

66794599

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



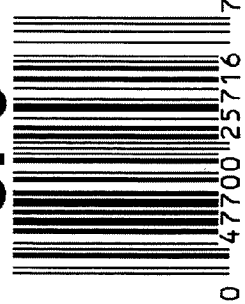
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794599

UPC



GUN SERIAL #

G 6794599

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE		9-30-08	RSN
475	DRILL AND TAP SIGHT HOLES		10/1/08	FM
480	MAGNAFLUX BBL ACTION		10/2/08	RSN
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/2/08	DG
542	APPLY COATINGS (BARREL ACTION)		10 3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-14-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

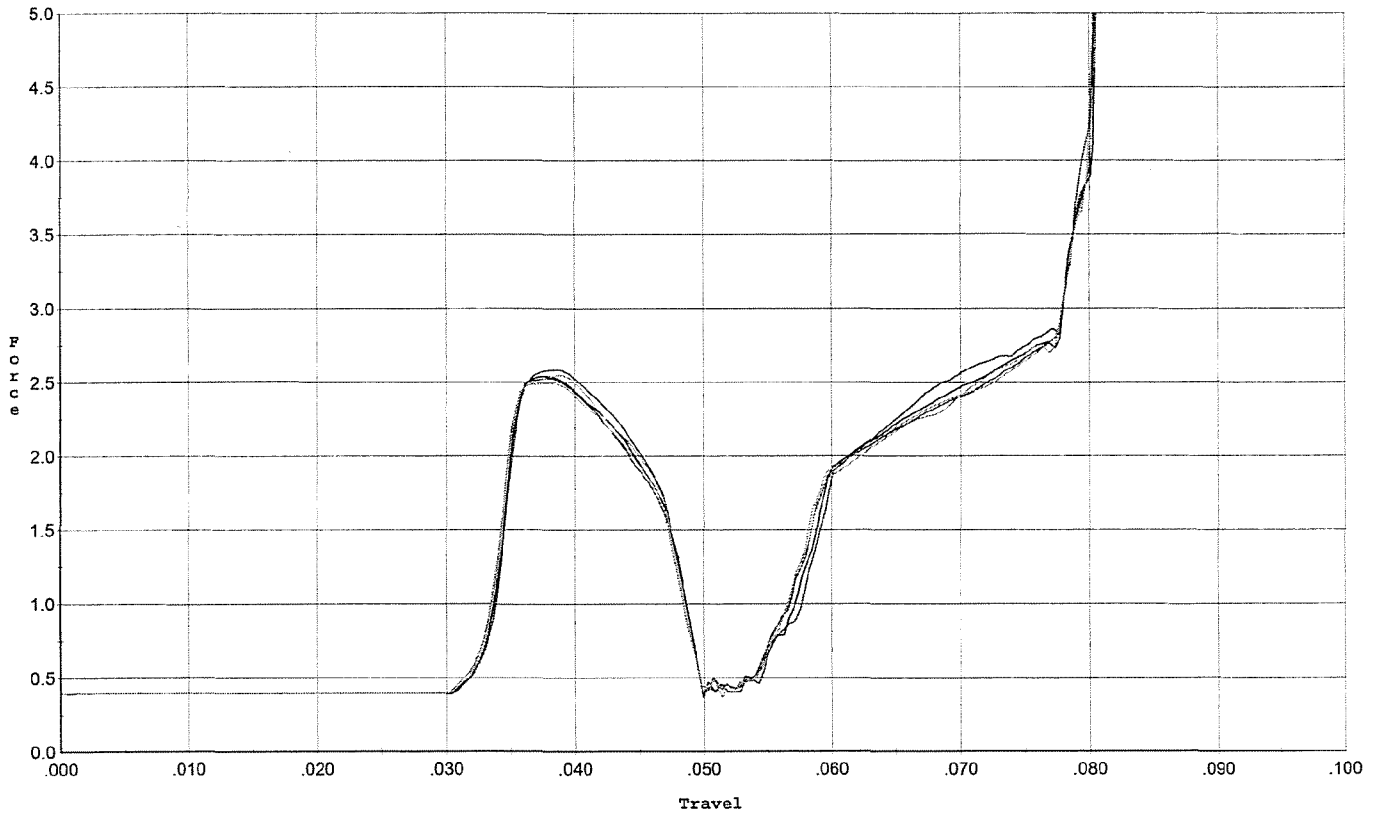
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>6.0</u>	10-28-08	L. N
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	10-28-08	L. N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-28-08	L. N
	J) ASSEMBLE STOCK		10-14-08	PSN
	K) ASSEMBLE SWIVEL STUDS		10-28-08	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	10-27-08 10-28-08	PSN PSN
	MALFUNCTION <u>BAC</u>	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-28-08	L. N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.19</u> <u>2.21</u> <u>2.14</u> <u>2.13</u> <u>2.12</u>	10-27-08	TC
	C) FUNCTION		10-28-08	L. N
690	PACK		11/3/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



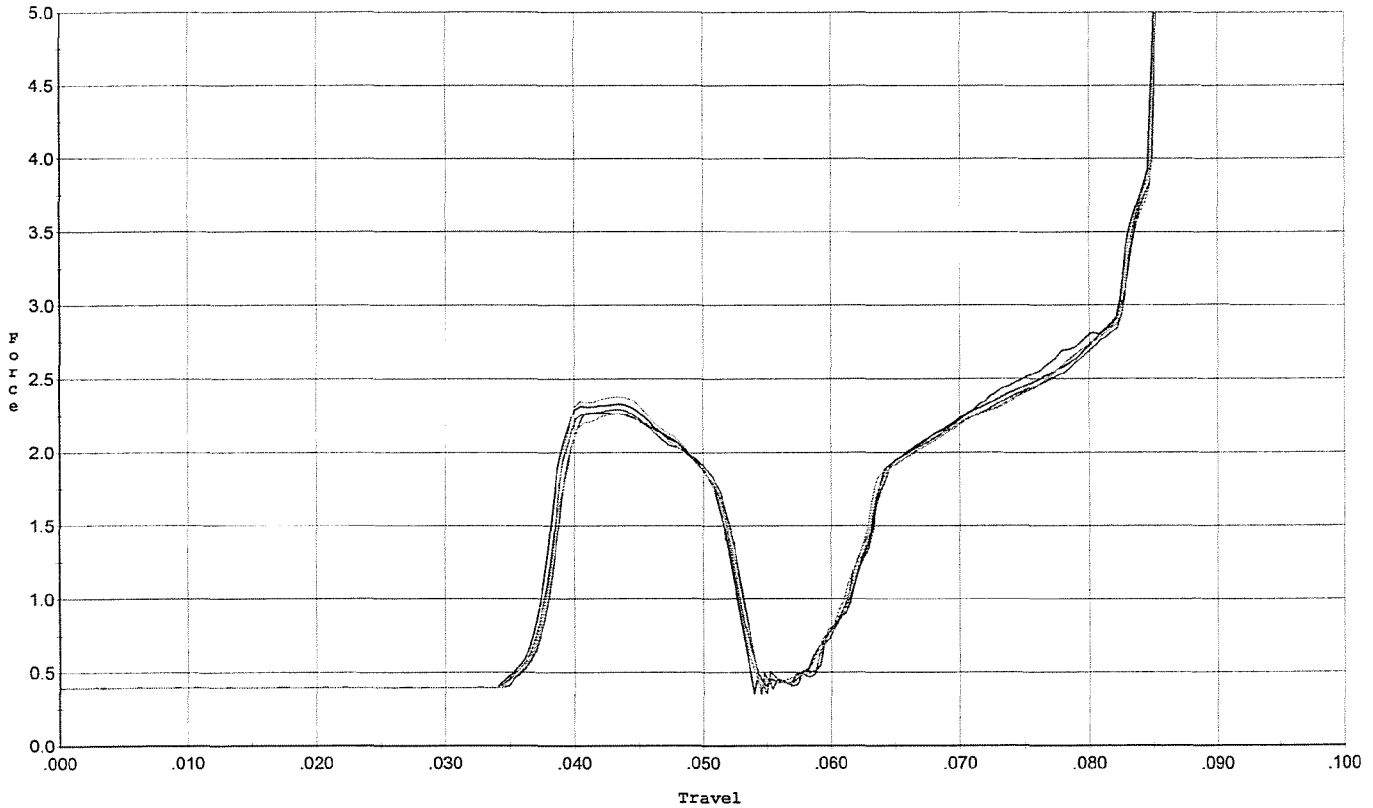
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.586	0.048	0.033	0.036	0.045		Set Trigger
2	2.541	0.048	0.032	0.036	0.044		Set Trigger
3	2.525	0.047	0.032	0.037	0.043		Set Trigger
4	2.495	0.047	0.032	0.037	0.043		Set Trigger
5	2.545	0.048	0.033	0.036	0.045		Set Trigger

Aug 253

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/13/08

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



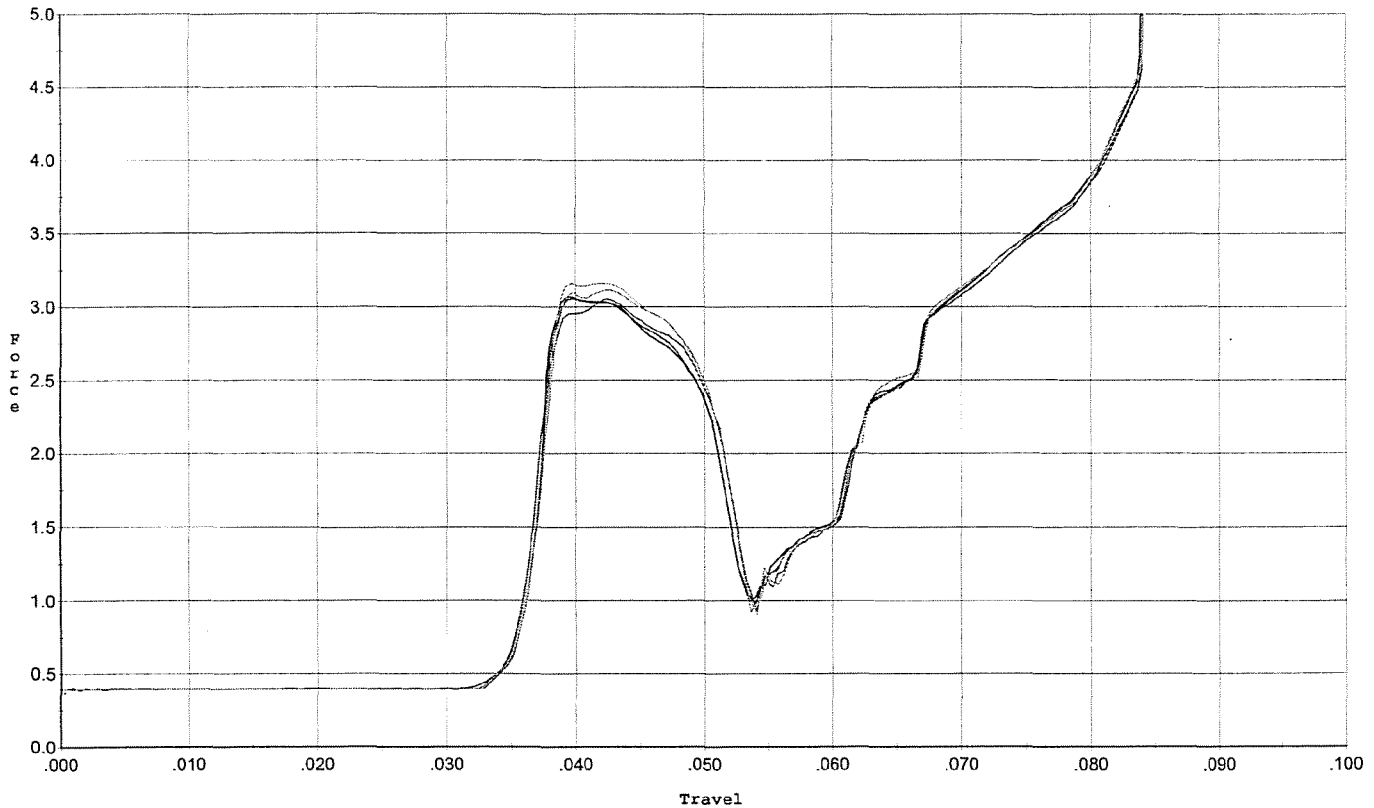
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.270	0.052	0.037	0.039	0.045		Set Trigger
2	2.330	0.052	0.036	0.038	0.045		Set Trigger
3	2.293	0.052	0.037	0.038	0.044		Set Trigger
4	2.379	0.052	0.037	0.038	0.045		Set Trigger
5	2.261	0.053	0.037	0.038	0.045		Set Trigger

Aug 2.30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



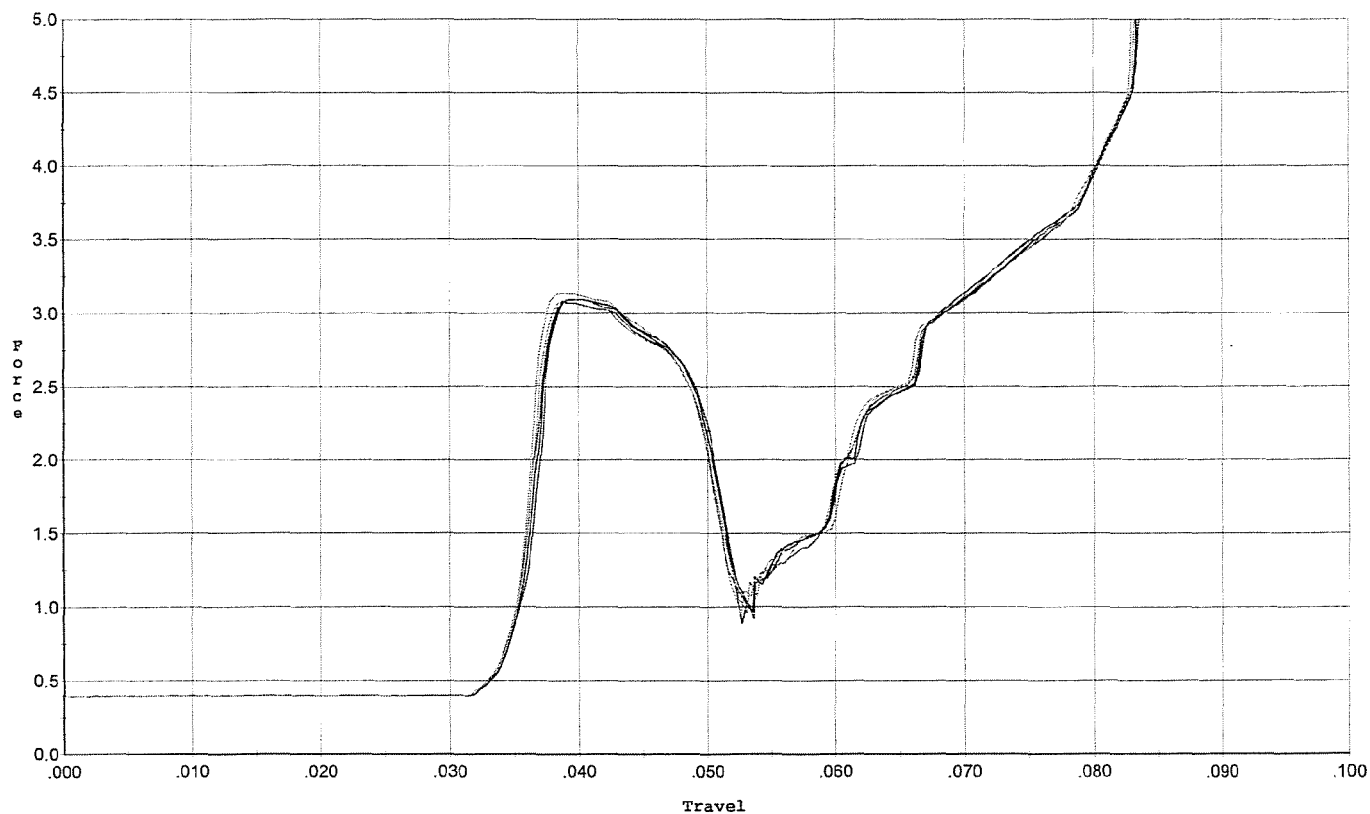
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.056	0.051	0.035	0.037	0.055		Set Trigger
2	3.071	0.051	0.035	0.037	0.055		Set Trigger
3	3.054	0.051	0.035	0.037	0.056		Set Trigger
4	3.111	0.051	0.035	0.037	0.057		Set Trigger
5	3.160	0.051	0.035	0.037	0.057		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



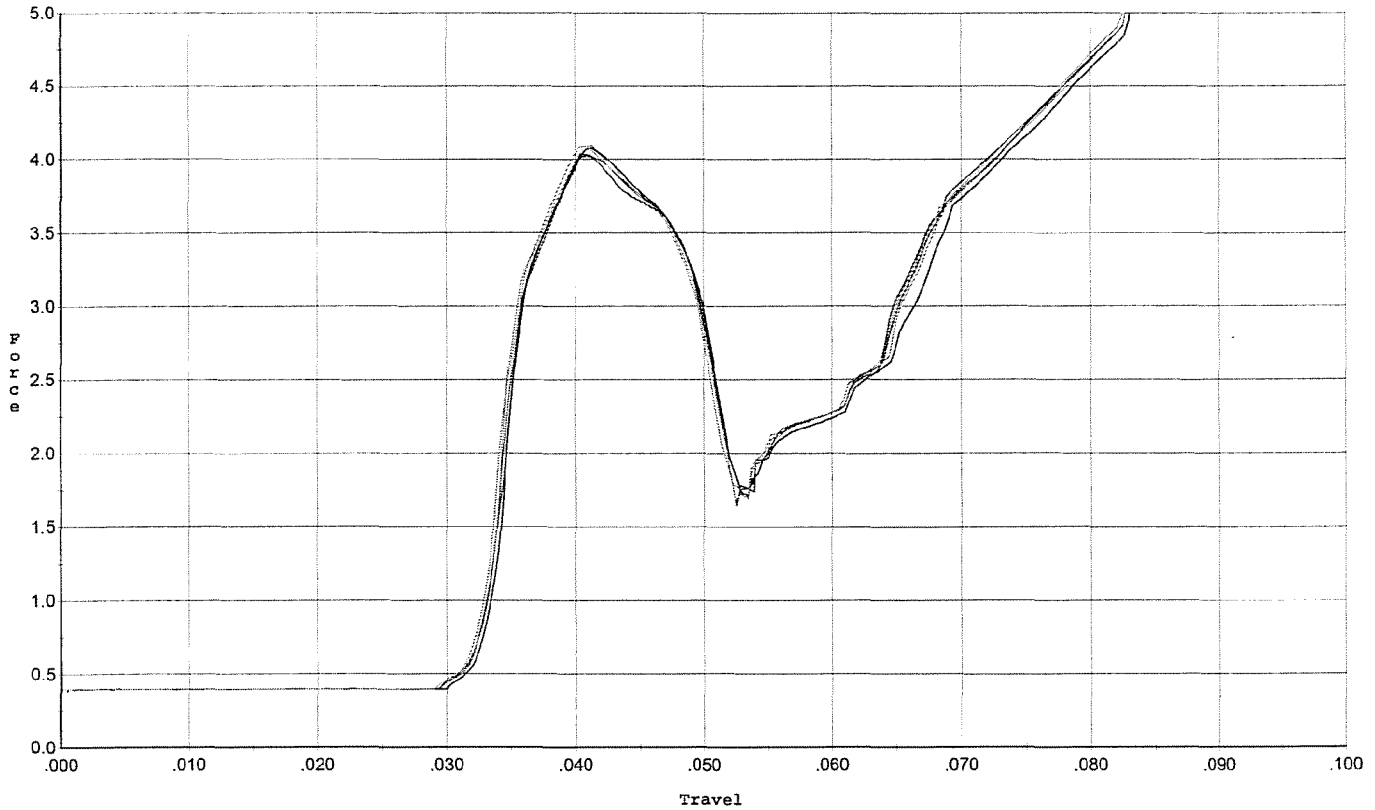
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.092	0.050	0.034	0.037	0.055		Set Trigger
2	3.091	0.051	0.034	0.037	0.056		Set Trigger
3	3.075	0.050	0.034	0.037	0.054		Set Trigger
4	3.134	0.050	0.034	0.036	0.055		Set Trigger
5	3.090	0.049	0.034	0.037	0.054		Set Trigger

Aug 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



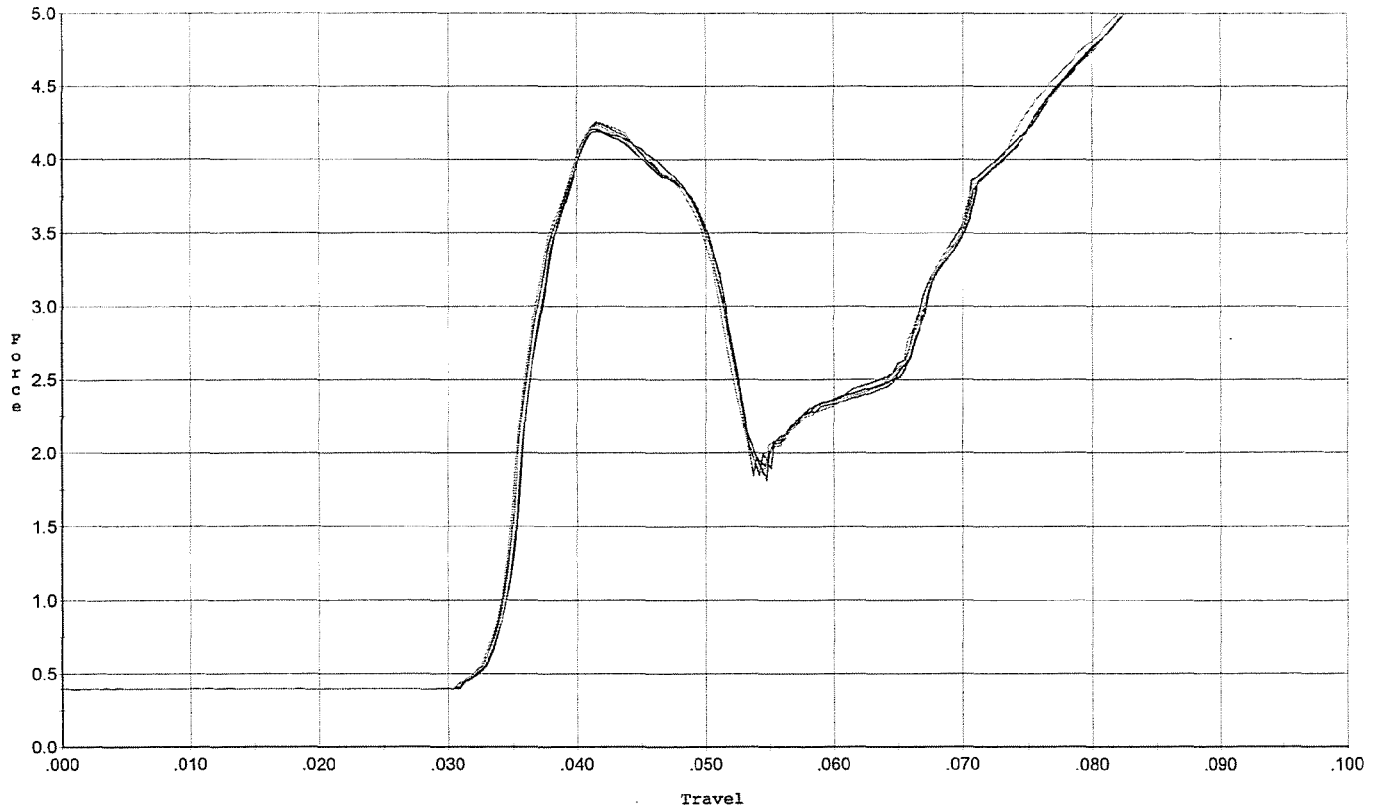
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.032	0.050	0.032	0.035	0.072		Set Trigger
2	4.074	0.050	0.032	0.035	0.072		Set Trigger
3	4.025	0.050	0.032	0.035	0.072		Set Trigger
4	4.091	0.049	0.032	0.034	0.071		Set Trigger
5	4.093	0.051	0.032	0.034	0.073		Set Trigger

Aug 4.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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



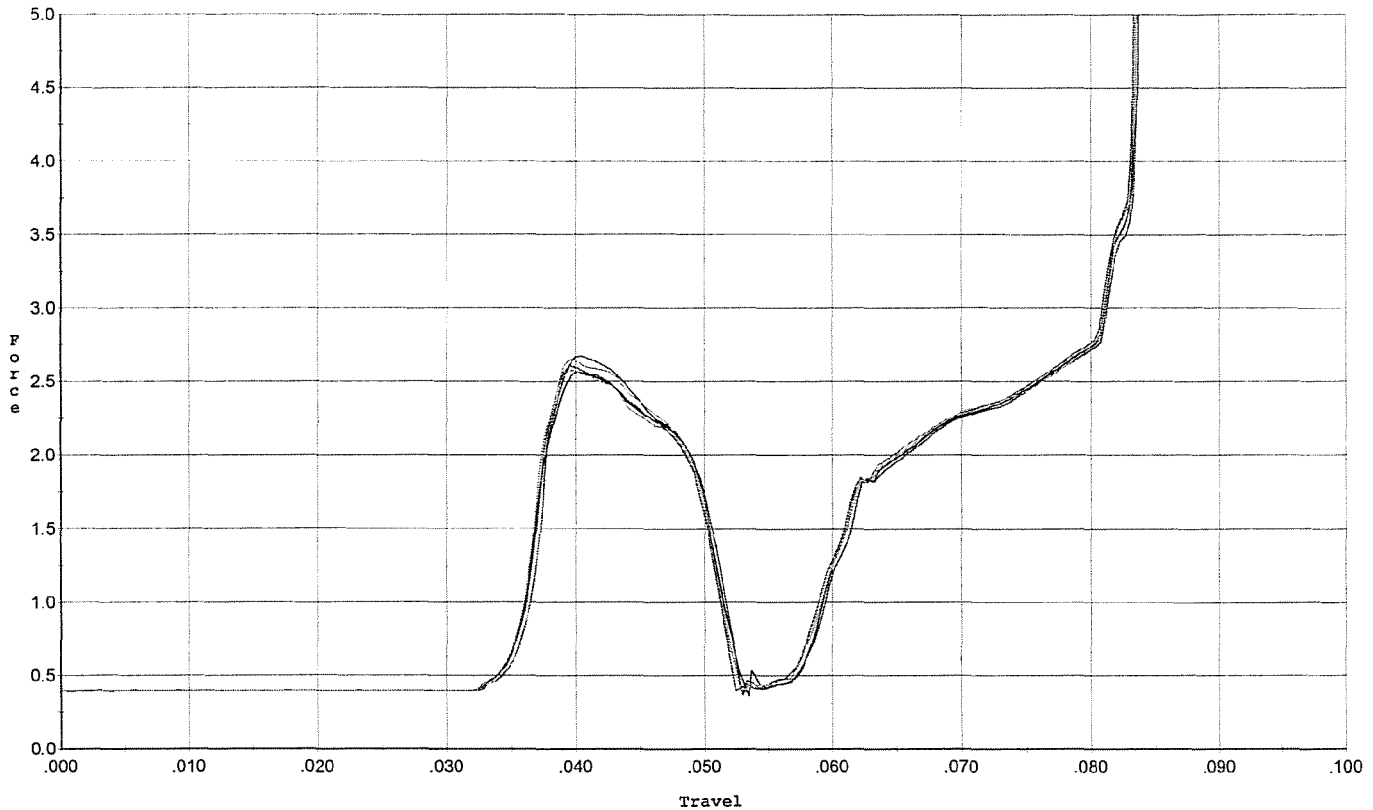
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.203	0.052	0.033	0.035	0.077		Set Trigger
2	4.192	0.051	0.033	0.035	0.075		Set Trigger
3	4.243	0.051	0.033	0.035	0.075		Set Trigger
4	4.230	0.051	0.033	0.035	0.075		Set Trigger
5	4.254	0.051	0.033	0.035	0.076		Set Trigger

Avg 4.22

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/13/08

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



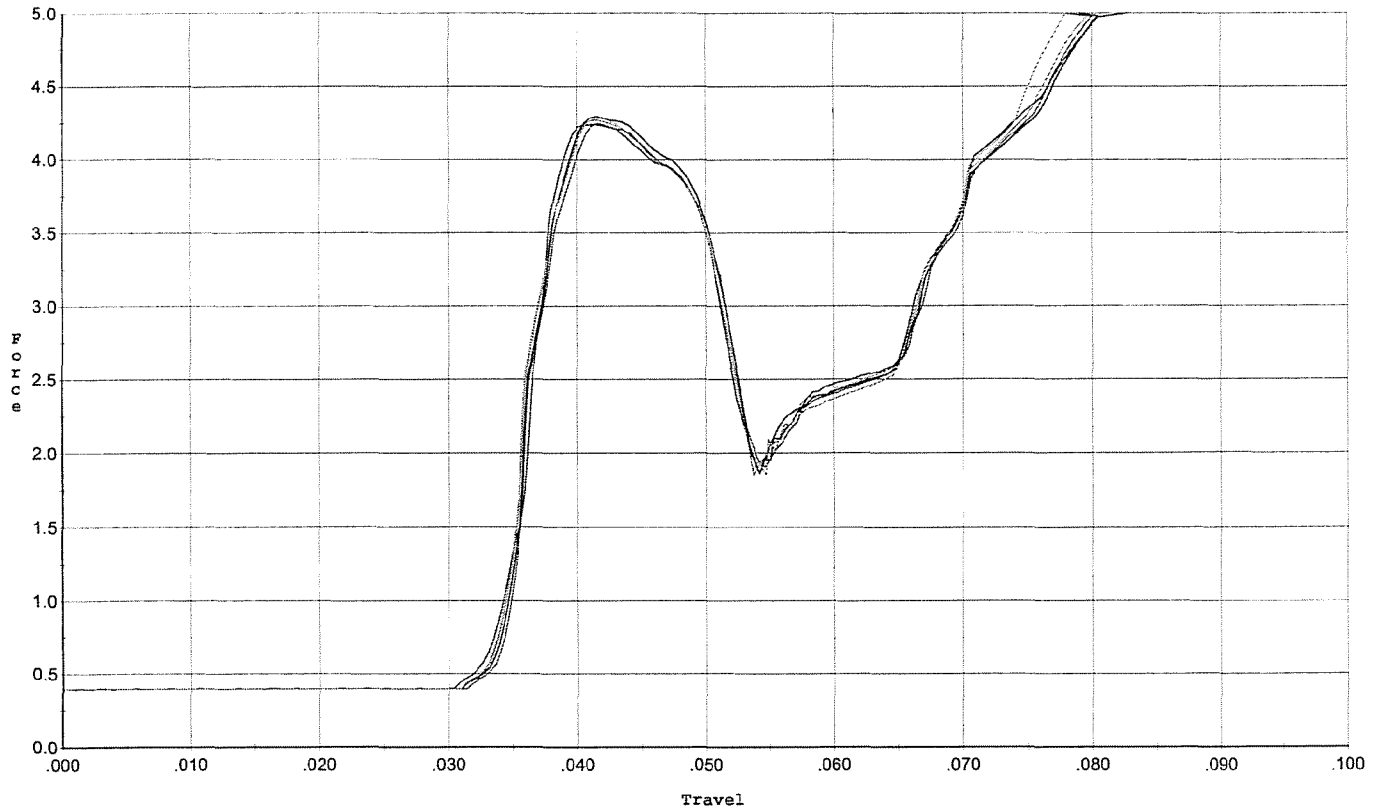
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.051	0.035	0.038	0.047		Set Trigger
2	2.566	0.050	0.035	0.038	0.046		Set Trigger
3	2.609	0.050	0.035	0.037	0.046		Set Trigger
4	2.577	0.050	0.035	0.037	0.046		Set Trigger
5	2.651	0.050	0.035	0.038	0.046		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/13/08

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	4.238	0.050	0.033	0.036	0.074		Set Trigger
2	4.294	0.051	0.034	0.035	0.076		Set Trigger
3	4.246	0.051	0.034	0.035	0.075		Set Trigger
4	4.270	0.051	0.034	0.035	0.076		Set Trigger
5	4.296	0.052	0.033	0.035	0.077		Set Trigger

Avg 4.26