

G 680 7713

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



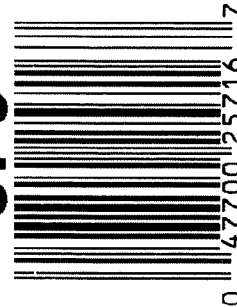
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807713

UPC



GUN SERIAL # G6807713

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	SPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	SPD
460	CHECK HEADSPACE		2-27-09	SPD
470	DIS-ASSEMBLE ACTION		2-27-09	SPD
472	SERIALIZE BOLT HANDLE		3-2-09	RT
480	MAGNAFLUX BBL ACTION	(H)	3/5/09	(H)
490	MAGNAFLUX BOLT		3/5/09	MR
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	JP
520	GOFF BLAST BBL / REC		3/6	son
540	APPLY COATINGS (BARREL ACTION)		3/9	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-10-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-10-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-10-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-12-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

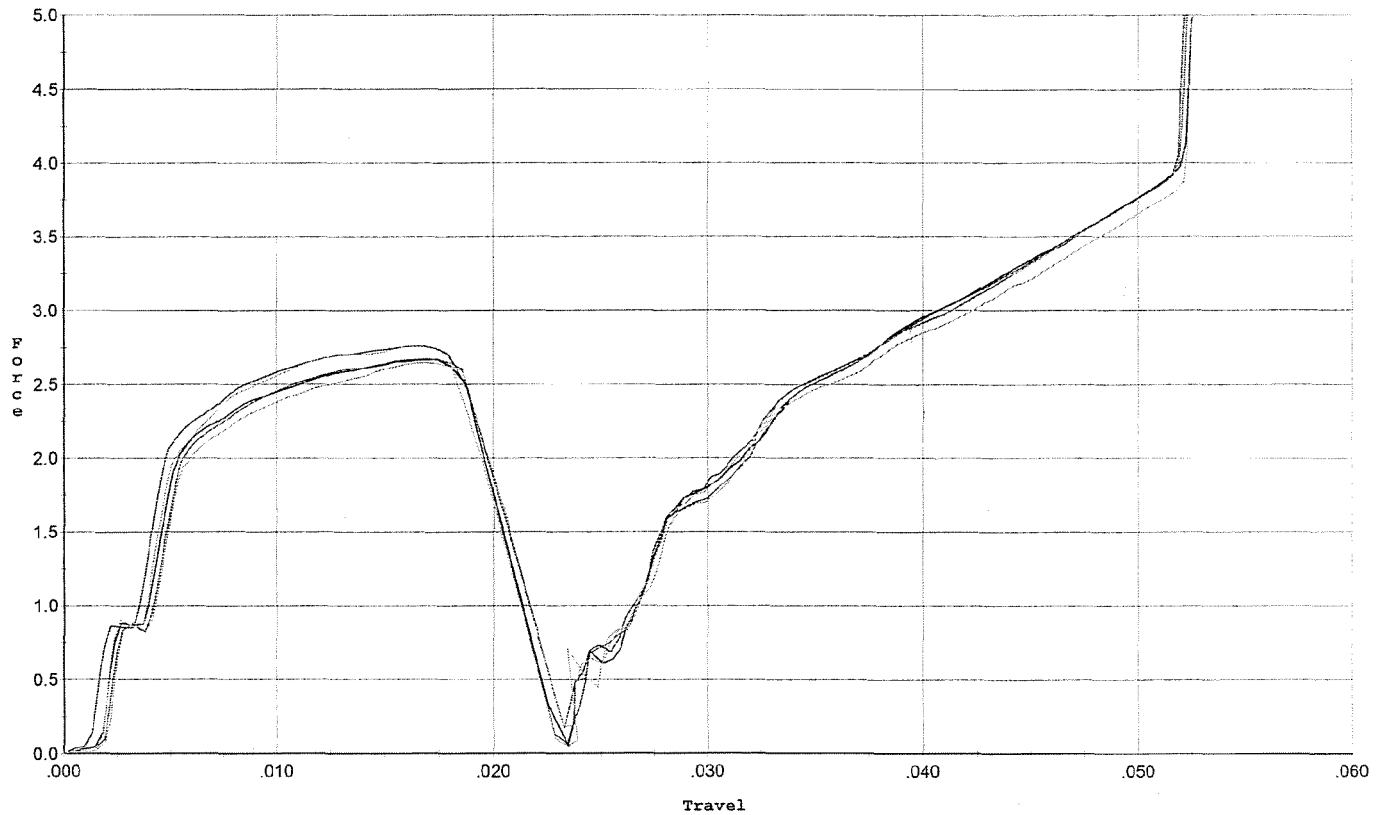
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0016704 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	3-19-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-19-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-19-09	NW
	J) ASSEMBLE STOCK		3-12-09	SPD
	K) ASSEMBLE SWIVEL STUDS		3-19-09	NW
	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	3-16-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-16-09	NW
670	FINAL INSPECTION A) HEADSPACE		3-19-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.63</u> <u>2.73</u> <u>2.74</u> <u>2.74</u>	3-18-09	NW
	C) FUNCTION		3-19-09	NW
690	PACK		3-20-09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



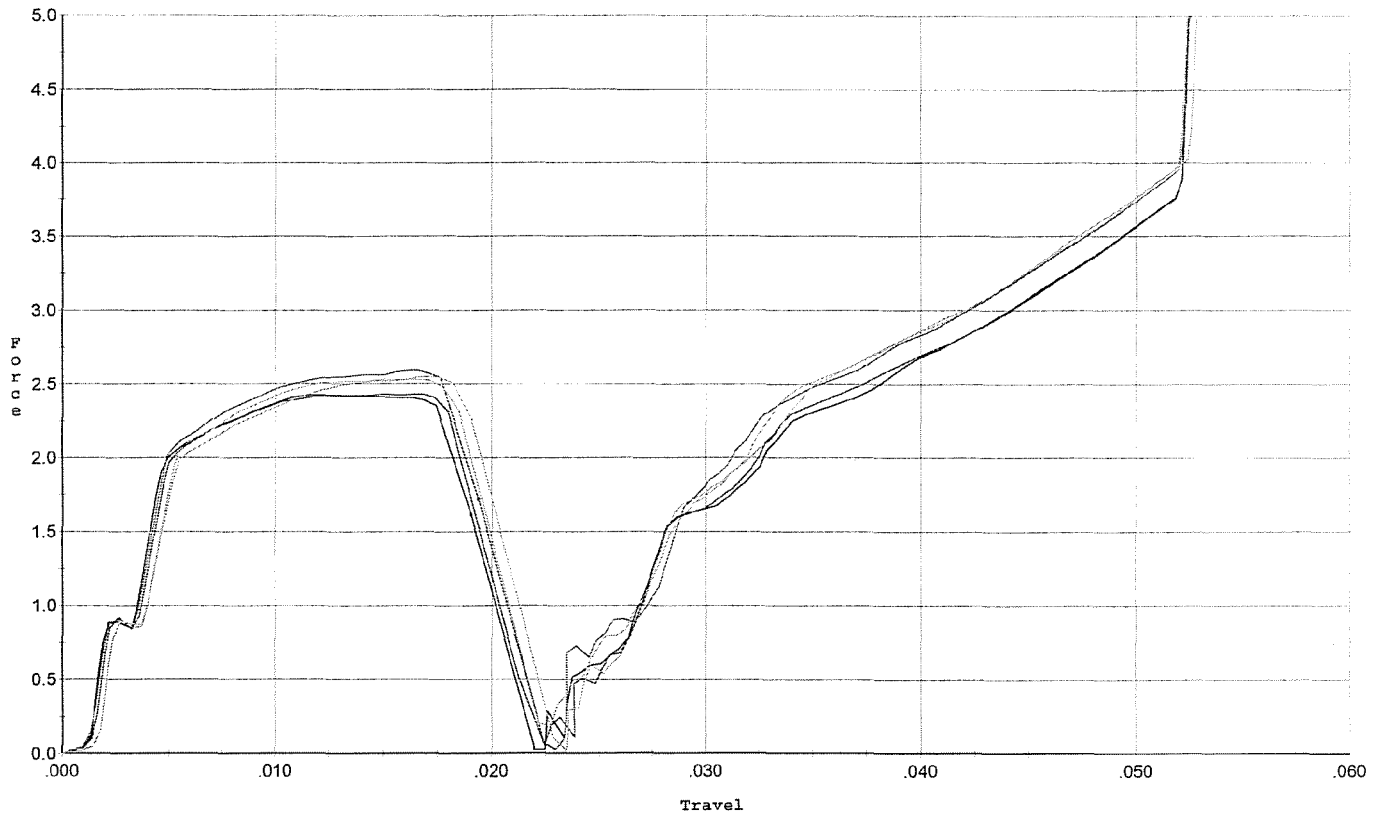
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.760	0.019	0.003	0.036	0.037		Set Trigger
2	2.670	0.019	0.004	0.036	0.035		Set Trigger
3	2.669	0.021	0.00	0.035	0.039		Set Trigger
4	2.758	0.019	0.00	0.036	0.038		Set Trigger
5	2.646	0.020	0.002	0.035	0.037		Set Trigger

A-2-20

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



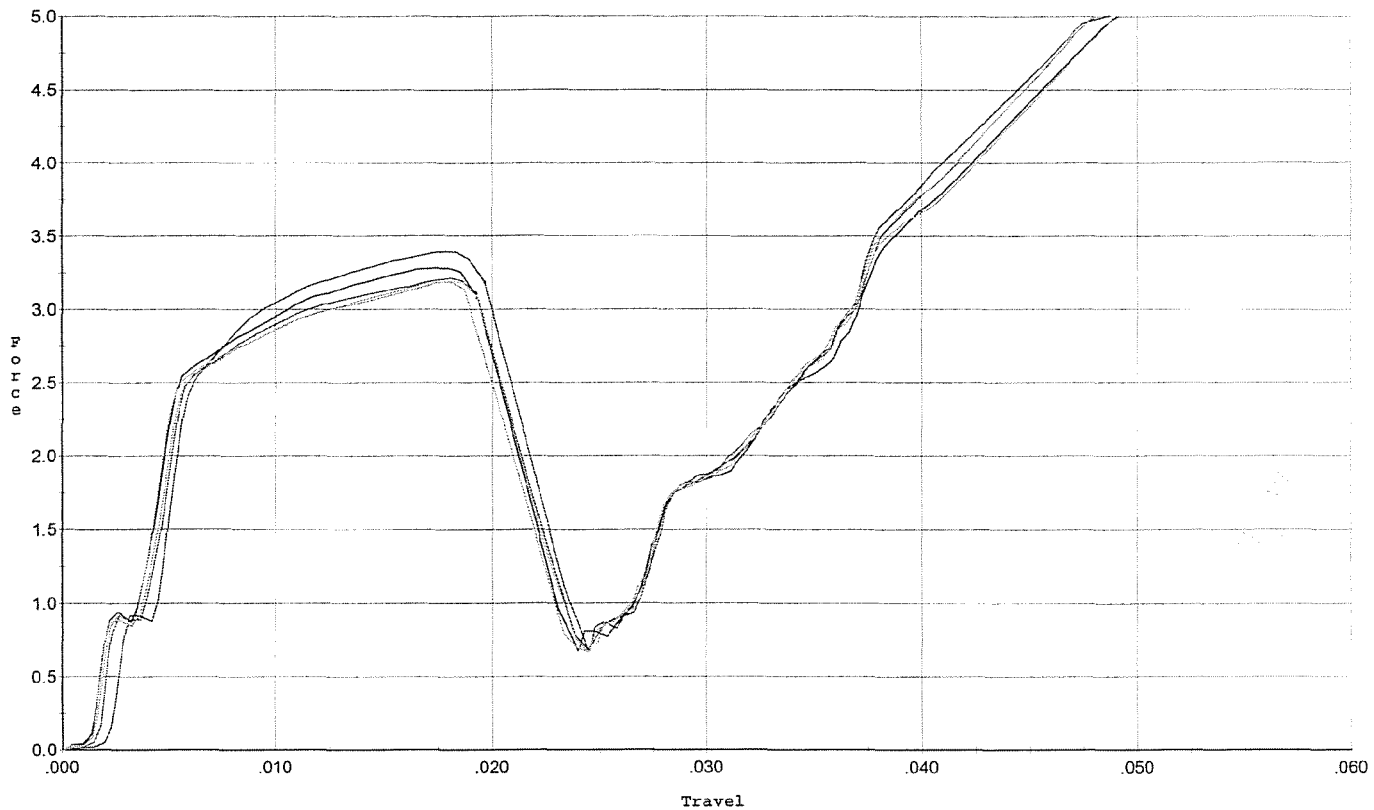
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.431	0.018	0.00	0.037	0.032		Set Trigger
2	2.425	0.019	0.003	0.037	0.034		Set Trigger
3	2.593	0.019	0.00	0.036	0.036		Set Trigger
4	2.535	0.018	0.004	0.036	0.034		Set Trigger
5	2.551	0.019	0.004	0.036	0.035		Set Trigger

A-2.50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



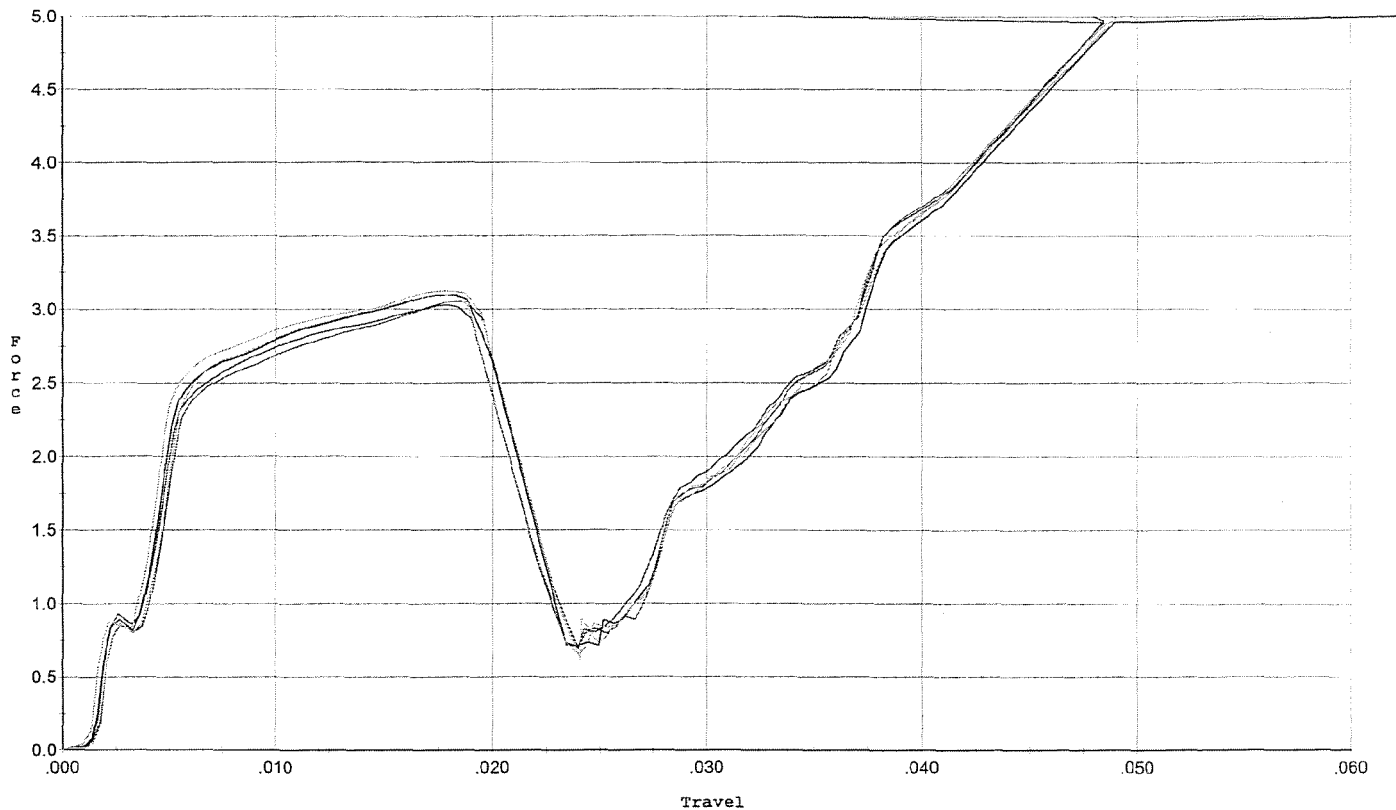
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.394	0.020	0.002	0.034	0.045		Set Trigger
2	3.282	0.019	0.00	0.035	0.044		Set Trigger
3	3.207	0.019	0.004	0.035	0.043		Set Trigger
4	3.194	0.019	0.00	0.035	0.043		Set Trigger
5	3.187	0.021	0.00	0.035	0.047		Set Trigger

1A-3.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



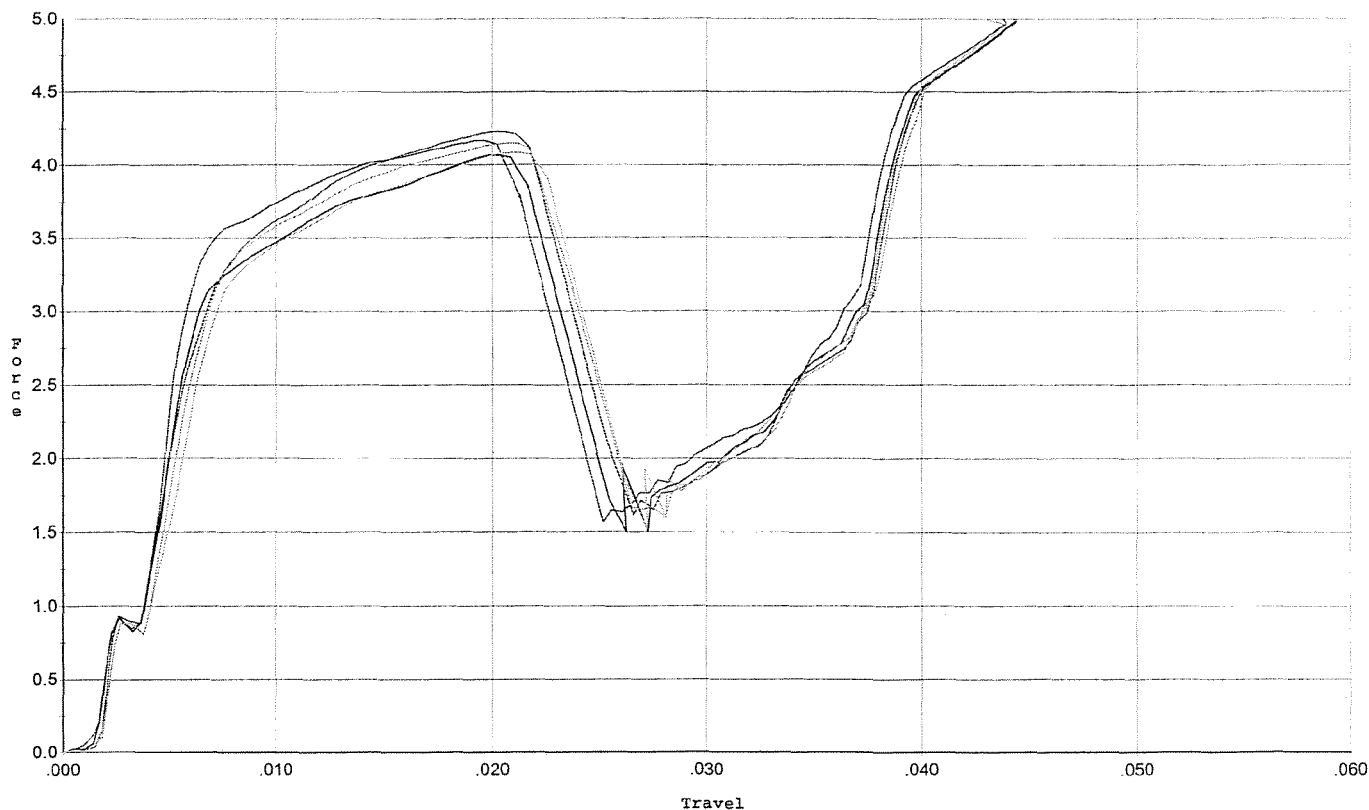
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.029	0.019	0.00	0.035	0.040		Set Trigger
2	3.096	0.020	0.00	0.035	0.043		Set Trigger
3	3.054	0.020	0.00	0.035	0.041		Set Trigger
4	3.096	0.019	0.003	0.035	0.042		Set Trigger
5	3.123	0.019	0.00	0.035	0.042		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/11/2009

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



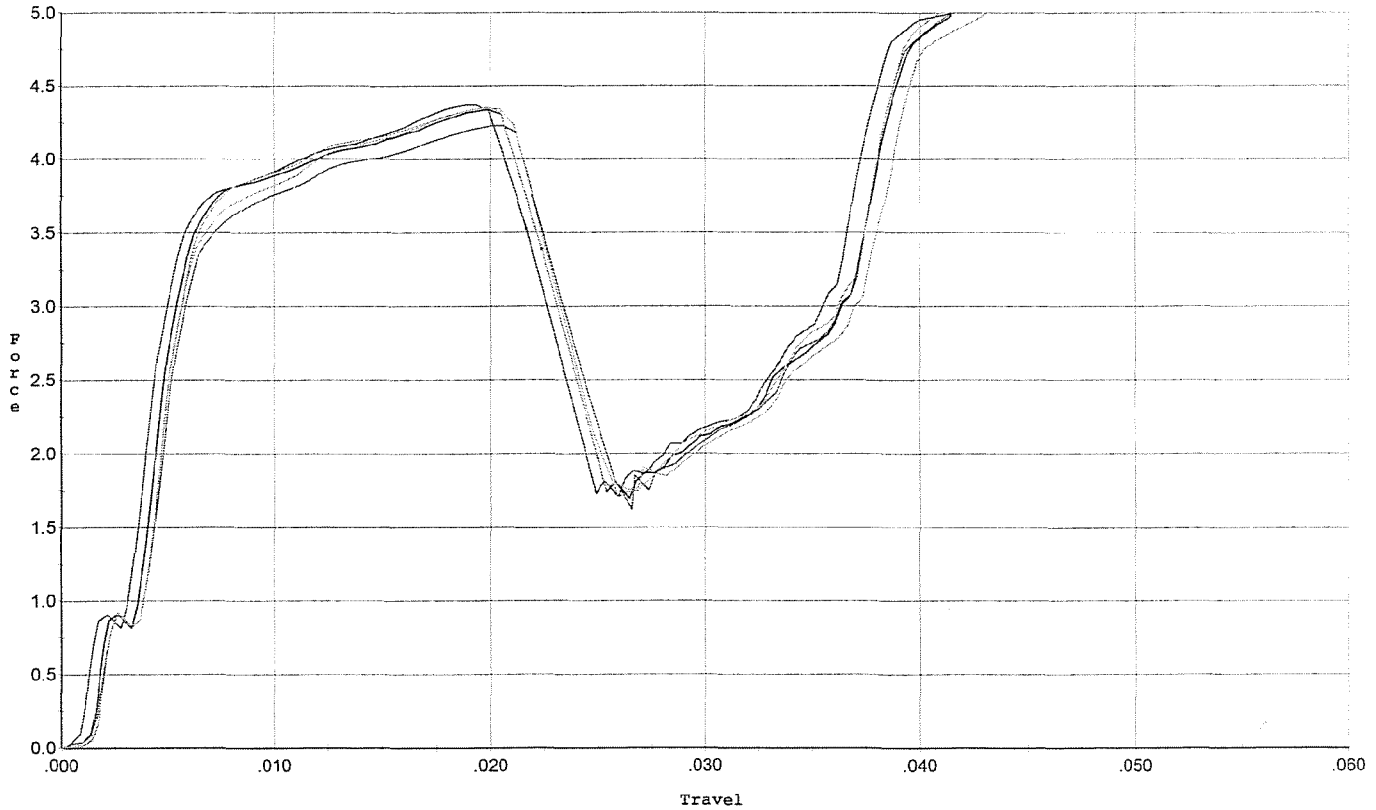
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.021	0.004	0.029	0.061		Set Trigger
2	4.066	0.022	0.00	0.029	0.060		Set Trigger
3	4.228	0.022	0.00	0.029	0.062		Set Trigger
4	4.083	0.023	0.004	0.028	0.062		Set Trigger
5	4.147	0.024	0.004	0.028	0.067		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



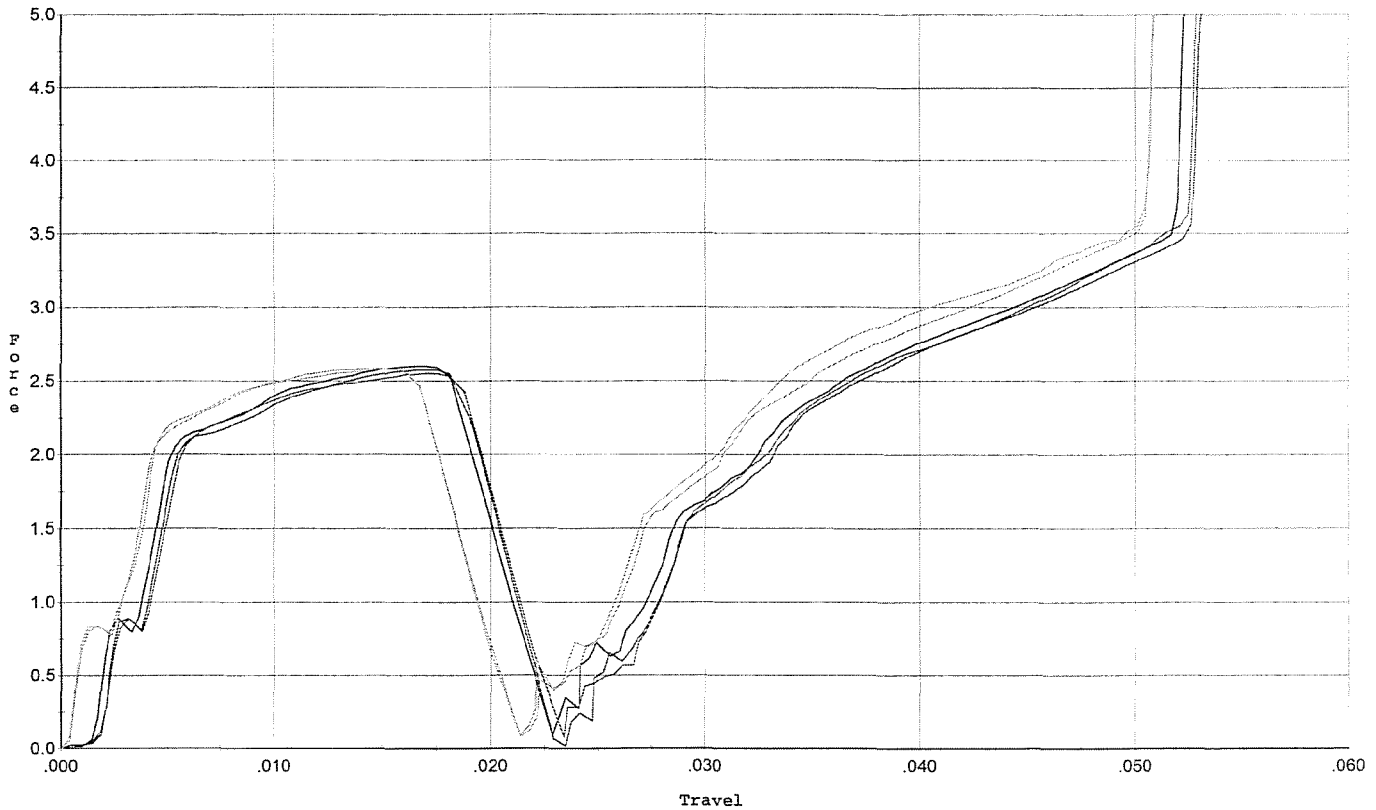
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.369	0.022	0.00	0.026	0.066		Set Trigger
2	4.338	0.022	0.00	0.026	0.067		Set Trigger
3	4.226	0.021	0.00	0.024	0.061		Set Trigger
4	4.355	0.022	0.00	0.025	0.066		Set Trigger
5	4.347	0.021	0.00	0.026	0.063		Set Trigger

A-4-32

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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



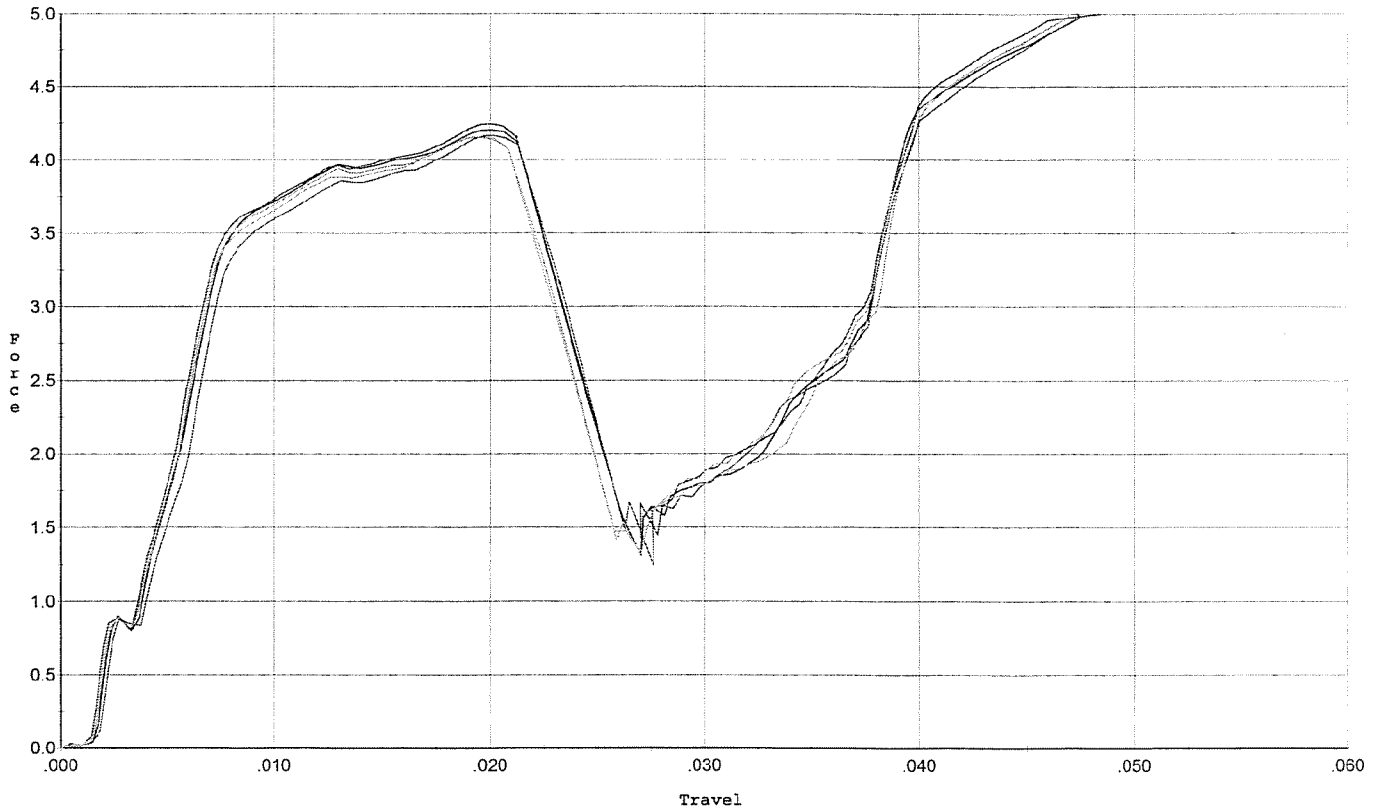
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.019	0.00	0.036	0.035		Set Trigger
2	2.601	0.018	0.00	0.036	0.034		Set Trigger
3	2.553	0.019	0.00	0.036	0.034		Set Trigger
4	2.583	0.017	0.003	0.036	0.032		Set Trigger
5	2.586	0.017	0.00	0.036	0.032		Set Trigger

A-2.57

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/11/2009

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	4.243	0.021	0.00	0.033	0.061		Set Trigger
2	4.201	0.021	0.00	0.033	0.060		Set Trigger
3	4.165	0.023	0.004	0.032	0.064		Set Trigger
4	4.157	0.023	0.00	0.033	0.064		Set Trigger
5	4.153	0.022	0.00	0.033	0.063		Set Trigger

A-4.18