

5680 1457

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



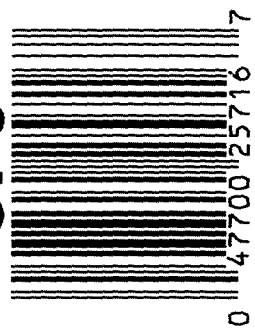
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801457

UPC



INSPECTION CHECKLIST NEW GUNS

GUN SERIAL #

G6801457

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	RIZ
480	MAGNAFLUX BBL ACTION		3/9/09	(D)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SPD
	D) OIL FIRING PIN ASSEMBLY		3-19-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

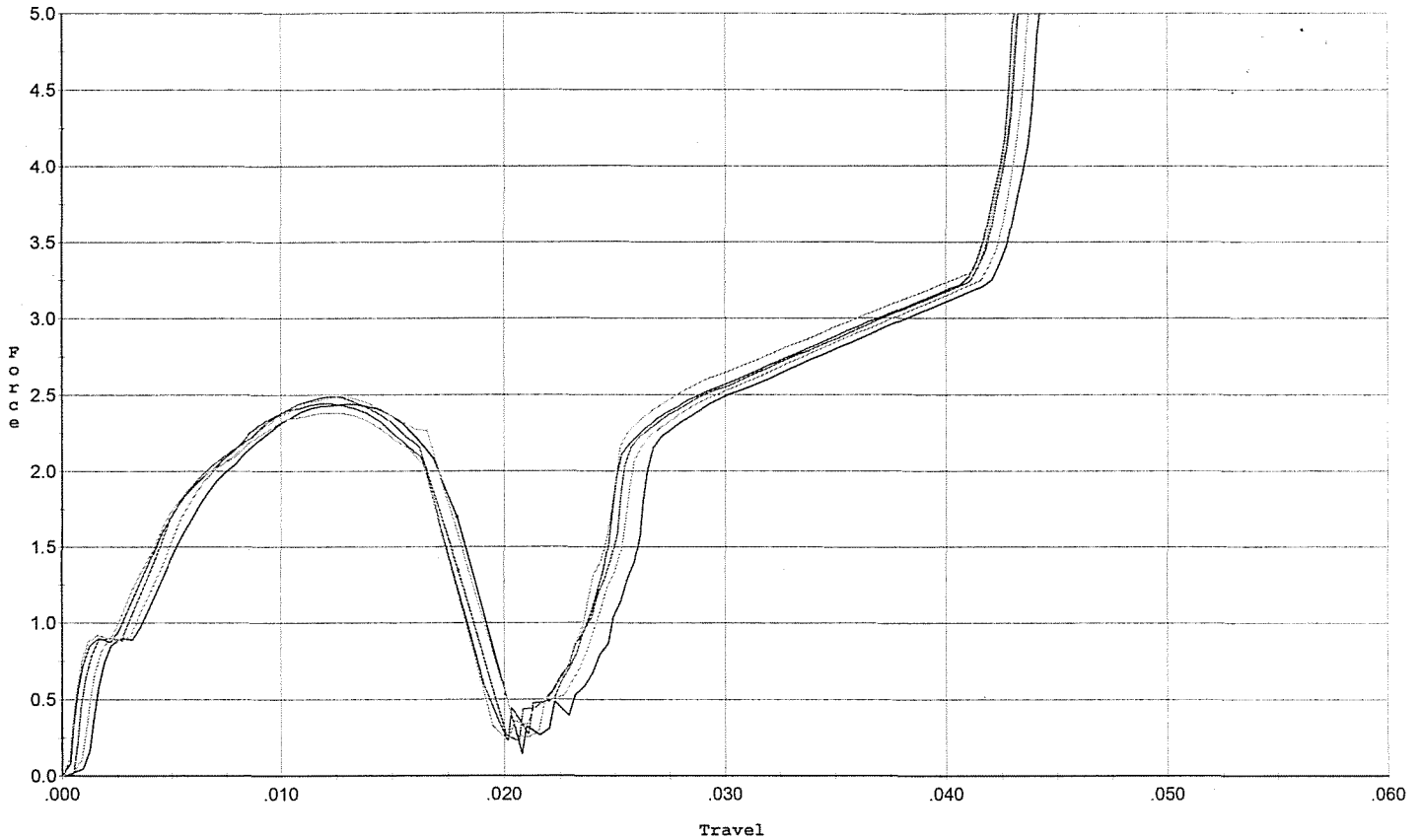
BARBER - M24 0015512

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-23-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	3-23-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-23-09	WV
	J) ASSEMBLE STOCK		3-19-09	LD
	K) ASSEMBLE SWIVEL STUDS		3-23-09	WV
	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	3-23-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-23-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.33</u> <u>2.26</u> <u>2.23</u> <u>2.20</u> <u>2.25</u>	3-23-09	TL
	C) FUNCTION		3-23-09	WV
690	PACK		3/23/09	Fmy

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



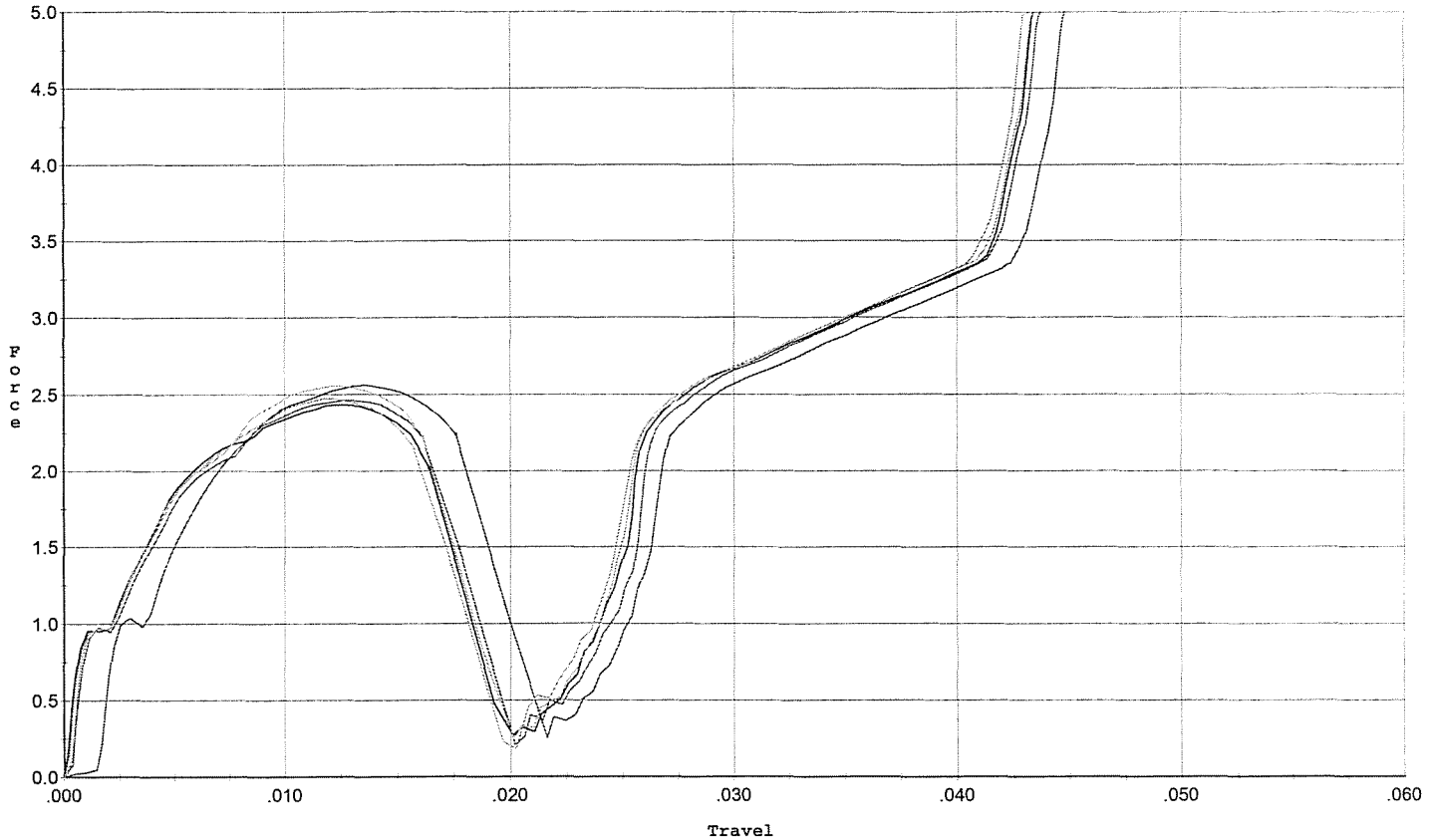
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.442	0.016	0.00	0.030	0.029		Set Trigger
2	2.439	0.018	0.00	0.030	0.030		Set Trigger
3	2.490	0.018	0.00	0.029	0.031		Set Trigger
4	2.493	0.017	0.00	0.030	0.029		Set Trigger
5	2.382	0.016	0.00	0.030	0.029		Set Trigger

A. 2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



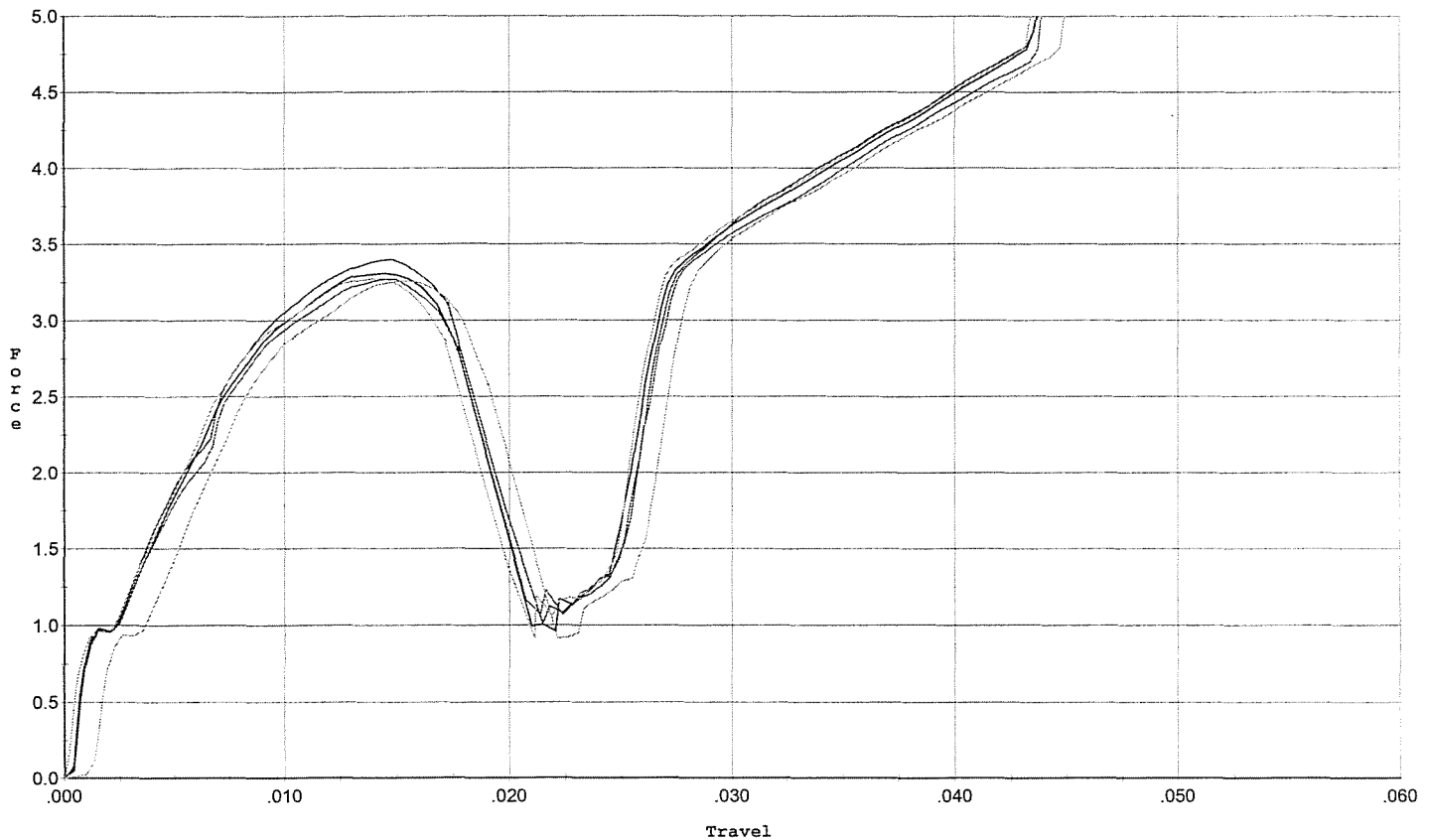
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.565	0.018	0.00	0.030	0.031		Set Trigger
2	2.434	0.016	0.00	0.030	0.030		Set Trigger
3	2.462	0.018	0.00	0.030	0.032		Set Trigger
4	2.557	0.016	0.00	0.030	0.030		Set Trigger
5	2.474	0.017	0.00	0.029	0.031		Set Trigger

A-2-49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



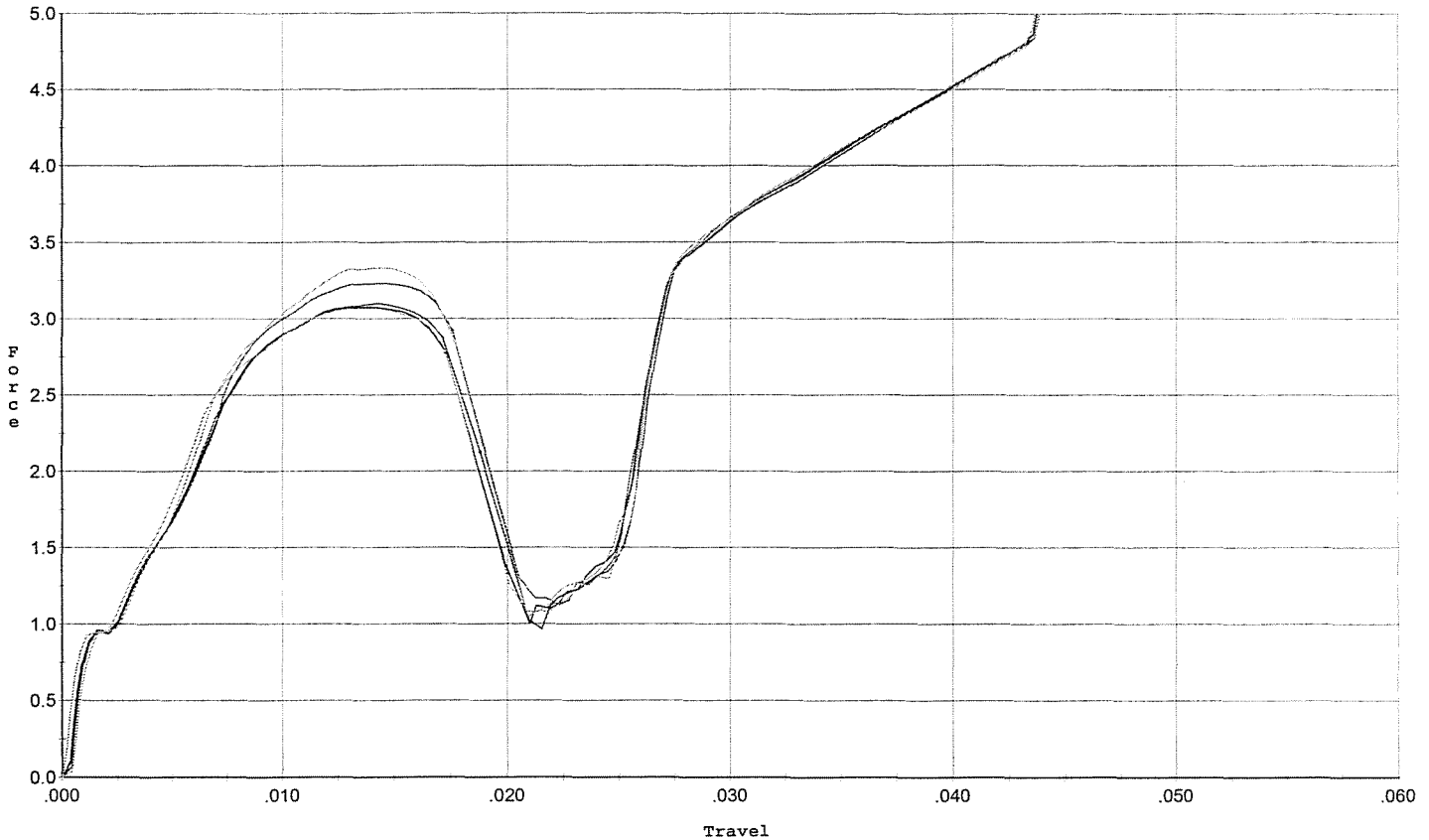
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.401	0.017	0.00	0.027	0.039		Set Trigger
2	3.309	0.018	0.00	0.027	0.040		Set Trigger
3	3.272	0.018	0.00	0.027	0.039		Set Trigger
4	3.273	0.017	0.00	0.027	0.038		Set Trigger
5	3.258	0.019	0.00	0.028	0.040		Set Trigger

A 3.30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



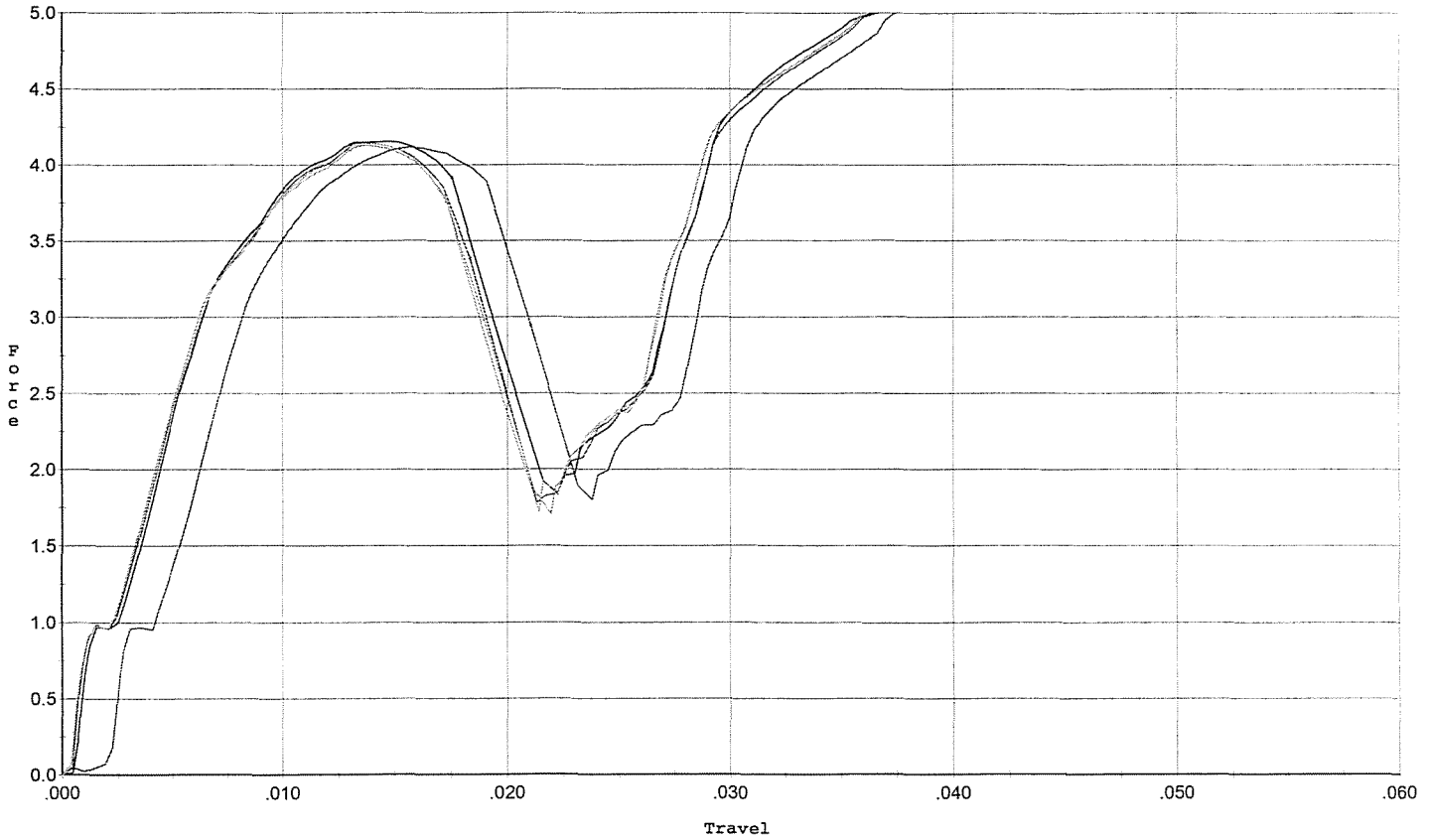
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.019	0.00	0.027	0.040		Set Trigger
2	3.074	0.017	0.00	0.027	0.037		Set Trigger
3	3.231	0.018	0.00	0.027	0.039		Set Trigger
4	3.334	0.018	0.00	0.027	0.039		Set Trigger
5	3.068	0.017	0.00	0.027	0.037		Set Trigger

A.3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



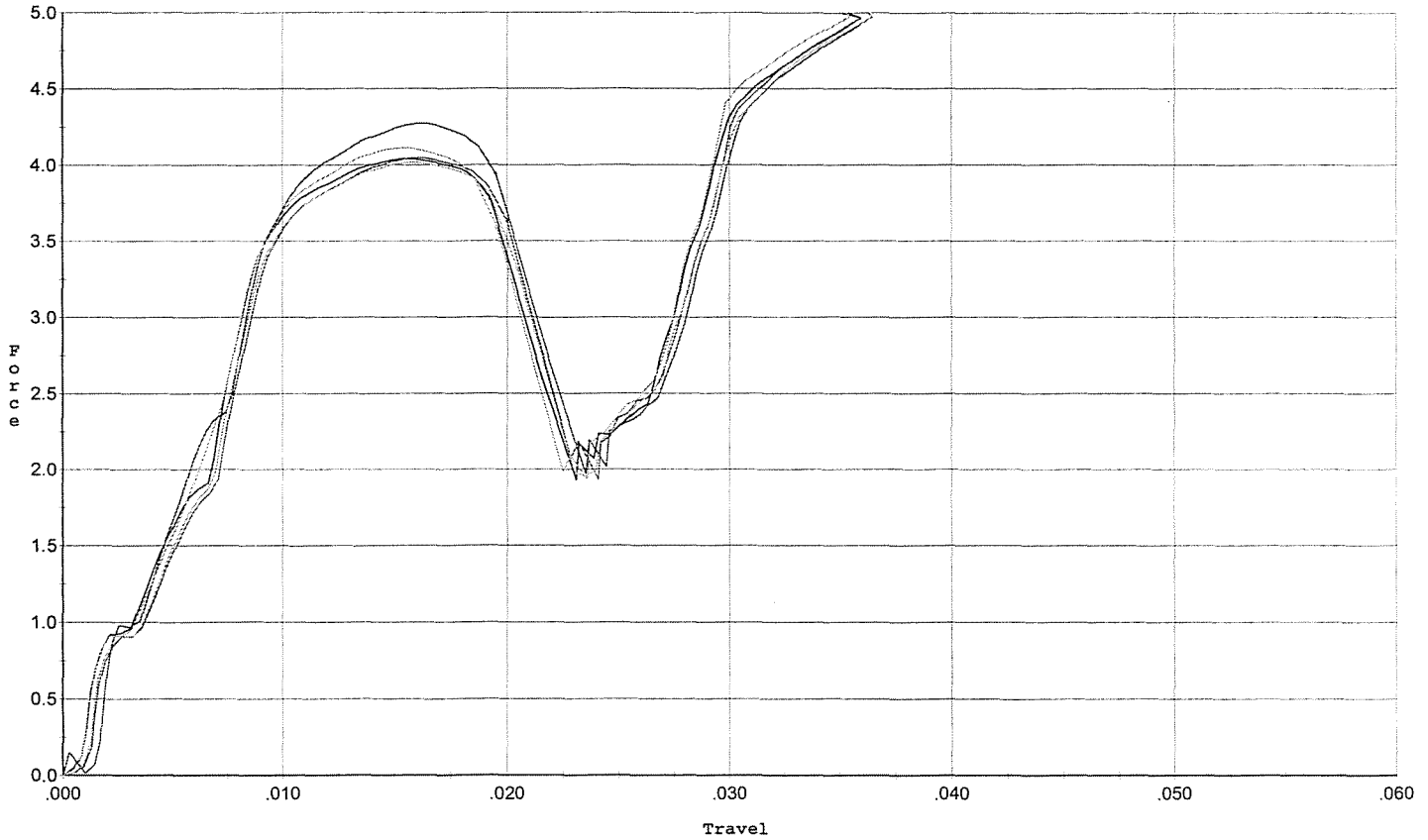
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.021	0.004	0.018	0.054		Set Trigger
2	4.156	0.018	0.00	0.022	0.049		Set Trigger
3	4.147	0.018	0.00	0.022	0.051		Set Trigger
4	4.138	0.017	0.00	0.022	0.048		Set Trigger
5	4.131	0.019	0.00	0.022	0.052		Set Trigger

A. 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



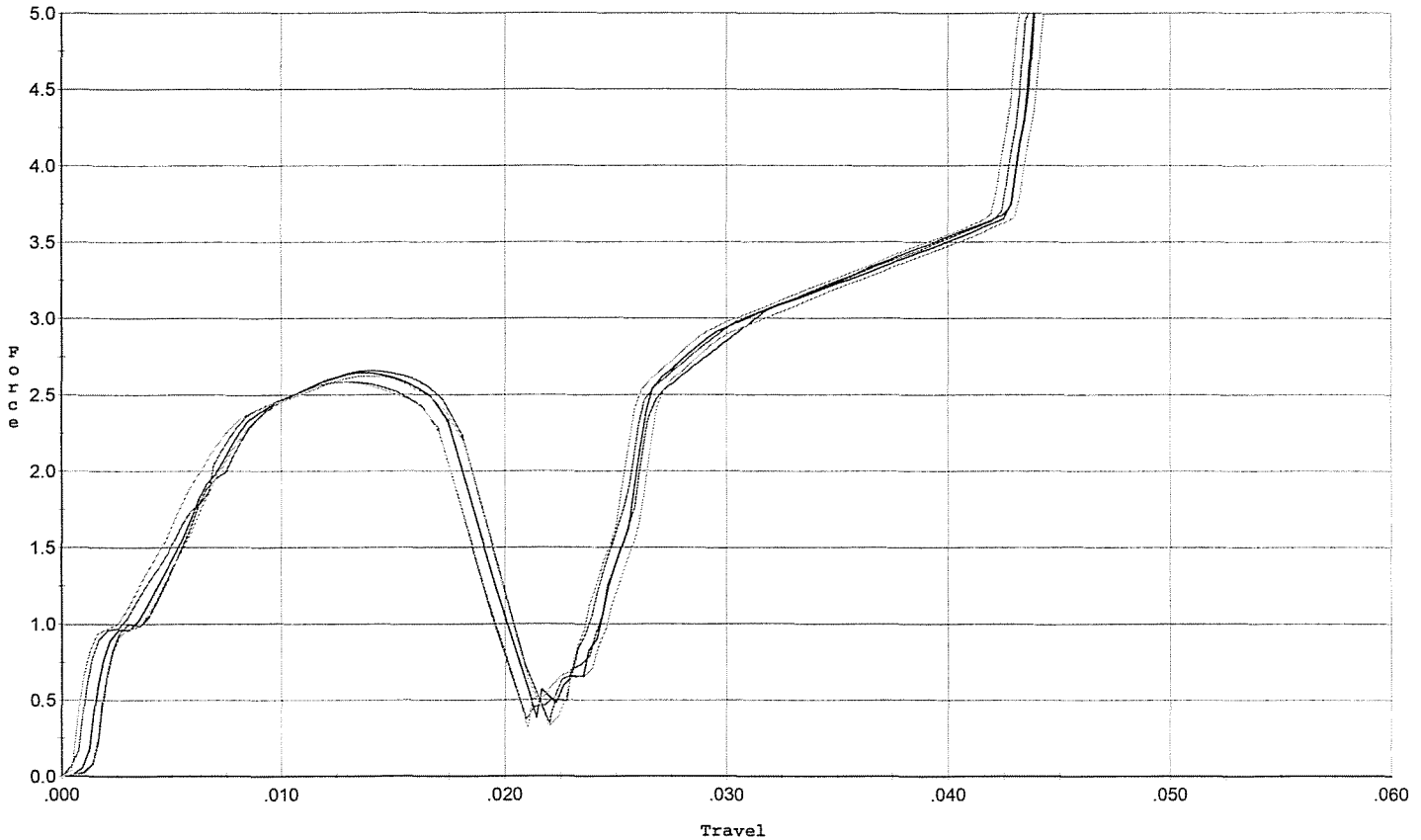
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.273	0.020	0.00	0.025	0.053		Set Trigger
2	4.042	0.019	0.00	0.025	0.050		Set Trigger
3	4.049	0.020	0.00	0.024	0.051		Set Trigger
4	4.019	0.020	0.00	0.024	0.053		Set Trigger
5	4.111	0.020	0.00	0.024	0.052		Set Trigger

A. 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



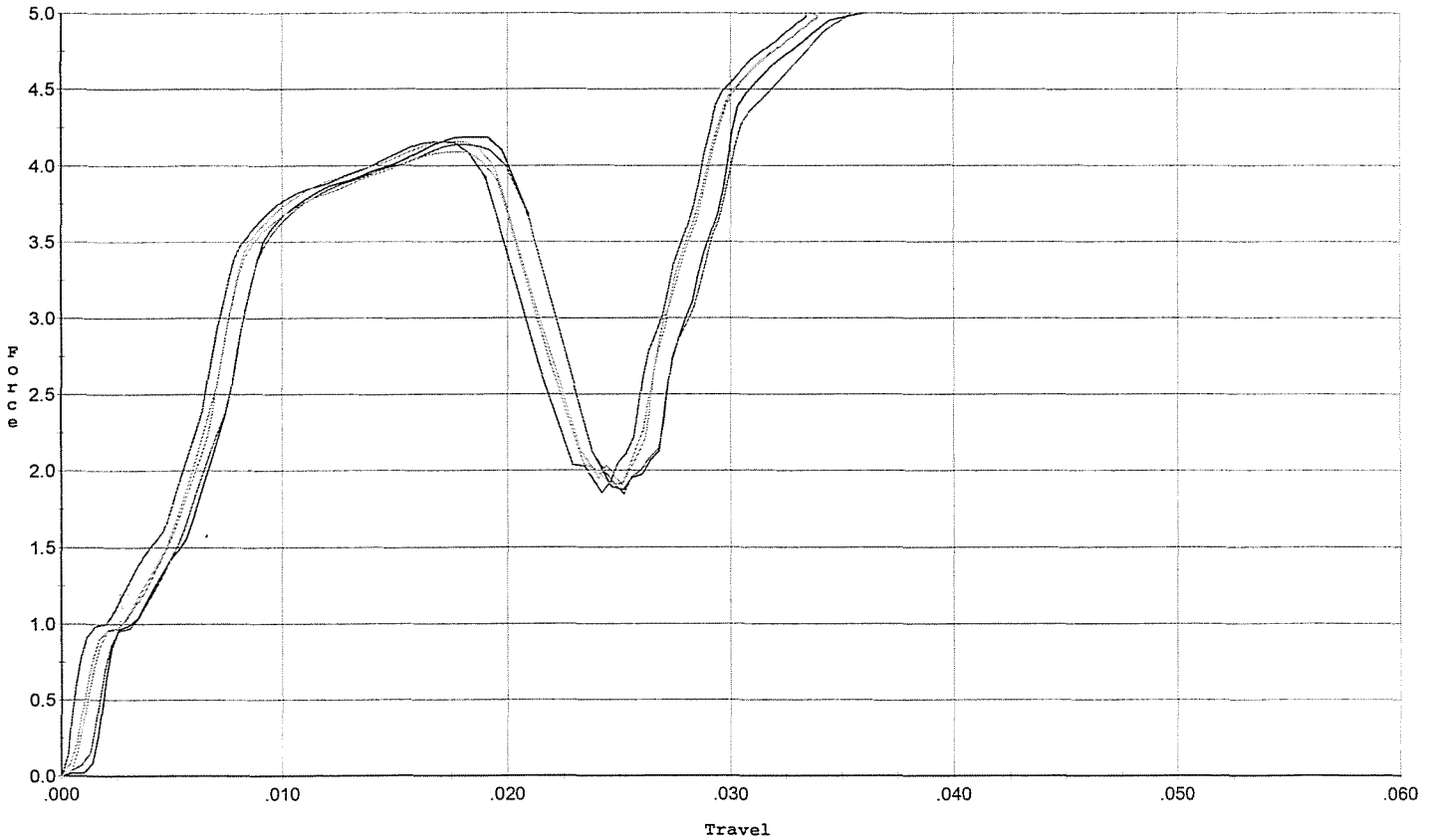
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.658	0.018	0.00	0.028	0.032		Set Trigger
2	2.644	0.017	0.00	0.029	0.031		Set Trigger
3	2.586	0.017	0.00	0.029	0.031		Set Trigger
4	2.623	0.018	0.00	0.028	0.032		Set Trigger
5	2.585	0.017	0.00	0.028	0.032		Set Trigger

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Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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	4.157	0.019	0.00	0.025	0.053		Set Trigger
2	4.188	0.021	0.00	0.025	0.056		Set Trigger
3	4.138	0.021	0.00	0.025	0.056		Set Trigger
4	4.160	0.019	0.00	0.025	0.053		Set Trigger
5	4.092	0.020	0.00	0.025	0.053		Set Trigger

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