

G6807707

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



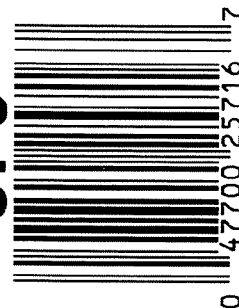
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807707

UPC



GUN SERIAL #

G 680 7707

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RT
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
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	Bd
542	APPLY COATINGS (BARREL ACTION)		3-29	
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	L. N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

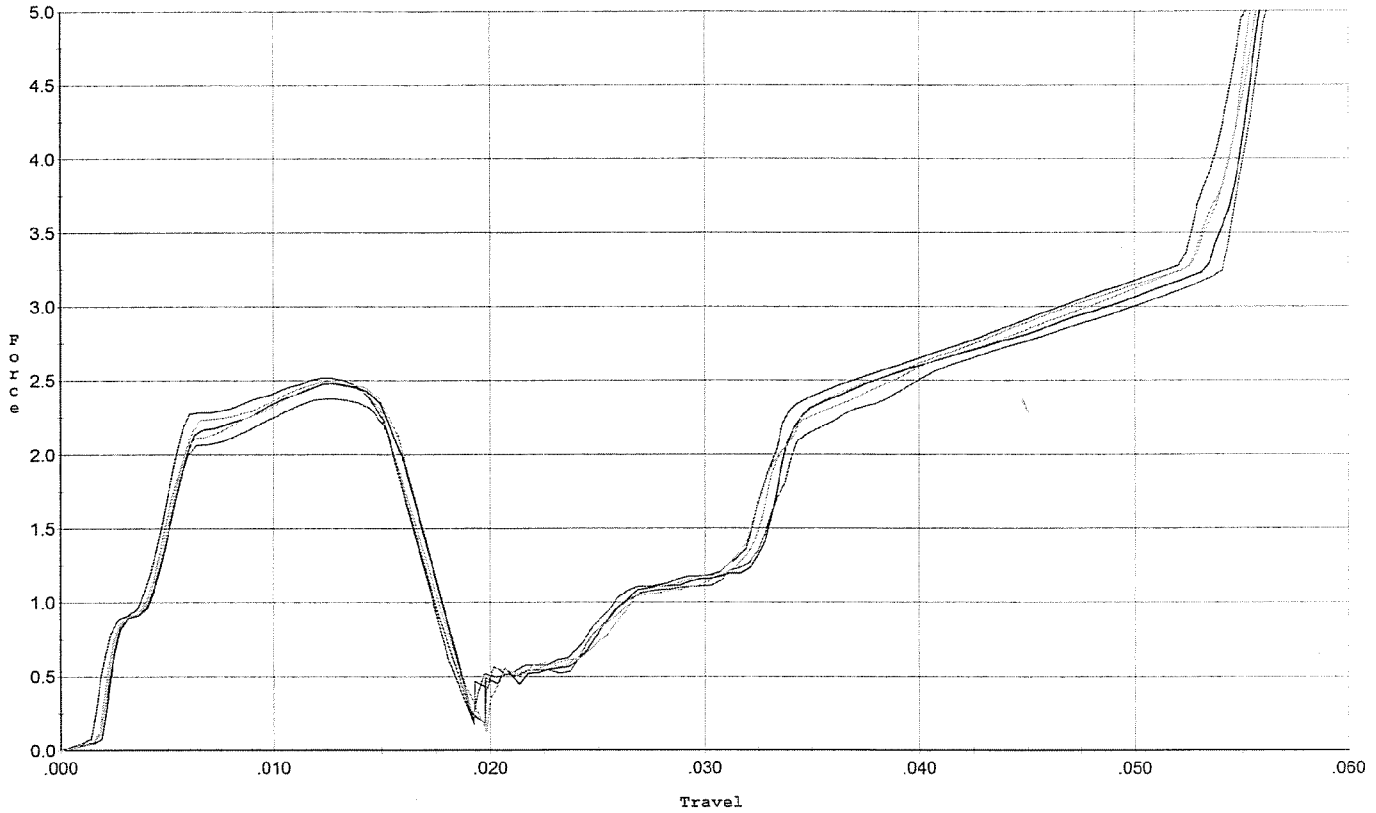
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0016631 F) SAFETY ON FORCE 10 LBS MIN 10 LBS MAX	<u>2</u> <u>7</u> <u>6.5</u>	4-29-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-29-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-29-09	WV
	J) ASSEMBLE STOCK		4-22-09	WV
	K) ASSEMBLE SWIVEL STUDS		4-29-09	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	4-24-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		4-29-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.61</u> <u>2.41</u> <u>2.35</u> <u>2.39</u>	4-28-09	WV
	C) FUNCTION		4-29-09	WV
690	PACK		5/29/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schulis 2/25/2009

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



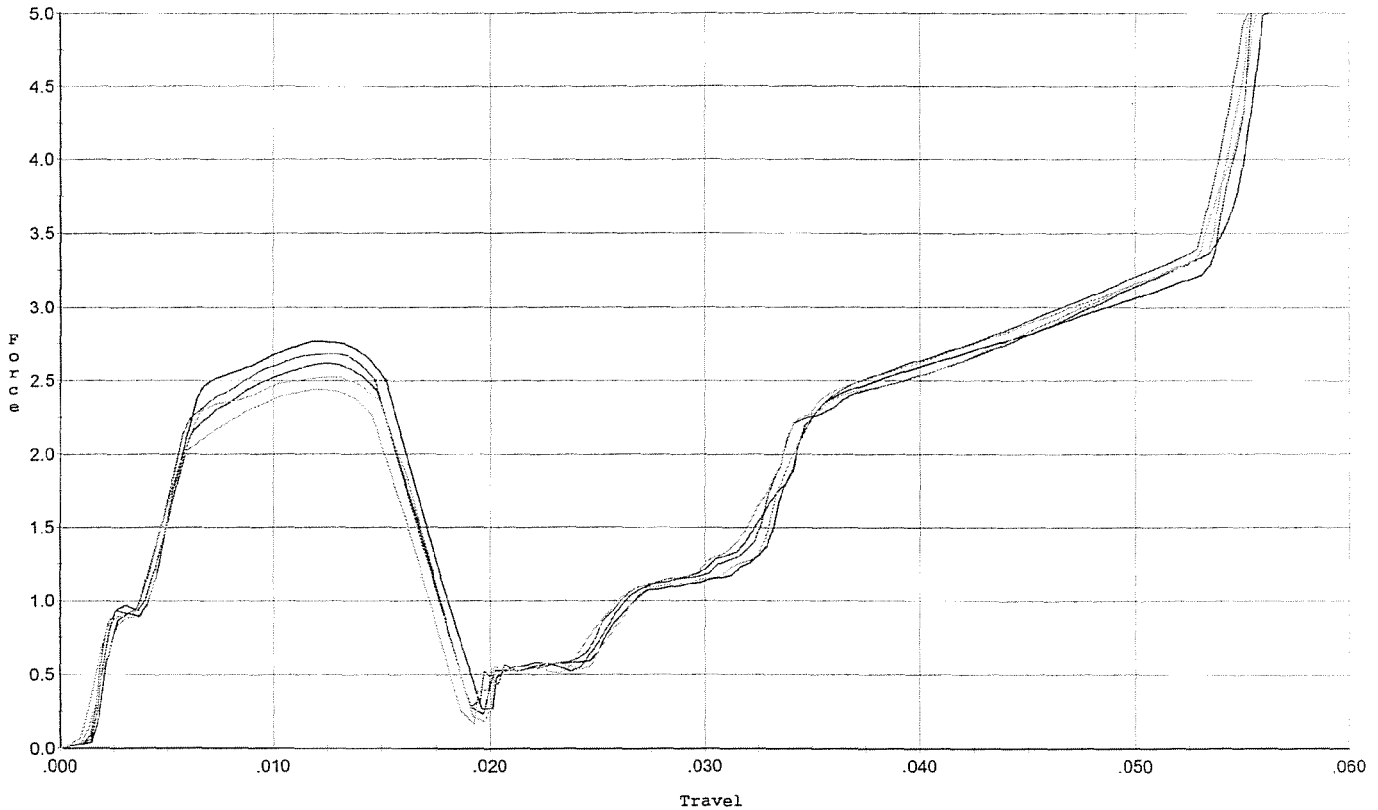
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.516	0.015	0.00	0.042	0.026		Set Trigger
2	2.480	0.016	0.00	0.043	0.026		Set Trigger
3	2.375	0.015	0.00	0.043	0.024		Set Trigger
4	2.488	0.015	0.00	0.043	0.025		Set Trigger
5	2.497	0.016	0.00	0.042	0.026		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



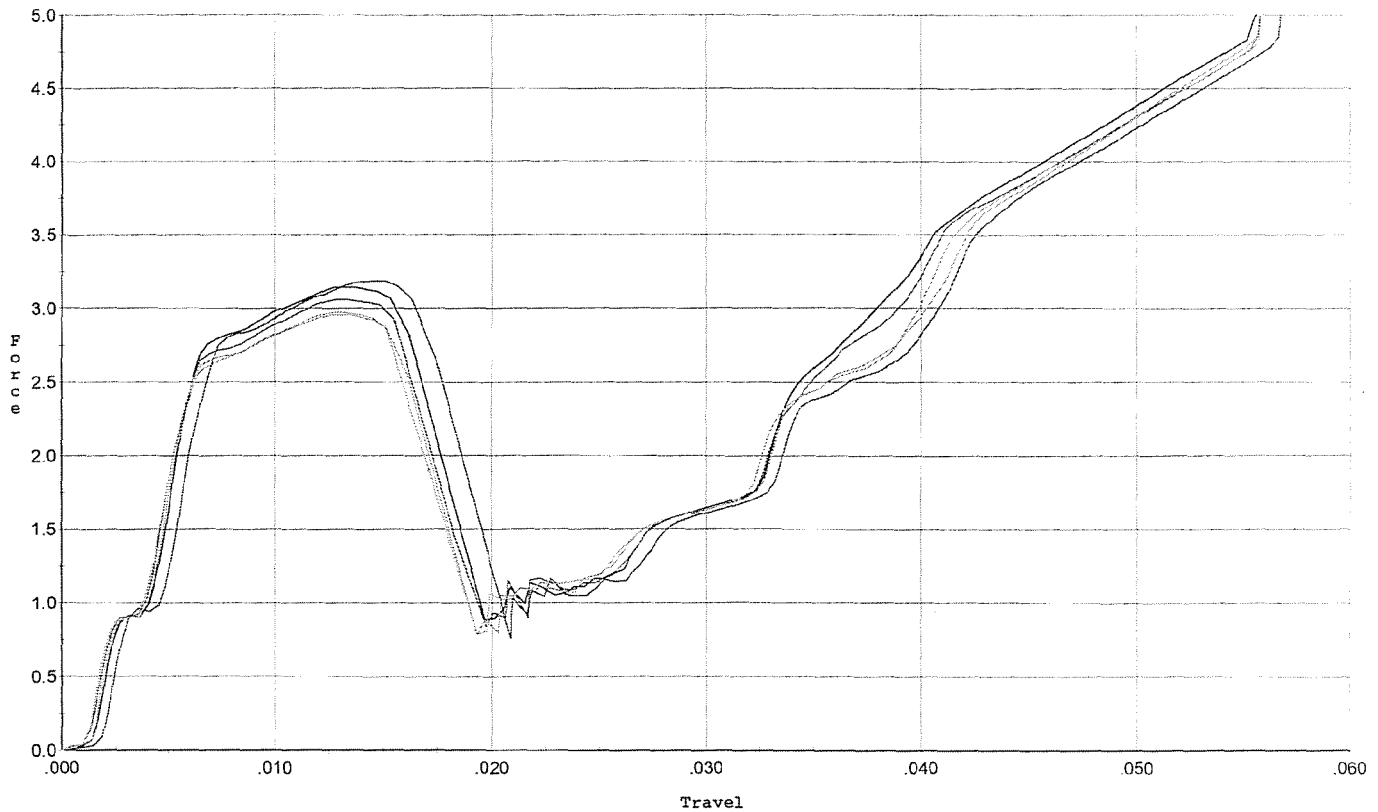
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.619	0.017	0.00	0.042	0.029		Set Trigger
2	2.766	0.015	0.00	0.043	0.028		Set Trigger
3	2.684	0.015	0.00	0.043	0.026		Set Trigger
4	2.526	0.016	0.00	0.042	0.028		Set Trigger
5	2.438	0.016	0.00	0.042	0.027		Set Trigger

A-2.60

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



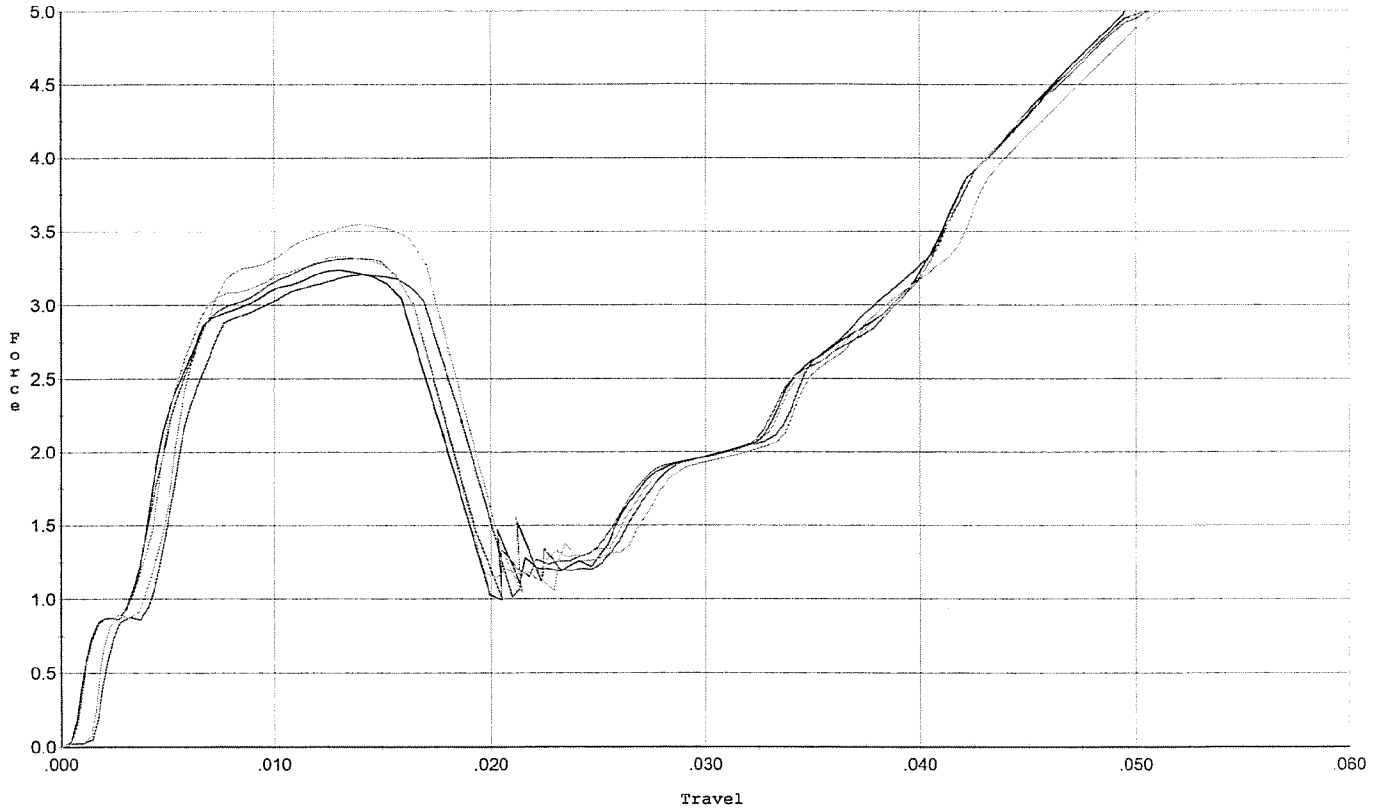
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.188	0.018	0.00	0.041	0.036		Set Trigger
2	3.144	0.016	0.00	0.040	0.033		Set Trigger
3	3.059	0.016	0.00	0.041	0.032		Set Trigger
4	2.972	0.017	0.00	0.041	0.034		Set Trigger
5	2.954	0.016	0.00	0.041	0.032		Set Trigger

A.3.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



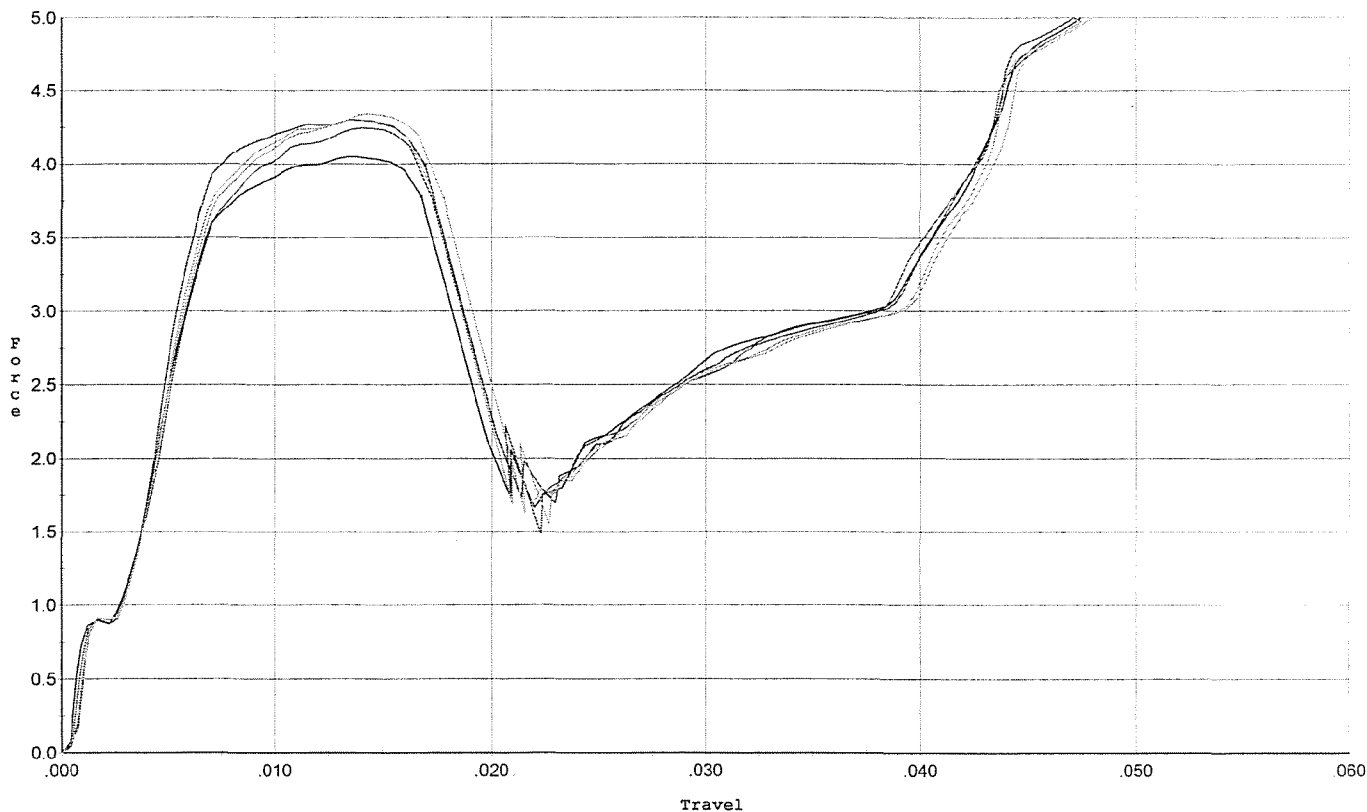
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.206	0.019	0.00	0.039	0.040		Set Trigger
2	3.238	0.018	0.00	0.040	0.039		Set Trigger
3	3.318	0.016	0.00	0.040	0.037		Set Trigger
4	3.333	0.016	0.00	0.040	0.037		Set Trigger
5	3.548	0.017	0.00	0.040	0.040		Set Trigger

A - 3-32

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



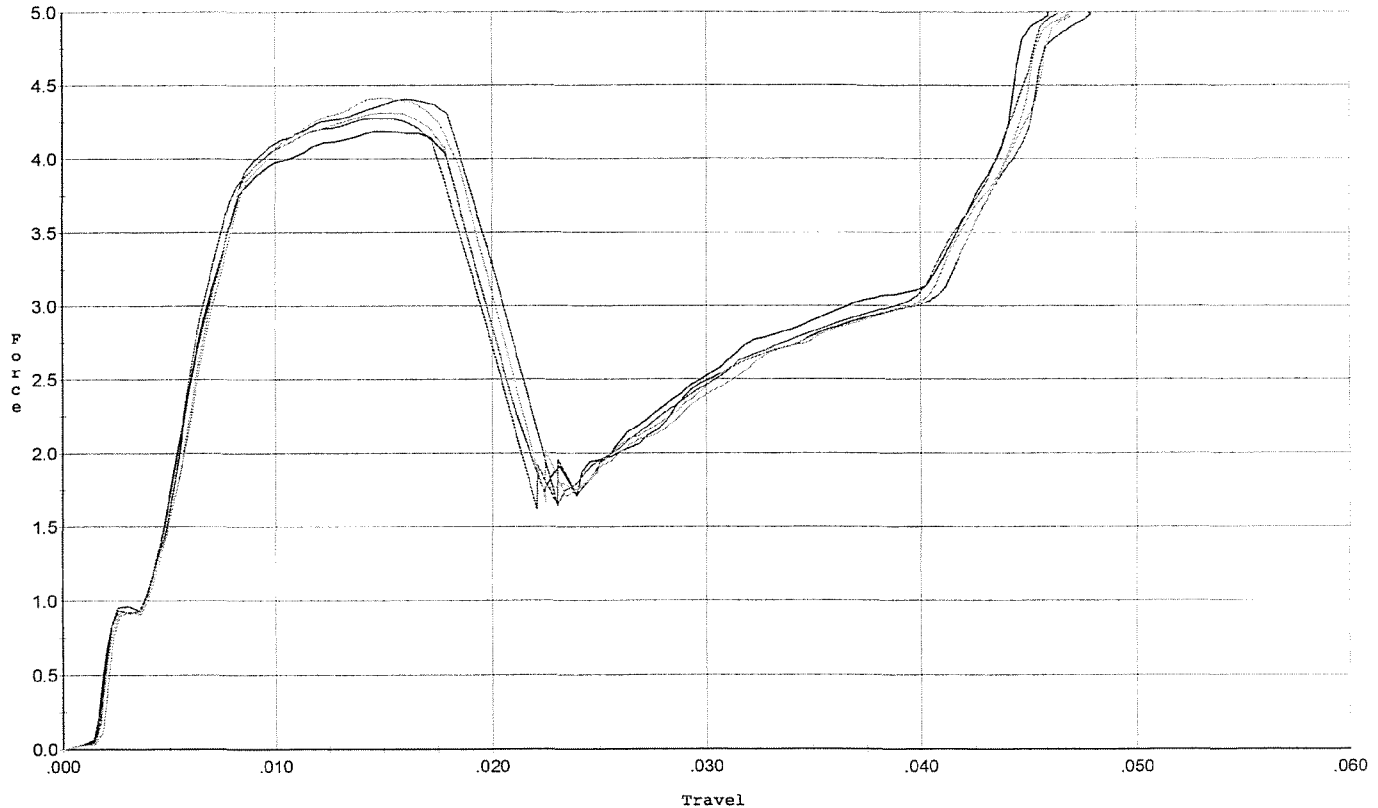
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.301	0.017	0.00	0.038	0.049		Set Trigger
2	4.049	0.017	0.00	0.038	0.046		Set Trigger
3	4.246	0.017	0.00	0.038	0.049		Set Trigger
4	4.296	0.017	0.00	0.038	0.049		Set Trigger
5	4.340	0.018	0.00	0.038	0.051		Set Trigger

A.4.24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



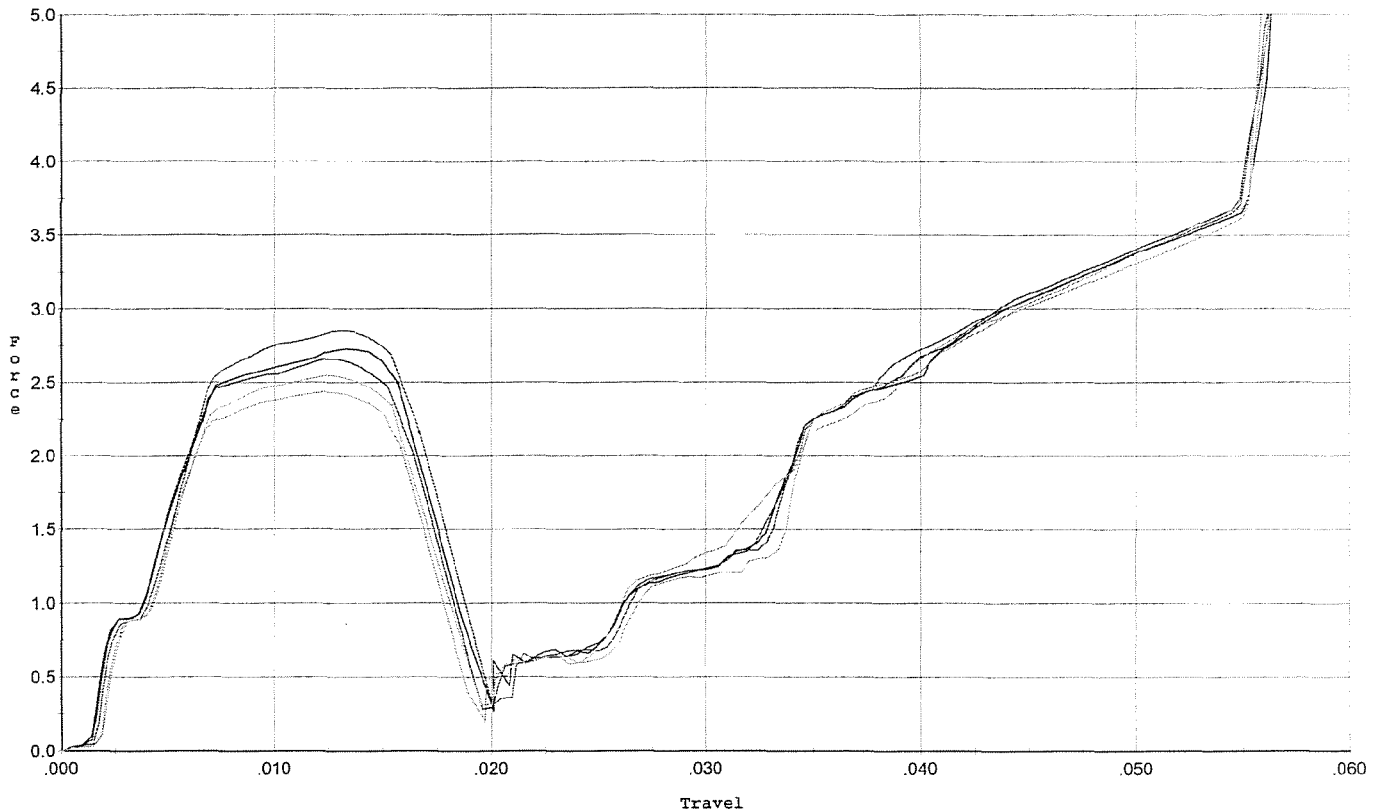
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.403	0.020	0.00	0.038	0.056		Set Trigger
2	4.187	0.018	0.00	0.038	0.048		Set Trigger
3	4.274	0.019	0.00	0.038	0.053		Set Trigger
4	4.411	0.019	0.00	0.039	0.051		Set Trigger
5	4.310	0.018	0.00	0.039	0.049		Set Trigger

A-4.31

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



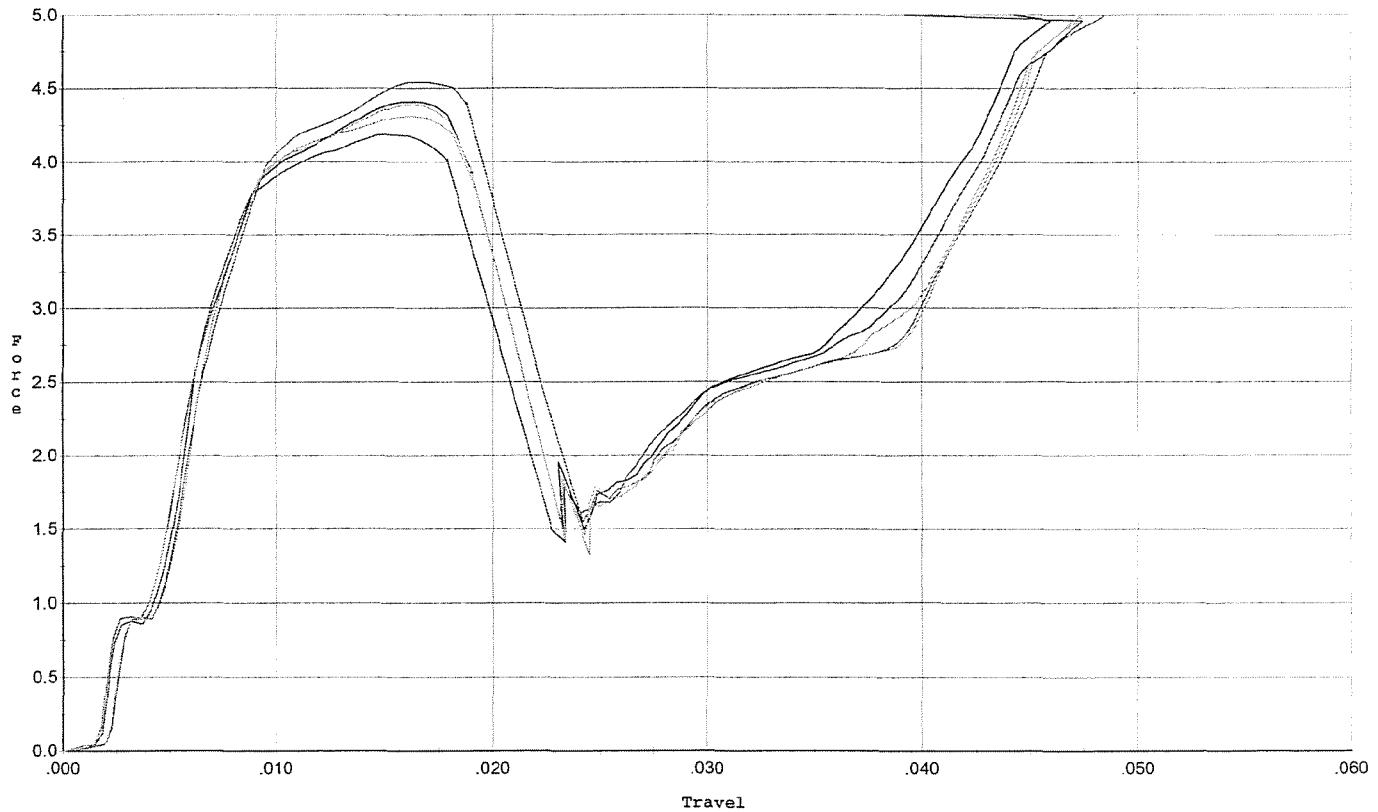
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.661	0.016	0.00	0.042	0.029		Set Trigger
2	2.730	0.016	0.00	0.042	0.029		Set Trigger
3	2.848	0.017	0.00	0.042	0.031		Set Trigger
4	2.550	0.015	0.00	0.043	0.026		Set Trigger
5	2.439	0.016	0.00	0.042	0.026		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.188	0.018	0.00	0.038	0.048		Set Trigger
2	4.408	0.019	0.00	0.037	0.053		Set Trigger
3	4.540	0.019	0.00	0.038	0.053		Set Trigger
4	4.396	0.019	0.00	0.038	0.053		Set Trigger
5	4.308	0.019	0.00	0.038	0.052		Set Trigger

A-4.36