

BARBER - M24 0016240

G6807675

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



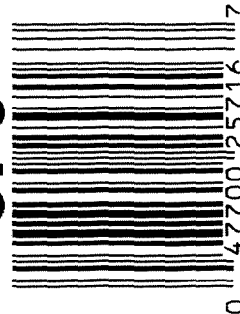
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807675

UPC



GUN SERIAL #

G 6807675

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RTZ
472	SERIALIZE BOLT HANDLE		3-6-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION		3/9/09	(P)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	na
542	APPLY COATINGS (BARREL ACTION)		3-20	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-34-09	LW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

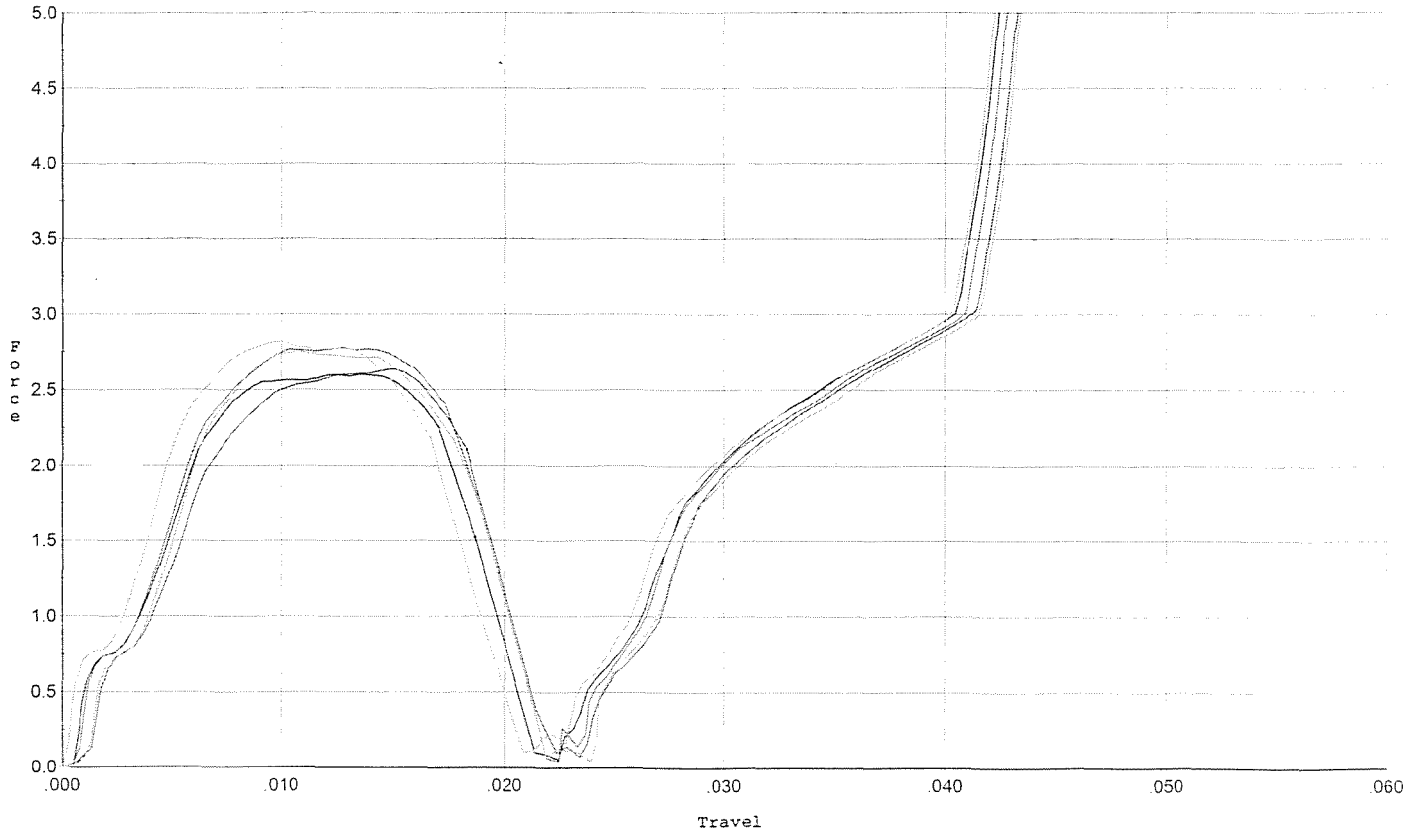
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	3-26-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-26-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-26-09	WV
	J) ASSEMBLE STOCK		3-24-09	WV
	K) ASSEMBLE SWIVEL STUDS		3-26-09	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	3-25-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-25-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-26-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.47</u> <u>2.49</u> <u>2.50</u> <u>2.54</u>	3-25-09	TL
	C) FUNCTION		3-26-09	WV
690	PACK		3/27/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



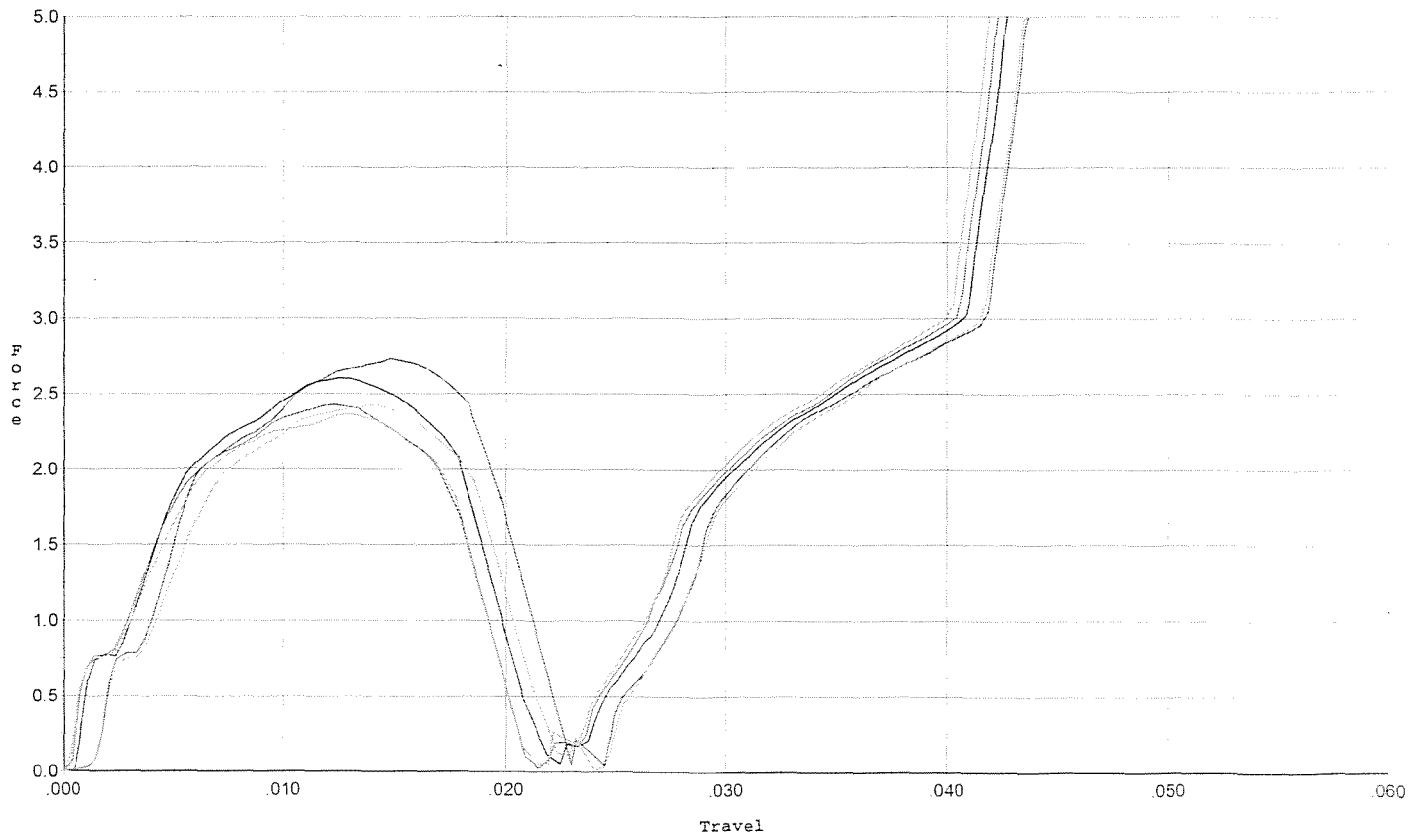
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.637	0.018	0.00	0.029	0.033		Set Trigger
2	2.601	0.019	0.00	0.029	0.034		Set Trigger
3	2.777	0.019	0.00	0.028	0.036		Set Trigger
4	2.820	0.017	0.00	0.029	0.033		Set Trigger
5	2.751	0.019	0.00	0.029	0.035		Set Trigger

A-2.71

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



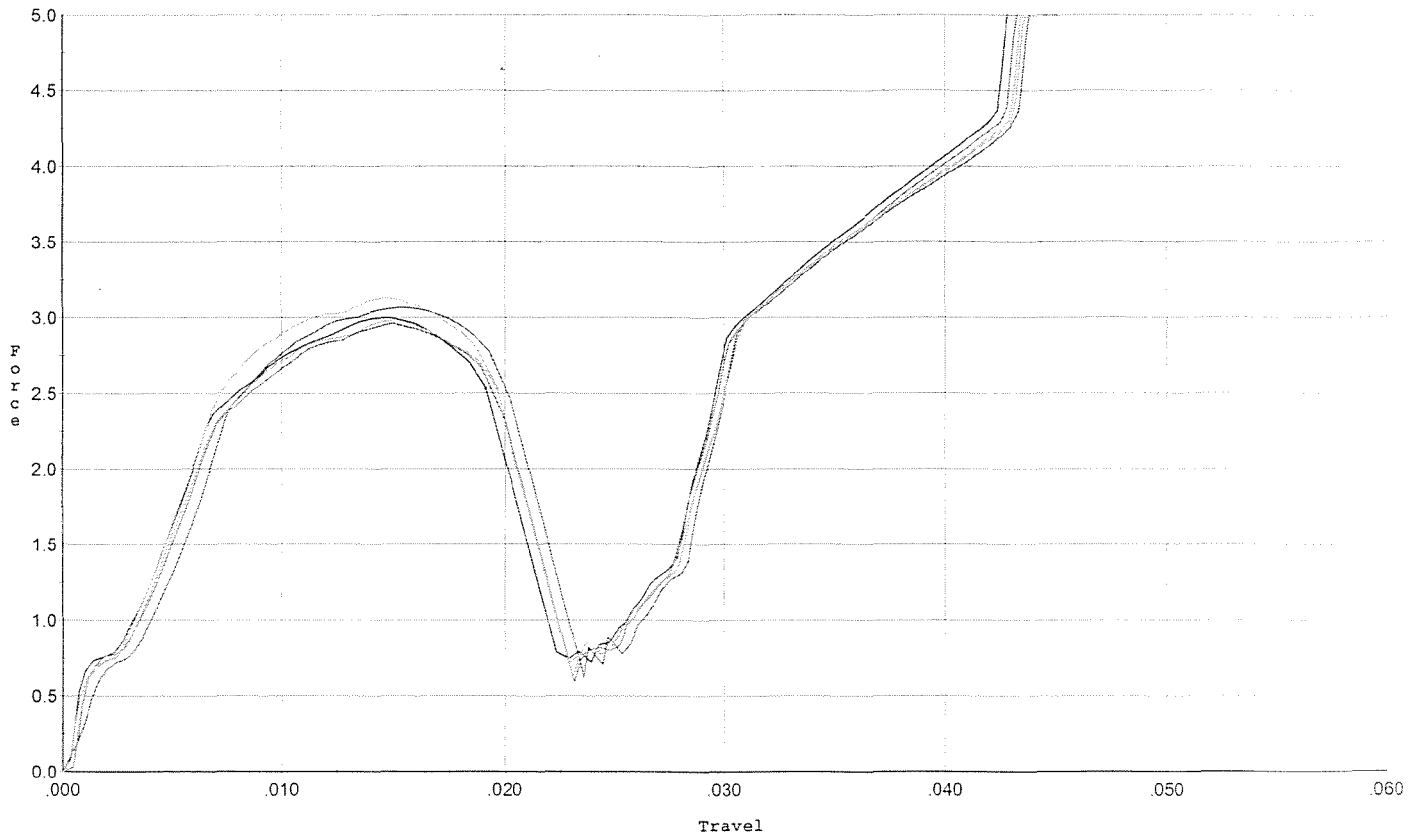
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.734	0.020	0.00	0.029	0.036		Set Trigger
2	2.602	0.018	0.00	0.029	0.033		Set Trigger
3	2.426	0.018	0.00	0.029	0.031		Set Trigger
4	2.426	0.019	0.00	0.029	0.031		Set Trigger
5	2.365	0.018	0.00	0.029	0.030		Set Trigger

A-2.51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



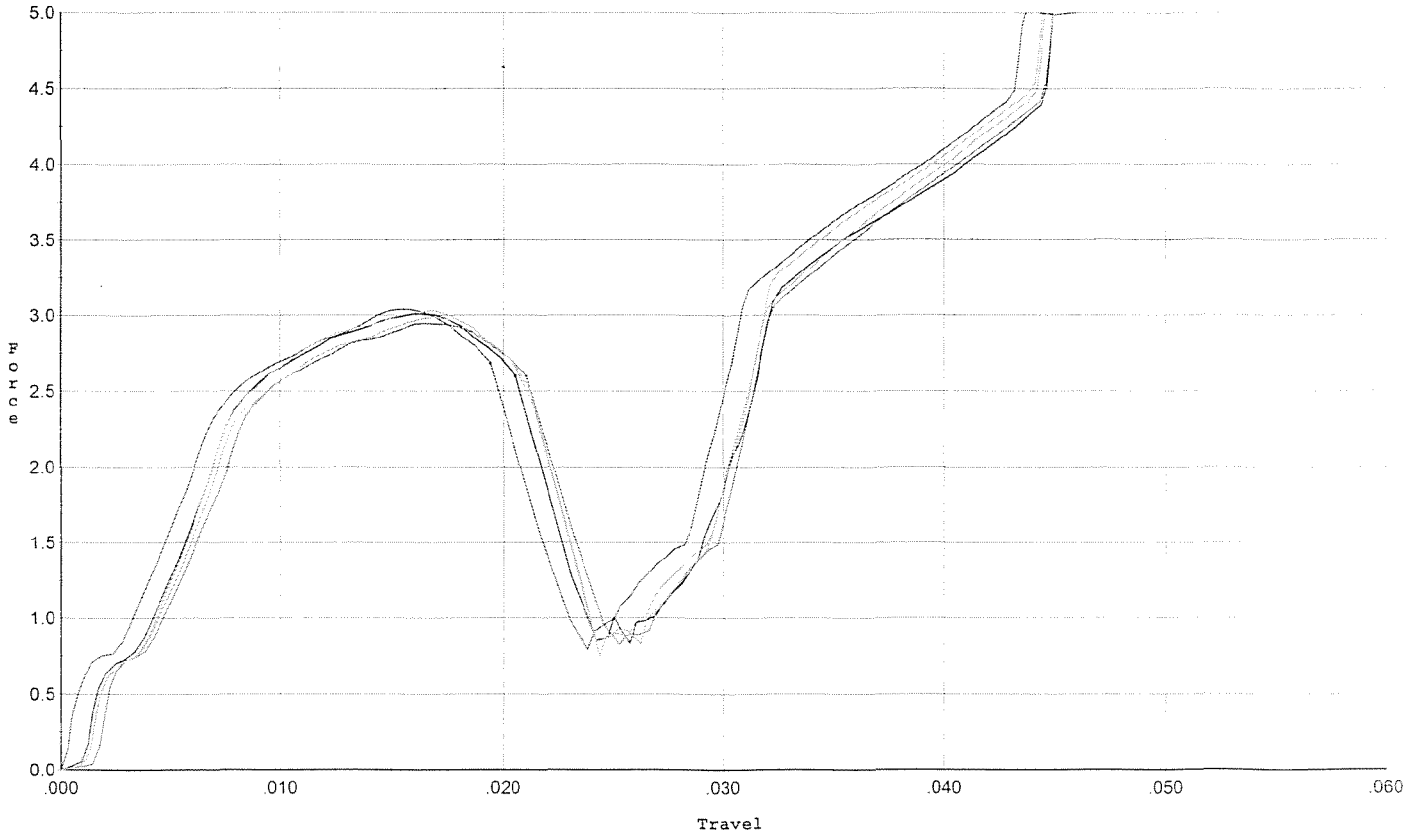
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.066	0.020	0.00	0.028	0.042		Set Trigger
2	2.999	0.019	0.00	0.028	0.040		Set Trigger
3	2.962	0.020	0.00	0.028	0.041		Set Trigger
4	3.131	0.020	0.00	0.028	0.042		Set Trigger
5	2.978	0.020	0.00	0.028	0.041		Set Trigger

A-3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



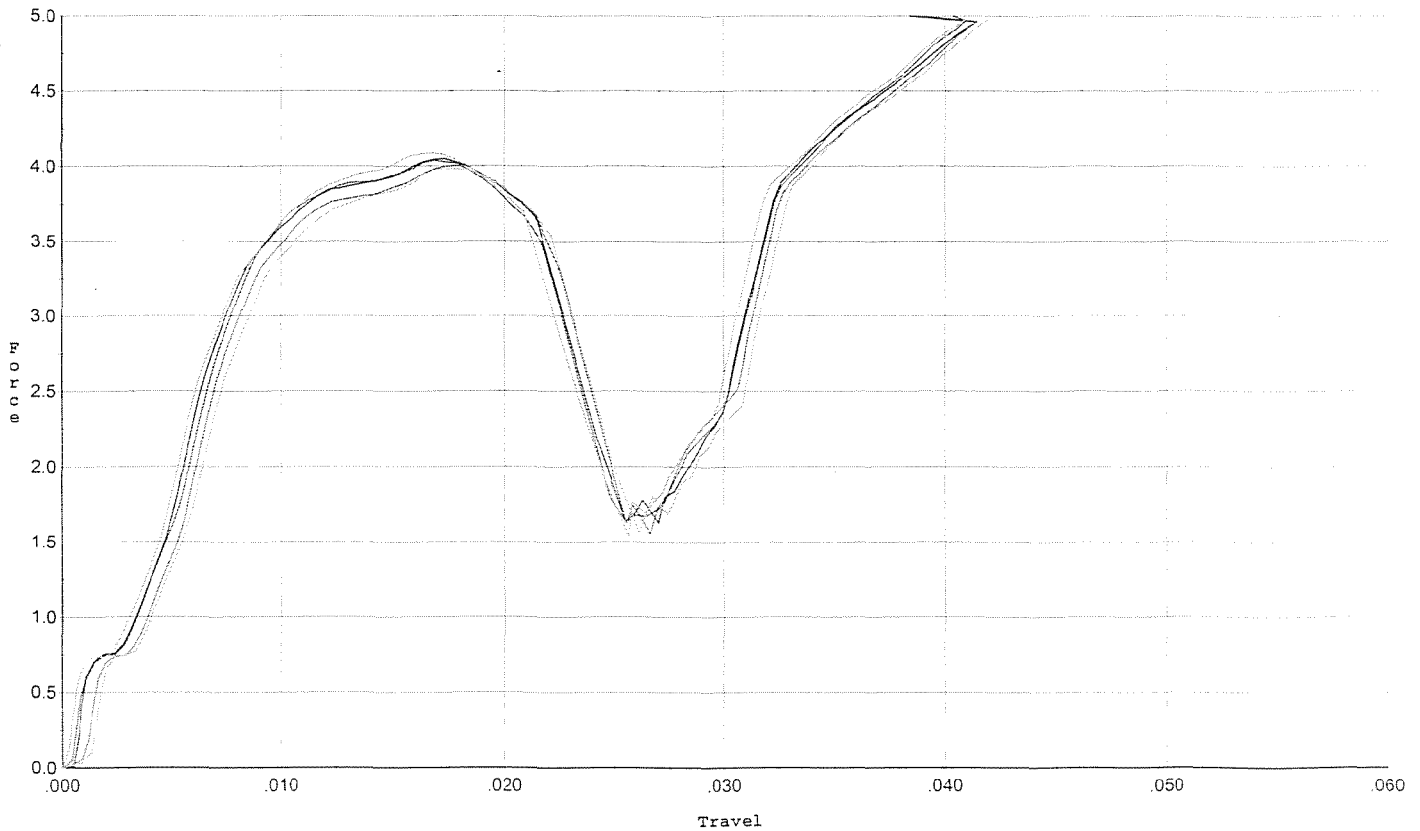
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.039	0.019	0.00	0.028	0.041		Set Trigger
2	3.009	0.021	0.00	0.029	0.042		Set Trigger
3	2.945	0.021	0.00	0.028	0.041		Set Trigger
4	3.032	0.021	0.00	0.028	0.043		Set Trigger
5	2.988	0.021	0.00	0.028	0.042		Set Trigger

A-3.00

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



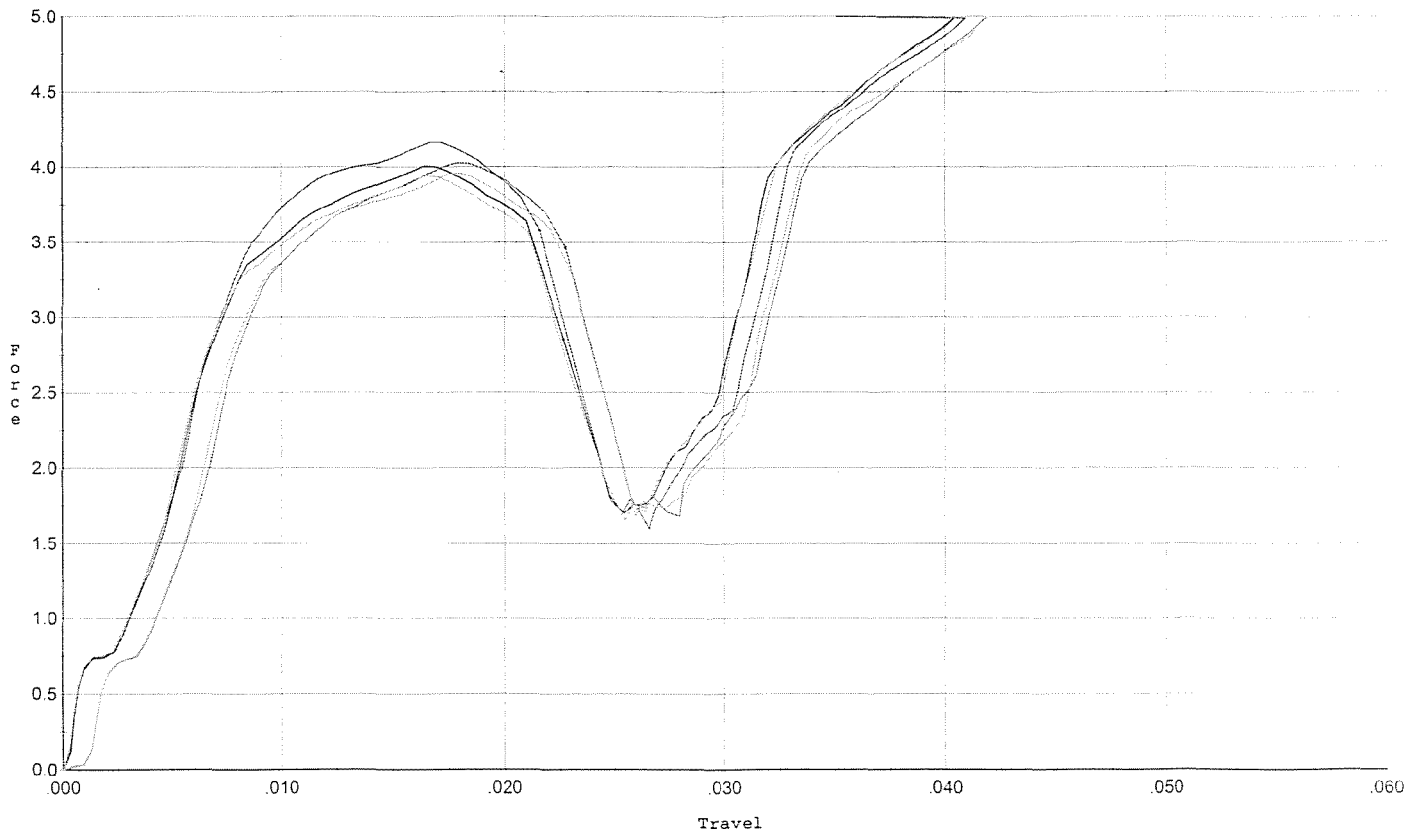
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.038	0.022	0.00	0.022	0.059		Set Trigger
2	4.047	0.021	0.00	0.021	0.059		Set Trigger
3	4.002	0.022	0.00	0.021	0.060		Set Trigger
4	3.985	0.022	0.00	0.021	0.058		Set Trigger
5	4.088	0.021	0.00	0.023	0.058		Set Trigger

A-4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



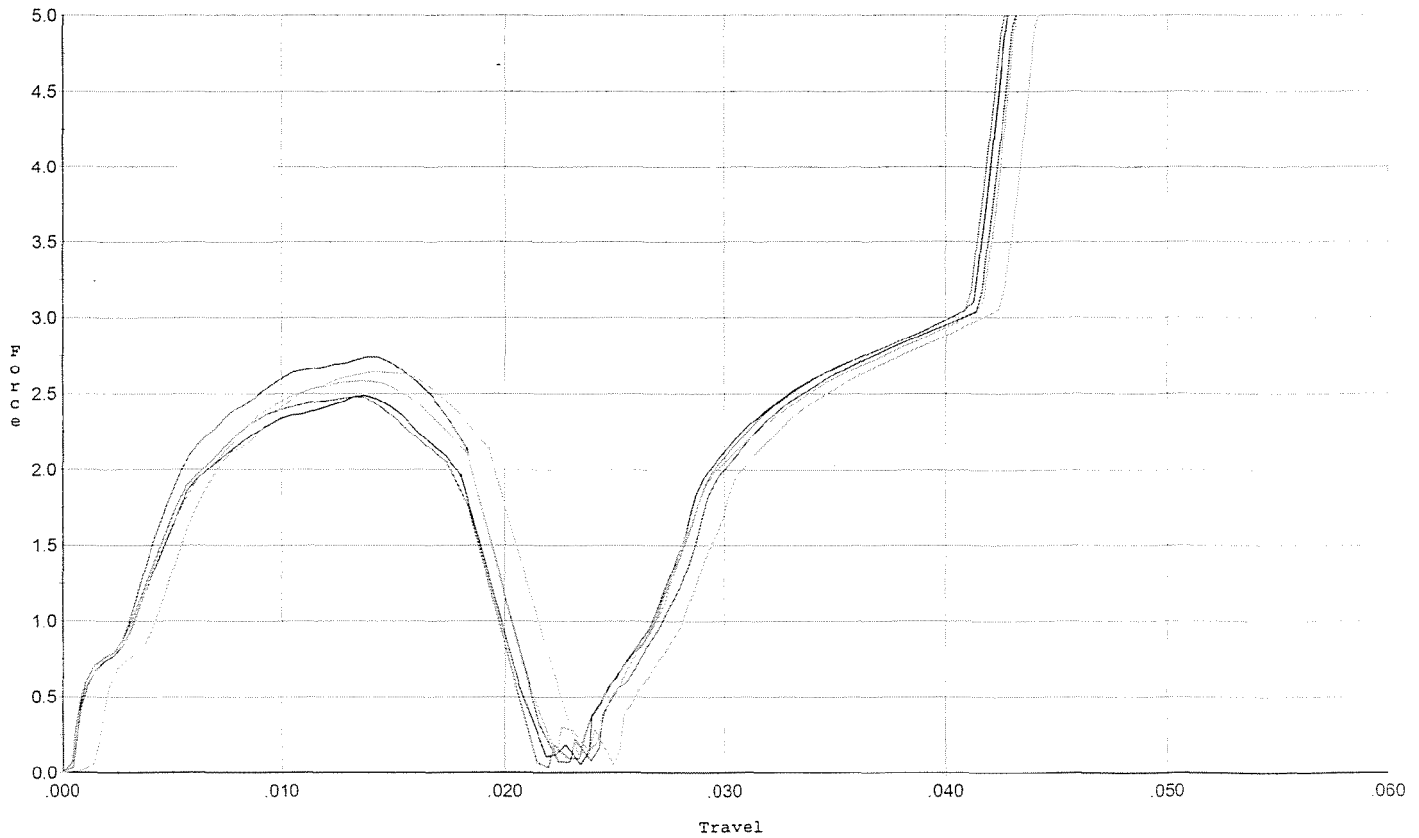
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.164	0.022	0.00	0.025	0.061		Set Trigger
2	4.006	0.023	0.00	0.021	0.062		Set Trigger
3	4.026	0.023	0.00	0.021	0.059		Set Trigger
4	3.957	0.023	0.00	0.021	0.060		Set Trigger
5	3.940	0.021	0.00	0.023	0.057		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



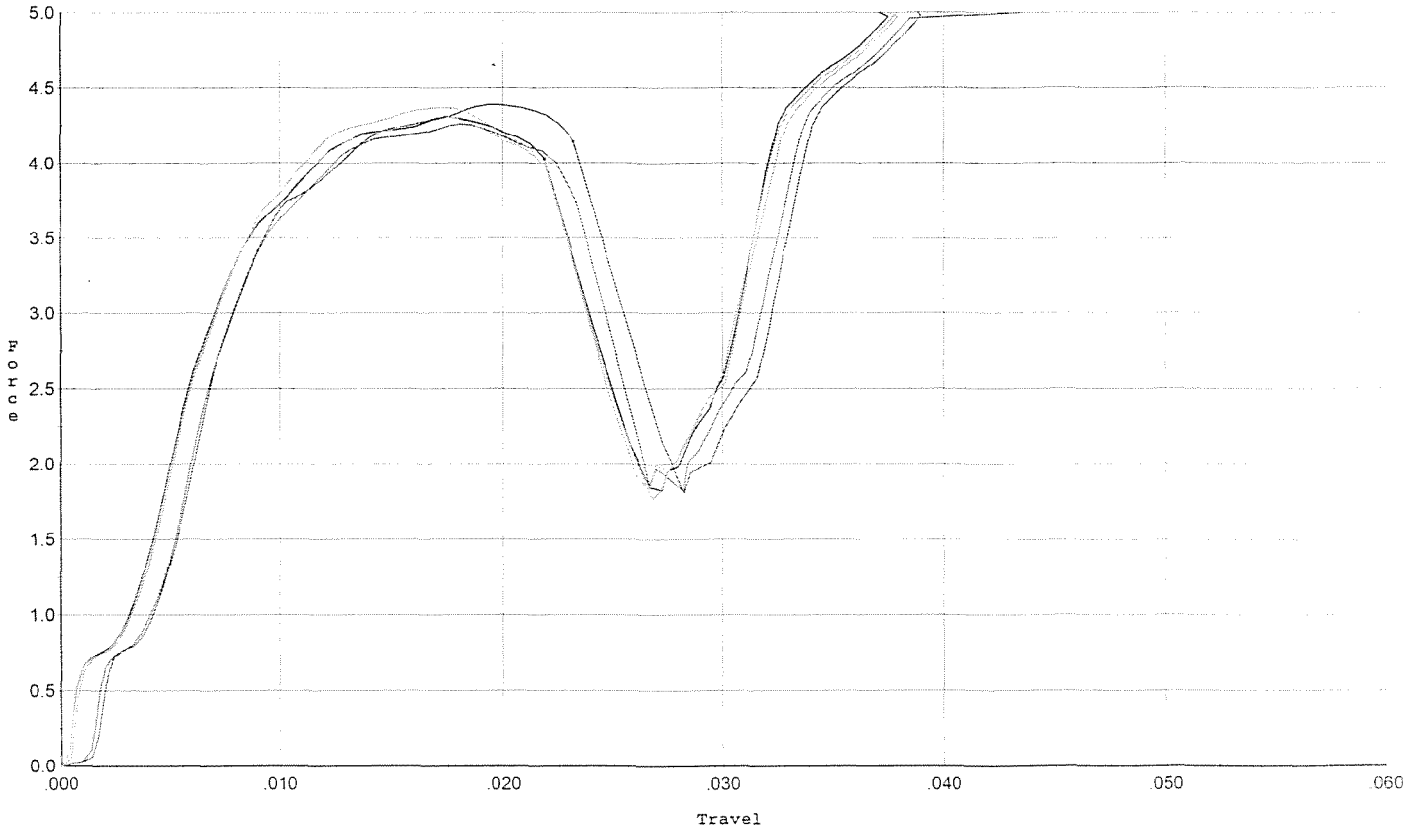
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.742	0.018	0.00	0.029	0.035		Set Trigger
2	2.490	0.018	0.00	0.029	0.032		Set Trigger
3	2.480	0.018	0.00	0.029	0.032		Set Trigger
4	2.641	0.019	0.00	0.029	0.034		Set Trigger
5	2.585	0.018	0.00	0.029	0.033		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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	4.386	0.023	0.00	0.019	0.067		Set Trigger
2	4.307	0.022	0.00	0.019	0.065		Set Trigger
3	4.258	0.023	0.00	0.019	0.066		Set Trigger
4	4.308	0.022	0.00	0.019	0.065		Set Trigger
5	4.370	0.022	0.00	0.020	0.065		Set Trigger

A. 4.32