

G6801487

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



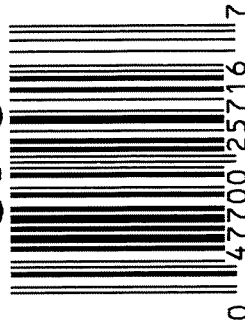
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801487

UPC



GUN SERIAL # G 6801487

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	RT
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	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-20-09	L. D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

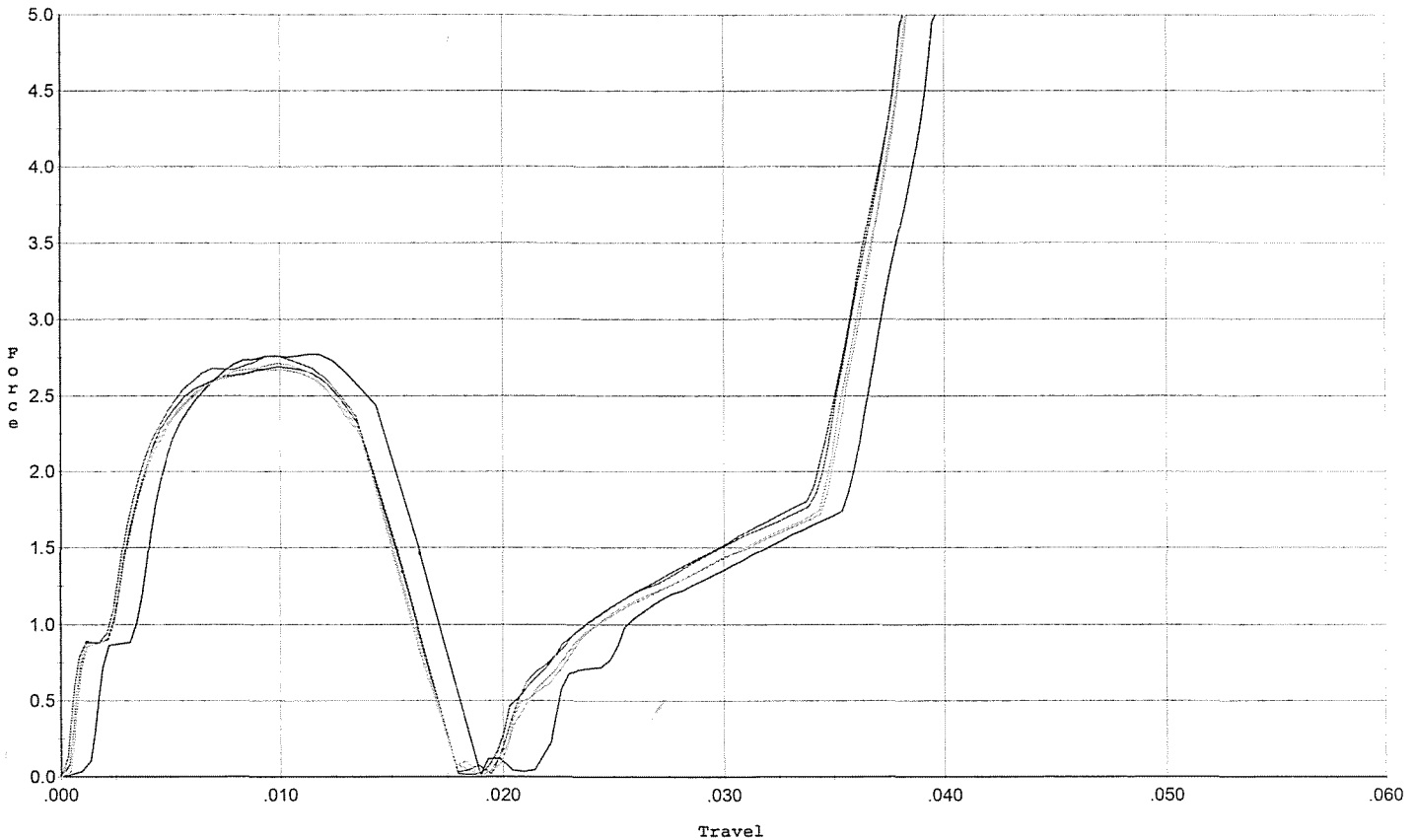
F004 REV 5/2006

BARBER - M24 0015871									
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	2.2	2.2	2.2	3/23/09	RP		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	3.4	3.4	3.4	3/23/09	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.022	.022	.022	3/23/09	RP		
	J) ASSEMBLE STOCK					3-20-09	N/A		
	K) ASSEMBLE SWIVEL STUDS					3-20-09	RP		
	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		PASS	FAIL		3-23-09	TL		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION			N/A			
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					3-23-09	N/A		
670	FINAL INSPECTION A) HEADSPACE					3/23/09	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.46	2.43	2.43	2.34	2.39	3-23-09	TL
	C) FUNCTION					3/23/09	RP		
690	PACK					3/24/09	FM		

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



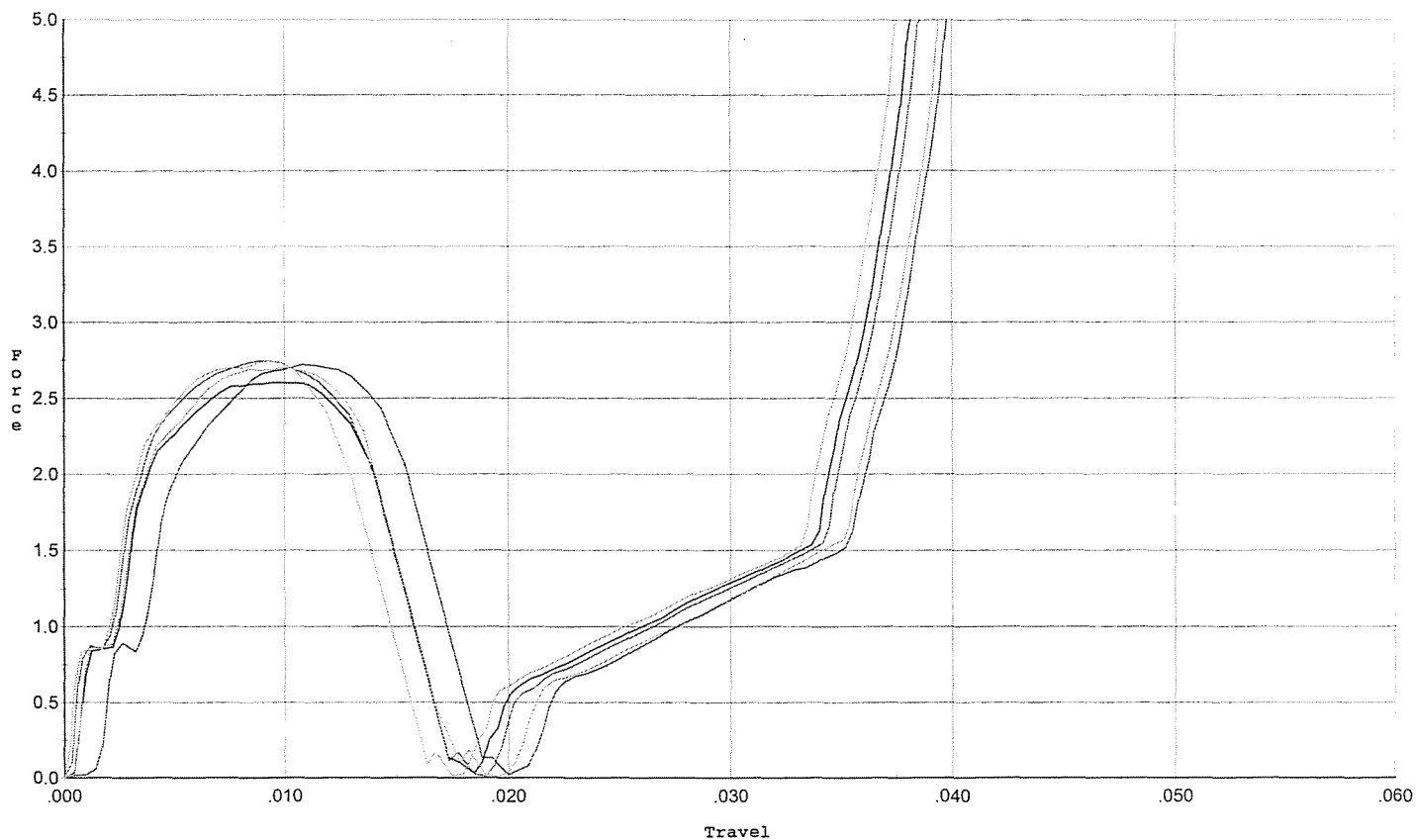
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.692	0.015	0.00	0.028	0.030		Set Trigger
2	2.774	0.016	0.00	0.029	0.030		Set Trigger
3	2.766	0.015	0.00	0.028	0.030		Set Trigger
4	2.673	0.014	0.00	0.029	0.026		Set Trigger
5	2.712	0.014	0.00	0.029	0.026		Set Trigger

A-2.72

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



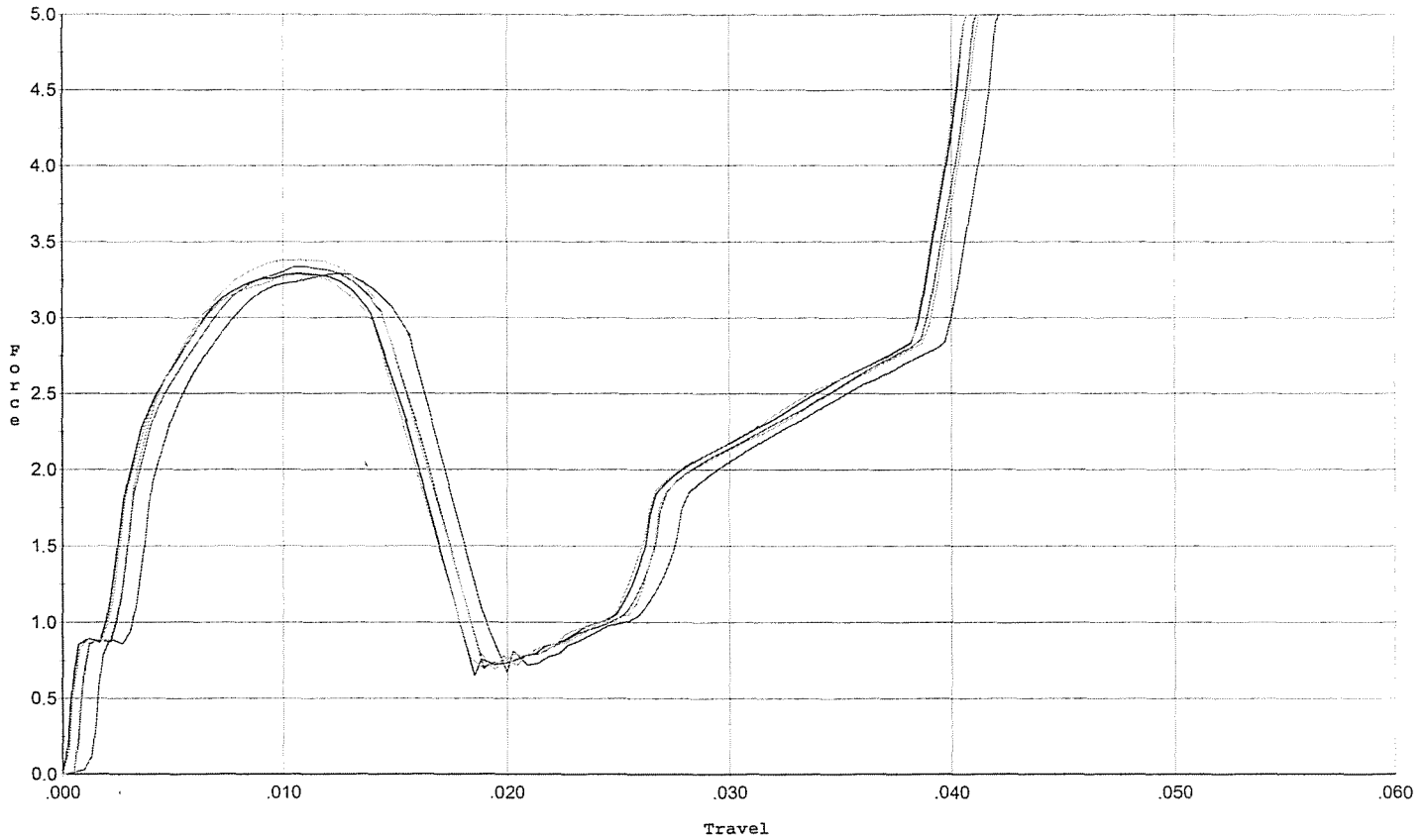
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.720	0.015	0.00	0.029	0.028		Set Trigger
2	2.604	0.014	0.00	0.029	0.026		Set Trigger
3	2.743	0.014	0.00	0.030	0.027		Set Trigger
4	2.746	0.013	0.00	0.030	0.025		Set Trigger
5	2.701	0.014	0.00	0.031	0.026		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- 1.0 lb



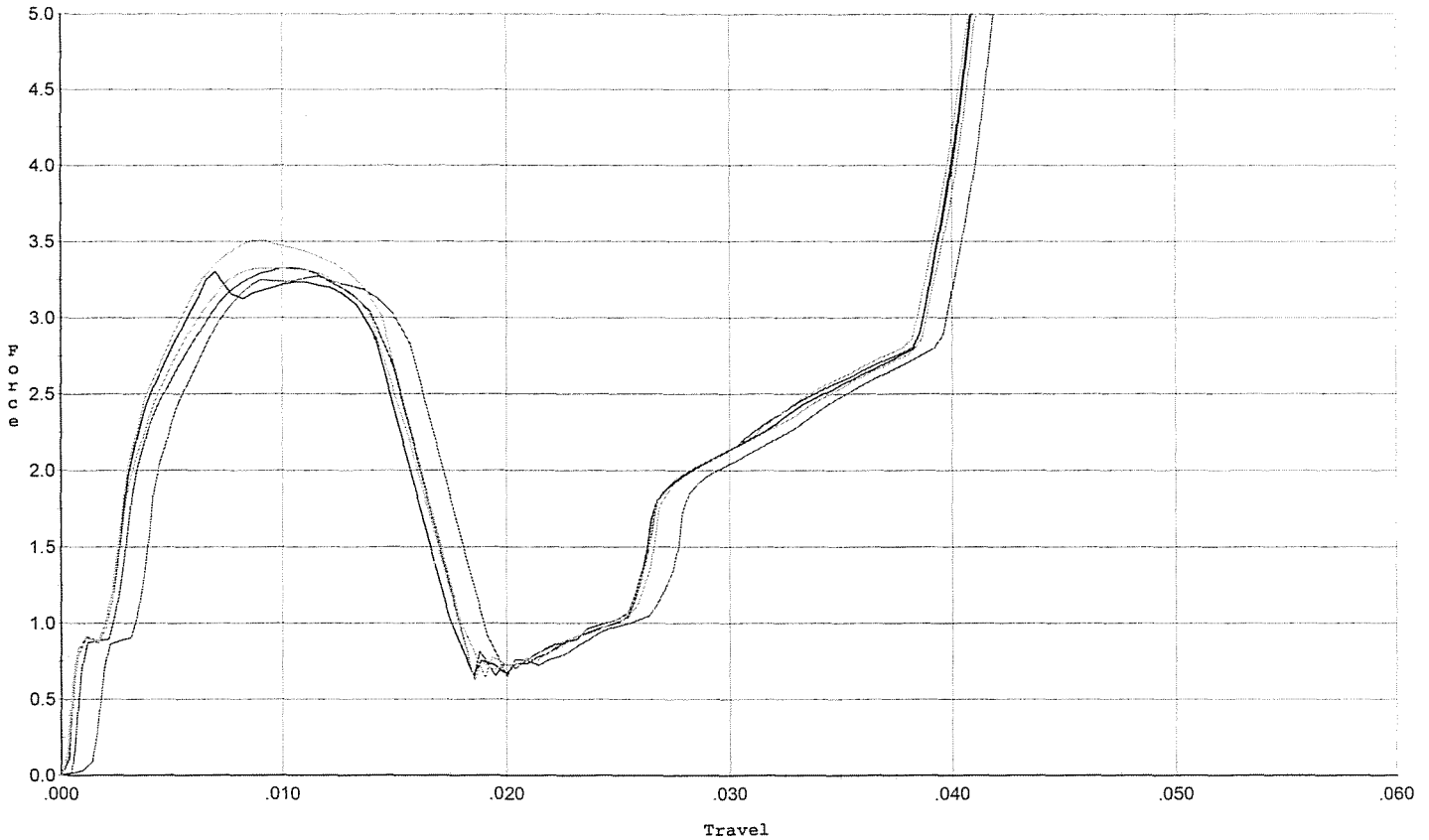
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.289	0.016	0.00	0.029	0.035		Set Trigger
2	3.292	0.015	0.00	0.028	0.036		Set Trigger
3	3.336	0.016	0.00	0.028	0.037		Set Trigger
4	3.382	0.017	0.00	0.028	0.039		Set Trigger
5	3.281	0.016	0.00	0.028	0.037		Set Trigger

A-3.31

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs after 20 cycles+/- 1.0 lb



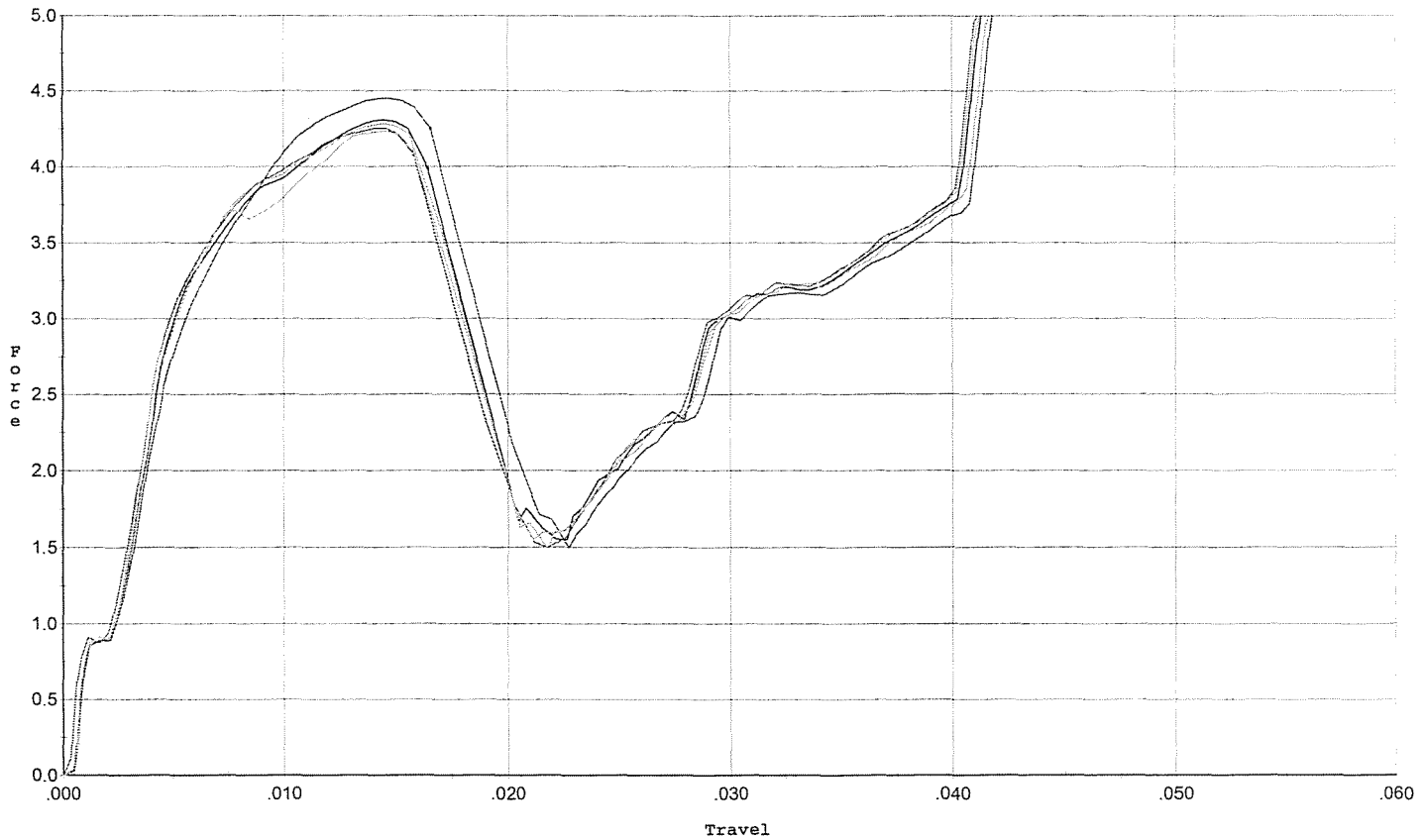
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.329	0.015	0.00	0.029	0.034		Set Trigger
2	3.305	0.014	0.00	0.029	0.033		Set Trigger
3	3.272	0.016	0.00	0.029	0.034		Set Trigger
4	3.326	0.016	0.00	0.028	0.037		Set Trigger
5	3.510	0.014	0.00	0.029	0.036		Set Trigger

A.3.34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



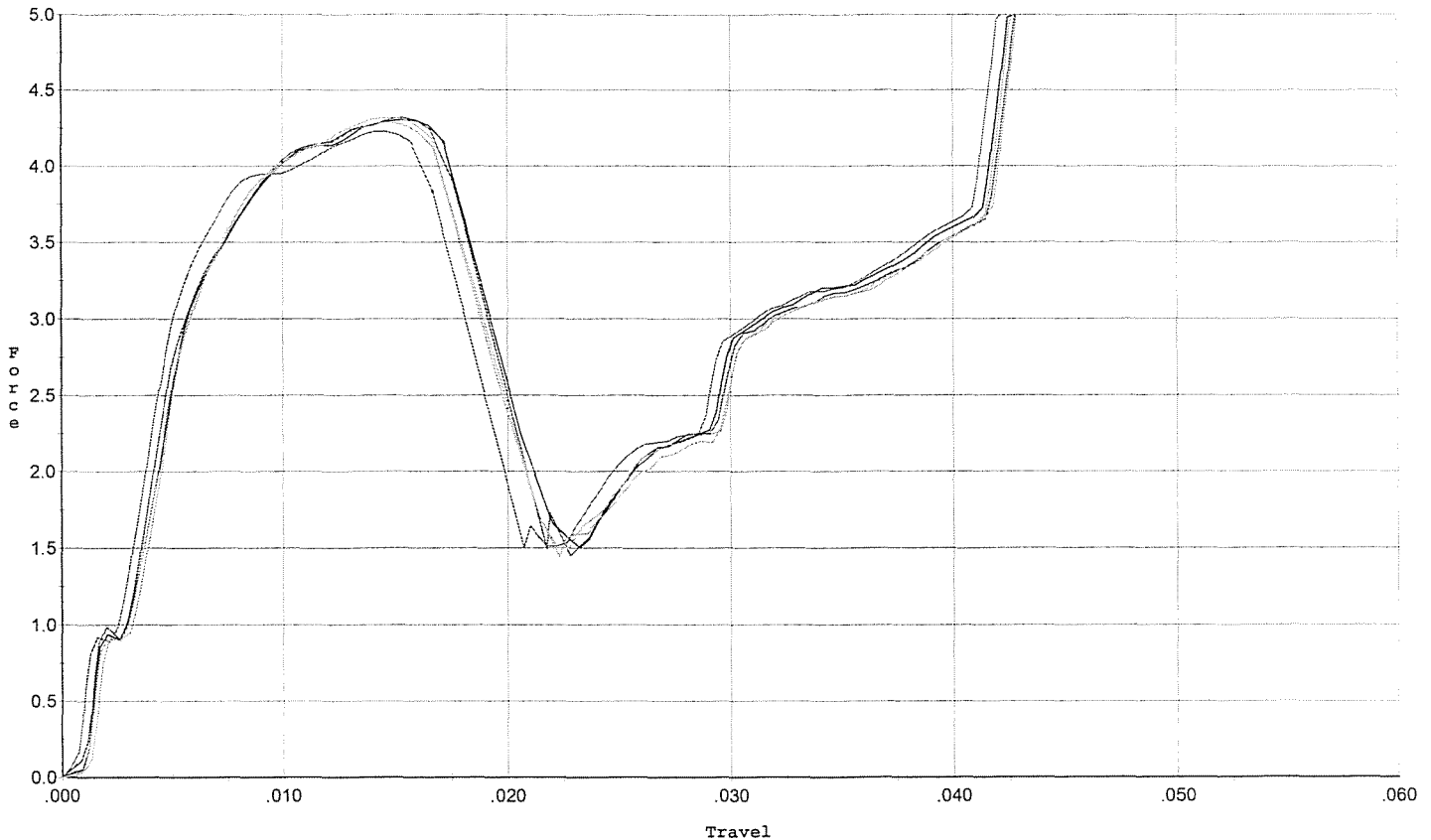
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.448	0.017	0.00	0.025	0.048		Set Trigger
2	4.309	0.016	0.00	0.025	0.047		Set Trigger
3	4.253	0.016	0.00	0.026	0.045		Set Trigger
4	4.233	0.018	0.00	0.026	0.050		Set Trigger
5	4.283	0.017	0.00	0.025	0.049		Set Trigger

A. 4.30

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/19/2009

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



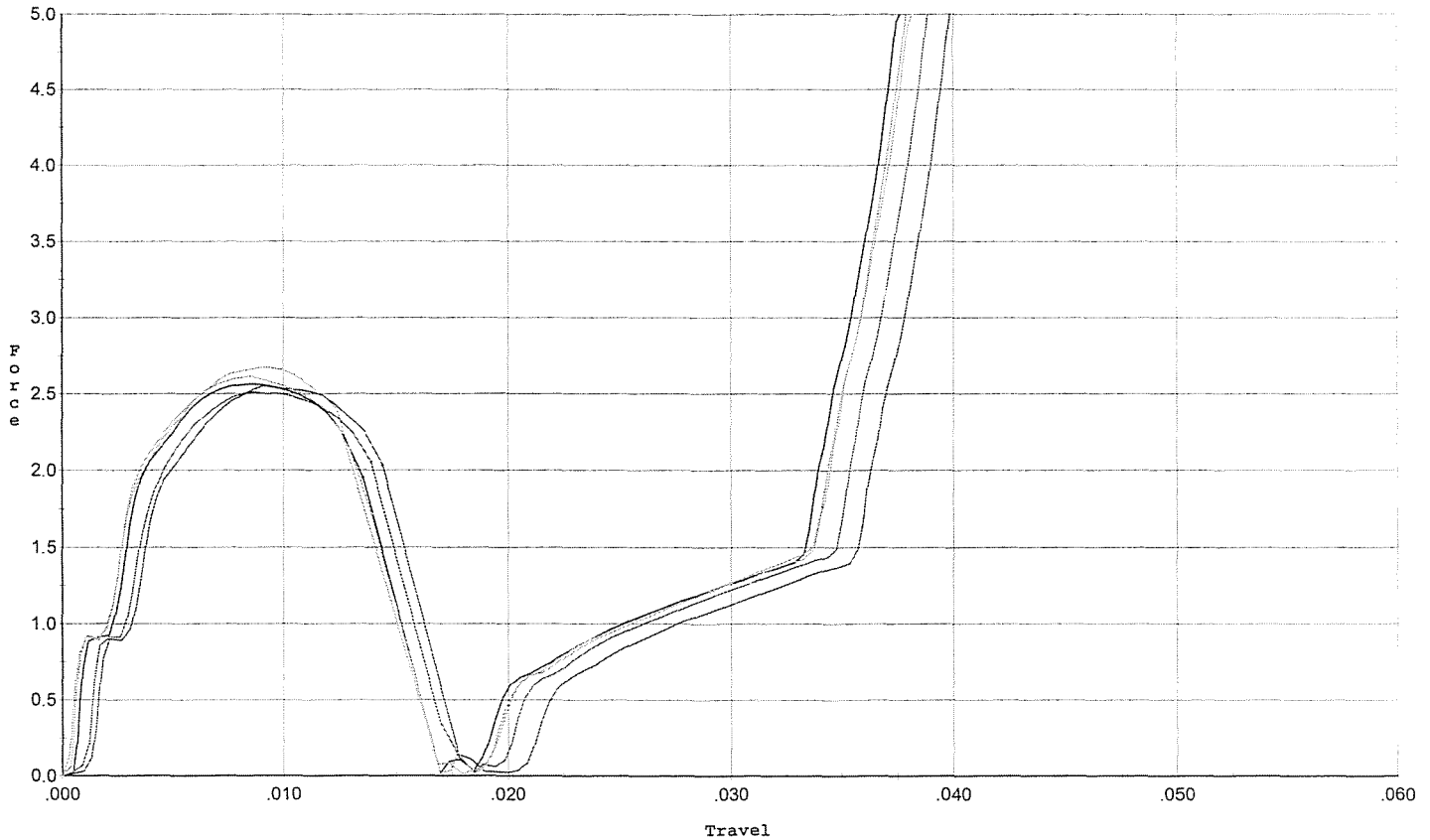
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.317	0.018	0.00	0.026	0.050		Set Trigger
2	4.303	0.017	0.00	0.026	0.049		Set Trigger
3	4.226	0.017	0.00	0.026	0.048		Set Trigger
4	4.320	0.019	0.00	0.026	0.054		Set Trigger
5	4.288	0.017	0.00	0.026	0.047		Set Trigger

A-4.29

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



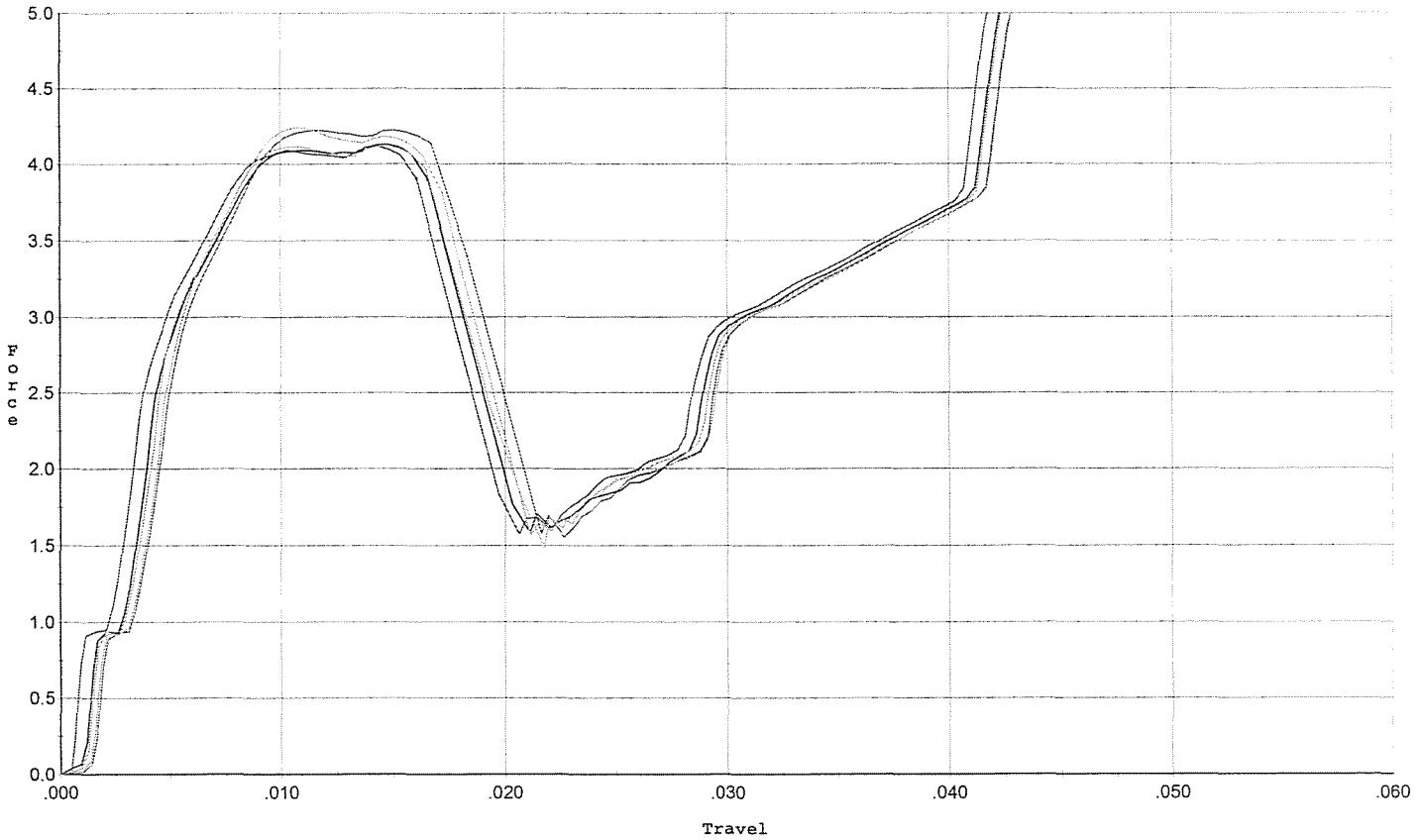
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.553	0.014	0.00	0.031	0.025		Set Trigger
2	2.564	0.014	0.00	0.029	0.025		Set Trigger
3	2.509	0.014	0.00	0.030	0.024		Set Trigger
4	2.614	0.015	0.00	0.030	0.028		Set Trigger
5	2.671	0.014	0.00	0.030	0.027		Set Trigger

A-258

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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	4.119	0.016	0.00	0.026	0.046		Set Trigger
2	4.130	0.017	0.00	0.027	0.046		Set Trigger
3	4.224	0.018	0.00	0.026	0.051		Set Trigger
4	4.115	0.016	0.00	0.027	0.046		Set Trigger
5	4.241	0.017	0.00	0.027	0.048		Set Trigger

A. 4.16