

66794617

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



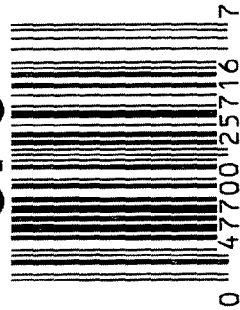
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794617

UPC



GUN SERIAL #

G 6794617

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-14-08	SP
430	ASSEMBLE TO STOCK		10-14-08	SP
440	PROOF		10-14-08	SP
460	CHECK HEADSPACE		10-14-08	SP
470	DIS-ASSEMBLE ACTION		10-14-08	SP
472	SERIALIZE BOLT HANDLE		10-15-08	RT
475	DRILL AND TAP SIGHT HOLES		10-15-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/17/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/17/08	RT
520	GOFF BLAST BBL / REC		10/20/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-22-08	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-23-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

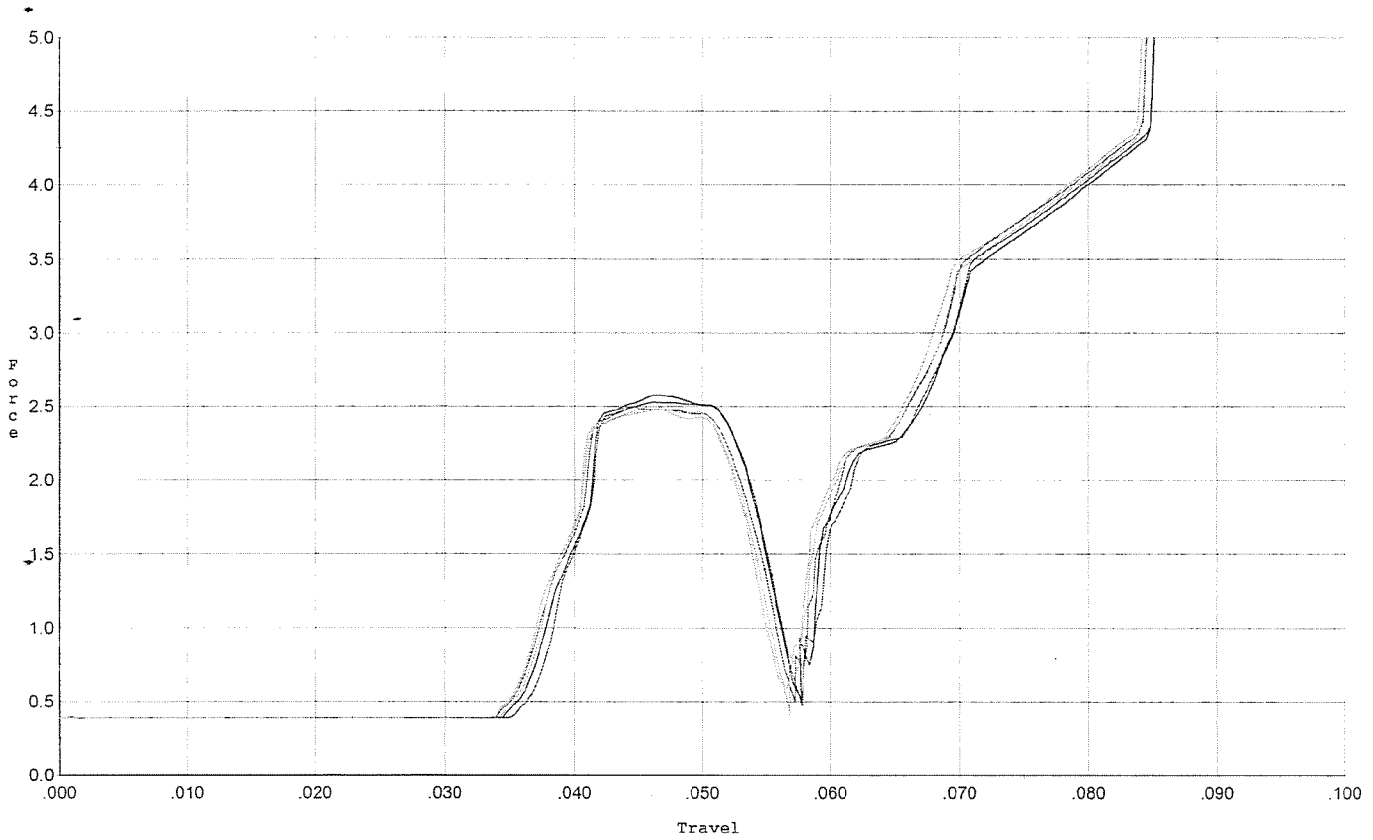
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.5</u>	10-27-08	R. D.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.5</u>	10-27-08	R. D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-27-08	R. D.
	J) ASSEMBLE STOCK		10-23-08	R. D.
	K) ASSEMBLE SWIVEL STUDS		10-27-08	R. D.
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10-24-08	R. D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	R. D.
670	FINAL INSPECTION A) HEADSPACE		10-27-08	R. D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>3.12</u> <u>3.14</u> <u>3.14</u> <u>3.15</u> <u>3.14</u>	10-24-08	R. D.
	C) FUNCTION		10-27-08	R. D.
690	PACK		10/29/08	F. M.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/21/08

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



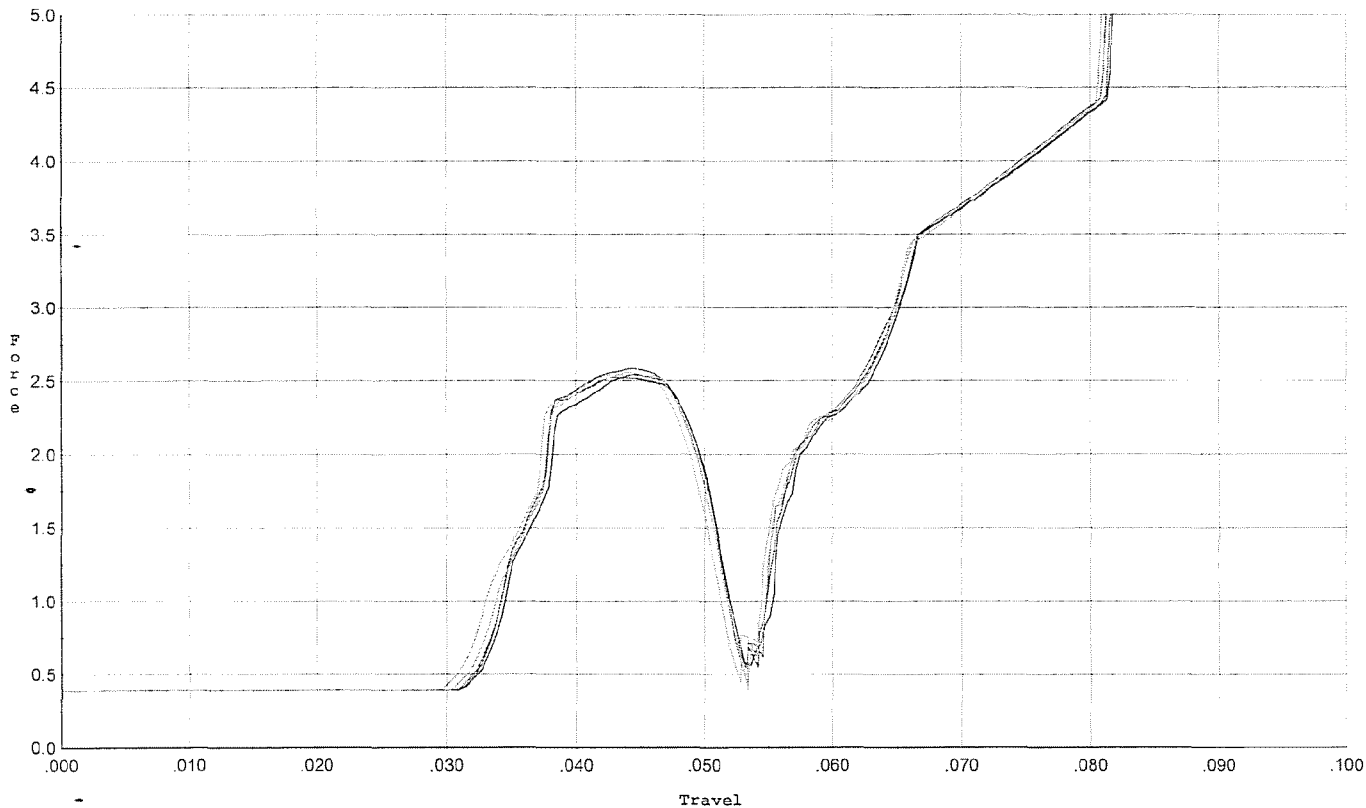
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.530	0.055	0.037	0.036	0.053		Set Trigger
2	2.578	0.054	0.036	0.037	0.053		Set Trigger
3	2.497	0.055	0.036	0.036	0.053		Set Trigger
4	2.479	0.054	0.036	0.036	0.051		Set Trigger
5	2.500	0.053	0.034	0.037	0.051		Set Trigger

Aug 2.51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/21/08

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



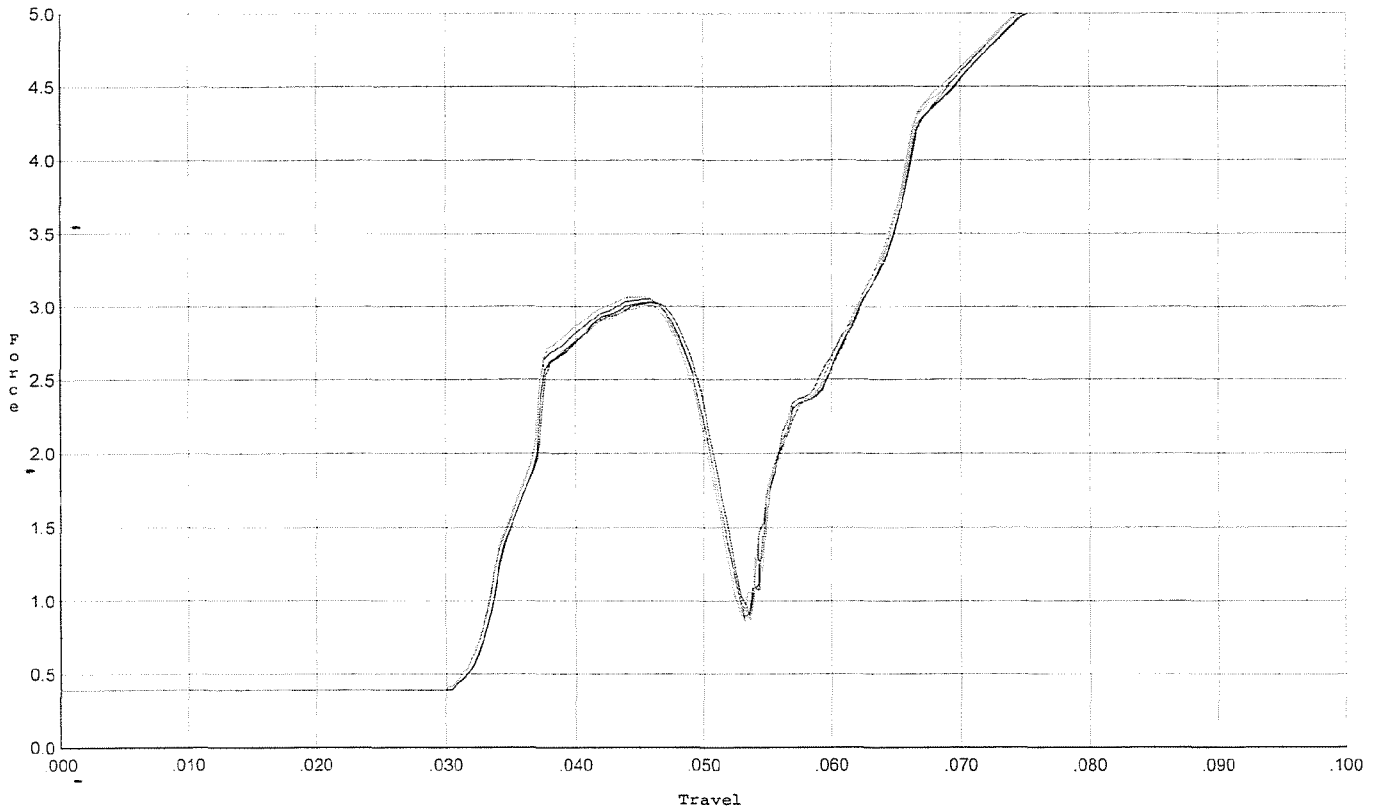
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.546	0.050	0.033	0.036	0.050		Set Trigger
2	2.519	0.050	0.033	0.036	0.049		Set Trigger
3	2.584	0.051	0.033	0.036	0.050		Set Trigger
4	2.543	0.051	0.032	0.036	0.050		Set Trigger
5	2.558	0.050	0.032	0.036	0.050		Set Trigger

Avg 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/21/08

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



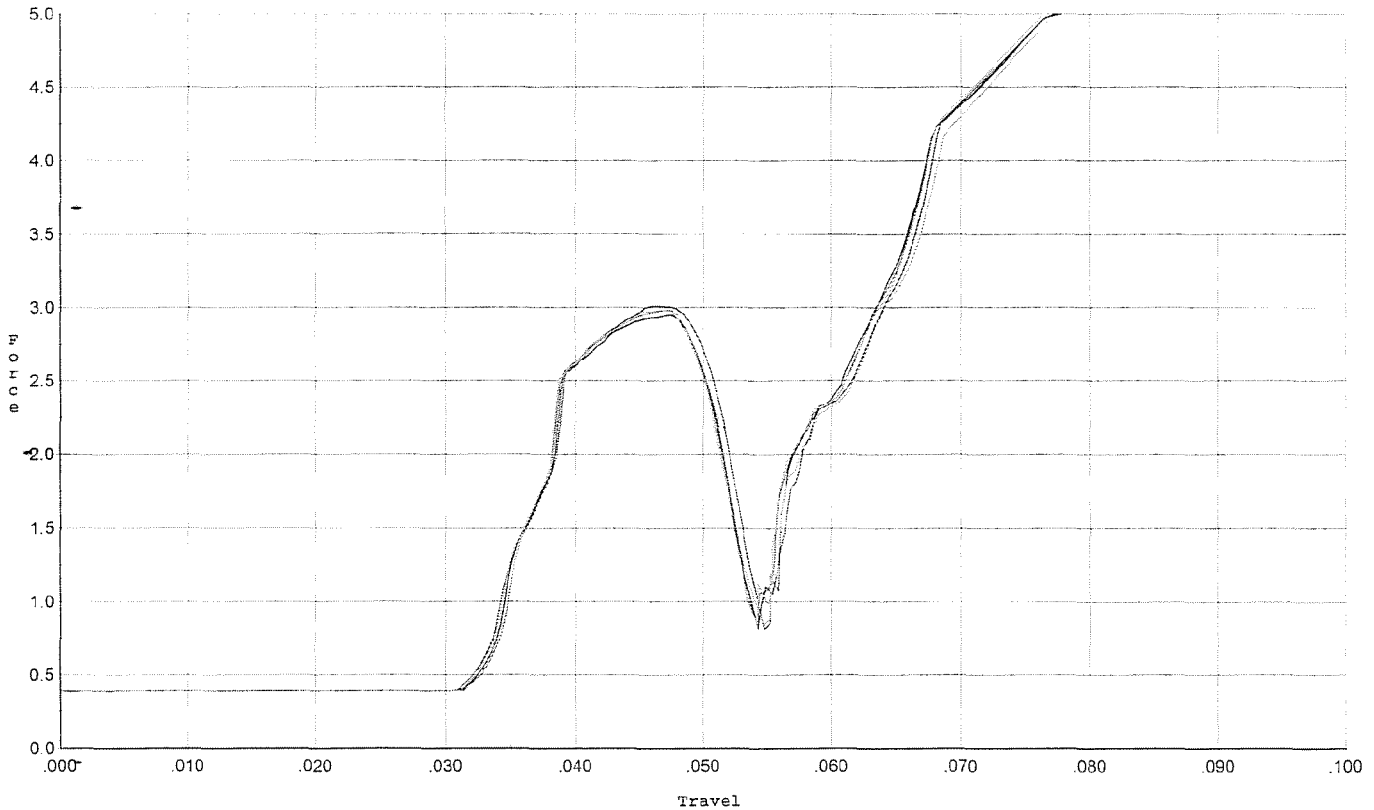
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.029	0.050	0.033	0.035	0.056		Set Trigger
2	3.032	0.050	0.033	0.035	0.057		Set Trigger
3	3.052	0.050	0.032	0.035	0.057		Set Trigger
4	3.011	0.051	0.032	0.035	0.057		Set Trigger
5	3.065	0.050	0.032	0.035	0.058		Set Trigger

Aug 3.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/21/08

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



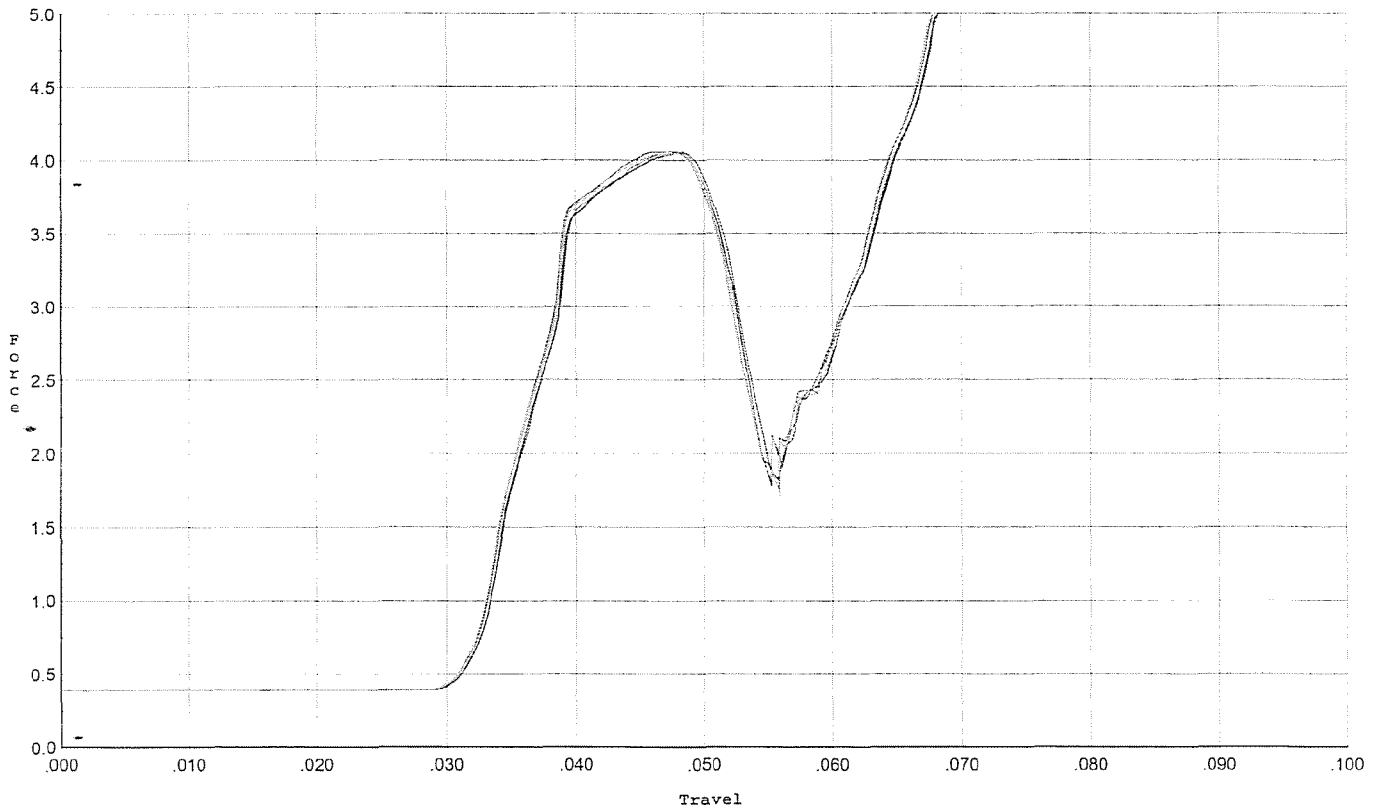
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.011	0.052	0.034	0.035	0.057		Set Trigger
2	2.951	0.051	0.033	0.035	0.056		Set Trigger
3	2.980	0.051	0.033	0.035	0.057		Set Trigger
4	2.979	0.051	0.034	0.035	0.056		Set Trigger
5	2.983	0.052	0.033	0.035	0.057		Set Trigger

Aug 2.98

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/21/08

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



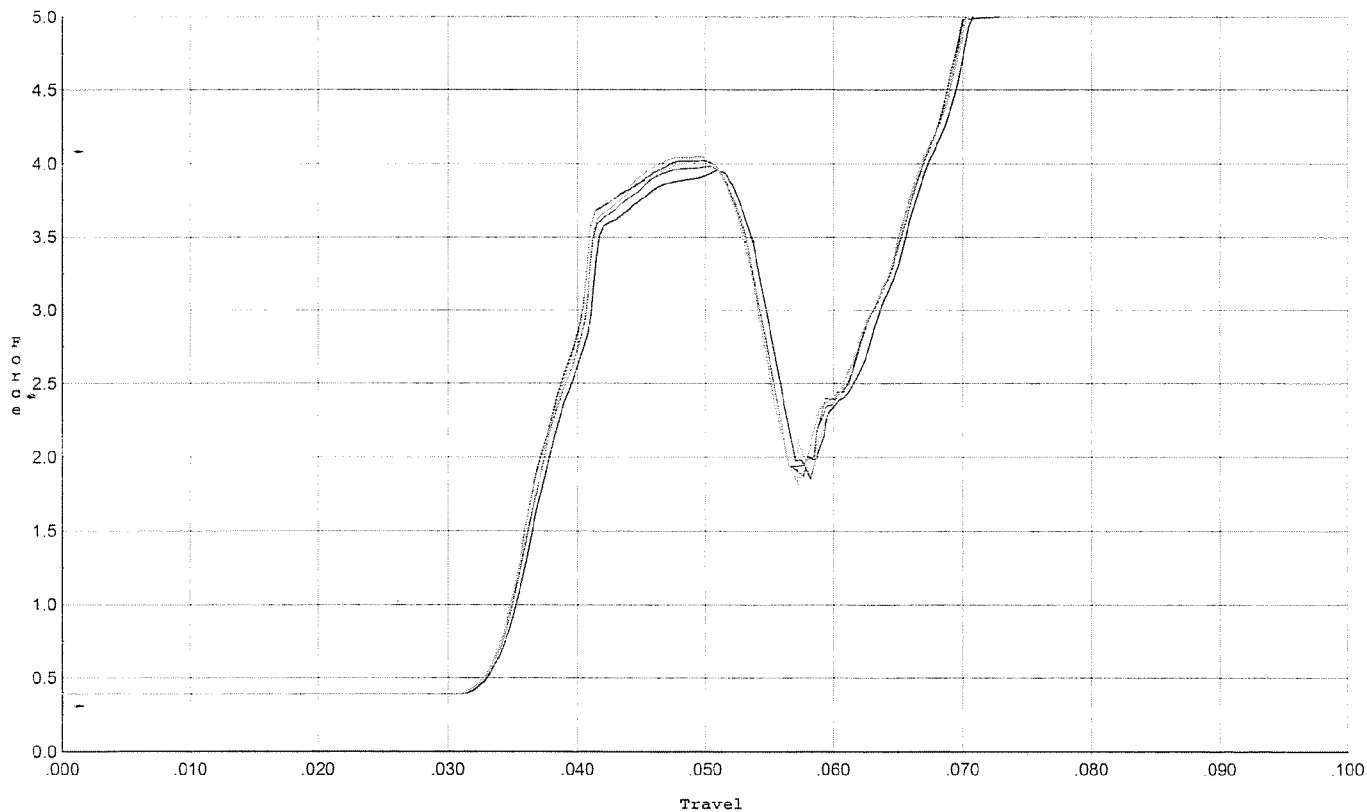
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.053	0.052	0.032	0.028	0.077		Set Trigger
2	4.045	0.052	0.032	0.028	0.078		Set Trigger
3	4.060	0.051	0.031	0.028	0.077		Set Trigger
4	4.048	0.051	0.031	0.028	0.076		Set Trigger
5	4.063	0.053	0.031	0.028	0.079		Set Trigger

Aug 4.05

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/21/08

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



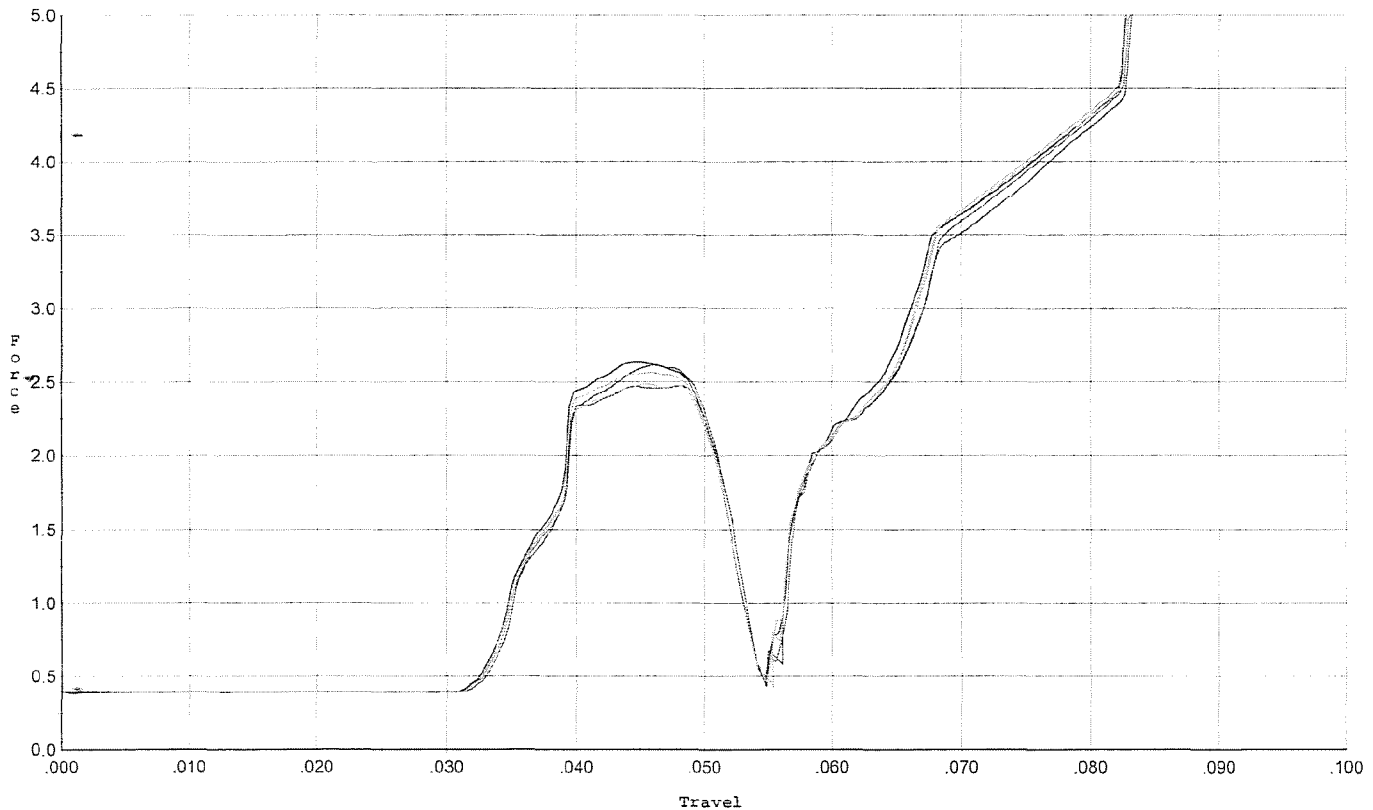
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.020	0.055	0.033	0.029	0.081		Set Trigger
2	3.956	0.054	0.033	0.029	0.077		Set Trigger
3	3.982	0.053	0.033	0.029	0.076		Set Trigger
4	4.030	0.055	0.033	0.029	0.080		Set Trigger
5	4.048	0.053	0.033	0.029	0.078		Set Trigger

Aug 4.00

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 8/21/08

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



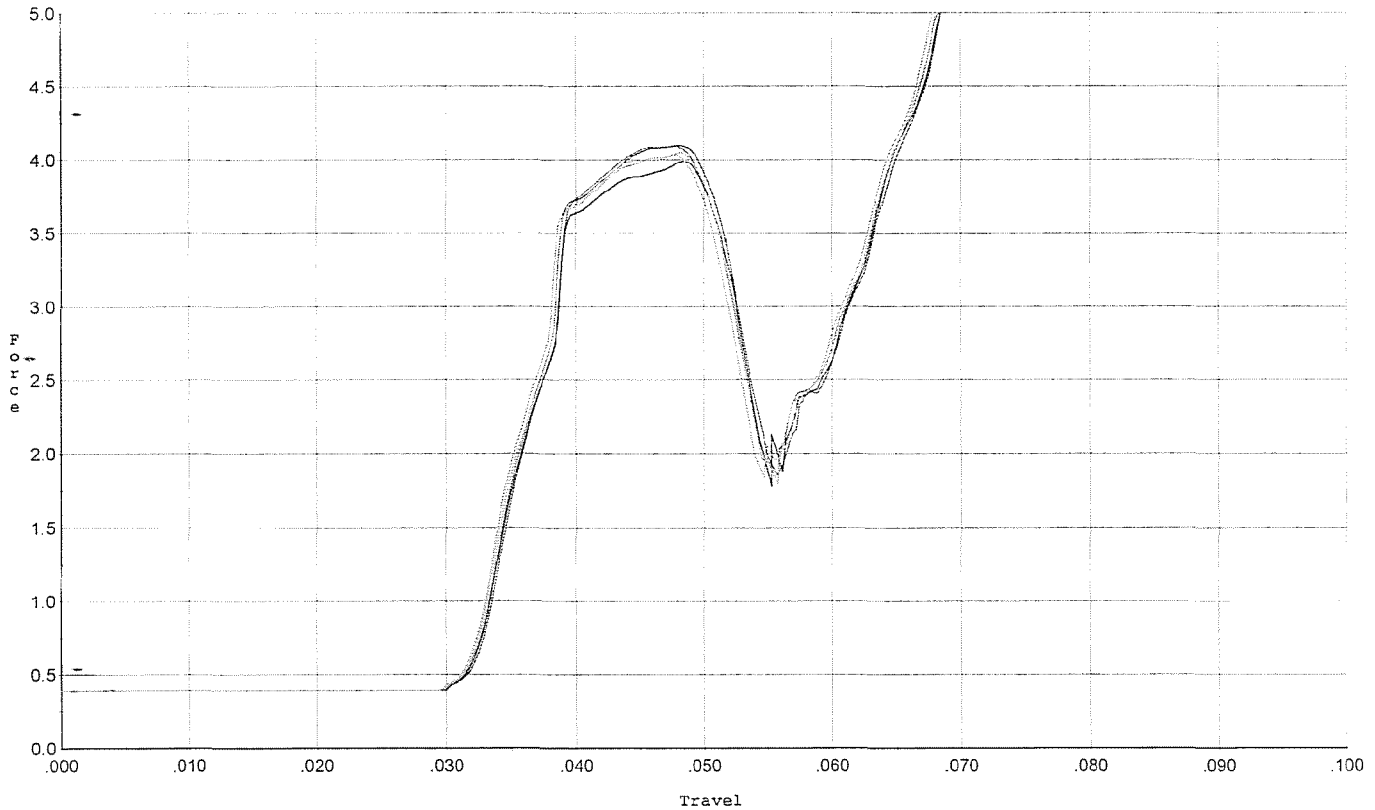
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.615	0.052	0.033	0.036	0.051		Set Trigger
2	2.638	0.051	0.033	0.036	0.051		Set Trigger
3	2.475	0.052	0.033	0.036	0.050		Set Trigger
4	2.486	0.051	0.033	0.036	0.049		Set Trigger
5	2.562	0.051	0.033	0.036	0.050		Set Trigger

AUG 2.55

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 8/21/08

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	4.098	0.052	0.032	0.029	0.077		Set Trigger
2	3.990	0.052	0.032	0.029	0.077		Set Trigger
3	4.093	0.053	0.032	0.028	0.079		Set Trigger
4	4.047	0.053	0.032	0.028	0.079		Set Trigger
5	4.036	0.052	0.032	0.029	0.077		Set Trigger

Avg. 4.05