

G680 7747

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



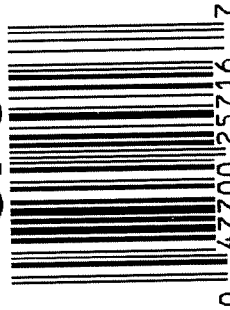
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807747

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6807747

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE		2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR <u>(H)</u>	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	no
540	APPLY COATINGS (BARREL ACTION)		3/11	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-18-09	X.N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATOR NAME	00017113	READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6</u>	<u>6</u>	<u>6</u>	3-23-09	WW		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4</u>	<u>4</u>	<u>4</u>	3-23-09	WW		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.022</u>	<u>.024</u>	3-23-09	WW		
	J) ASSEMBLE STOCK					3-18-09	WW		
	K) ASSEMBLE SWIVEL STUDS					3-24-09	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		<u>PASS</u>	FAIL		3-20-09	WW		
			<u>PASS</u>	FAIL					
	MALFUNCTION.		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					3-20-09	RP		
670	FINAL INSPECTION A) HEADSPACE					3-23-09	WW		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u>	<u>2.45</u>	<u>2.54</u>	<u>2.43</u>	<u>2.59</u>	3-23-09	TC
	C) FUNCTION					3-23-09	WW		
690	PACK					3-23-09	FW		

F004 REV 5/2006

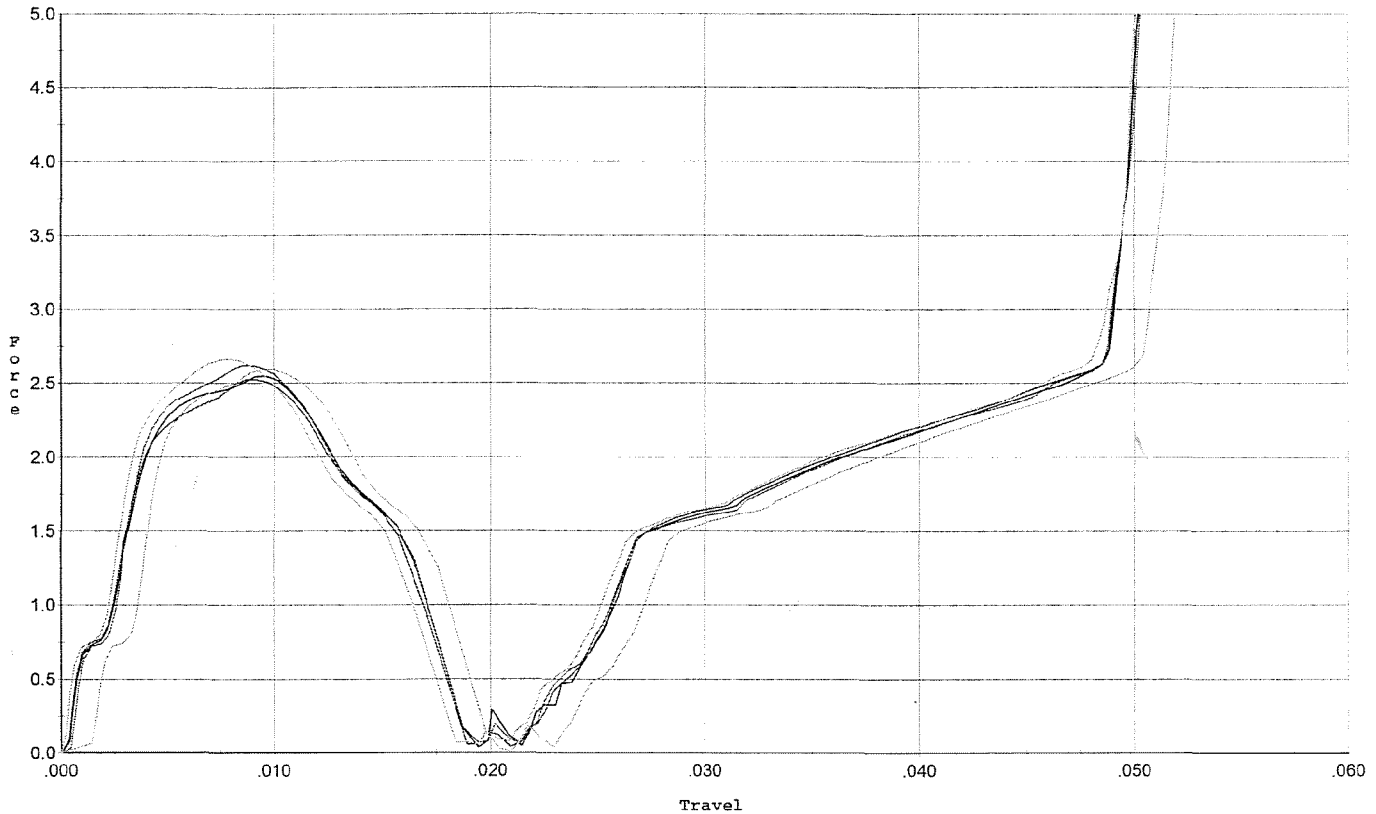
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 004499917152

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C C Schults 3/17/2009

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



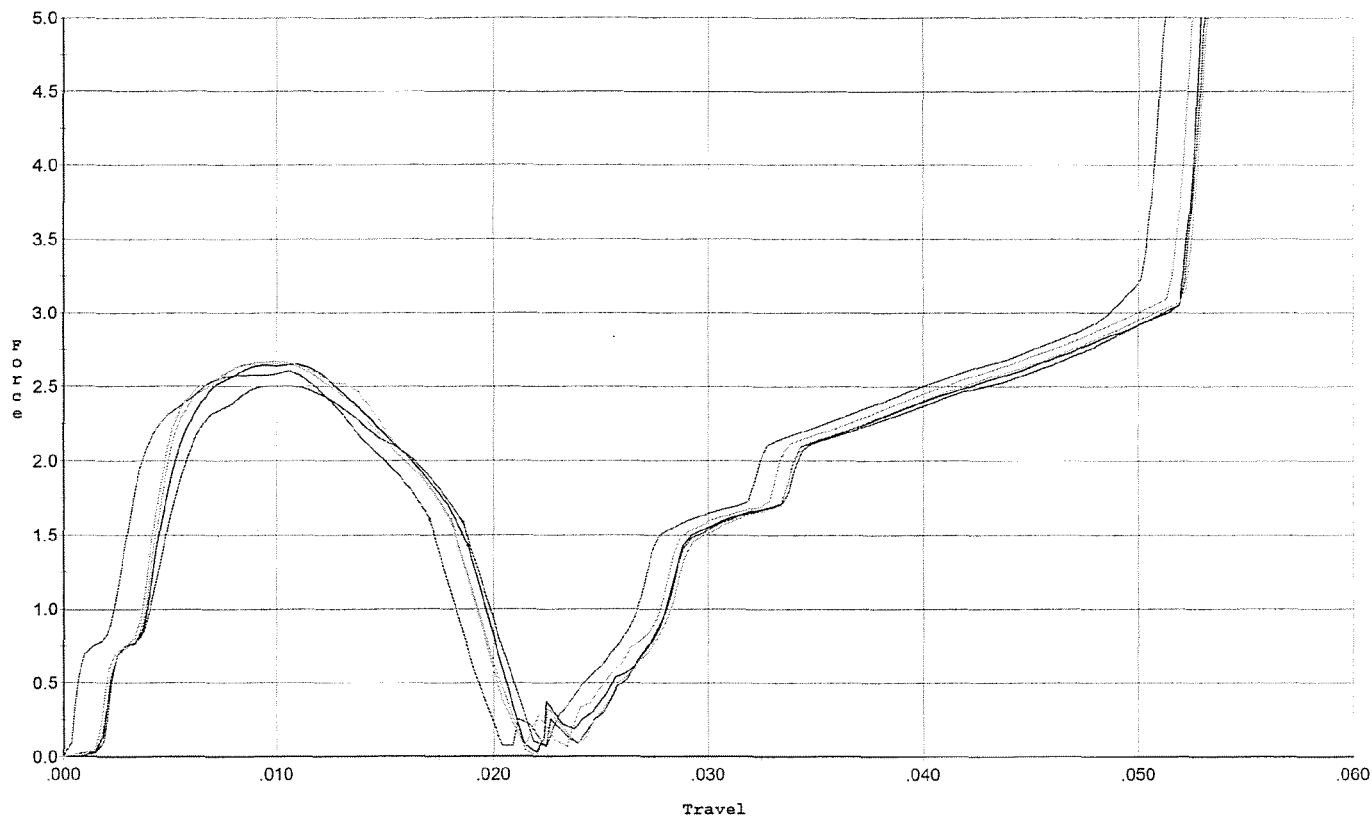
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.525	0.017	0.00	0.038	0.030		Set Trigger
2	2.549	0.017	0.00	0.038	0.029		Set Trigger
3	2.622	0.017	0.00	0.038	0.029		Set Trigger
4	2.664	0.017	0.00	0.039	0.030		Set Trigger
5	2.599	0.018	0.00	0.039	0.030		Set Trigger

A-2.59

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



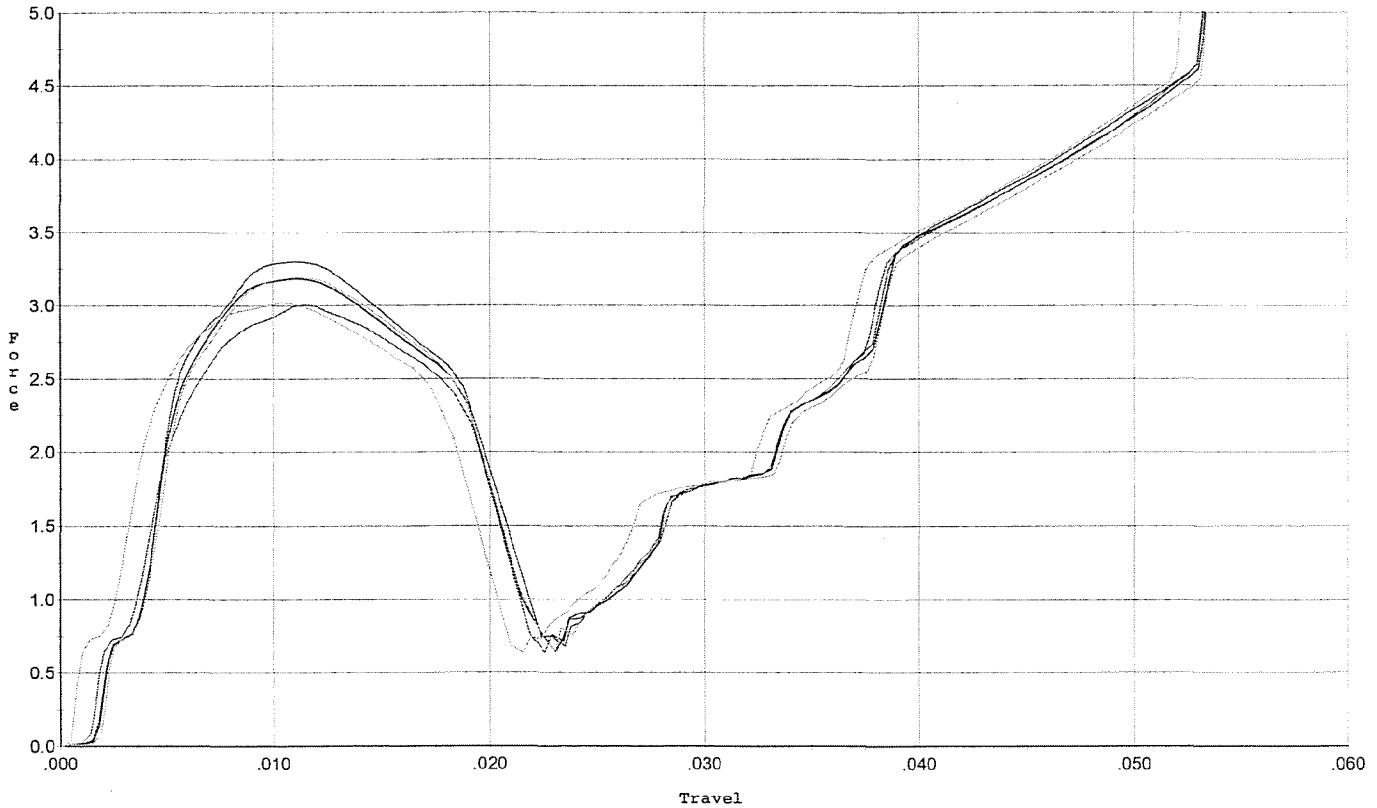
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.501	0.019	0.00	0.039	0.031		Set Trigger
2	2.650	0.019	0.00	0.038	0.033		Set Trigger
3	2.607	0.017	0.00	0.038	0.032		Set Trigger
4	2.654	0.018	0.00	0.038	0.033		Set Trigger
5	2.669	0.018	0.00	0.039	0.032		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



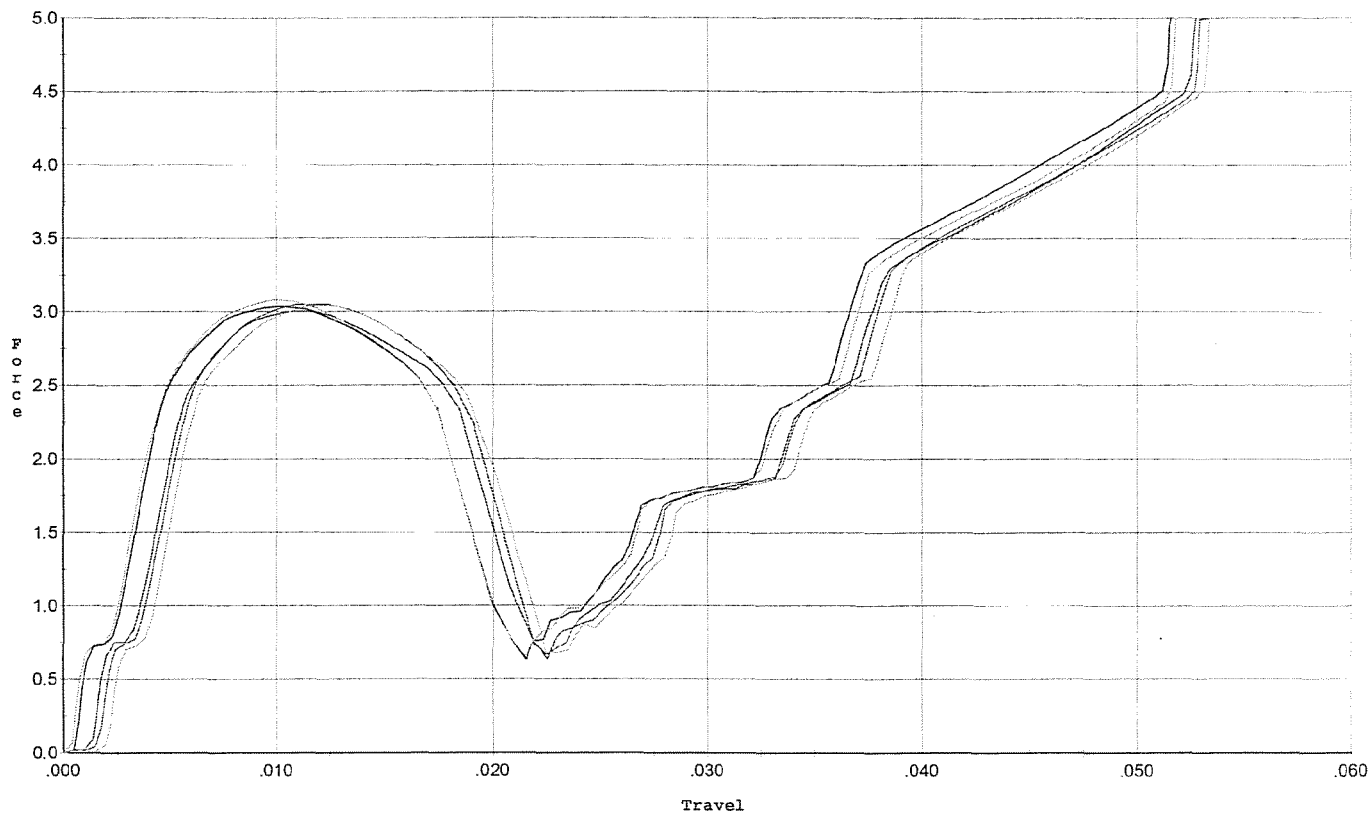
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.301	0.021	0.00	0.036	0.045		Set Trigger
2	3.185	0.019	0.00	0.037	0.040		Set Trigger
3	3.007	0.019	0.00	0.037	0.039		Set Trigger
4	3.020	0.018	0.00	0.037	0.040		Set Trigger
5	3.194	0.019	0.00	0.037	0.040		Set Trigger

A-3.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



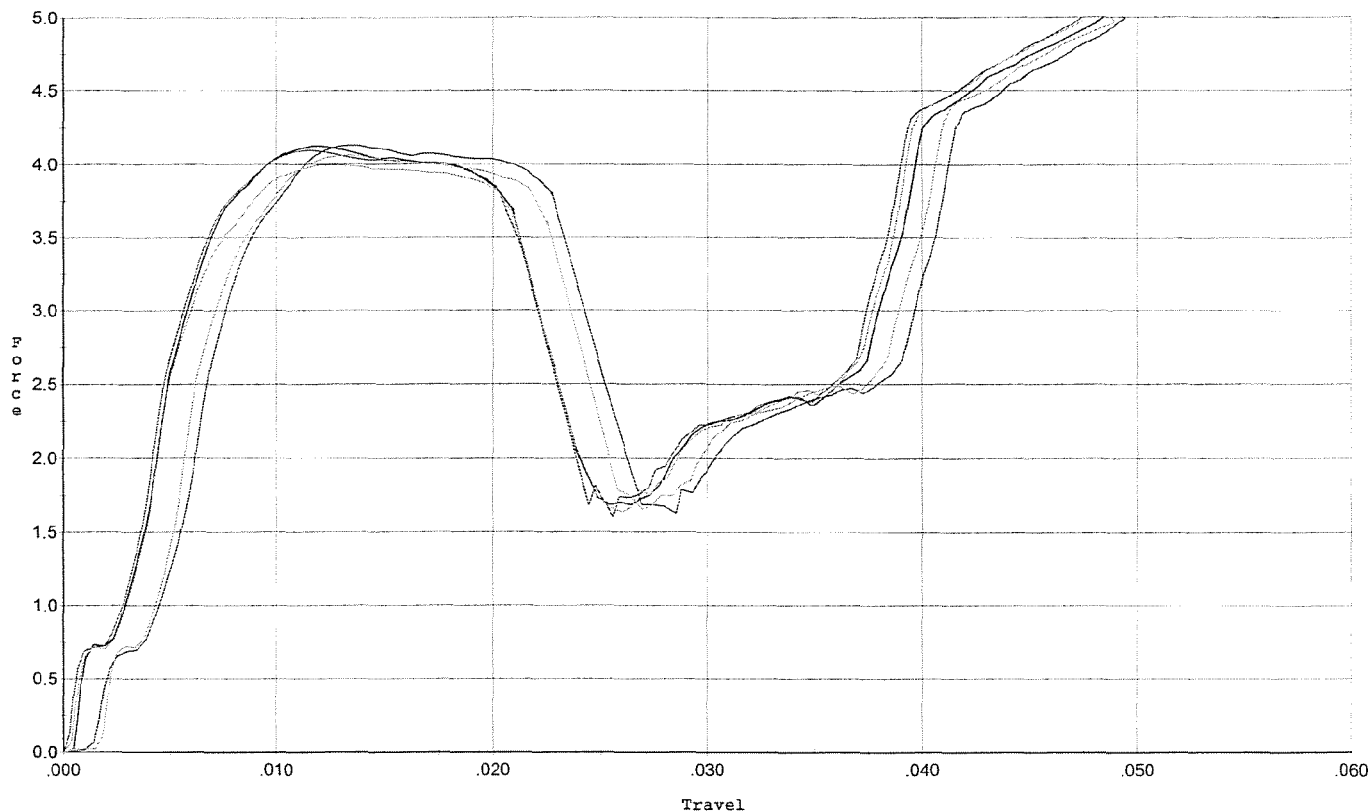
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.001	0.018	0.00	0.037	0.038		Set Trigger
2	3.034	0.017	0.00	0.036	0.038		Set Trigger
3	3.053	0.019	0.00	0.036	0.040		Set Trigger
4	3.047	0.020	0.00	0.036	0.041		Set Trigger
5	3.080	0.017	0.00	0.036	0.039		Set Trigger

A-3.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



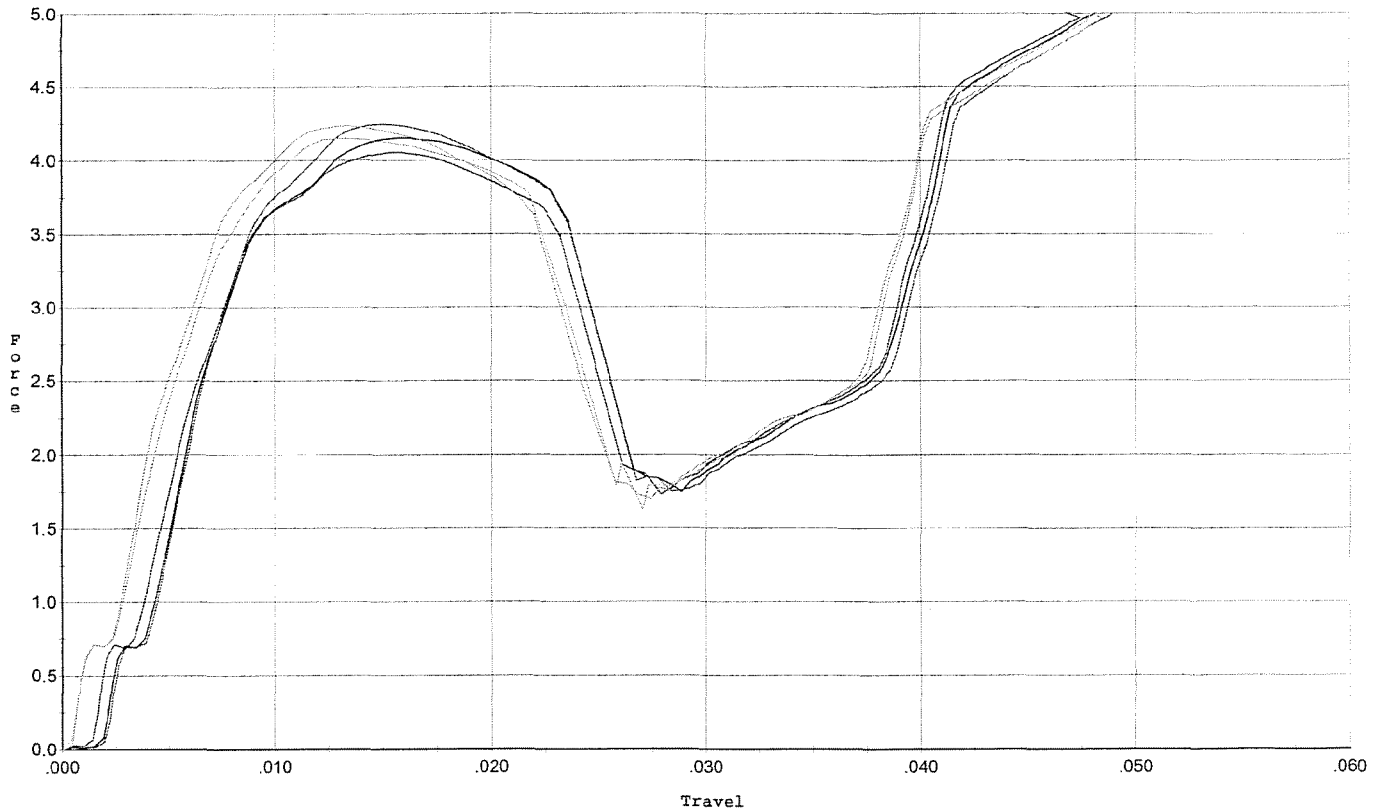
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.023	0.00	0.033	0.063		Set Trigger
2	4.124	0.021	0.00	0.033	0.061		Set Trigger
3	4.093	0.021	0.00	0.032	0.063		Set Trigger
4	4.064	0.023	0.002	0.033	0.063		Set Trigger
5	3.996	0.021	0.00	0.033	0.060		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



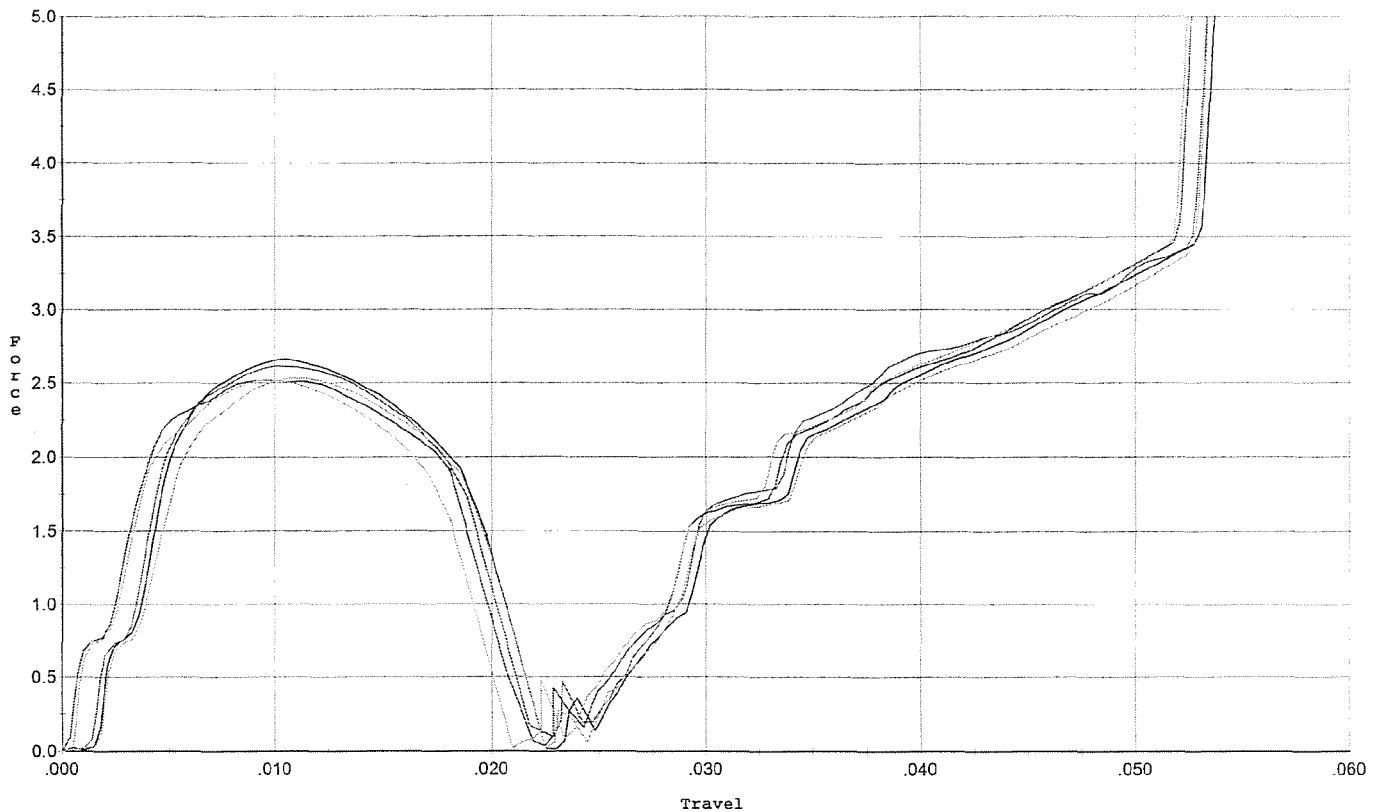
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.054	0.023	0.00	0.032	0.064		Set Trigger
2	4.152	0.024	0.00	0.032	0.066		Set Trigger
3	4.245	0.024	0.002	0.032	0.067		Set Trigger
4	4.149	0.023	0.00	0.032	0.069		Set Trigger
5	4.234	0.022	0.00	0.033	0.066		Set Trigger

A-4-16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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



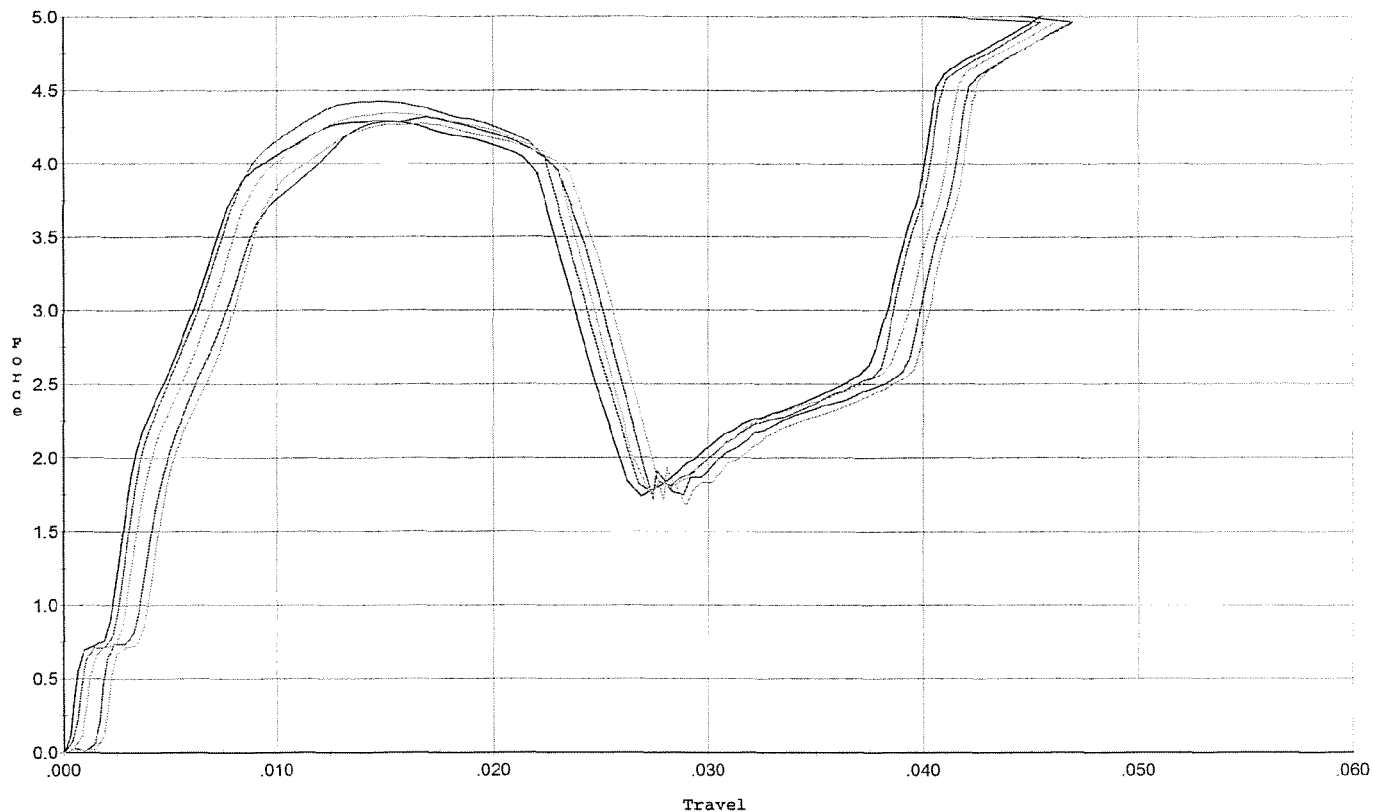
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.518	0.018	0.00	0.038	0.034		Set Trigger
2	2.663	0.020	0.00	0.038	0.036		Set Trigger
3	2.614	0.019	0.00	0.038	0.035		Set Trigger
4	2.522	0.018	0.00	0.038	0.033		Set Trigger
5	2.534	0.020	0.00	0.037	0.035		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C C Schults 3/17/2009

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	4.316	0.024	0.00	0.032	0.072		Set Trigger
2	4.293	0.022	0.00	0.032	0.069		Set Trigger
3	4.427	0.022	0.00	0.032	0.071		Set Trigger
4	4.347	0.023	0.00	0.032	0.071		Set Trigger
5	4.269	0.025	0.00	0.032	0.073		Set Trigger

A. 4.33