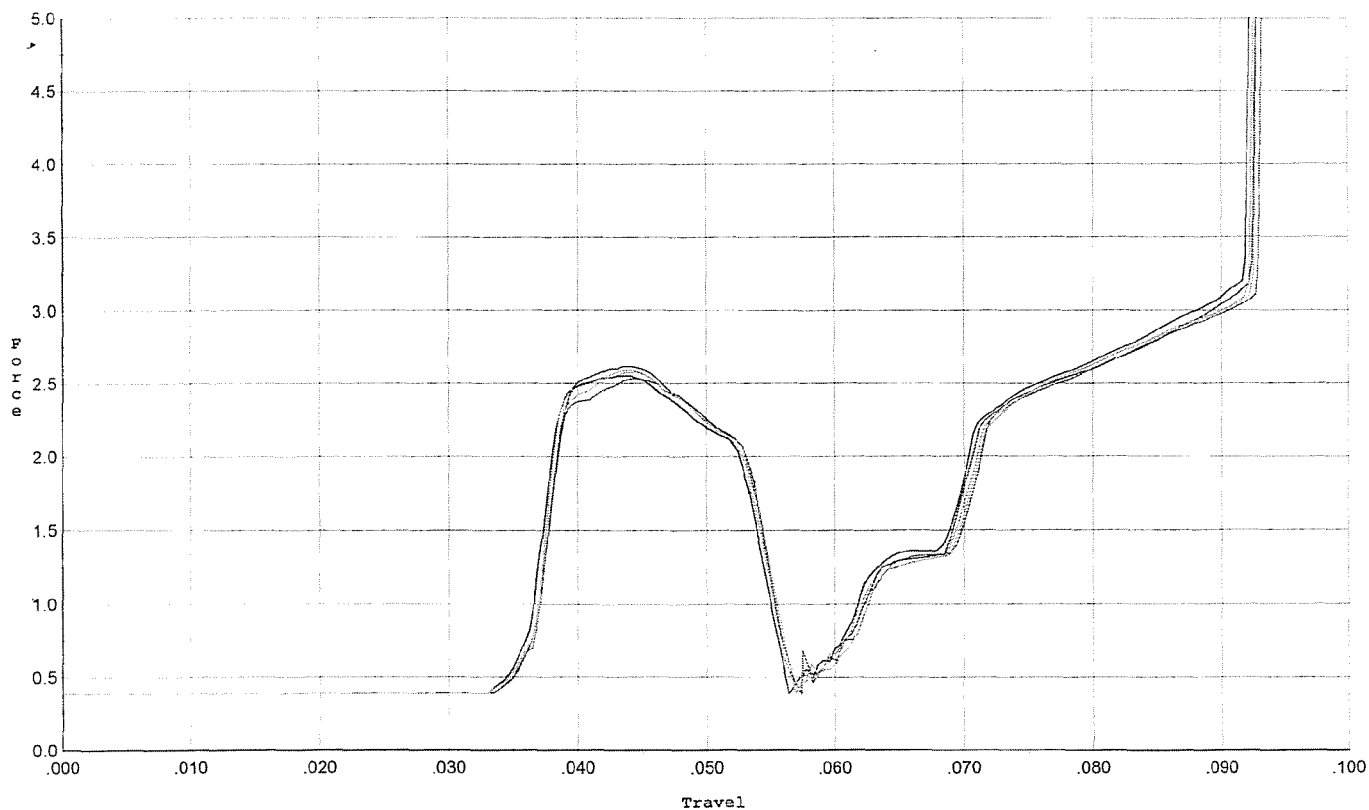
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.991	0.055	0.036	0.038	0.084		Set Trigger
2	4.029	0.055	0.036	0.038	0.084		Set Trigger
3	3.960	0.056	0.036	0.038	0.085		Set Trigger
4	3.964	0.056	0.036	0.038	0.085		Set Trigger
5	3.994	0.055	0.036	0.038	0.083		Set Trigger

Aug 3.98

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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



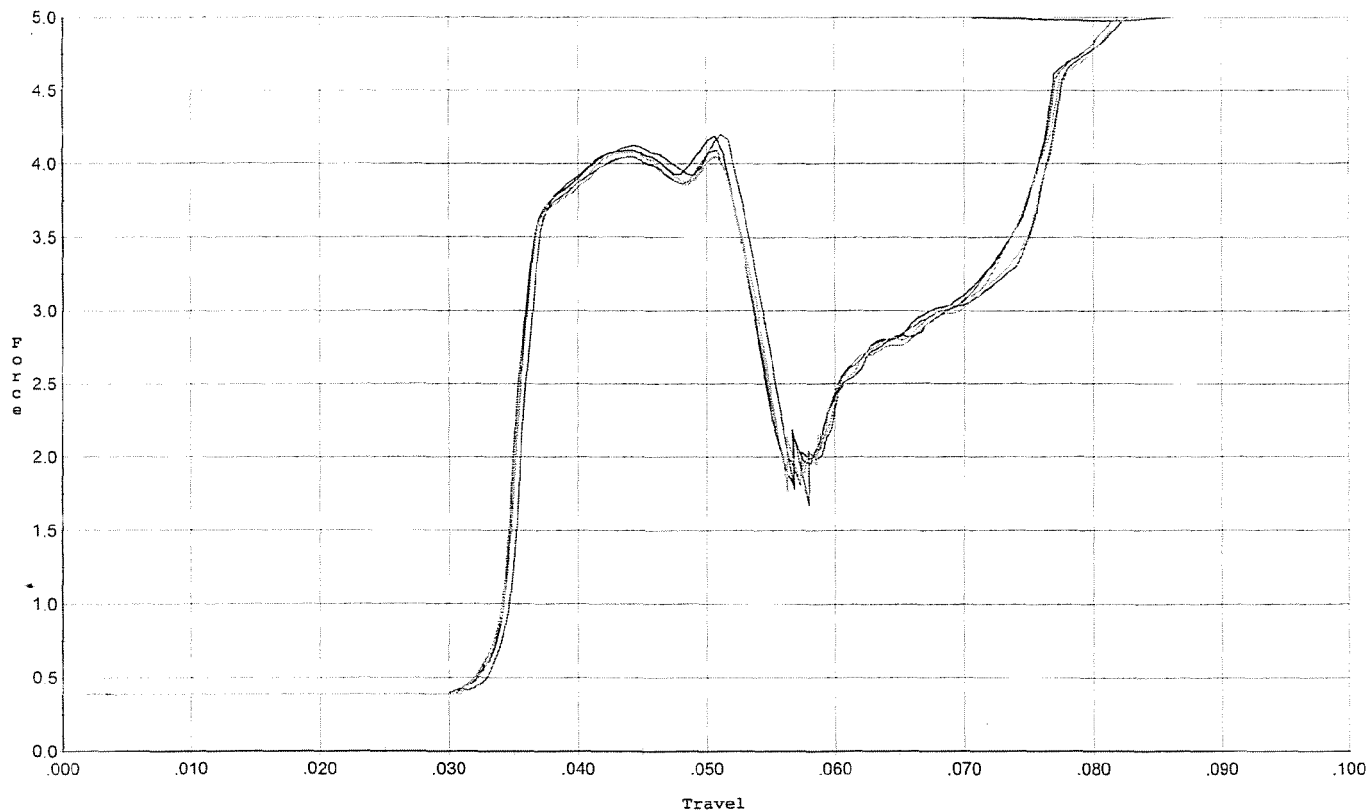
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.617	0.054	0.036	0.042	0.054		Set Trigger
2	2.553	0.053	0.035	0.042	0.053		Set Trigger
3	2.536	0.054	0.036	0.043	0.053		Set Trigger
4	2.579	0.054	0.036	0.042	0.054		Set Trigger
5	2.591	0.054	0.036	0.042	0.055		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putrch 11/10/08

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	4.203	0.055	0.033	0.037	0.088		Set Trigger
2	4.191	0.053	0.033	0.037	0.085		Set Trigger
3	4.092	0.053	0.033	0.037	0.084		Set Trigger
4	4.076	0.054	0.033	0.037	0.087		Set Trigger
5	4.050	0.054	0.033	0.037	0.087		Set Trigger

Avg 4.12