

G6784564

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



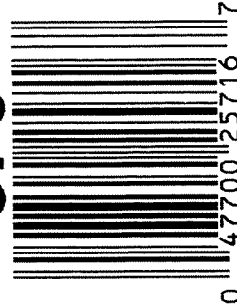
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6784564

UPC



GUNS

GUN SERIAL # G6784564

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	MAGNA-FLUX ULI 02 2008 OPERATOR <u>(KB)</u>	9-29-08	SPD
472	SERIALIZE BOLT HANDLE		9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES		10/1/08	Fm
480	MAGNAFLUX BBL ACTION		10/2/08	(KB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/00	RT
520	GOFF BLAST BBL / REC		10/3/08	PG
542	APPLY COATINGS (BARREL ACTION)		10 9	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-31-08	P8u
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.60 LBS +/- .5 LBS			

F004 REV 5/2006

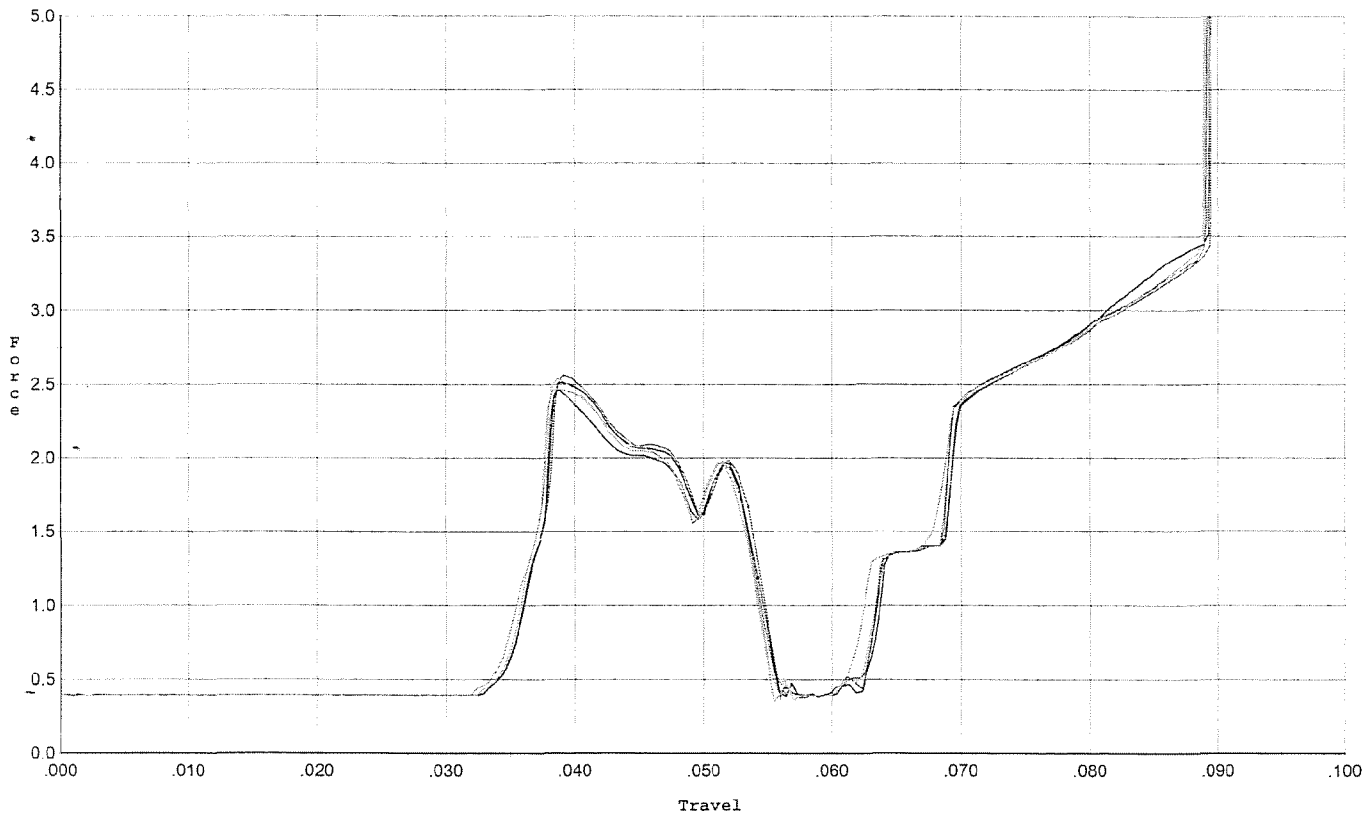
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-6-08	L.P.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-6-08	L.P.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-6-08	L.P.
	J) ASSEMBLE STOCK		10-31-08	ESR
	K) ASSEMBLE SWIVEL STUDS		11-6-08	L.P.
	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	11-3-08	L.P.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-6-08	L.P.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.14</u> <u>2.23</u> <u>2.13</u> <u>2.11</u> <u>2.11</u>	11-5-08	Fm
	C) FUNCTION		11-6-08	L.P.
690	PACK		11/5/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



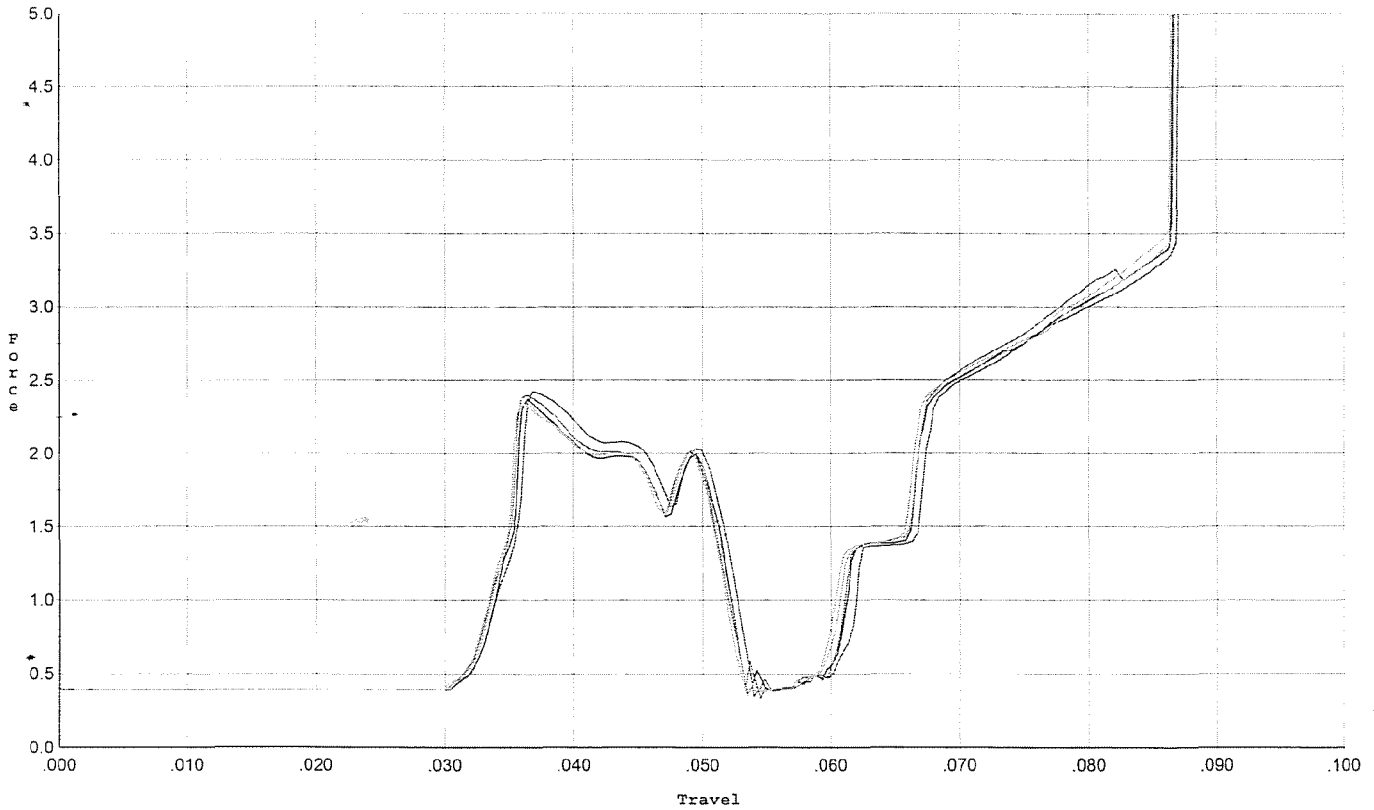
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.464	0.053	0.035	0.039	0.048		Set Trigger
2	2.512	0.054	0.035	0.039	0.050		Set Trigger
3	2.565	0.053	0.035	0.039	0.050		Set Trigger
4	2.539	0.053	0.034	0.039	0.049		Set Trigger
5	2.469	0.053	0.034	0.039	0.050		Set Trigger

Aug 2.51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



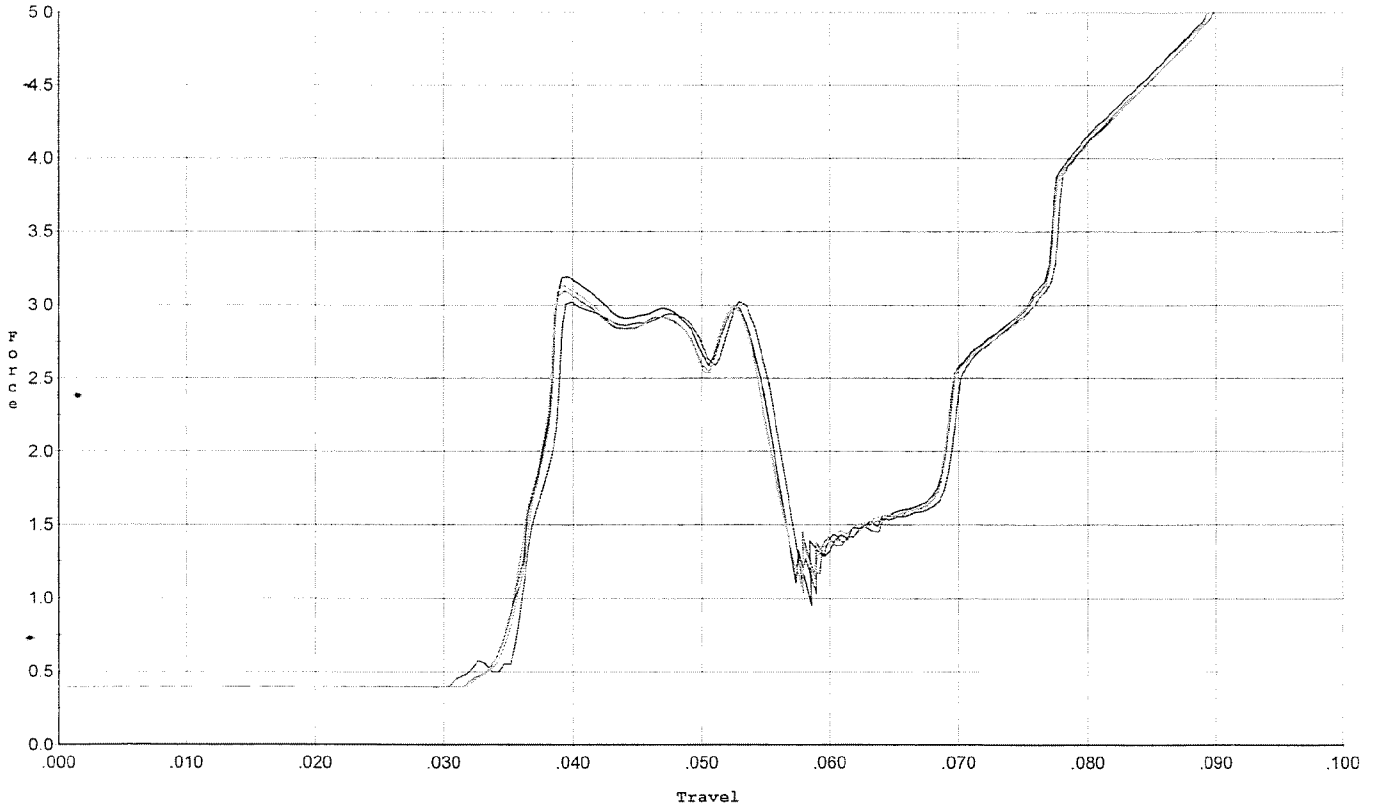
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.420	0.052	0.033	0.039	0.049		Set Trigger
2	2.370	0.051	0.033	0.039	0.047		Set Trigger
3	2.396	0.050	0.032	0.040	0.047		Set Trigger
4	2.347	0.050	0.032	0.040	0.047		Set Trigger
5	2.343	0.052	0.033	0.040	0.048		Set Trigger

AUG 2.37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



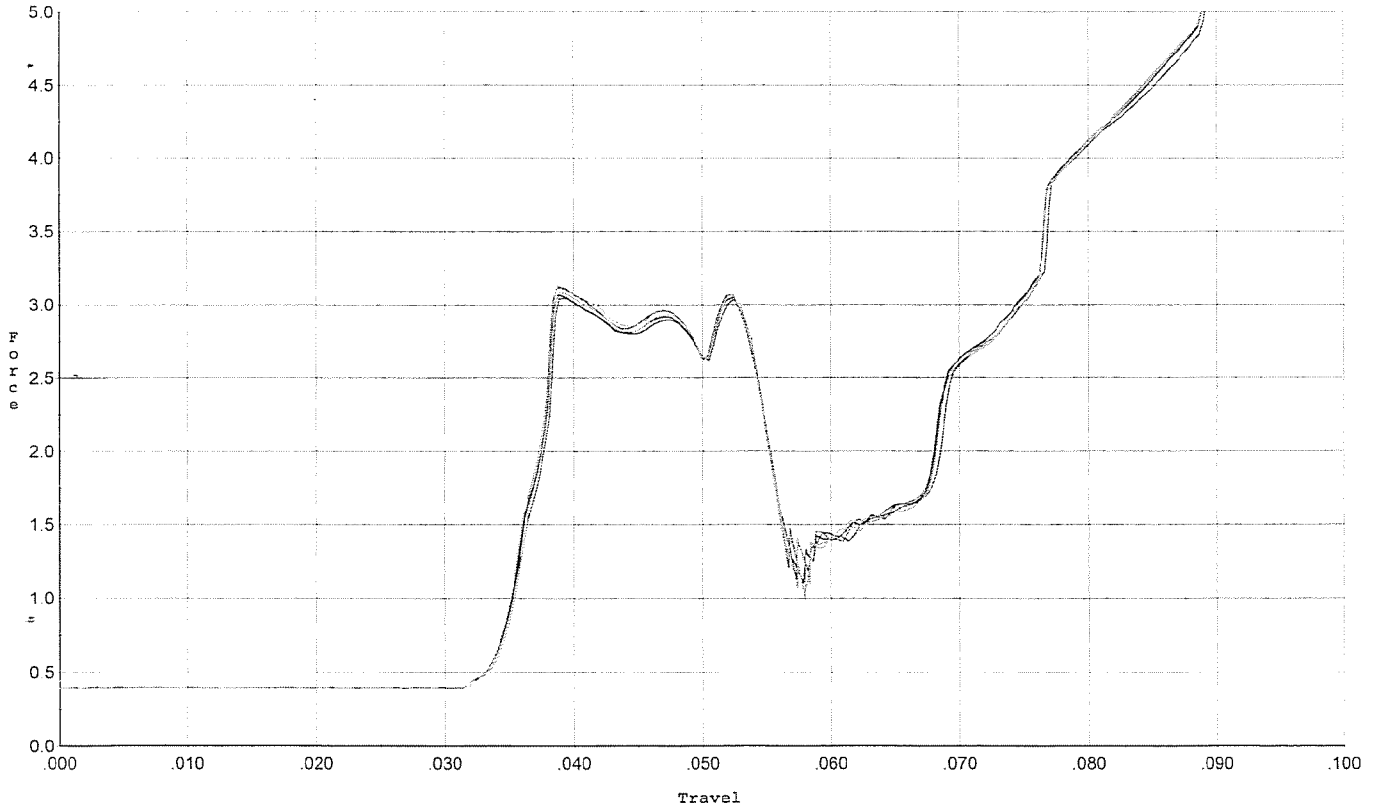
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.025	0.055	0.035	0.038	0.067		Set Trigger
2	3.194	0.055	0.034	0.038	0.068		Set Trigger
3	3.099	0.054	0.034	0.038	0.065		Set Trigger
4	3.103	0.054	0.035	0.038	0.065		Set Trigger
5	3.136	0.054	0.034	0.038	0.066		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



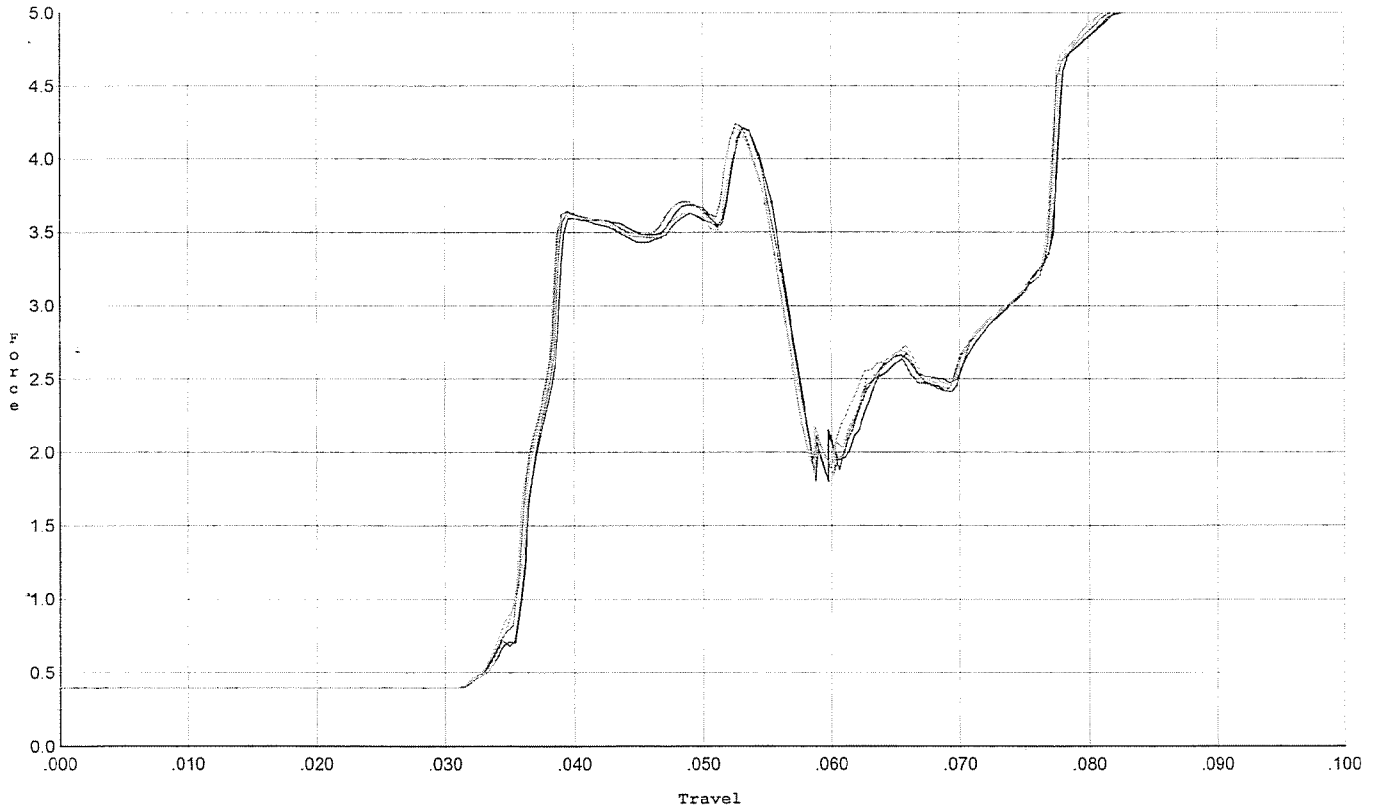
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.047	0.054	0.034	0.038	0.066		Set Trigger
2	3.069	0.054	0.034	0.037	0.066		Set Trigger
3	3.121	0.054	0.034	0.037	0.067		Set Trigger
4	3.082	0.054	0.034	0.037	0.066		Set Trigger
5	3.131	0.054	0.034	0.037	0.067		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



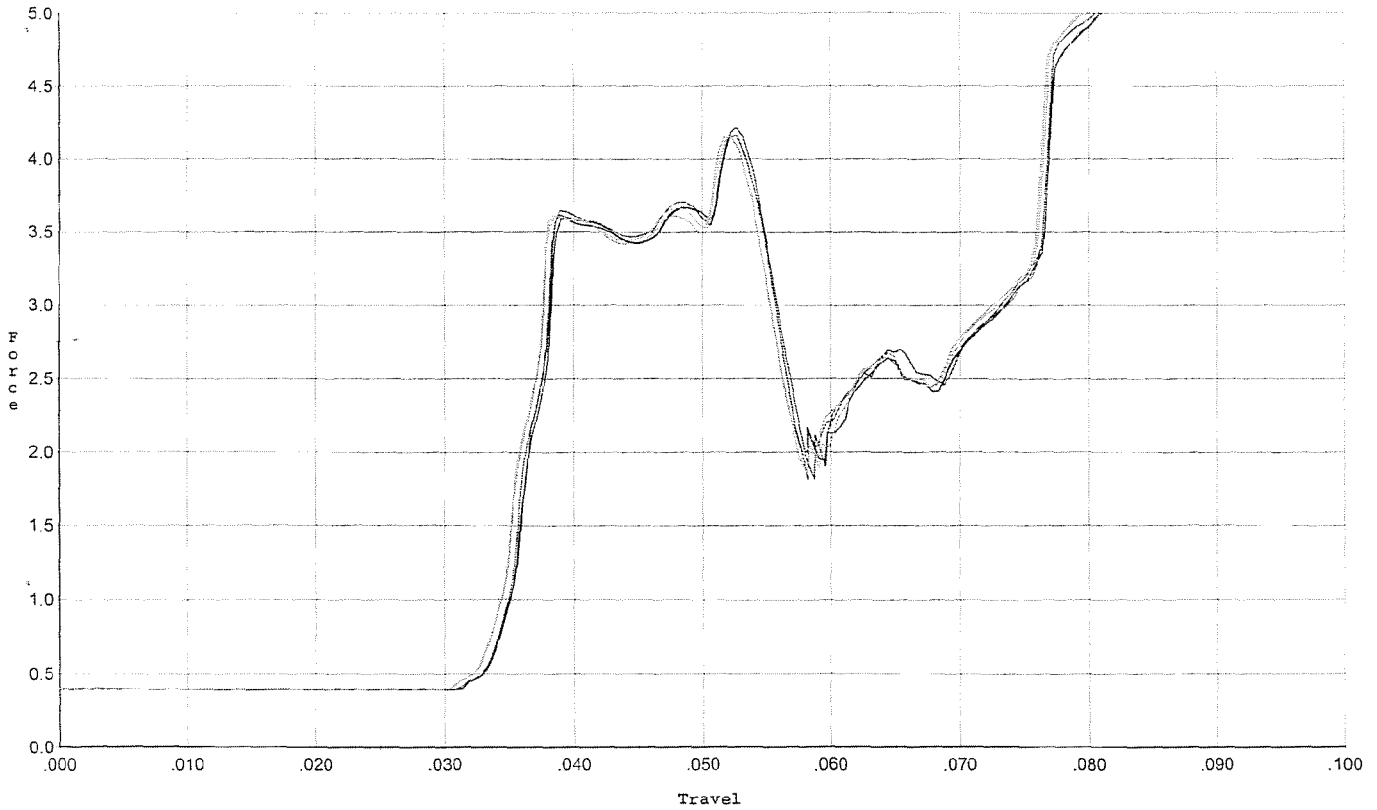
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.211	0.056	0.034	0.036	0.085		Set Trigger
2	4.215	0.055	0.034	0.036	0.084		Set Trigger
3	4.242	0.055	0.034	0.036	0.084		Set Trigger
4	4.208	0.055	0.034	0.036	0.085		Set Trigger
5	4.154	0.055	0.034	0.036	0.083		Set Trigger

Aug 4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



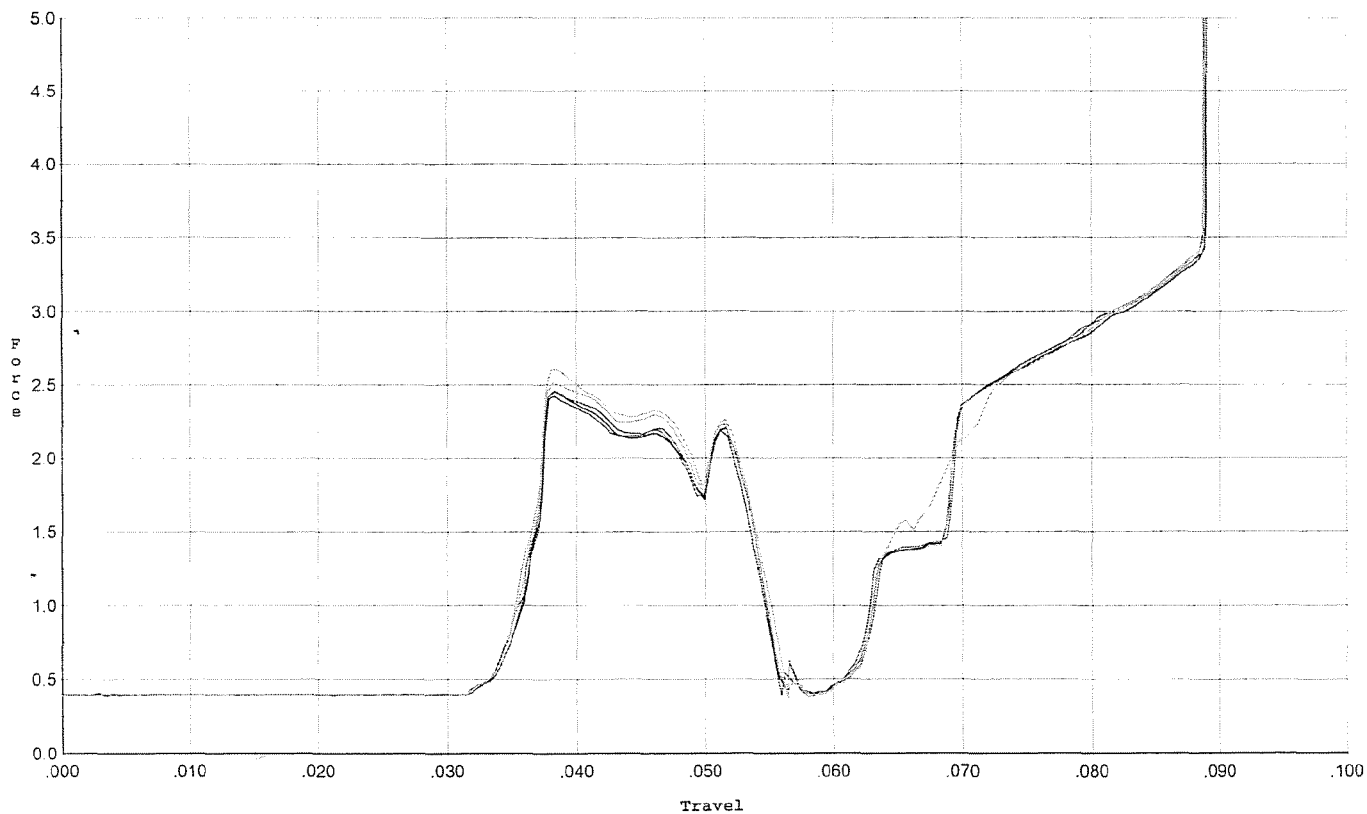
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.217	0.054	0.034	0.036	0.082		Set Trigger
2	4.164	0.054	0.034	0.036	0.082		Set Trigger
3	4.163	0.054	0.034	0.036	0.083		Set Trigger
4	4.157	0.054	0.033	0.036	0.082		Set Trigger
5	4.162	0.054	0.033	0.036	0.082		Set Trigger

Aug 4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



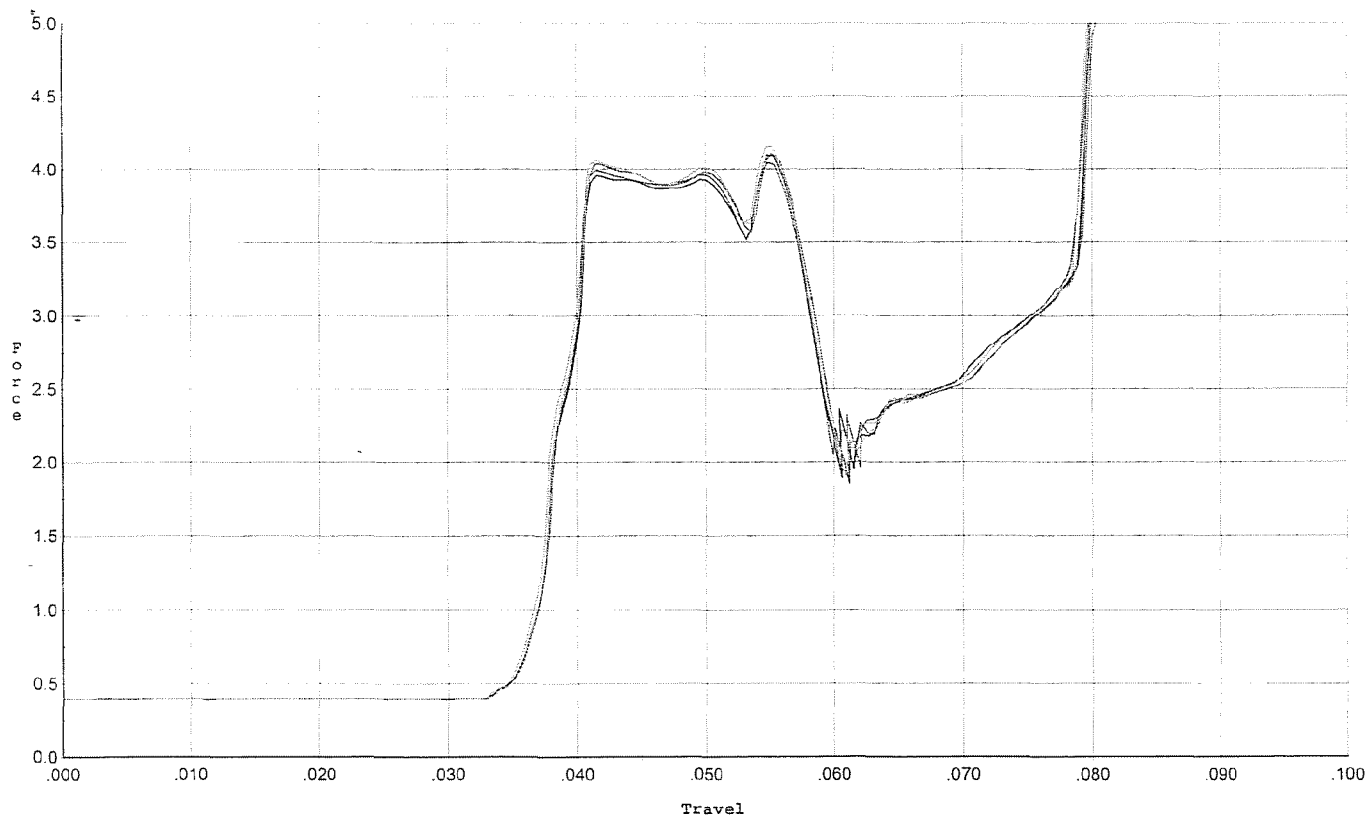
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.424	0.054	0.034	0.039	0.052		Set Trigger
2	2.461	0.053	0.034	0.039	0.052		Set Trigger
3	2.458	0.053	0.034	0.039	0.052		Set Trigger
4	2.516	0.053	0.034	0.039	0.053		Set Trigger
5	2.605	0.055	0.034	0.038	0.056		Set Trigger

Aug 2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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	4.046	0.057	0.036	0.029	0.090		Set Trigger
2	4.092	0.057	0.036	0.029	0.089		Set Trigger
3	4.112	0.058	0.036	0.029	0.093		Set Trigger
4	4.112	0.057	0.036	0.029	0.090		Set Trigger
5	4.158	0.057	0.035	0.029	0.091		Set Trigger

Aug 4.10