

G6807735

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



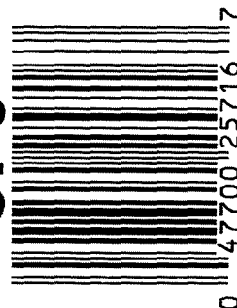
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807735

UPC



GUN SERIAL #

G 6807735

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RJZ
430	ASSEMBLE TO STOCK		3-6-09	RJZ
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RJZ
472	SERIALIZE BOLT HANDLE		3-6-09	LR
475	DRILL AND TAP SIGHT HOLES		3-6-09	JP
480	MAGNAFLUX BBL ACTION		3/9/09	
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	RM
542	APPLY COATINGS (BARREL ACTION)		3-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	JP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

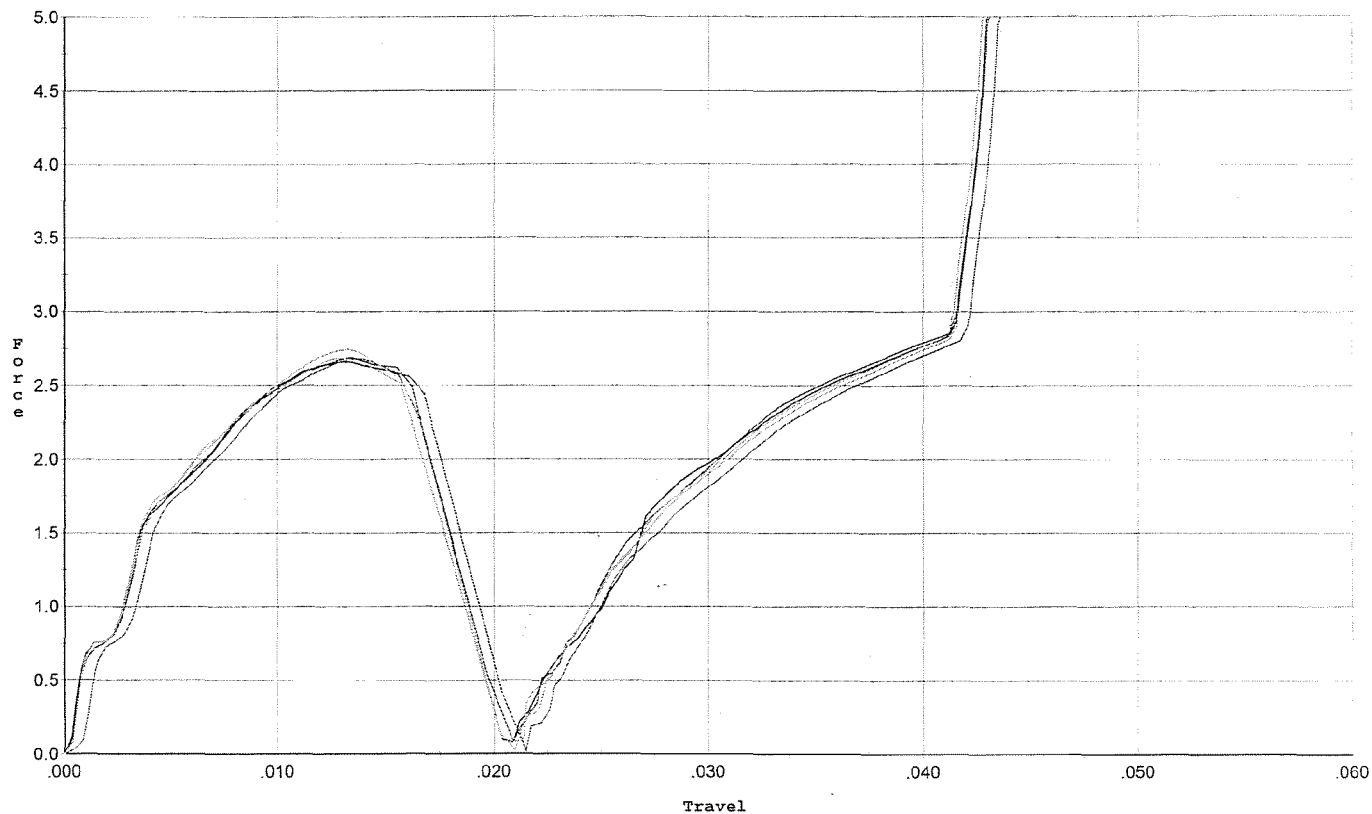
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0016968 F) SAFETY ON FORCE 10 LBS MIN 10 LBS MAX	<u>7.0 lbs</u> <u>7.0 lbs</u> <u>7.0 lbs</u>	<u>3-26-09</u>	<u>SPD</u>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5 lbs</u> <u>3.5 lbs</u> <u>3.5 lbs</u>	<u>3-26-09</u>	<u>SPD</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.027</u> <u>.027</u>	<u>3-26-09</u>	<u>SPD</u>
	J) ASSEMBLE STOCK		<u>3-23-09</u>	<u>SPD</u>
	K) ASSEMBLE SWIVEL STUDS		<u>3-26-09</u>	<u>SPD</u>
	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	<u>3-25-09</u>	<u>TL</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>3-25-09</u>	<u>WW</u>
670	FINAL INSPECTION A) HEADSPACE		<u>3-26-09</u>	<u>SPD</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.43</u> <u>2.40</u> <u>2.30</u> <u>2.28</u>	<u>3-25-09</u>	<u>TL</u>
	C) FUNCTION		<u>3-26-09</u>	<u>SPD</u>
690	PACK		<u>3/27/09</u>	<u>FM</u>

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



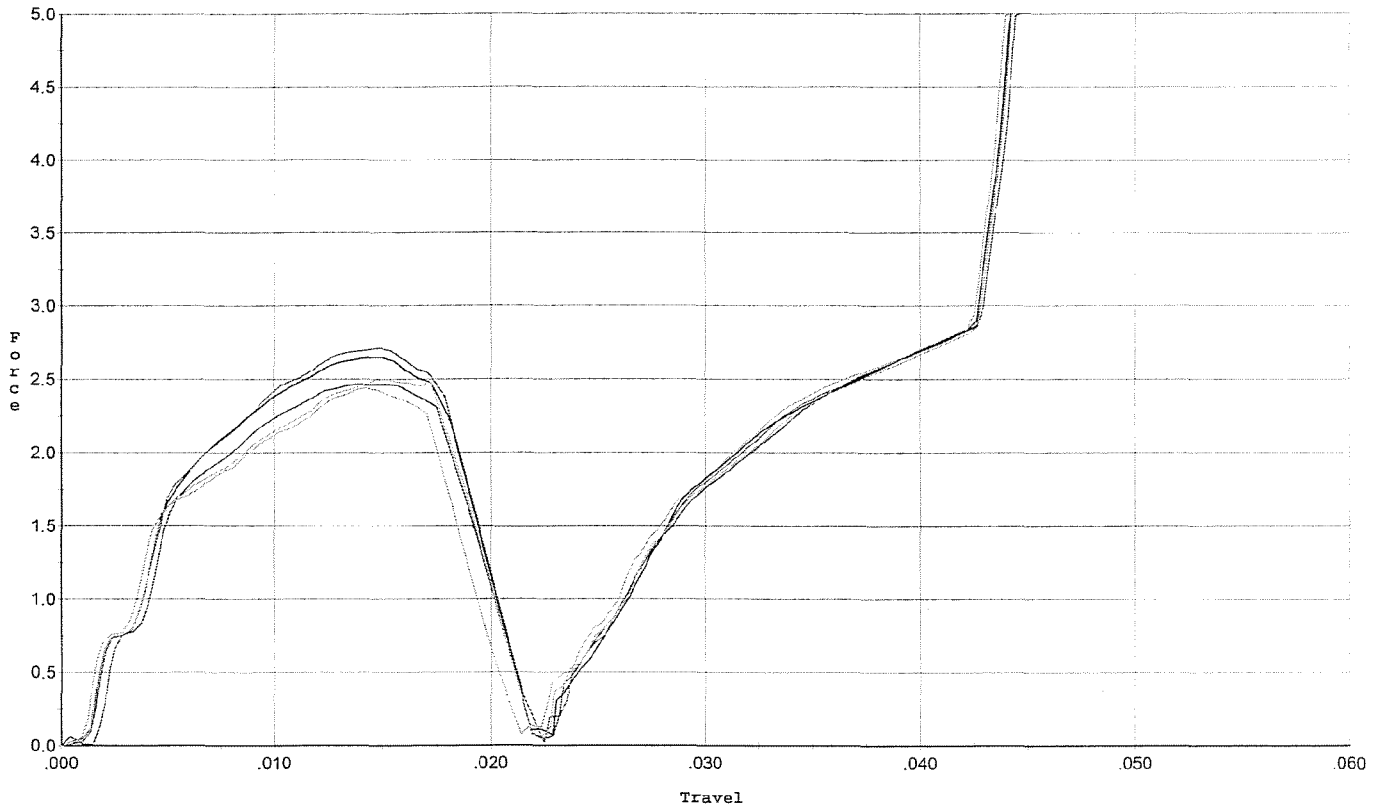
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.688	0.016	0.00	0.030	0.030		Set Trigger
2	2.660	0.017	0.00	0.030	0.031		Set Trigger
3	2.680	0.017	0.00	0.030	0.030		Set Trigger
4	2.747	0.016	0.00	0.030	0.031		Set Trigger
5	2.685	0.018	0.00	0.030	0.033		Set Trigger

A-2-69

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



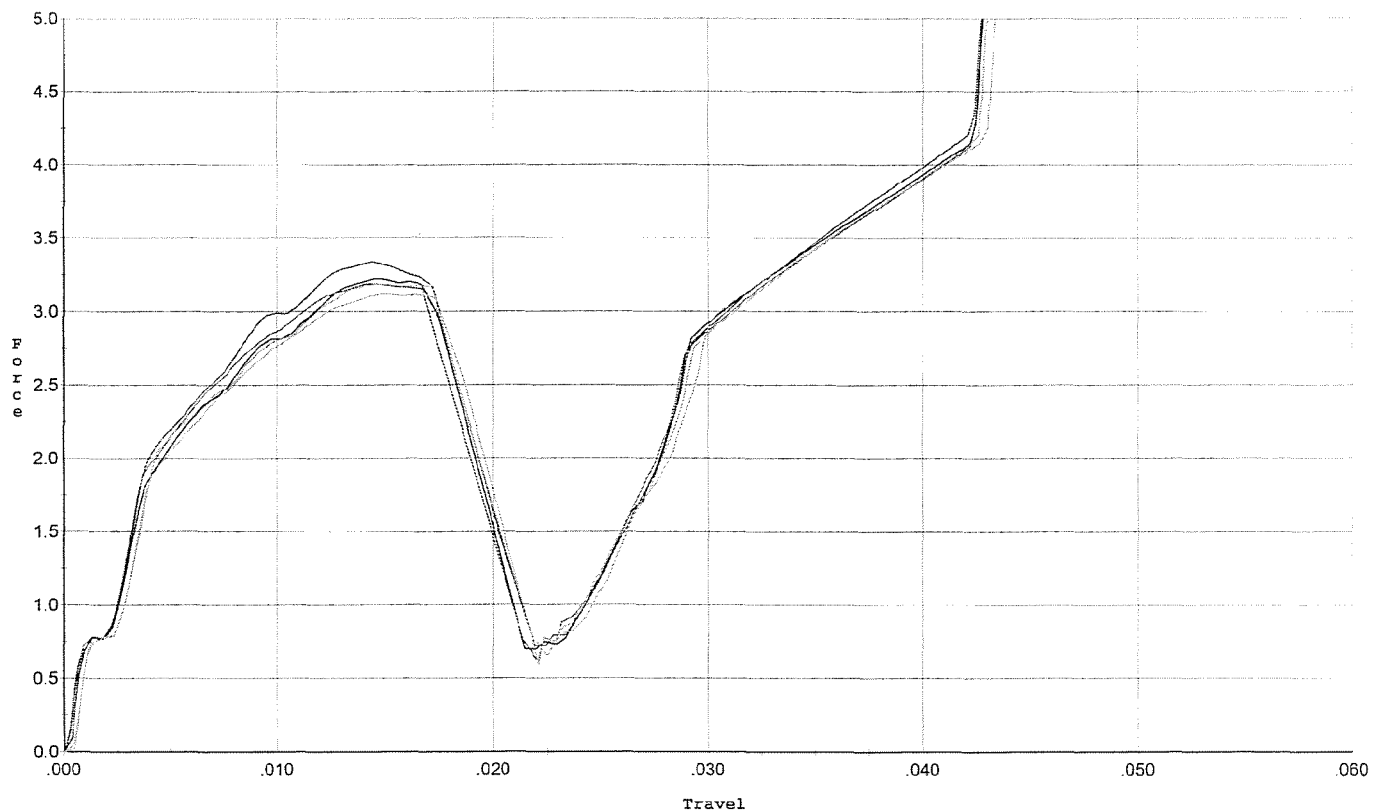
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.466	0.019	0.002	0.030	0.032		Set Trigger
2	2.647	0.018	0.00	0.030	0.033		Set Trigger
3	2.708	0.018	0.00	0.030	0.033		Set Trigger
4	2.500	0.019	0.00	0.030	0.032		Set Trigger
5	2.442	0.017	0.00	0.031	0.028		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



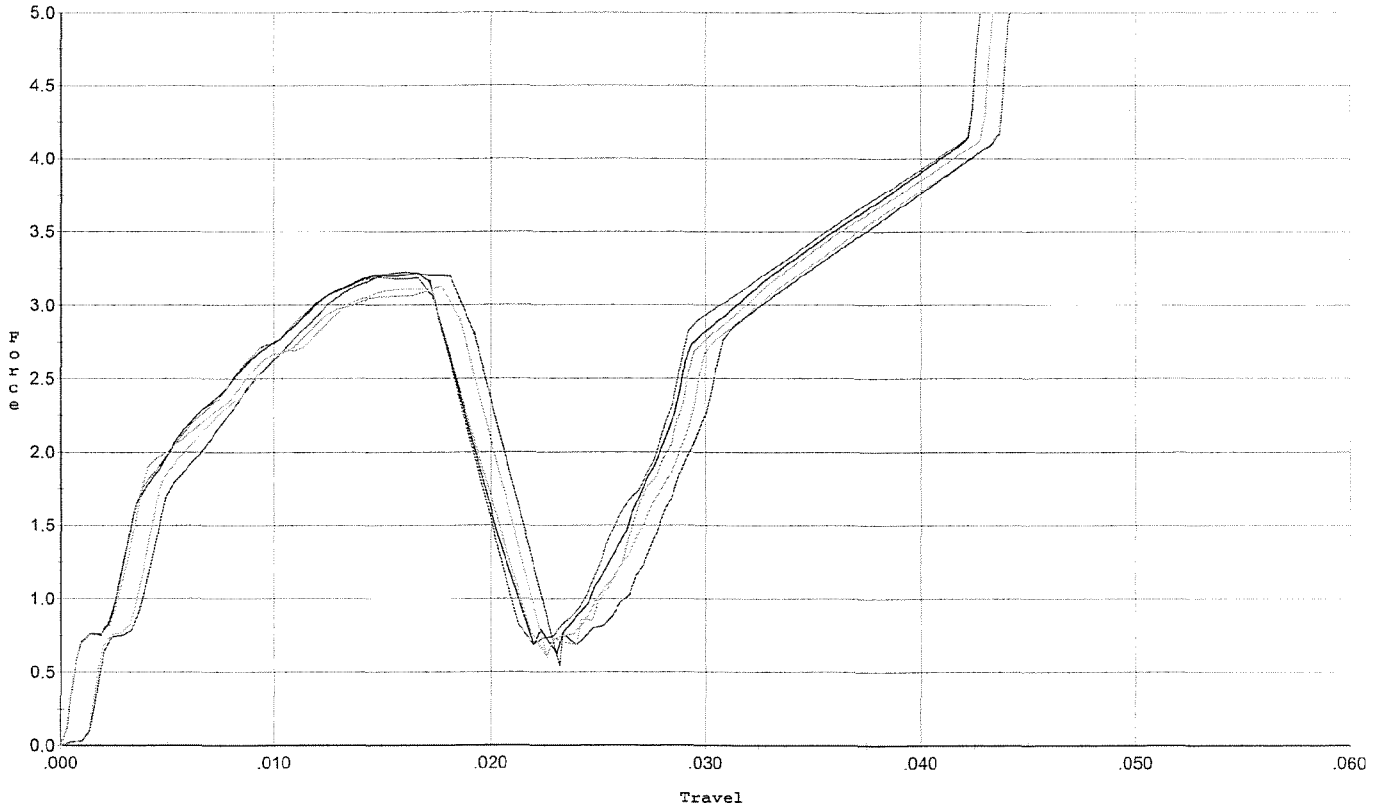
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.336	0.017	0.00	0.028	0.040		Set Trigger
2	3.223	0.017	0.00	0.028	0.039		Set Trigger
3	3.188	0.017	0.00	0.028	0.037		Set Trigger
4	3.117	0.017	0.00	0.028	0.037		Set Trigger
5	3.185	0.019	0.00	0.028	0.041		Set Trigger

A-3-21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



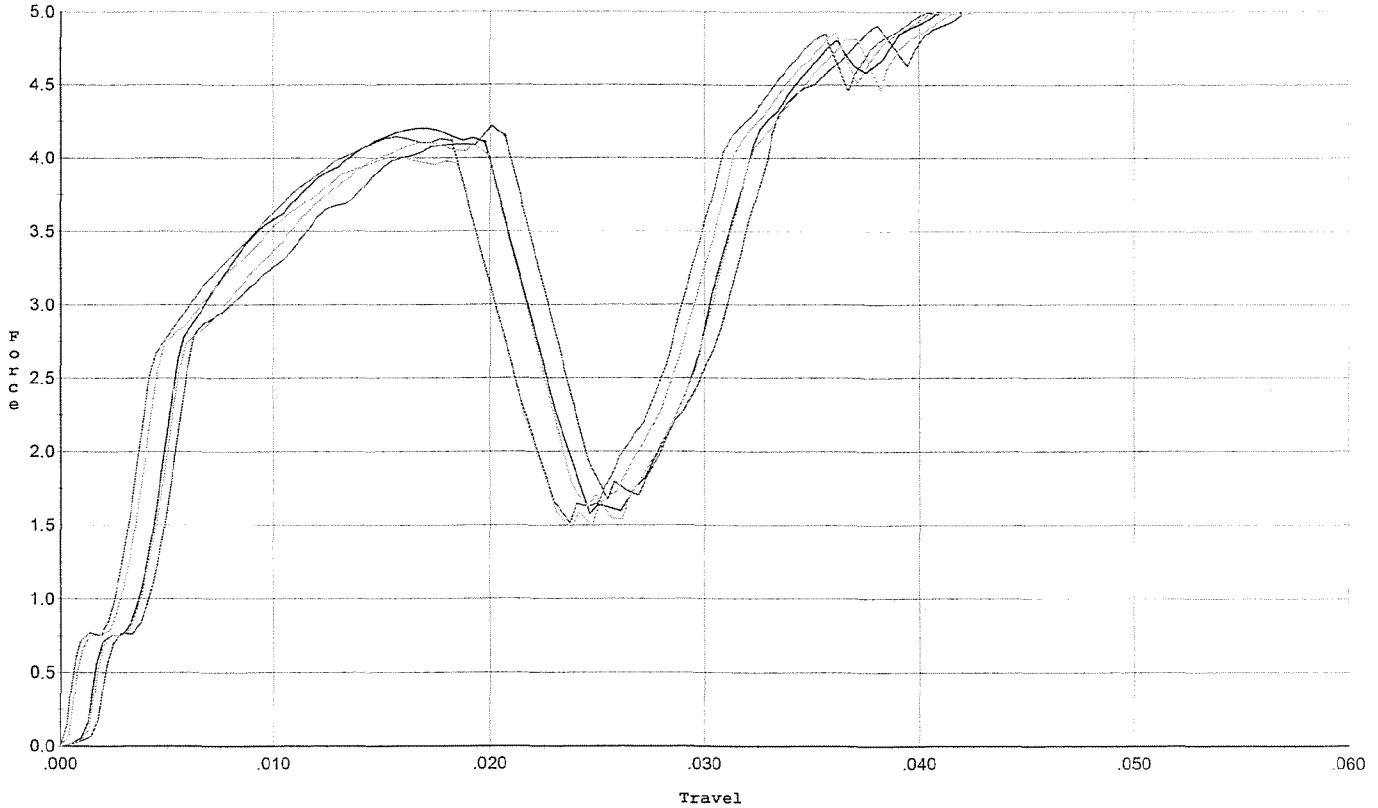
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.223	0.019	0.00	0.028	0.040		Set Trigger
2	3.216	0.017	0.00	0.028	0.038		Set Trigger
3	3.187	0.017	0.00	0.028	0.038		Set Trigger
4	3.130	0.019	0.00	0.028	0.038		Set Trigger
5	3.093	0.017	0.00	0.028	0.037		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



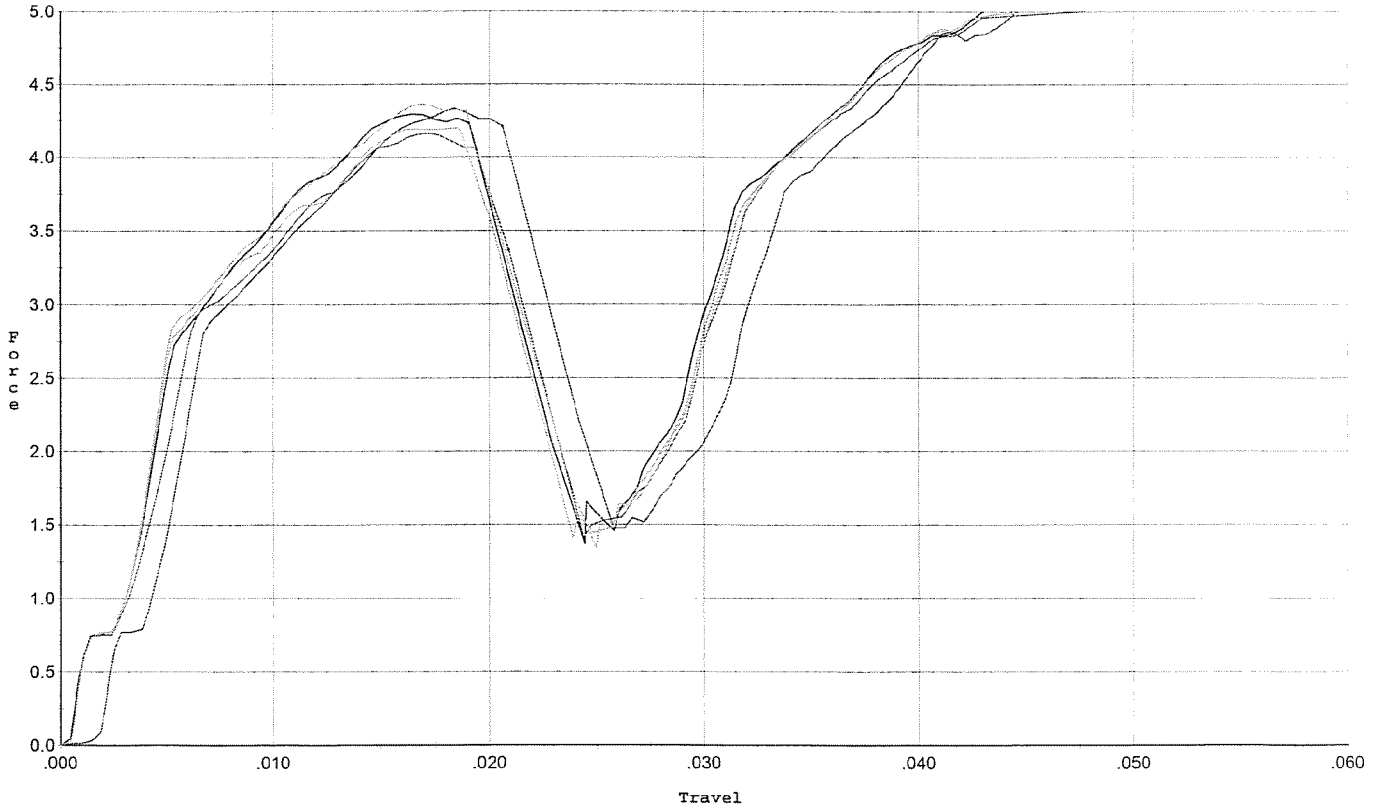
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.218	0.021	0.00	0.025	0.055		Set Trigger
2	4.202	0.020	0.00	0.026	0.055		Set Trigger
3	4.143	0.018	0.00	0.025	0.052		Set Trigger
4	4.108	0.020	0.00	0.026	0.054		Set Trigger
5	4.010	0.018	0.00	0.026	0.051		Set Trigger

A-4.13

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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



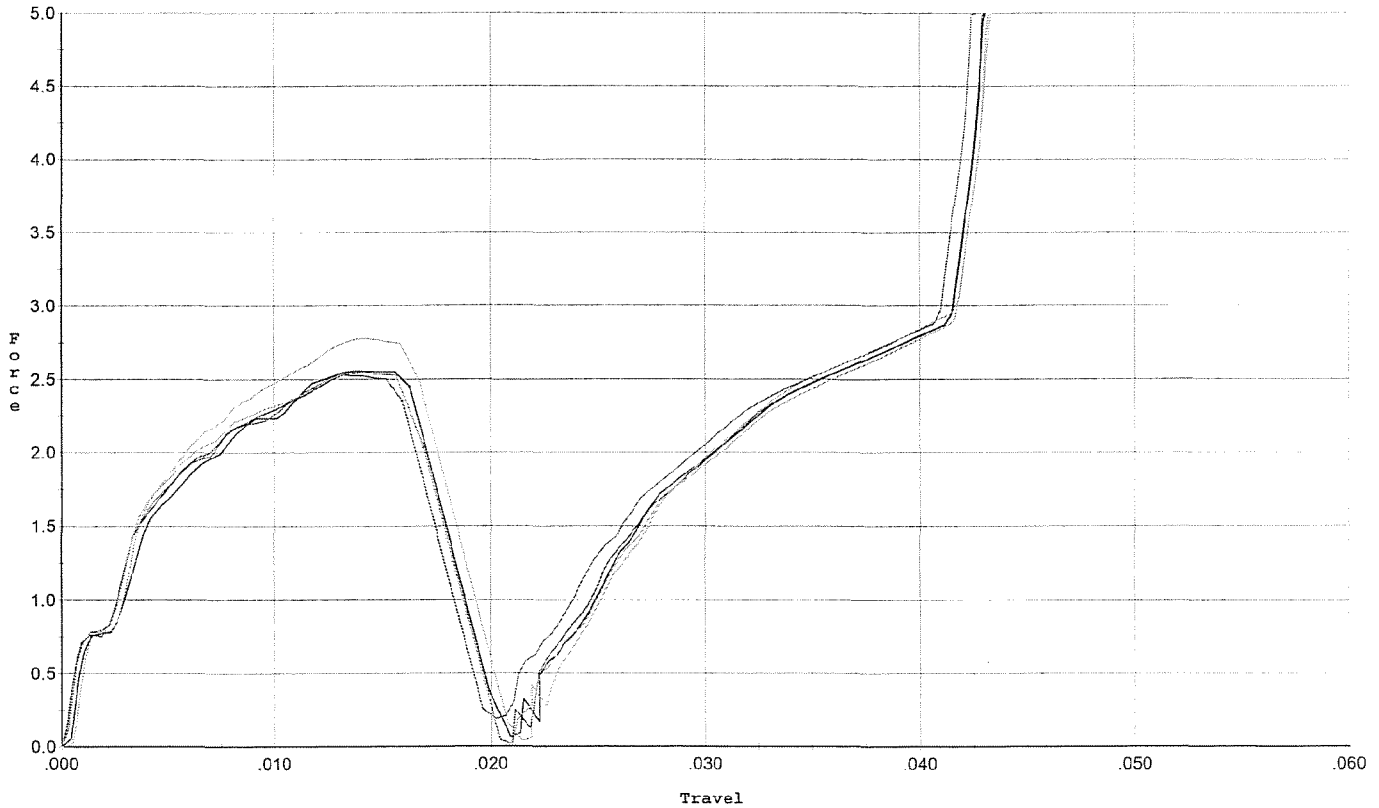
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.335	0.021	0.00	0.026	0.056		Set Trigger
2	4.296	0.019	0.00	0.026	0.054		Set Trigger
3	4.164	0.021	0.00	0.026	0.057		Set Trigger
4	4.201	0.020	0.00	0.026	0.056		Set Trigger
5	4.365	0.019	0.00	0.026	0.054		Set Trigger

A-4-27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/23/2009

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



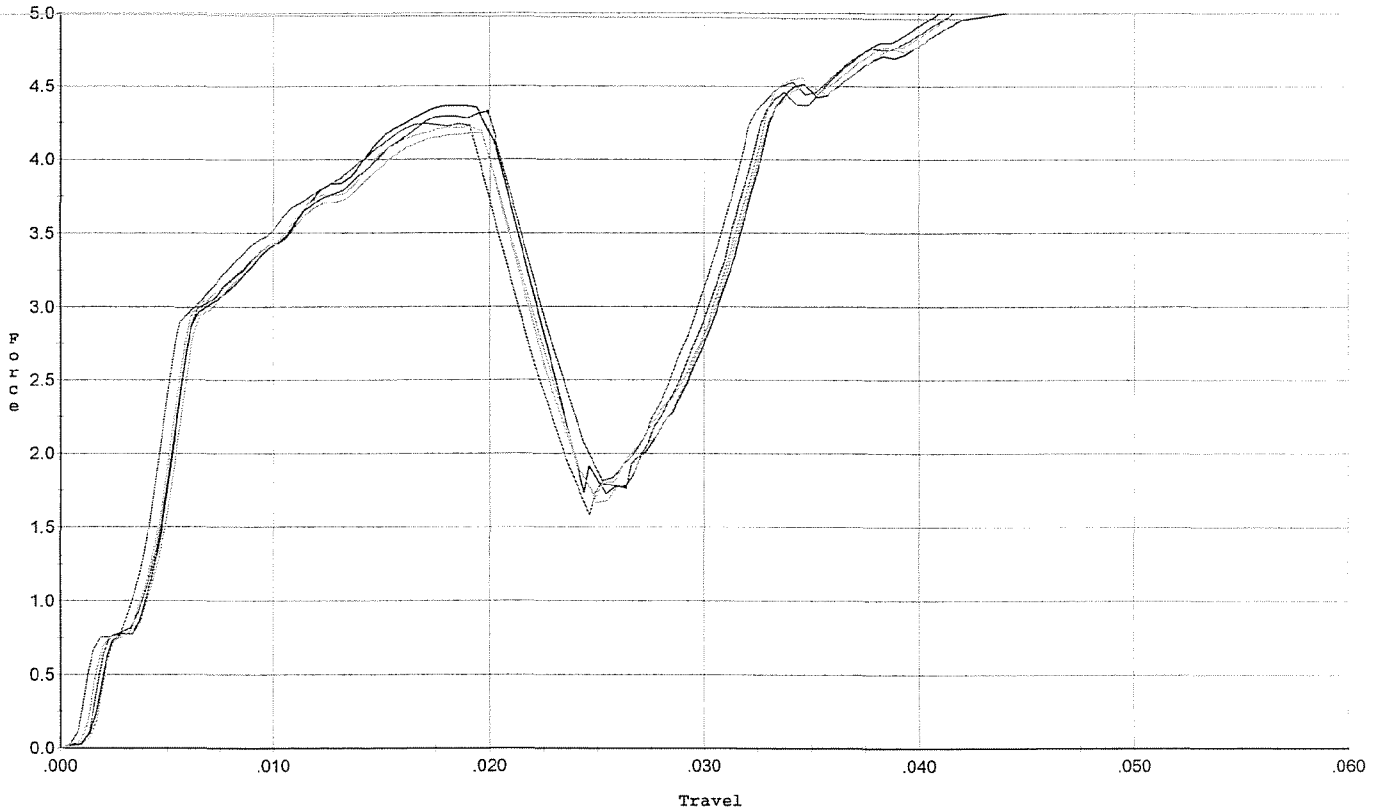
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.017	0.00	0.030	0.030		Set Trigger
2	2.555	0.016	0.00	0.030	0.029		Set Trigger
3	2.531	0.016	0.00	0.029	0.028		Set Trigger
4	2.780	0.017	0.00	0.030	0.032		Set Trigger
5	2.549	0.017	0.00	0.030	0.031		Set Trigger

A-7-59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/23/2009

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	4.325	0.020	0.00	0.025	0.055		Set Trigger
2	4.363	0.020	0.00	0.025	0.056		Set Trigger
3	4.242	0.019	0.00	0.026	0.053		Set Trigger
4	4.223	0.020	0.00	0.026	0.054		Set Trigger
5	4.176	0.020	0.00	0.026	0.052		Set Trigger

A. 4.26