

G678 4714

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



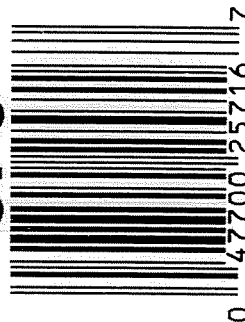
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6784714

UPC



GUN SERIAL #

G 6784714

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-9-08	SP
430	ASSEMBLE TO STOCK		9-9-08	SP
440	PROOF		9-9-08	SP
460	CHECK HEADSPACE		9-9-08	SP
470	DIS-ASSEMBLE ACTION		9-9-08	SP
472	SERIALIZE BOLT HANDLE		9-10-08	RT
475	DRILL AND TAP SIGHT HOLES		9-11-08	SP
480	MAGNAFLUX BBL ACTION		9-12-08	BN
490	MAGNAFLUX BOLT		9-12-08	MS
500	ROLLMARK CALIBER		9-12-08	RT
520	GOFF BLAST BBL / REC		9-13-08	DS
542	APPLY COATINGS (BARREL ACTION)		9/16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-13-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
	2.50 LBS +/- .5 LBS			

F004 REV 5/2006

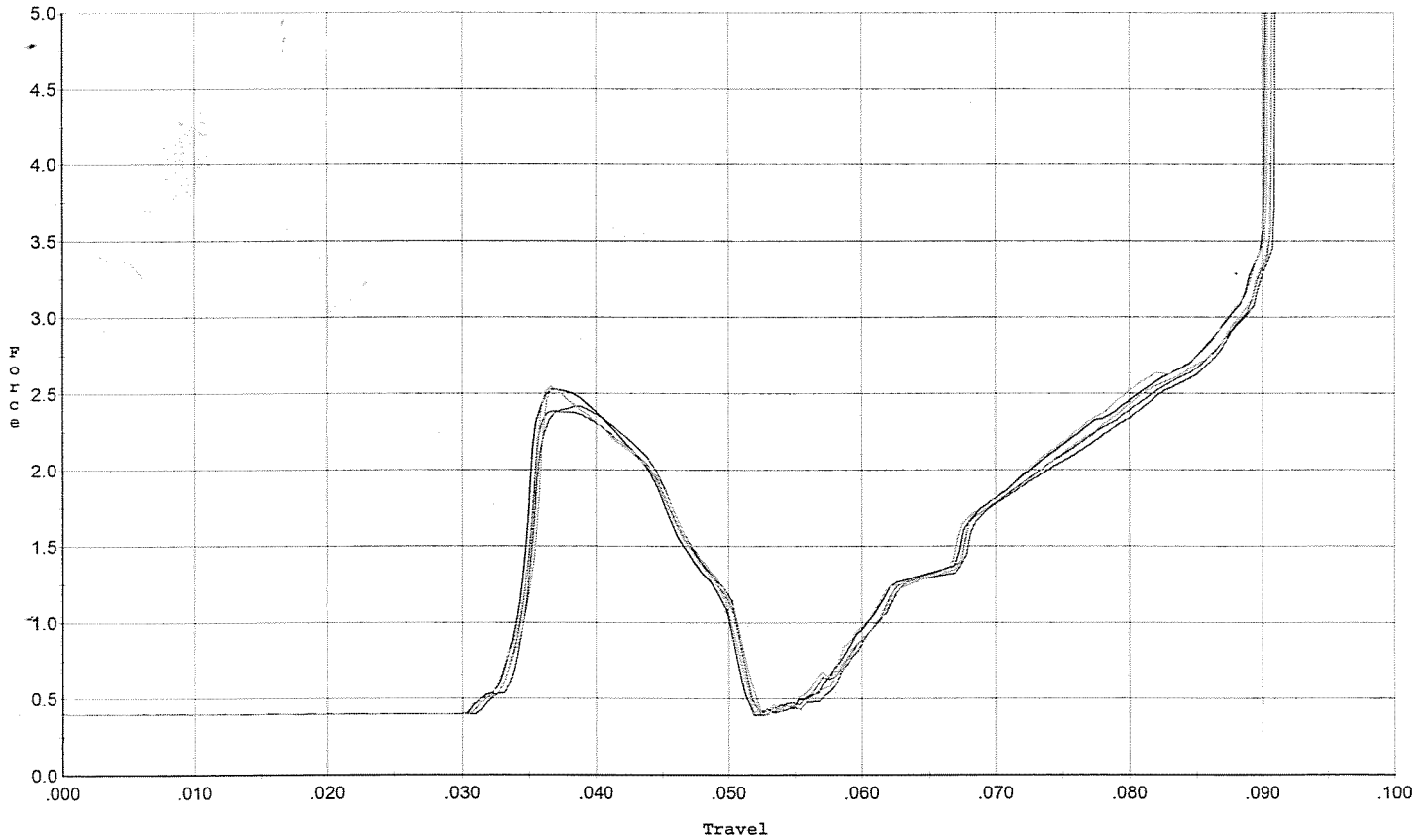
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>2.5</u>	<u>2.5</u>	<u>3.0</u>	11-18-08	LJH		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	11-18-08	LJH		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.022</u>	<u>.022</u>	11-18-08	LJH		
	J) ASSEMBLE STOCK					11-13-08	Rgn		
	K) ASSEMBLE SWIVEL STUDS					11-18-08	LJH		
	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		11-14-08	TL		
			<u>PASS</u>	FAIL					
	MALFUNCTION		MA						
		CORRECTION							
	MALFUNCTION								
		CORRECTION							
	MALFUNCTION		MA						
		CORRECTION							
660	INSPECT FOR LIVE AMMO					11-14-08	LJH		
670	FINAL INSPECTION A) HEADSPACE					11-18-08	LJH		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u>	<u>2.41</u>	<u>2.47</u>	<u>2.49</u>	<u>2.47</u>	11-14-08	TL
	C) FUNCTION							11-18-08	LJH
690	PACK							3/17/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/6/08

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



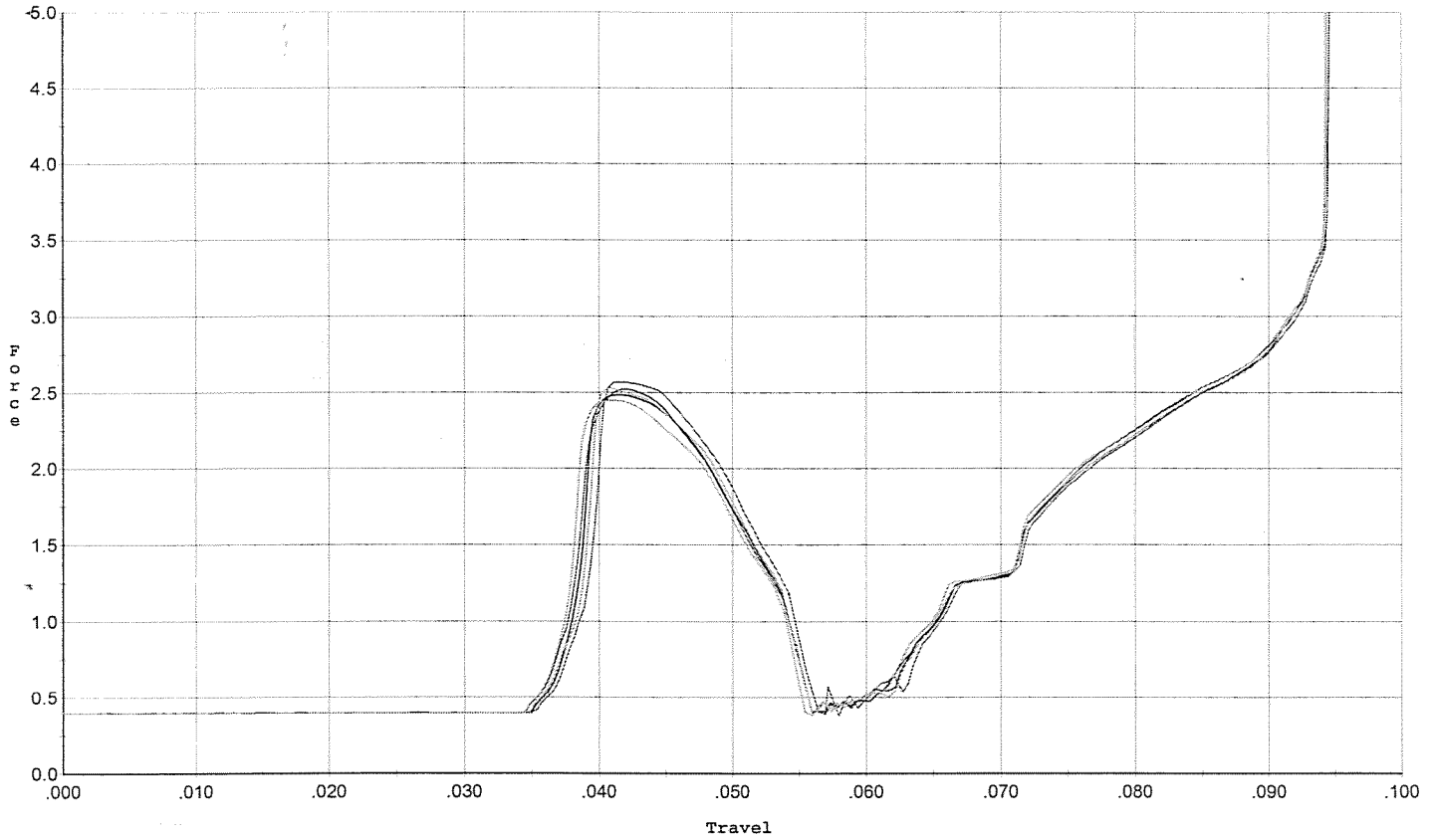
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.417	0.050	0.034	0.046	0.045		Set Trigger
2	2.526	0.050	0.031	0.046	0.045		Set Trigger
3	2.388	0.050	0.033	0.046	0.045		Set Trigger
4	2.547	0.051	0.033	0.045	0.045		Set Trigger
5	2.534	0.050	0.033	0.045	0.045		Set Trigger

Avg 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



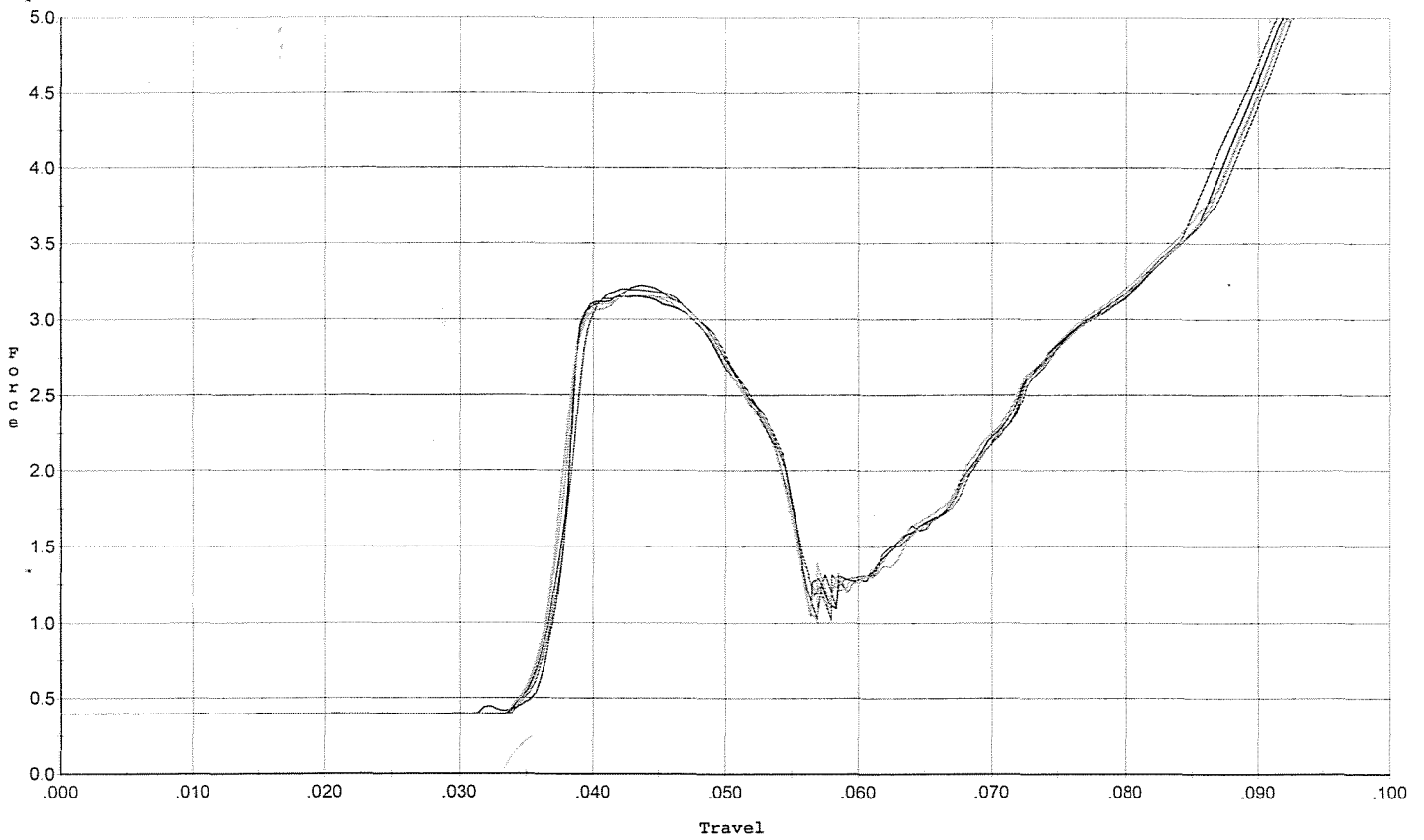
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.523	0.055	0.036	0.044	0.049		Set Trigger
2	2.482	0.055	0.035	0.044	0.048		Set Trigger
3	2.569	0.054	0.036	0.044	0.048		Set Trigger
4	2.531	0.055	0.035	0.044	0.048		Set Trigger
5	2.450	0.054	0.036	0.045	0.048		Set Trigger

Avg 2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



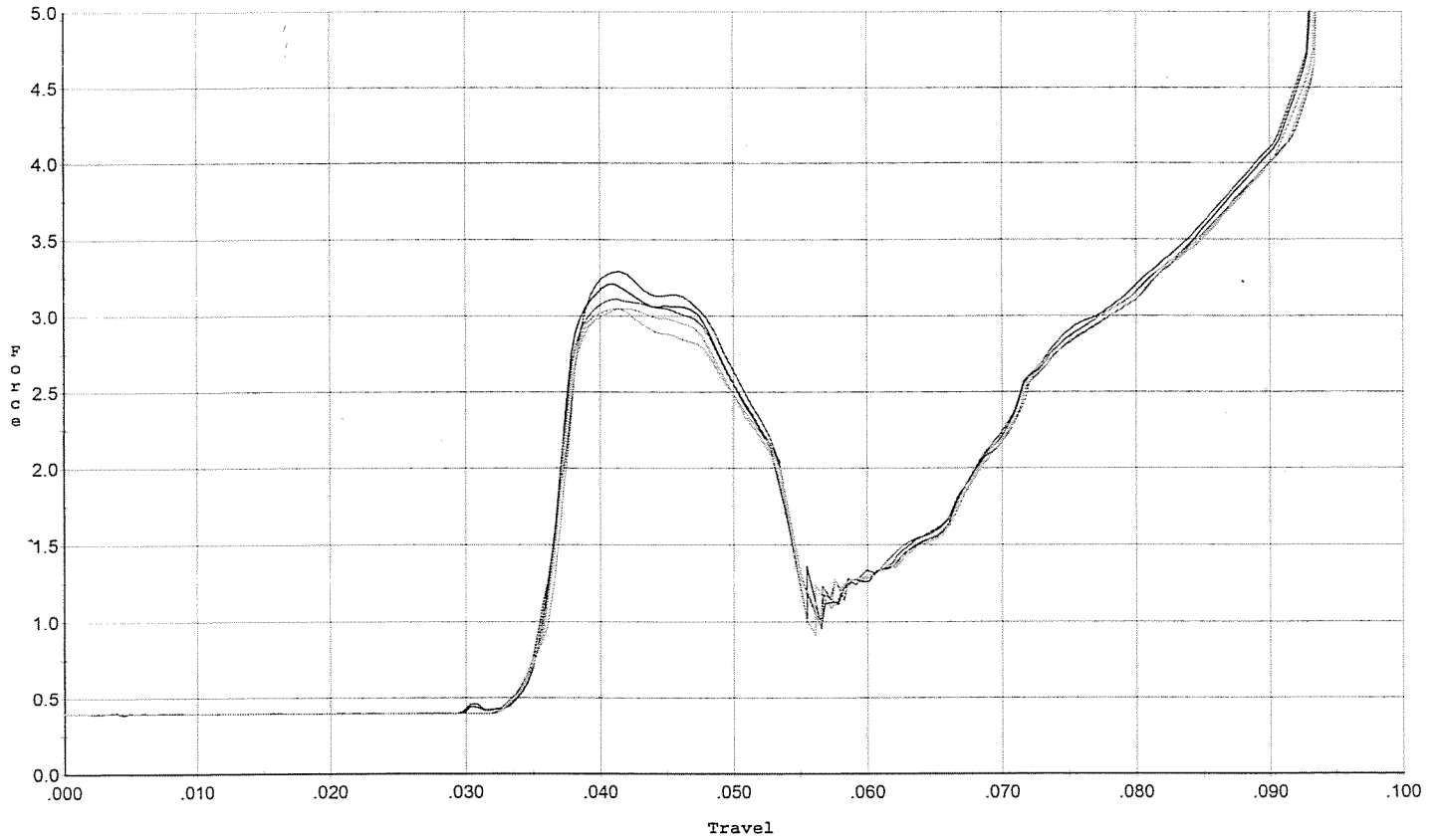
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.226	0.054	0.036	0.041	0.064		Set Trigger
2	3.152	0.055	0.036	0.041	0.064		Set Trigger
3	3.195	0.054	0.036	0.041	0.063		Set Trigger
4	3.155	0.055	0.035	0.041	0.064		Set Trigger
5	3.158	0.055	0.035	0.041	0.065		Set Trigger

Avg 3.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



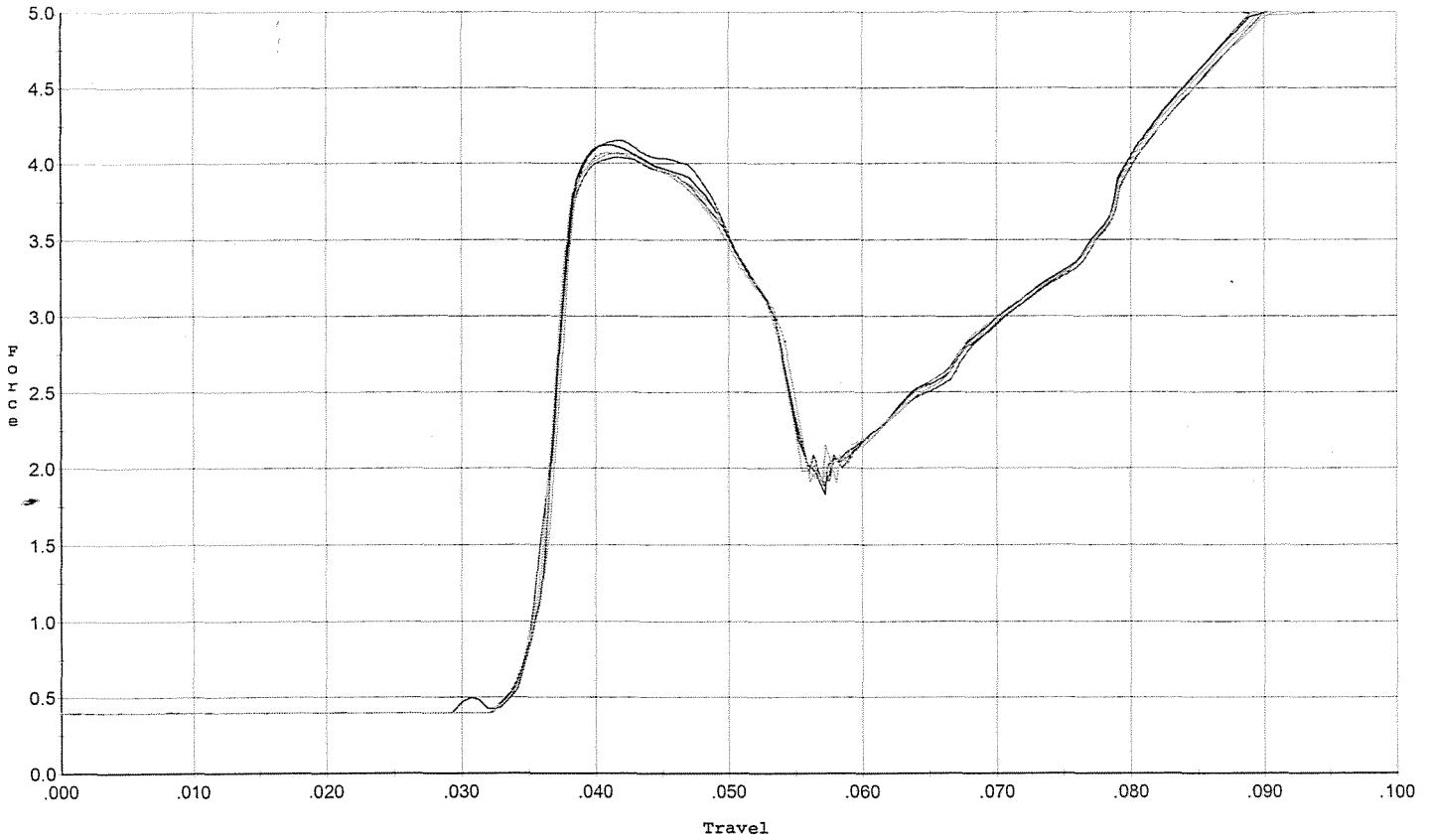
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.292	0.053	0.035	0.041	0.064		Set Trigger
2	3.208	0.054	0.035	0.041	0.064		Set Trigger
3	3.113	0.053	0.034	0.042	0.063		Set Trigger
4	3.046	0.054	0.035	0.042	0.062		Set Trigger
5	3.050	0.053	0.035	0.042	0.061		Set Trigger

AVG 3.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



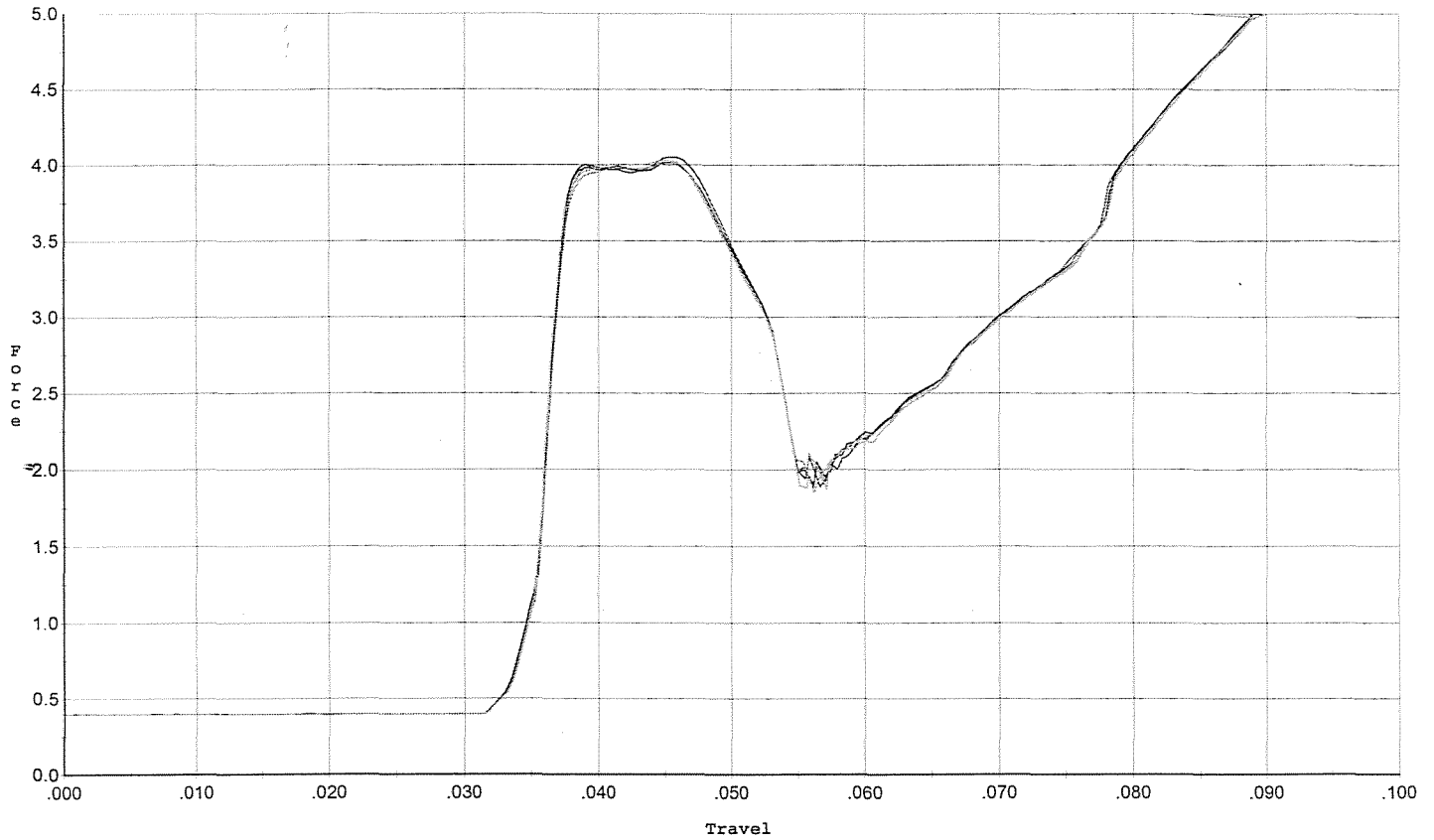
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.151	0.053	0.035	0.038	0.081		Set Trigger
2	4.120	0.053	0.034	0.038	0.080		Set Trigger
3	4.039	0.053	0.034	0.038	0.079		Set Trigger
4	4.064	0.054	0.034	0.038	0.080		Set Trigger
5	4.070	0.054	0.034	0.038	0.081		Set Trigger

Arg 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



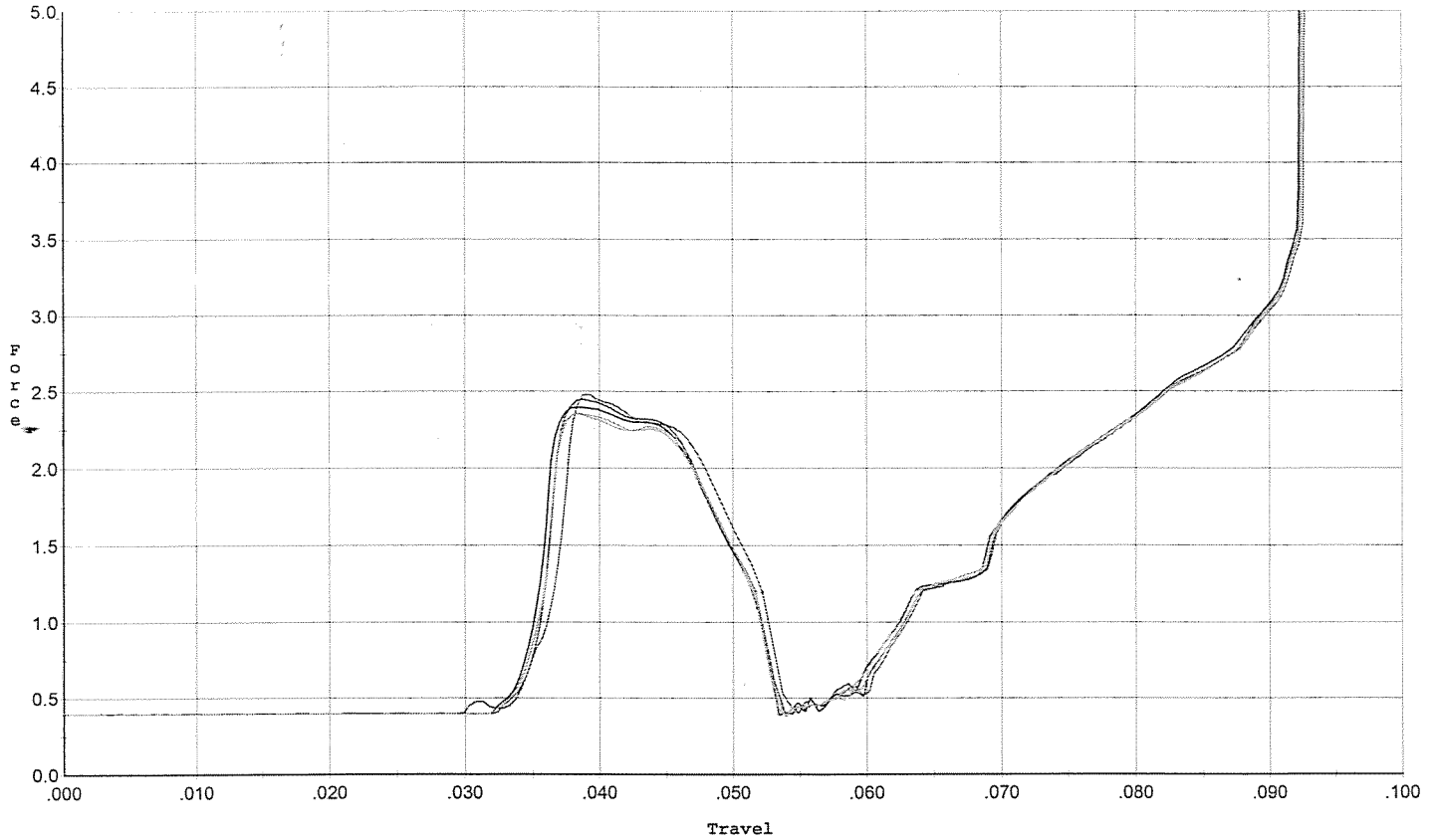
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.051	0.053	0.033	0.038	0.080		Set Trigger
2	4.015	0.053	0.033	0.038	0.080		Set Trigger
3	4.018	0.053	0.034	0.038	0.080		Set Trigger
4	4.033	0.053	0.034	0.038	0.080		Set Trigger
5	4.012	0.053	0.034	0.038	0.079		Set Trigger

Avg 4.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/6/08

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



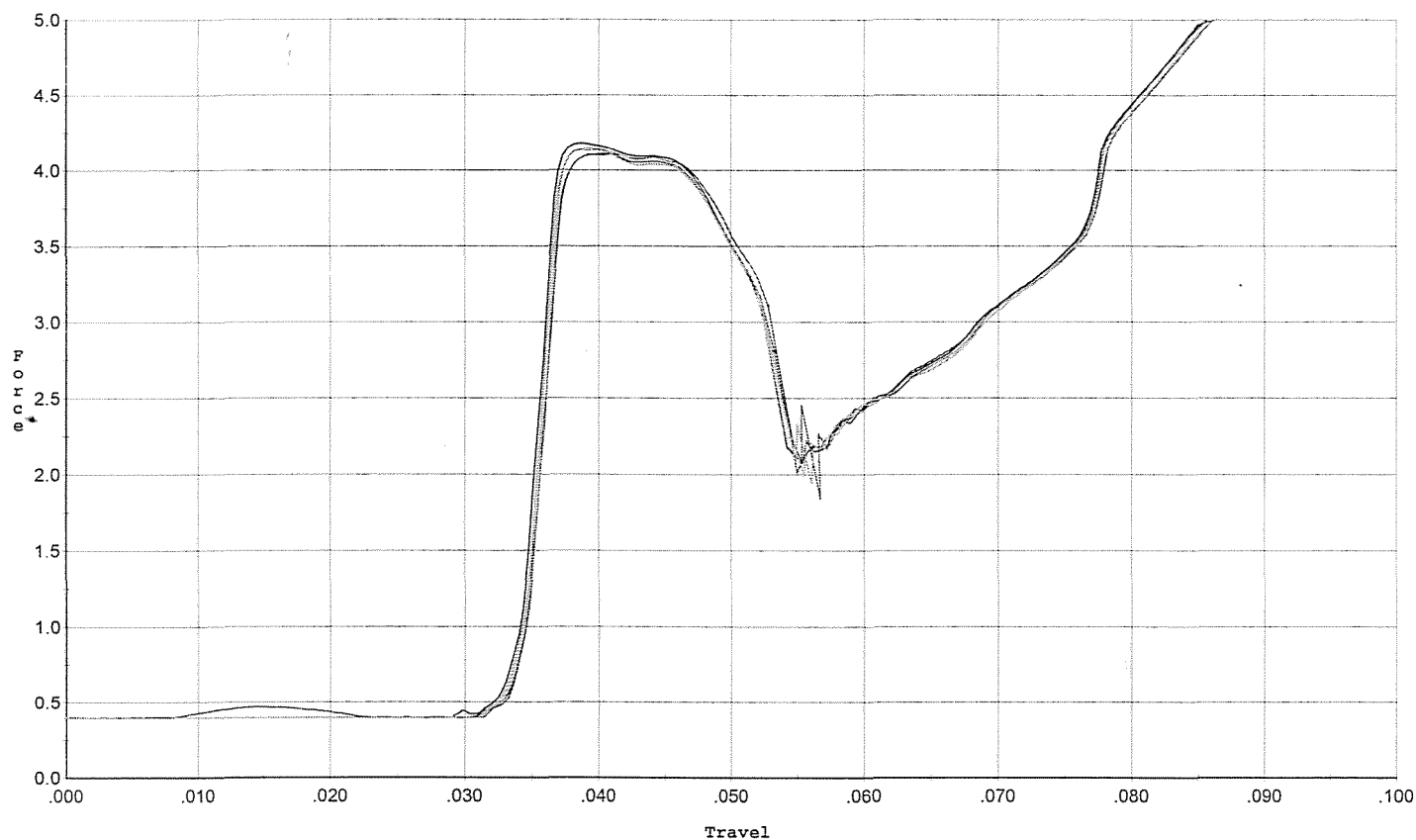
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.447	0.052	0.034	0.045	0.048		Set Trigger
2	2.397	0.052	0.034	0.045	0.048		Set Trigger
3	2.480	0.052	0.034	0.045	0.048		Set Trigger
4	2.351	0.052	0.034	0.045	0.047		Set Trigger
5	2.358	0.052	0.034	0.045	0.047		Set Trigger

Aug 2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/6/08

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	4.104	0.053	0.034	0.038	0.082		Set Trigger
2	4.181	0.052	0.033	0.038	0.082		Set Trigger
3	4.109	0.053	0.034	0.038	0.083		Set Trigger
4	4.149	0.052	0.033	0.038	0.081		Set Trigger
5	4.135	0.052	0.033	0.038	0.080		Set Trigger

Avg 4.13