

66794517

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



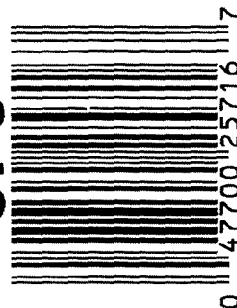
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794517

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794517

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SP
430	ASSEMBLE TO STOCK		11-3-08	SP
440	PROOF		11-3-08	SP
460	CHECK HEADSPACE		11-3-08	SP
470	DIS-ASSEMBLE ACTION		11-3-08	SP
472	SERIALIZE BOLT HANDLE		11-4-08	RT
475	DRILL AND TAP SIGHT HOLES		11-4-08	SP
480	MAGNAFLUX BBL ACTION		11/6/08	SP
490	MAGNAFLUX BOLT		11/3/08	RT
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	SP
542	APPLY COATINGS (BARREL ACTION)		11/15	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-19-08	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			

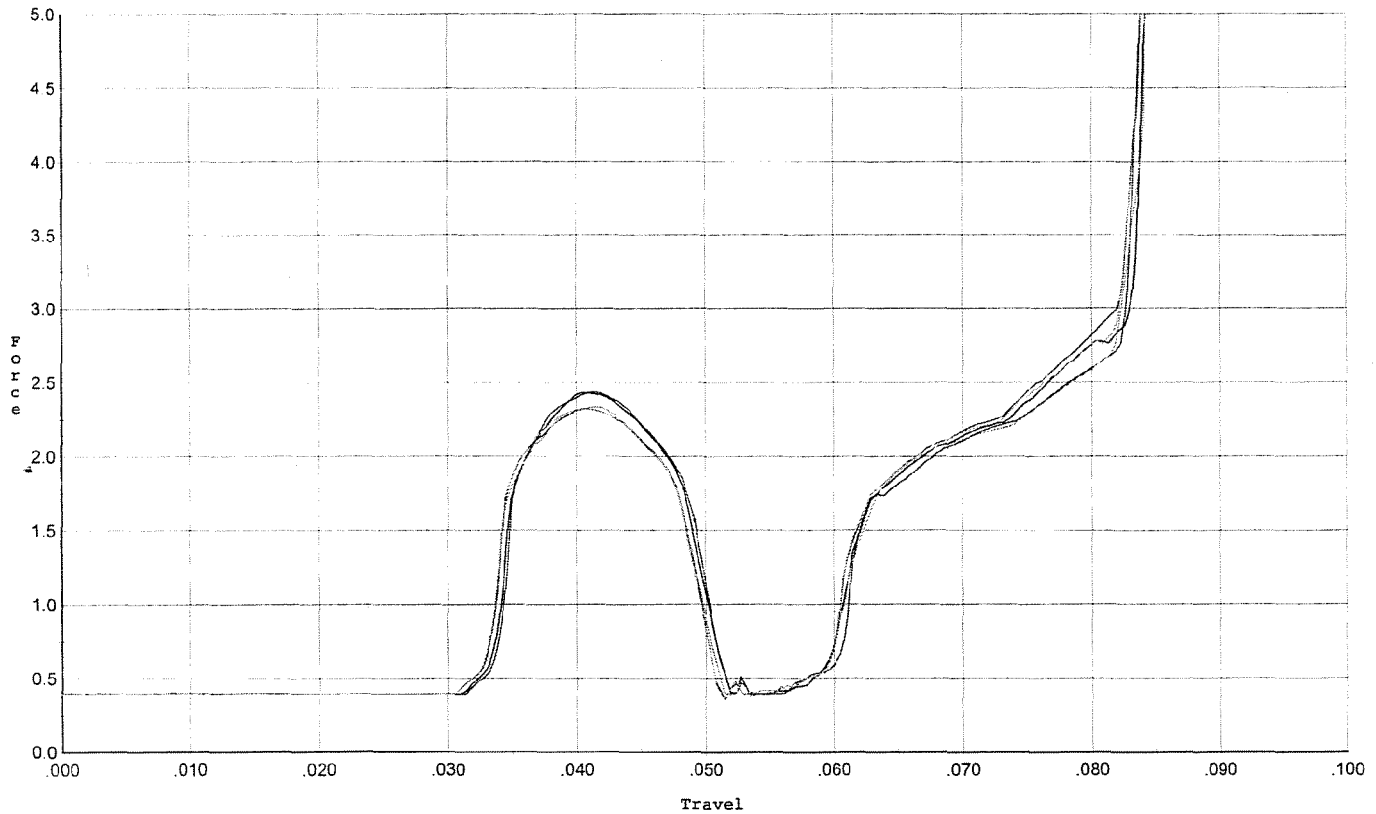
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>3.5</u>	11-20-08	LP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	11-20-08	LP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-20-08	LP
	J) ASSEMBLE STOCK		11-19-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-20-08	LP
	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	11-19-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	LP
670	FINAL INSPECTION A) HEADSPACE		11-20-08	LP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.49</u> <u>2.44</u> <u>2.46</u> <u>2.46</u>	11-20-08	TL
	C) FUNCTION		11-20-08	LP
690	PACK		12-2-08	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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



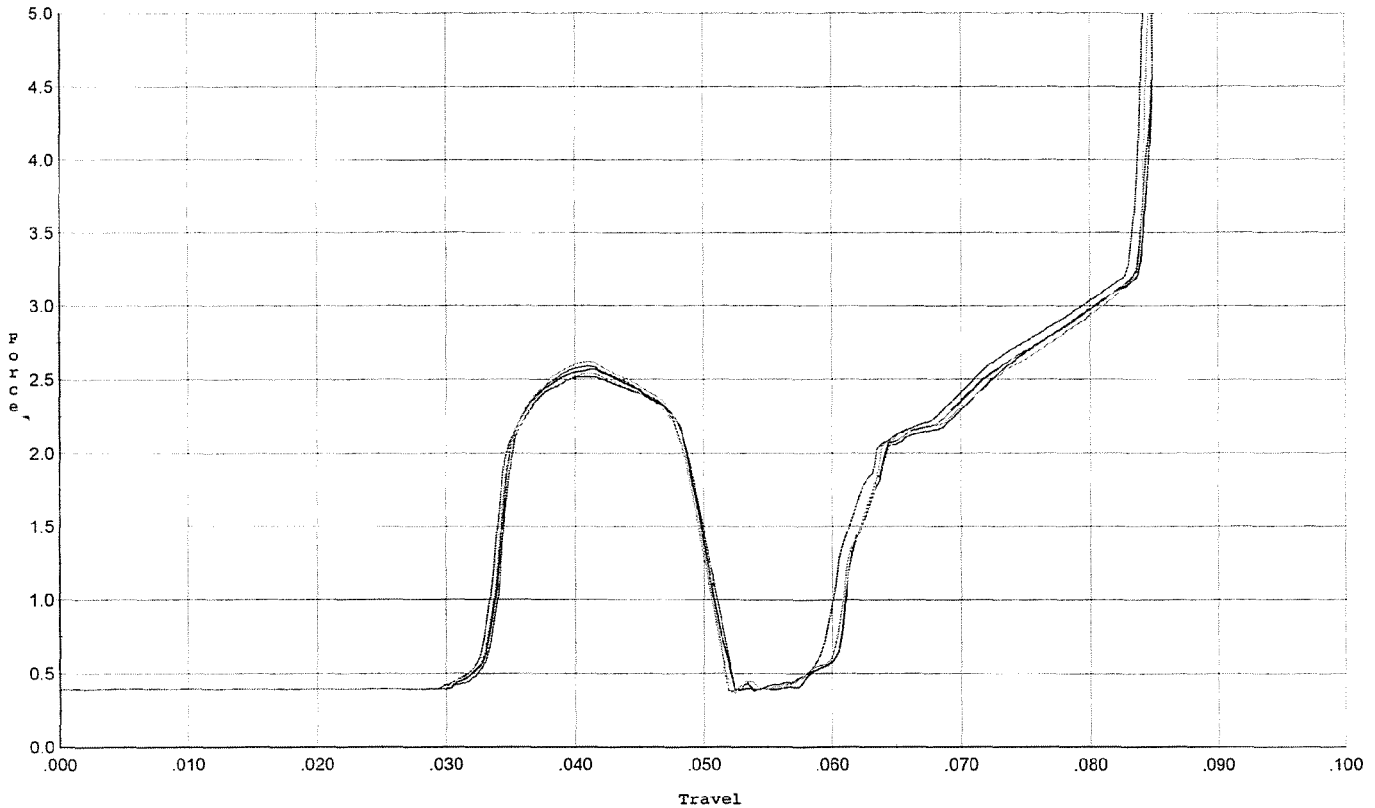
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.049	0.034	0.038	0.046		Set Trigger
2	2.430	0.048	0.033	0.039	0.045		Set Trigger
3	2.319	0.049	0.033	0.039	0.045		Set Trigger
4	2.317	0.049	0.033	0.039	0.045		Set Trigger
5	2.331	0.049	0.033	0.039	0.045		Set Trigger

Aug 2.36

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putsch 11/13/08

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



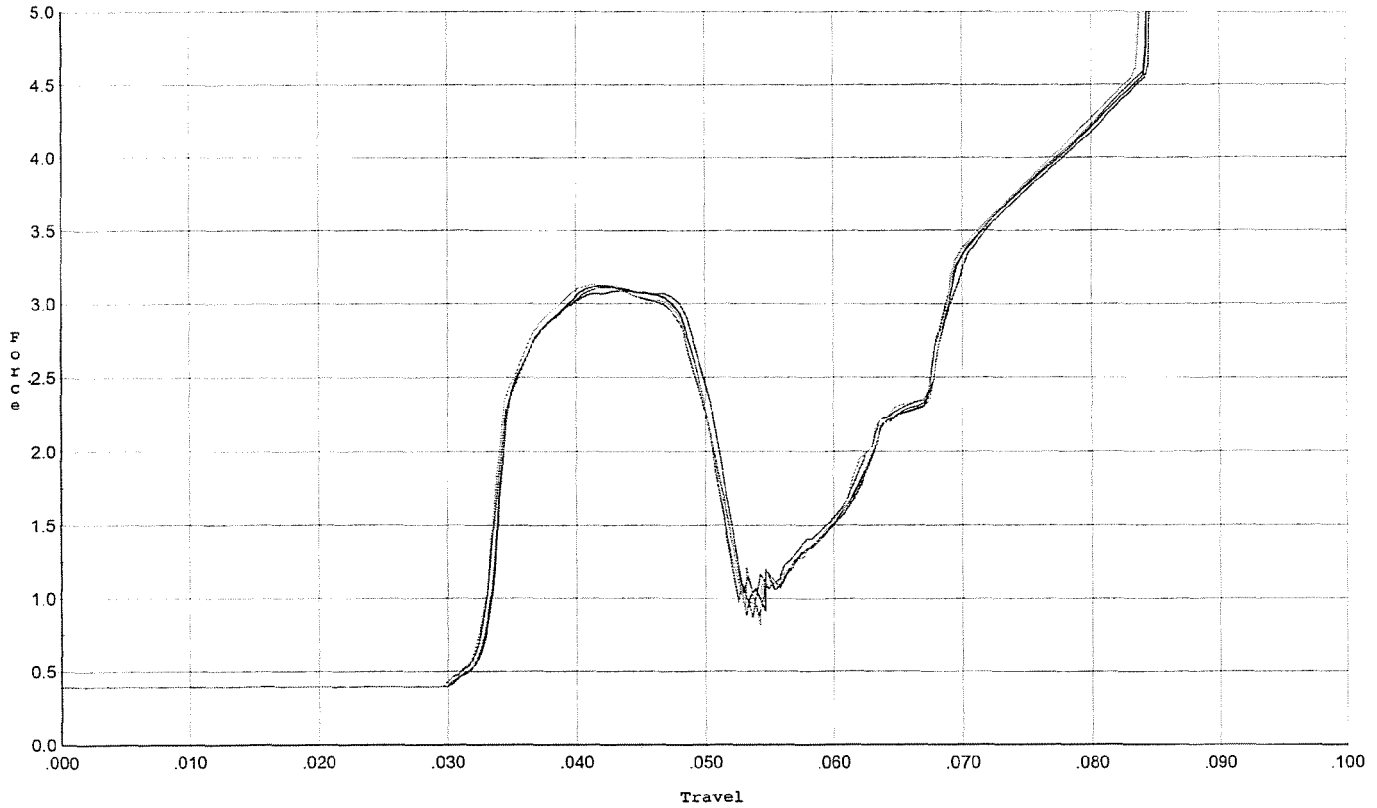
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.051	0.033	0.038	0.051		Set Trigger
2	2.566	0.050	0.033	0.039	0.050		Set Trigger
3	2.592	0.050	0.033	0.038	0.051		Set Trigger
4	2.618	0.050	0.033	0.039	0.051		Set Trigger
5	2.541	0.050	0.033	0.039	0.050		Set Trigger

Aug 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

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



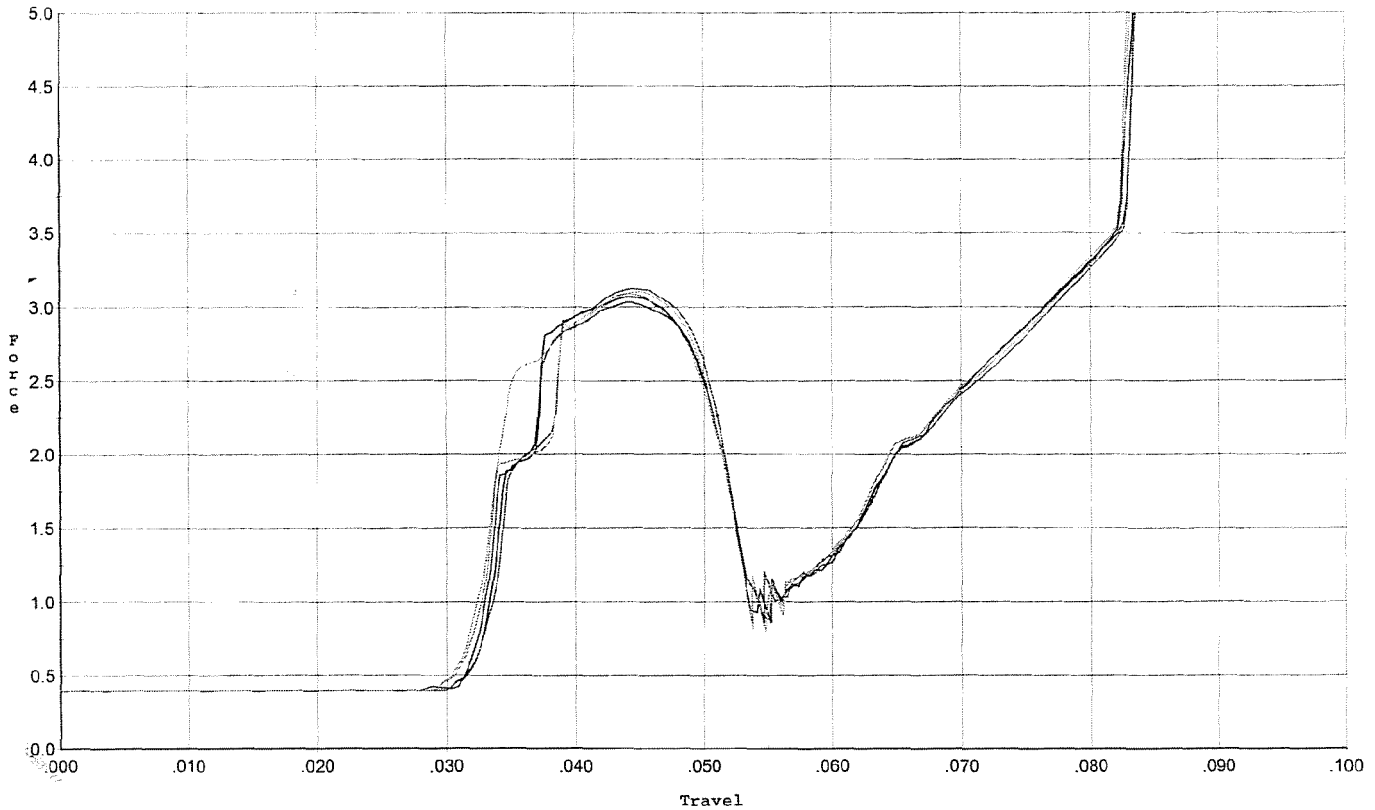
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.084	0.051	0.033	0.036	0.062		Set Trigger
2	3.123	0.051	0.033	0.036	0.063		Set Trigger
3	3.115	0.050	0.032	0.036	0.061		Set Trigger
4	3.107	0.051	0.033	0.036	0.063		Set Trigger
5	3.136	0.050	0.032	0.036	0.062		Set Trigger

Avg 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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



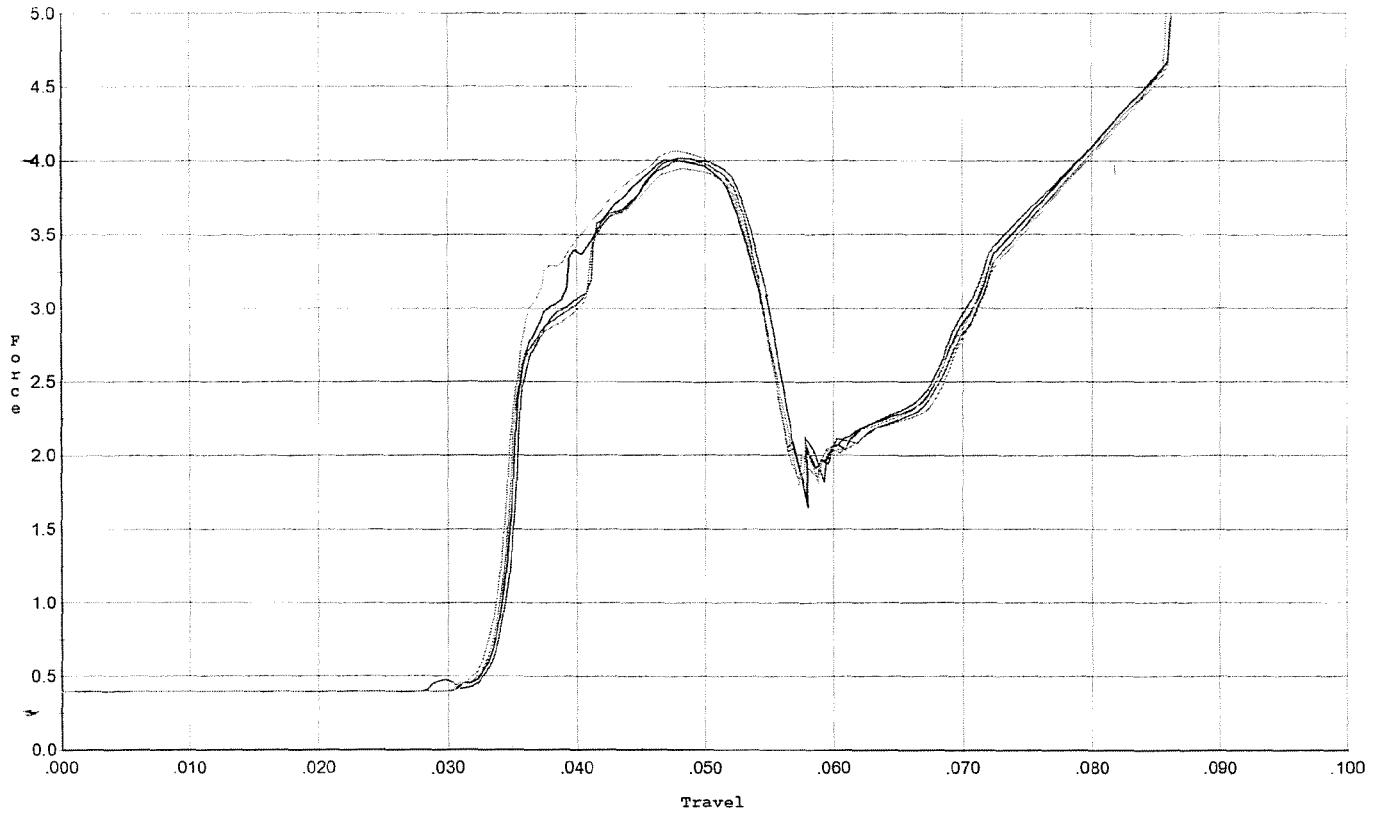
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.031	0.052	0.031	0.036	0.061		Set Trigger
2	3.067	0.051	0.032	0.036	0.061		Set Trigger
3	3.125	0.051	0.032	0.036	0.061		Set Trigger
4	3.104	0.052	0.031	0.035	0.064		Set Trigger
5	3.088	0.052	0.031	0.036	0.061		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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



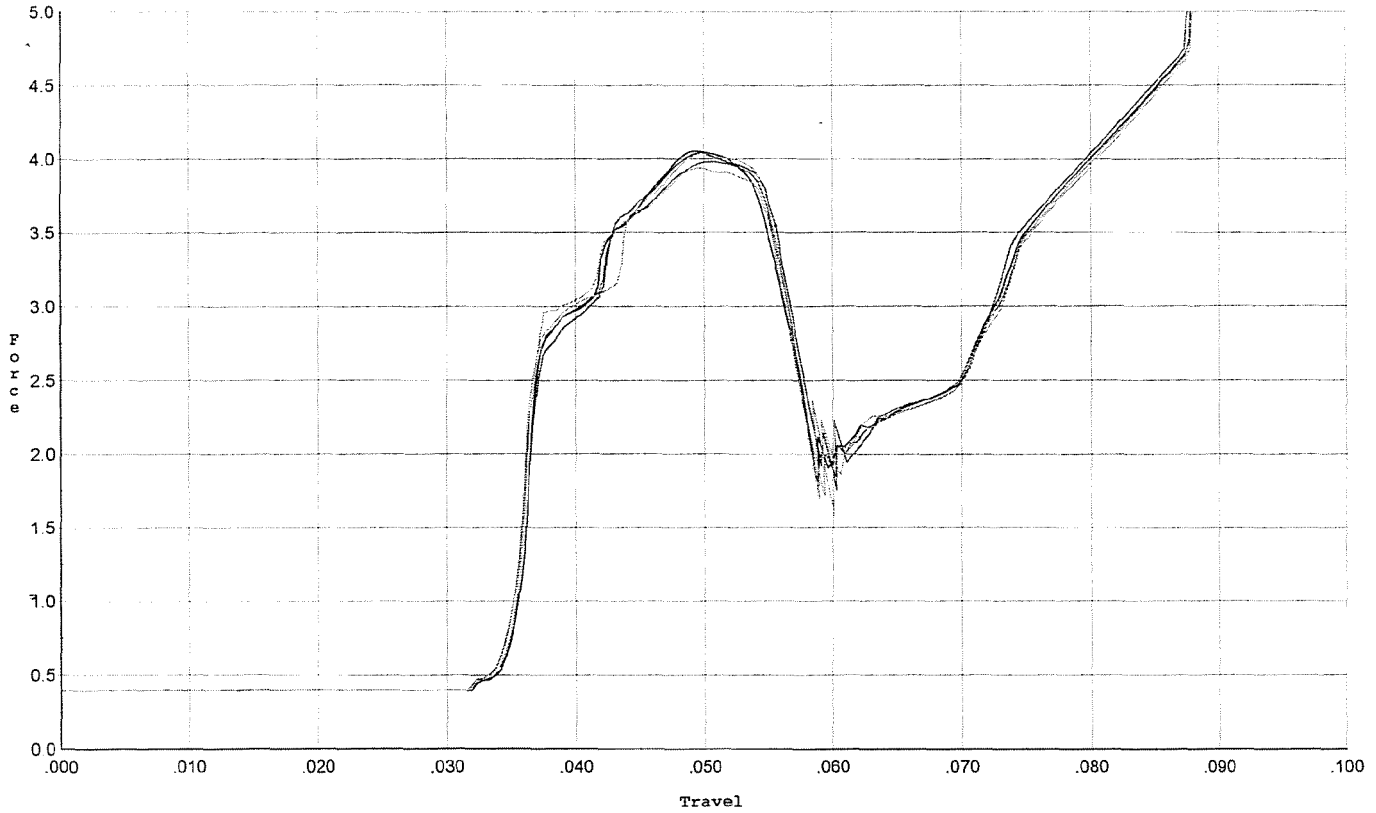
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.014	0.055	0.033	0.035	0.085		Set Trigger
2	4.003	0.054	0.033	0.035	0.084		Set Trigger
3	3.999	0.054	0.033	0.035	0.083		Set Trigger
4	4.066	0.054	0.033	0.035	0.086		Set Trigger
5	3.945	0.054	0.033	0.034	0.083		Set Trigger

Avg 4.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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



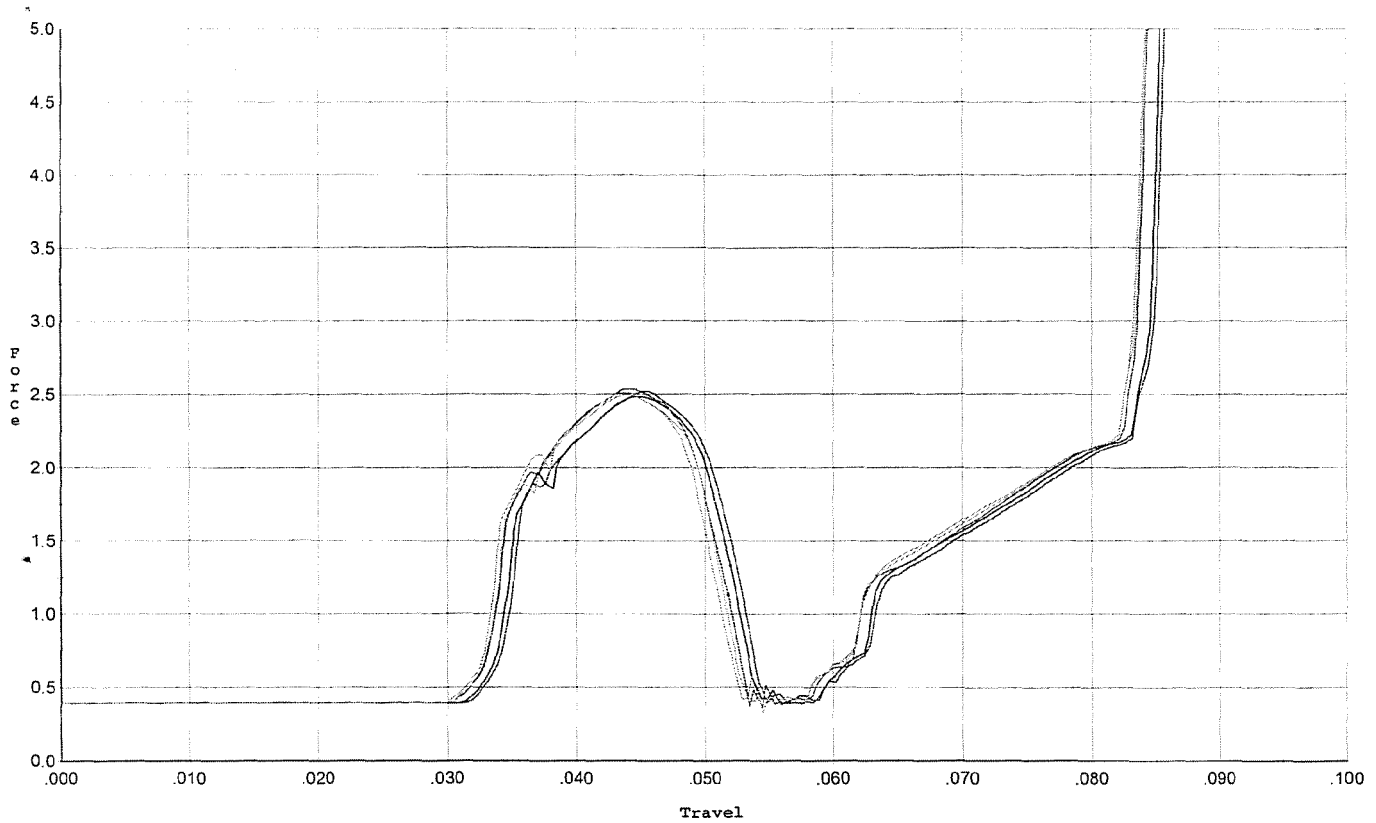
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.039	0.056	0.035	0.035	0.086		Set Trigger
2	4.055	0.057	0.035	0.035	0.087		Set Trigger
3	3.980	0.056	0.034	0.035	0.087		Set Trigger
4	4.039	0.056	0.034	0.035	0.087		Set Trigger
5	3.939	0.057	0.034	0.035	0.087		Set Trigger

Avg 4.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 11/13/08

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



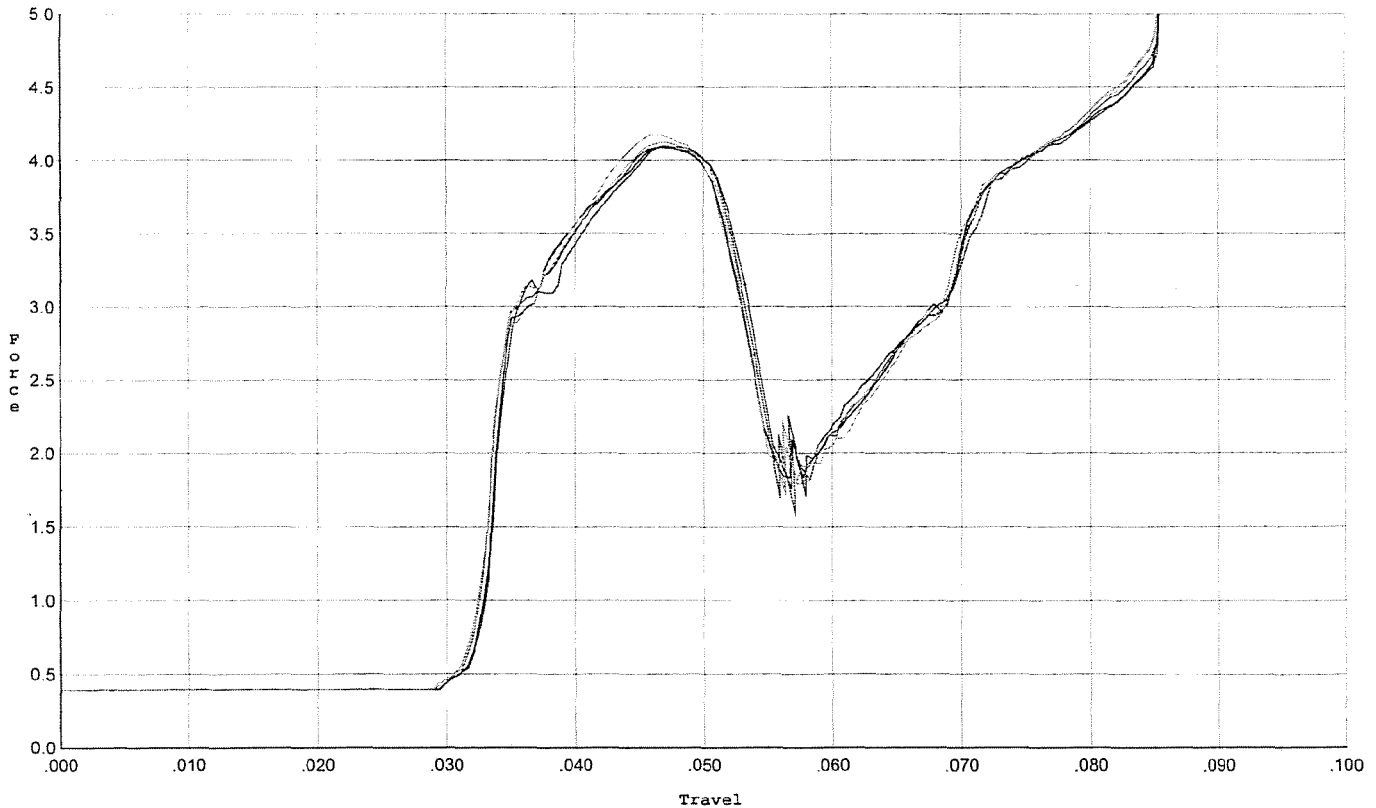
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.520	0.053	0.034	0.038	0.052		Set Trigger
2	2.483	0.052	0.033	0.038	0.051		Set Trigger
3	2.536	0.052	0.033	0.038	0.052		Set Trigger
4	2.494	0.051	0.033	0.038	0.050		Set Trigger
5	2.511	0.050	0.033	0.038	0.050		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/13/08

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	4.091	0.053	0.032	0.034	0.085		Set Trigger
2	4.095	0.053	0.032	0.034	0.084		Set Trigger
3	4.088	0.054	0.032	0.034	0.087		Set Trigger
4	4.177	0.053	0.032	0.034	0.085		Set Trigger
5	4.121	0.052	0.032	0.034	0.084		Set Trigger

Avg 4.11