

G6801344

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



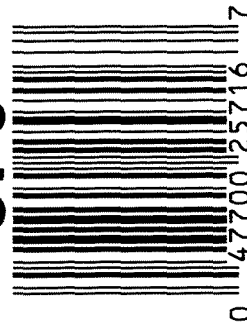
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801344

UPC

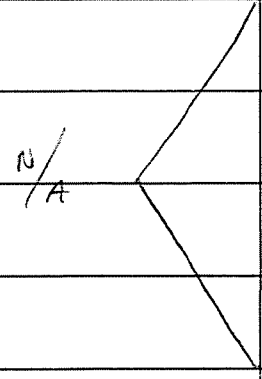


GUN SERIAL #

G 680 1344

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	SP
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TC
460	CHECK HEADSPACE		3-24-09	TC
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/27/09	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/27/09	RT
520	GOFF BLAST BBL / REC		3-27	BT
542	APPLY COATINGS (BARREL ACTION)		3-29	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-22-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

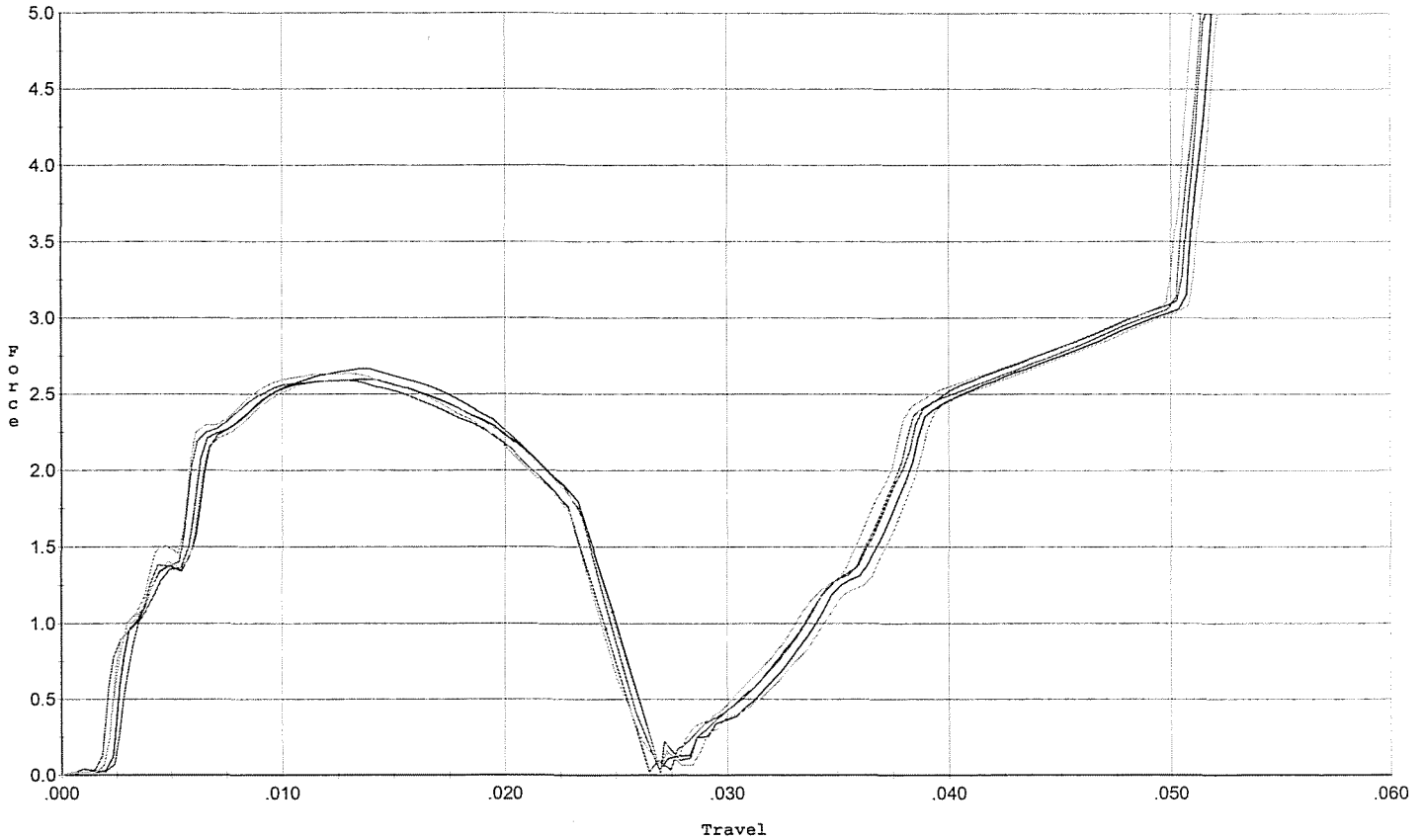
BARBER - M24 0014180		2 LBS MIN							
560	F) SAFETY ON FORCE	10 LBS MAX	<u>40</u>	<u>40</u>	<u>40</u>	5-6-09	RP		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>50</u>	<u>50</u>	<u>50</u>	5-6-09	RP		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	5-6-09	RP		
	J) ASSEMBLE STOCK					4-22-09	RP		
	K) ASSEMBLE SWIVEL STUDS					5-6-09	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	4-24-09	RP		
			(PASS)		FAIL				
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					4-14-09	SP		
670	FINAL INSPECTION A) HEADSPACE					5-6-09	RP		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u>	<u>2.49</u>	<u>2.50</u>	<u>2.53</u>	<u>2.63</u>	4-28-09	RP
	C) FUNCTION					5-6-09	RP		
690	PACK					5-29-09	RP		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



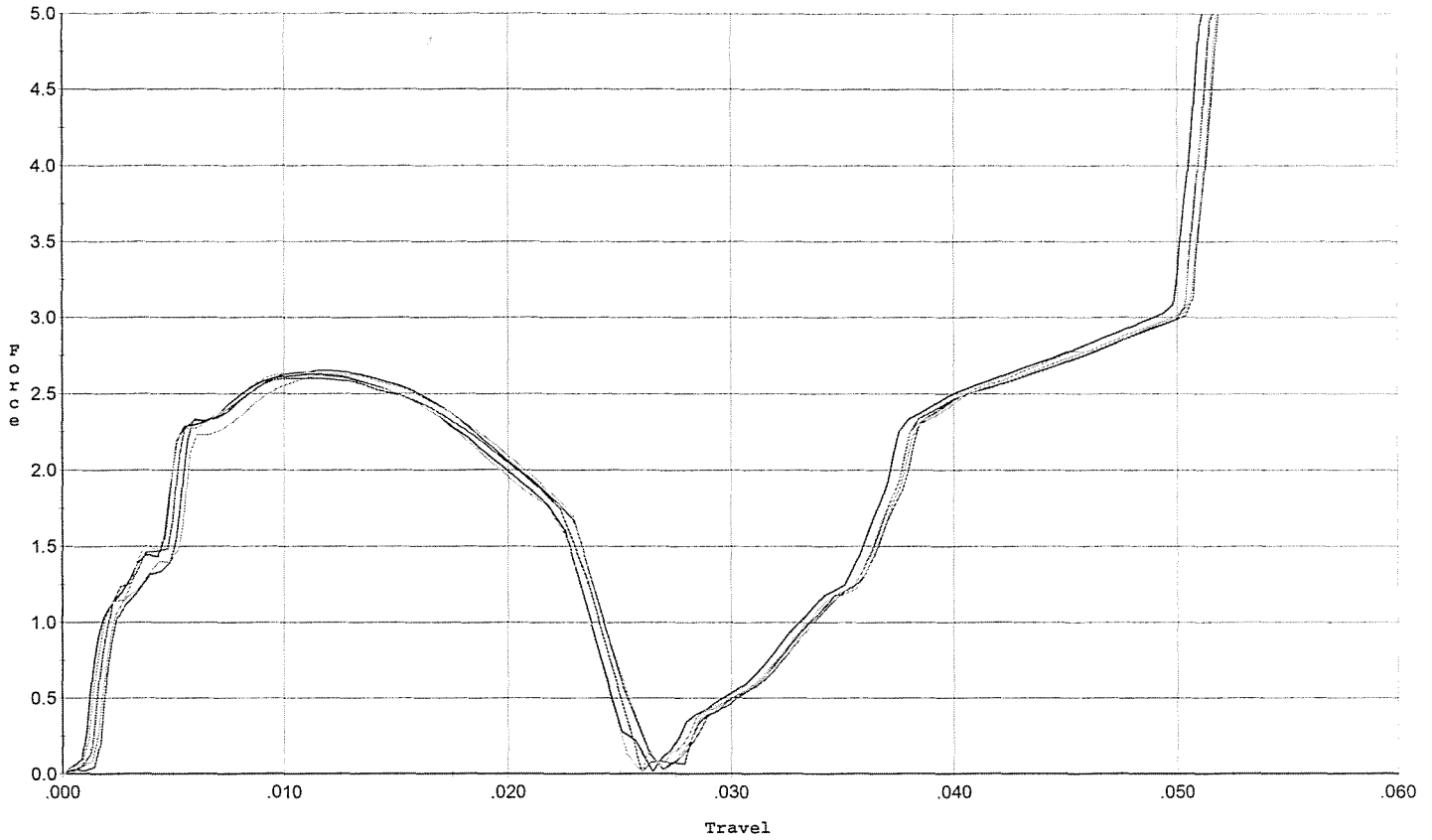
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.665	0.023	0.003	0.034	0.043		Set Trigger
2	2.596	0.025	0.002	0.034	0.045		Set Trigger
3	2.588	0.025	0.00	0.034	0.045		Set Trigger
4	2.601	0.025	0.00	0.034	0.046		Set Trigger
5	2.635	0.023	0.00	0.034	0.043		Set Trigger

Aug 2.61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



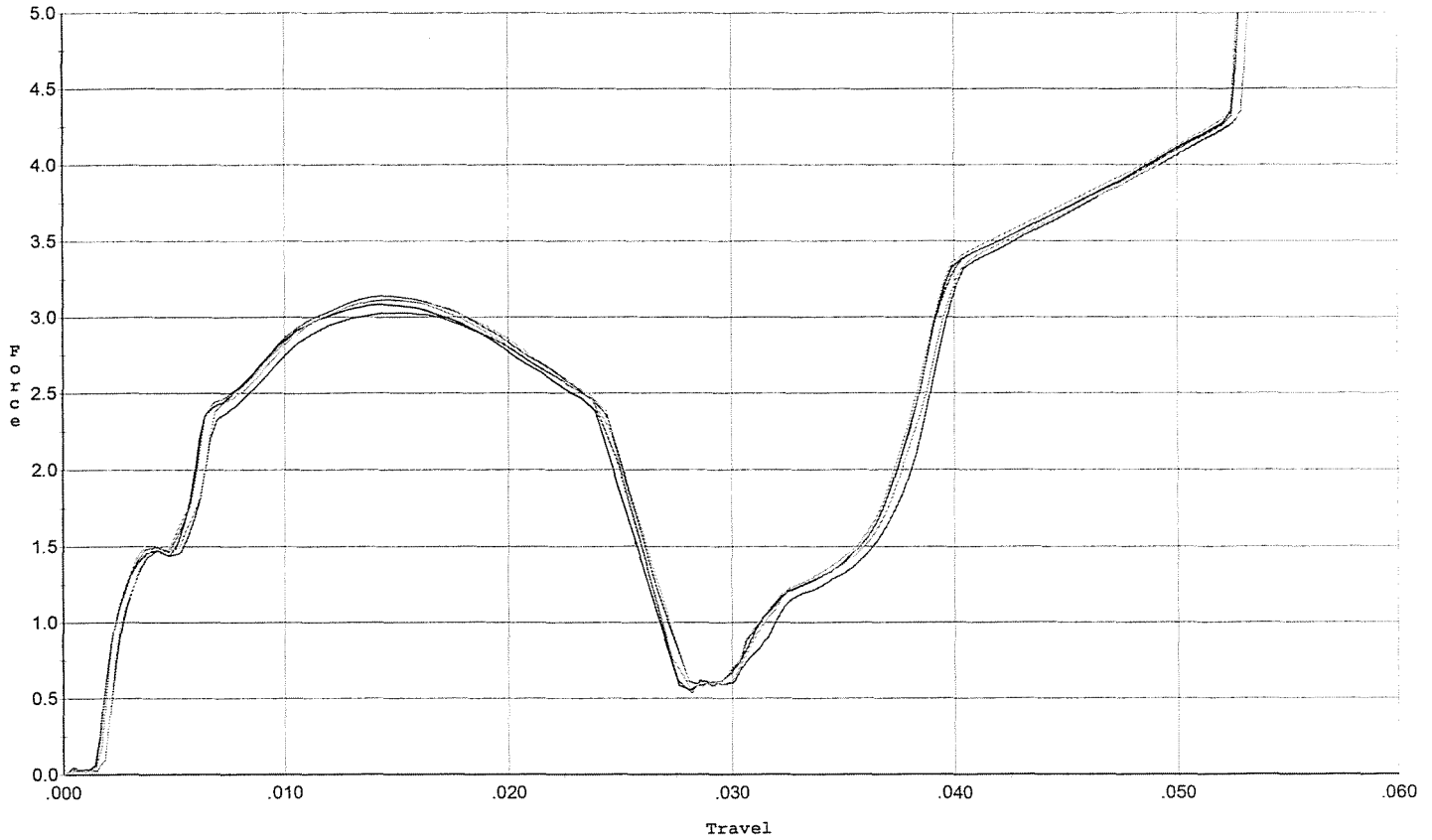
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.651	0.023	0.00	0.034	0.044		Set Trigger
2	2.628	0.023	0.00	0.034	0.044		Set Trigger
3	2.600	0.024	0.00	0.035	0.045		Set Trigger
4	2.642	0.023	0.00	0.035	0.044		Set Trigger
5	2.628	0.023	0.00	0.035	0.043		Set Trigger

Avg 2.63

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



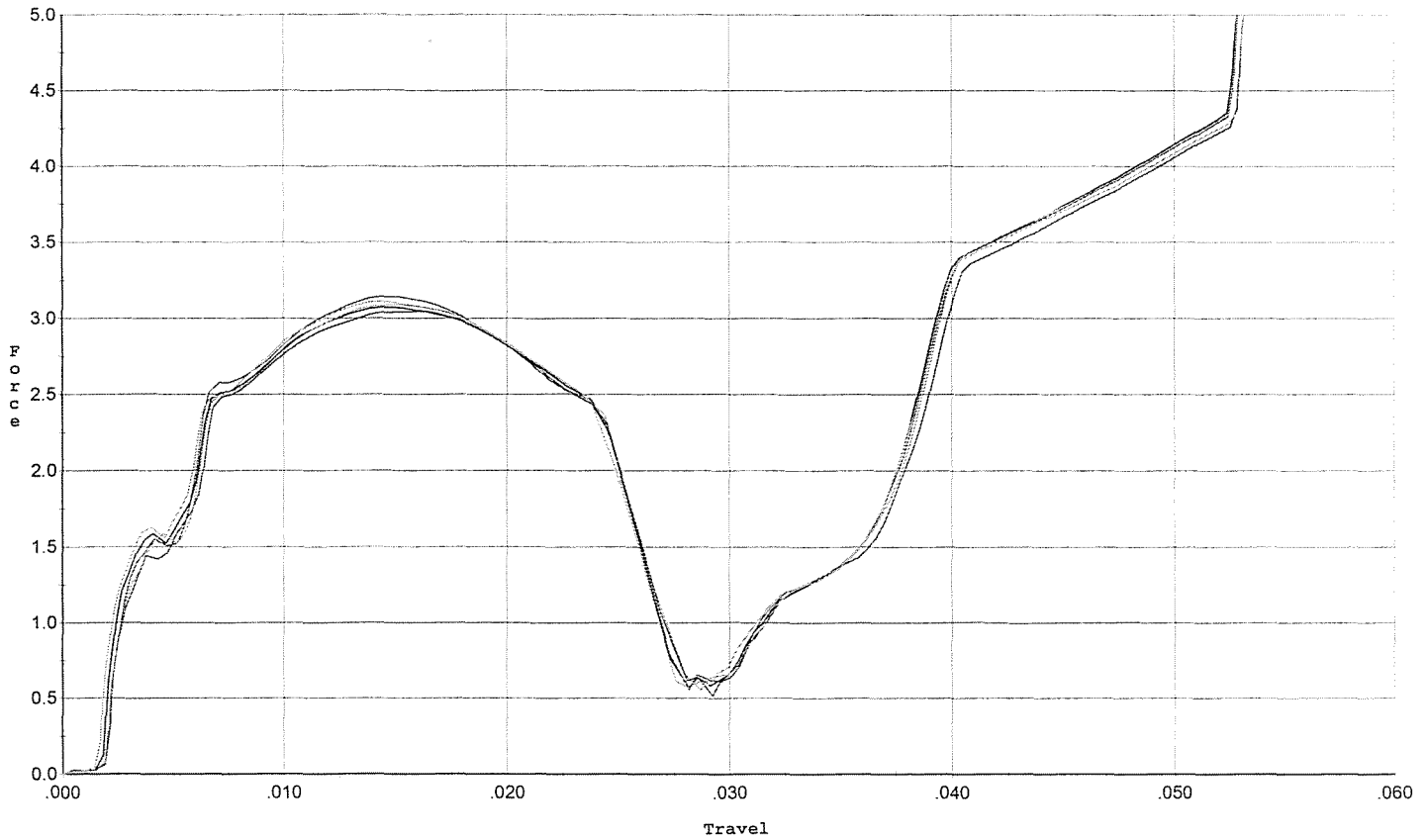
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.029	0.024	0.00	0.033	0.053		Set Trigger
2	3.083	0.026	0.00	0.033	0.057		Set Trigger
3	3.139	0.025	0.00	0.033	0.056		Set Trigger
4	3.118	0.024	0.002	0.033	0.054		Set Trigger
5	3.111	0.025	0.005	0.033	0.055		Set Trigger

Avg 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



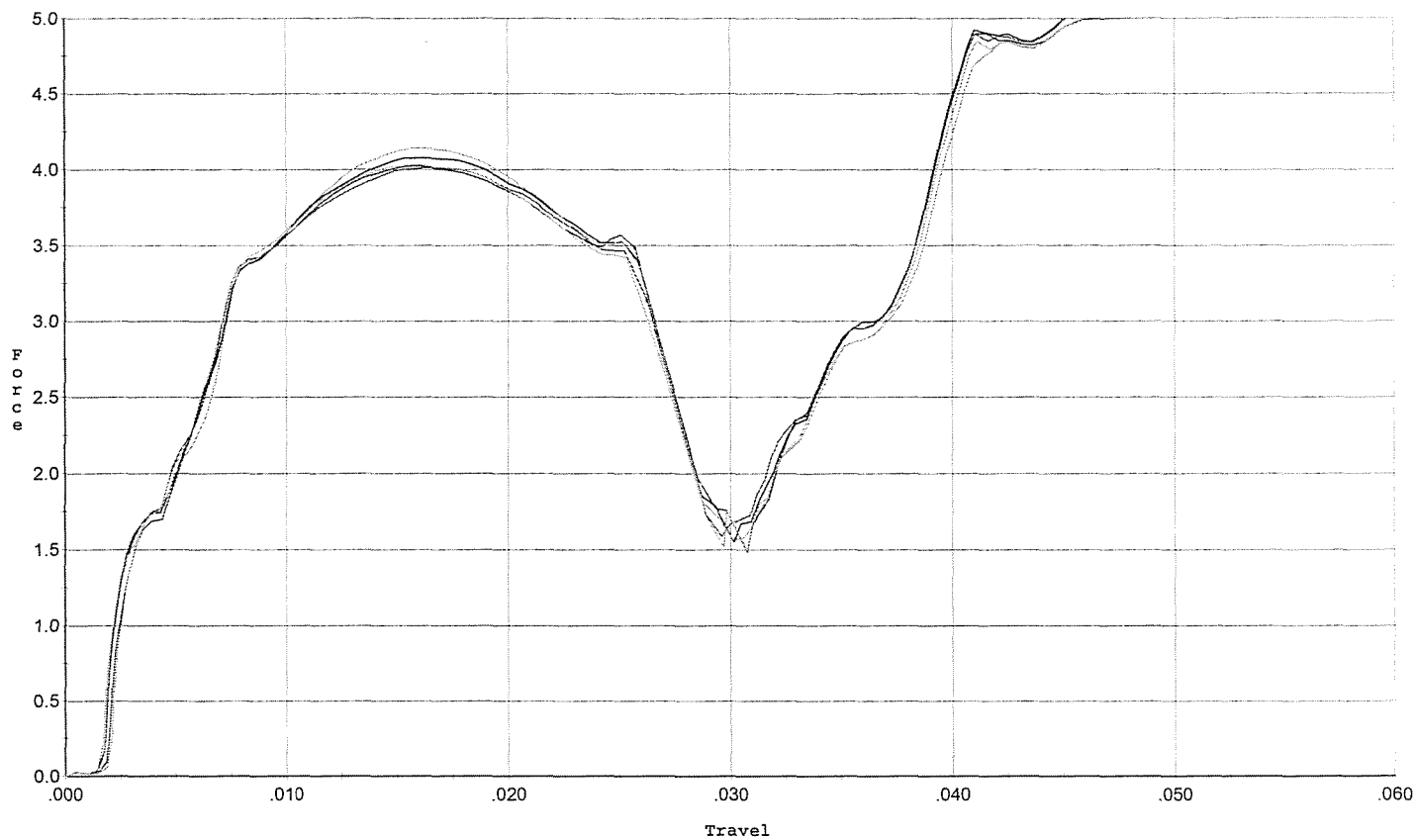
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.024	0.002	0.033	0.053		Set Trigger
2	3.073	0.025	0.00	0.033	0.055		Set Trigger
3	3.139	0.025	0.002	0.033	0.055		Set Trigger
4	3.110	0.025	0.00	0.033	0.056		Set Trigger
5	3.088	0.024	0.00	0.033	0.054		Set Trigger

Aug 3.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



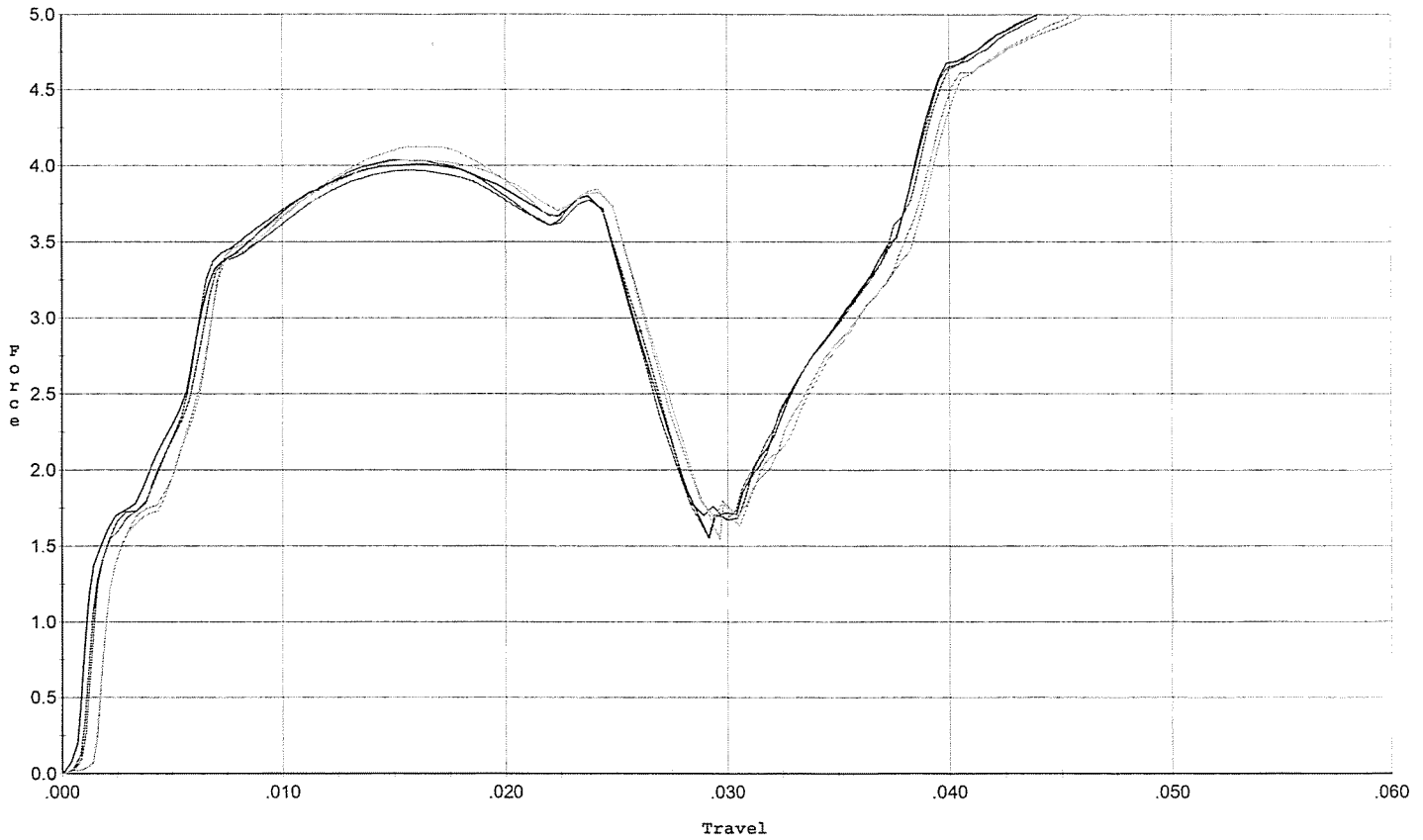
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.025	0.026	0.002	0.029	0.074		Set Trigger
2	4.078	0.026	0.00	0.029	0.075		Set Trigger
3	4.013	0.026	0.00	0.030	0.076		Set Trigger
4	4.034	0.027	0.00	0.030	0.077		Set Trigger
5	4.143	0.026	0.002	0.029	0.075		Set Trigger

Aug 4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



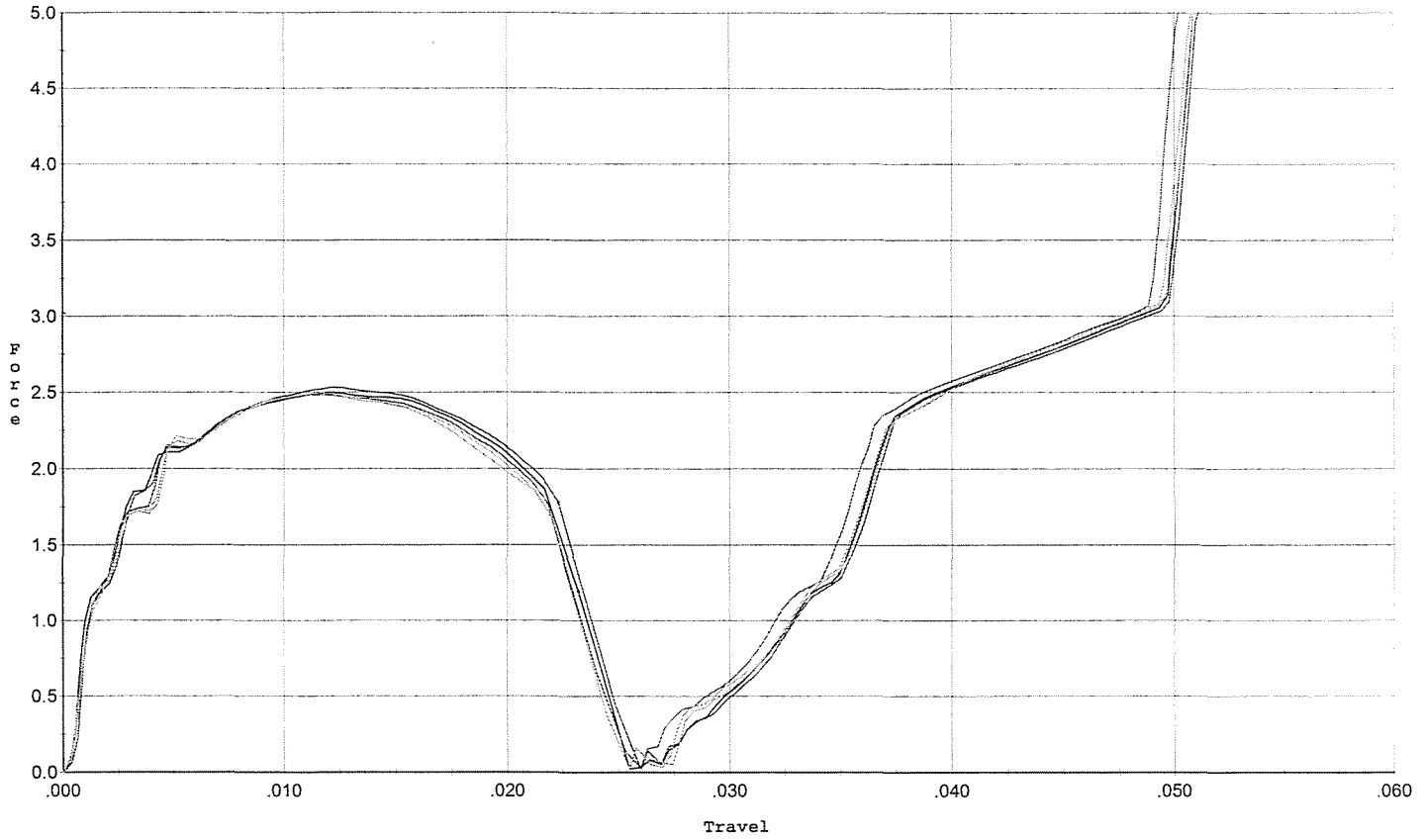
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.036	0.024	0.00	0.029	0.073		Set Trigger
2	4.008	0.024	0.00	0.029	0.073		Set Trigger
3	3.969	0.026	0.00	0.029	0.077		Set Trigger
4	4.034	0.025	0.00	0.030	0.073		Set Trigger
5	4.126	0.025	0.00	0.029	0.074		Set Trigger

Avg 4.03

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



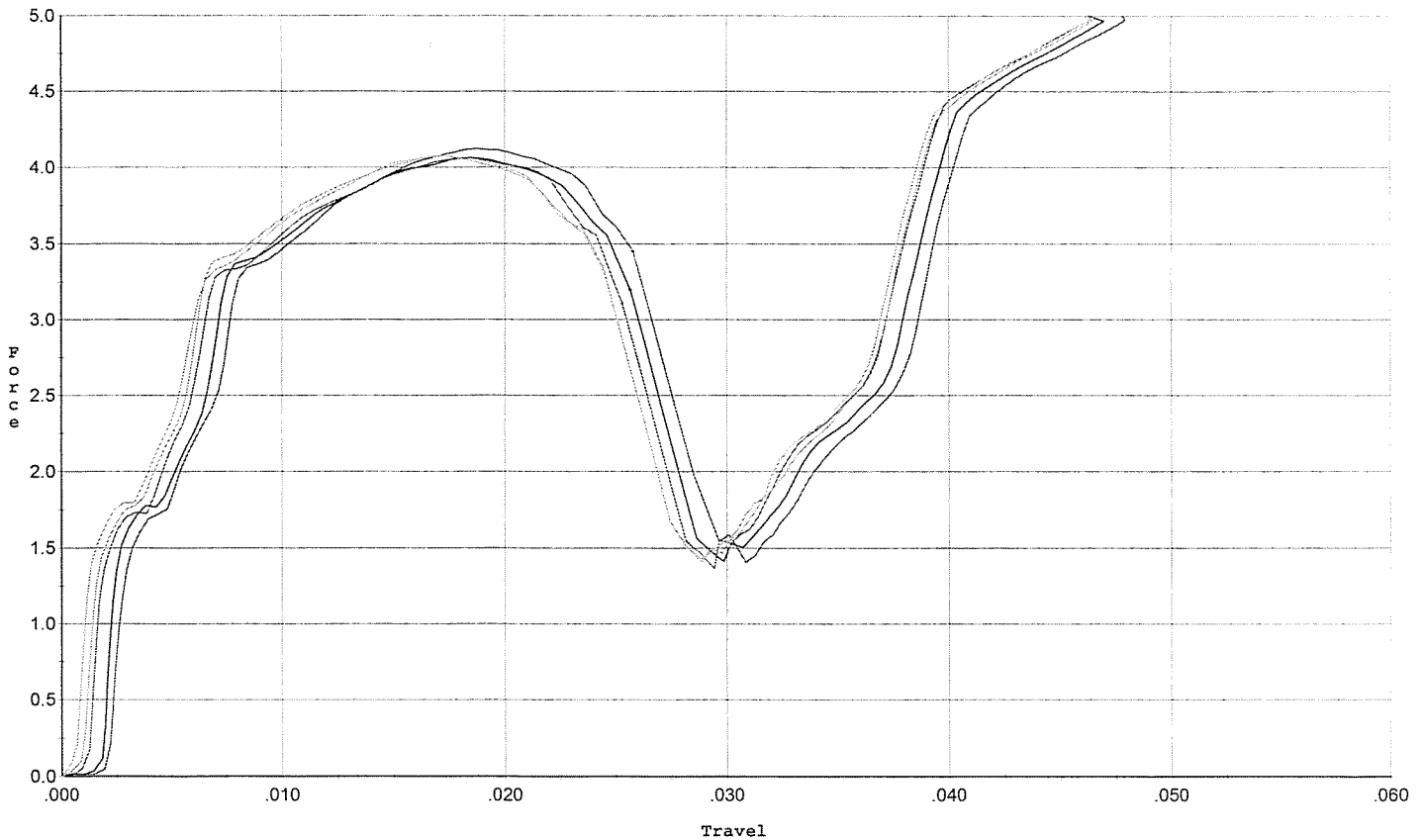
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.534	0.022	0.00	0.034	0.045		Set Trigger
2	2.500	0.023	0.00	0.034	0.046		Set Trigger
3	2.491	0.022	0.00	0.034	0.043		Set Trigger
4	2.499	0.022	0.00	0.034	0.043		Set Trigger
5	2.482	0.022	0.00	0.035	0.043		Set Trigger

Avg 2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/16/09

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.026	0.002	0.030	0.074		Set Trigger
2	4.064	0.026	0.00	0.030	0.074		Set Trigger
3	4.060	0.025	0.00	0.029	0.074		Set Trigger
4	4.077	0.024	0.00	0.030	0.074		Set Trigger
5	4.074	0.024	0.00	0.030	0.073		Set Trigger

Avg 4.08