

G6845316

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



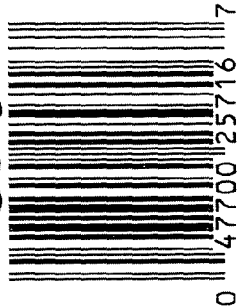
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6845316

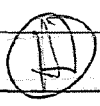
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BM FORM

BARBER - M24 0053352 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66845316

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	RPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	RPD
460	CHECK HEADSPACE		3-17-09	RPD
470	DIS-ASSEMBLE ACTION		3-17-09	RPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-19-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3-20-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-27	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		3-31-09	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

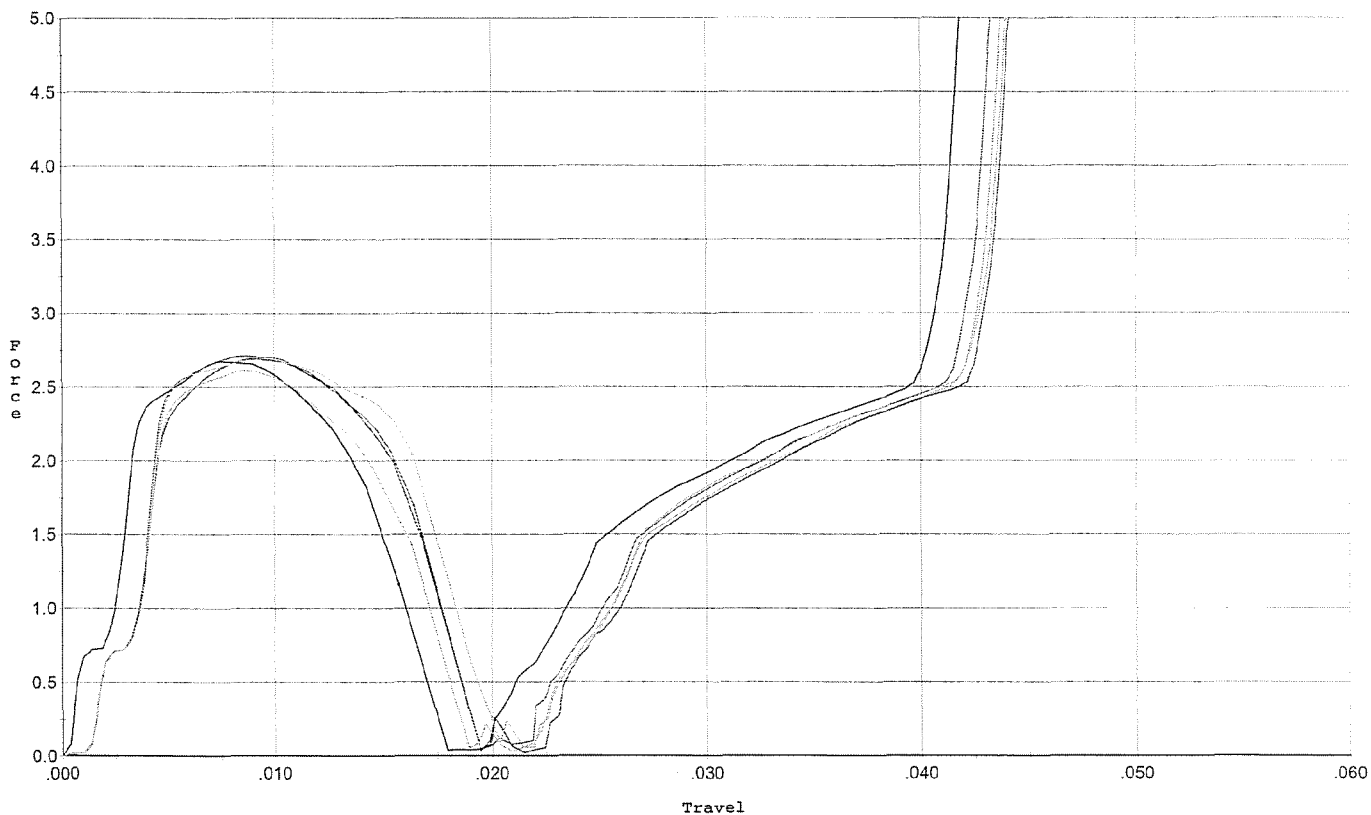
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6</u> <u>6</u>	4-1-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-1-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-1-09	NW
	J) ASSEMBLE STOCK		3-31-09	RT
	K) ASSEMBLE SWIVEL STUDS		4-2-09	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	3-31-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.40</u> <u>2.43</u> <u>2.34</u> <u>2.29</u>	4-1-09	NW
	C) FUNCTION		4-1-09	NW
690	PACK		6/5/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



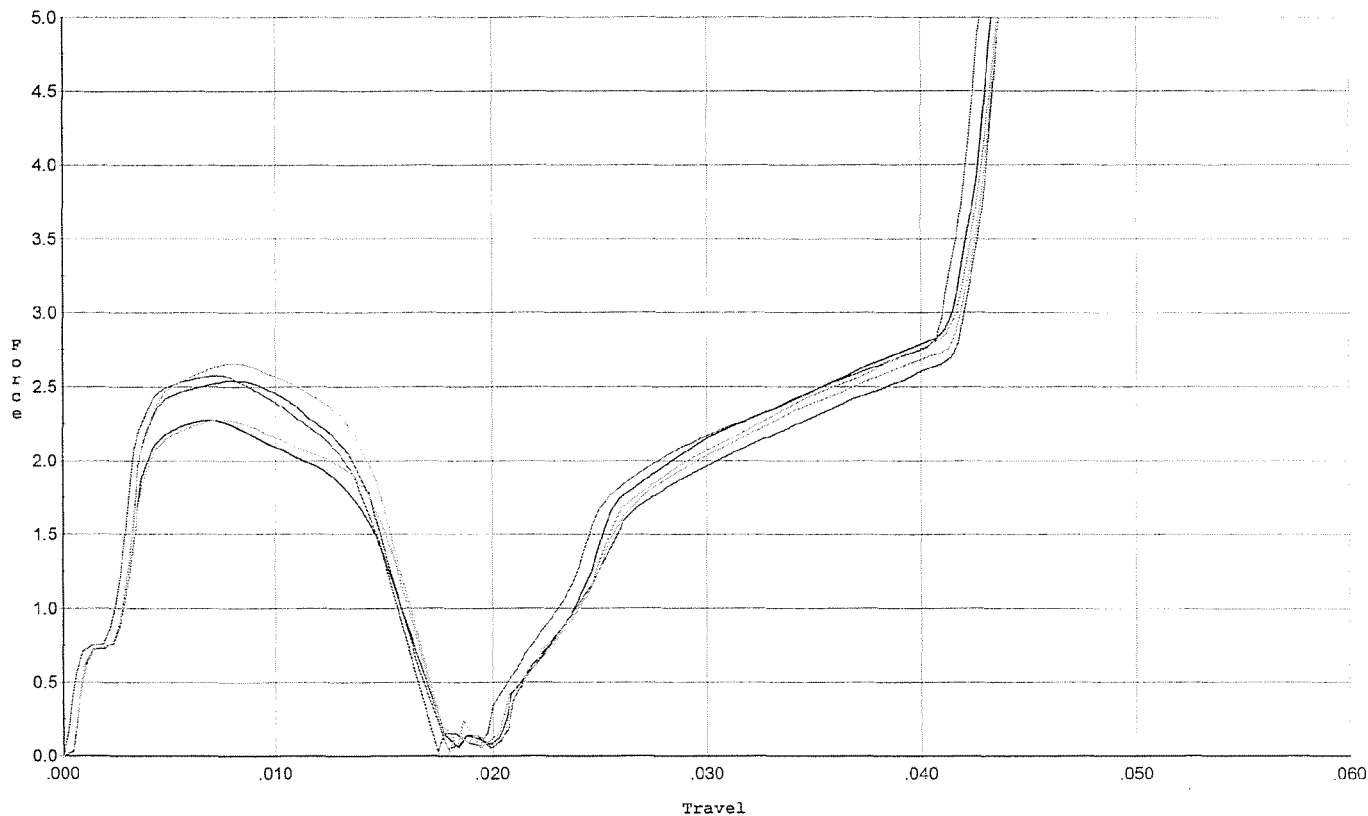
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.694	0.017	0.00	0.032	0.030		Set Trigger
2	2.671	0.016	0.00	0.031	0.030		Set Trigger
3	2.712	0.016	0.00	0.031	0.030		Set Trigger
4	2.685	0.016	0.00	0.032	0.031		Set Trigger
5	2.616	0.016	0.00	0.032	0.028		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



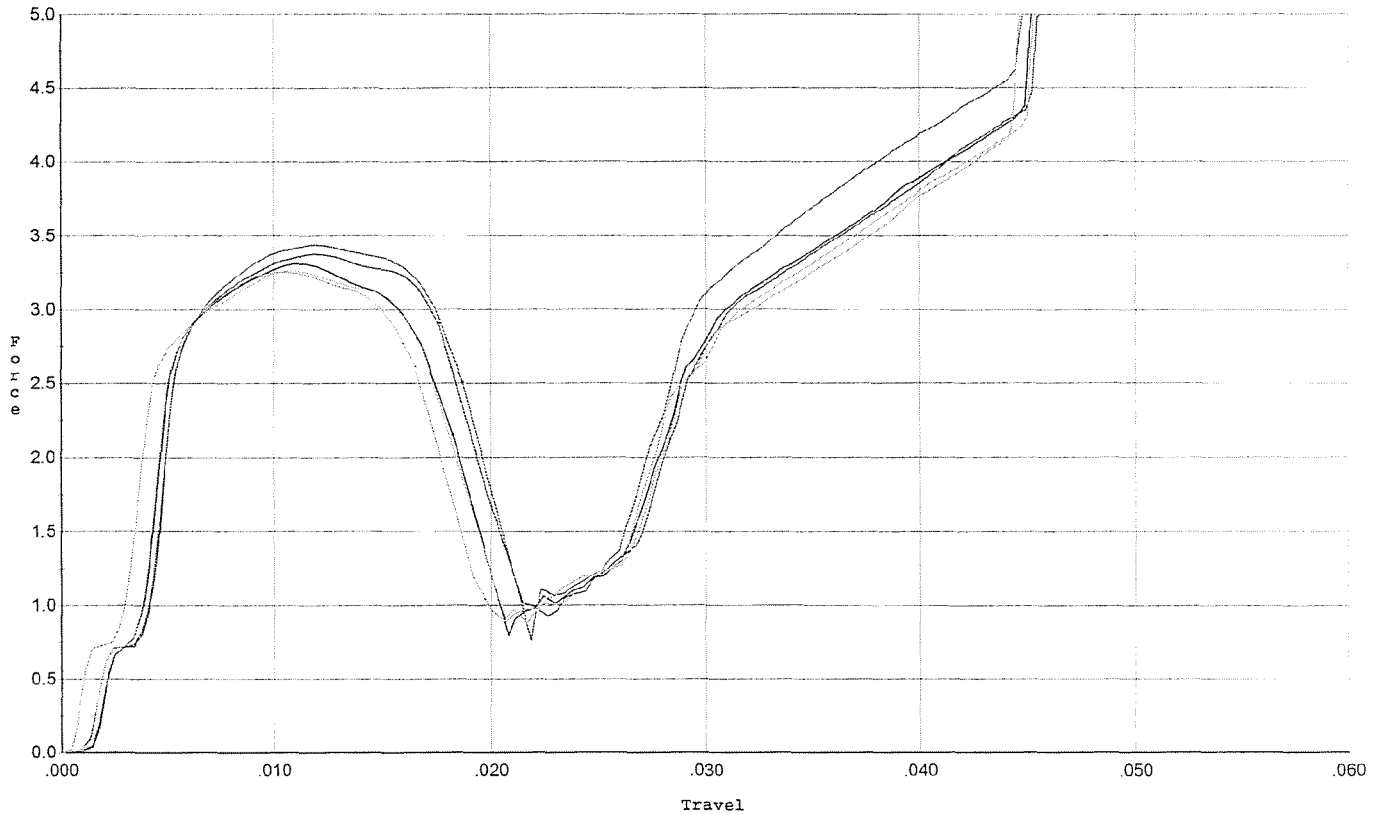
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.537	0.014	0.00	0.033	0.026		Set Trigger
2	2.273	0.015	0.00	0.032	0.024		Set Trigger
3	2.574	0.015	0.00	0.032	0.027		Set Trigger
4	2.277	0.015	0.00	0.033	0.025		Set Trigger
5	2.658	0.015	0.00	0.033	0.028		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



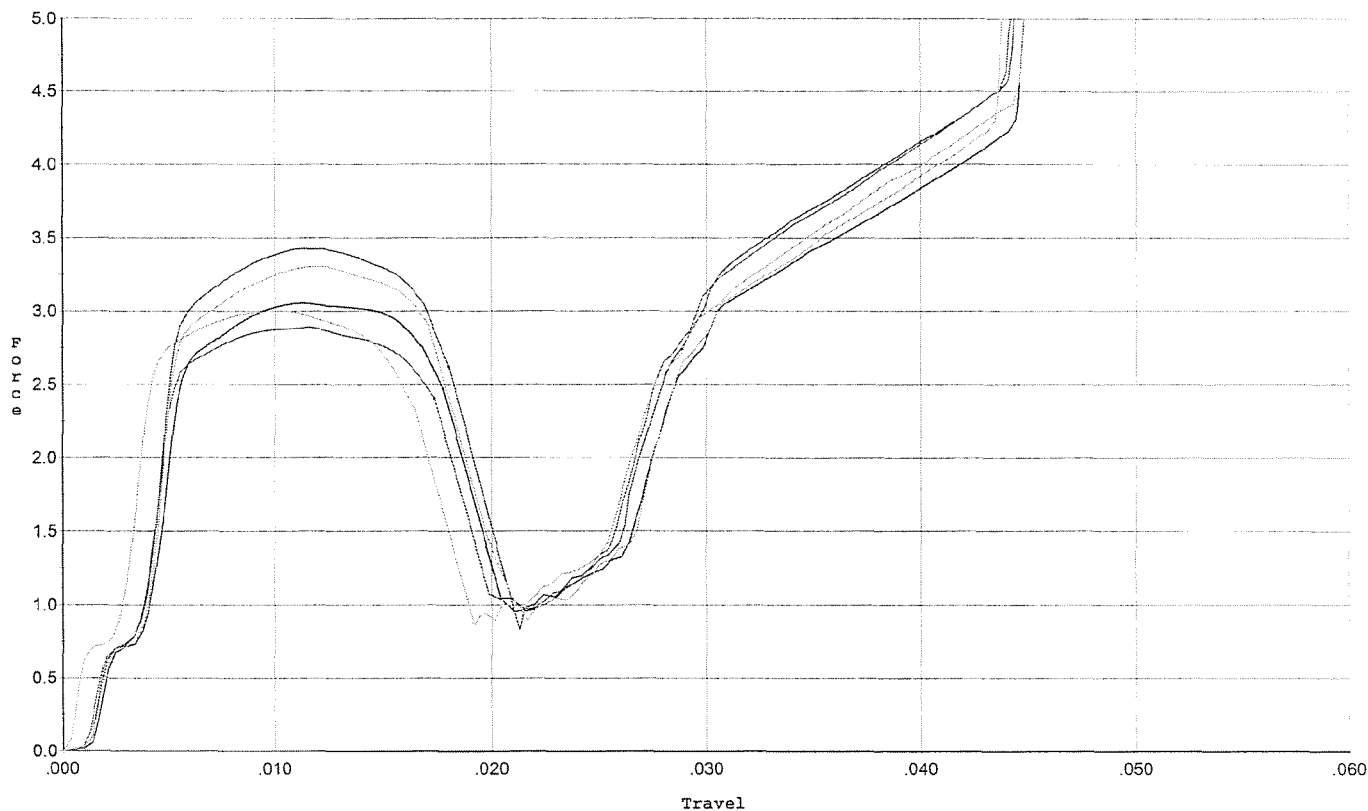
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.380	0.018	0.00	0.030	0.040		Set Trigger
2	3.313	0.018	0.00	0.029	0.041		Set Trigger
3	3.439	0.019	0.00	0.028	0.043		Set Trigger
4	3.261	0.019	0.00	0.030	0.041		Set Trigger
5	3.255	0.017	0.00	0.030	0.038		Set Trigger

A-3-33

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



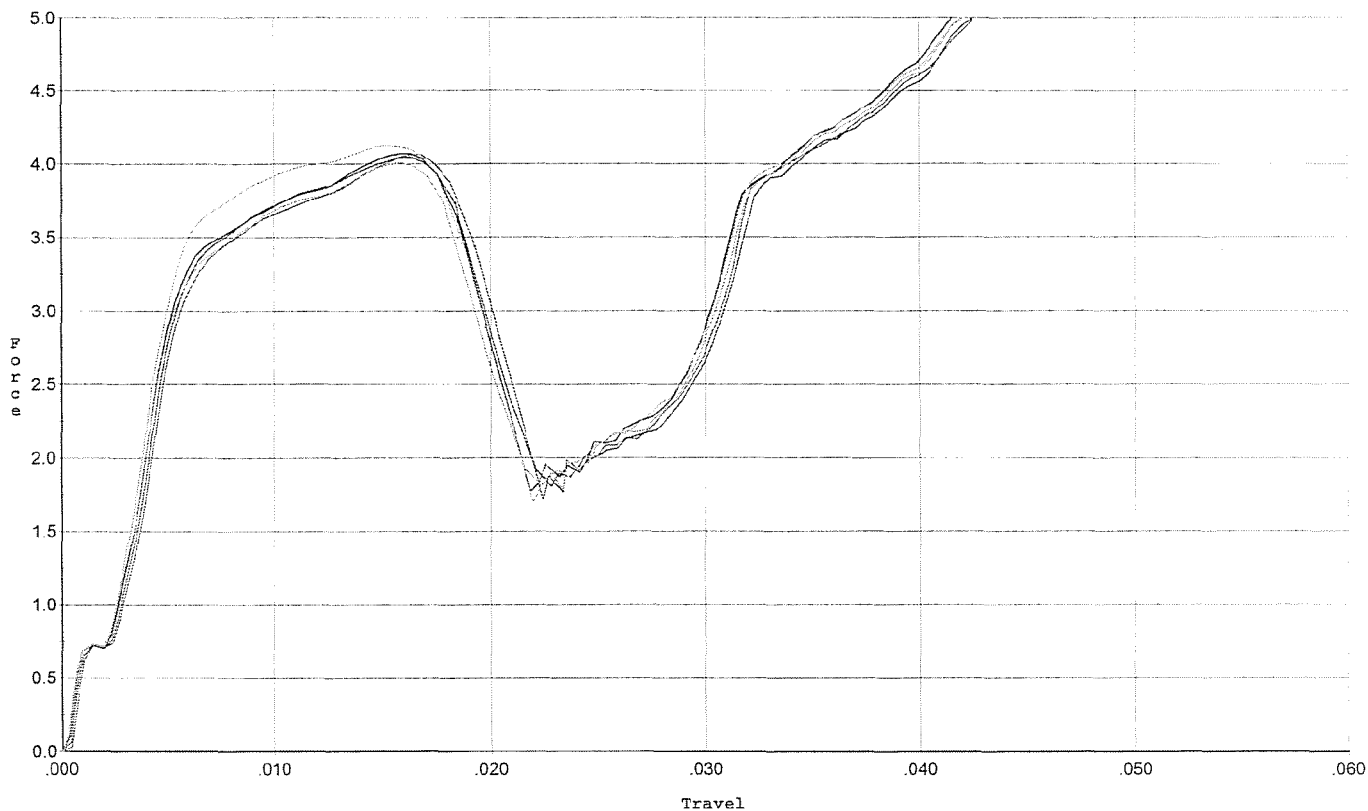
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.429	0.018	0.00	0.028	0.042		Set Trigger
2	3.055	0.018	0.00	0.029	0.037		Set Trigger
3	2.891	0.017	0.00	0.029	0.035		Set Trigger
4	3.001	0.016	0.00	0.029	0.036		Set Trigger
5	3.308	0.017	0.00	0.029	0.038		Set Trigger

A-3.13

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

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



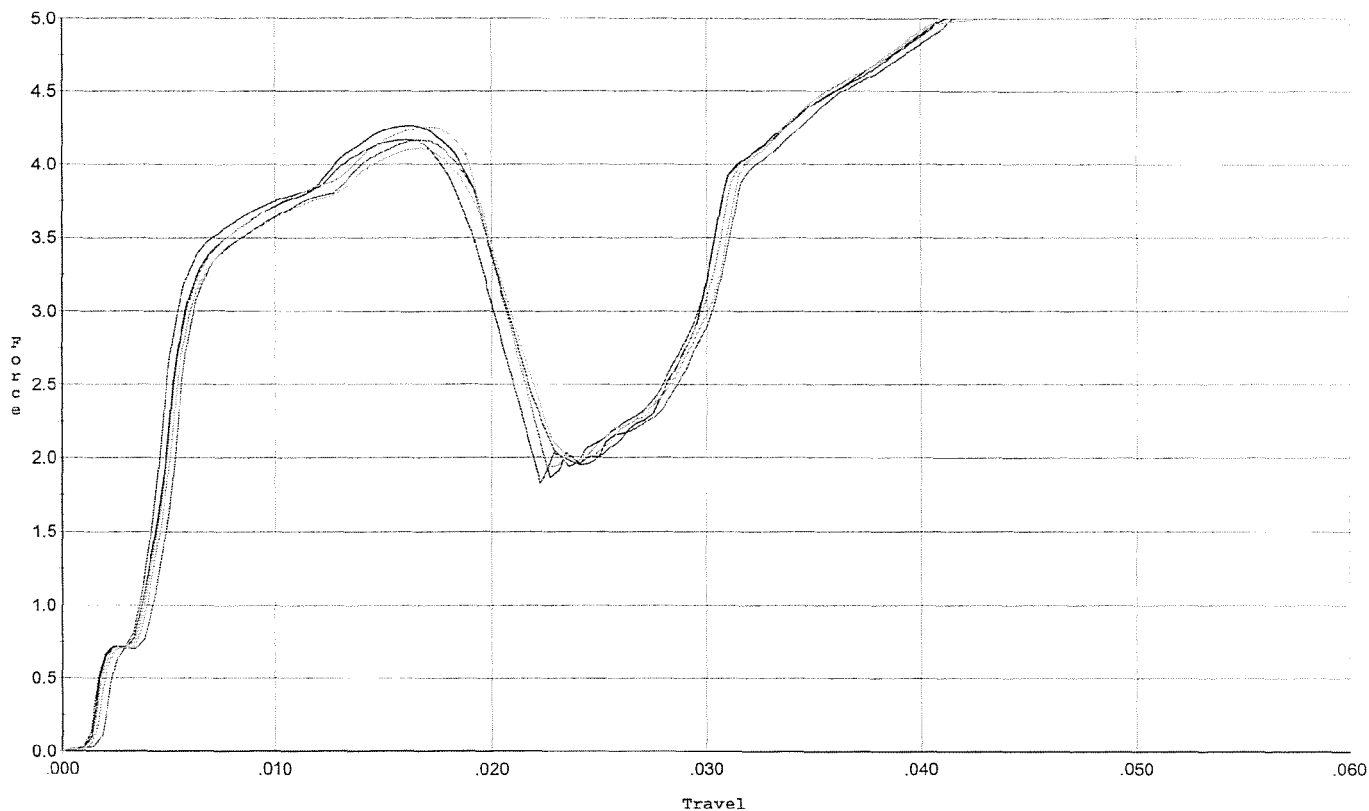
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.045	0.018	0.00	0.028	0.051		Set Trigger
2	4.069	0.019	0.00	0.027	0.052		Set Trigger
3	4.060	0.019	0.00	0.027	0.053		Set Trigger
4	4.122	0.019	0.00	0.027	0.054		Set Trigger
5	4.008	0.018	0.00	0.027	0.049		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



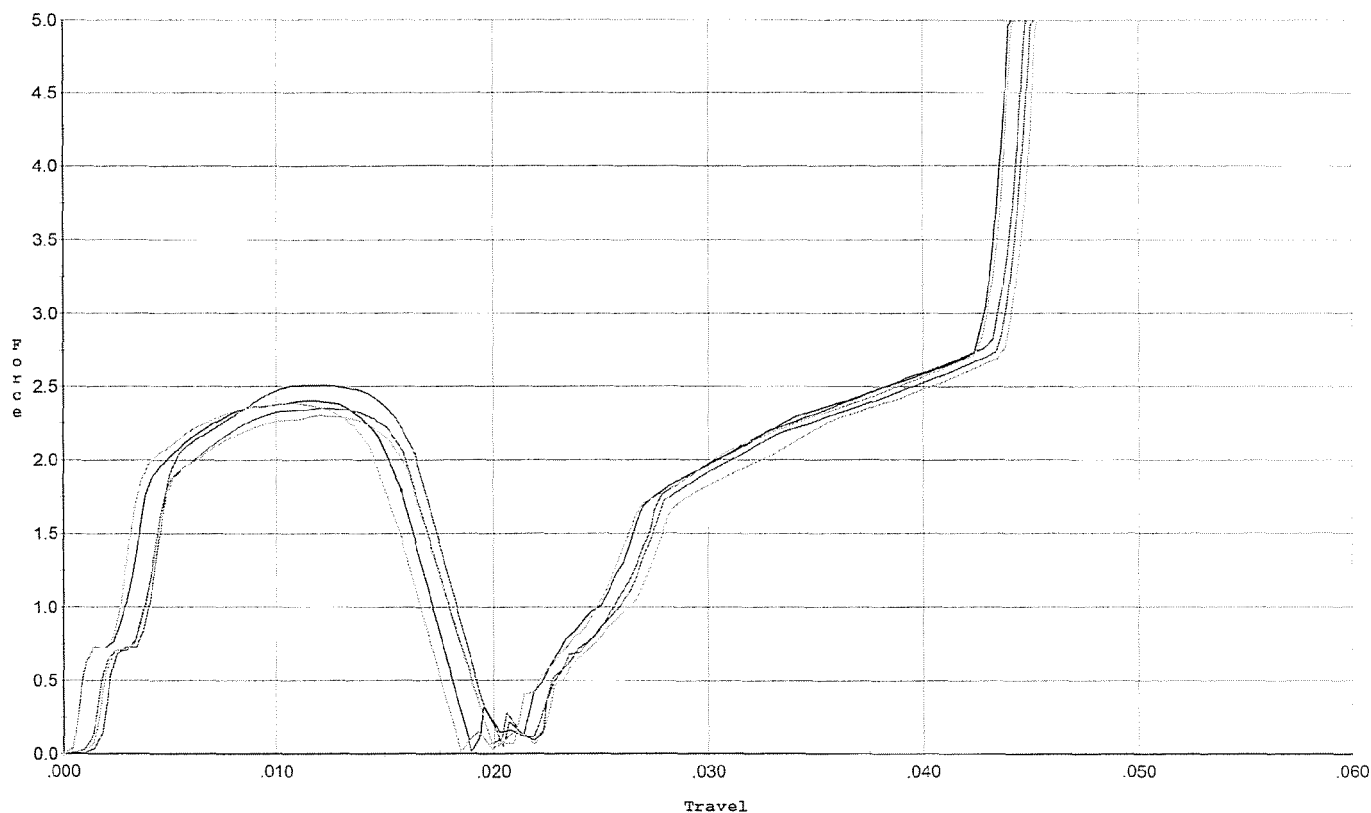
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.172	0.019	0.00	0.027	0.053		Set Trigger
2	4.265	0.019	0.00	0.026	0.053		Set Trigger
3	4.168	0.019	0.00	0.027	0.051		Set Trigger
4	4.115	0.019	0.00	0.026	0.052		Set Trigger
5	4.257	0.019	0.00	0.026	0.052		Set Trigger

A. 4.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/30/2009

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



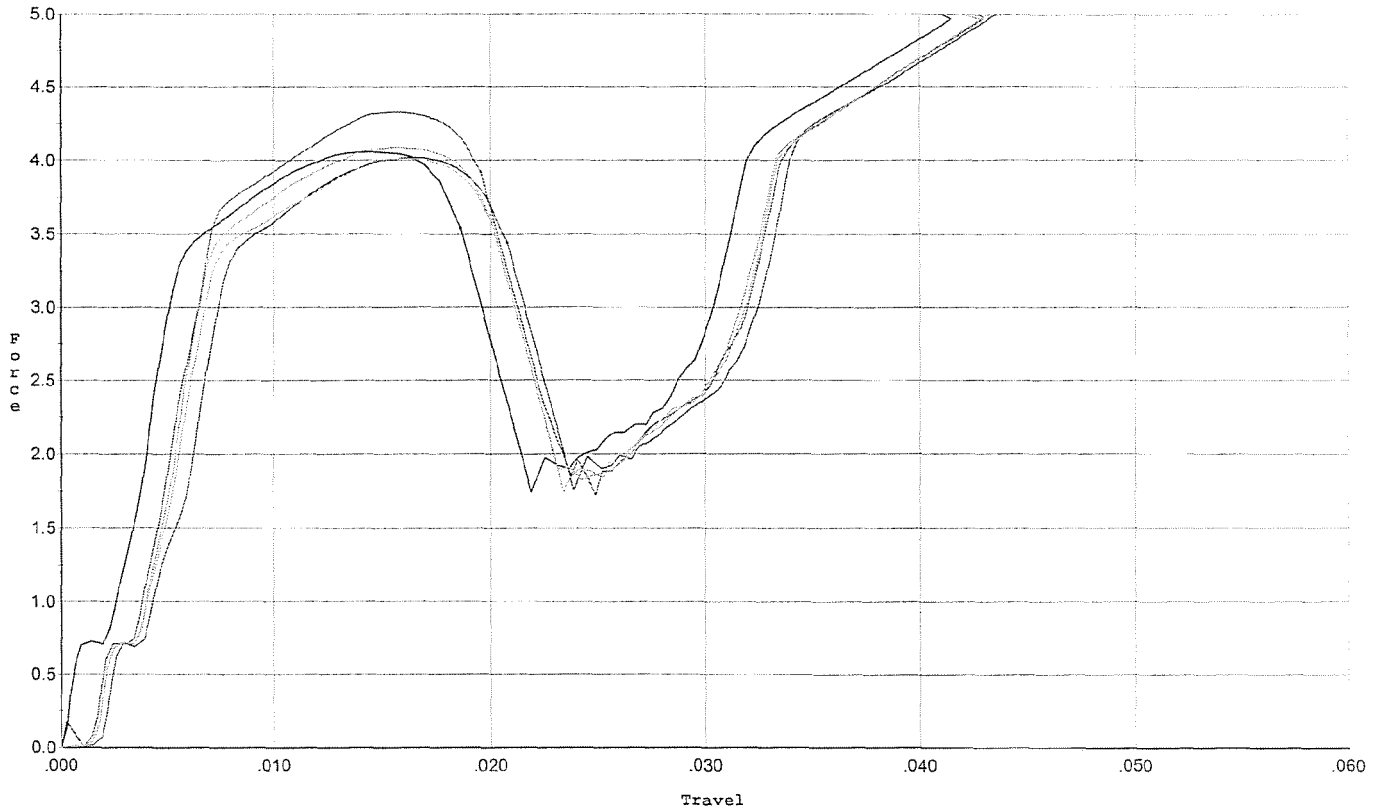
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.509	0.016	0.00	0.032	0.028		Set Trigger
2	2.403	0.016	0.00	0.032	0.028		Set Trigger
3	2.352	0.016	0.00	0.033	0.026		Set Trigger
4	2.304	0.016	0.00	0.033	0.026		Set Trigger
5	2.388	0.016	0.00	0.033	0.028		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/30/2009

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs ini +/- 1.0 lb for target & accurac



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.018	0.021	0.002	0.028	0.054		Set Trigger
2	4.058	0.019	0.00	0.028	0.053		Set Trigger
3	4.328	0.020	0.00	0.028	0.056		Set Trigger
4	4.012	0.020	0.00	0.027	0.053		Set Trigger
5	4.088	0.020	0.00	0.028	0.054		Set Trigger

A-4.10