

G6778929

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



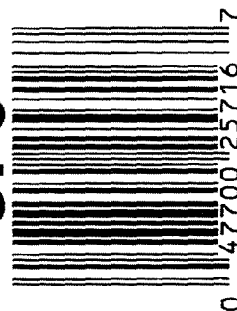
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6778929

UPC



GUN SERIAL #

G 677 8929

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	SPD
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	SPD
460	CHECK HEADSPACE		8-20-08	SPD
470	DIS-ASSEMBLE ACTION		8-20-08	SPD
472	SERIALIZE BOLT HANDLE		8-21-08	RTZ
475	DRILL AND TAP SIGHT HOLES		8-21-08	SP
480	MAGNAFLUX BBL ACTION		8-21-08	BIT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-22-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			

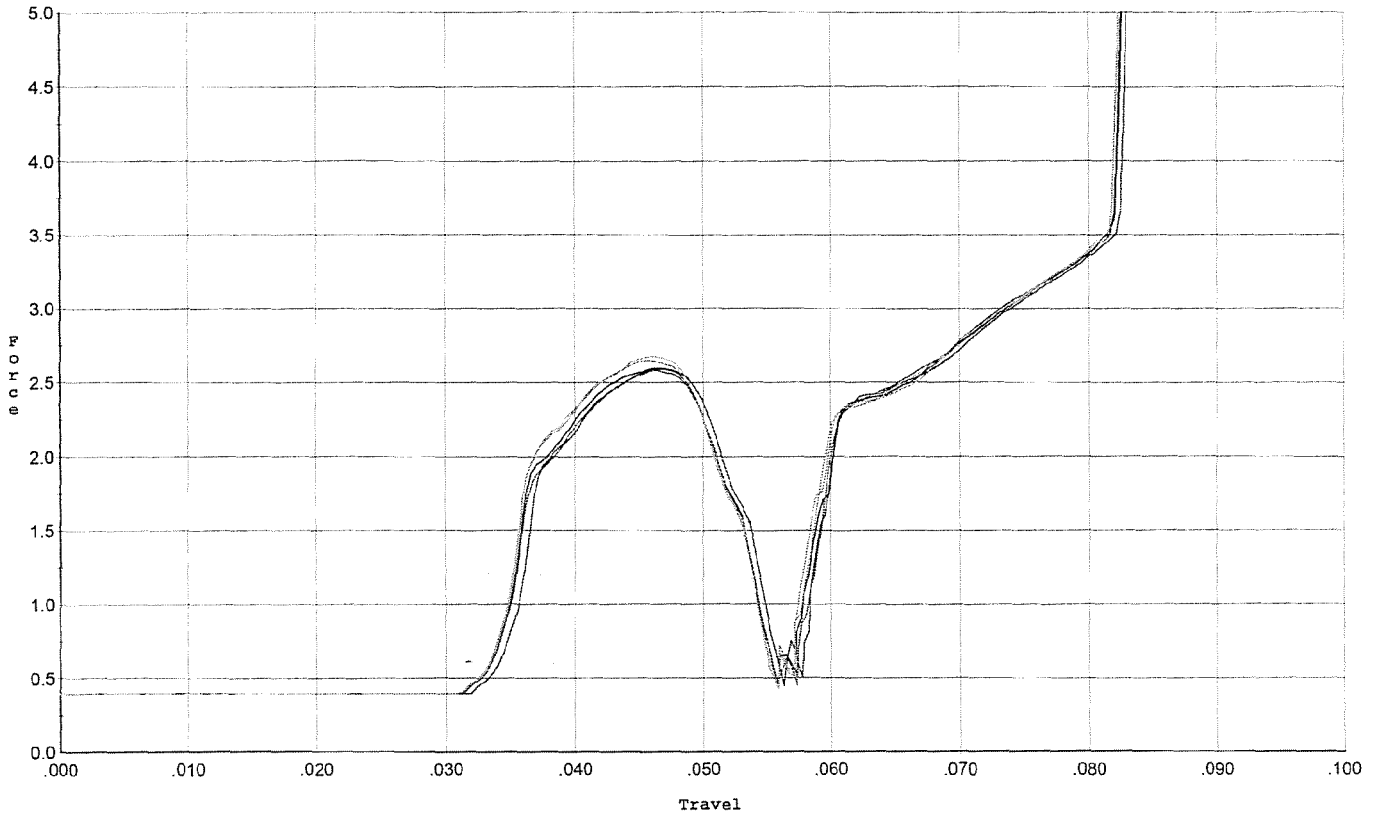
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-28-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	10-28-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-28-08	LJ
	J) ASSEMBLE STOCK		10-28-08	RBW
	K) ASSEMBLE SWIVEL STUDS		10-28-08	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	PASS FAIL PASS FAIL	10-24-08	RBW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-28-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.35</u> <u>2.42</u> <u>2.36</u> <u>2.37</u>	10-28-08	TC
	C) FUNCTION		10-28-08	LJ
690	PACK		11/3/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



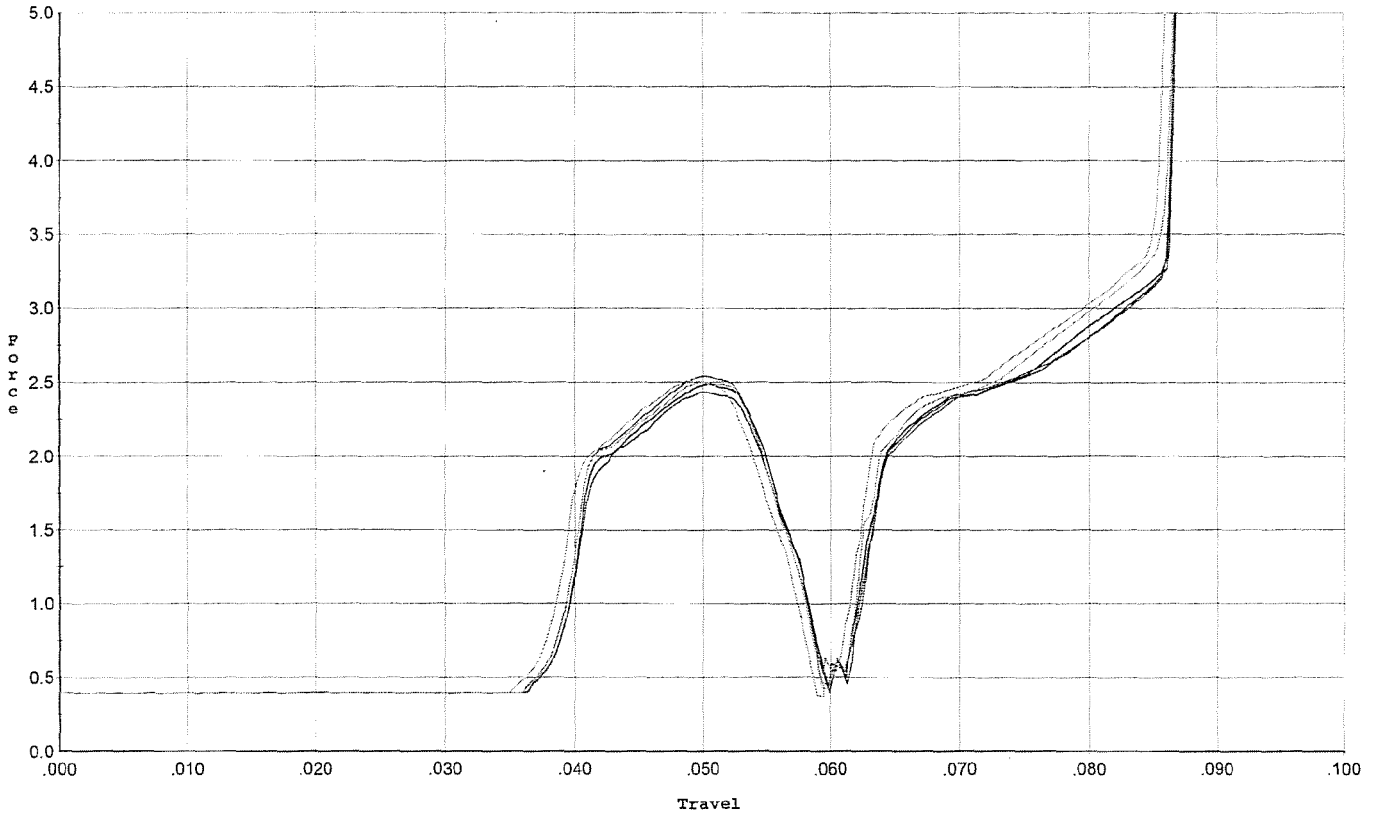
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.591	0.054	0.034	0.035	0.054		Set Trigger
2	2.596	0.053	0.034	0.035	0.055		Set Trigger
3	2.583	0.053	0.034	0.035	0.054		Set Trigger
4	2.676	0.053	0.034	0.035	0.056		Set Trigger
5	2.649	0.053	0.034	0.035	0.056		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



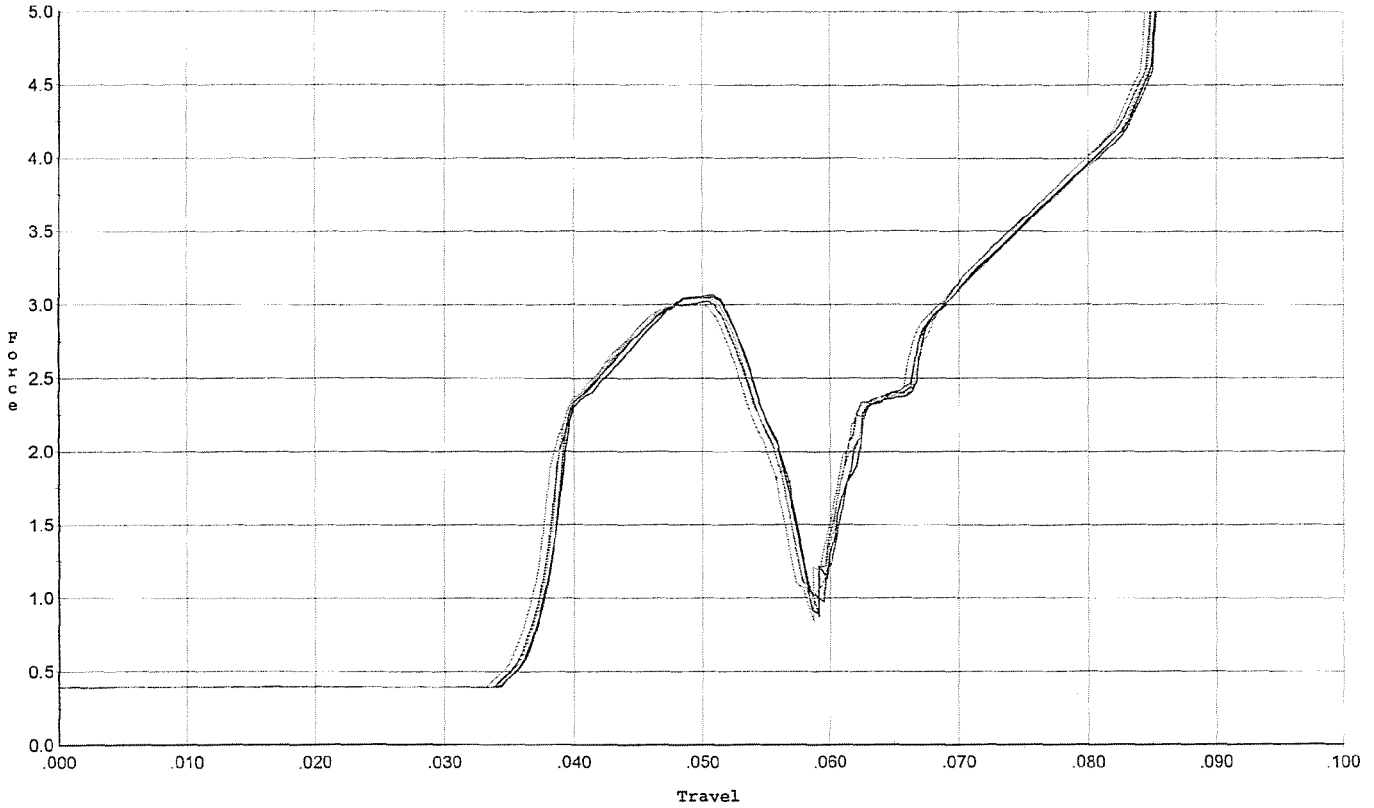
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.435	0.058	0.037	0.036	0.053		Set Trigger
2	2.486	0.058	0.038	0.036	0.054		Set Trigger
3	2.544	0.058	0.038	0.036	0.055		Set Trigger
4	2.503	0.058	0.038	0.036	0.055		Set Trigger
5	2.510	0.058	0.037	0.036	0.055		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



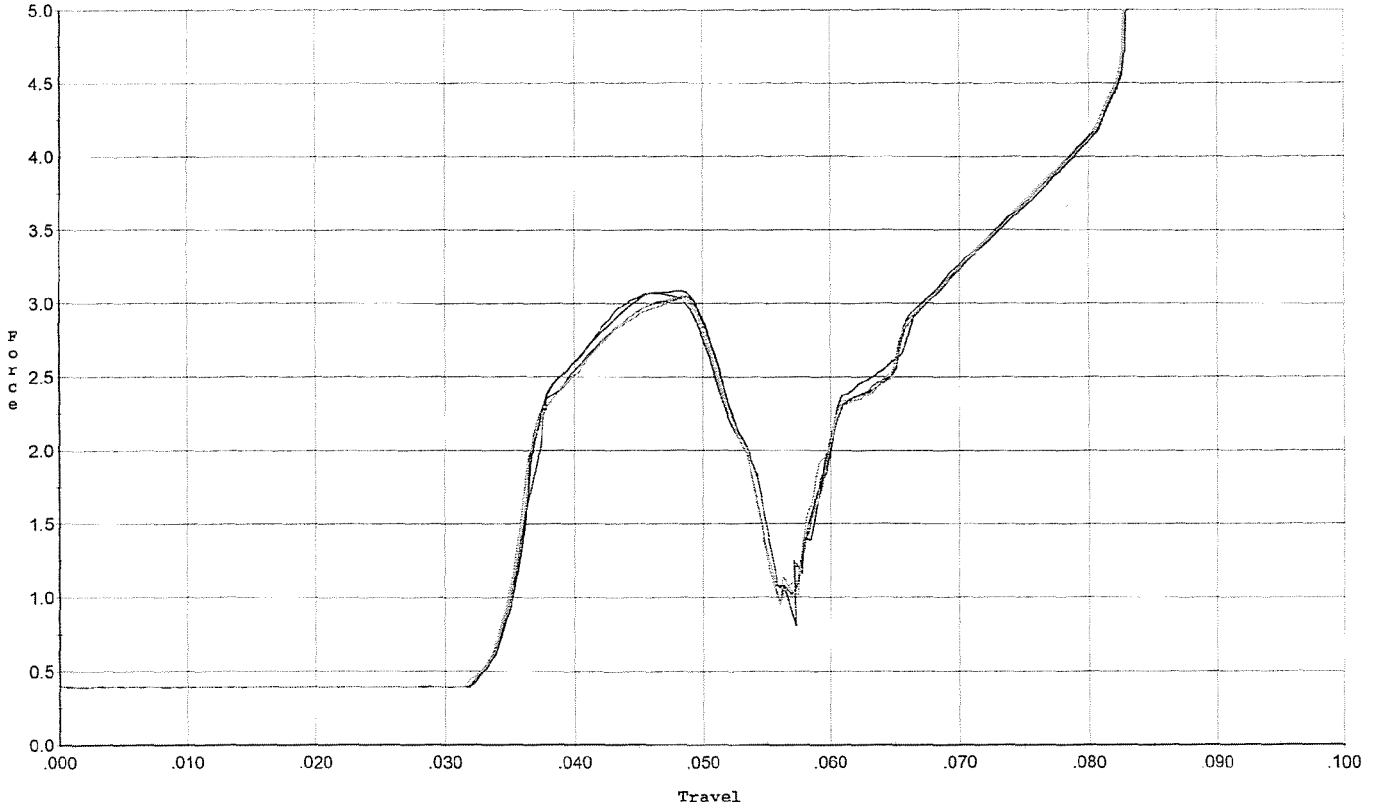
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.057	0.037	0.035	0.064		Set Trigger
2	3.050	0.057	0.036	0.035	0.064		Set Trigger
3	3.020	0.056	0.036	0.035	0.063		Set Trigger
4	3.042	0.056	0.036	0.035	0.064		Set Trigger
5	2.999	0.056	0.035	0.035	0.063		Set Trigger

Aug 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



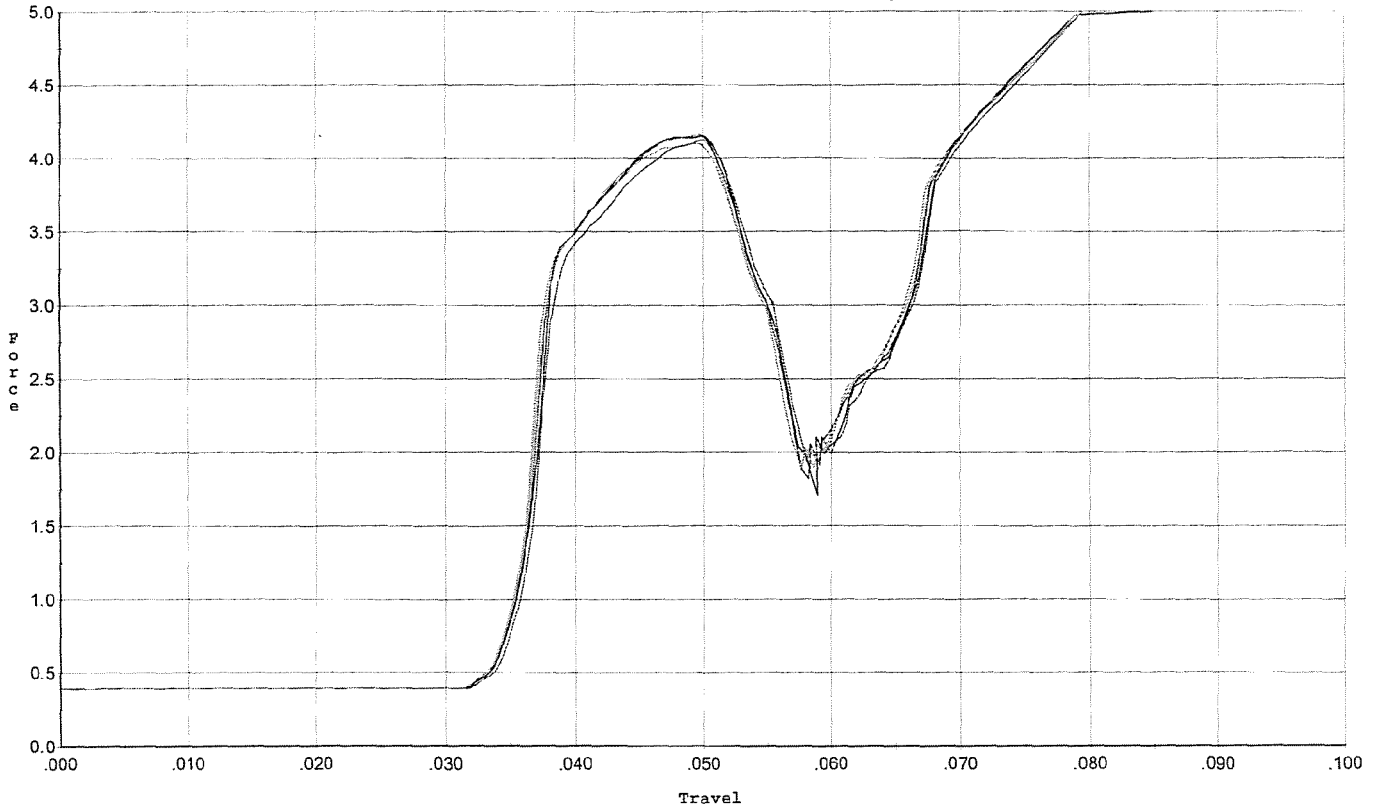
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.069	0.054	0.032	0.035	0.062		Set Trigger
2	3.085	0.054	0.034	0.034	0.064		Set Trigger
3	3.042	0.054	0.034	0.034	0.063		Set Trigger
4	3.047	0.054	0.034	0.035	0.062		Set Trigger
5	3.032	0.054	0.034	0.035	0.062		Set Trigger

Avg 3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



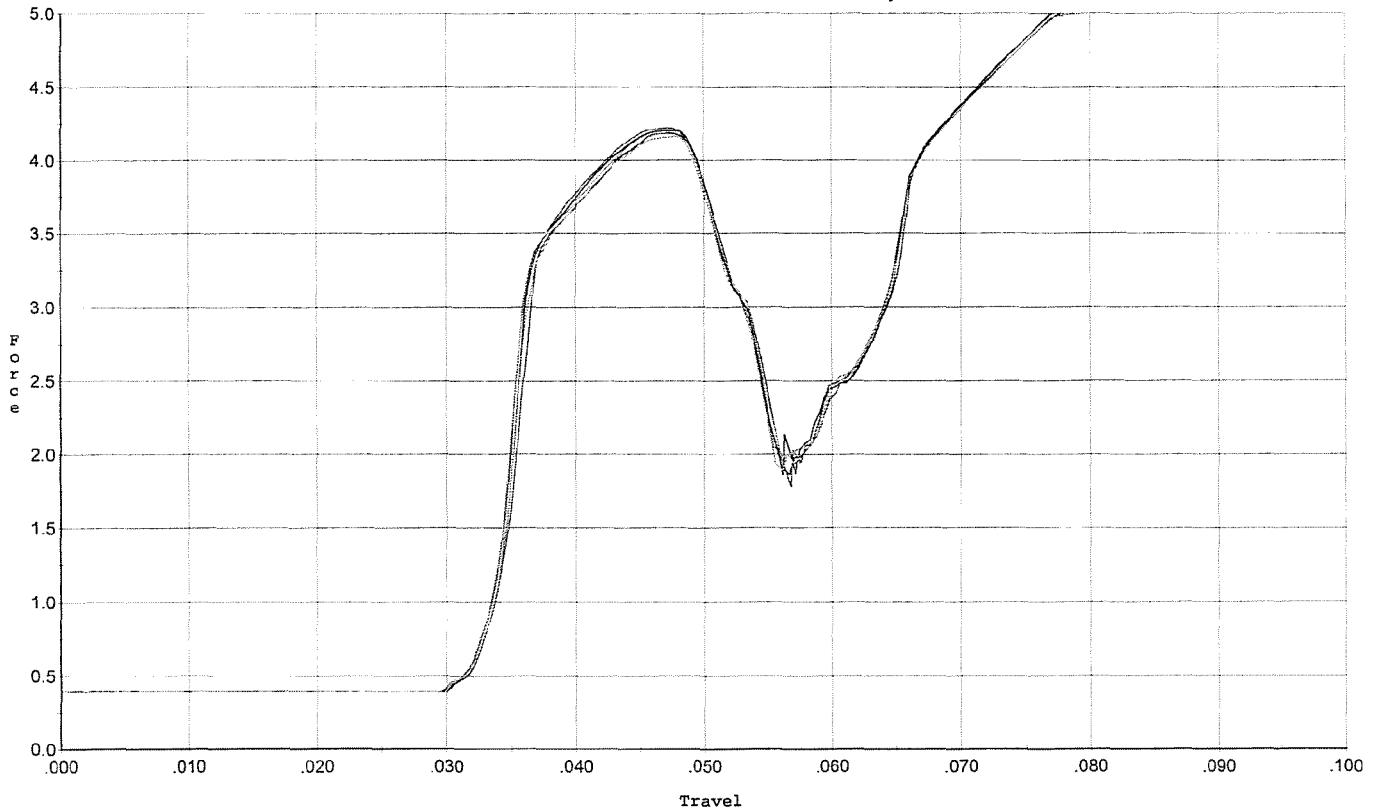
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.163	0.056	0.034	0.032	0.086		Set Trigger
2	4.151	0.056	0.034	0.033	0.086		Set Trigger
3	4.123	0.055	0.035	0.033	0.084		Set Trigger
4	4.161	0.055	0.034	0.033	0.085		Set Trigger
5	4.101	0.055	0.034	0.033	0.084		Set Trigger

Aug 4.14

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



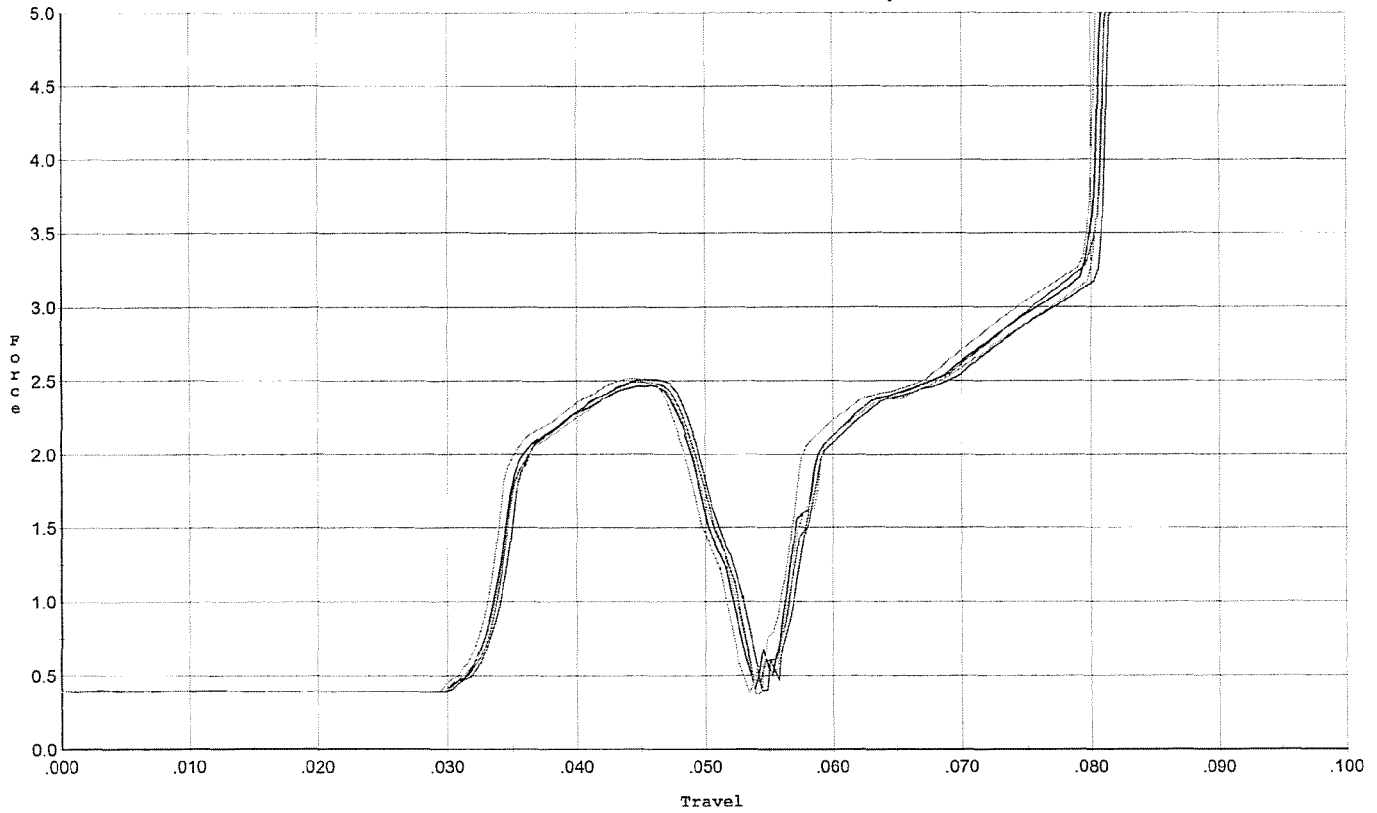
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.191	0.054	0.032	0.032	0.086		Set Trigger
2	4.204	0.053	0.032	0.033	0.085		Set Trigger
3	4.223	0.054	0.032	0.032	0.086		Set Trigger
4	4.162	0.053	0.032	0.032	0.084		Set Trigger
5	4.182	0.054	0.032	0.032	0.085		Set Trigger

Avg 4.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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



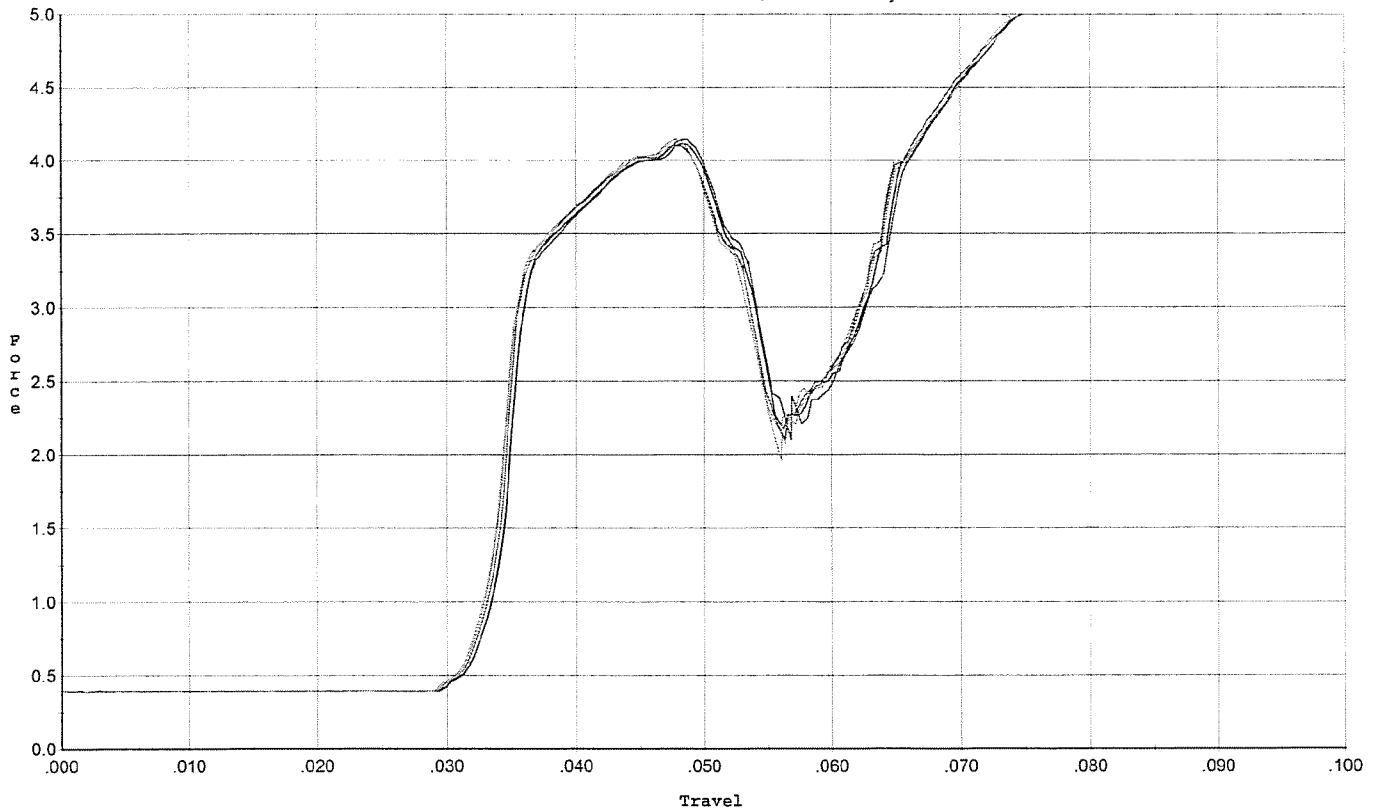
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.509	0.053	0.033	0.035	0.053		Set Trigger
2	2.467	0.052	0.032	0.035	0.051		Set Trigger
3	2.491	0.052	0.033	0.035	0.052		Set Trigger
4	2.489	0.053	0.032	0.035	0.052		Set Trigger
5	2.515	0.051	0.032	0.034	0.052		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/14/08

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	4.143	0.053	0.032	0.032	0.086		Set Trigger
2	4.115	0.054	0.032	0.031	0.086		Set Trigger
3	4.108	0.053	0.032	0.032	0.085		Set Trigger
4	4.139	0.053	0.032	0.032	0.085		Set Trigger
5	4.148	0.054	0.032	0.031	0.086		Set Trigger

Aug 4.13