

56794773

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



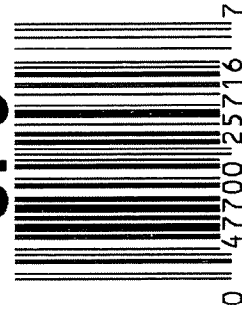
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794773

UPC



GUN SERIAL #

G 6794773

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-8-08	ES
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	10/11/08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-29-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

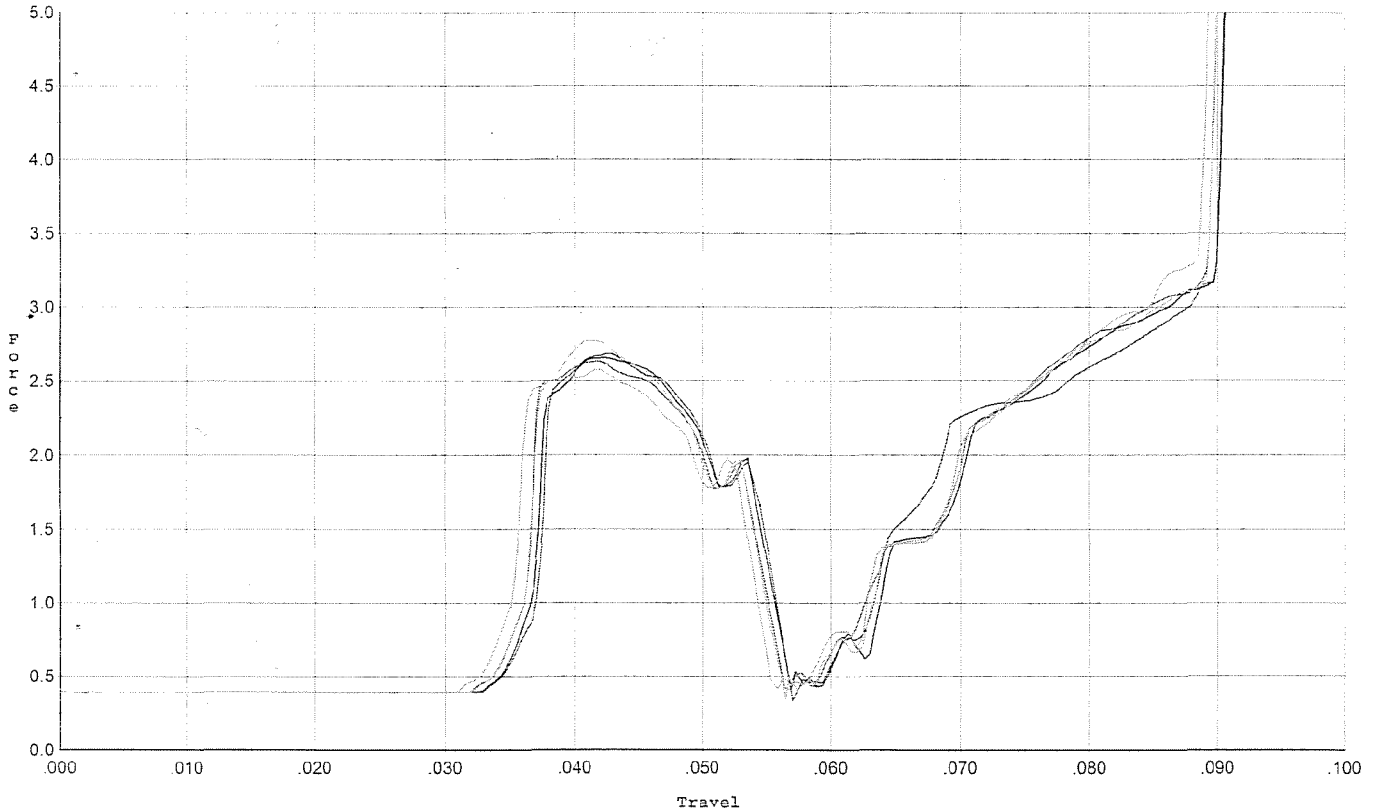
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.5</u> <u>4.5</u>	11-5-08	L.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-5-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	11-5-08	L.N.
	J) ASSEMBLE STOCK		10-29-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-5-08	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10-30-08	FSW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-5-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.03</u> <u>2.08</u> <u>2.01</u> <u>2.05</u> <u>2.02</u>	11-5-08	Fm
	C) FUNCTION		11-5-08	L.N.
690	PACK		11/7/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



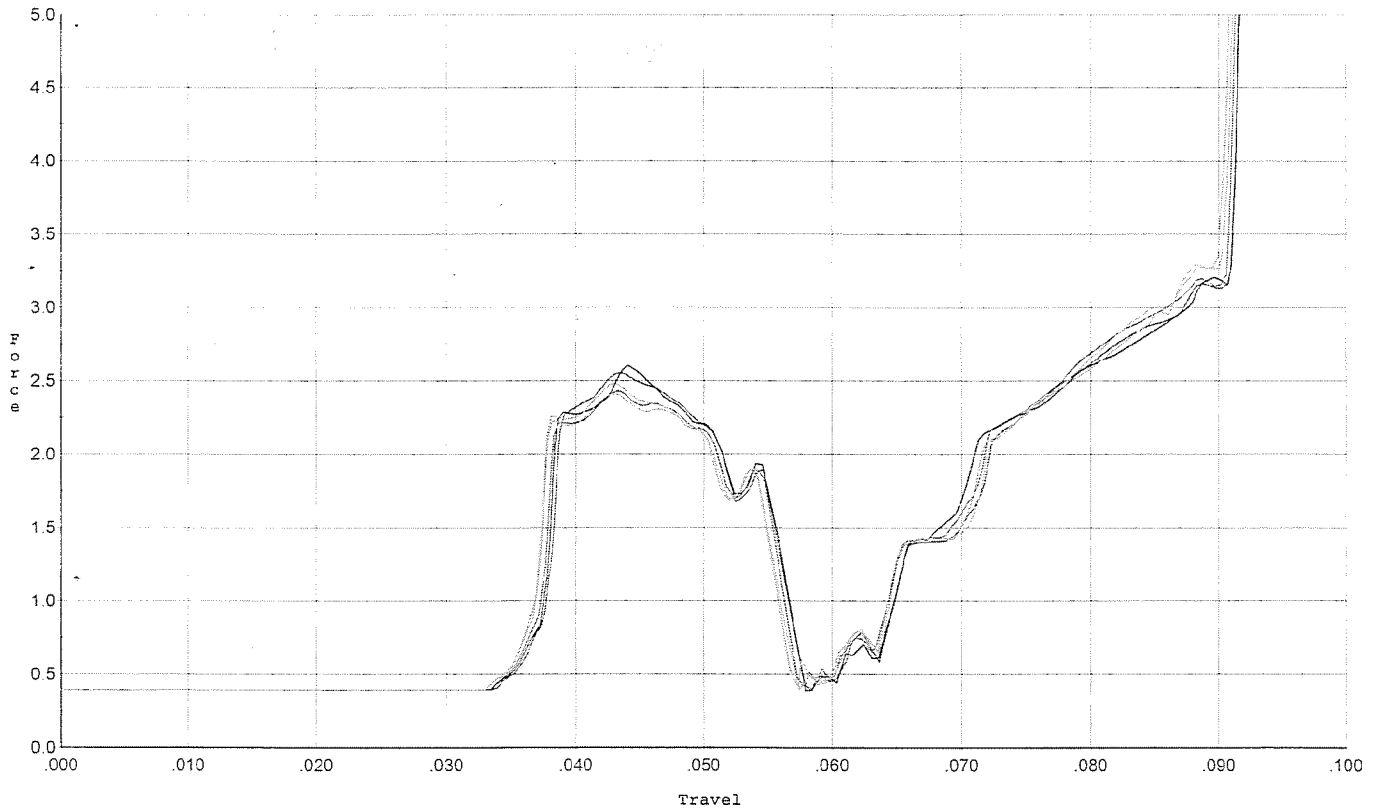
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.681	0.054	0.035	0.039	0.056		Set Trigger
2	2.654	0.053	0.035	0.040	0.055		Set Trigger
3	2.629	0.053	0.035	0.040	0.055		Set Trigger
4	2.773	0.053	0.035	0.039	0.055		Set Trigger
5	2.576	0.053	0.033	0.040	0.055		Set Trigger

Aug 2.66

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



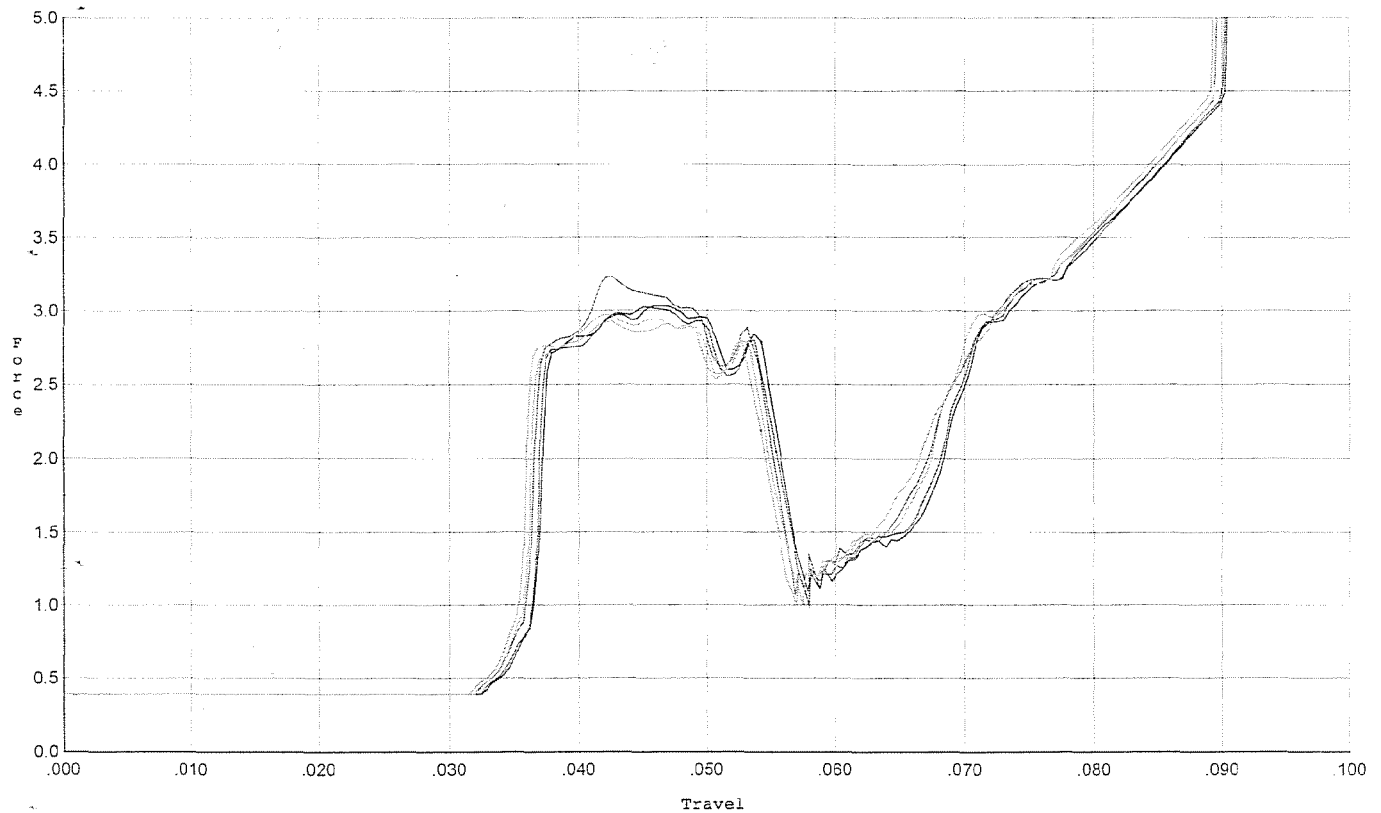
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.555	0.056	0.036	0.040	0.055		Set Trigger
2	2.603	0.056	0.036	0.040	0.055		Set Trigger
3	2.431	0.055	0.036	0.040	0.053		Set Trigger
4	2.409	0.054	0.035	0.040	0.052		Set Trigger
5	2.480	0.054	0.035	0.040	0.053		Set Trigger

Aug 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



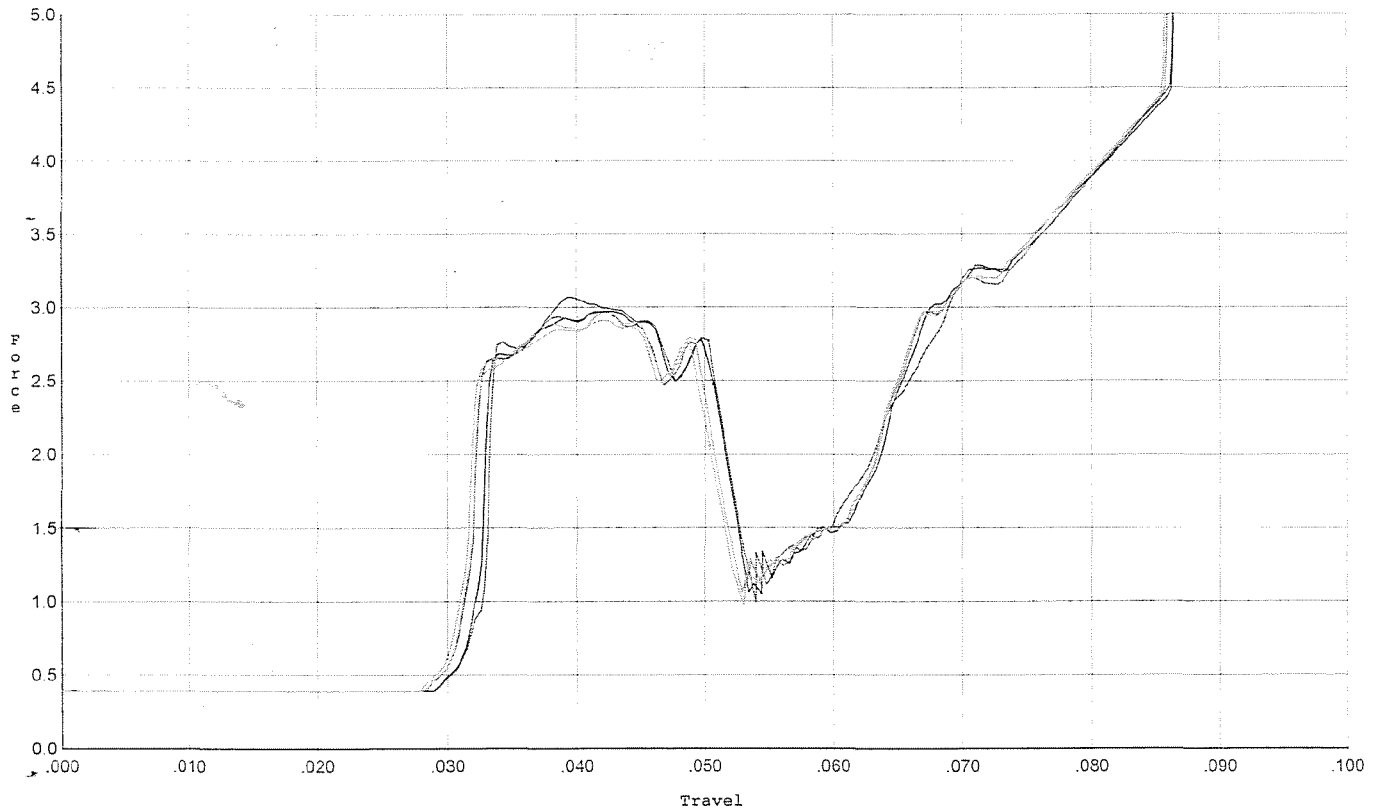
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.024	0.055	0.035	0.037	0.068		Set Trigger
2	3.033	0.054	0.035	0.038	0.066		Set Trigger
3	3.233	0.054	0.034	0.037	0.068		Set Trigger
4	2.929	0.053	0.034	0.038	0.065		Set Trigger
5	2.976	0.054	0.034	0.037	0.067		Set Trigger

Aug 3.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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



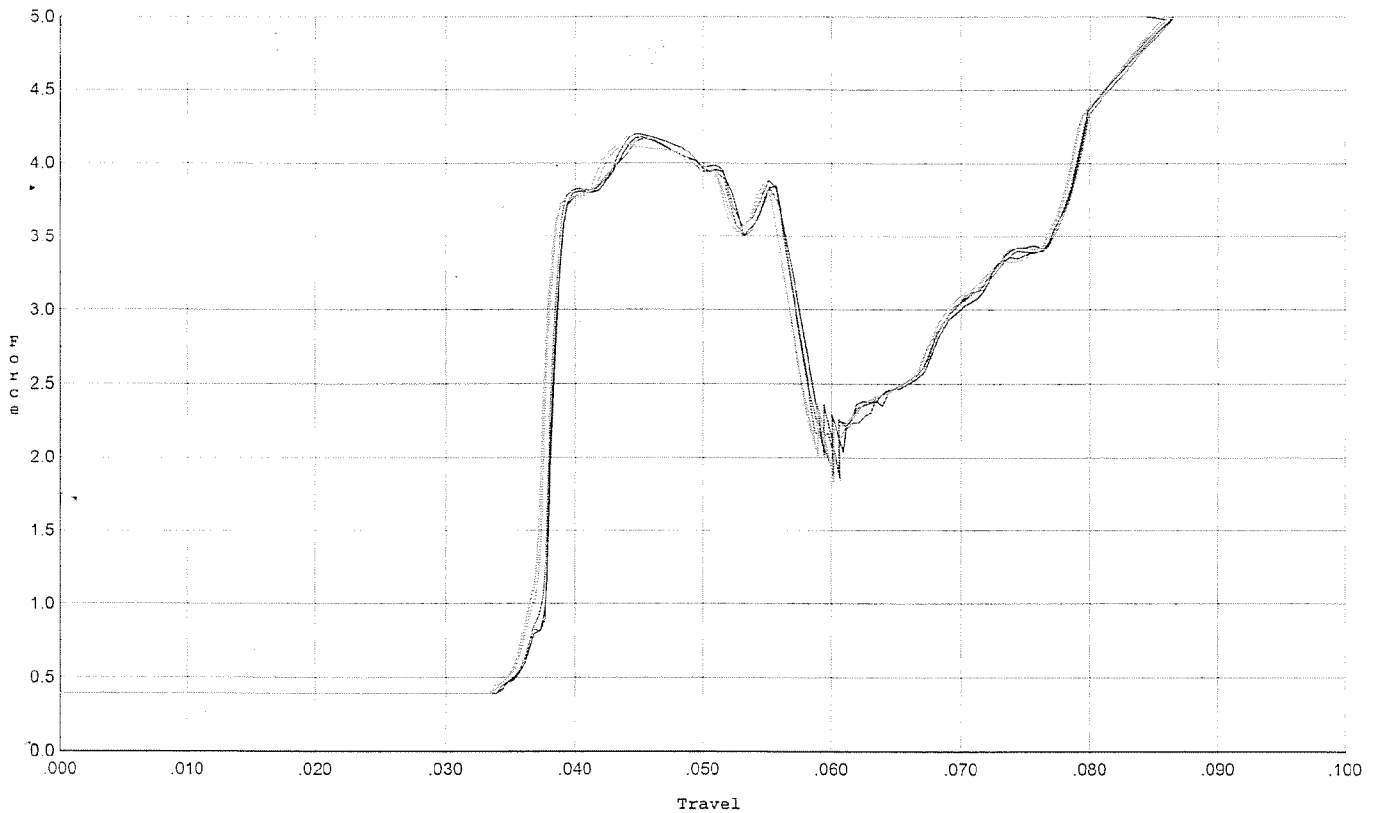
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.071	0.050	0.031	0.037	0.064		Set Trigger
2	2.972	0.051	0.031	0.037	0.064		Set Trigger
3	2.964	0.049	0.029	0.038	0.063		Set Trigger
4	2.961	0.049	0.029	0.038	0.062		Set Trigger
5	2.909	0.050	0.030	0.038	0.064		Set Trigger

Avg 2.97

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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

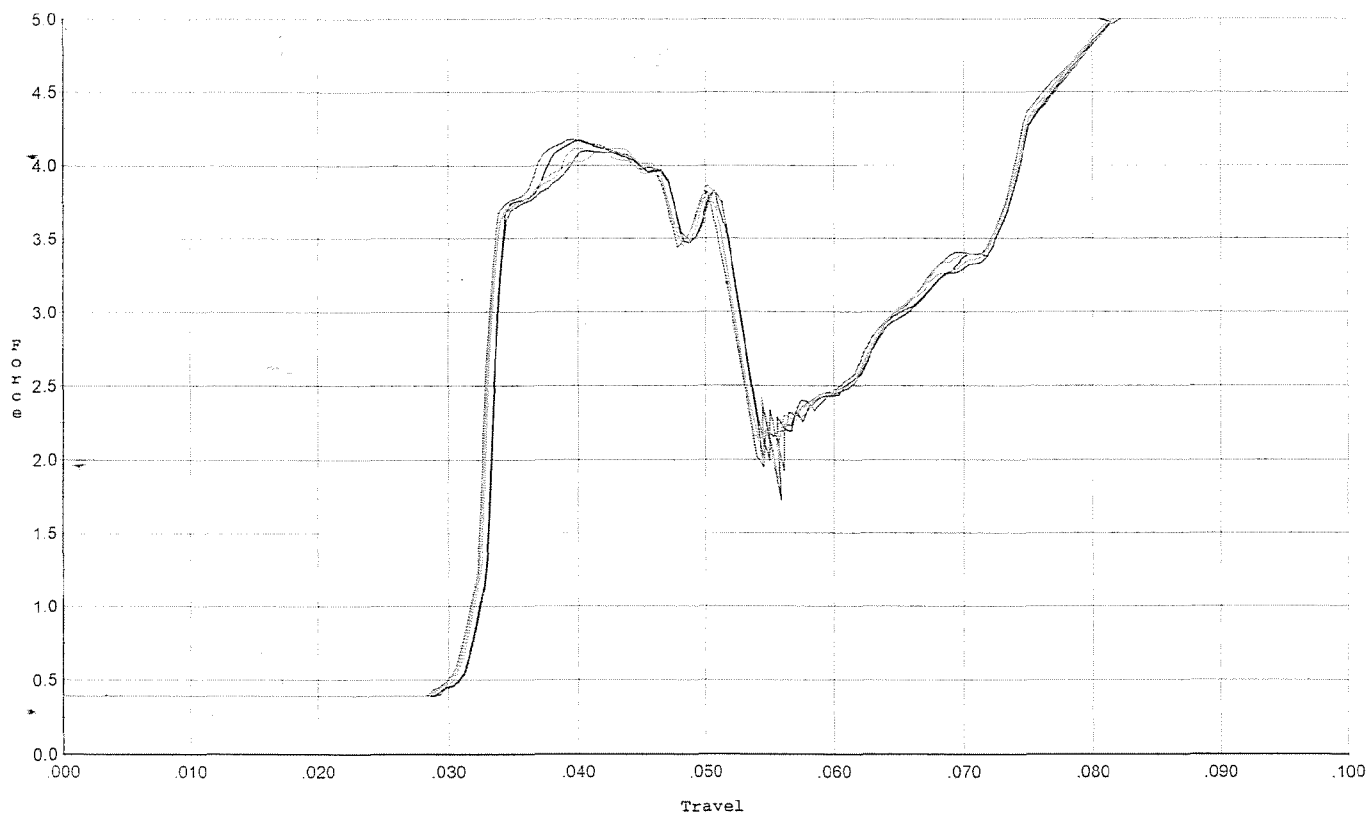


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.198	0.056	0.036	0.038	0.088		Set Trigger
2	4.176	0.057	0.036	0.038	0.090		Set Trigger
3	4.164	0.056	0.036	0.038	0.088		Set Trigger
4	4.185	0.055	0.036	0.037	0.087		Set Trigger
5	4.128	0.055	0.035	0.037	0.088		Set Trigger

Aug 4.17

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R. Putch 10/28/08		



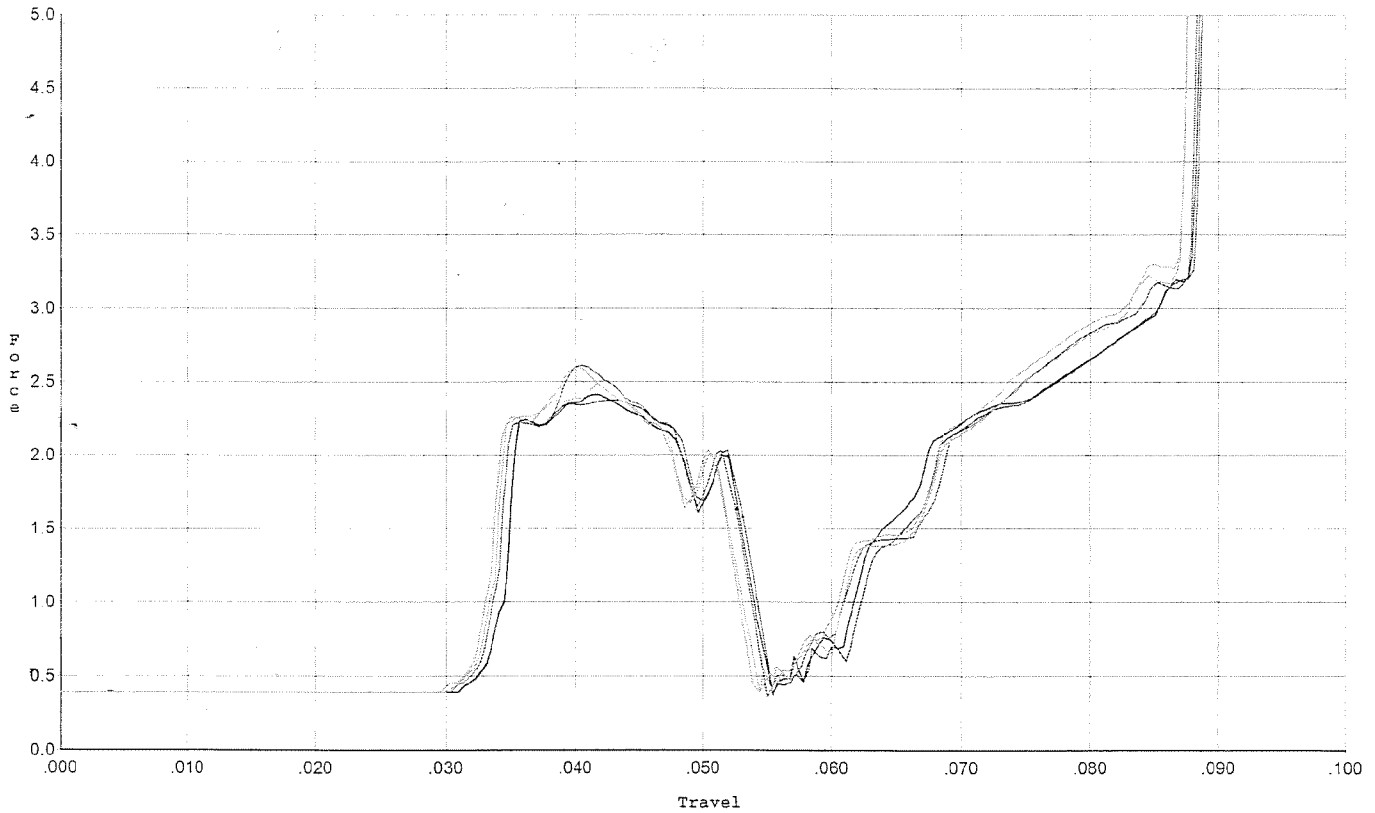
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.051	0.032	0.034	0.085		Set Trigger
2	4.171	0.052	0.031	0.034	0.086		Set Trigger
3	4.174	0.052	0.031	0.034	0.088		Set Trigger
4	4.084	0.051	0.031	0.034	0.085		Set Trigger
5	4.120	0.051	0.031	0.034	0.086		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/28/08

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

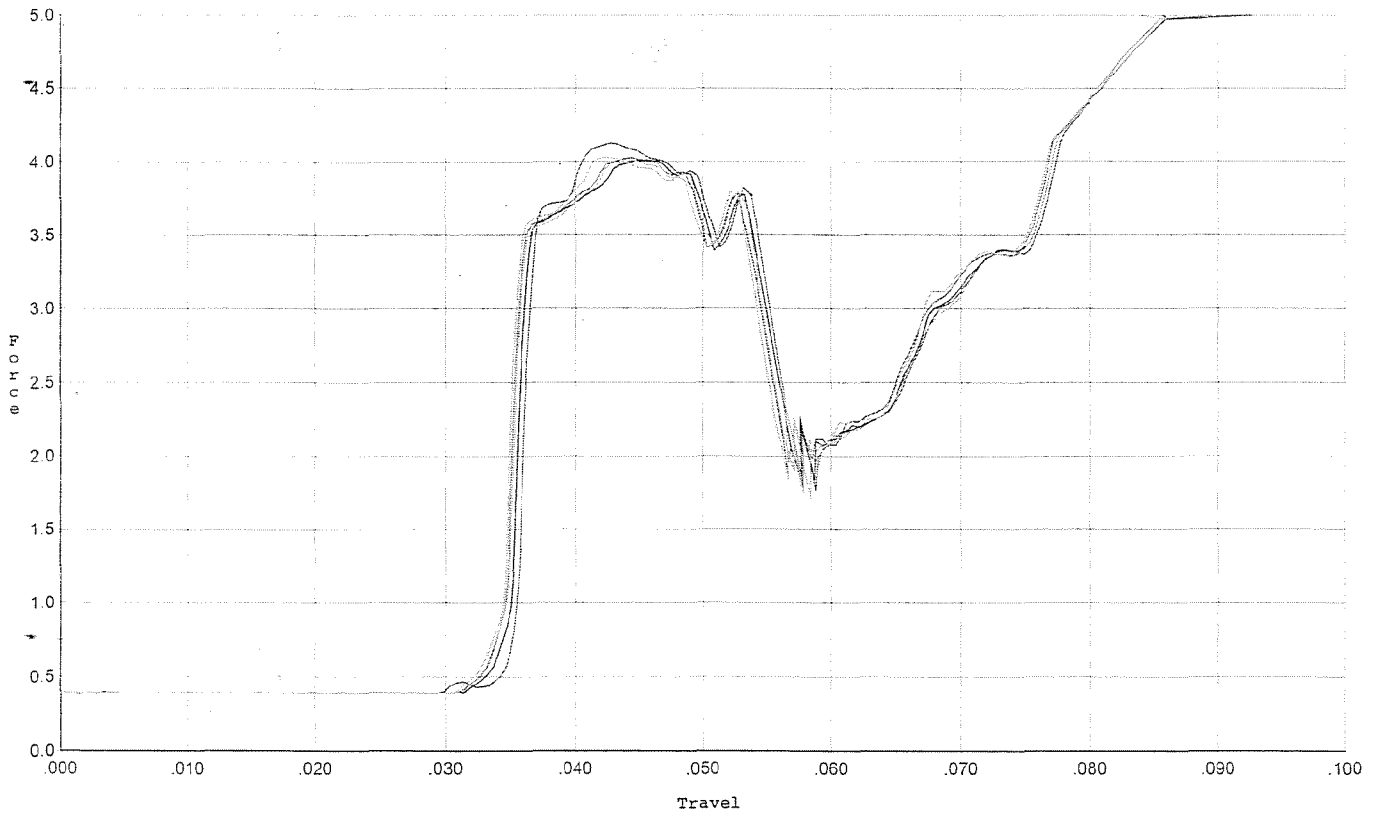


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.376	0.053	0.033	0.039	0.054		Set Trigger
2	2.412	0.052	0.033	0.039	0.052		Set Trigger
3	2.610	0.053	0.033	0.039	0.055		Set Trigger
4	2.599	0.051	0.033	0.040	0.053		Set Trigger
5	2.486	0.051	0.032	0.039	0.053		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile:	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 10/28/08		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.126	0.054	0.035	0.036	0.086		Set Trigger
2	4.006	0.055	0.034	0.036	0.087		Set Trigger
3	4.024	0.054	0.034	0.036	0.087		Set Trigger
4	4.008	0.053	0.034	0.036	0.085		Set Trigger
5	4.028	0.053	0.033	0.035	0.084		Set Trigger

Avg 4.03