

66794520

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



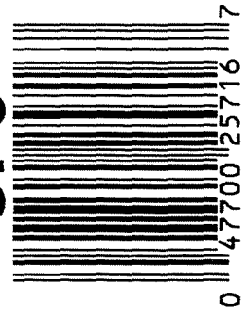
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794520

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794520

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		11-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-28-08	RBR
475	DRILL AND TAP SIGHT HOLES	NOV 20 2008	10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	10-29-08	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10 30	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-6-08	P8W
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

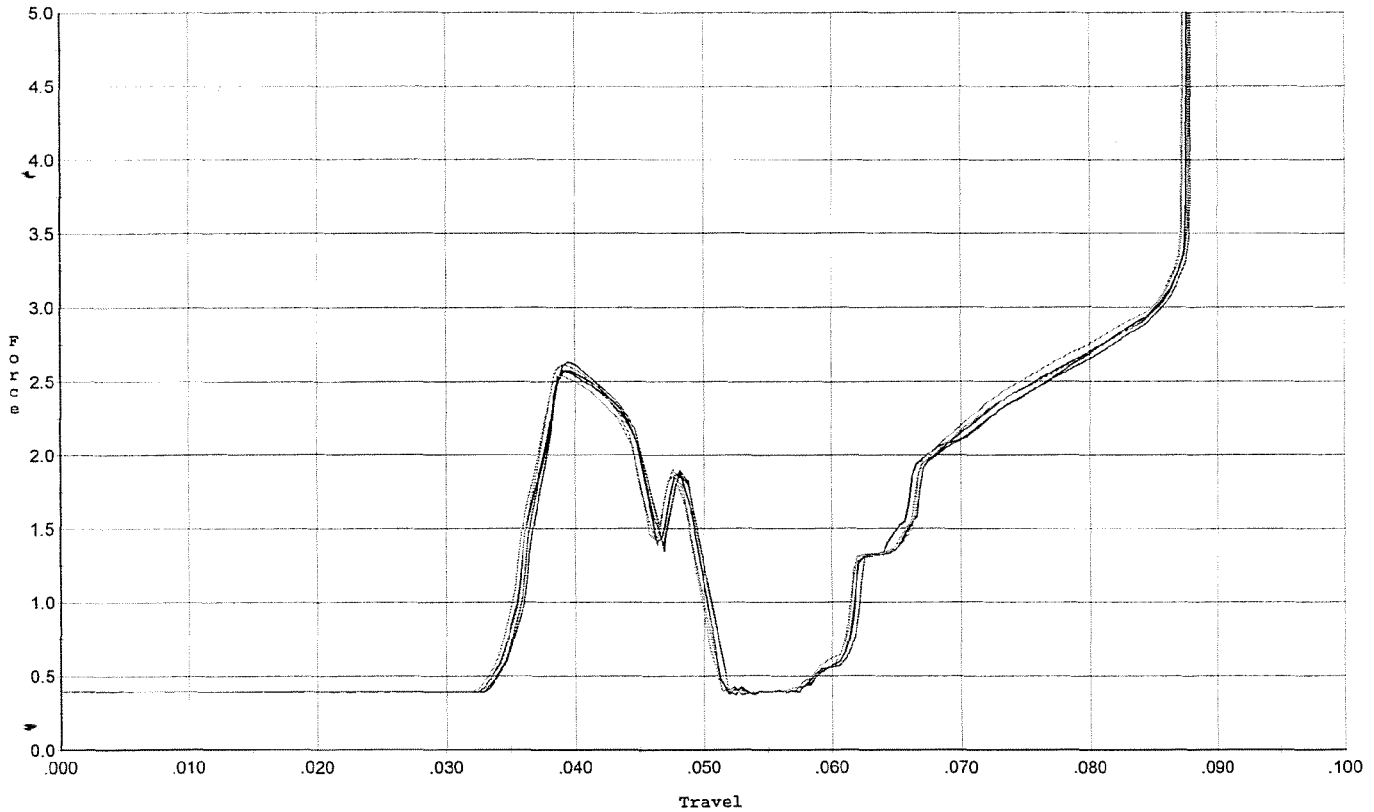
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>30</u> <u>30</u>	11-13-08	R.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	11-13-08	R.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-13-08	R.D.
	J) ASSEMBLE STOCK		11-6-08	LSW
	K) ASSEMBLE SWIVEL STUDS		11-13-08	R.D.
	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	11-7-08	R.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-7-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-13-08	R.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.31</u> <u>2.30</u> <u>2.28</u> <u>2.29</u>	11-7-08	TC
	C) FUNCTION		11-13-08	R.D.
690	PACK		11/17/08	Fm

F004 REV 5/2006

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. ini. +/- .50 lbs.



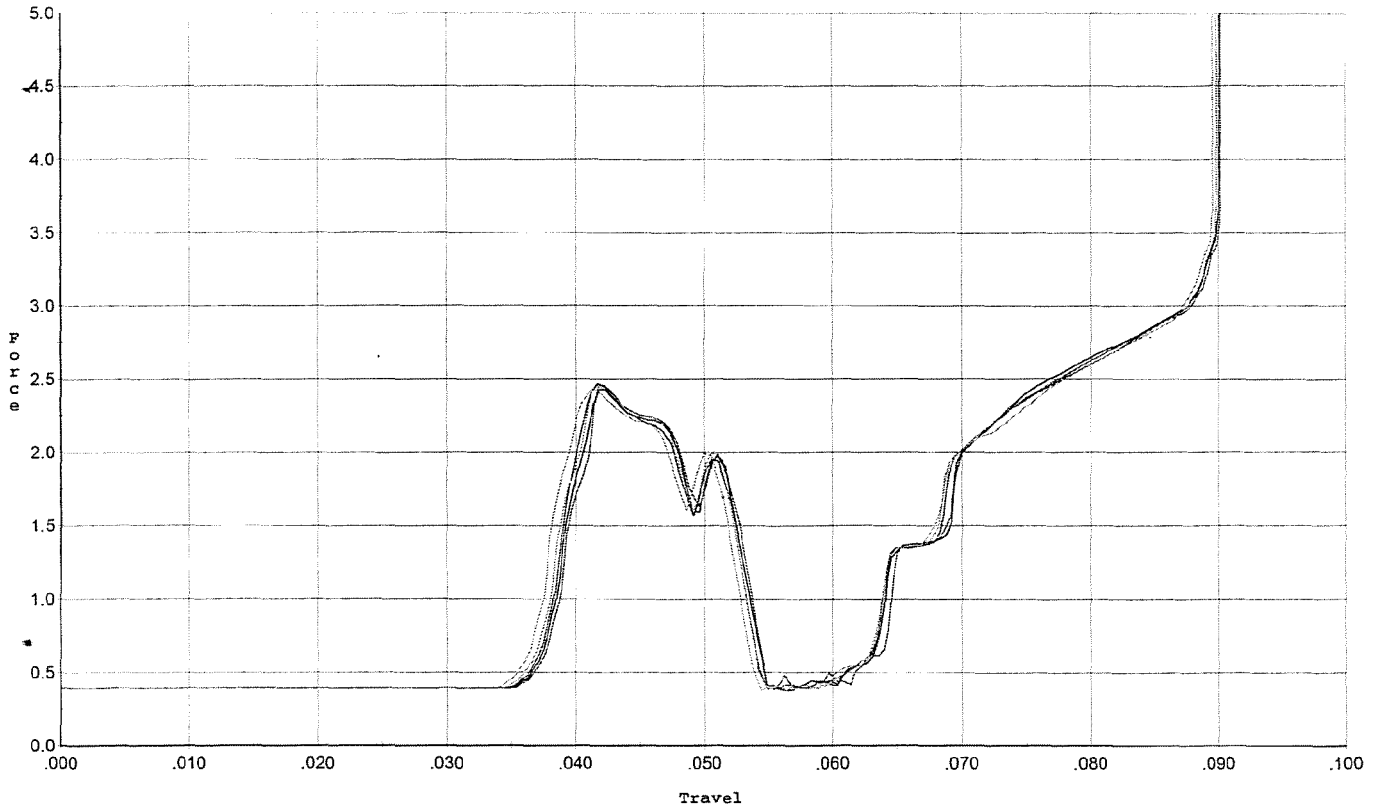
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.565	0.050	0.034	0.042	0.043		Set Trigger
2	2.575	0.049	0.034	0.042	0.043		Set Trigger
3	2.634	0.049	0.034	0.042	0.042		Set Trigger
4	2.538	0.048	0.034	0.042	0.042		Set Trigger
5	2.614	0.048	0.035	0.042	0.042		Set Trigger

Aug 2.58

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.



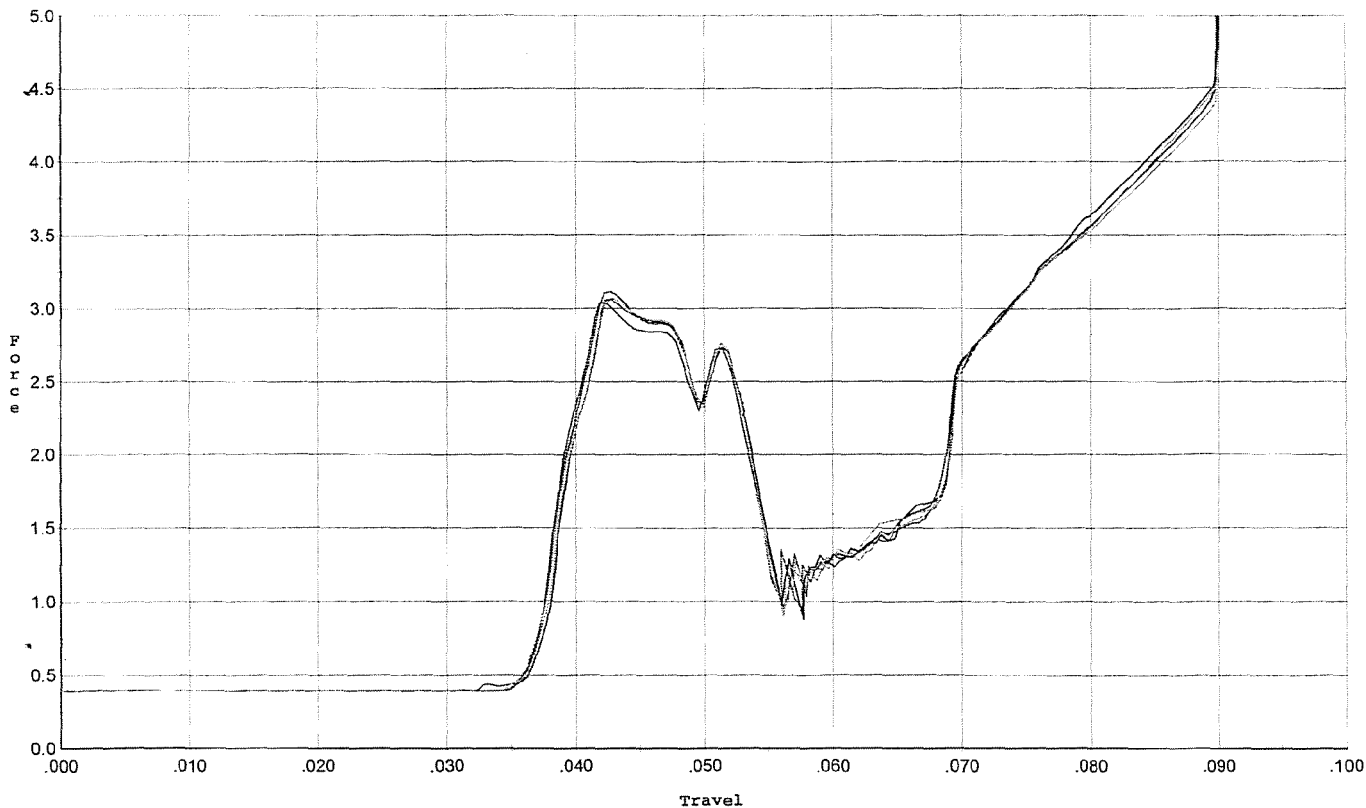
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.473	0.052	0.037	0.041	0.044		Set Trigger
2	2.426	0.052	0.037	0.041	0.043		Set Trigger
3	2.461	0.053	0.037	0.041	0.044		Set Trigger
4	2.455	0.052	0.036	0.041	0.044		Set Trigger
5	2.434	0.051	0.036	0.041	0.044		Set Trigger

Avg 2.45

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.



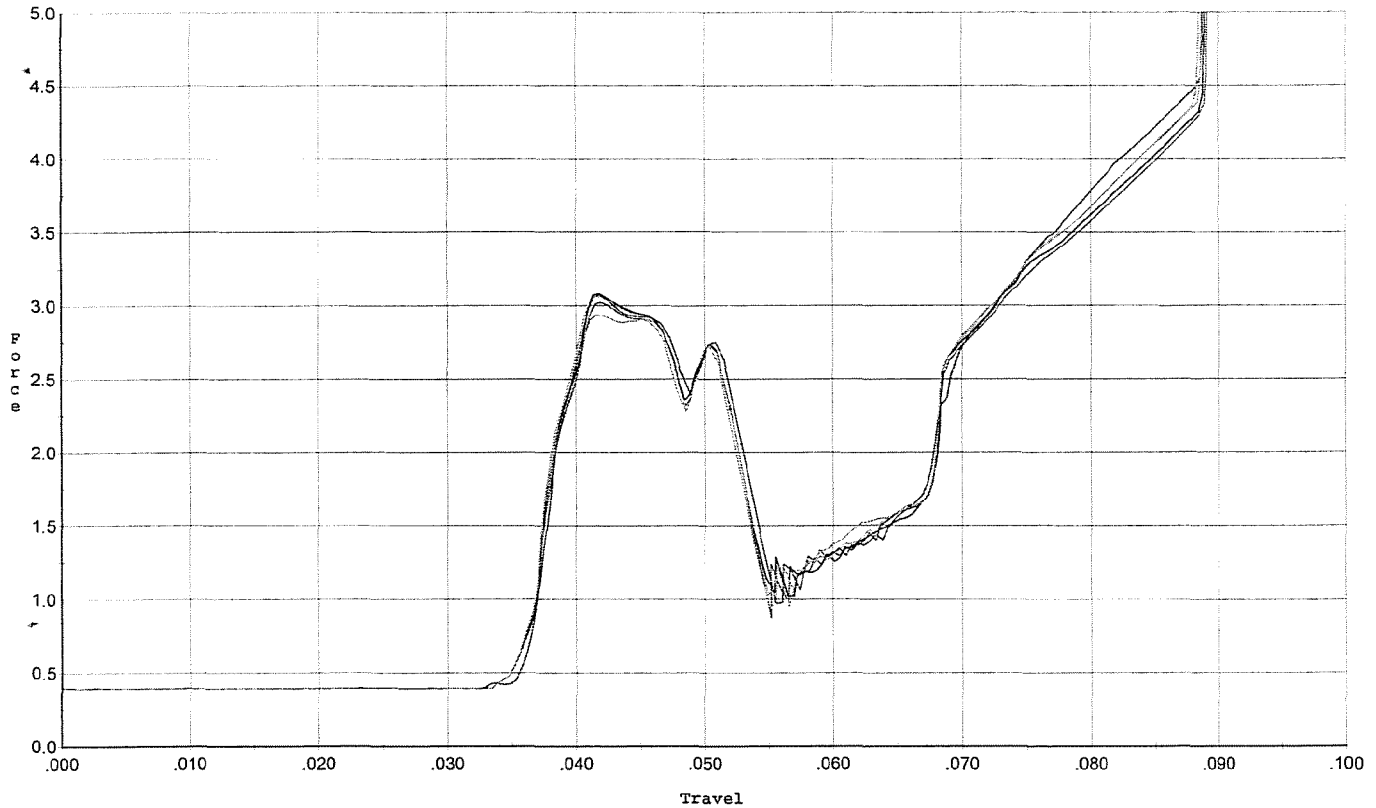
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.040	0.052	0.036	0.040	0.054		Set Trigger
2	3.059	0.053	0.037	0.040	0.055		Set Trigger
3	3.115	0.053	0.036	0.040	0.056		Set Trigger
4	3.069	0.053	0.037	0.040	0.056		Set Trigger
5	3.057	0.053	0.036	0.040	0.056		Set Trigger

Avg 3.06

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.



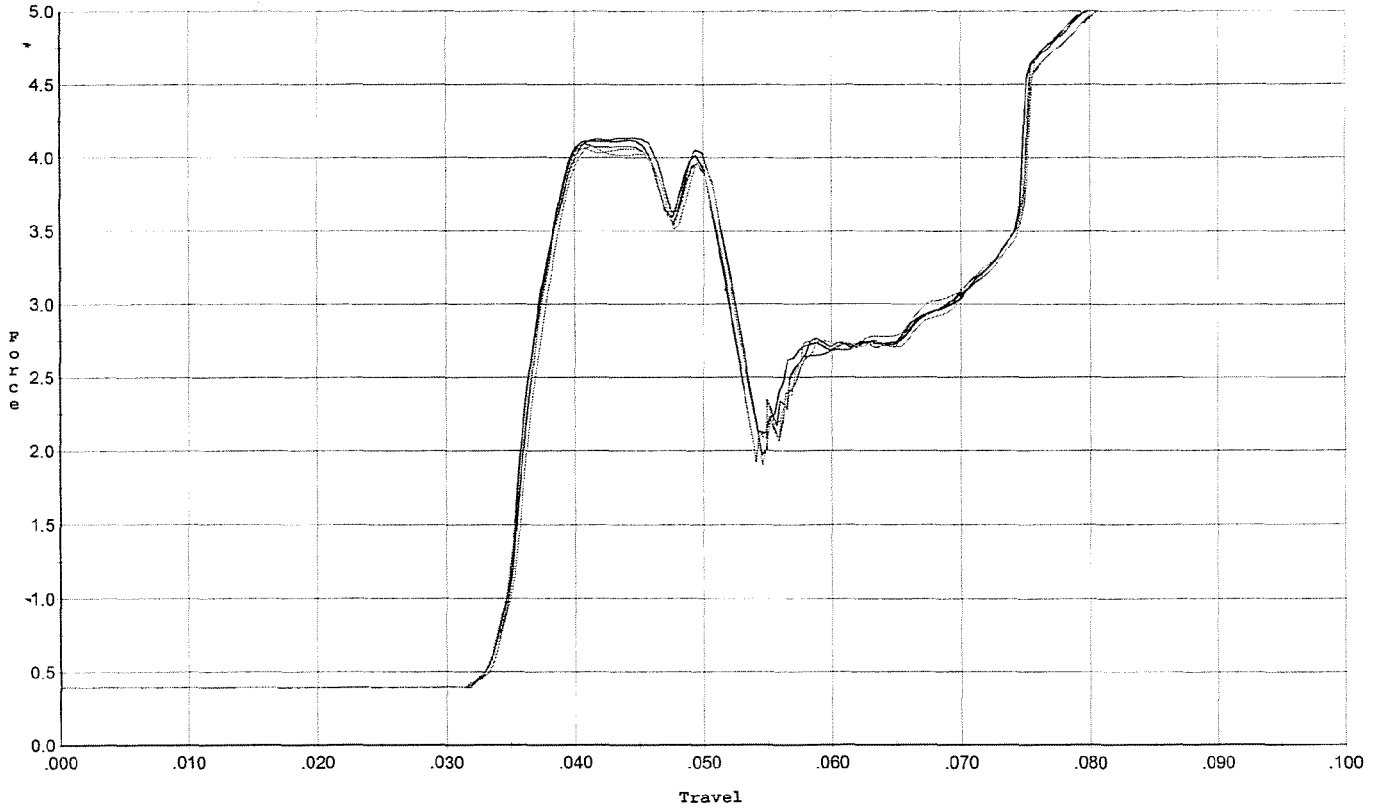
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.077	0.053	0.036	0.039	0.057		Set Trigger
2	3.082	0.052	0.035	0.039	0.056		Set Trigger
3	3.023	0.052	0.035	0.039	0.055		Set Trigger
4	2.939	0.052	0.035	0.039	0.055		Set Trigger
5	3.063	0.051	0.035	0.039	0.054		Set Trigger

AVG 3.03

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.



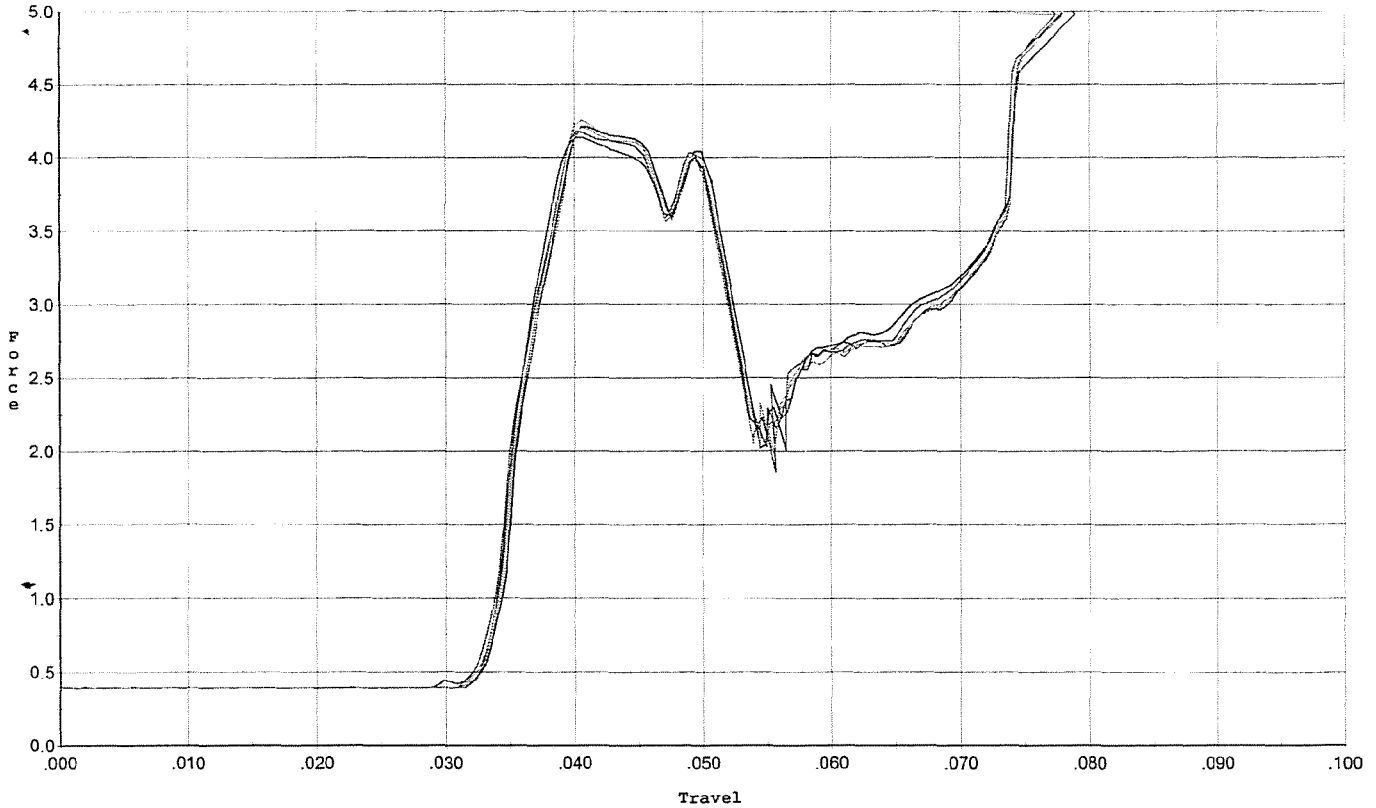
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.132	0.052	0.034	0.037	0.078		Set Trigger
2	4.119	0.052	0.033	0.037	0.077		Set Trigger
3	4.096	0.052	0.033	0.037	0.076		Set Trigger
4	4.064	0.051	0.033	0.037	0.076		Set Trigger
5	4.075	0.051	0.034	0.037	0.074		Set Trigger

Aug 409

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.



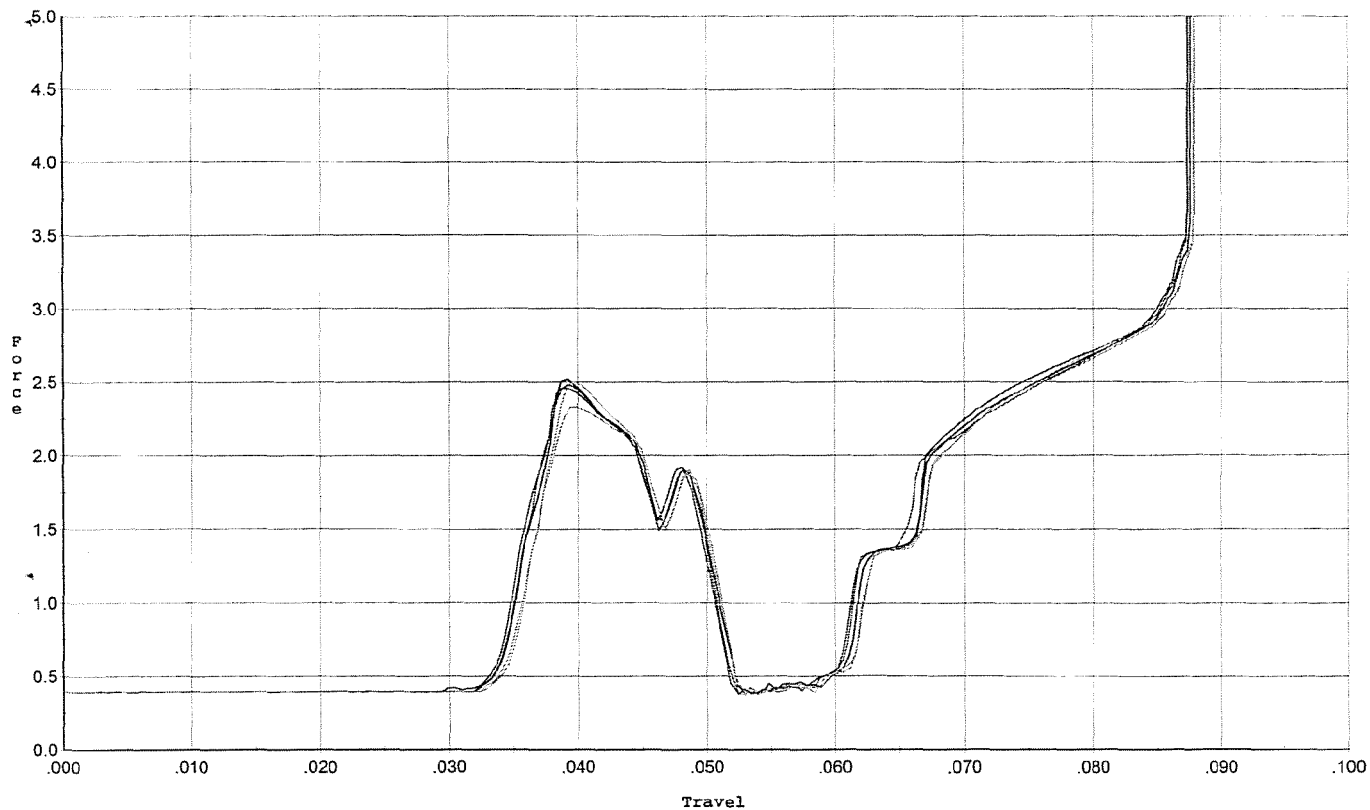
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.137	0.051	0.033	0.036	0.078		Set Trigger
2	4.207	0.051	0.033	0.036	0.076		Set Trigger
3	4.178	0.052	0.033	0.036	0.079		Set Trigger
4	4.201	0.051	0.033	0.036	0.077		Set Trigger
5	4.255	0.052	0.033	0.036	0.078		Set Trigger

Avg 4.19

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



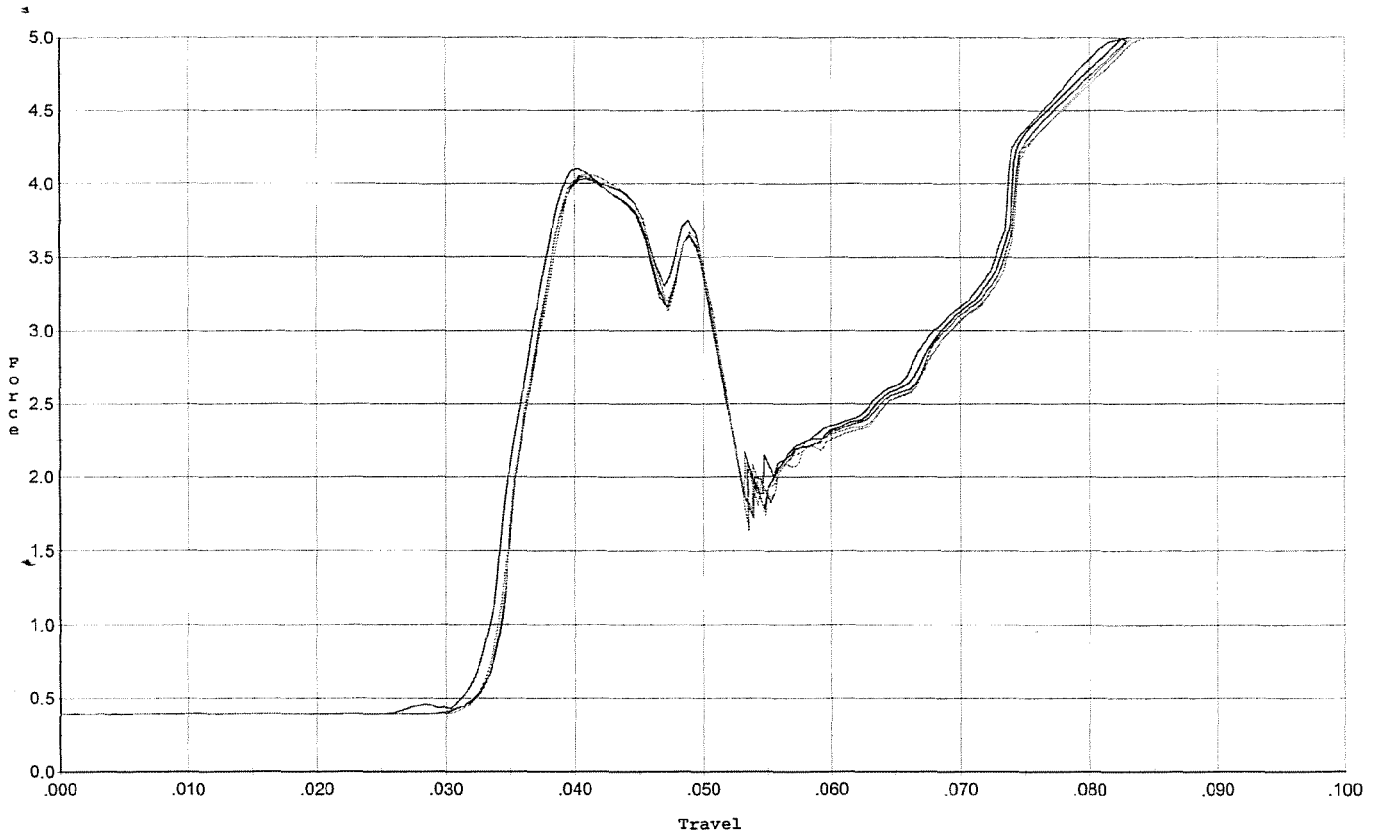
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.050	0.034	0.042	0.044		Set Trigger
2	2.517	0.050	0.034	0.041	0.043		Set Trigger
3	2.483	0.050	0.034	0.041	0.043		Set Trigger
4	2.504	0.050	0.035	0.041	0.043		Set Trigger
5	2.326	0.051	0.034	0.042	0.043		Set Trigger

Aug 2.45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 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	0.051	0.032	0.037	0.074		Set Trigger
2	4.047	0.051	0.033	0.037	0.072		Set Trigger
3	4.032	0.050	0.033	0.037	0.069		Set Trigger
4	4.050	0.051	0.033	0.037	0.072		Set Trigger
5	4.061	0.051	0.033	0.037	0.071		Set Trigger

AVG 4.05