

56794660

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



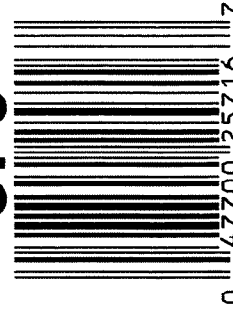
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794660

UPC



GUN SERIAL # G6794660

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA FLUX	10-28-08	SP
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION		10/28/08	RT
490	MAGNAFLUX BOLT		10/27/08	RT
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC		10/29/08	RT
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	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

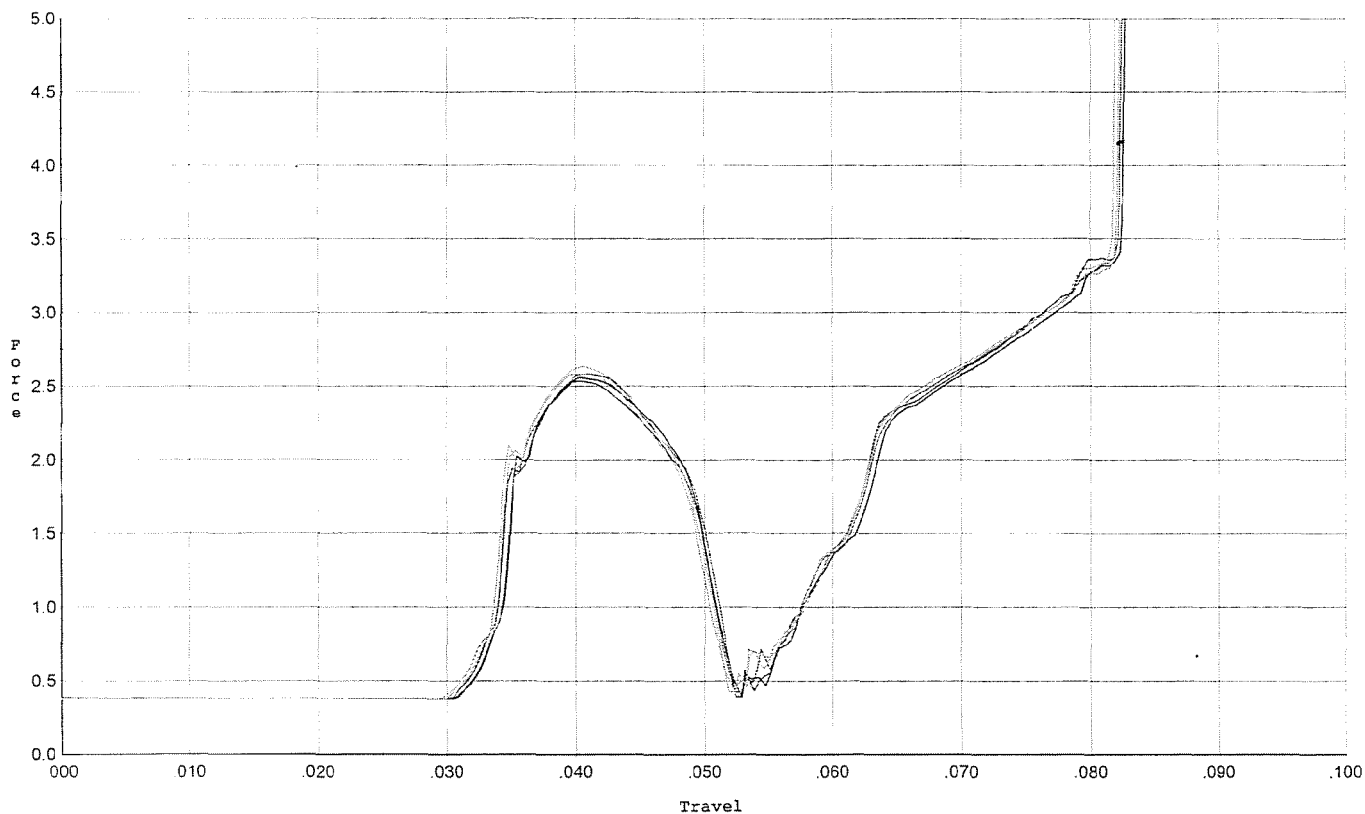
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>30</u> <u>40</u>	11-18-08	RH
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	11-18-08	RH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-18-08	LH
	J) ASSEMBLE STOCK		11-10-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		11-18-08	LH
	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	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-11-08	JS
670	FINAL INSPECTION A) HEADSPACE		11-18-08	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.48</u> <u>2.48</u> <u>2.53</u> <u>2.54</u>	11-11-08	TL
	C) FUNCTION		11-18-08	LH
690	PACK		12-2-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/30/08

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



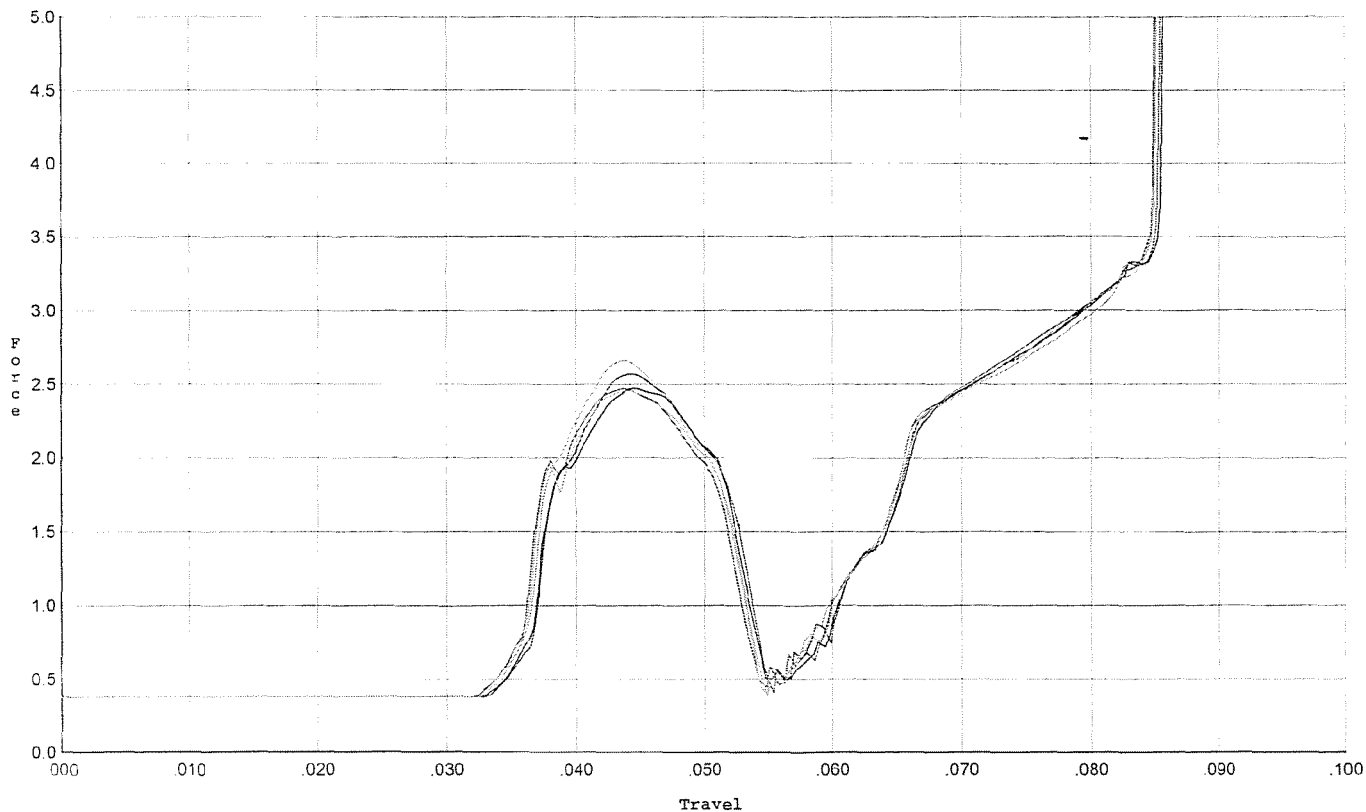
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.538	0.050	0.032	0.037	0.048		Set Trigger
2	2.558	0.049	0.033	0.037	0.048		Set Trigger
3	2.584	0.050	0.033	0.036	0.049		Set Trigger
4	2.634	0.050	0.032	0.037	0.049		Set Trigger
5	2.584	0.049	0.032	0.037	0.048		Set Trigger

Aug 2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



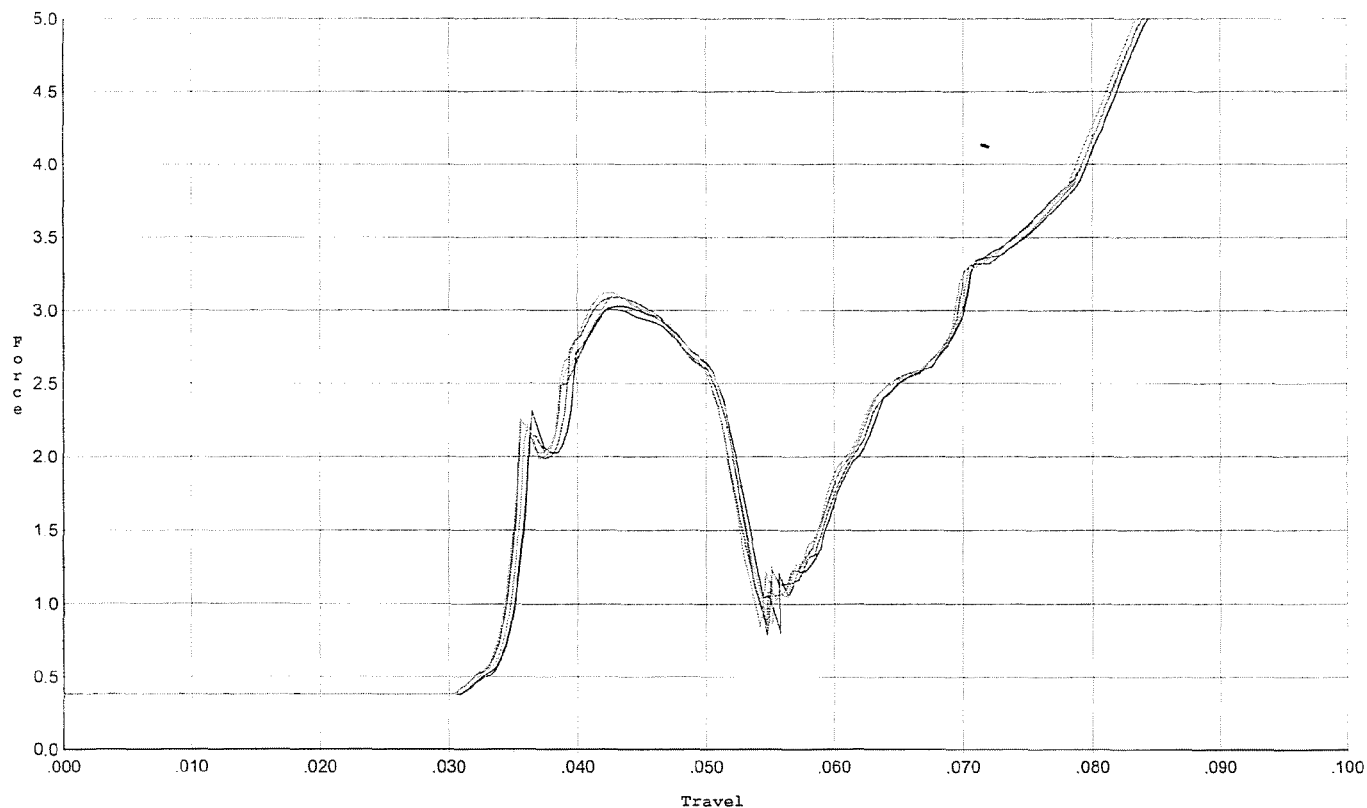
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.053	0.036	0.038	0.049		Set Trigger
2	2.471	0.052	0.036	0.038	0.047		Set Trigger
3	2.471	0.051	0.035	0.038	0.047		Set Trigger
4	2.455	0.052	0.035	0.037	0.048		Set Trigger
5	2.662	0.052	0.035	0.037	0.049		Set Trigger

Aug 2.52

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/30/08

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



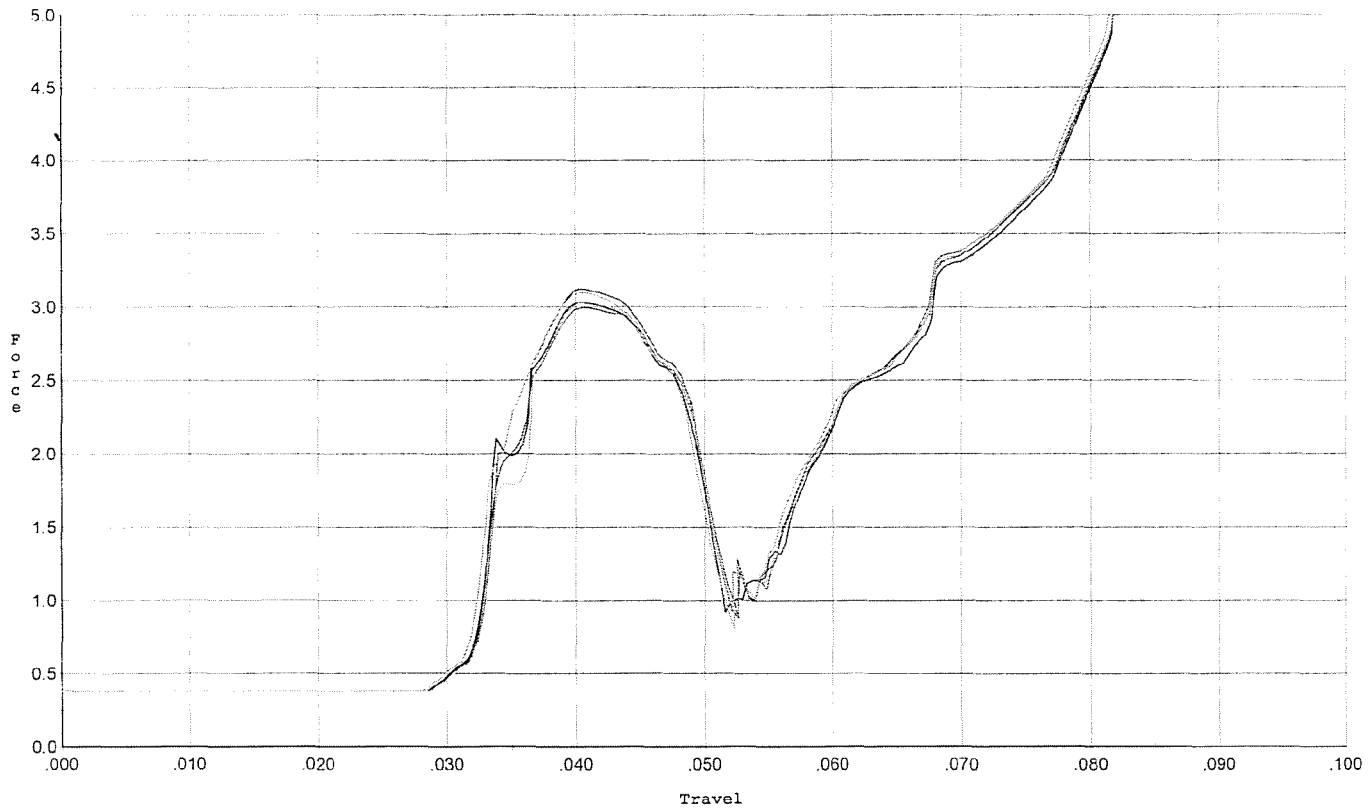
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.007	0.052	0.034	0.036	0.057		Set Trigger
2	3.033	0.053	0.034	0.036	0.059		Set Trigger
3	3.091	0.051	0.034	0.036	0.058		Set Trigger
4	3.096	0.051	0.034	0.036	0.058		Set Trigger
5	3.124	0.051	0.033	0.035	0.058		Set Trigger

Avg 3.07

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/30/08

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



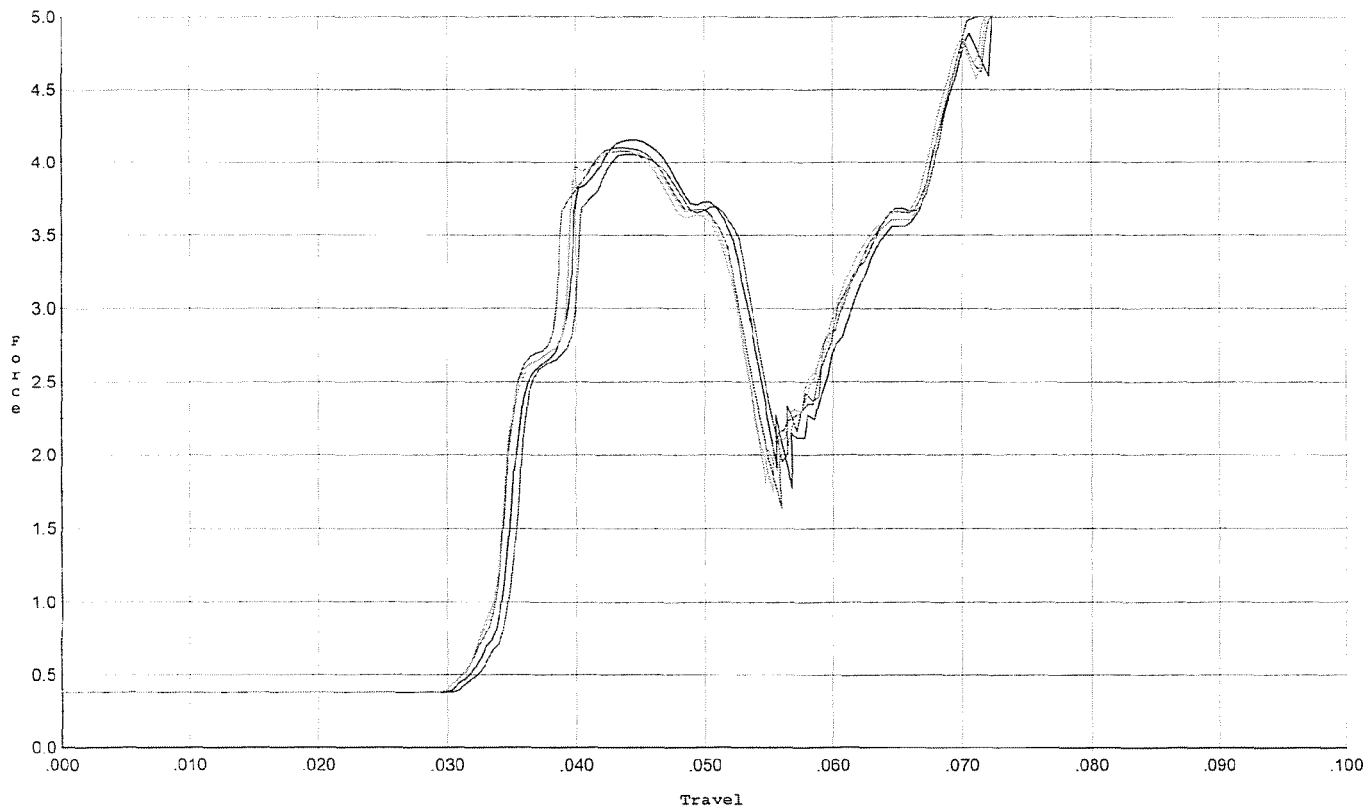
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.049	0.032	0.036	0.057		Set Trigger
2	3.033	0.049	0.032	0.036	0.056		Set Trigger
3	2.994	0.049	0.032	0.036	0.056		Set Trigger
4	3.034	0.049	0.032	0.036	0.055		Set Trigger
5	3.098	0.048	0.031	0.035	0.056		Set Trigger

Aug 3.05

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/30/08

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



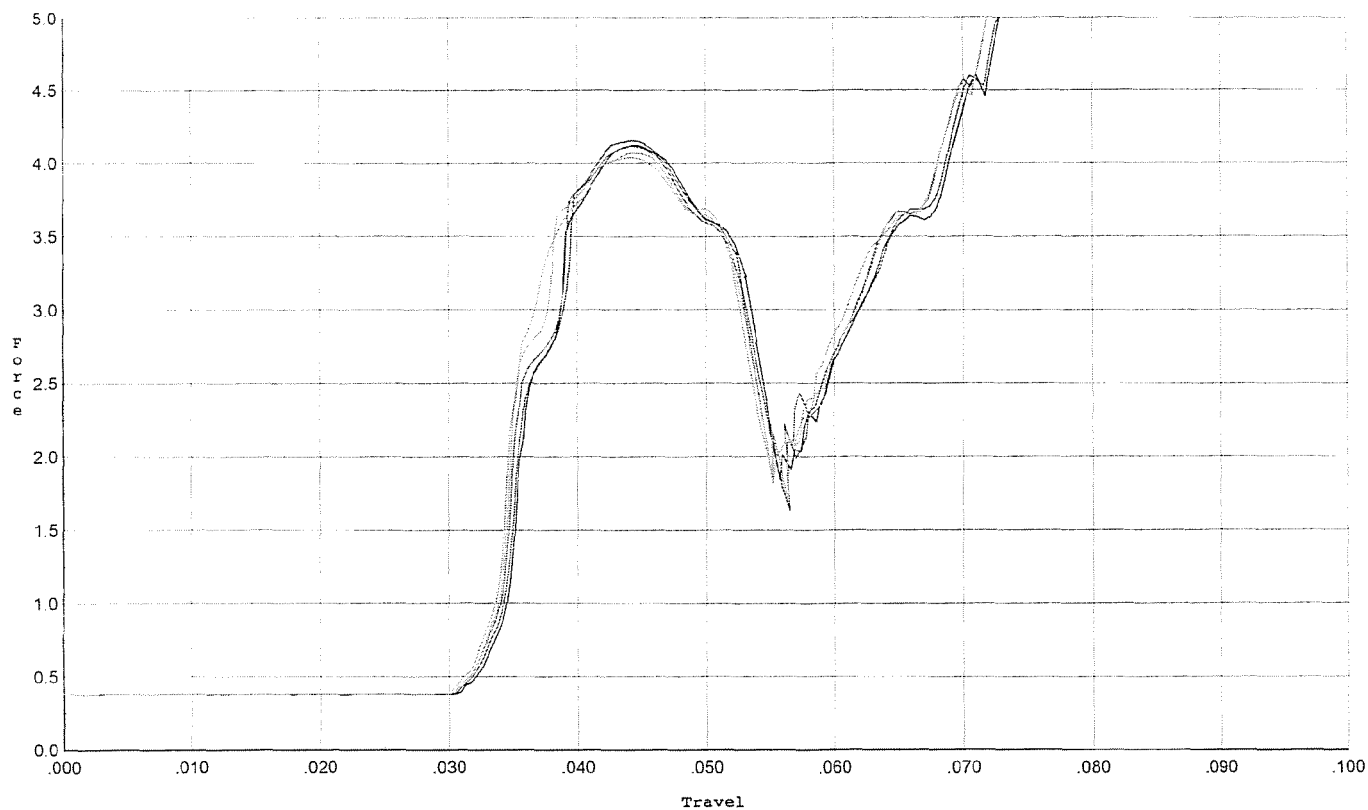
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.054	0.053	0.033	0.035	0.077		Set Trigger
2	4.153	0.054	0.033	0.034	0.081		Set Trigger
3	4.101	0.052	0.032	0.034	0.078		Set Trigger
4	4.079	0.052	0.032	0.034	0.078		Set Trigger
5	4.077	0.052	0.032	0.034	0.078		Set Trigger

Aug 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/30/08

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



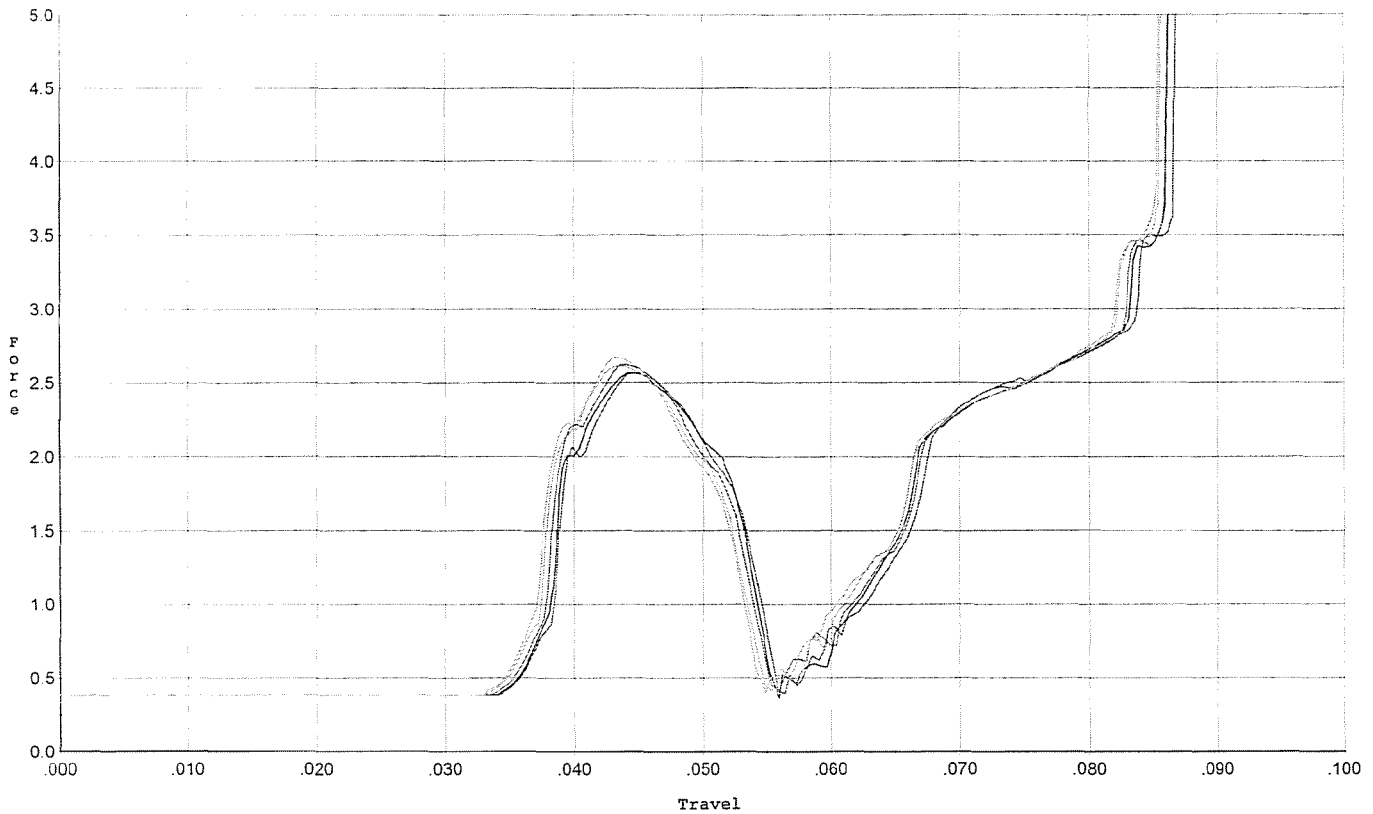
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.155	0.052	0.033	0.035	0.079		Set Trigger
2	4.122	0.053	0.033	0.034	0.080		Set Trigger
3	4.117	0.053	0.032	0.034	0.080		Set Trigger
4	4.038	0.053	0.031	0.034	0.081		Set Trigger
5	4.069	0.052	0.032	0.034	0.079		Set Trigger

Aug 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/30/08

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



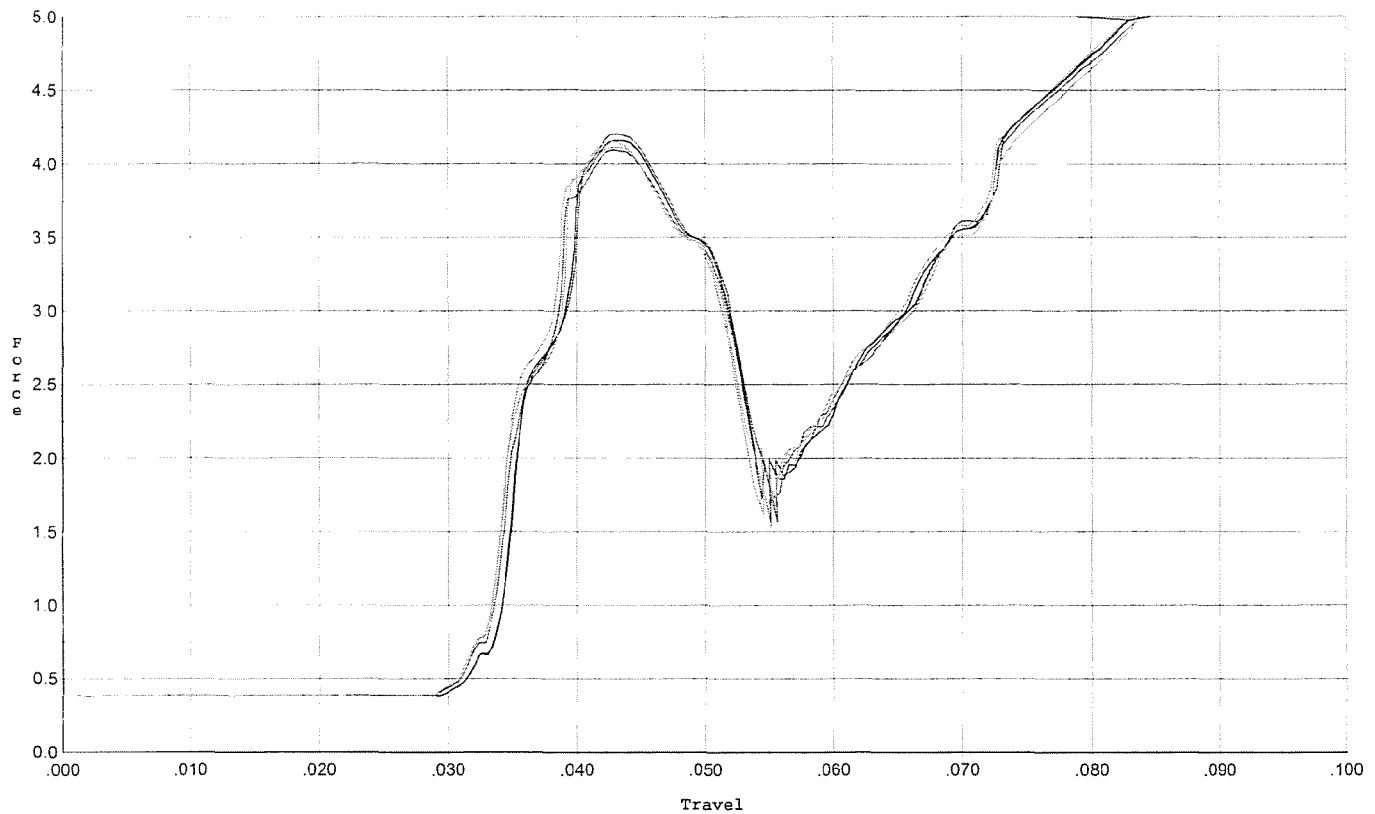
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.054	0.037	0.039	0.049		Set Trigger
2	2.565	0.053	0.036	0.039	0.049		Set Trigger
3	2.623	0.053	0.036	0.038	0.048		Set Trigger
4	2.675	0.052	0.036	0.038	0.048		Set Trigger
5	2.614	0.052	0.035	0.038	0.048		Set Trigger

Aug 2.60

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 10/30/08

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	4.204	0.052	0.032	0.035	0.075		Set Trigger
2	4.160	0.052	0.032	0.035	0.075		Set Trigger
3	4.093	0.052	0.032	0.034	0.076		Set Trigger
4	4.116	0.051	0.031	0.034	0.074		Set Trigger
5	4.155	0.052	0.031	0.034	0.076		Set Trigger

Aug 4.14