

G6845265

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



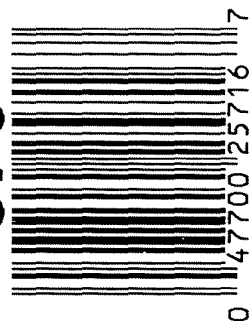
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6845265

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845265

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
472	SERIALIZE BOLT HANDLE		3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION		3-20-09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-9-09	L. N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

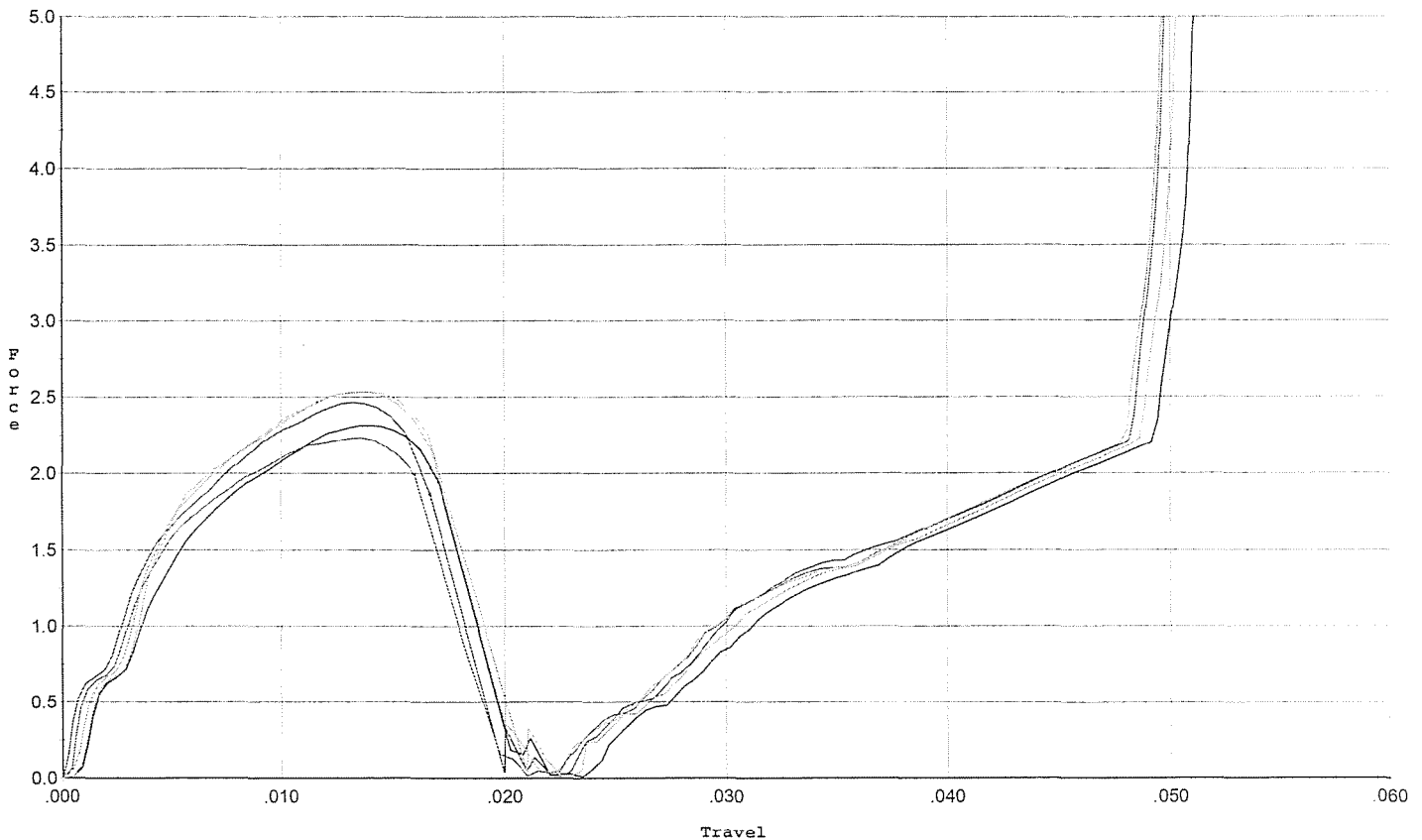
OP #	OPERATION NAME	READINGS	DATE	INITIAL
BARBER - M24 0052742				
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4.5</u> <u>7</u>	4-17-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-17-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.024</u> <u>.024</u>	4-17-09	WW
	J) ASSEMBLE STOCK		4-9-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-17-09	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 <u>PASS</u> FAIL	4-14-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-14-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-17-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.38</u> <u>2.38</u> <u>2.34</u> <u>2.37</u>	4-16-09	RP
	C) FUNCTION		4-17-09	WW
690	PACK		5/30/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



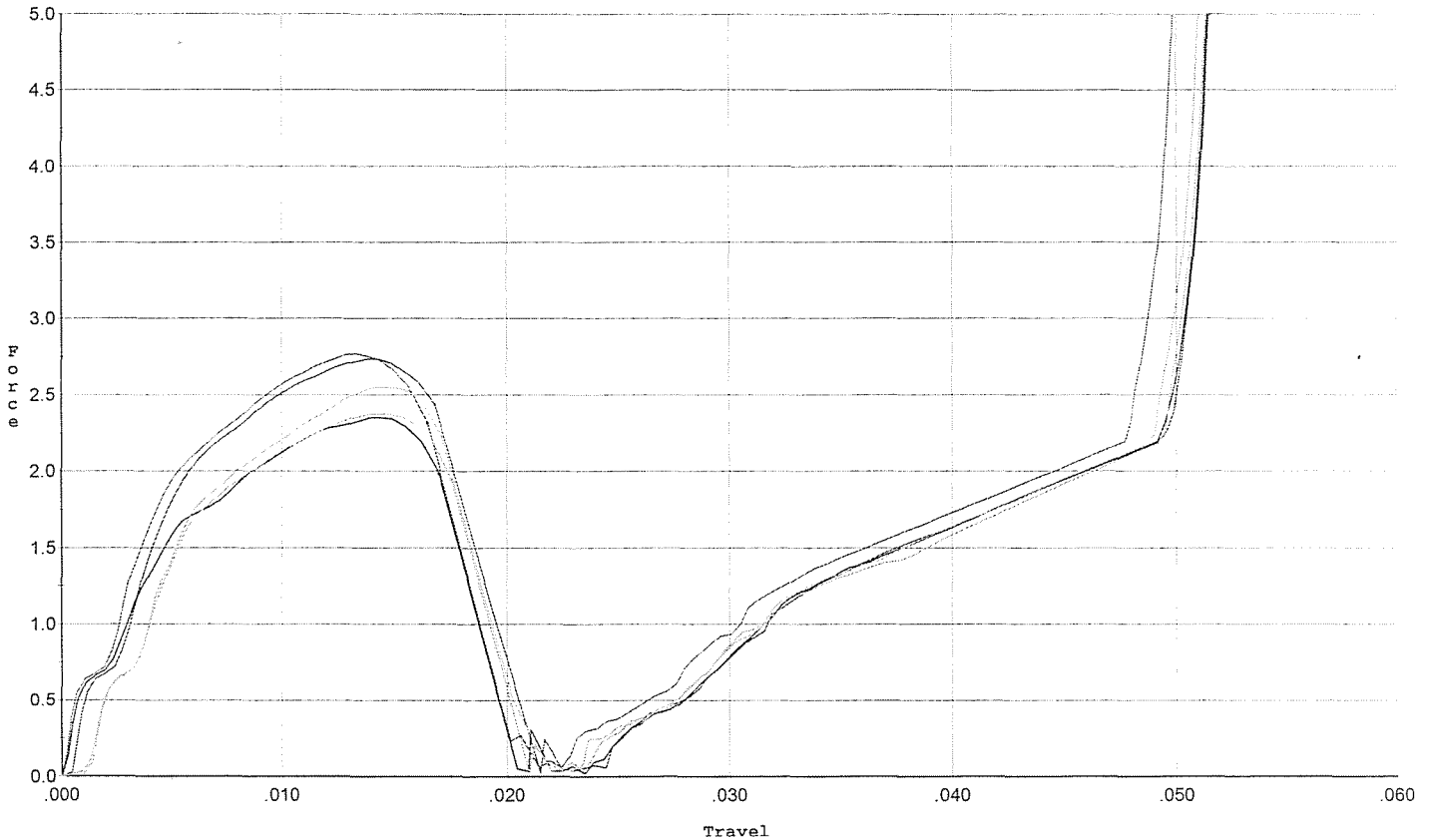
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.464	0.017	0.00	0.038	0.029		Set Trigger
2	2.313	0.017	0.00	0.038	0.027		Set Trigger
3	2.231	0.016	0.00	0.038	0.025		Set Trigger
4	2.533	0.017	0.00	0.037	0.029		Set Trigger
5	2.536	0.019	0.00	0.037	0.032		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



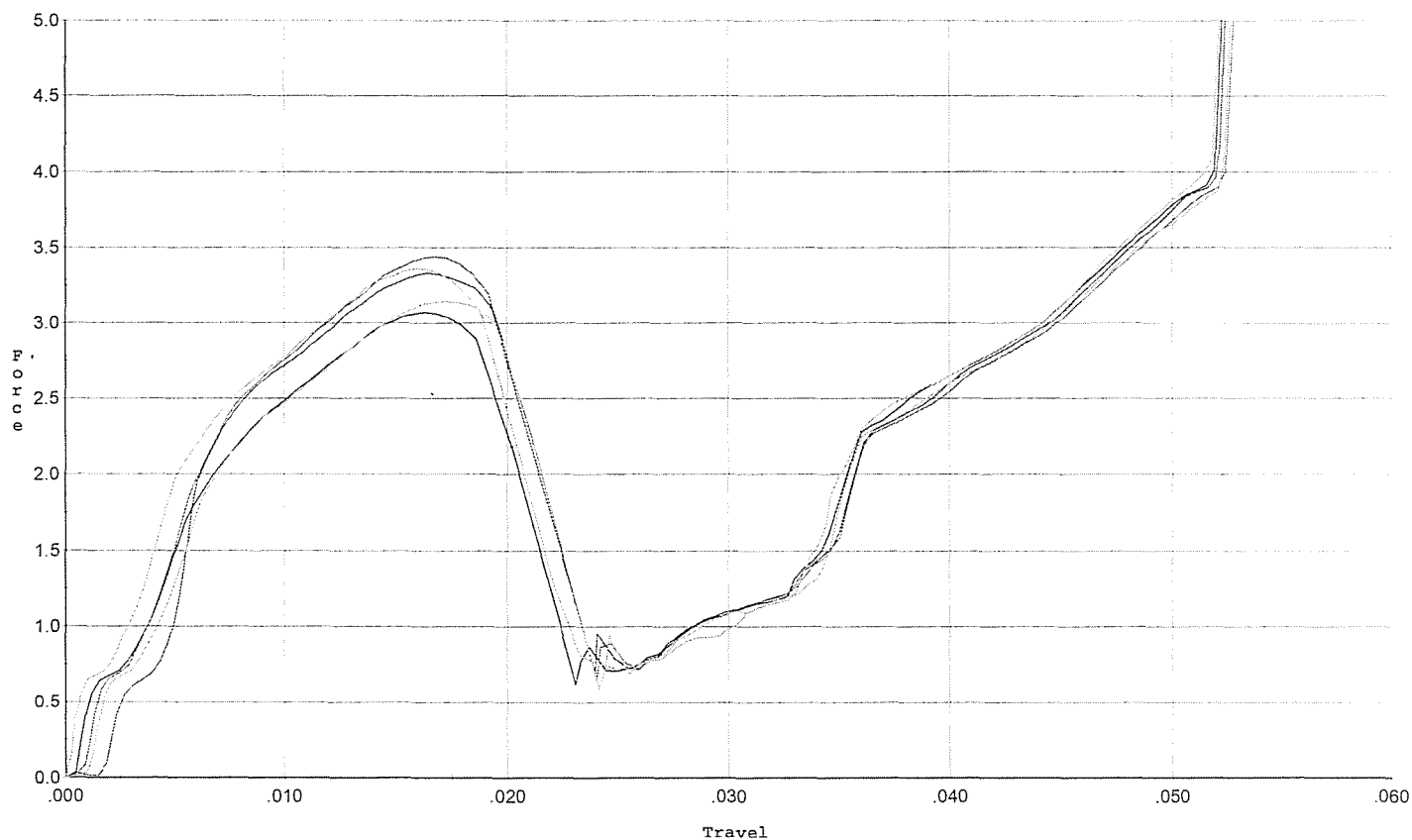
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.738	0.017	0.00	0.038	0.032		Set Trigger
2	2.350	0.017	0.00	0.039	0.028		Set Trigger
3	2.772	0.016	0.00	0.037	0.032		Set Trigger
4	2.553	0.017	0.00	0.038	0.028		Set Trigger
5	2.377	0.018	0.00	0.038	0.028		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



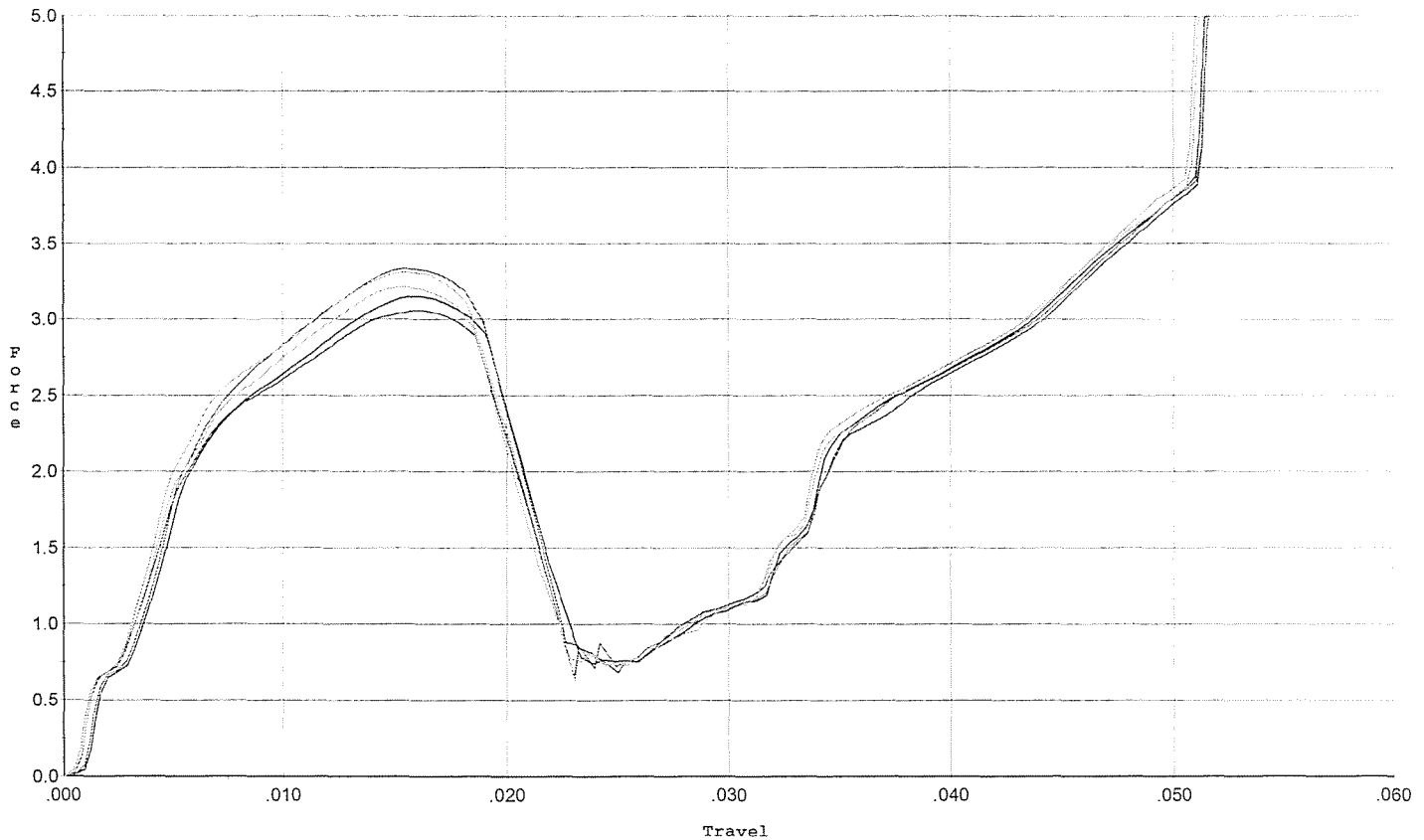
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.333	0.019	0.002	0.035	0.040		Set Trigger
2	3.073	0.020	0.00	0.035	0.040		Set Trigger
3	3.440	0.021	0.00	0.035	0.047		Set Trigger
4	3.146	0.021	0.00	0.035	0.042		Set Trigger
5	3.362	0.019	0.00	0.035	0.043		Set Trigger

A-3-27

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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

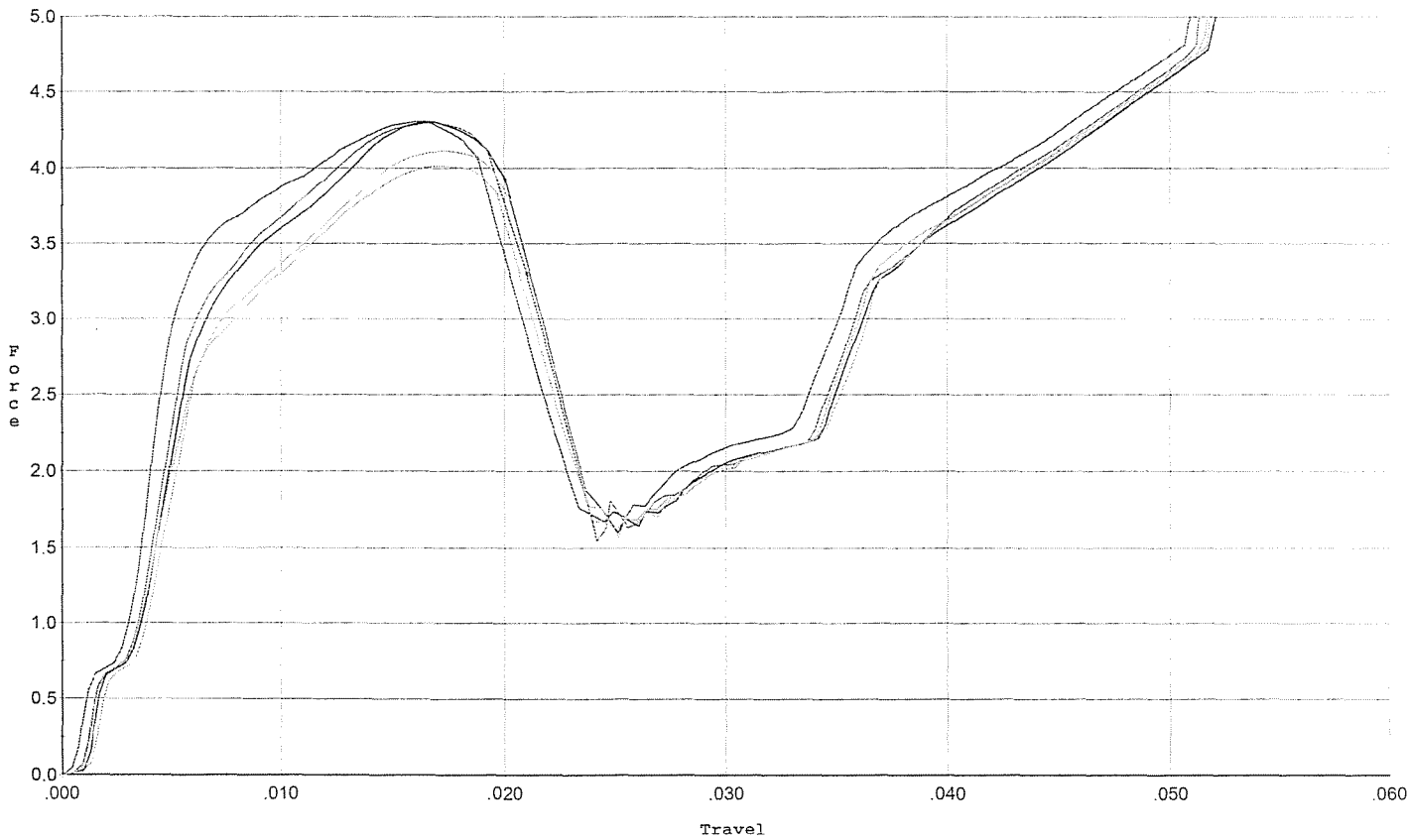


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.060	0.021	0.00	0.034	0.043		Set Trigger
2	3.153	0.019	0.00	0.034	0.040		Set Trigger
3	3.336	0.019	0.00	0.034	0.042		Set Trigger
4	3.214	0.019	0.00	0.035	0.040		Set Trigger
5	3.312	0.020	0.00	0.034	0.045		Set Trigger

A-3.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009
Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lb



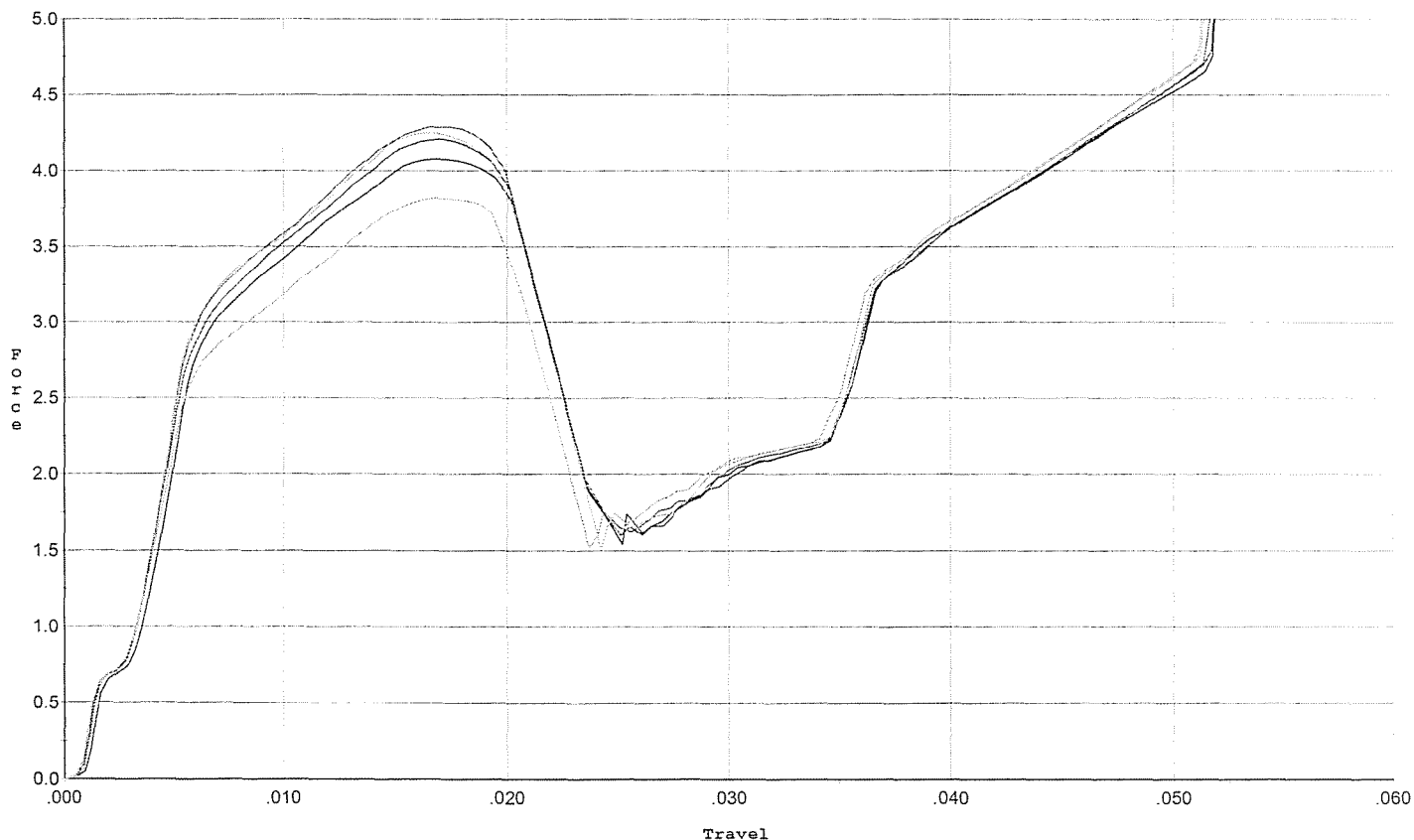
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.306	0.019	0.00	0.032	0.055		Set Trigger
2	4.304	0.020	0.00	0.032	0.056		Set Trigger
3	4.297	0.021	0.00	0.032	0.060		Set Trigger
4	4.115	0.020	0.00	0.032	0.054		Set Trigger
5	4.015	0.020	0.00	0.033	0.052		Set Trigger

A 4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



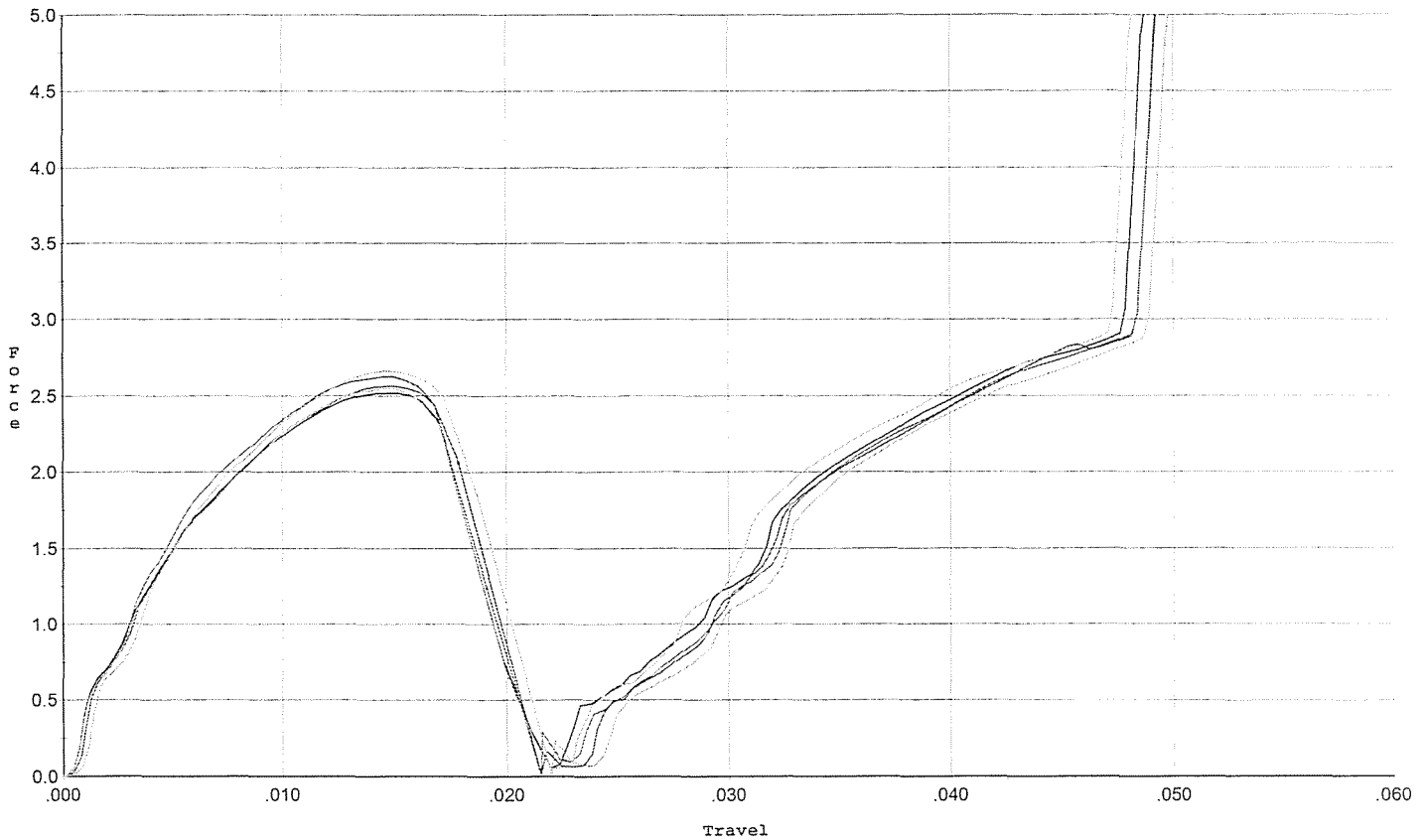
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.208	0.020	0.00	0.032	0.056		Set Trigger
2	4.076	0.020	0.00	0.032	0.055		Set Trigger
3	4.290	0.020	0.00	0.032	0.057		Set Trigger
4	4.250	0.020	0.00	0.032	0.058		Set Trigger
5	3.818	0.021	0.00	0.032	0.053		Set Trigger

A-4012

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



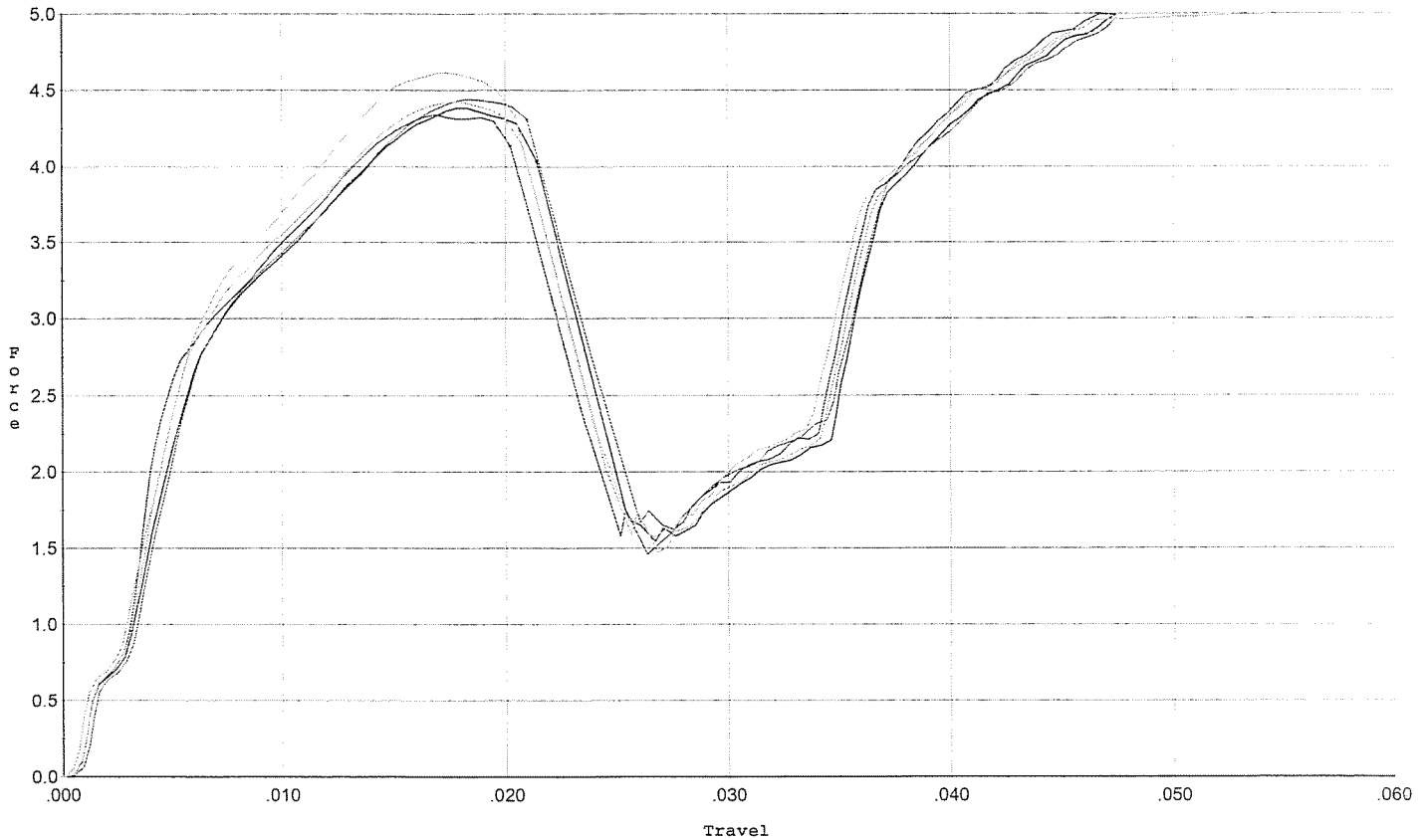
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.564	0.018	0.00	0.035	0.031		Set Trigger
2	2.518	0.017	0.00	0.035	0.029		Set Trigger
3	2.626	0.019	0.00	0.035	0.034		Set Trigger
4	2.550	0.017	0.00	0.034	0.029		Set Trigger
5	2.661	0.019	0.00	0.035	0.033		Set Trigger

A-2-58

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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	4.342	0.020	0.00	0.031	0.058		Set Trigger
2	4.385	0.021	0.00	0.031	0.061		Set Trigger
3	4.441	0.021	0.00	0.030	0.060		Set Trigger
4	4.612	0.020	0.00	0.030	0.061		Set Trigger
5	4.425	0.021	0.00	0.031	0.061		Set Trigger

4.44