

G6784720

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



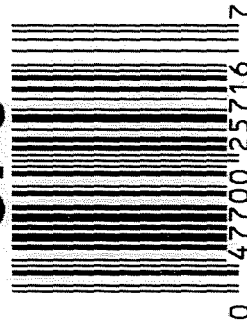
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6784720

UPC



GUN SERIAL # G 6784720

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SP
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SP
460	CHECK HEADSPACE		9-19-08	SP
470	DIS-ASSEMBLE ACTION		9-19-08	SP
472	SERIALIZE BOLT HANDLE		9-20-08	BSW
475	DRILL AND TAP SIGHT HOLES		9-20-08	SP
480	MAGNAFLUX BBL ACTION		9-22-08	BSW
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		9-24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-16-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

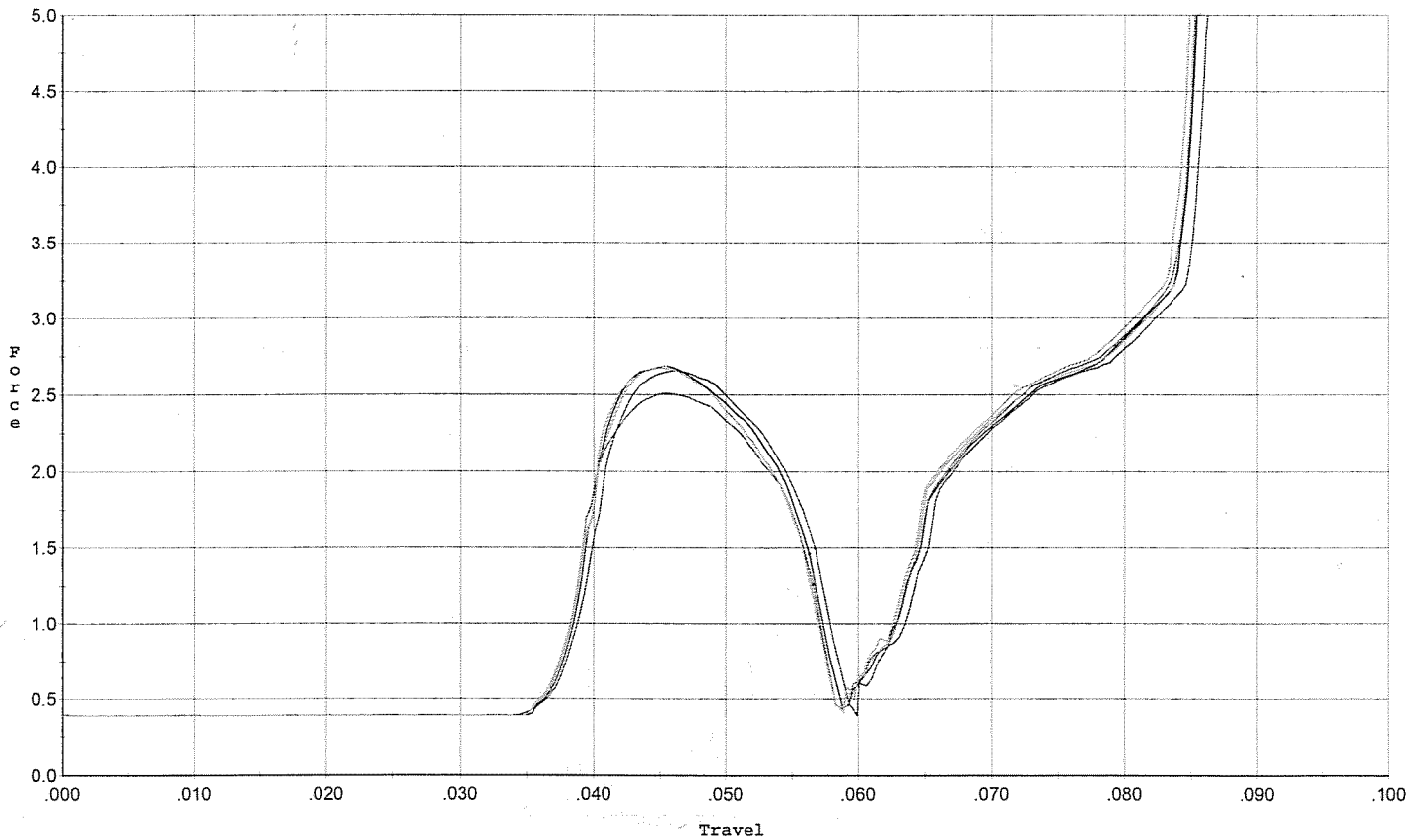
560	F) SAFETY ON FORCE	BARBER - M24 0069486 2 LBS MIN 10 LBS MAX	<u>3.0</u>	<u>4.0</u>	<u>3.0</u>	10-27-08	X J		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	10-27-08	J N.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.024</u>	<u>.024</u>	10-27-08	R J		
	J) ASSEMBLE STOCK					10-16-08	BSW		
	K) ASSEMBLE SWIVEL STUDS					10-27-08	X J		
	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		10-27-08	R J		
			<u>PASS</u>	FAIL		10-23-08	TC		
	MALFUNCTION	BAC	CORRECTION						
	MALFUNCTION		CORRECTION	N/A					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					10-23-08	BSW		
670	FINAL INSPECTION A) HEADSPACE					10-27-08	X J		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u>	<u>2.36</u>	<u>2.49</u>	<u>2.33</u>	<u>2.52</u>	10-27-08	BSW
	C) FUNCTION					10-27-08	X J		
690	PACK					10/29/08	FM		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



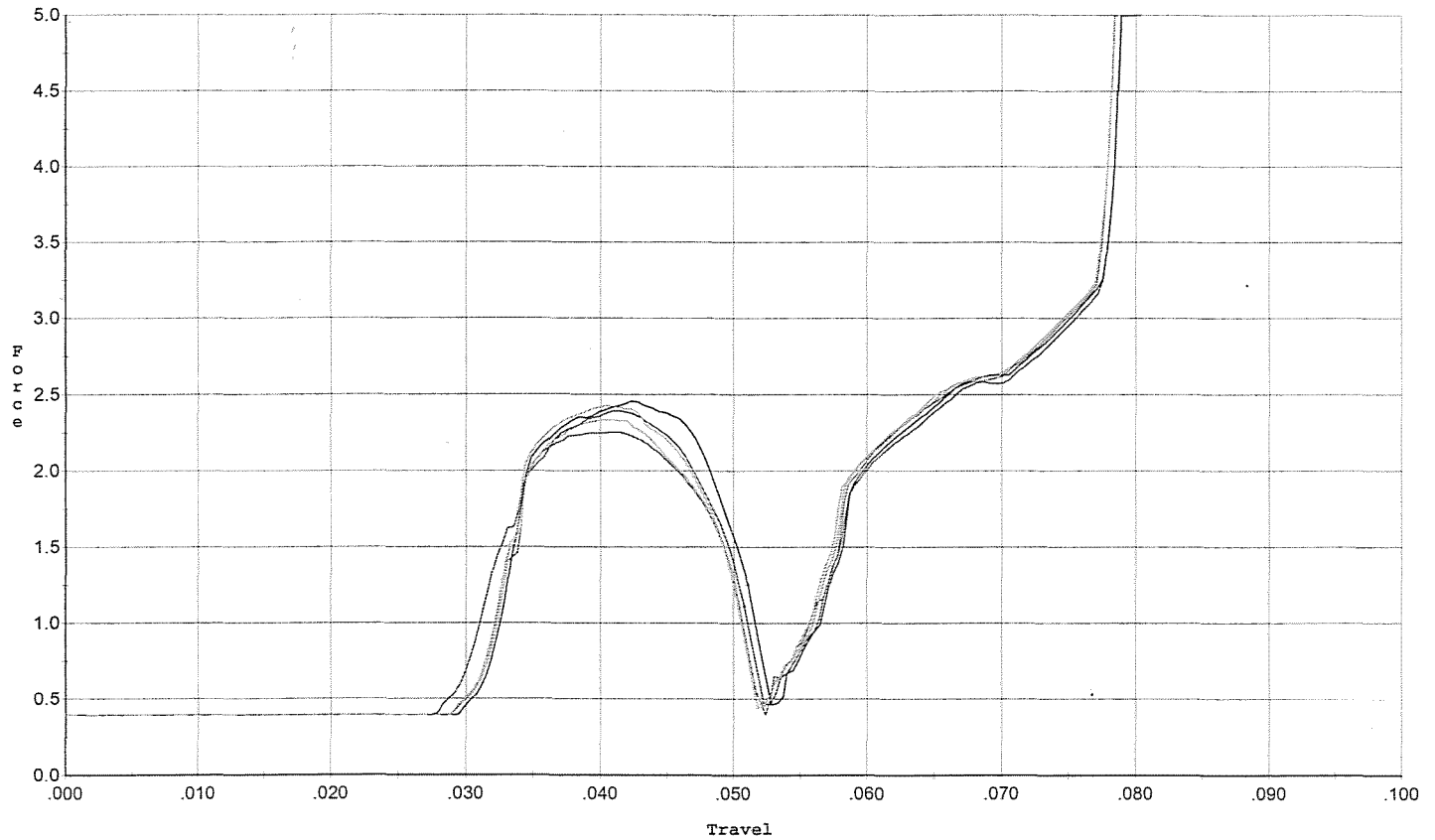
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.655	0.057	0.038	0.036	0.056		Set Trigger
2	2.687	0.056	0.036	0.036	0.056		Set Trigger
3	2.509	0.057	0.037	0.036	0.055		Set Trigger
4	2.674	0.057	0.037	0.036	0.056		Set Trigger
5	2.687	0.057	0.037	0.036	0.056		Set Trigger

A-2-64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



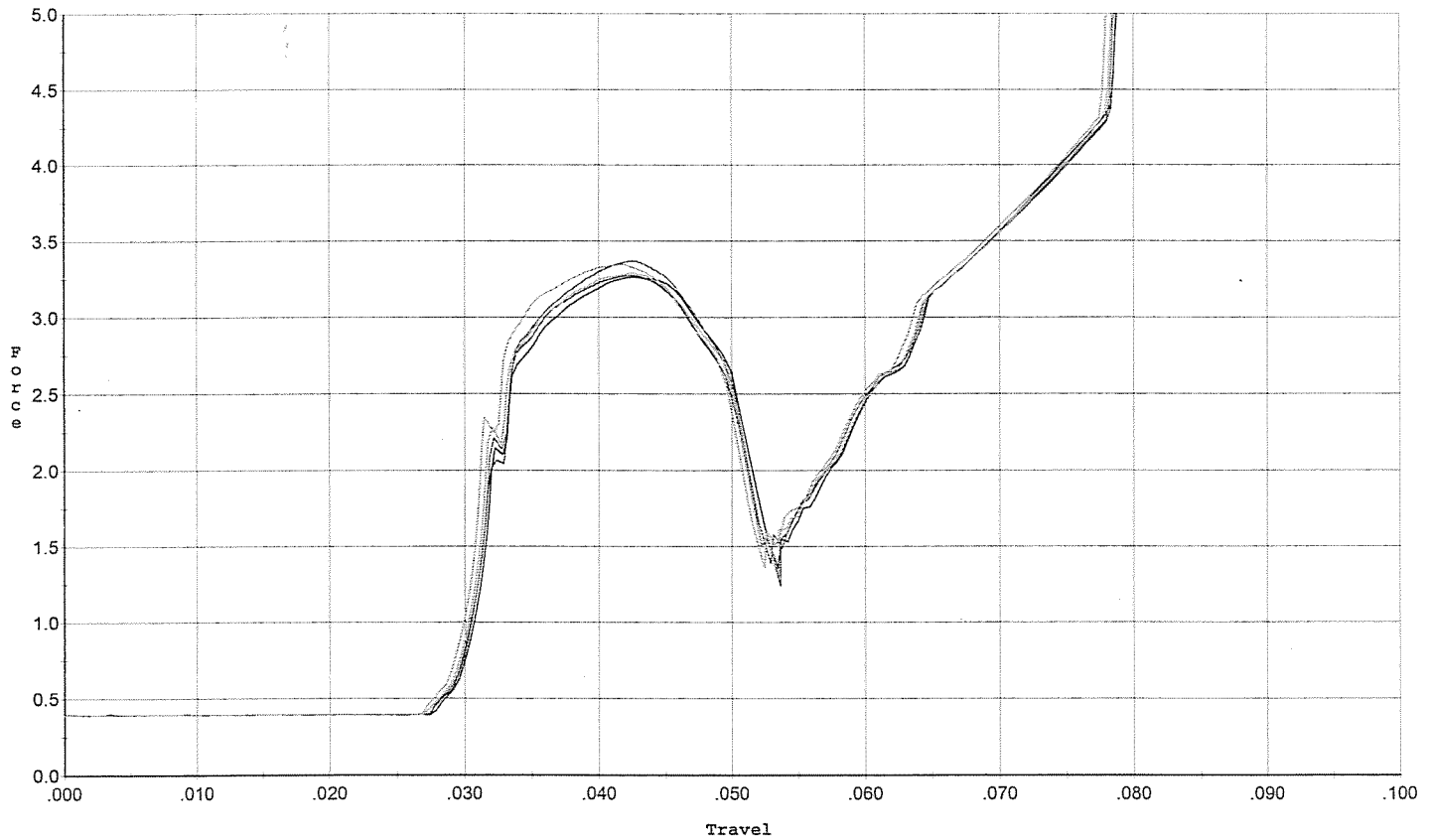
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.394	0.051	0.028	0.034	0.052		Set Trigger
2	2.455	0.051	0.031	0.034	0.053		Set Trigger
3	2.254	0.050	0.031	0.034	0.048		Set Trigger
4	2.336	0.050	0.031	0.034	0.049		Set Trigger
5	2.426	0.050	0.031	0.034	0.050		Set Trigger

A-237

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



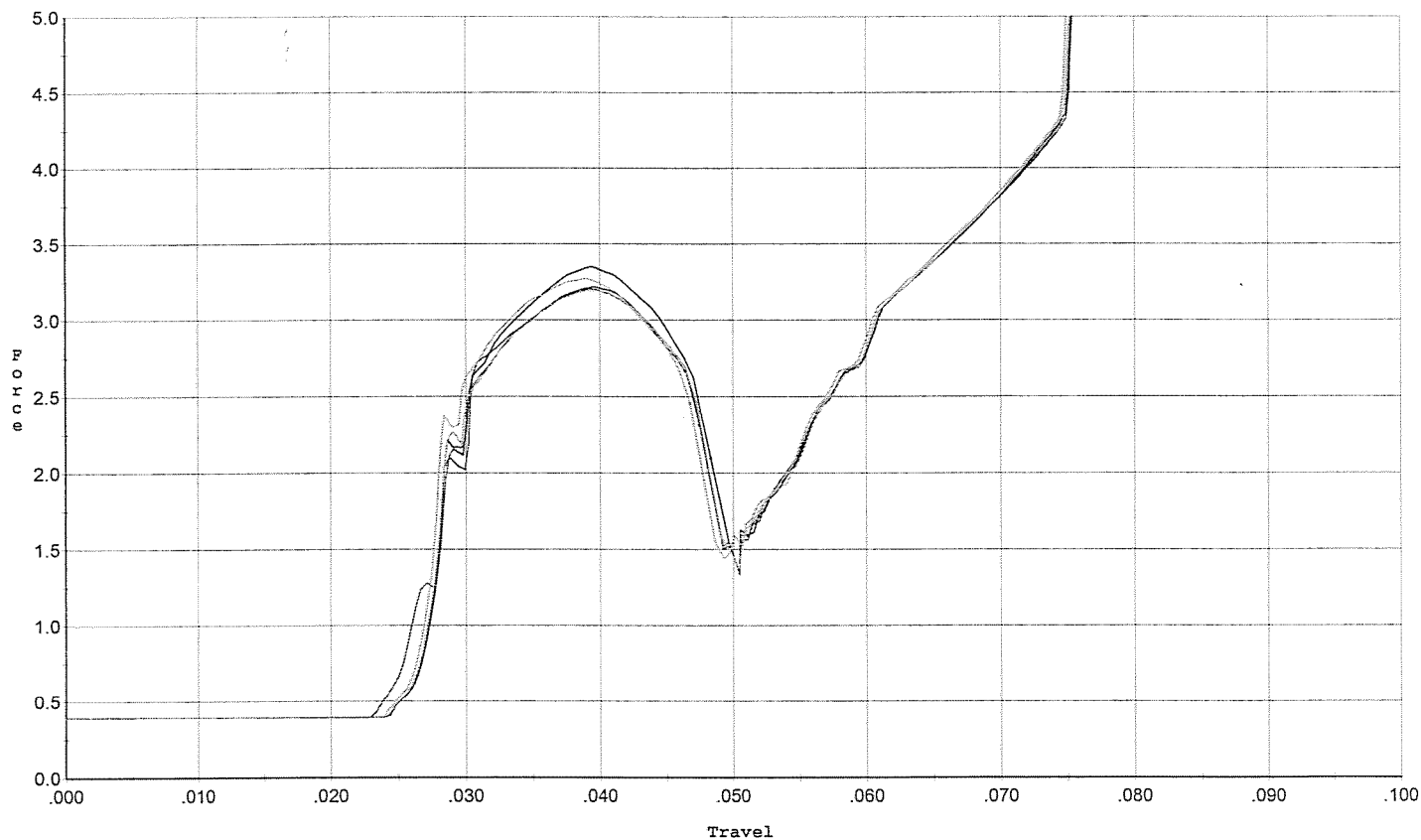
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.276	0.050	0.028	0.032	0.069		Set Trigger
2	3.264	0.050	0.028	0.032	0.069		Set Trigger
3	3.369	0.050	0.028	0.032	0.070		Set Trigger
4	3.292	0.050	0.029	0.032	0.070		Set Trigger
5	3.347	0.050	0.027	0.031	0.071		Set Trigger

A-3.31

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



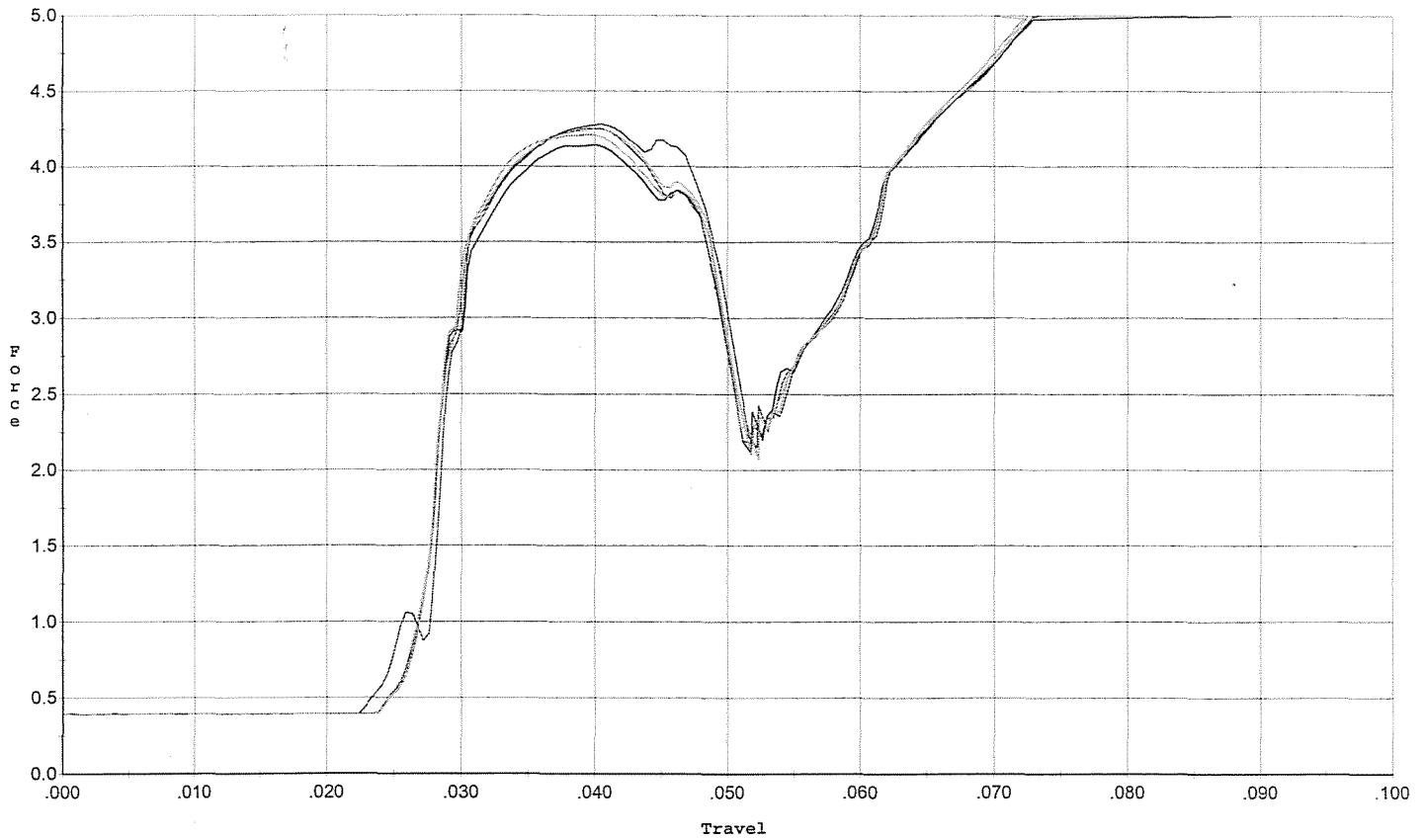
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.218	0.047	0.024	0.030	0.069		Set Trigger
2	3.352	0.048	0.025	0.030	0.071		Set Trigger
3	3.207	0.047	0.025	0.030	0.067		Set Trigger
4	3.195	0.047	0.025	0.030	0.068		Set Trigger
5	3.272	0.047	0.024	0.030	0.068		Set Trigger

A-3-24

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



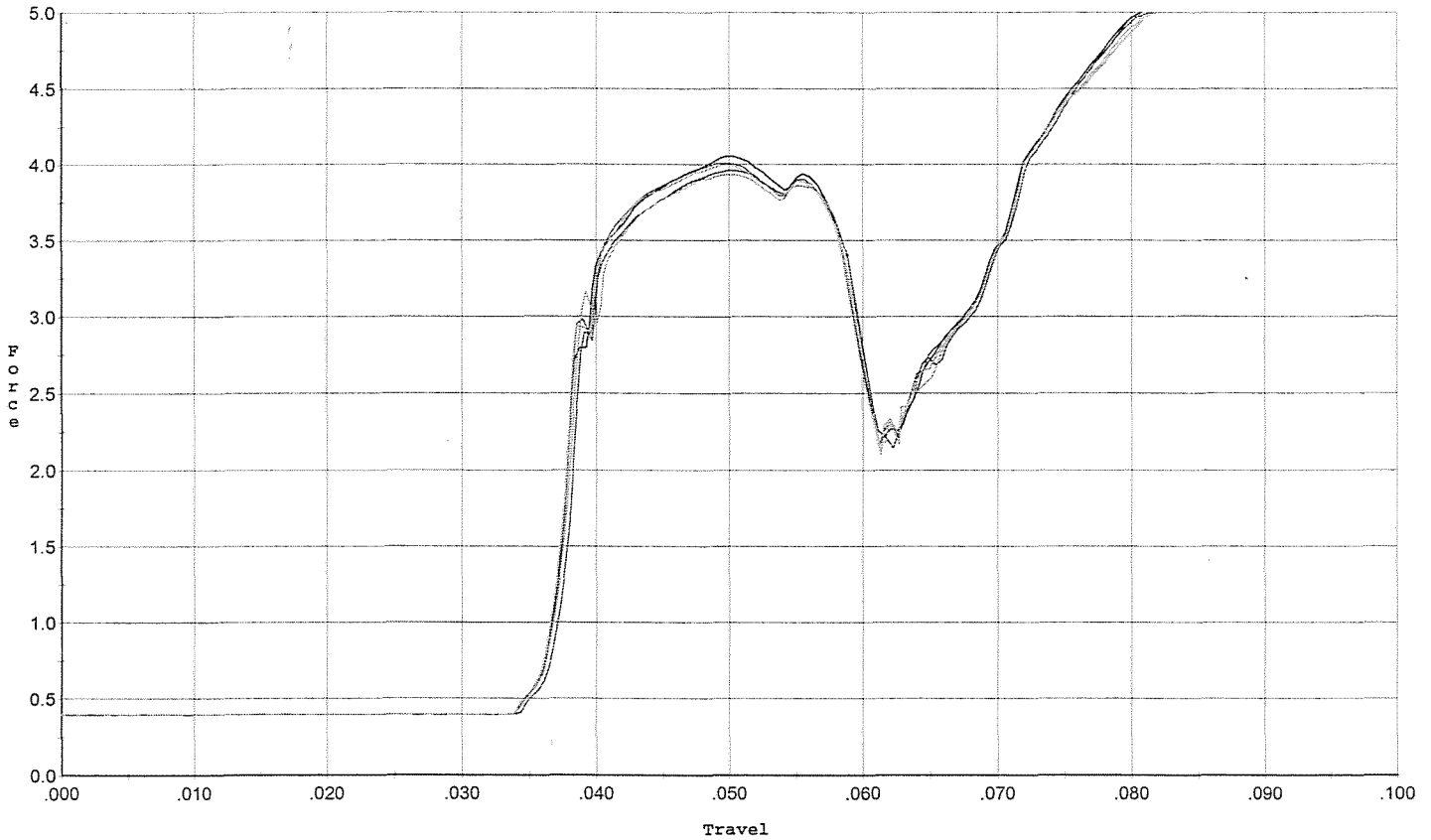
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.283	0.049	0.023	0.028	0.096		Set Trigger
2	4.140	0.049	0.024	0.028	0.092		Set Trigger
3	4.256	0.049	0.024	0.028	0.093		Set Trigger
4	4.253	0.048	0.024	0.028	0.093		Set Trigger
5	4.212	0.049	0.026	0.028	0.092		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



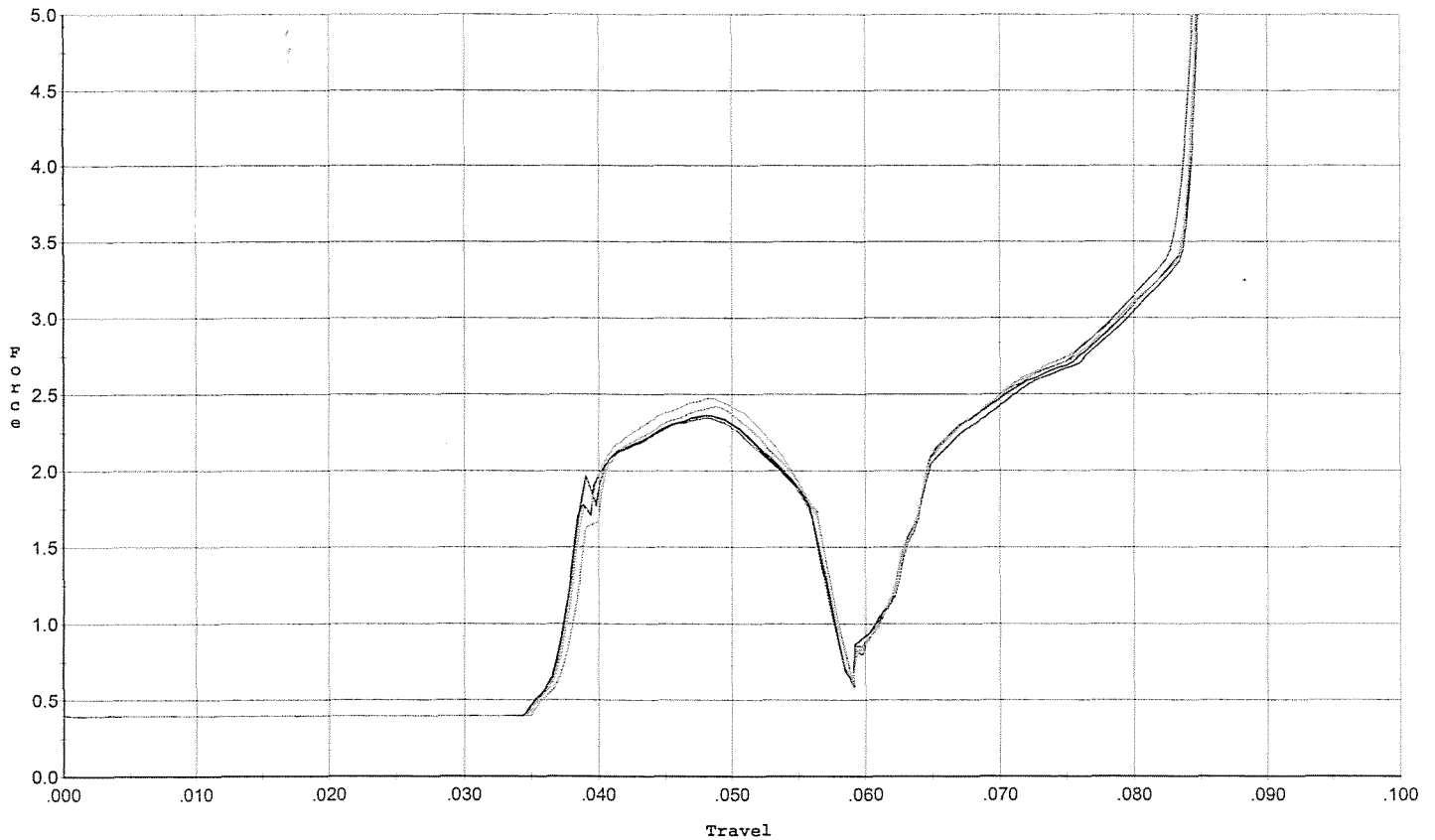
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.961	0.059	0.035	0.031	0.094		Set Trigger
2	4.055	0.058	0.034	0.031	0.094		Set Trigger
3	4.007	0.058	0.034	0.031	0.094		Set Trigger
4	3.998	0.058	0.034	0.031	0.094		Set Trigger
5	3.934	0.059	0.036	0.030	0.095		Set Trigger

A 3.99

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

Model: M/24
 Serial No: Form #F005
 Trigger: reset tot2.5 lbs. +/- .50 ls. for final test



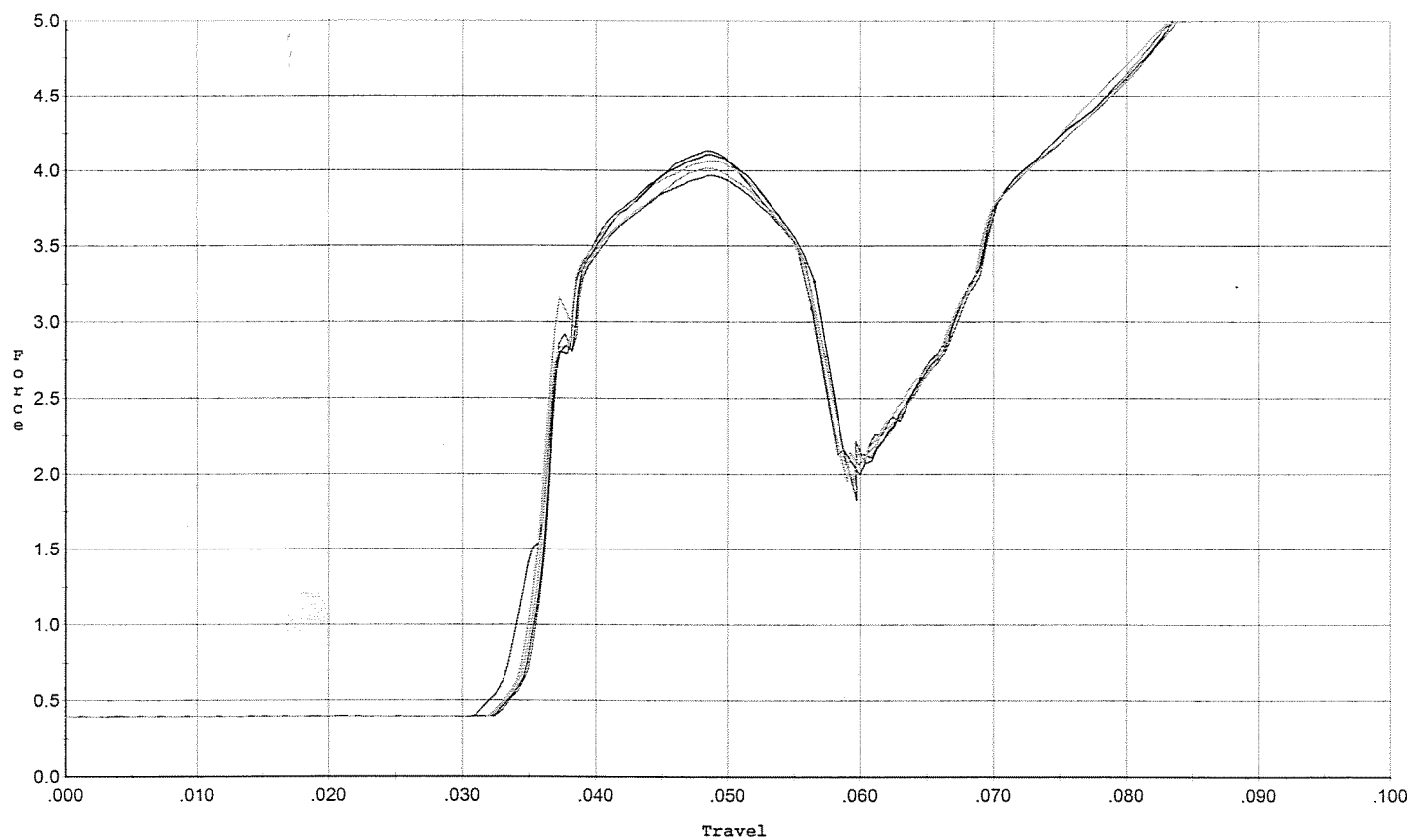
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.361	0.057	0.037	0.035	0.056		Set Trigger
2	2.362	0.057	0.037	0.035	0.056		Set Trigger
3	2.343	0.056	0.037	0.035	0.054		Set Trigger
4	2.474	0.056	0.035	0.035	0.056		Set Trigger
5	2.421	0.056	0.037	0.035	0.055		Set Trigger

A-2-39

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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	4.131	0.056	0.033	0.032	0.092		Set Trigger
2	4.108	0.057	0.035	0.031	0.091		Set Trigger
3	3.967	0.057	0.035	0.032	0.090		Set Trigger
4	4.068	0.057	0.034	0.031	0.093		Set Trigger
5	4.018	0.056	0.034	0.032	0.090		Set Trigger

A-4.05