

6680 7751

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



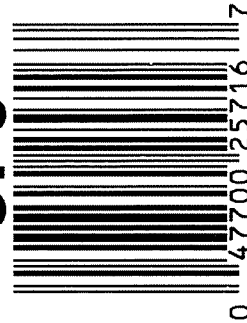
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807751

UPC



GUN SERIAL # G 6807751

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	TR
460	CHECK HEADSPACE		3-6-09	TR
470	DIS-ASSEMBLE ACTION		3-6-09	RR
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RR
475	DRILL AND TAP SIGHT HOLES	MAR 13 2009	3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/13/09	
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		3-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	BARBER M24 0017161	READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>40</u>	<u>40</u>	<u>30</u>	3-28-09	R N		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>40</u>	<u>40</u>	<u>40</u>	3-28-09	R N		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.021</u>	3-28-09	R N		
	J) ASSEMBLE STOCK					3-25-09	R N		
	K) ASSEMBLE SWIVEL STUDS					3-28-09	R 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		<u>PASS</u>	FAIL		3-26-09	N N		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					3-26-09	TL		
670	FINAL INSPECTION A) HEADSPACE					3-28-09	R N		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.63</u>	<u>2.55</u>	<u>2.63</u>	<u>2.60</u>	<u>2.52</u>	3-27-09	TL
	C) FUNCTION							3-28-09	R N
690	PACK							3/30/09	Fm

F004 REV 5/2006

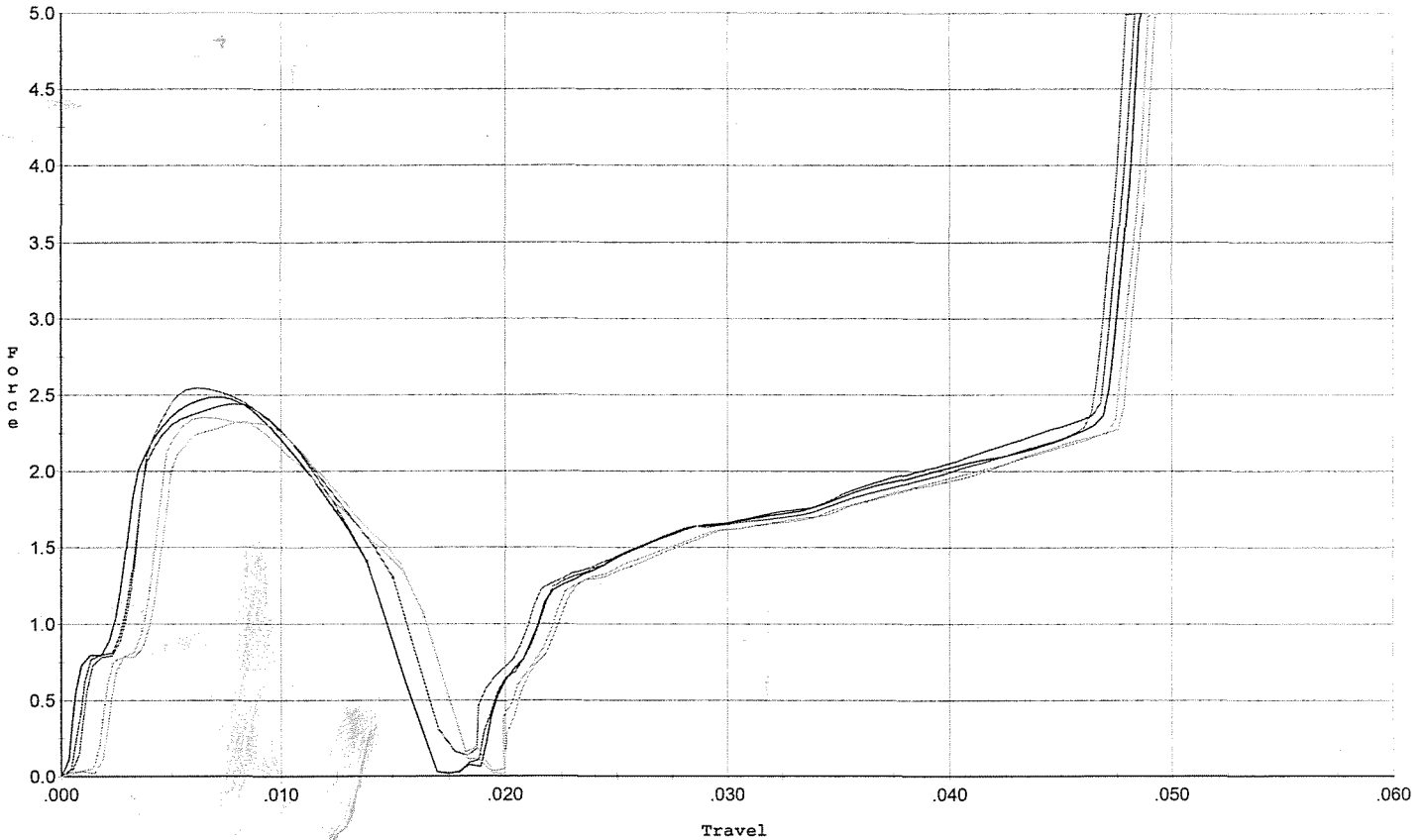
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 0017161 17200

Trigger Profile [lbs,inch]

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

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



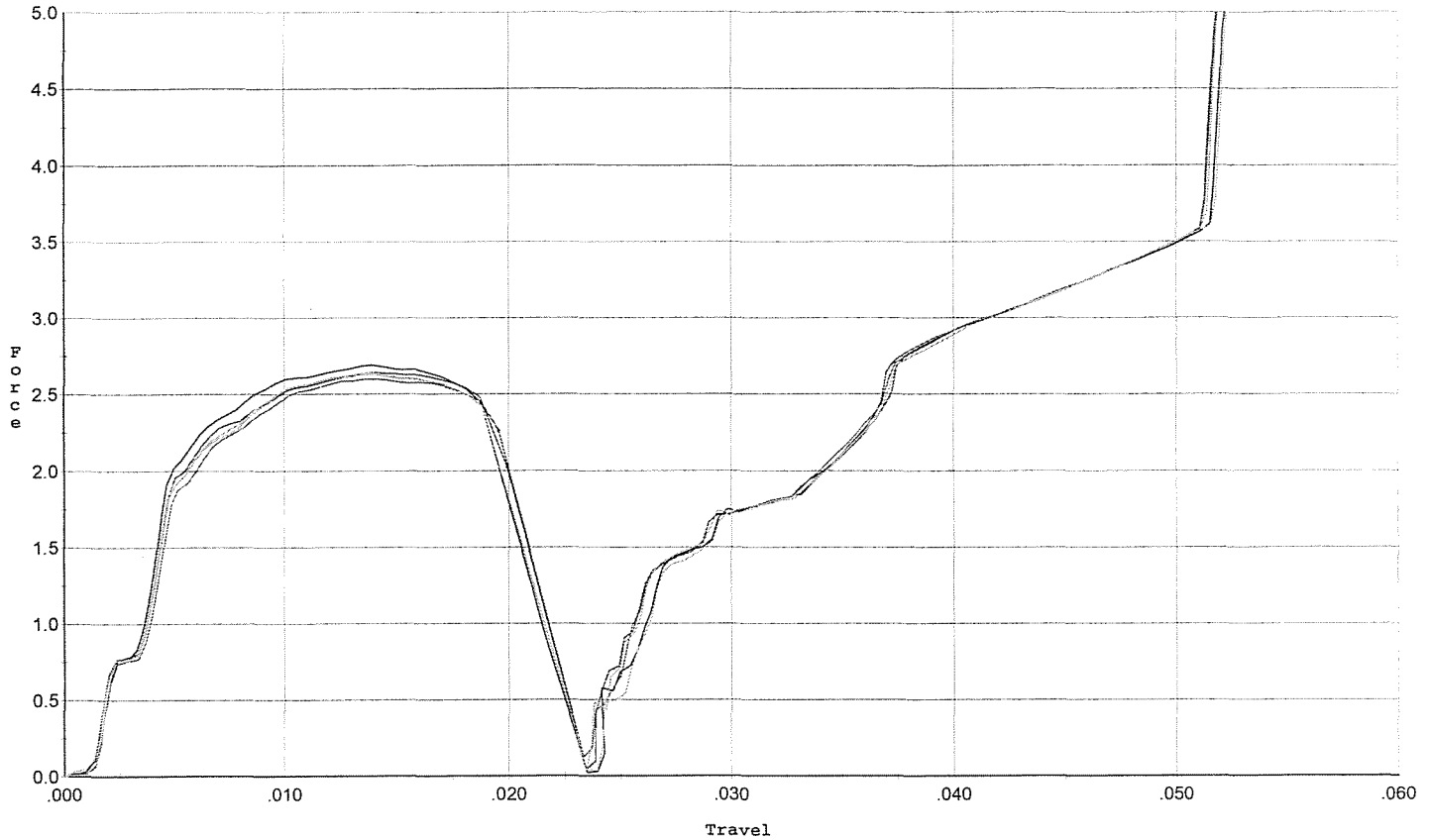
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.442	0.014	0.00	0.039	0.023		Set Trigger
2	2.488	0.014	0.00	0.039	0.024		Set Trigger
3	2.547	0.015	0.00	0.038	0.025		Set Trigger
4	2.353	0.016	0.00	0.038	0.025		Set Trigger
5	2.328	0.016	0.00	0.038	0.024		Set Trigger

1A 2.43

Trigger Profile [lbs,inch]

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

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



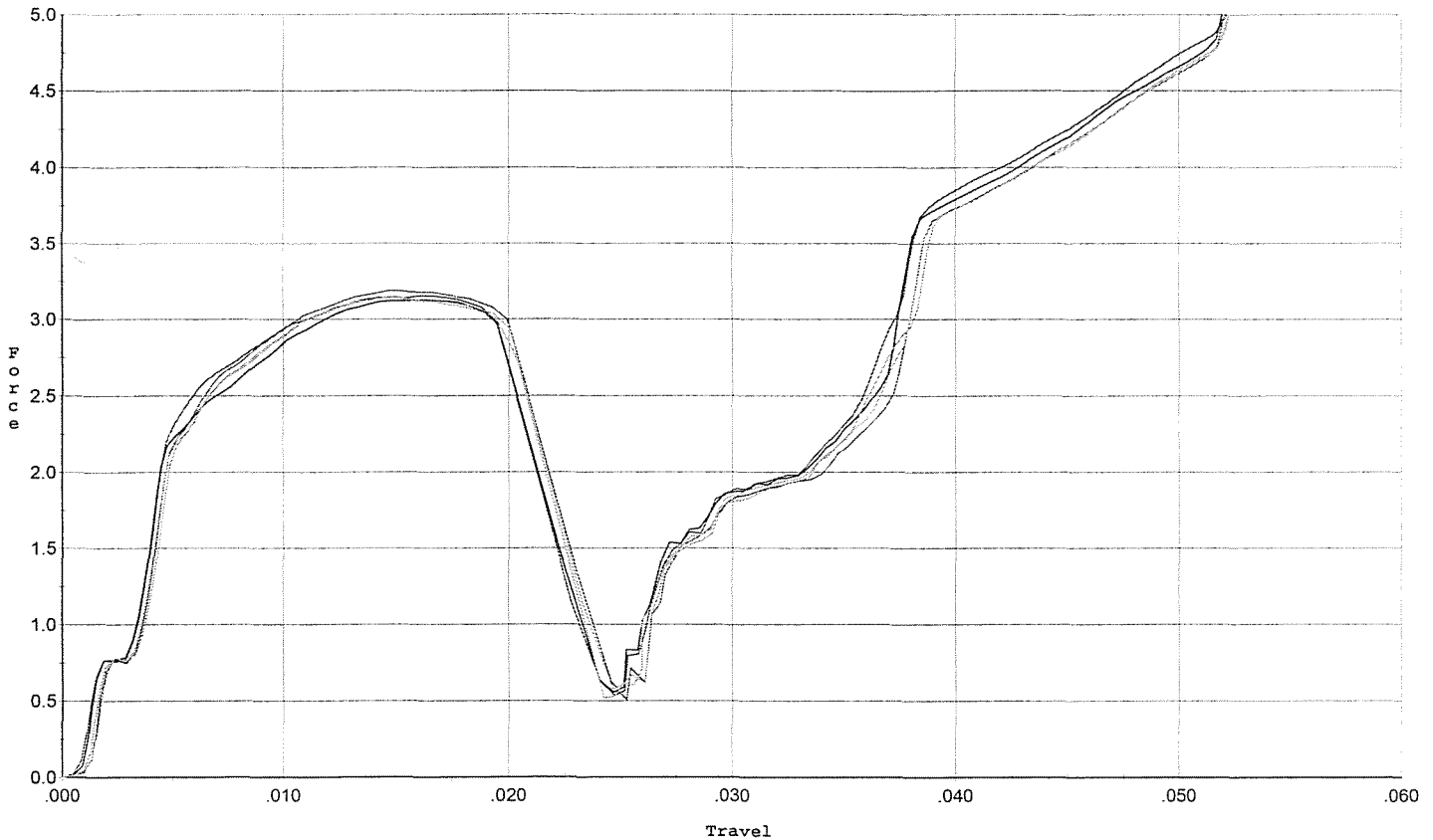
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.642	0.020	0.00	0.035	0.038		Set Trigger
2	2.690	0.019	0.00	0.036	0.037		Set Trigger
3	2.598	0.020	0.00	0.035	0.037		Set Trigger
4	2.630	0.021	0.00	0.036	0.040		Set Trigger
5	2.641	0.021	0.00	0.035	0.040		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

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

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



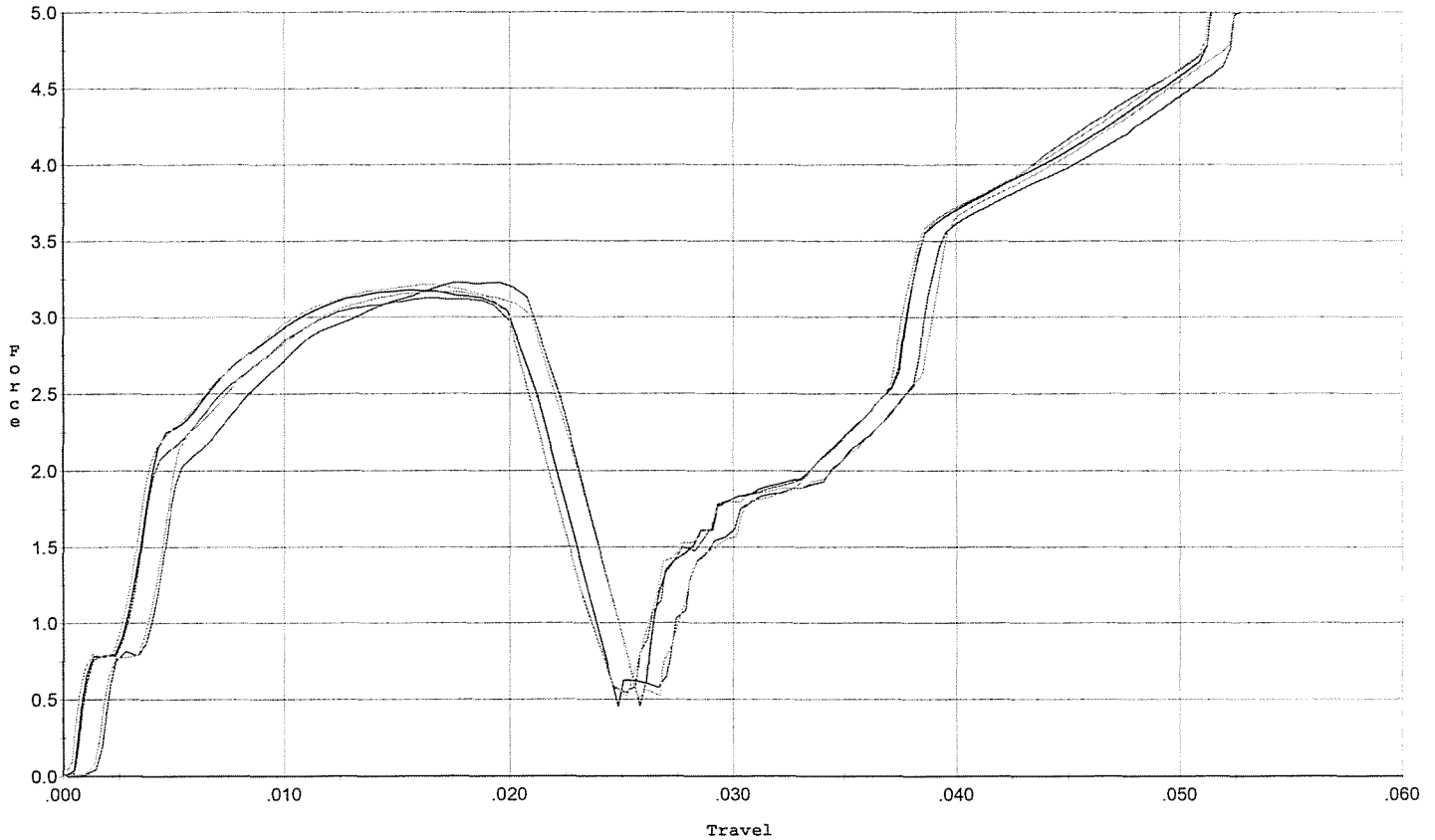
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.154	0.019	0.00	0.035	0.044		Set Trigger
2	3.126	0.019	0.00	0.034	0.044		Set Trigger
3	3.186	0.020	0.00	0.034	0.045		Set Trigger
4	3.145	0.020	0.00	0.034	0.046		Set Trigger
5	3.143	0.020	0.00	0.034	0.045		Set Trigger

A-3-15

Trigger Profile [lbs,inch]

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

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



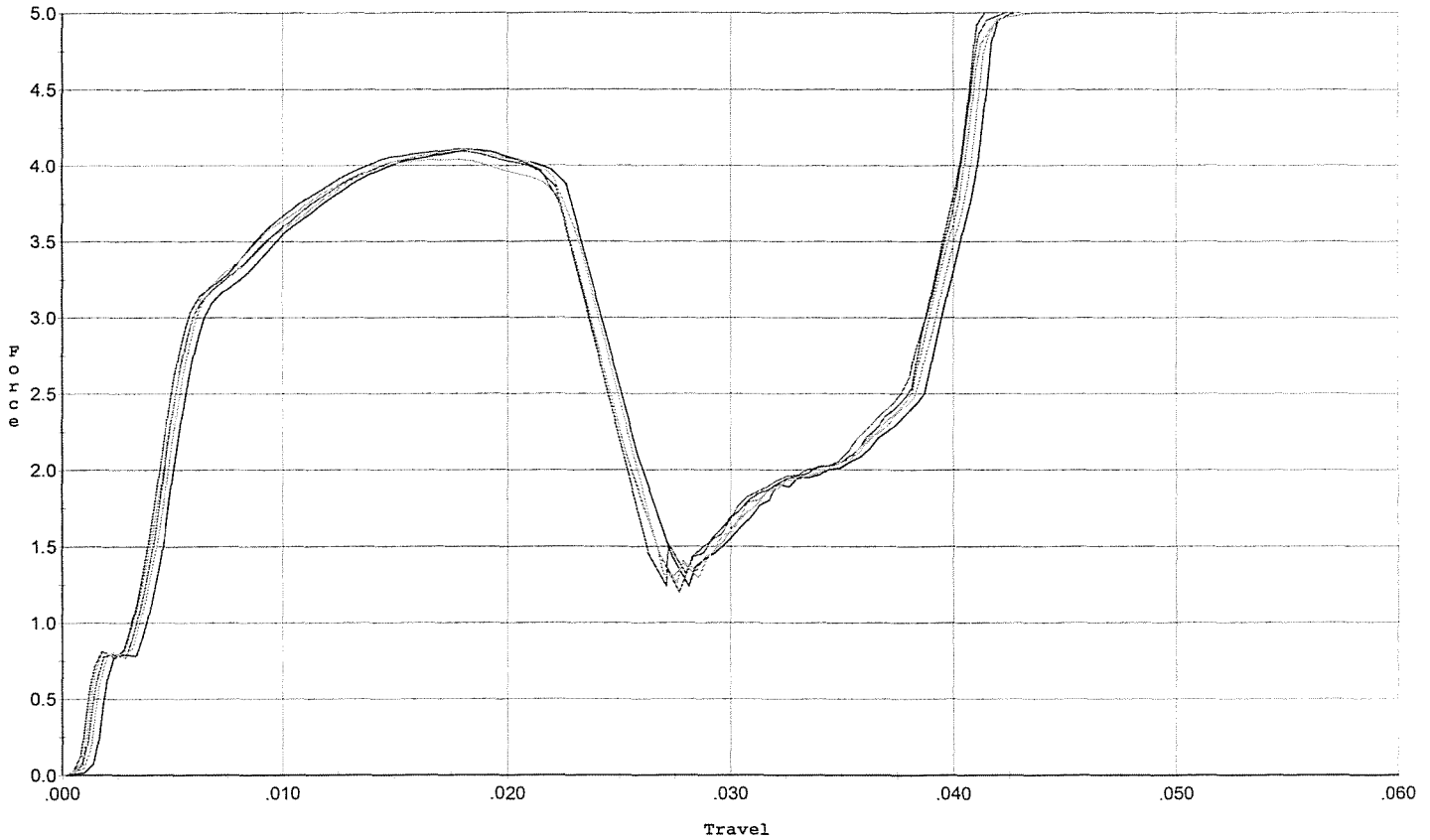
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.228	0.022	0.00	0.034	0.049		Set Trigger
2	3.176	0.021	0.00	0.033	0.050		Set Trigger
3	3.124	0.020	0.00	0.033	0.046		Set Trigger
4	3.215	0.020	0.00	0.033	0.047		Set Trigger
5	3.167	0.023	0.00	0.033	0.051		Set Trigger

A-3-18

Trigger Profile [lbs,inch]

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

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



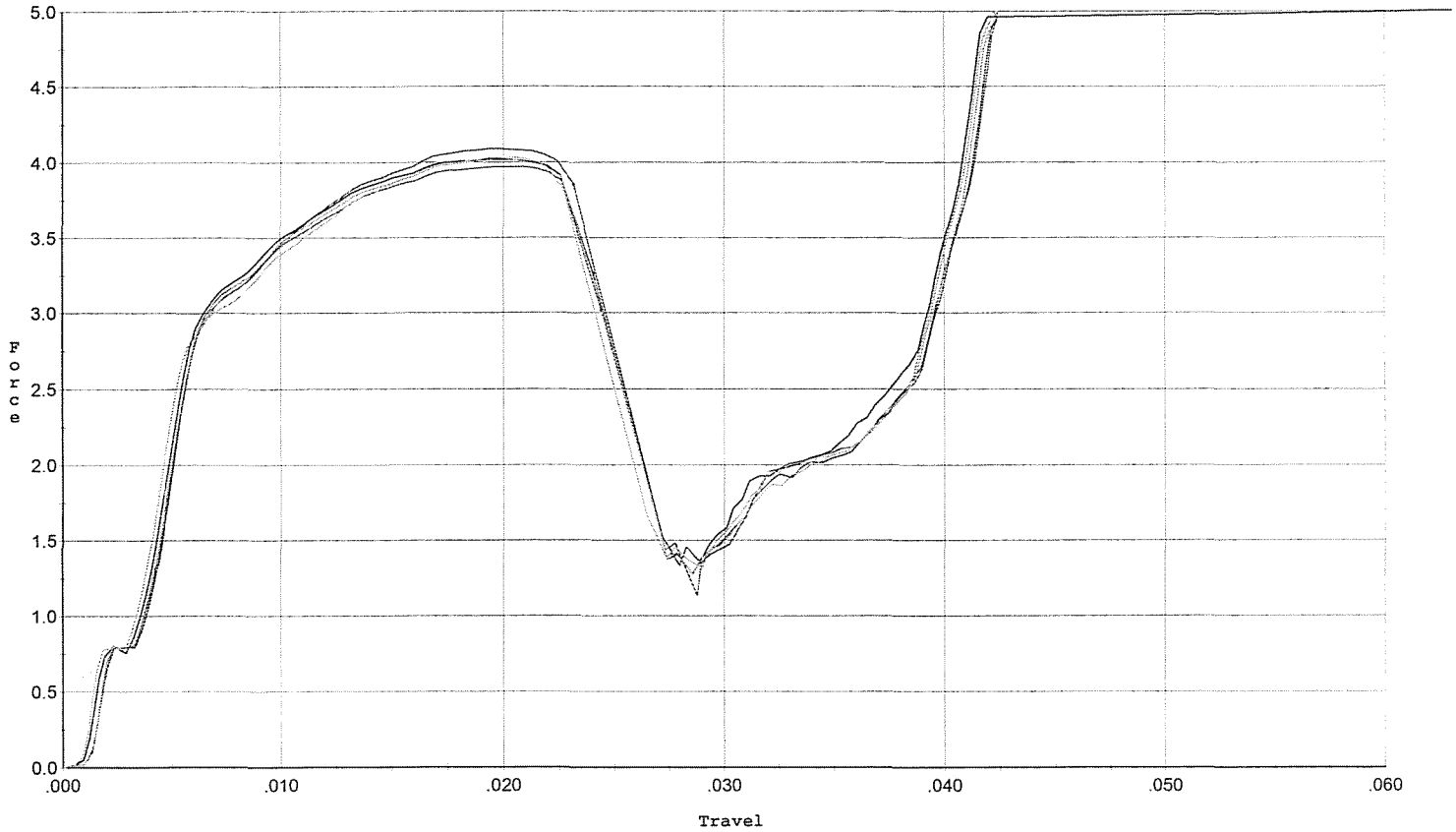
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.109	0.022	0.00	0.032	0.065		Set Trigger
2	4.104	0.023	0.00	0.032	0.064		Set Trigger
3	4.094	0.022	0.00	0.032	0.064		Set Trigger
4	4.106	0.023	0.00	0.032	0.067		Set Trigger
5	4.039	0.022	0.00	0.032	0.064		Set Trigger

A. 4.09

Trigger Profile [lbs,inch]

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

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



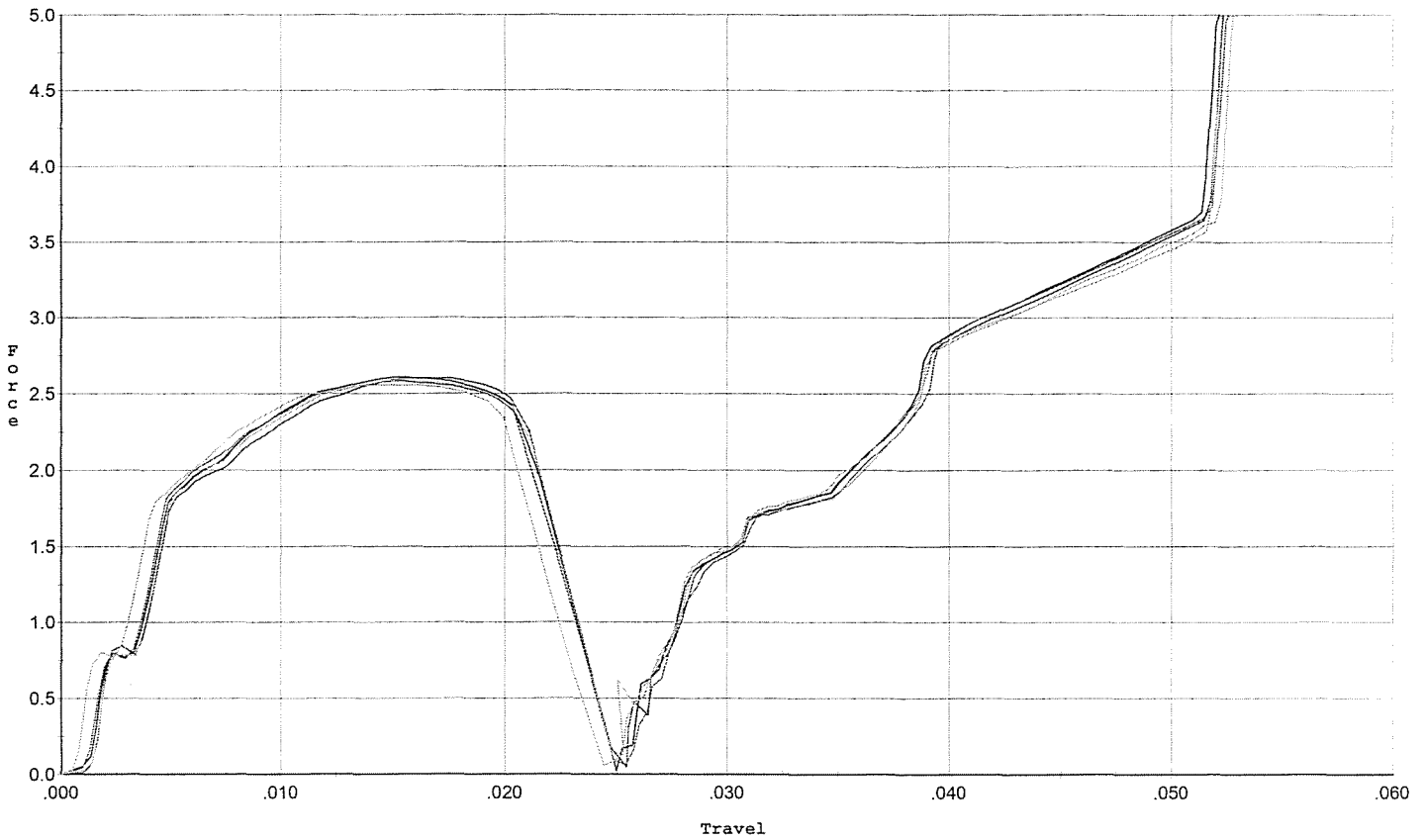
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.089	0.023	0.004	0.031	0.066		Set Trigger
2	4.024	0.024	0.00	0.031	0.068		Set Trigger
3	3.969	0.024	0.00	0.031	0.068		Set Trigger
4	4.031	0.023	0.00	0.032	0.064		Set Trigger
5	4.014	0.024	0.00	0.031	0.068		Set Trigger

ALF. 02

Trigger Profile [lbs,inch]

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

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



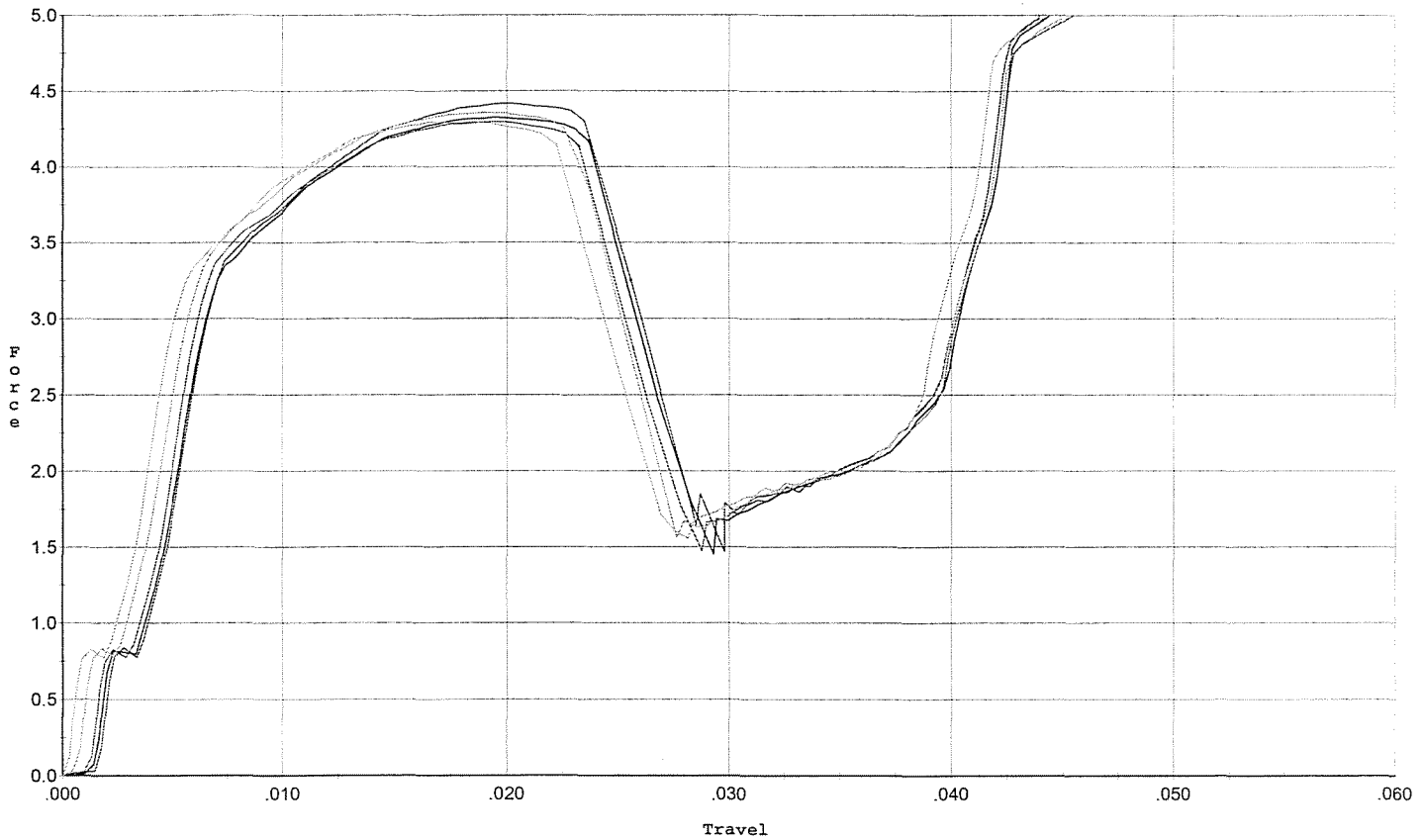
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.604	0.021	0.00	0.035	0.039		Set Trigger
2	2.608	0.021	0.00	0.035	0.041		Set Trigger
3	2.581	0.022	0.00	0.035	0.042		Set Trigger
4	2.592	0.021	0.00	0.035	0.040		Set Trigger
5	2.558	0.020	0.00	0.036	0.039		Set Trigger

A.2.58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: 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	4.419	0.026	0.00	0.031	0.078		Set Trigger
2	4.326	0.024	0.004	0.031	0.071		Set Trigger
3	4.297	0.023	0.00	0.032	0.070		Set Trigger
4	4.299	0.022	0.00	0.031	0.070		Set Trigger
5	4.359	0.024	0.00	0.031	0.074		Set Trigger

A- 4.34