G7178947

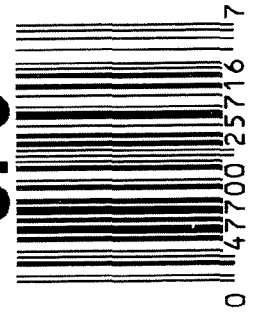
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6778947



BM FORM

BARBER - M24 0059358

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6778947

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	
430	ASSEMBLE TO STOCK		8-20-08	
440	PROOF		8-20-08	
460	CHECK HEADSPACE		8-20-08	
470	DIS-ASSEMBLE ACTION		8-20-08	
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	8/21 08	
475	DRILL AND TAP SIGHT HOLES	AUG 22 2008	8-21-08	
480	MAGNAFLUX BBL ACTION	OPERATOR	8/25/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8 25	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	
	D) OIL FIRING PIN ASSEMBLY		10-22-08	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

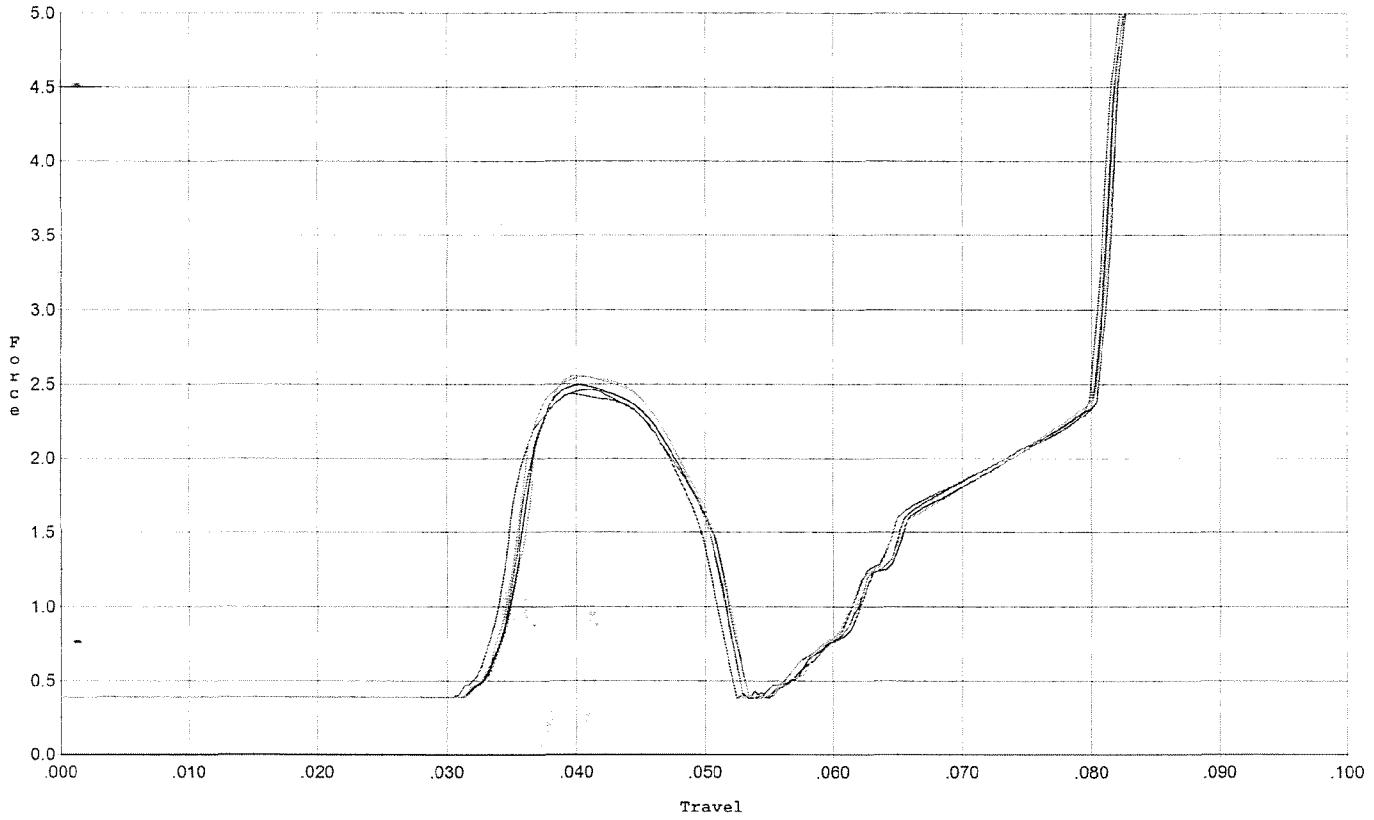
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
	BARBER - M24 0059359			
560	F) SAFETY ON FORCE [2 LBS MIN / 10 LBS MAX]	5.0 5.0 5.0	10-27-08	[illegible]
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	4.0 4.0 4.0	10-27-08	[illegible]
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.023 .023 .023	10-27-08	[illegible]
	J) ASSEMBLE STOCK		10-22-08	[illegible]
	K) ASSEMBLE SWIVEL STUDS		10-27-08	[illegible]
	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; PASS / FAIL	10-24-08	[illegible]
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	[illegible]
670	FINAL INSPECTION A) HEADSPACE		10-27-08	[illegible]
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	251 242 234 234 227	10-27-08	[illegible]
	C) FUNCTION		10-27-08	[illegible]
690	PACK		10/29/08	[illegible]

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. ini. +/- .50 lbs.
Note:	R. Putch 10/20/08		



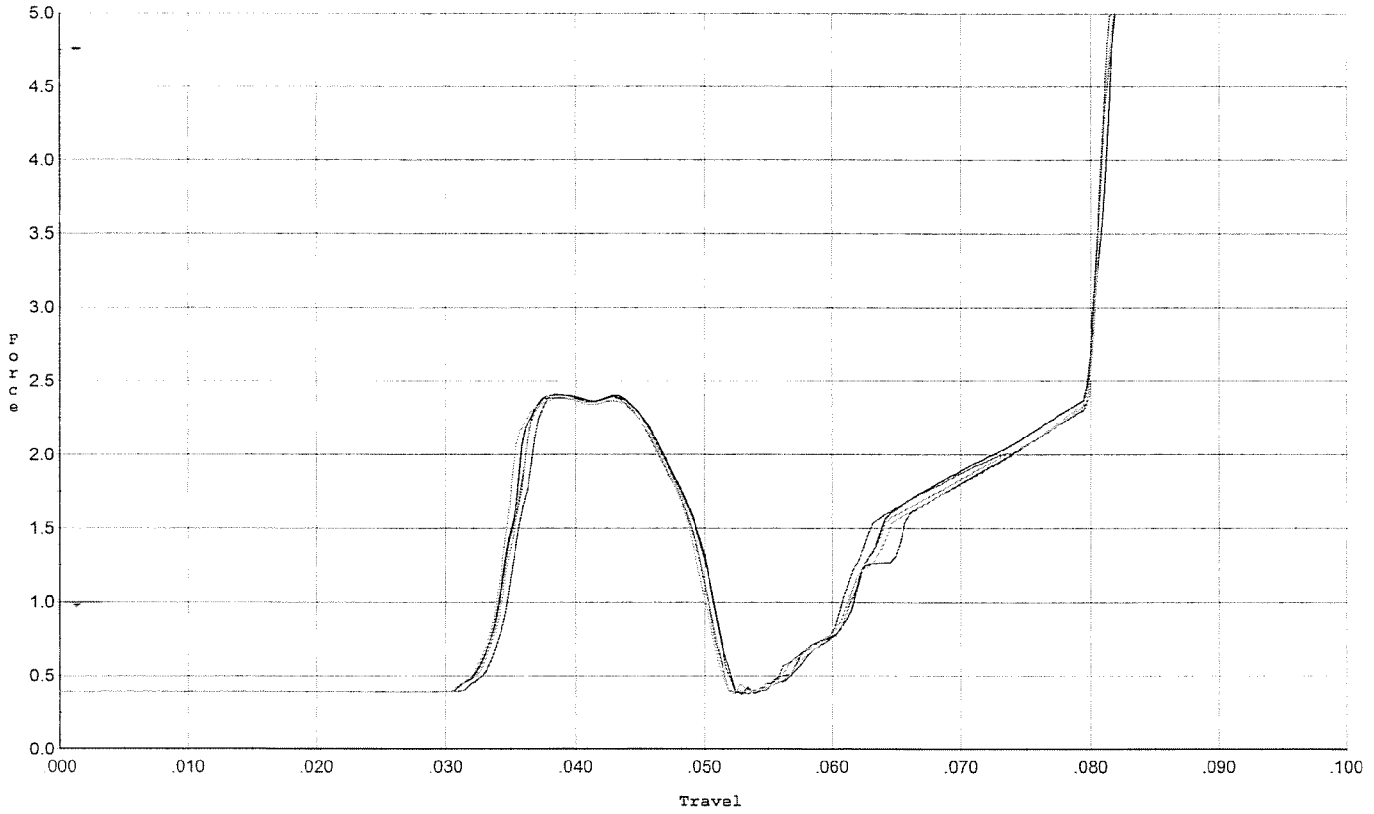
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.464	0.051	0.033	0.036	0.048		Set Trigger
2	2.497	0.051	0.034	0.037	0.048		Set Trigger
3	2.435	0.050	0.031	0.037	0.047		Set Trigger
4	2.558	0.052	0.034	0.036	0.050		Set Trigger
5	2.547	0.051	0.032	0.036	0.050		Set Trigger

Avg -2.50

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 12:57:15 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	2.5 lbs. after 50 cycles +/- .50 lbs.
Note:	R. Putch 10/20/08		



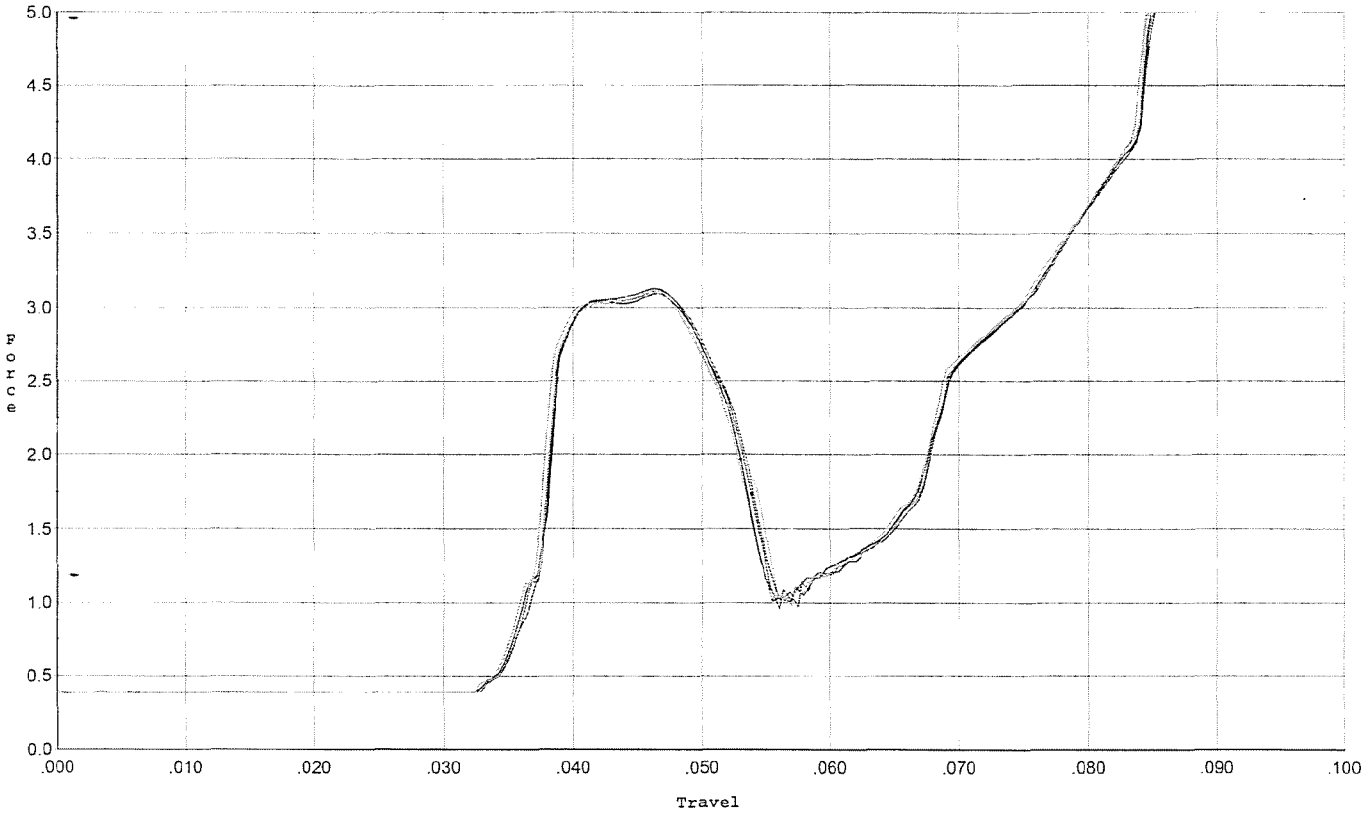
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.415	0.050	0.034	0.037	0.046		Set Trigger
2	2.404	0.050	0.033	0.037	0.047		Set Trigger
3	2.392	0.049	0.033	0.037	0.046		Set Trigger
4	2.380	0.050	0.033	0.037	0.047		Set Trigger
5	2.399	0.049	0.033	0.037	0.046		Set Trigger

Avg 2.39

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 12:58:55 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. ini. +/- .75 lbs.
Note:	R. Putch 10/20/08		



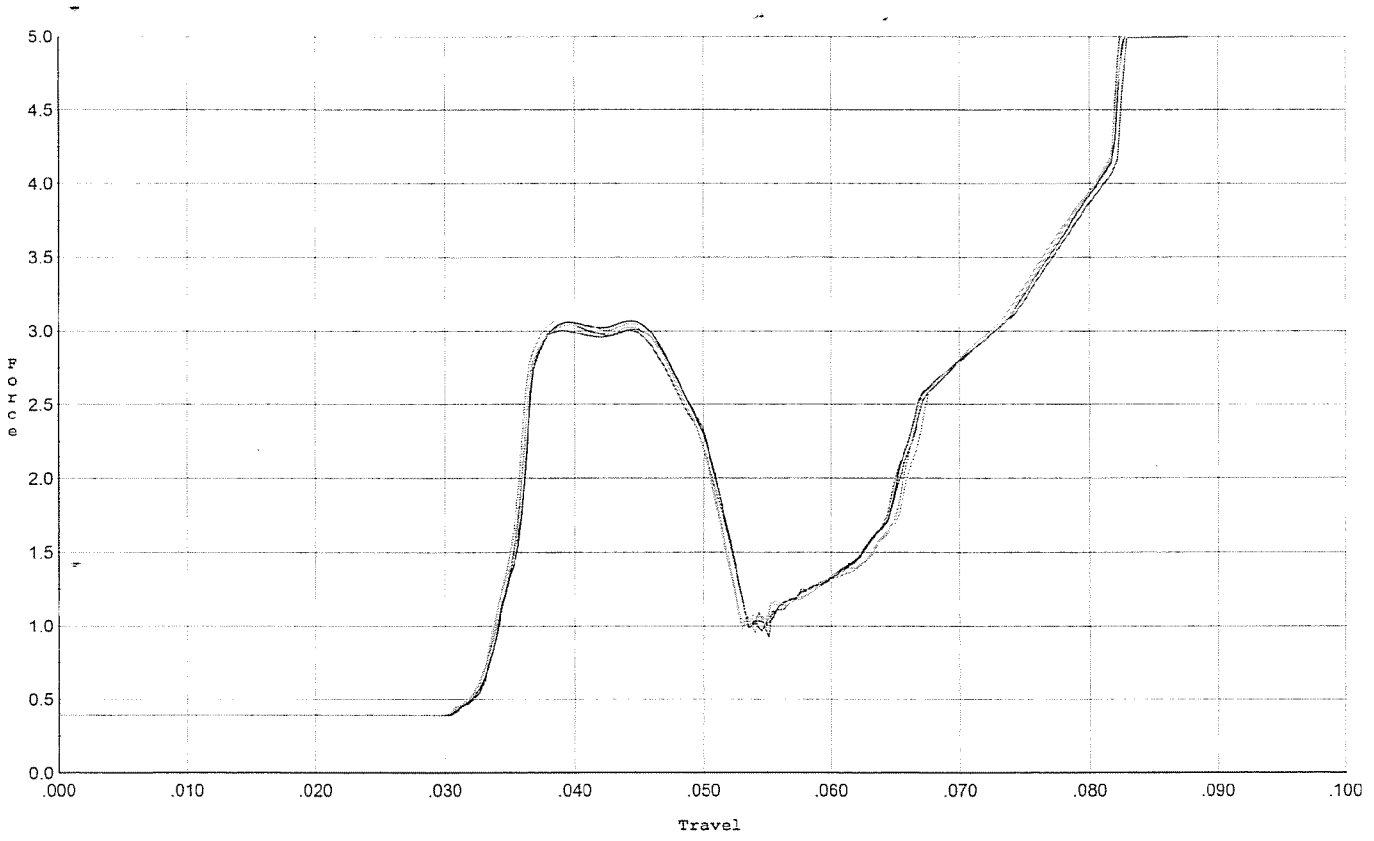
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.129	0.054	0.035	0.037	0.061		Set Trigger
2	3.096	0.053	0.035	0.037	0.060		Set Trigger
3	3.114	0.054	0.035	0.037	0.061		Set Trigger
4	3.101	0.054	0.035	0.036	0.062		Set Trigger
5	3.120	0.053	0.035	0.037	0.061		Set Trigger

Avg 3.11

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 1:00:47 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	3.0 lbs. after 20 cycles +/- .75 lbs.
Note:	R. Putch 10/20/08		



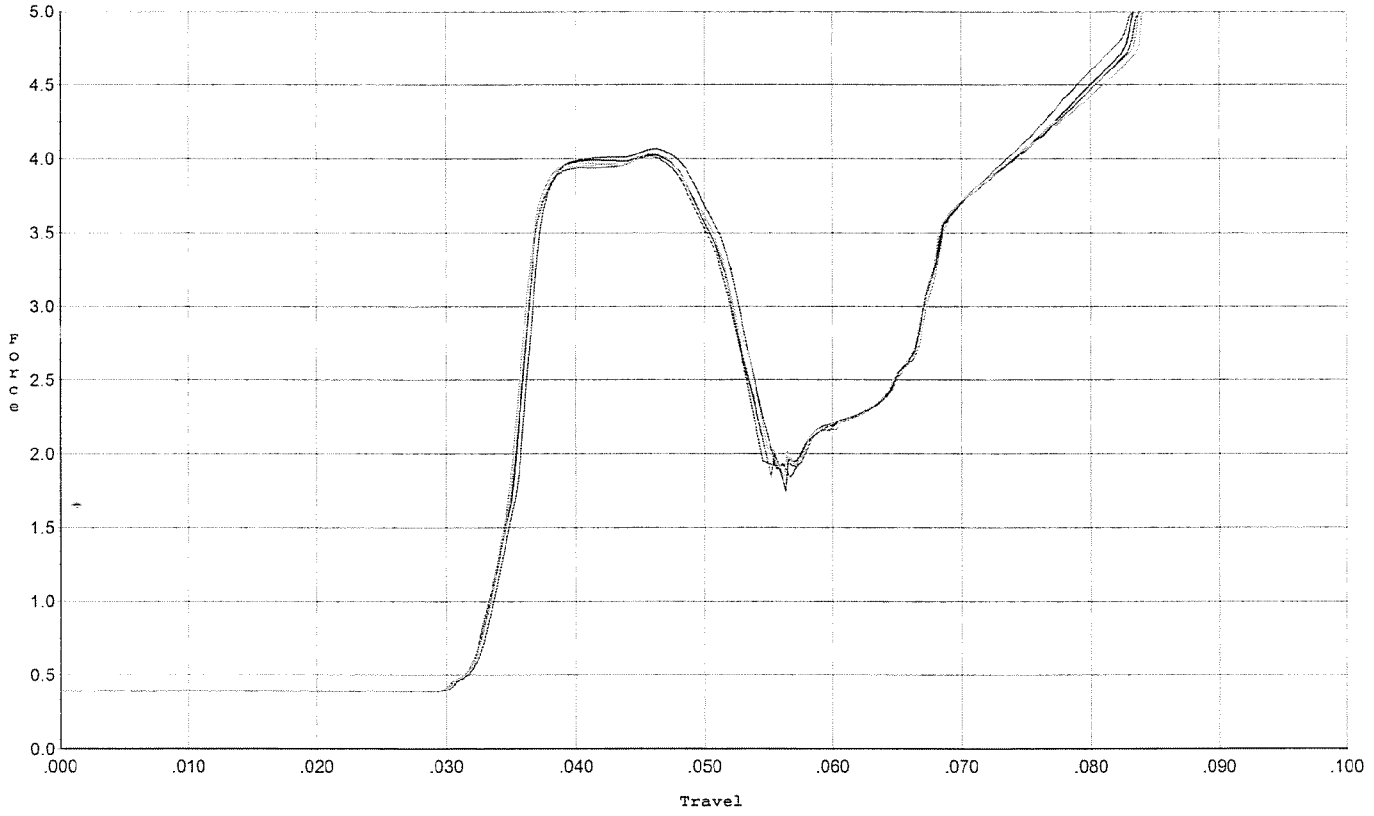
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.042	0.051	0.033	0.036	0.059		Set Trigger
2	3.068	0.052	0.033	0.036	0.060		Set Trigger
3	3.004	0.052	0.033	0.035	0.060		Set Trigger
4	3.042	0.051	0.033	0.036	0.059		Set Trigger
5	3.088	0.052	0.033	0.036	0.060		Set Trigger

Avg 3.04

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 1:02:33 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. ini. +/- 1.0 lbs.
Note:	R. Putch 10/20/08		



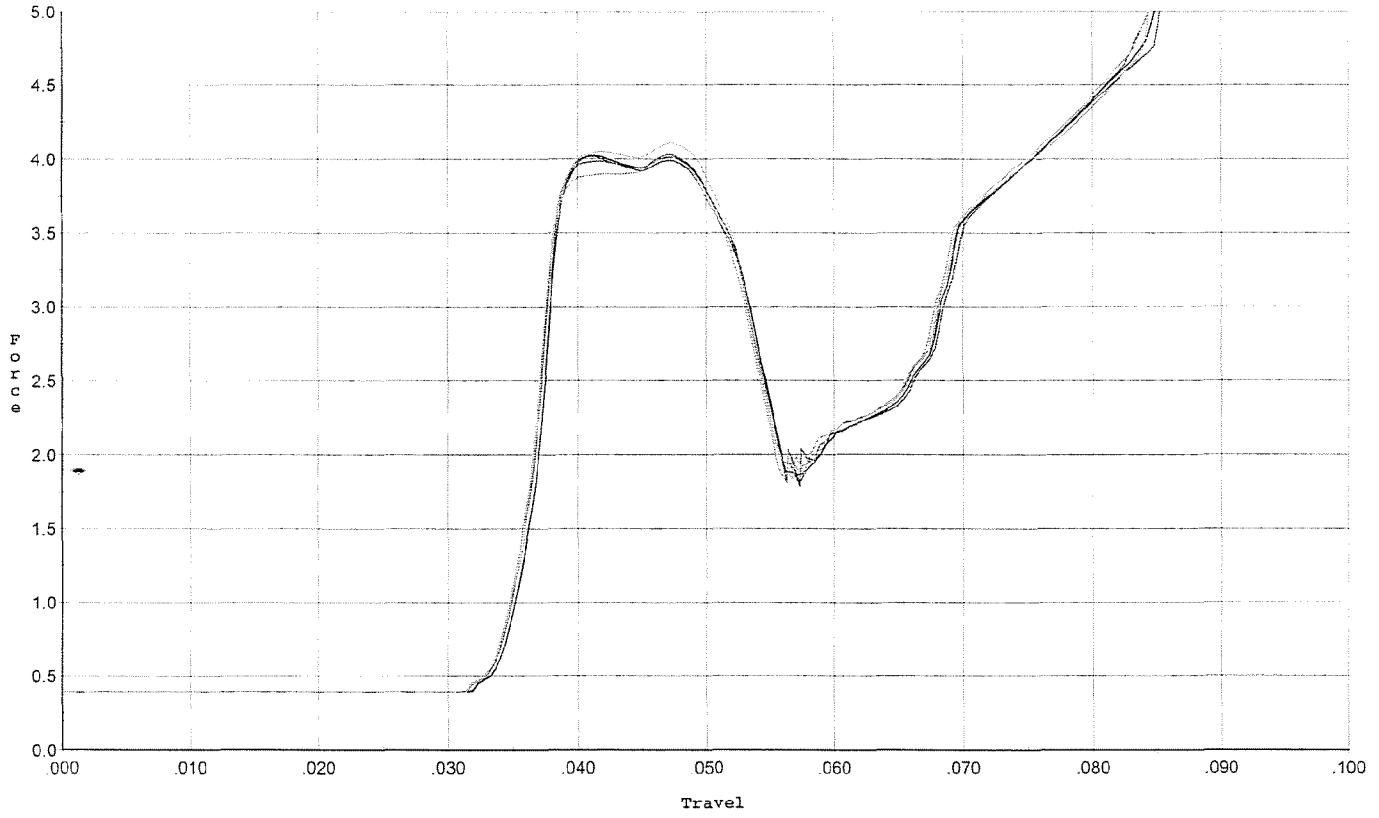
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.066	0.052	0.032	0.035	0.080		Set Trigger
2	4.026	0.052	0.032	0.035	0.079		Set Trigger
3	4.015	0.053	0.032	0.034	0.081		Set Trigger
4	4.036	0.053	0.032	0.034	0.083		Set Trigger
5	4.039	0.052	0.032	0.035	0.079		Set Trigger

Avg 4.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 1:05:12 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	4.0 lbs. after 20 cycles +/- 1.0 lbs.
Note:	R. Putch 10/20/08		



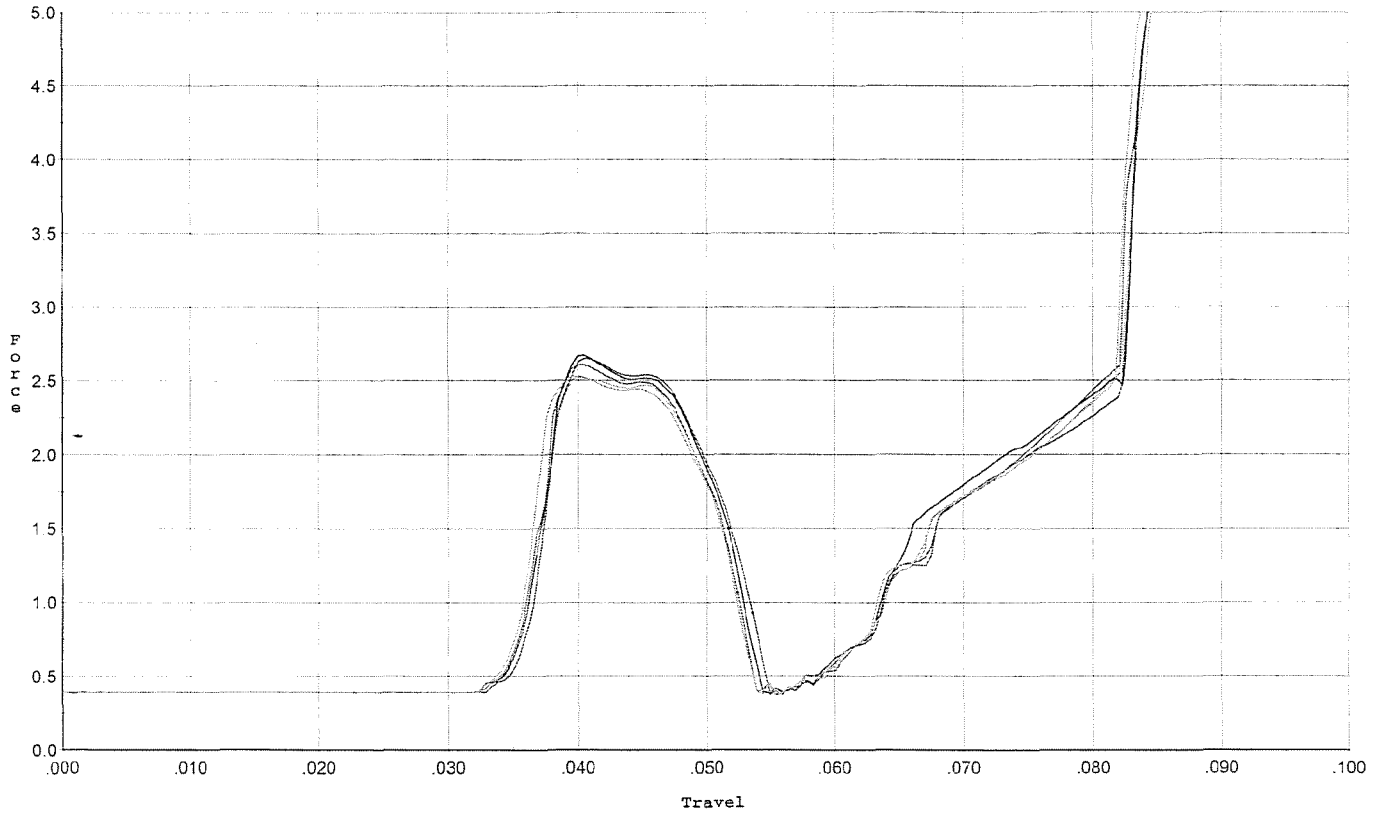
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.015	0.052	0.034	0.036	0.077		Set Trigger
2	4.023	0.053	0.032	0.035	0.079		Set Trigger
3	4.027	0.052	0.034	0.035	0.078		Set Trigger
4	4.112	0.054	0.034	0.035	0.081		Set Trigger
5	4.017	0.053	0.034	0.035	0.078		Set Trigger

Avg 4.03

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 1:06:33 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	reset to 2.5 lbs. +/- .50 lbs. for final test
Note:	R. Putch 10/20/08		



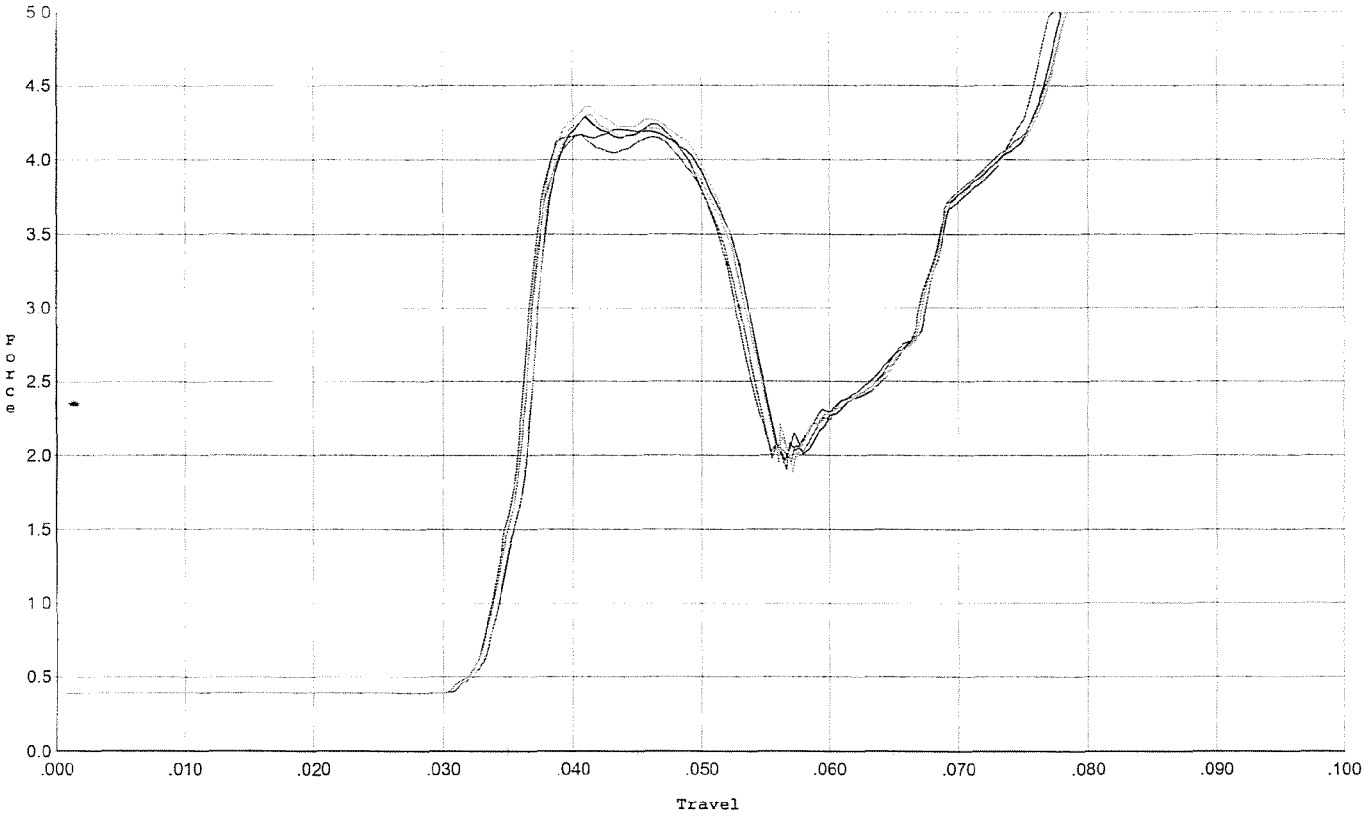
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.652	0.054	0.035	0.037	0.051		Set Trigger
2	2.673	0.052	0.035	0.037	0.050		Set Trigger
3	2.609	0.052	0.035	0.037	0.050		Set Trigger
4	2.530	0.051	0.035	0.038	0.049		Set Trigger
5	2.533	0.051	0.035	0.038	0.048		Set Trigger

Avg 2.59

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 1:08:05 AM

Trigger Profile [lbs,inch]

Profile	SWS	**Model:**	M/24
GunType:	Rifle	**Serial No:**	Form #F005
Make:	Remington	**Trigger:**	set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy
Note:	R. Putch 10/20/08		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.244	0.052	0.033	0.031	0.082		Set Trigger
2	4.289	0.053	0.033	0.031	0.083		Set Trigger
3	4.170	0.053	0.033	0.032	0.083		Set Trigger
4	4.301	0.055	0.033	0.031	0.086		Set Trigger
5	4.359	0.055	0.033	0.031	0.089		Set Trigger

AVG 4.27

Trigger Scan 2.01 ,SN 10337, printed by Remingyton Arms Co., Inc.. 10/21/2008 1:10:31 AM