

76801428

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



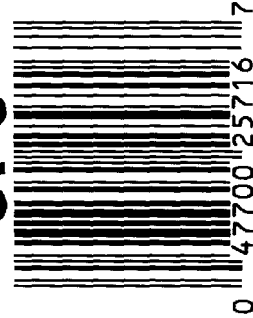
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801428

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 1428

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	EJECTOR (H8)	3/9/09	(H8)
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	R. G.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	R. G.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	R. G.
	D) OIL FIRING PIN ASSEMBLY		3-19-09	R. G.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	0015165	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>6</u>	3-23-09	WW
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-23-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-23-09	WW
	J) ASSEMBLE STOCK			3-19-09	RP
	K) ASSEMBLE SWIVEL STUDS			3-25-09	WW
	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	3-19-09	RP
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION N/A		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			3-20-09	RP
670	FINAL INSPECTION A) HEADSPACE			3/20/09	WW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.68</u> <u>2.72</u> <u>2.68</u> <u>2.66</u>	3-23-09	TC
	C) FUNCTION			3/20/09	WW
690	PACK			3/27/09	Fm

F004 REV 5/2006

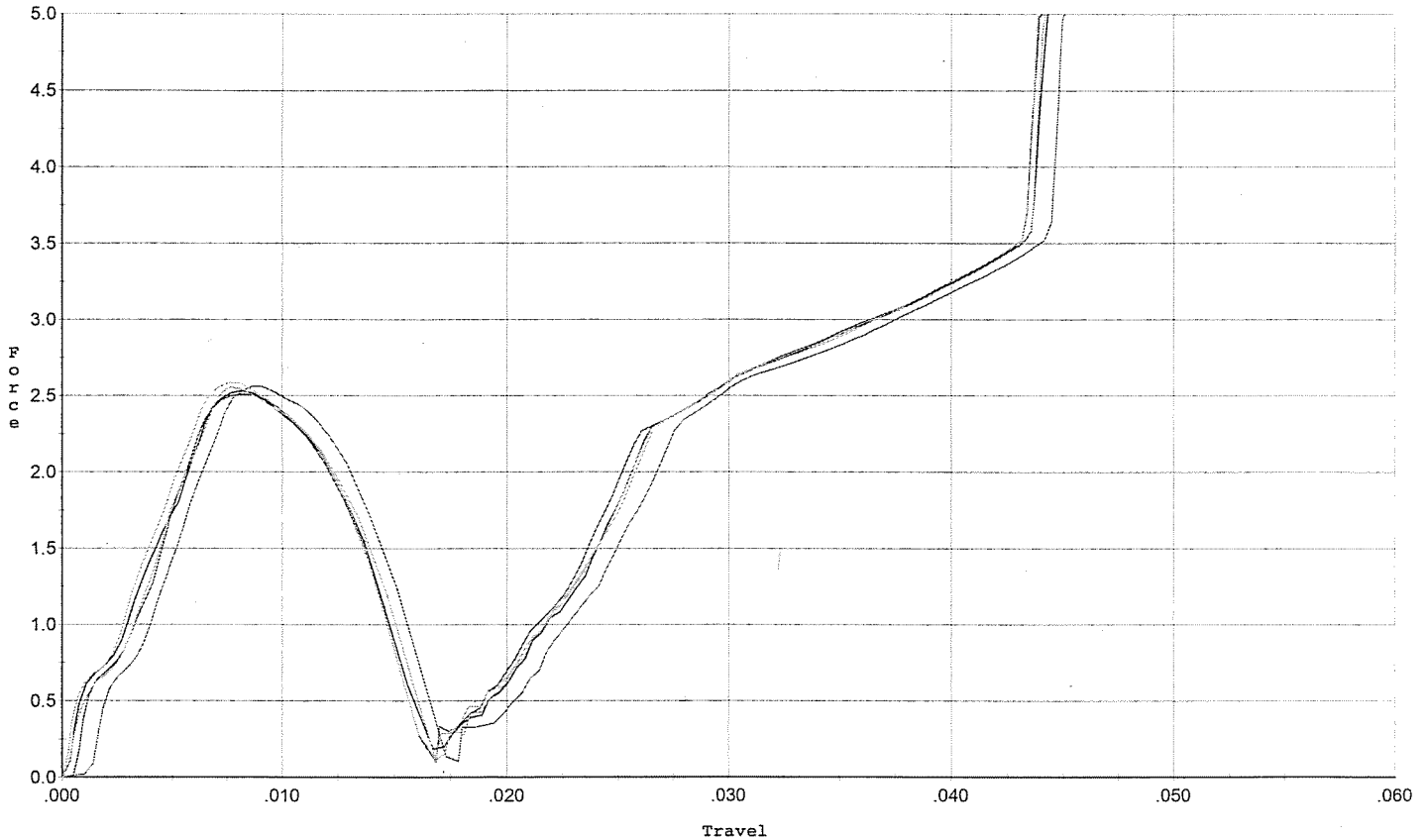
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 0015165 15204

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



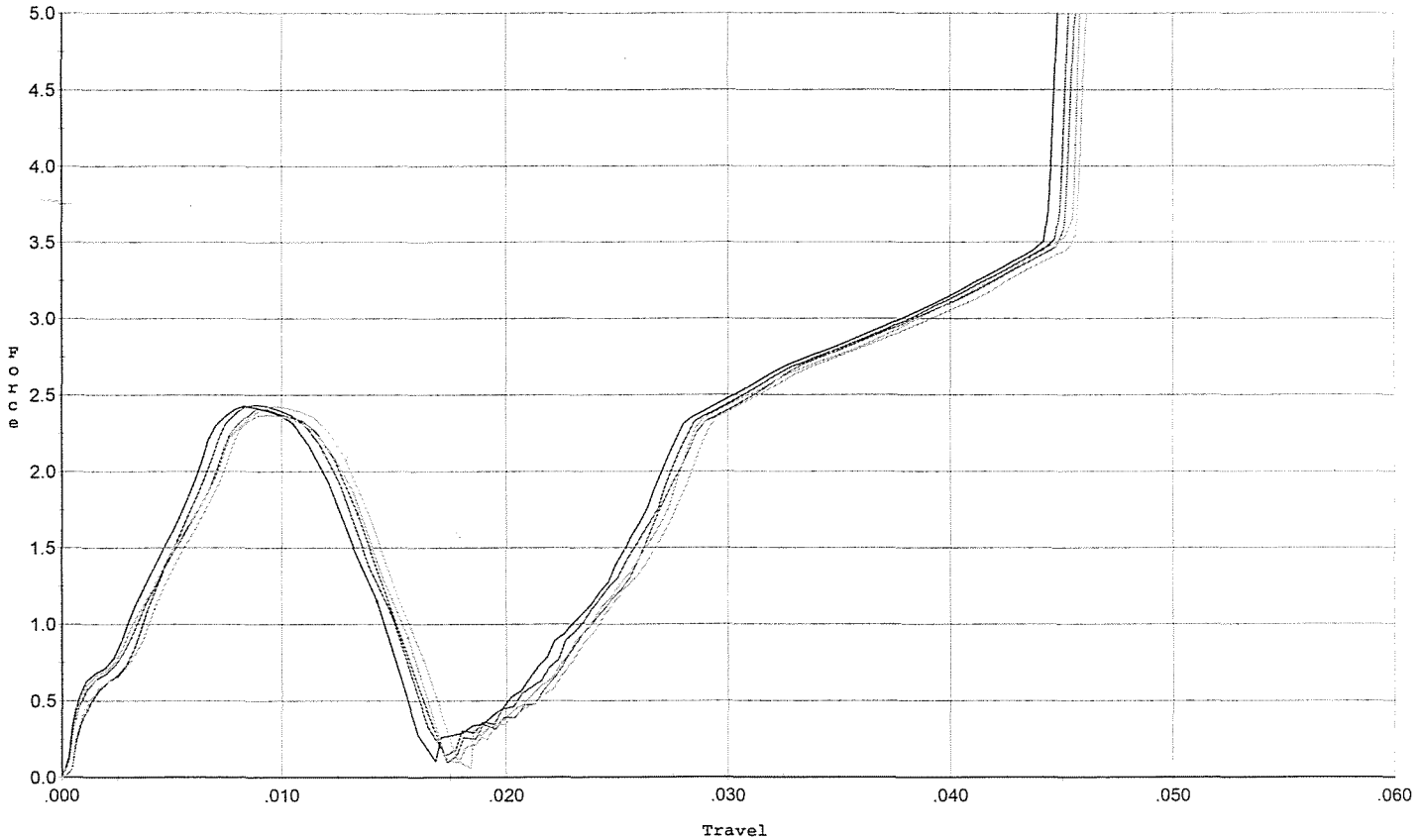
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.508	0.014	0.00	0.033	0.022		Set Trigger
2	2.532	0.014	0.00	0.034	0.022		Set Trigger
3	2.558	0.015	0.00	0.033	0.023		Set Trigger
4	2.586	0.014	0.00	0.033	0.023		Set Trigger
5	2.555	0.015	0.00	0.033	0.024		Set Trigger

A-2.54

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



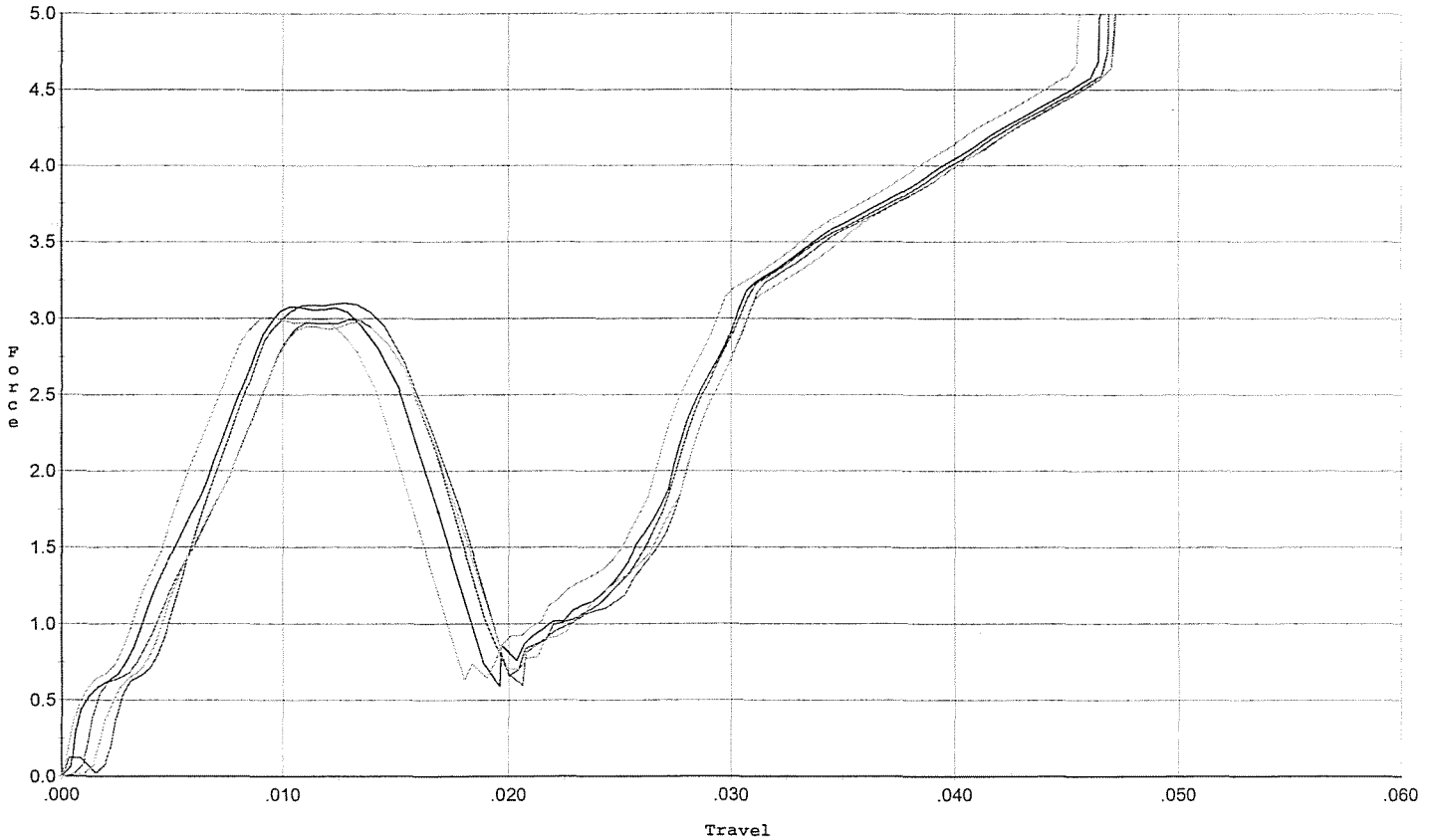
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.015	0.00	0.034	0.022		Set Trigger
2	2.426	0.014	0.00	0.034	0.022		Set Trigger
3	2.406	0.013	0.00	0.035	0.020		Set Trigger
4	2.425	0.016	0.00	0.034	0.024		Set Trigger
5	2.369	0.016	0.00	0.034	0.023		Set Trigger

A-2.41

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



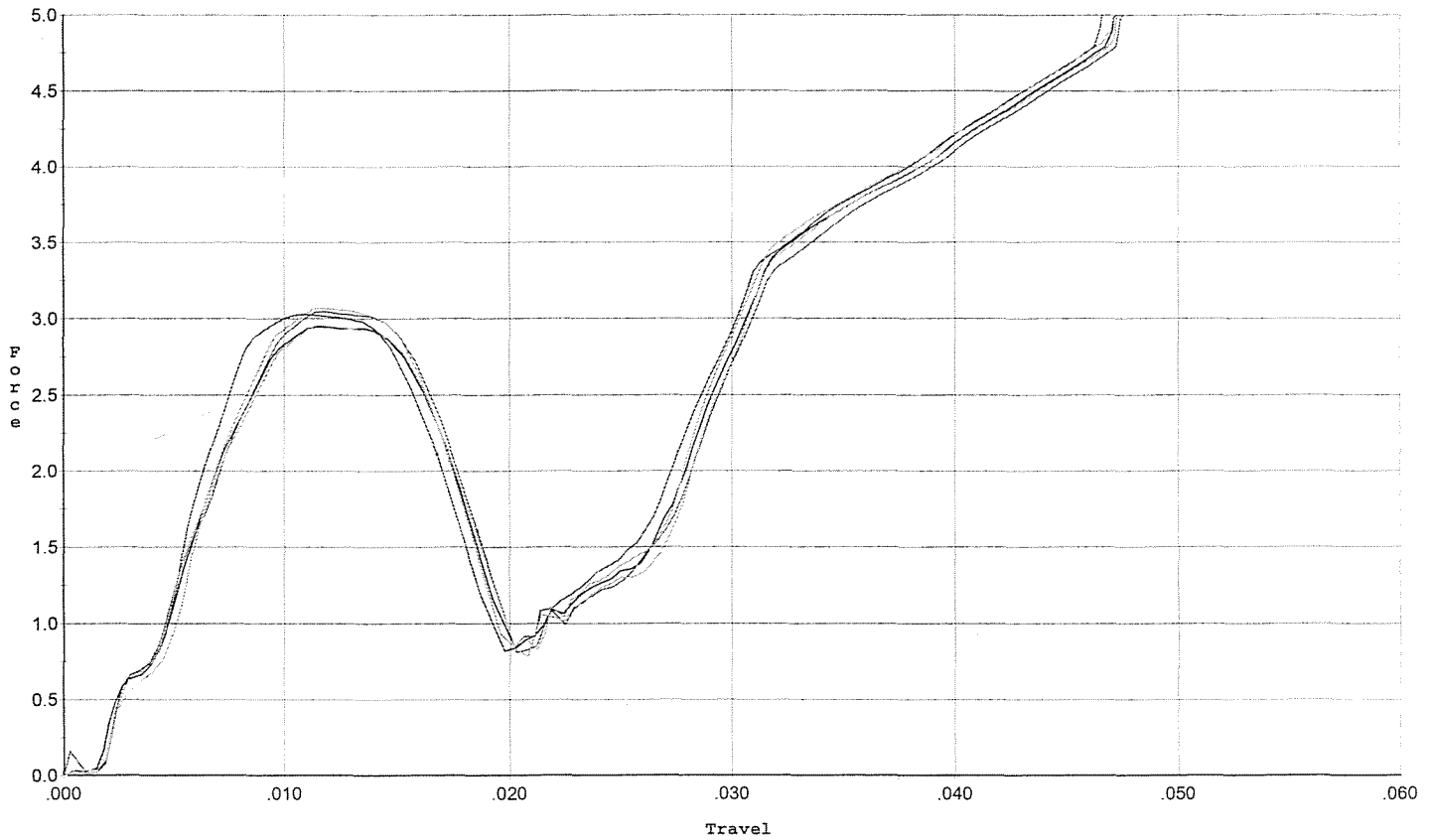
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.101	0.018	0.002	0.031	0.033		Set Trigger
2	3.078	0.017	0.00	0.032	0.032		Set Trigger
3	2.993	0.017	0.00	0.032	0.030		Set Trigger
4	2.972	0.018	0.00	0.032	0.032		Set Trigger
5	3.011	0.016	0.00	0.031	0.031		Set Trigger

A-3.03

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



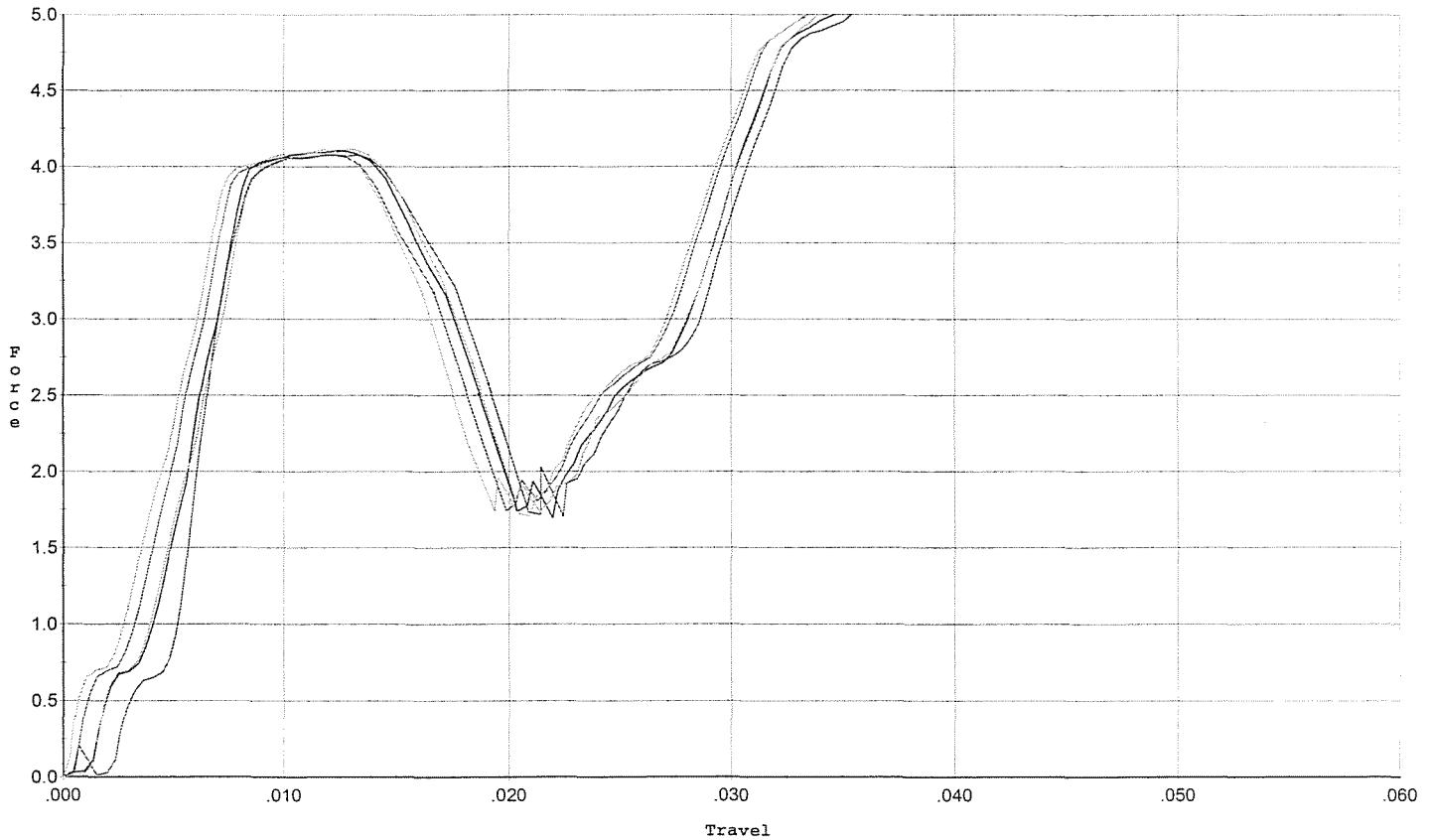
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.029	0.017	0.002	0.031	0.031		Set Trigger
2	2.949	0.017	0.00	0.031	0.031		Set Trigger
3	3.046	0.019	0.00	0.031	0.034		Set Trigger
4	2.955	0.019	0.00	0.031	0.033		Set Trigger
5	3.066	0.017	0.002	0.031	0.032		Set Trigger

A 3.00

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



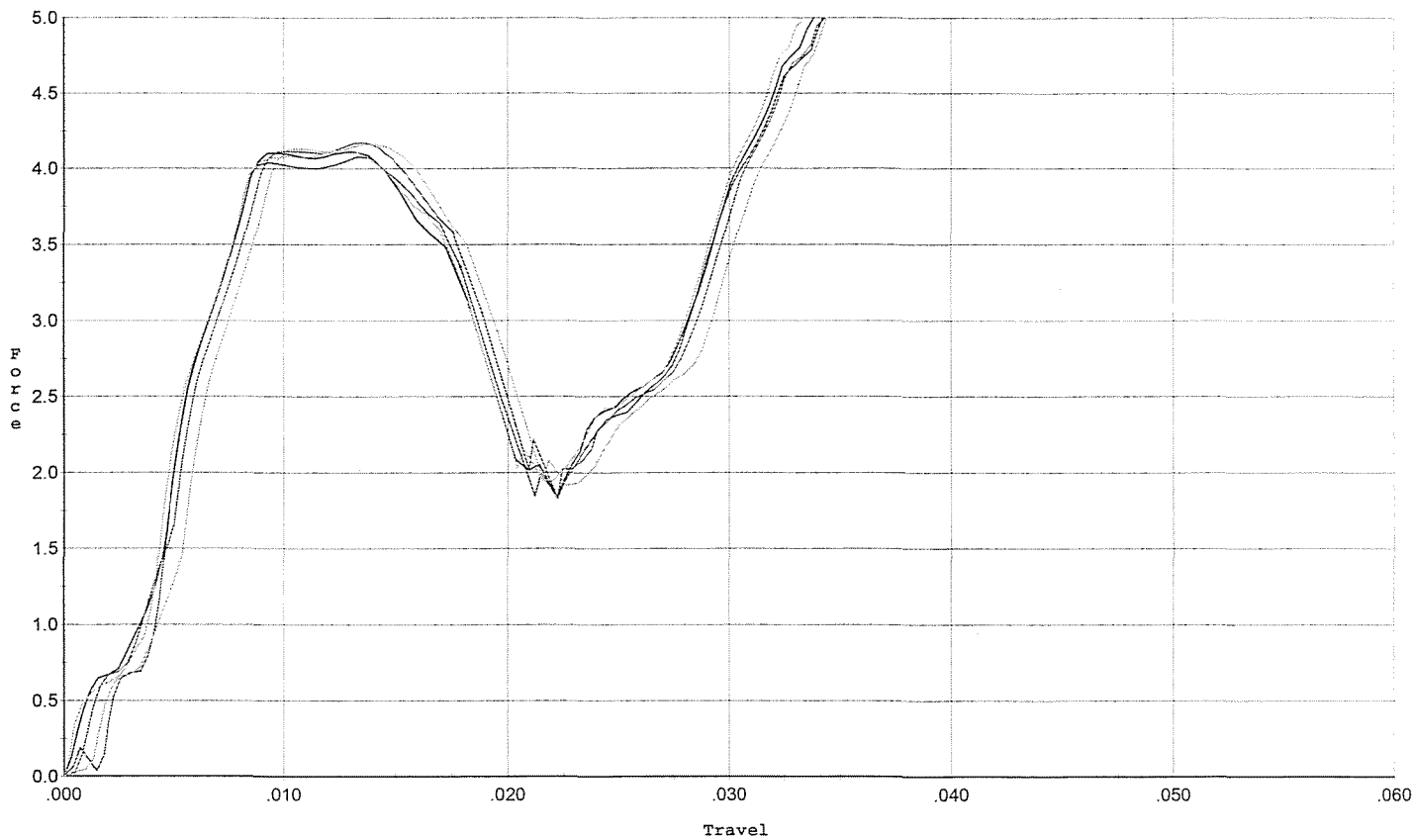
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.077	0.019	0.00	0.022	0.047		Set Trigger
2	4.105	0.019	0.00	0.022	0.047		Set Trigger
3	4.077	0.017	0.00	0.022	0.043		Set Trigger
4	4.112	0.016	0.00	0.022	0.043		Set Trigger
5	4.117	0.018	0.00	0.022	0.046		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: 4.0 lbs after 20 cycles+/- 1.0 lb



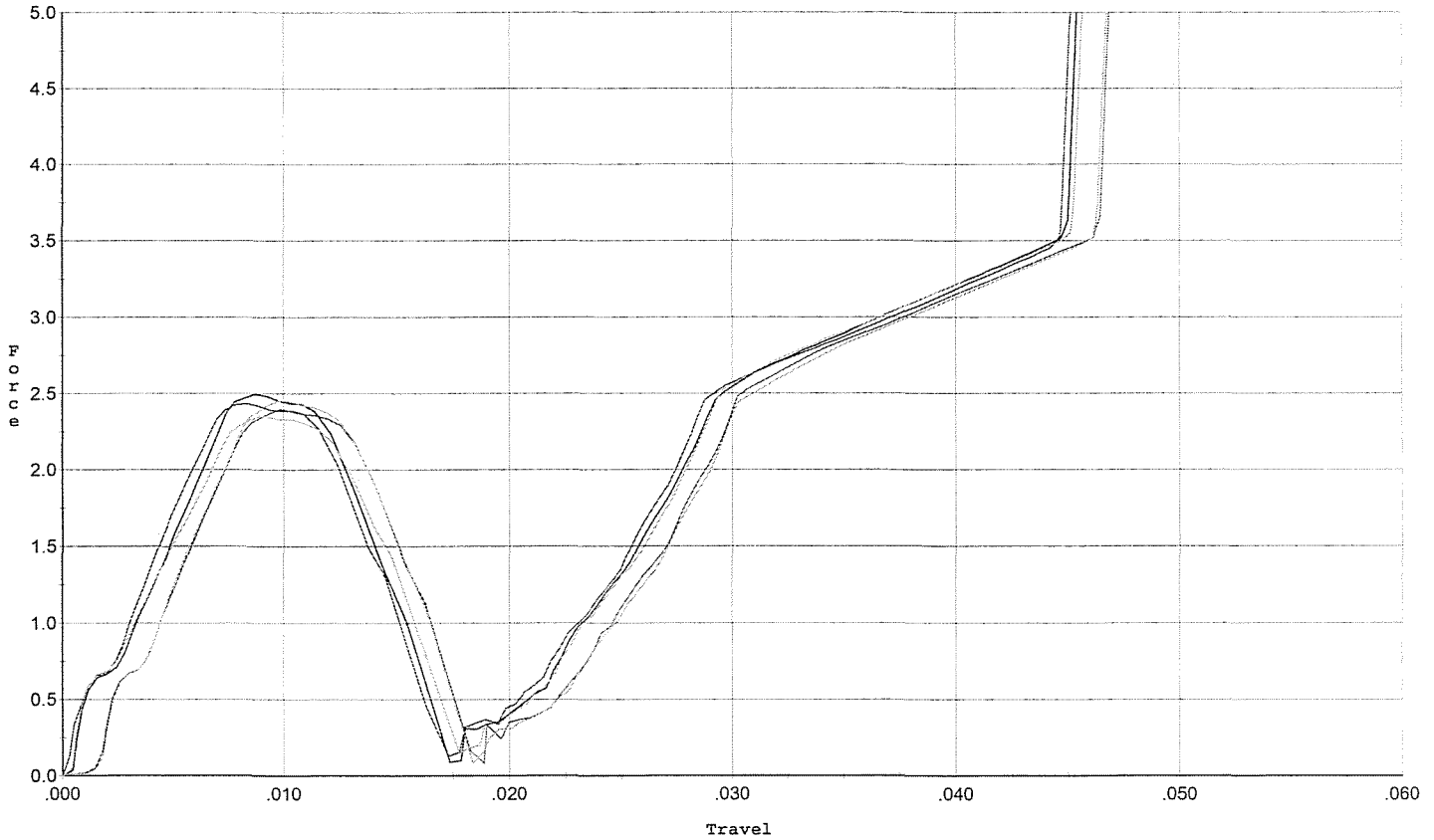
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.080	0.018	0.00	0.016	0.047		Set Trigger
2	4.109	0.018	0.00	0.016	0.049		Set Trigger
3	4.173	0.019	0.00	0.015	0.050		Set Trigger
4	4.124	0.018	0.00	0.015	0.049		Set Trigger
5	4.164	0.020	0.00	0.015	0.050		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: reset to 2.5 lbs +/- .50 lb for final test



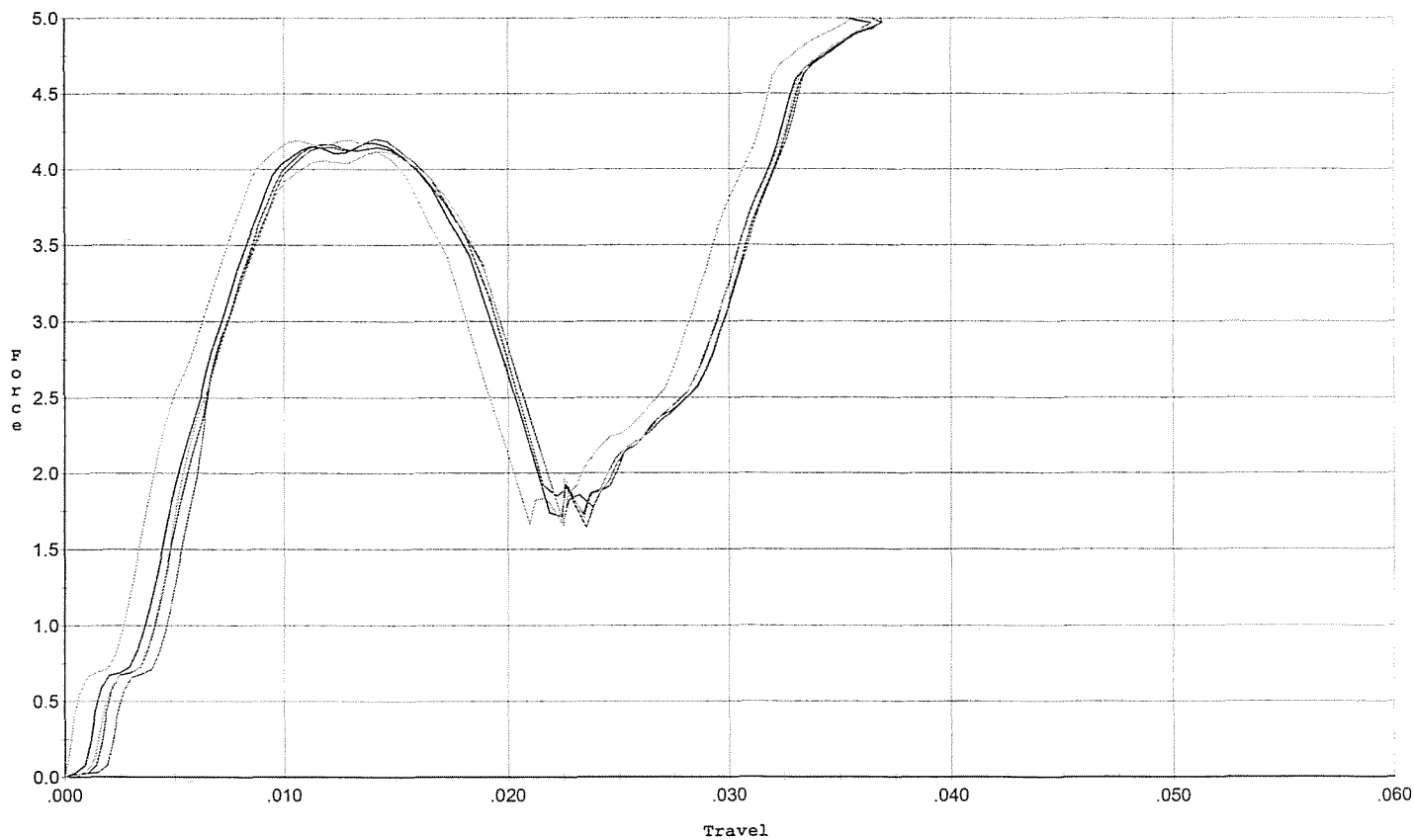
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.015	0.00	0.034	0.023		Set Trigger
2	2.496	0.015	0.00	0.034	0.024		Set Trigger
3	2.398	0.016	0.00	0.034	0.024		Set Trigger
4	2.354	0.016	0.00	0.034	0.025		Set Trigger
5	2.452	0.016	0.00	0.034	0.024		Set Trigger

A-2.42

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	4.164	0.019	0.00	0.023	0.049		Set Trigger
2	4.174	0.020	0.00	0.022	0.053		Set Trigger
3	4.199	0.019	0.00	0.023	0.049		Set Trigger
4	4.120	0.019	0.00	0.022	0.049		Set Trigger
5	4.193	0.017	0.00	0.023	0.048		Set Trigger

A-4-17