

5679 4630

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

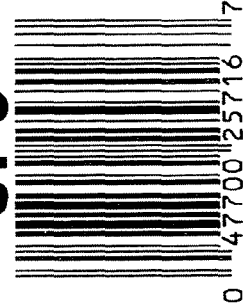
24"

CAPACITY

6

G6794630

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794630

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPJ
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPJ
460	CHECK HEADSPACE		9-29-08	SPJ
470	DIS-ASSEMBLE ACTION		9-29-08	SPJ
472	SERIALIZE BOLT HANDLE		9-30-08	SPJ
475	DRILL AND TAP SIGHT HOLES		10/1/08	FM
480	MAGNAFLUX BBL ACTION		10/2/08	(RB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/2/08	DG
542	APPLY COATINGS (BARREL ACTION)		10 3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-15-08	SPW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

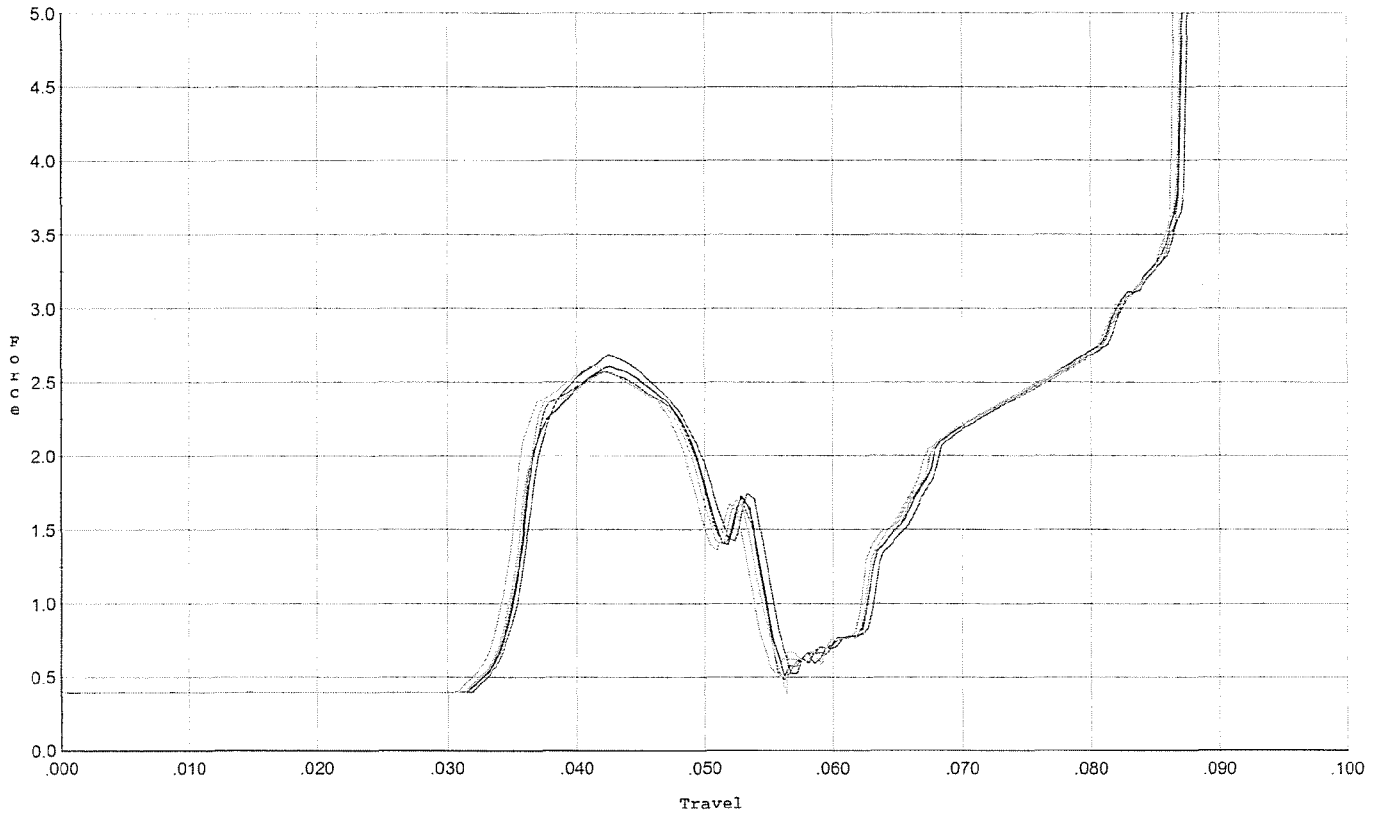
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	10-27-08	L.P.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	10-27-08	L.P.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-27-08	L.P.
	J) ASSEMBLE STOCK		10-15-08	RSN
	K) ASSEMBLE SWIVEL STUDS		10-27-08	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 &	FUNCTION TEST AND	<u>PASS</u> FAIL	10-23-08	RSN
650	TARGET	<u>PASS</u> FAIL	10-23-08	RSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-08	TL
670	FINAL INSPECTION A) HEADSPACE		10-27-08	L.P.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>205</u> <u>216</u> <u>242</u> <u>223</u> <u>226</u>	10-27-08	RSN
	C) FUNCTION		10-27-08	L.P.
690	PACK		10/28/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

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

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



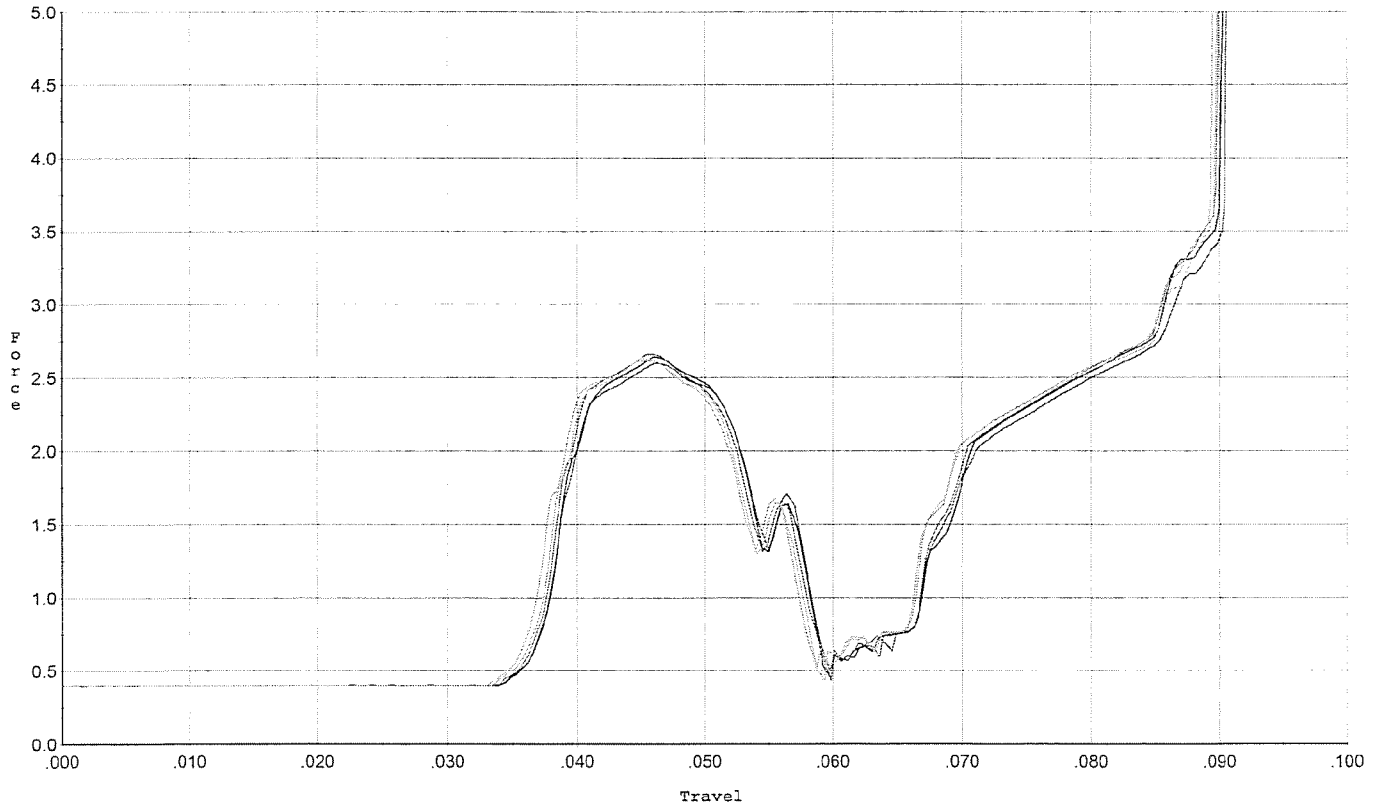
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.687	0.054	0.034	0.037	0.055		Set Trigger
2	2.609	0.054	0.034	0.037	0.054		Set Trigger
3	2.571	0.054	0.034	0.037	0.054		Set Trigger
4	2.566	0.053	0.034	0.037	0.053		Set Trigger
5	2.612	0.053	0.033	0.037	0.054		Set Trigger

Avg 2.60

Trigger Profile [lbs,inch]

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

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



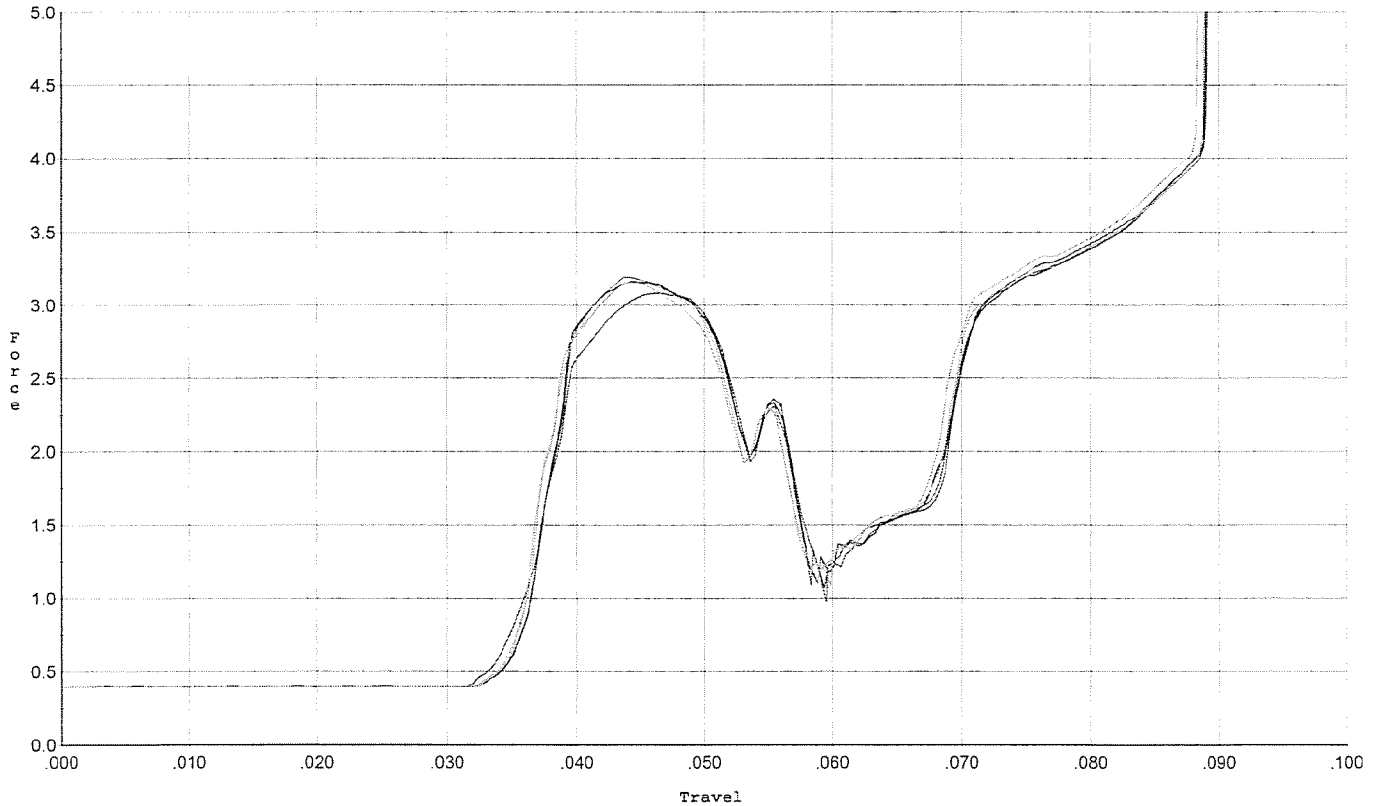
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.599	0.057	0.037	0.038	0.057		Set Trigger
2	2.642	0.057	0.037	0.038	0.057		Set Trigger
3	2.661	0.057	0.036	0.038	0.057		Set Trigger
4	2.633	0.057	0.036	0.038	0.057		Set Trigger
5	2.617	0.056	0.036	0.038	0.057		Set Trigger

Aug 2.63

Trigger Profile [lbs,inch]

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

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



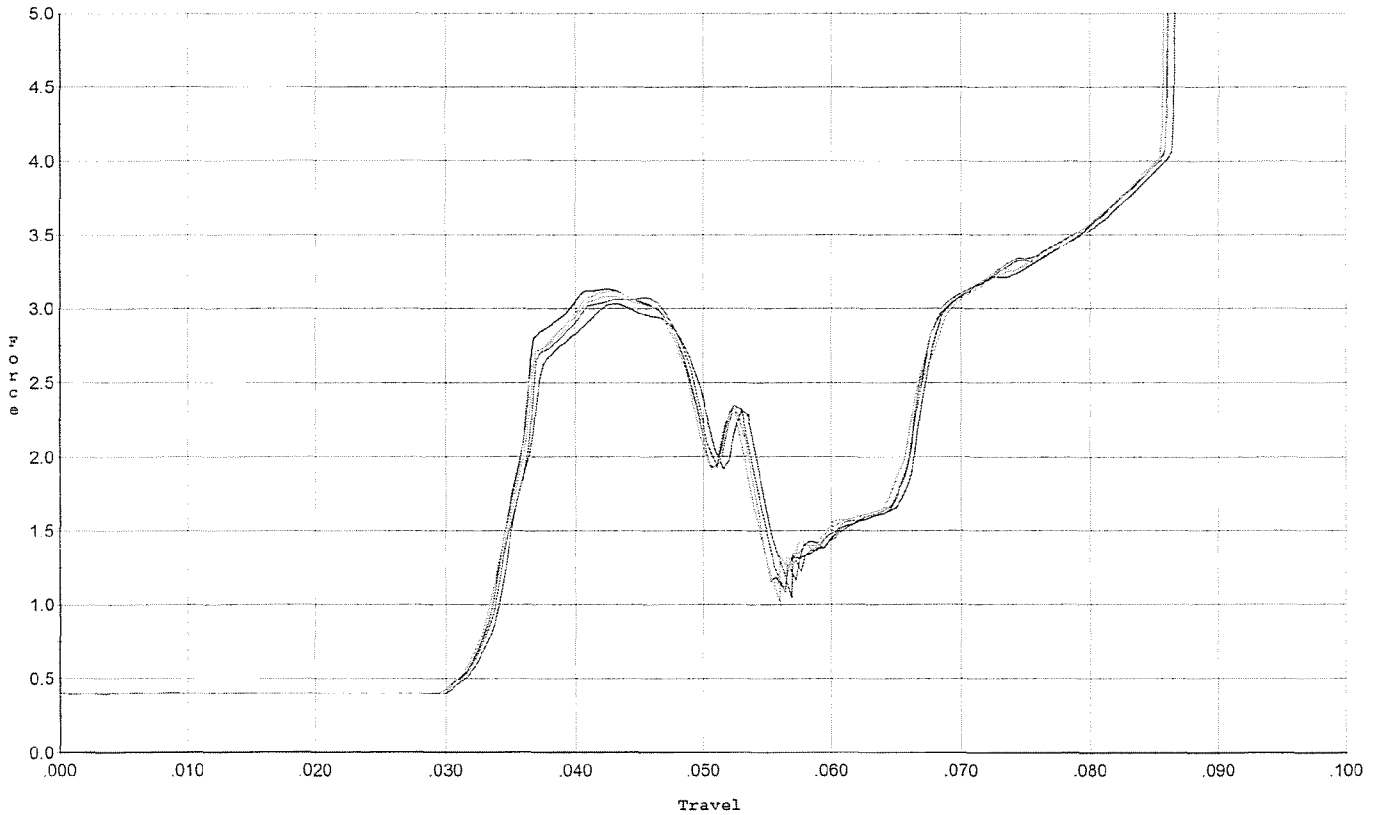
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.056	0.034	0.037	0.067		Set Trigger
2	3.156	0.056	0.035	0.037	0.068		Set Trigger
3	3.190	0.056	0.035	0.037	0.068		Set Trigger
4	3.171	0.056	0.035	0.037	0.067		Set Trigger
5	3.152	0.056	0.035	0.037	0.067		Set Trigger

Avg 3.15

Trigger Profile [lbs,inch]

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

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



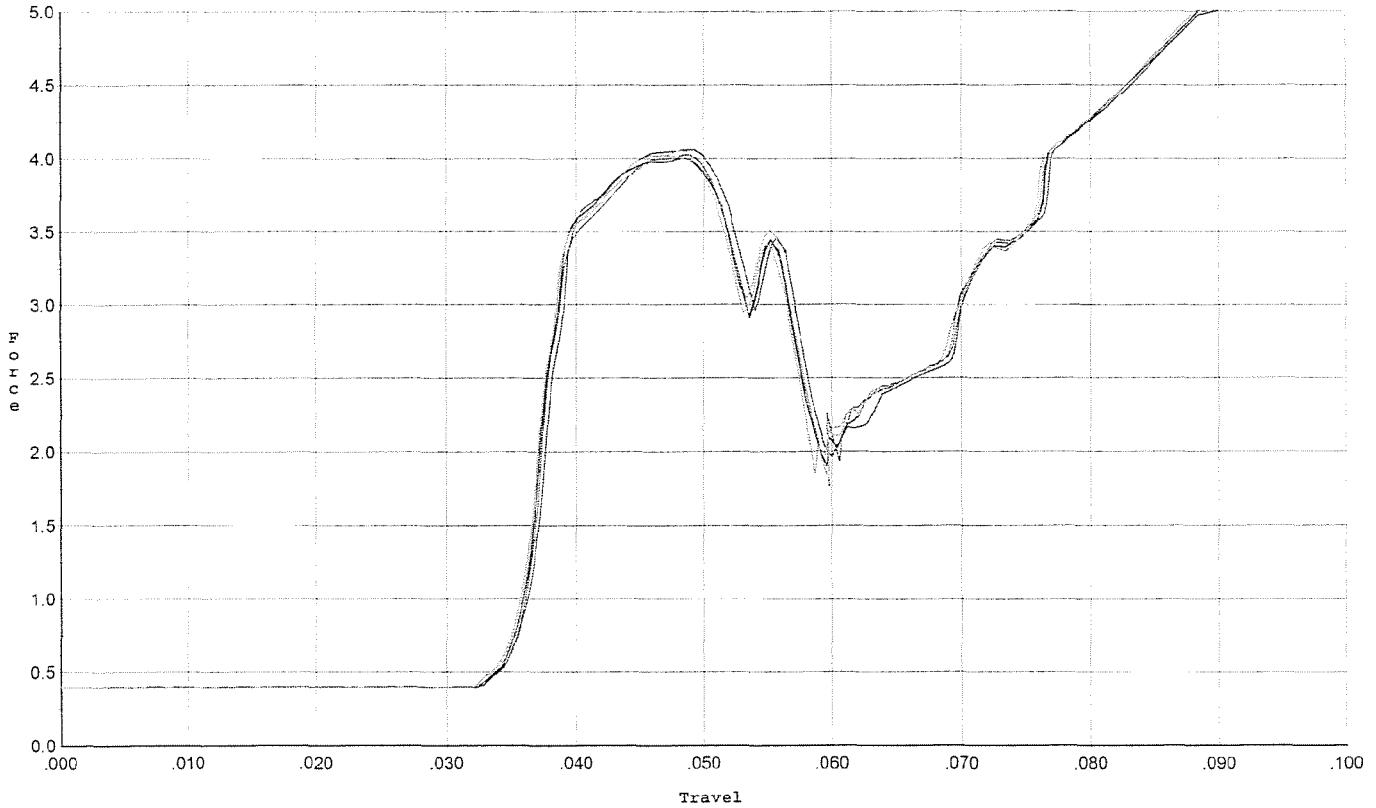
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.028	0.054	0.033	0.036	0.064		Set Trigger
2	3.128	0.053	0.032	0.036	0.066		Set Trigger
3	3.075	0.053	0.032	0.036	0.064		Set Trigger
4	3.085	0.053	0.032	0.036	0.065		Set Trigger
5	3.117	0.053	0.032	0.036	0.064		Set Trigger

Aug 3.08

Trigger Profile [lbs,inch]

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

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



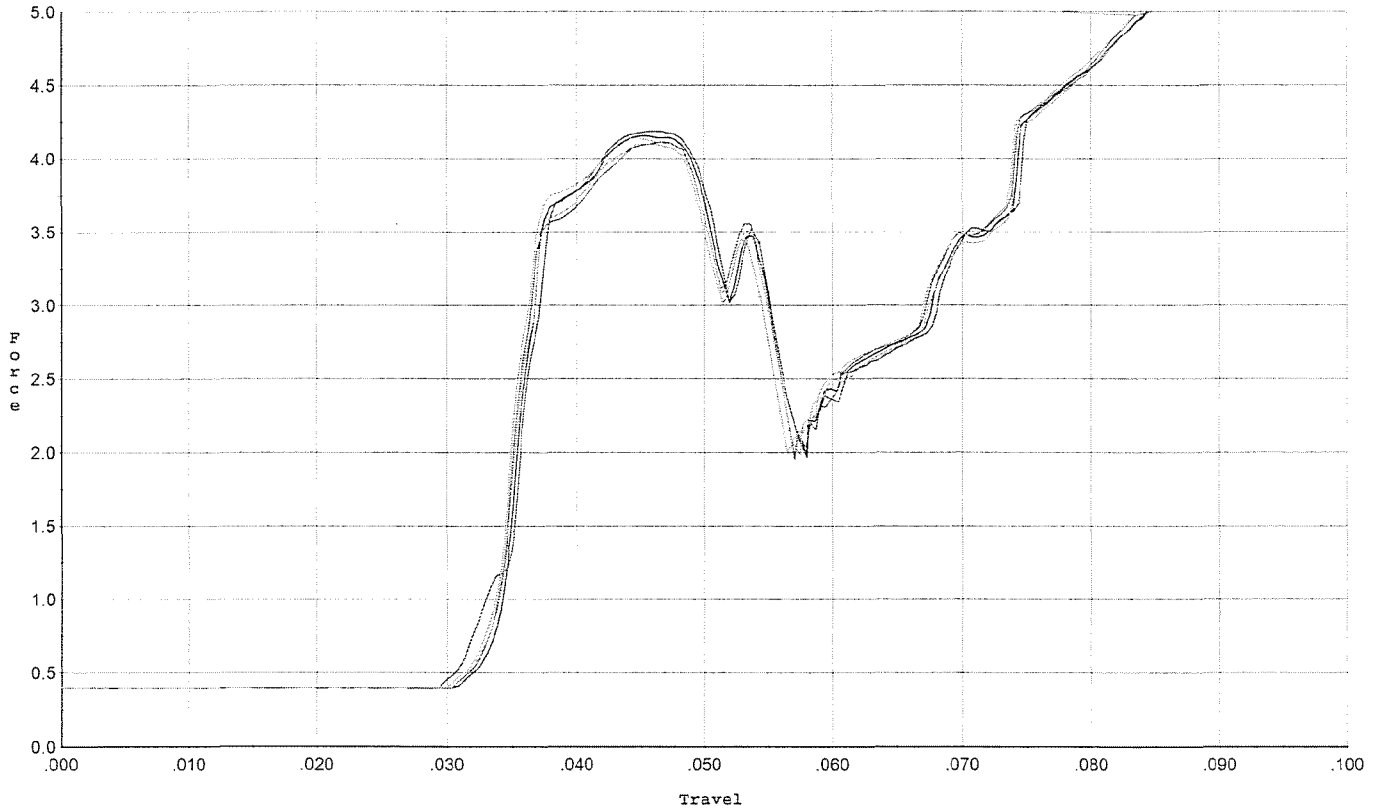
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.058	0.056	0.035	0.036	0.087		Set Trigger
2	4.005	0.056	0.035	0.036	0.086		Set Trigger
3	4.025	0.056	0.035	0.036	0.085		Set Trigger
4	4.054	0.056	0.035	0.036	0.086		Set Trigger
5	4.020	0.056	0.035	0.036	0.086		Set Trigger

Aug 4.03

Trigger Profile [lbs,inch]

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

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



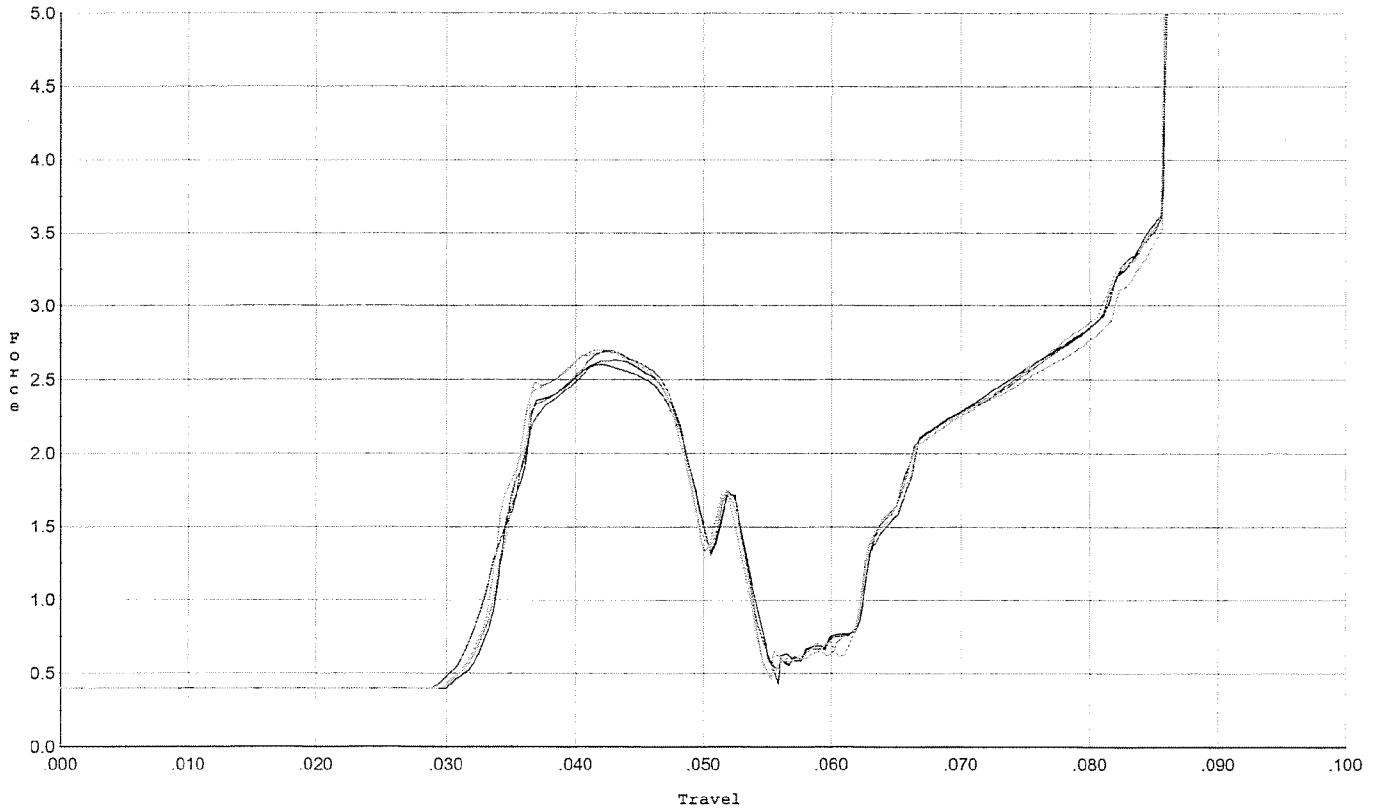
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.186	0.054	0.031	0.035	0.088		Set Trigger
2	4.156	0.055	0.033	0.035	0.088		Set Trigger
3	4.114	0.055	0.033	0.034	0.088		Set Trigger
4	4.142	0.054	0.032	0.035	0.088		Set Trigger
5	4.100	0.055	0.033	0.035	0.088		Set Trigger

Aug 4.14

Trigger Profile [lbs,inch]

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

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



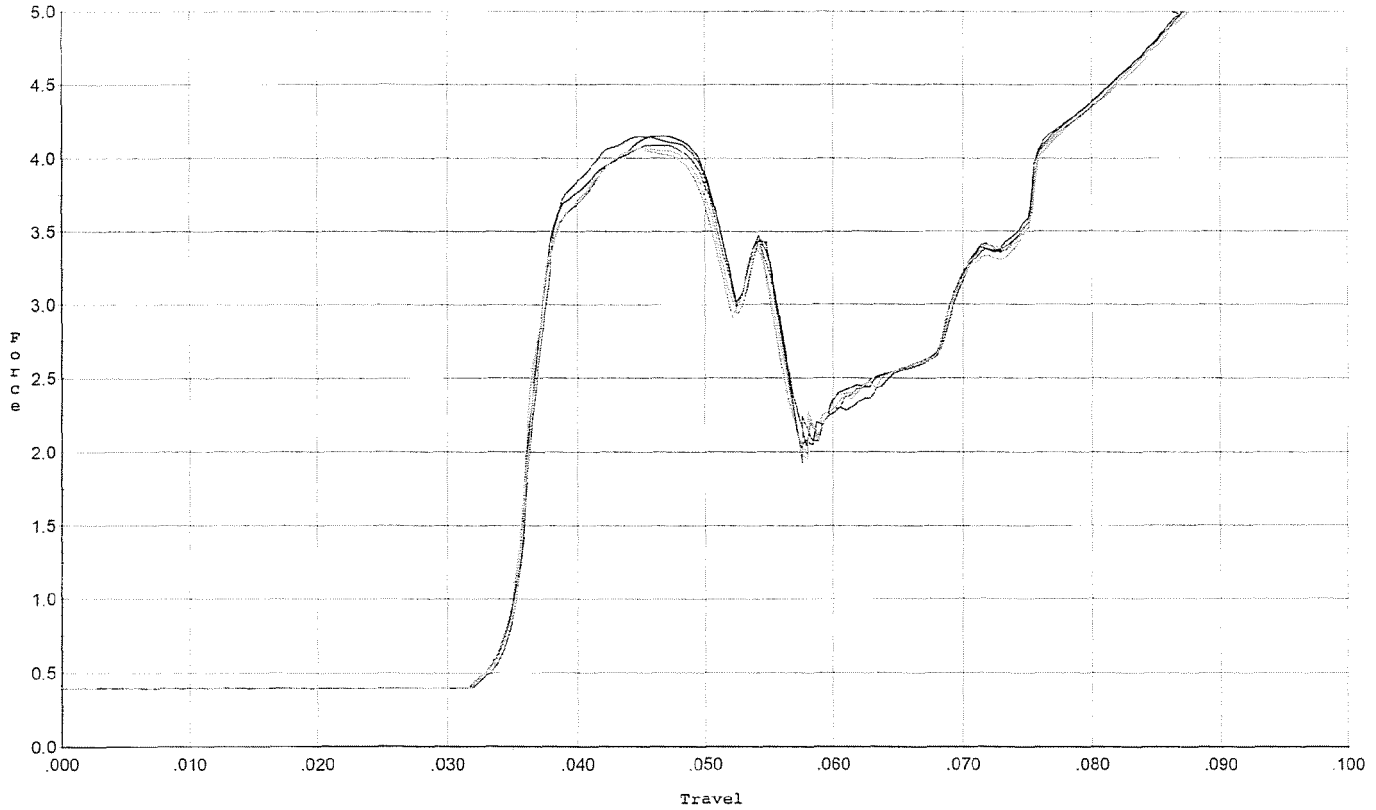
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.601	0.052	0.031	0.037	0.055		Set Trigger
2	2.633	0.052	0.032	0.037	0.055		Set Trigger
3	2.694	0.052	0.032	0.037	0.055		Set Trigger
4	2.703	0.053	0.032	0.037	0.057		Set Trigger
5	2.685	0.053	0.032	0.037	0.056		Set Trigger

Avg 2.66

Trigger Profile [lbs,inch]

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

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	4.145	0.055	0.034	0.036	0.086		Set Trigger
2	4.149	0.055	0.034	0.035	0.087		Set Trigger
3	4.088	0.055	0.034	0.036	0.086		Set Trigger
4	4.069	0.056	0.034	0.036	0.086		Set Trigger
5	4.053	0.054	0.034	0.036	0.084		Set Trigger

Aug 4.09