

G 680 1472

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



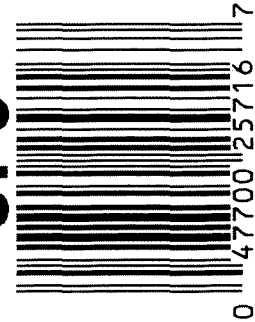
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6801472

UPC



GUN SERIAL # G 6801472

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RR
430	ASSEMBLE TO STOCK		3-6-09	RR
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RR
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RR
475	DRILL AND TAP SIGHT HOLES		3-9-09	JP
480	MAGNAFLUX BBL ACTION	OPERATOR (D)	3/13/09	(D)
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-26-09	LR
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

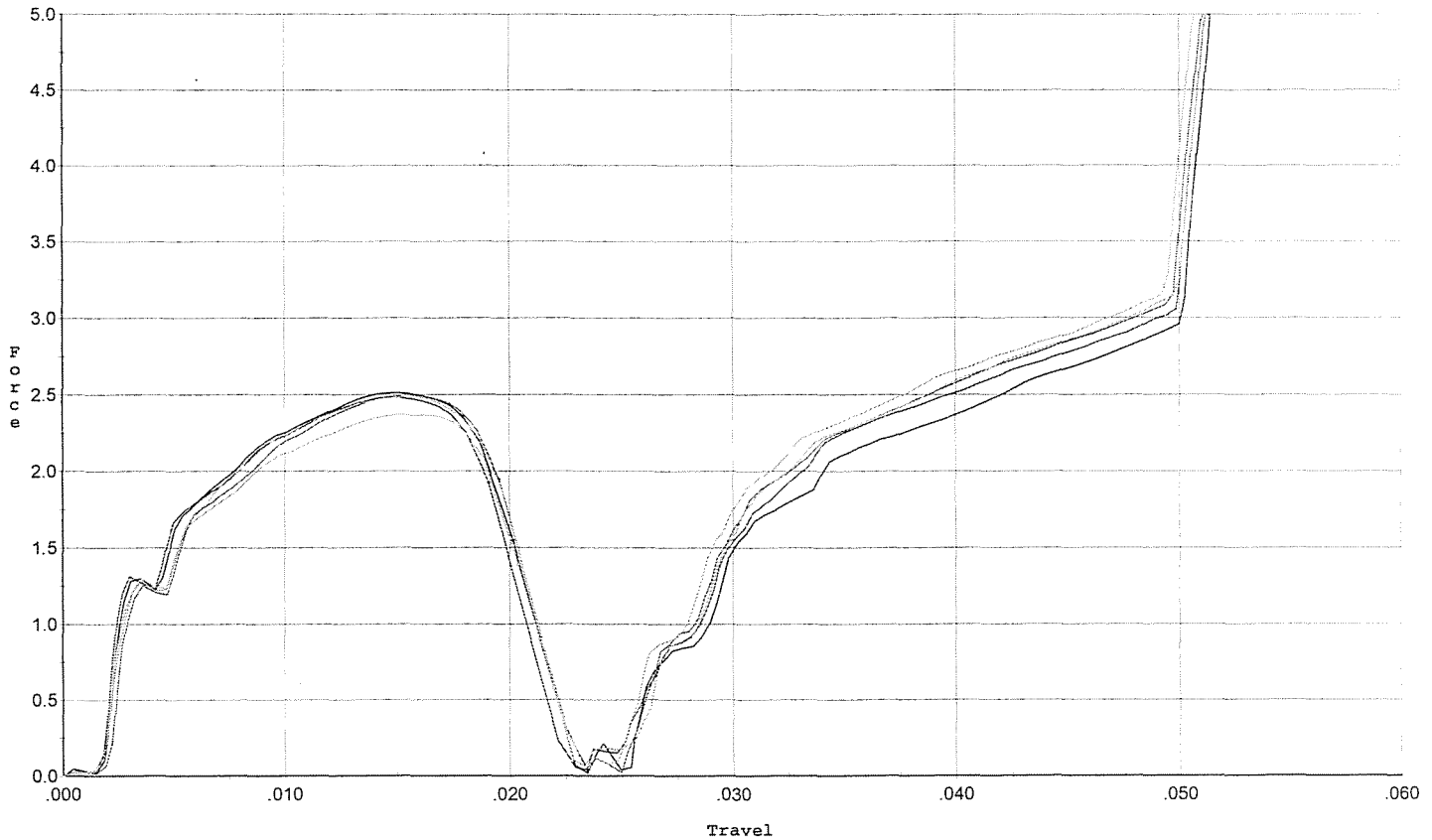
F004 REV 5/2006

BARBER - M24-0015692									
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0	4.0	4.0	3-30-09	L N		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	6.0	6.0	5.0	3-30-09	L N		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.024	3-30-09	L N		
	J) ASSEMBLE STOCK					3-26-09	L N		
	K) ASSEMBLE SWIVEL STUDS					3-30-09	L N		
	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		3-27-09	TL		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					3-27-09	TL		
670	FINAL INSPECTION A) HEADSPACE					3-30-09	L N		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.59	2.51	2.46	2.53	2.42	3-28-09	TL
	C) FUNCTION					3-30-09	L N		
690	PACK					3/31/09	FM		

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



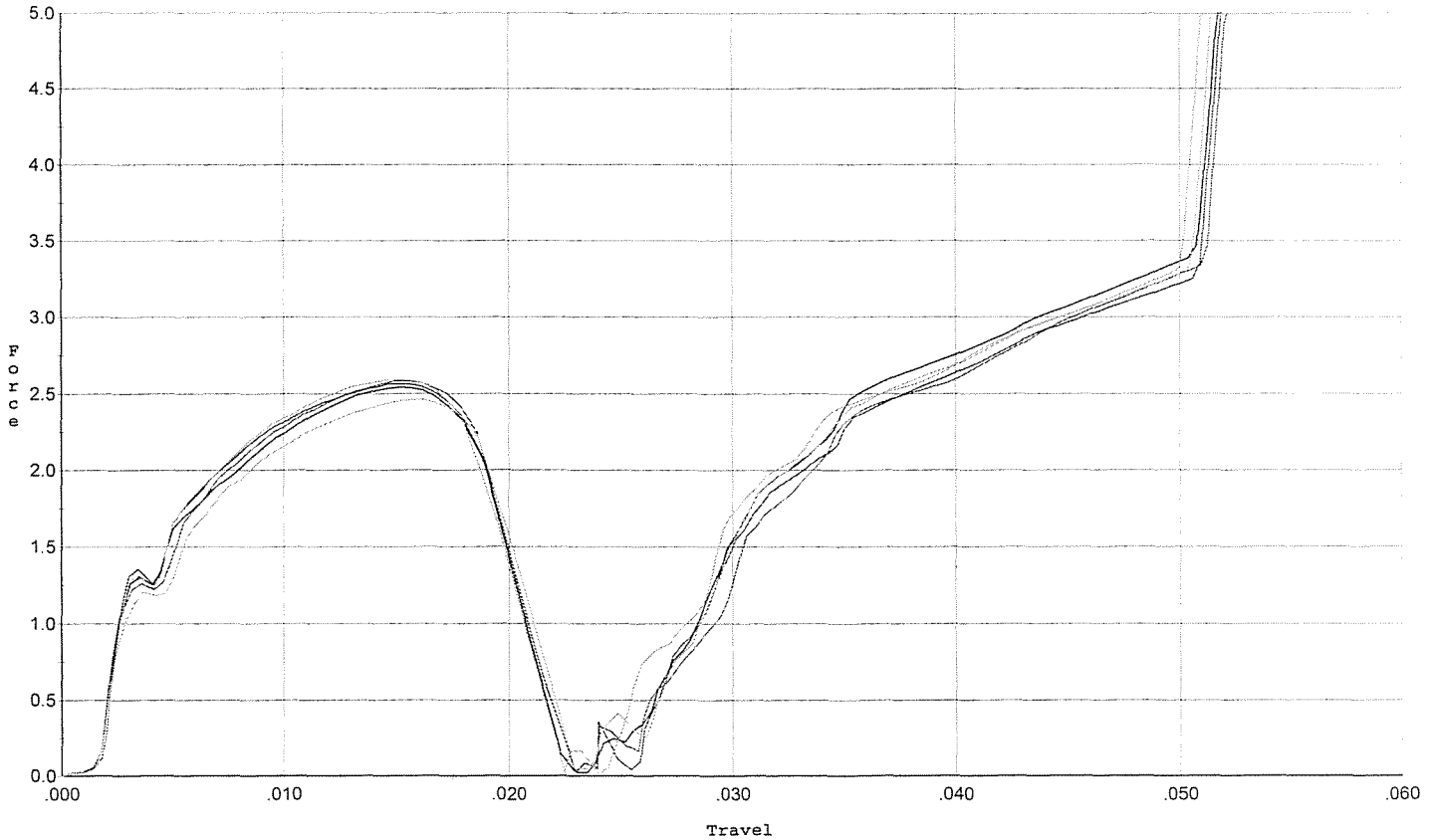
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.482	0.019	0.004	0.036	0.033		Set Trigger
2	2.512	0.020	0.002	0.036	0.035		Set Trigger
3	2.499	0.020	0.002	0.035	0.033		Set Trigger
4	2.370	0.020	0.005	0.035	0.034		Set Trigger
5	2.490	0.020	0.00	0.035	0.034		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



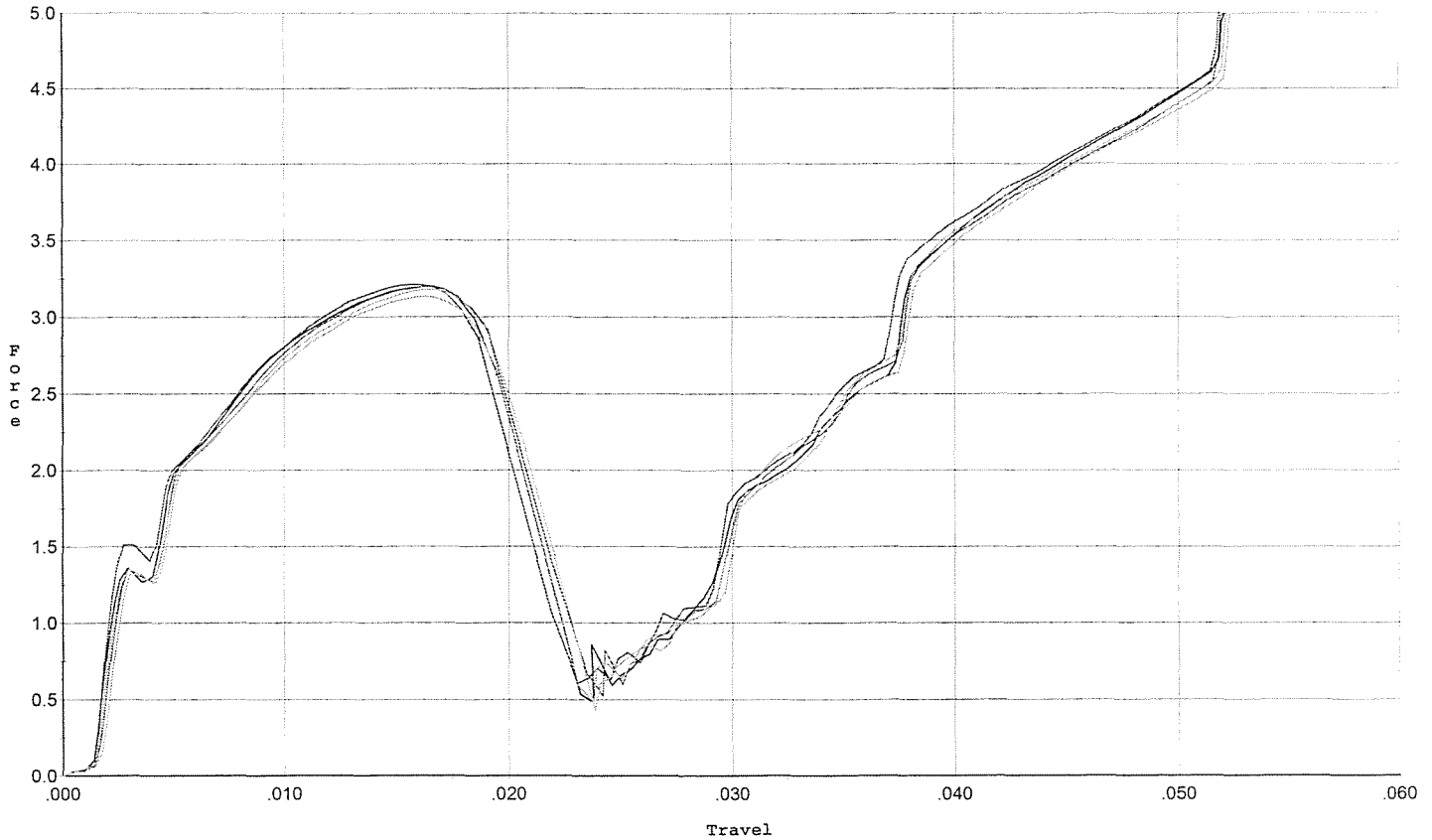
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.019	0.00	0.036	0.034		Set Trigger
2	2.541	0.019	0.00	0.036	0.033		Set Trigger
3	2.585	0.019	0.00	0.036	0.033		Set Trigger
4	2.463	0.020	0.00	0.035	0.034		Set Trigger
5	2.591	0.019	0.00	0.035	0.035		Set Trigger

A-2.54

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



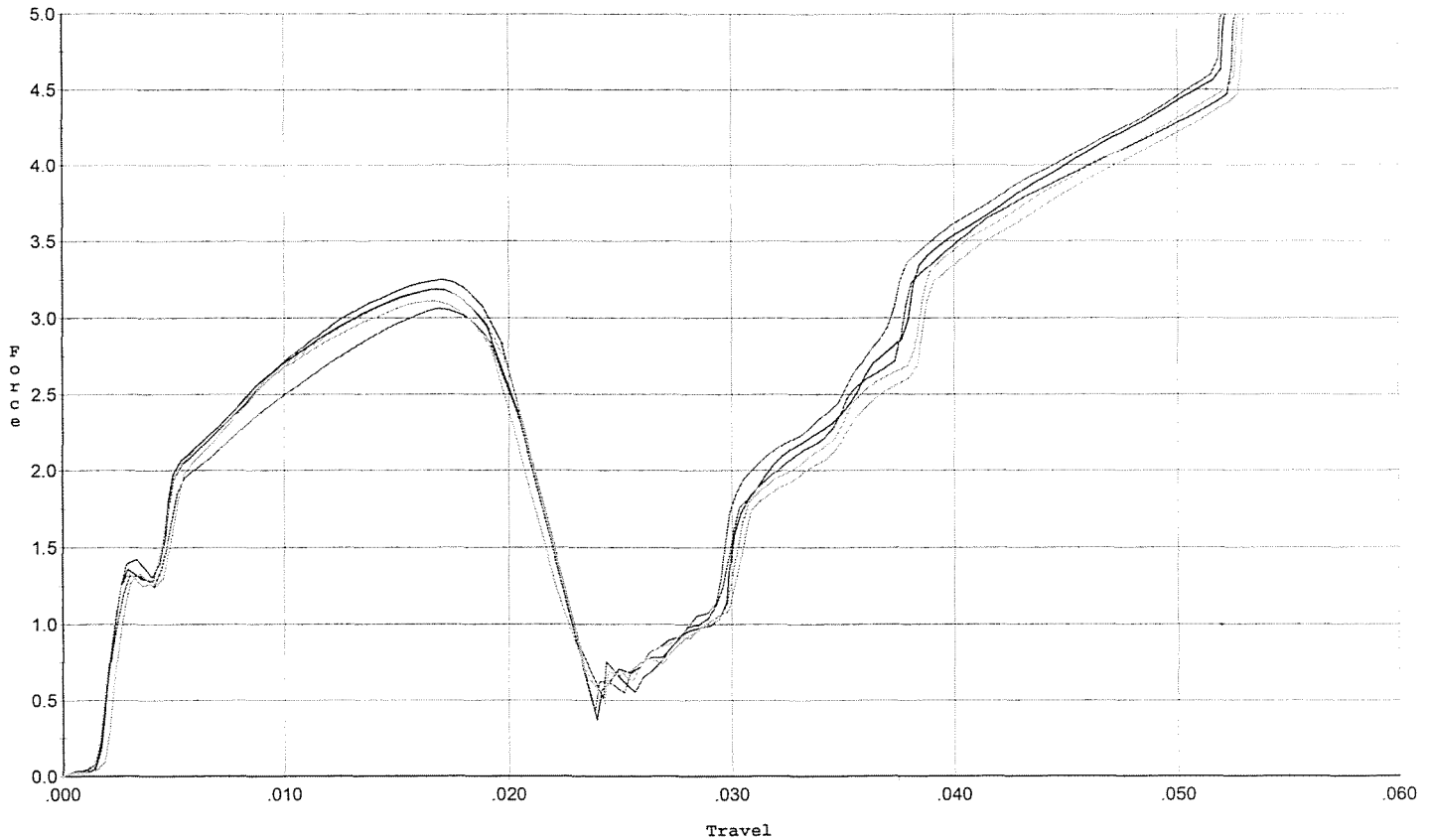
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.211	0.019	0.004	0.035	0.041		Set Trigger
2	3.199	0.020	0.00	0.035	0.043		Set Trigger
3	3.196	0.019	0.004	0.035	0.041		Set Trigger
4	3.179	0.021	0.00	0.034	0.044		Set Trigger
5	3.134	0.019	0.004	0.035	0.041		Set Trigger

A-3.18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



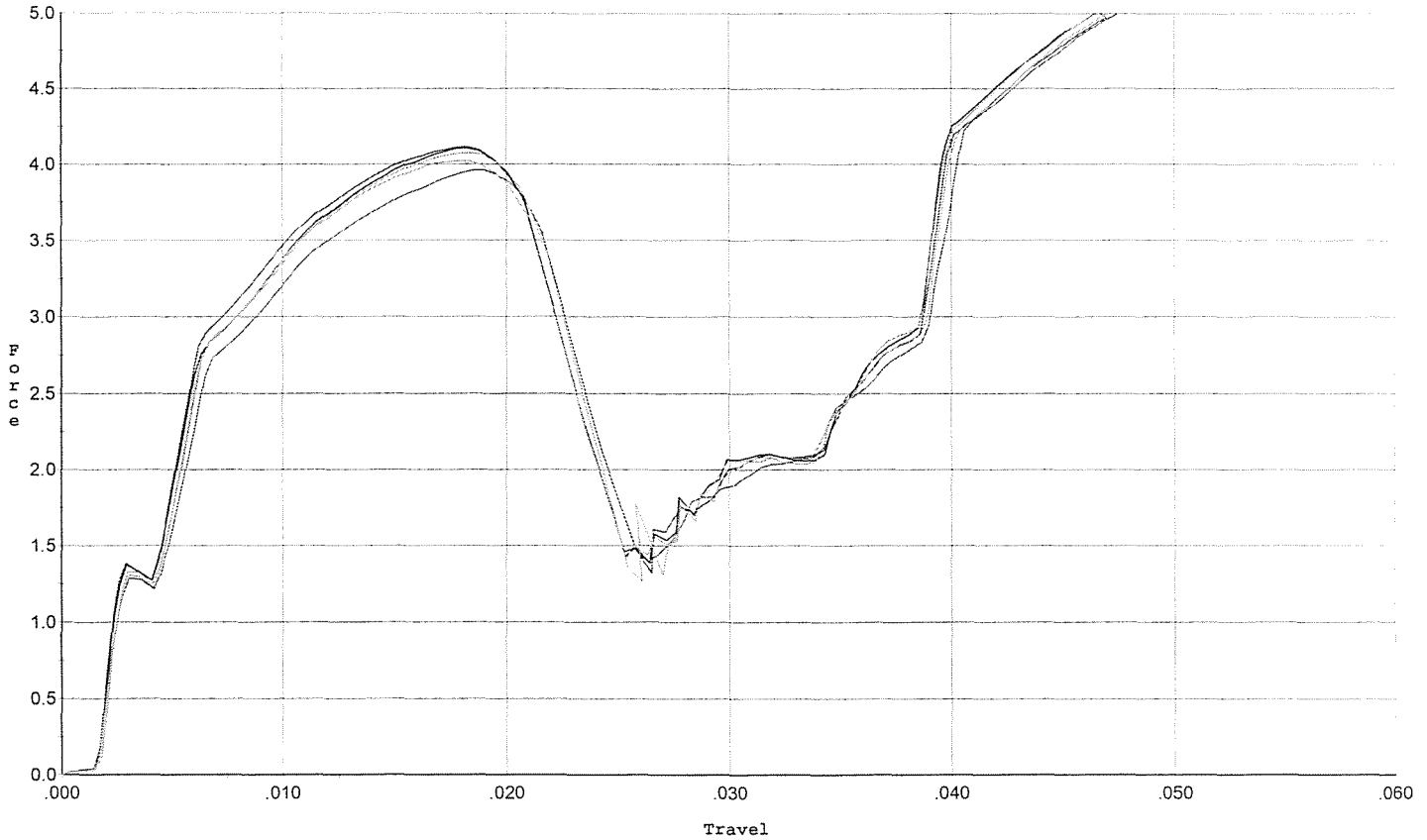
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.249	0.020	0.00	0.035	0.043		Set Trigger
2	3.187	0.020	0.004	0.034	0.044		Set Trigger
3	3.061	0.020	0.004	0.034	0.042		Set Trigger
4	3.111	0.019	0.00	0.035	0.041		Set Trigger
5	3.183	0.020	0.00	0.035	0.042		Set Trigger

A-3.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



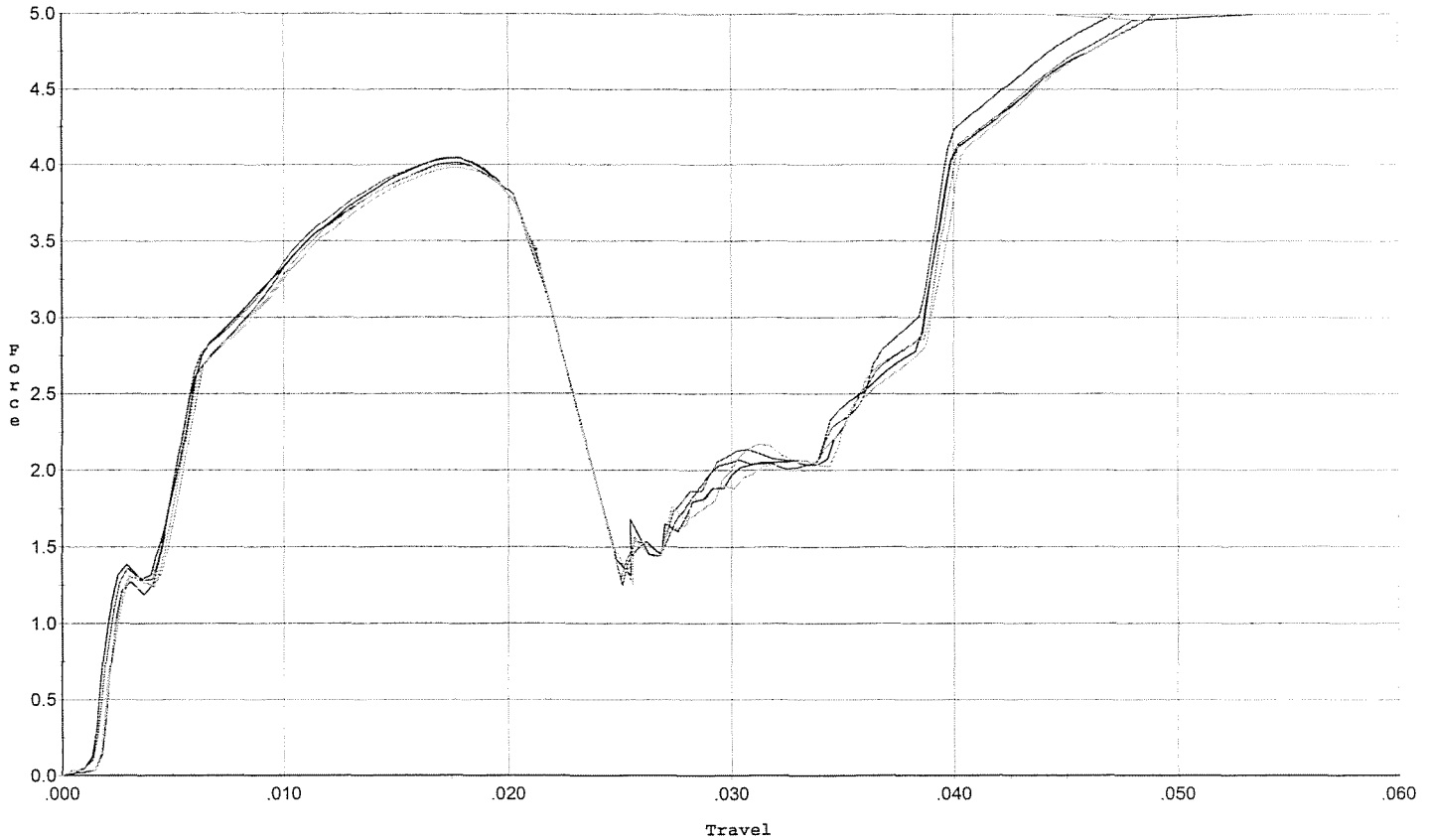
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.115	0.021	0.004	0.033	0.057		Set Trigger
2	4.107	0.021	0.004	0.033	0.056		Set Trigger
3	3.958	0.022	0.004	0.033	0.057		Set Trigger
4	4.073	0.022	0.002	0.033	0.059		Set Trigger
5	4.020	0.021	0.002	0.033	0.056		Set Trigger

A-4.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



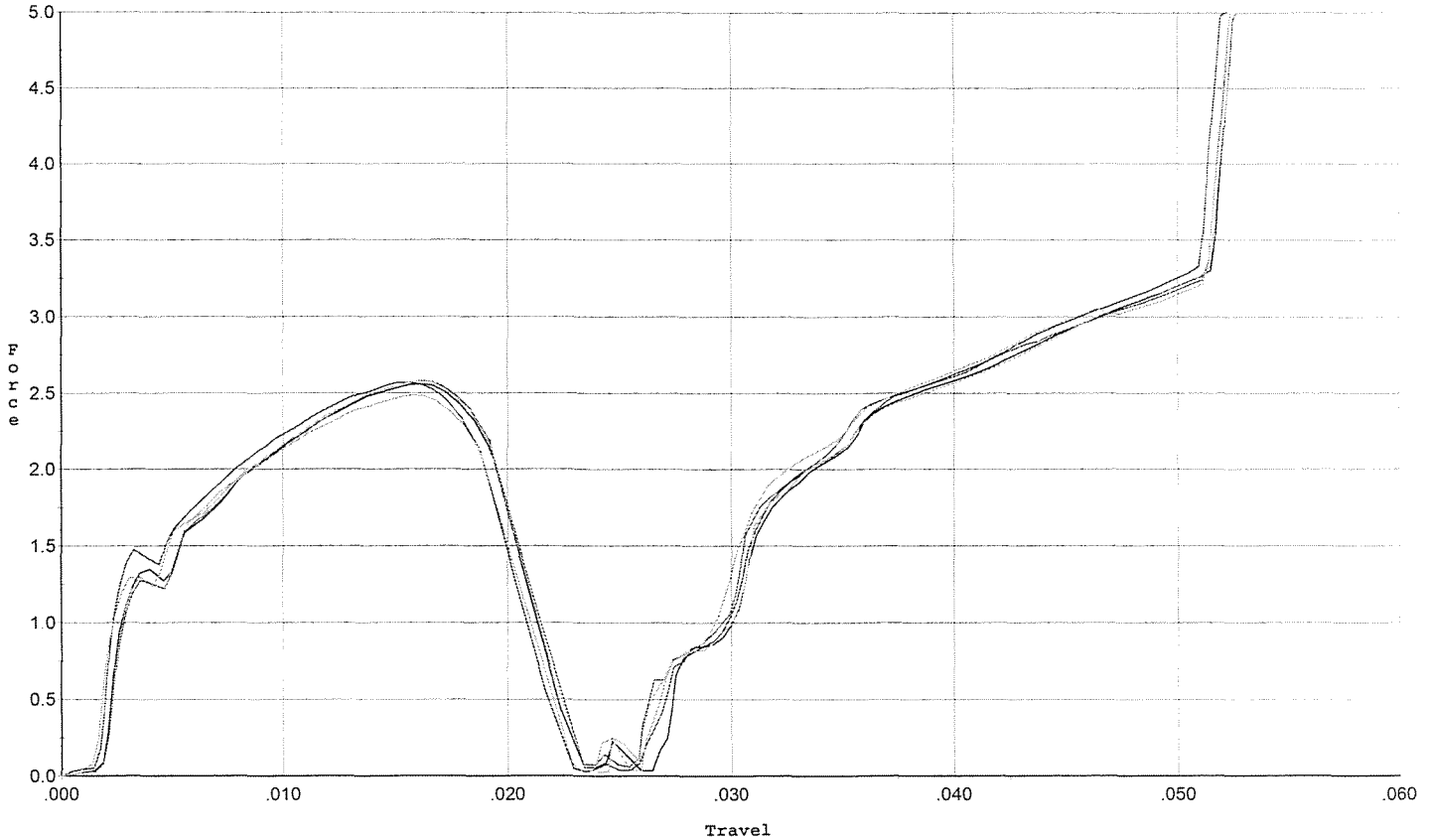
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.011	0.021	0.00	0.033	0.057		Set Trigger
2	4.047	0.021	0.00	0.033	0.057		Set Trigger
3	4.042	0.022	0.004	0.033	0.058		Set Trigger
4	3.980	0.022	0.002	0.034	0.057		Set Trigger
5	3.995	0.021	0.002	0.034	0.056		Set Trigger

A-4.01

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



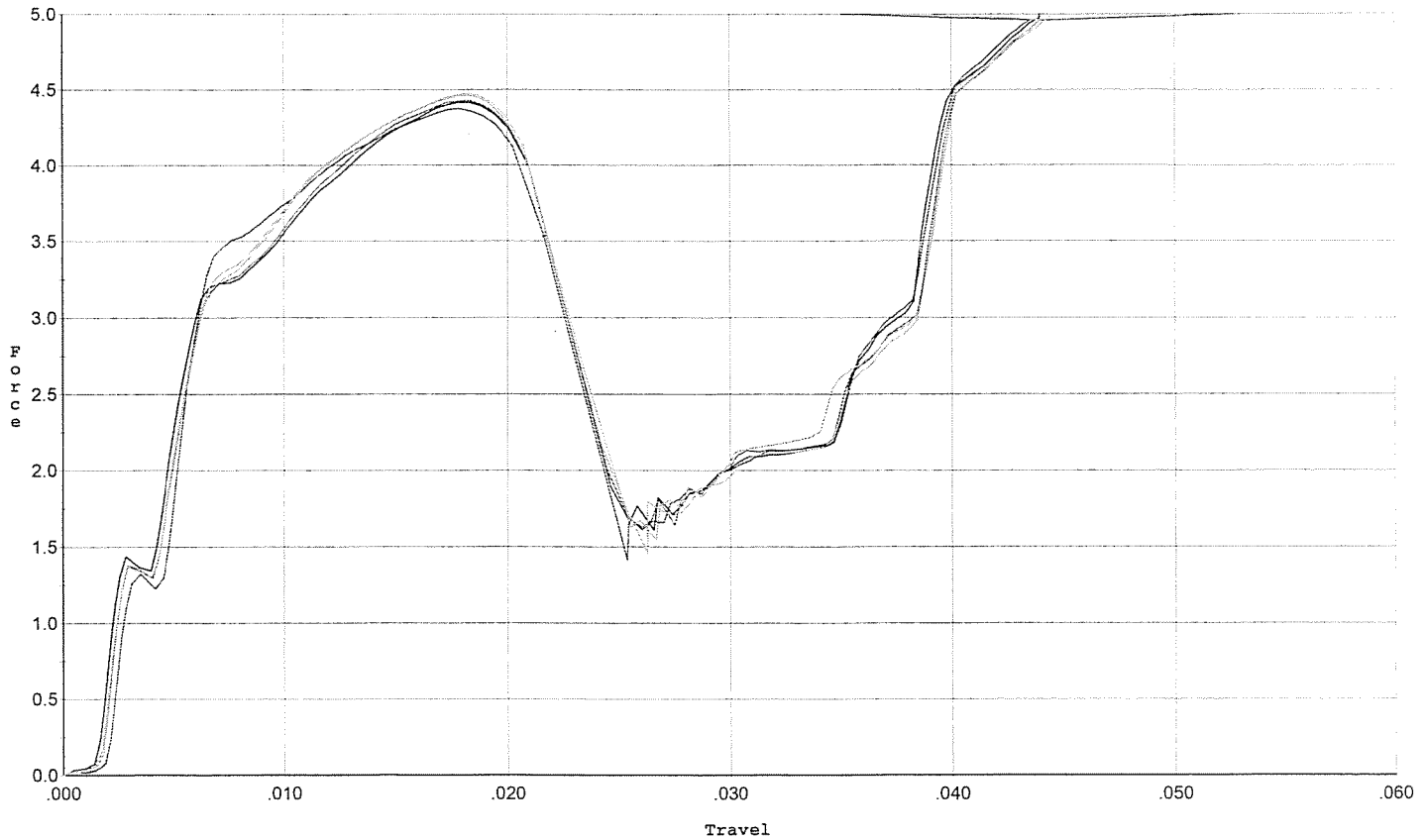
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.019	0.005	0.036	0.033		Set Trigger
2	2.559	0.019	0.00	0.036	0.033		Set Trigger
3	2.582	0.019	0.005	0.036	0.033		Set Trigger
4	2.580	0.019	0.005	0.036	0.033		Set Trigger
5	2.488	0.019	0.004	0.037	0.032		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.374	0.022	0.00	0.033	0.063		Set Trigger
2	4.417	0.021	0.004	0.032	0.061		Set Trigger
3	4.428	0.021	0.004	0.033	0.061		Set Trigger
4	4.474	0.021	0.004	0.033	0.061		Set Trigger
5	4.463	0.021	0.004	0.033	0.061		Set Trigger

A-4.43