

6680 1350

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



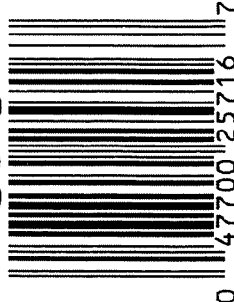
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

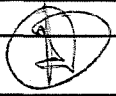
G6801350

UPC



BM FORM

GUN SERIAL # G 680 1350

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SP
460	CHECK HEADSPACE		2-27-09	SP
470	DIS-ASSEMBLE ACTION		2-27-09	SP
472	SERIALIZE BOLT HANDLE		3-2-09	LTZ
480	MAGNAFLUX BBL ACTION		3/5/09	
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	mm
540	APPLY COATINGS (BARREL ACTION)		3/9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-13-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

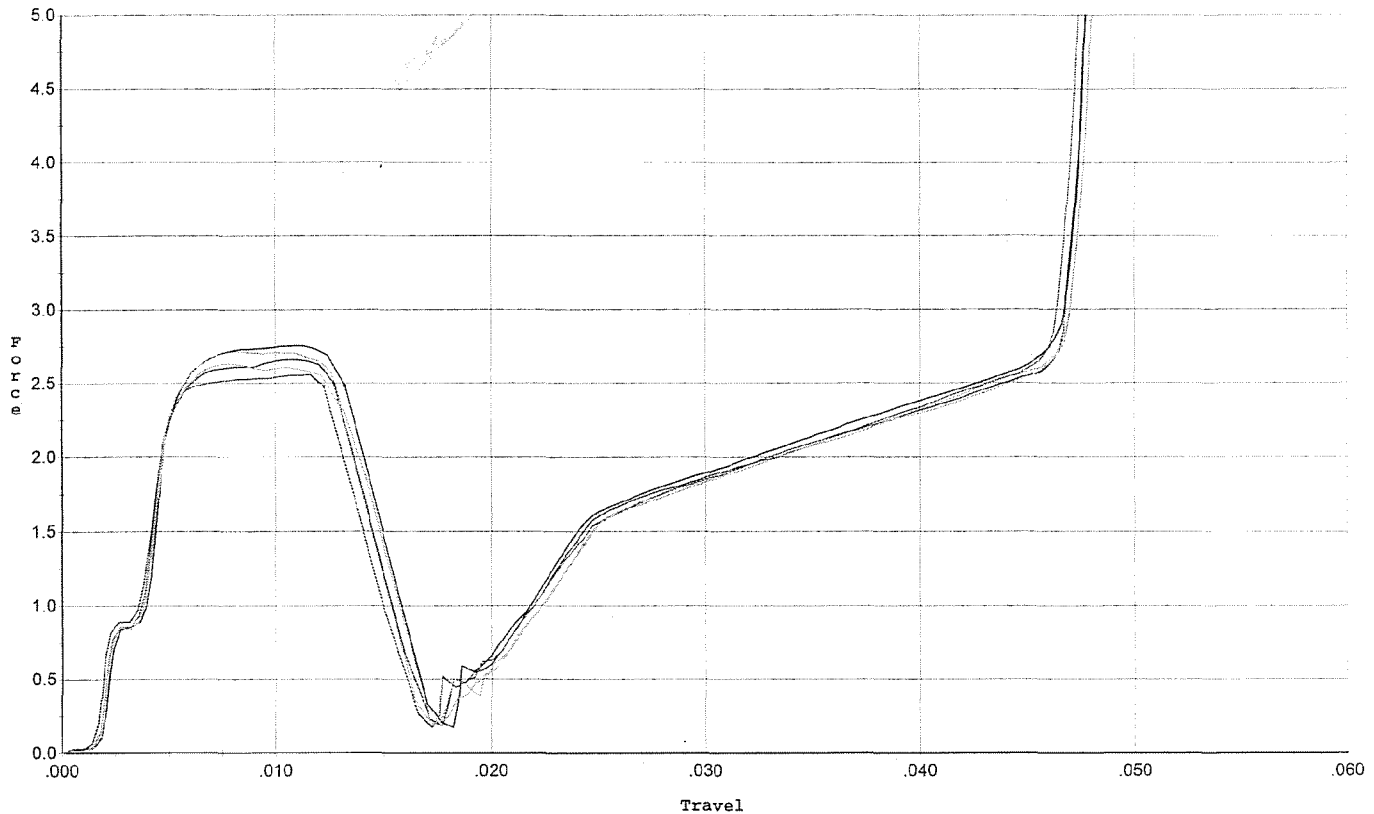
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0014251 F) SAFETY ON FORCE 1/2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	3-19-09	W/W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-19-09	W/W
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-19-09	W/W
	J) ASSEMBLE STOCK		3-13-09	J. J.
	K) ASSEMBLE SWIVEL STUDS		3-19-09	W/W
	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	3-17-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-09	W/W
670	FINAL INSPECTION A) HEADSPACE		3-19-09	W/W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.56</u> <u>2.55</u> <u>2.53</u> <u>2.64</u>	3-18-09	TL
	C) FUNCTION		3-19-09	W/W
690	PACK		3/21/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



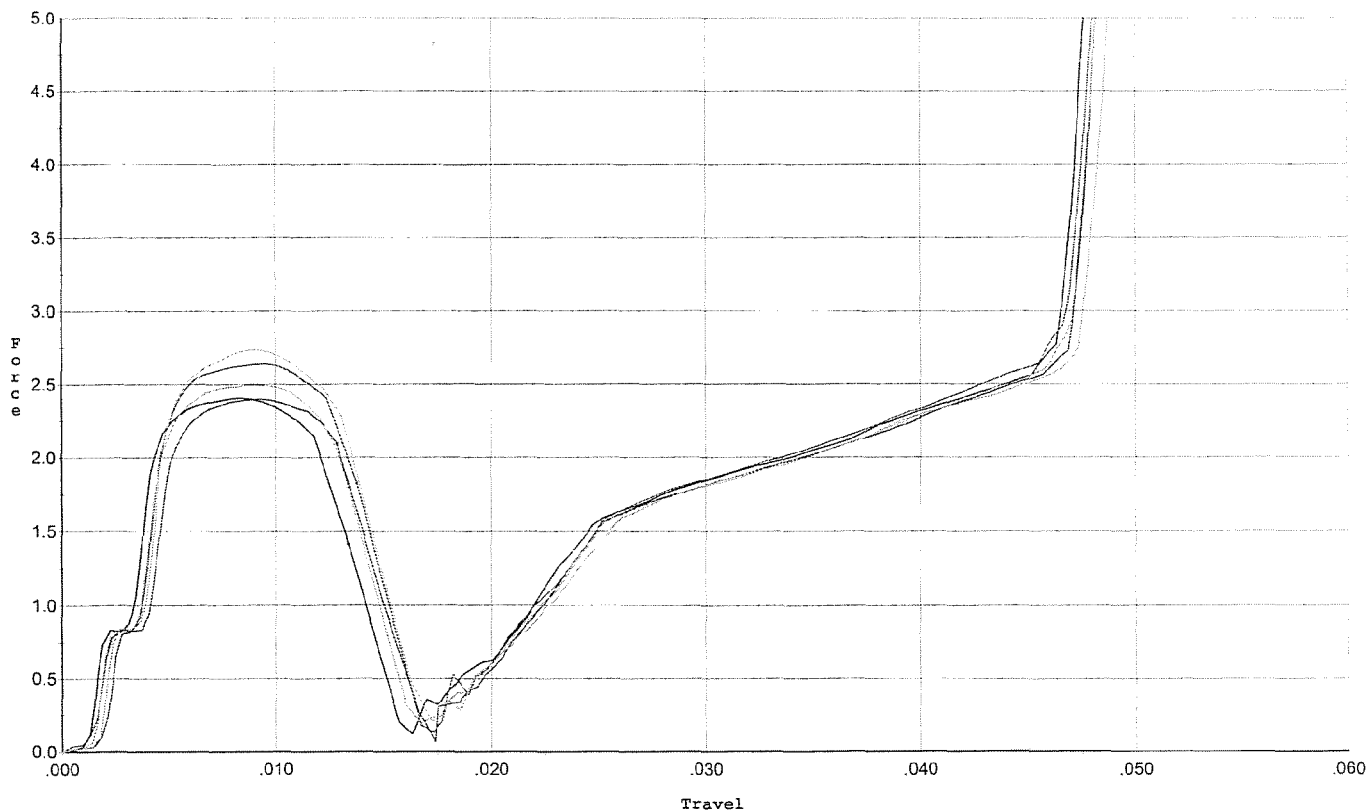
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.660	0.013	0.00	0.038	0.022		Set Trigger
2	2.755	0.013	0.00	0.037	0.024		Set Trigger
3	2.559	0.012	0.00	0.038	0.021		Set Trigger
4	2.633	0.013	0.00	0.038	0.022		Set Trigger
5	2.712	0.014	0.00	0.037	0.025		Set Trigger

A-2-66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



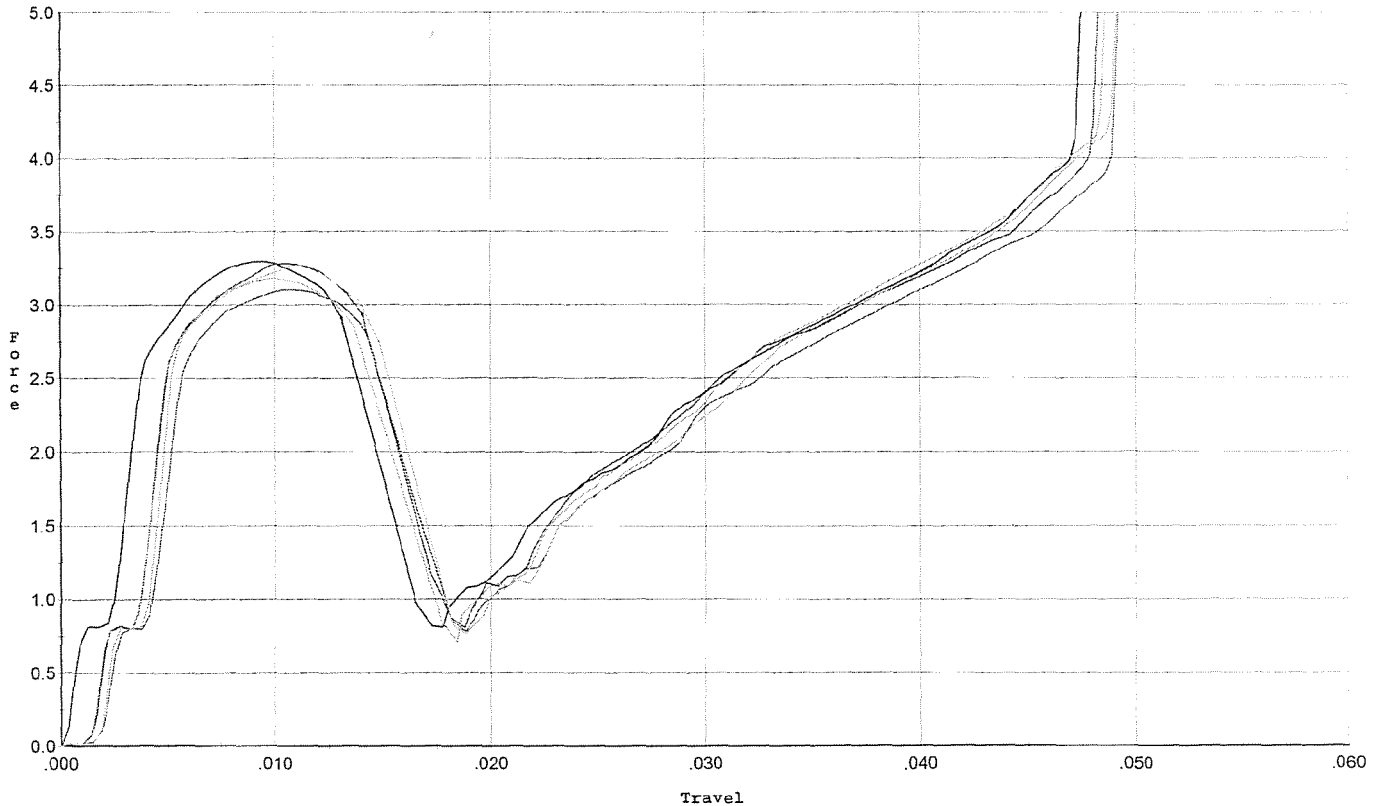
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.399	0.013	0.00	0.039	0.020		Set Trigger
2	2.406	0.013	0.00	0.039	0.021		Set Trigger
3	2.639	0.014	0.00	0.038	0.024		Set Trigger
4	2.735	0.013	0.00	0.039	0.023		Set Trigger
5	2.493	0.013	0.00	0.039	0.021		Set Trigger

A-253

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



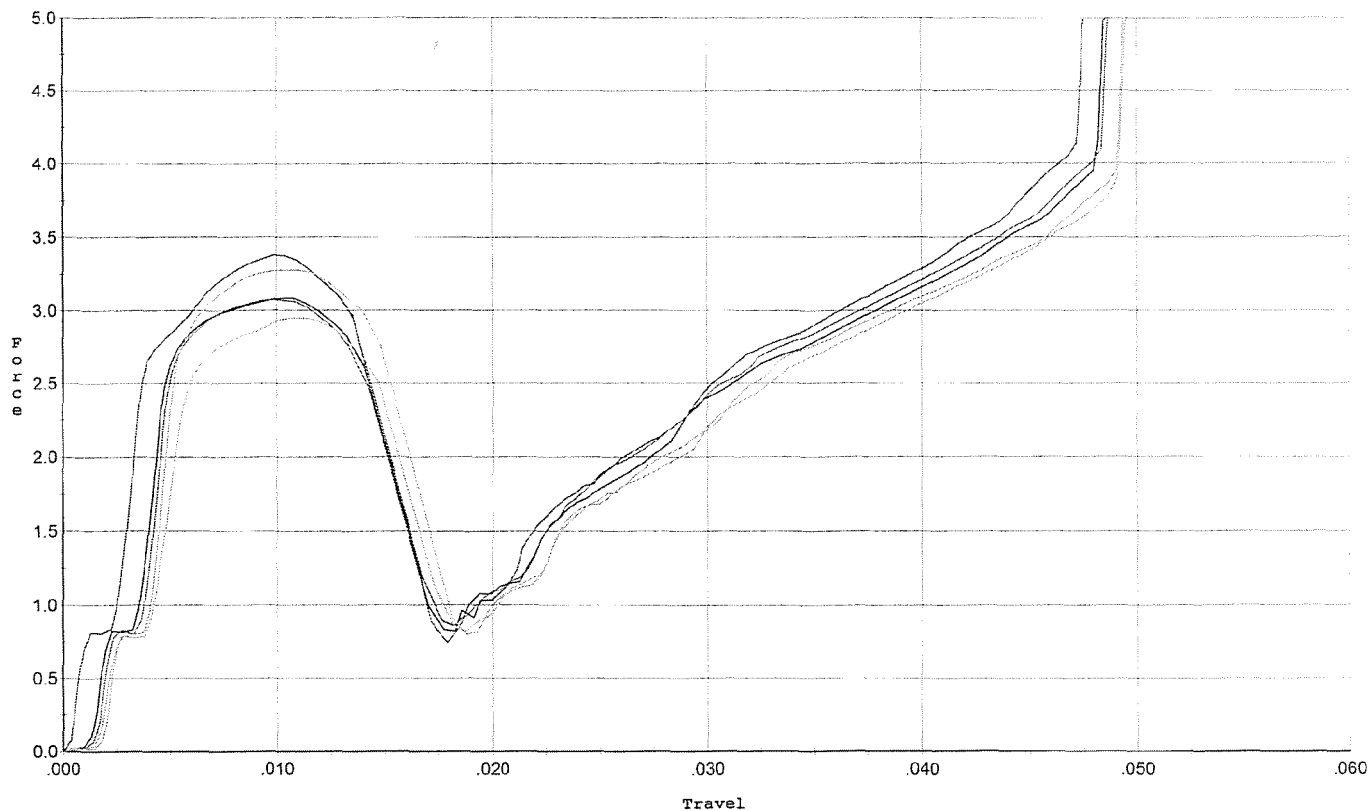
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.282	0.014	0.00	0.035	0.030		Set Trigger
2	3.295	0.013	0.00	0.035	0.030		Set Trigger
3	3.104	0.014	0.00	0.036	0.028		Set Trigger
4	3.273	0.015	0.00	0.036	0.031		Set Trigger
5	3.178	0.014	0.00	0.036	0.028		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



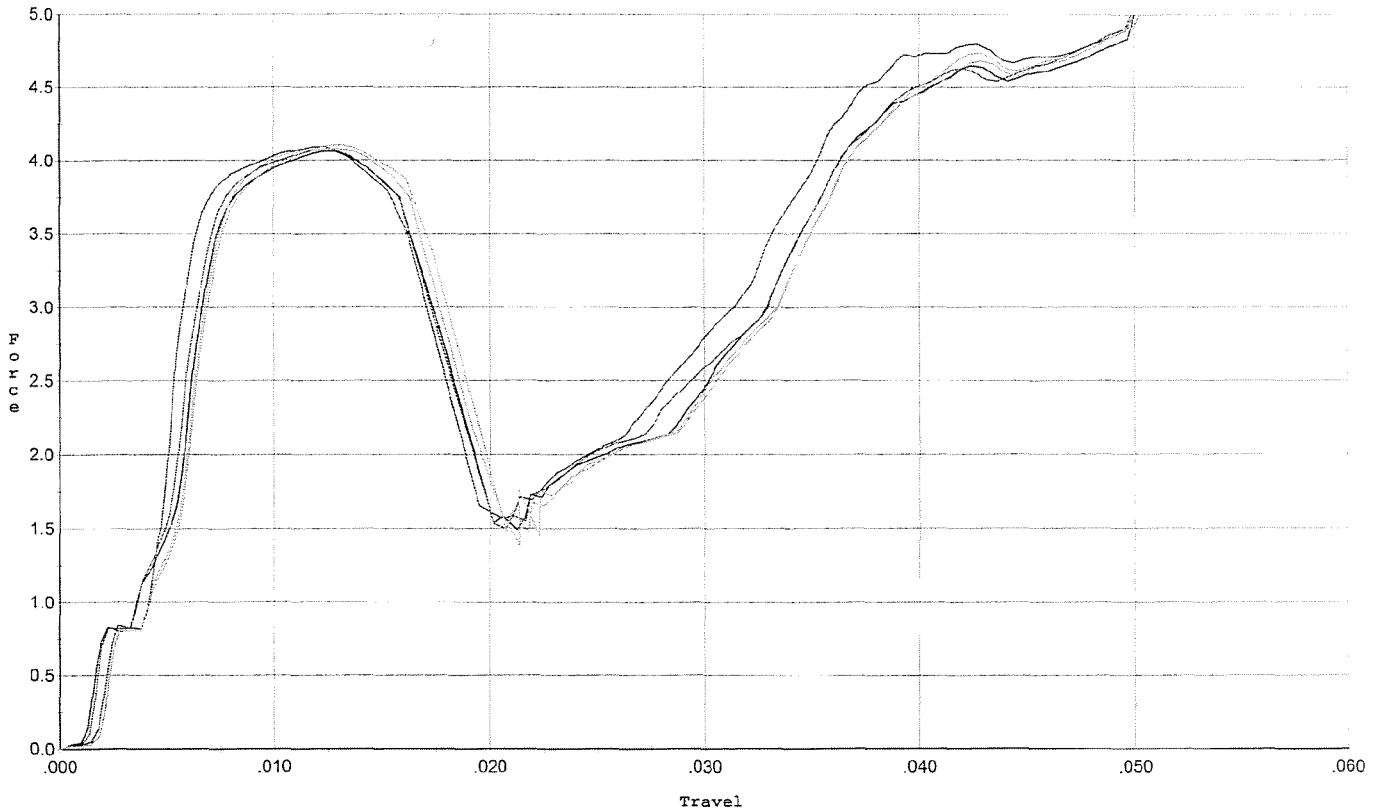
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.378	0.013	0.00	0.035	0.031		Set Trigger
2	3.084	0.014	0.00	0.036	0.029		Set Trigger
3	3.074	0.014	0.00	0.036	0.029		Set Trigger
4	2.950	0.015	0.00	0.036	0.028		Set Trigger
5	3.276	0.015	0.002	0.036	0.031		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



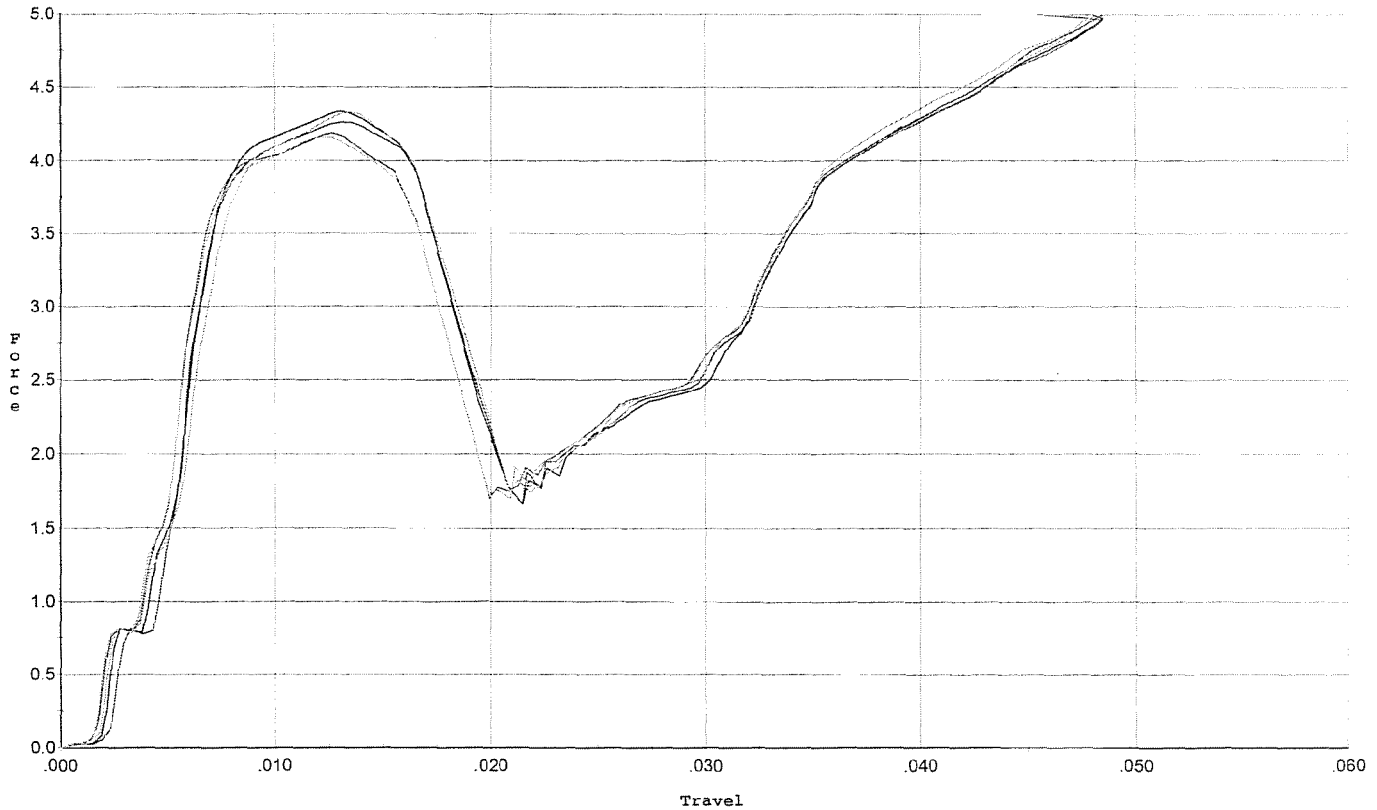
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.093	0.016	0.004	0.033	0.042		Set Trigger
2	4.064	0.018	0.00	0.033	0.044		Set Trigger
3	4.075	0.016	0.004	0.033	0.040		Set Trigger
4	4.081	0.016	0.004	0.033	0.041		Set Trigger
5	4.103	0.017	0.004	0.033	0.044		Set Trigger

A. 4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



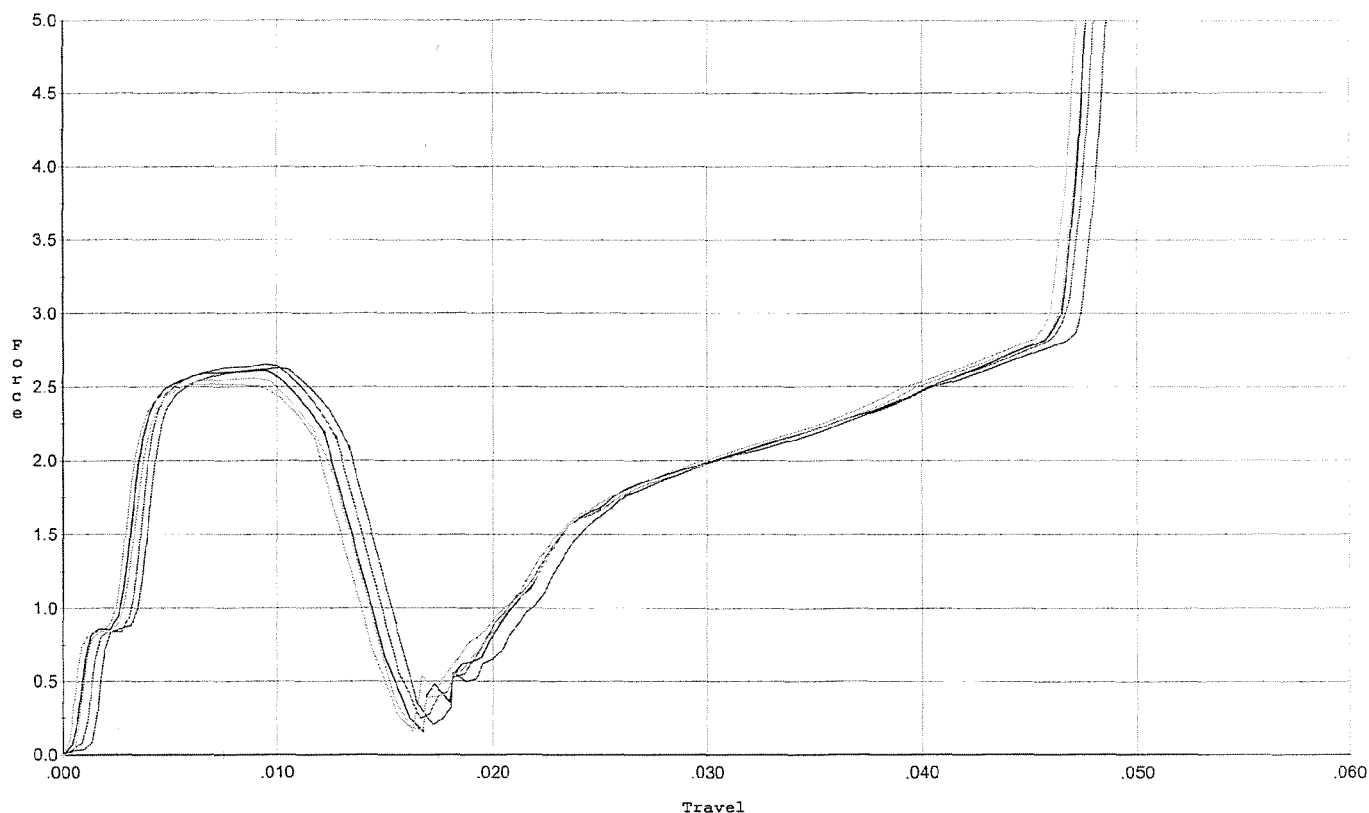
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.261	0.017	0.002	0.032	0.043		Set Trigger
2	4.334	0.017	0.004	0.032	0.044		Set Trigger
3	4.183	0.017	0.00	0.032	0.043		Set Trigger
4	4.158	0.017	0.00	0.032	0.043		Set Trigger
5	4.332	0.018	0.00	0.032	0.048		Set Trigger

A-4025

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



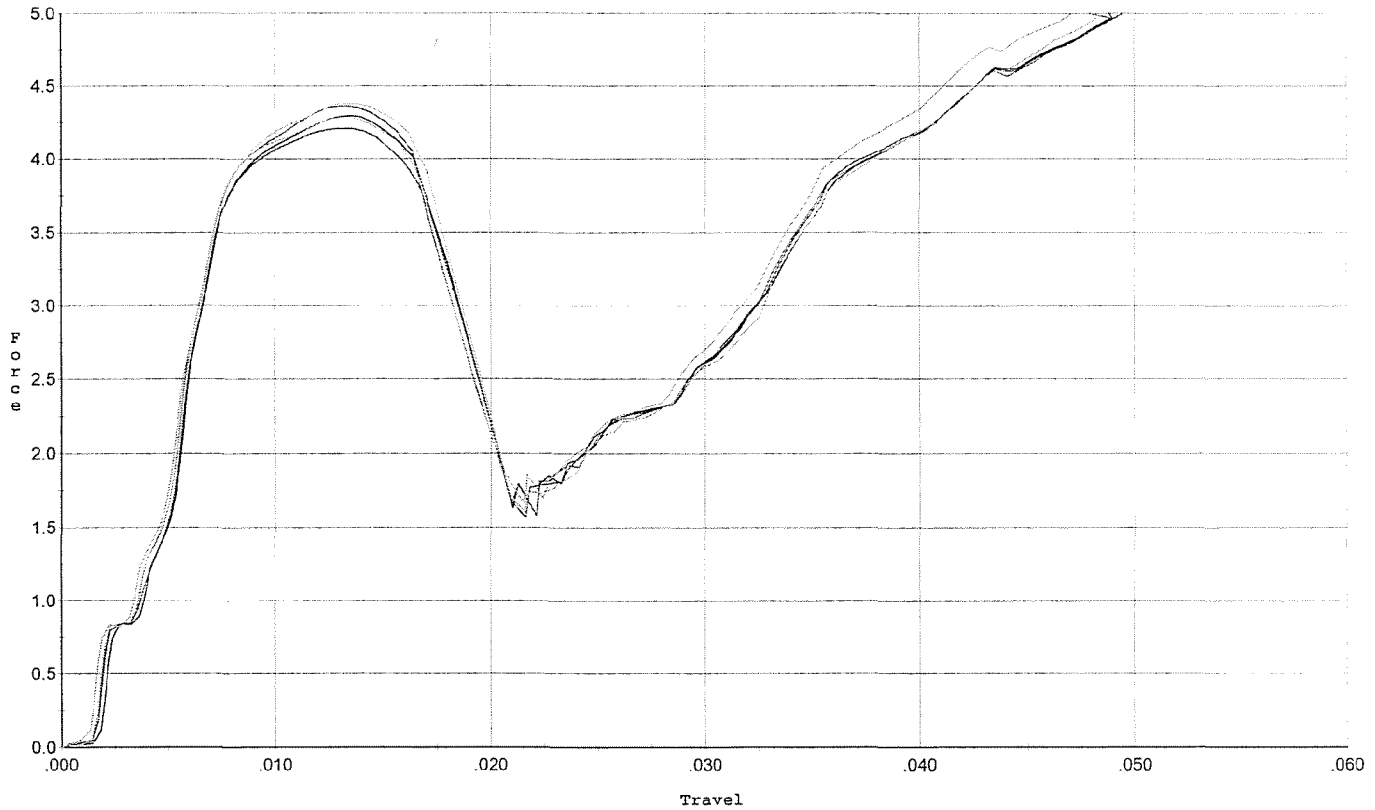
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.627	0.013	0.00	0.038	0.024		Set Trigger
2	2.609	0.012	0.00	0.038	0.023		Set Trigger
3	2.655	0.013	0.00	0.038	0.023		Set Trigger
4	2.561	0.013	0.00	0.038	0.022		Set Trigger
5	2.520	0.012	0.00	0.038	0.021		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs +/- 1.0 lb for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.209	0.017	0.00	0.033	0.044		Set Trigger
2	4.297	0.018	0.00	0.032	0.048		Set Trigger
3	4.363	0.018	0.00	0.032	0.050		Set Trigger
4	4.377	0.017	0.00	0.033	0.047		Set Trigger
5	4.285	0.017	0.00	0.032	0.045		Set Trigger

A-4.30