

G6784735

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



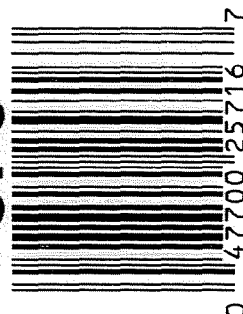
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6784735

UPC



GUN SERIAL # G6784735

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-9-08	SP
430	ASSEMBLE TO STOCK		9-9-08	SP
440	PROOF		9-9-08	SP
460	CHECK HEADSPACE		9-9-08	SP
470	DIS-ASSEMBLE ACTION		9-9-08	SP
472	SERIALIZE BOLT HANDLE		9-10-08	LTZ
475	DRILL AND TAP SIGHT HOLES		9-11-08	SP
480	MAGNAFLUX BBL ACTION		9-11-08	BA
490	MAGNAFLUX BOLT		9-9-08	MR
500	ROLLMARK CALIBER		9-12-08	RT
520	GOFF BLAST BBL / REC		9-13-08	TL
542	APPLY COATINGS (BARREL ACTION)		9-16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-20-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-20-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-20-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-12-08	BSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

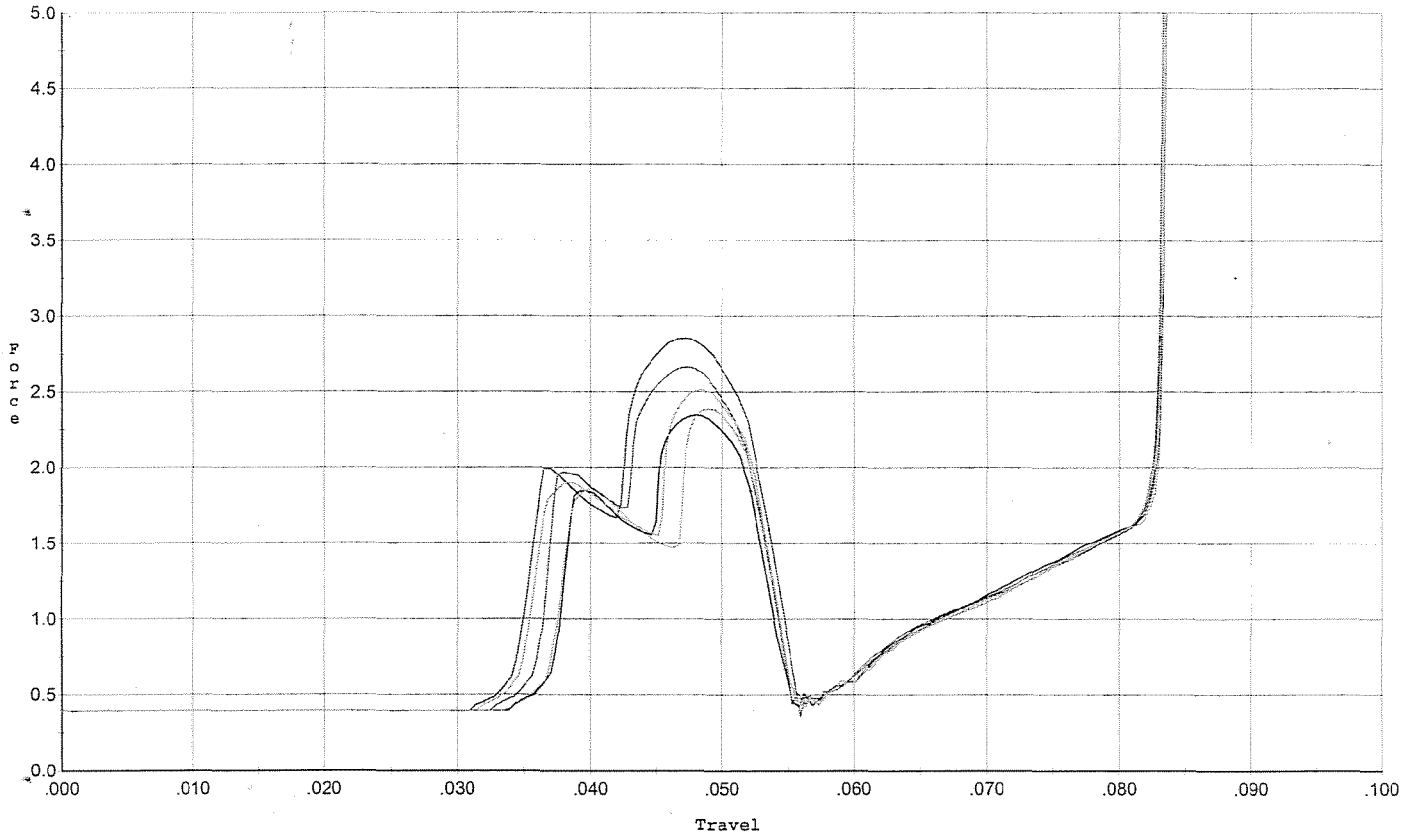
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0069645 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>3.5</u>	11-18-08	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-18-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-18-08	R.N.
	J) ASSEMBLE STOCK		11-12-08	Rsn
	K) ASSEMBLE SWIVEL STUDS		11-18-08	L.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 <u>PASS</u> FAIL	11-13-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-13-08	JS
670	FINAL INSPECTION A) HEADSPACE		11-18-08	R.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.16</u> <u>2.18</u> <u>2.19</u> <u>2.15</u> <u>2.18</u>	11-14-08	TC
	C) FUNCTION		11-18-08	L.N.
690	PACK		12-2-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



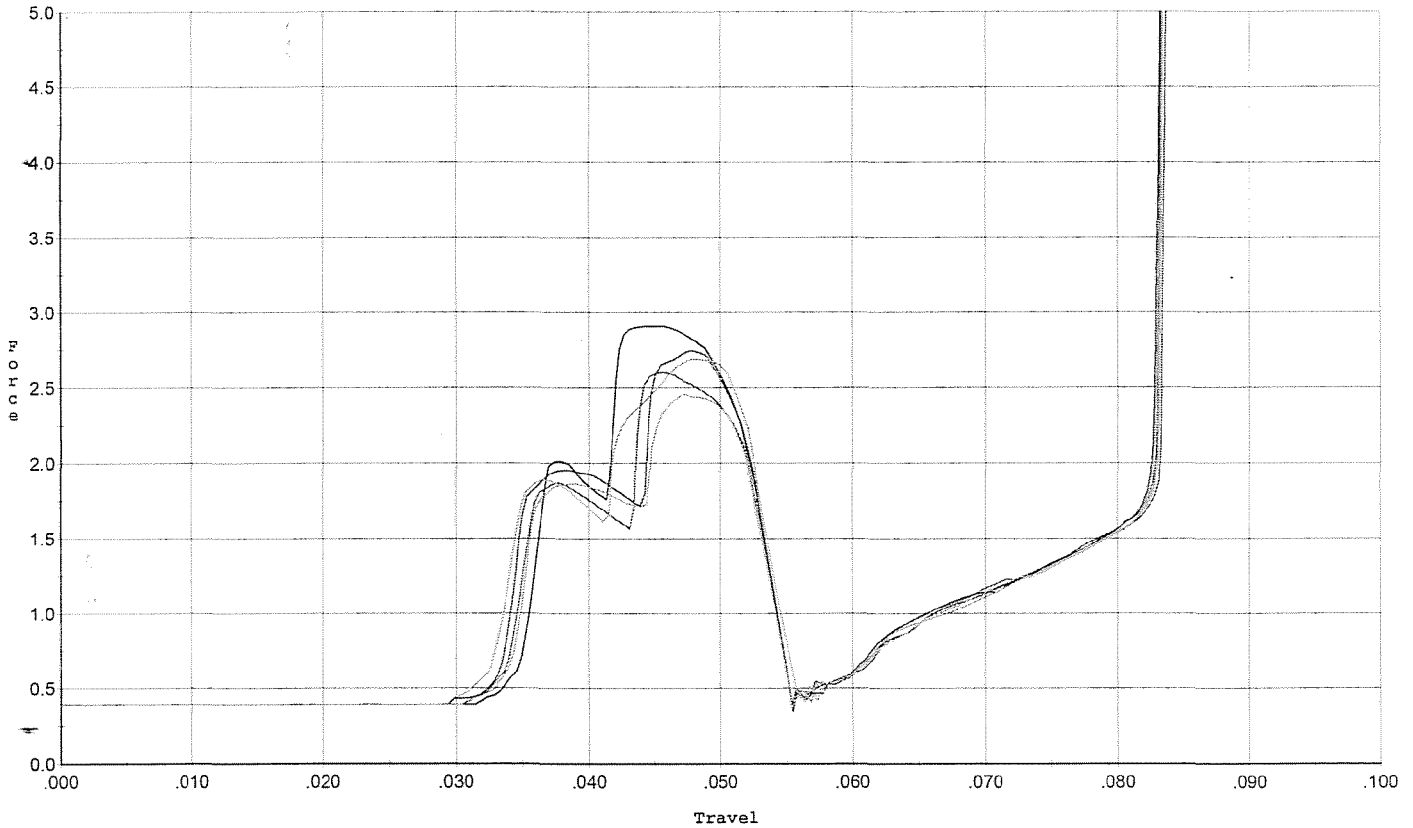
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.855	0.054	0.034	0.035	0.056		Set Trigger
2	2.344	0.052	0.037	0.037	0.044		Set Trigger
3	2.665	0.053	0.036	0.036	0.051		Set Trigger
4	2.511	0.053	0.034	0.036	0.049		Set Trigger
5	2.385	0.053	0.037	0.037	0.044		Set Trigger

A-255

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



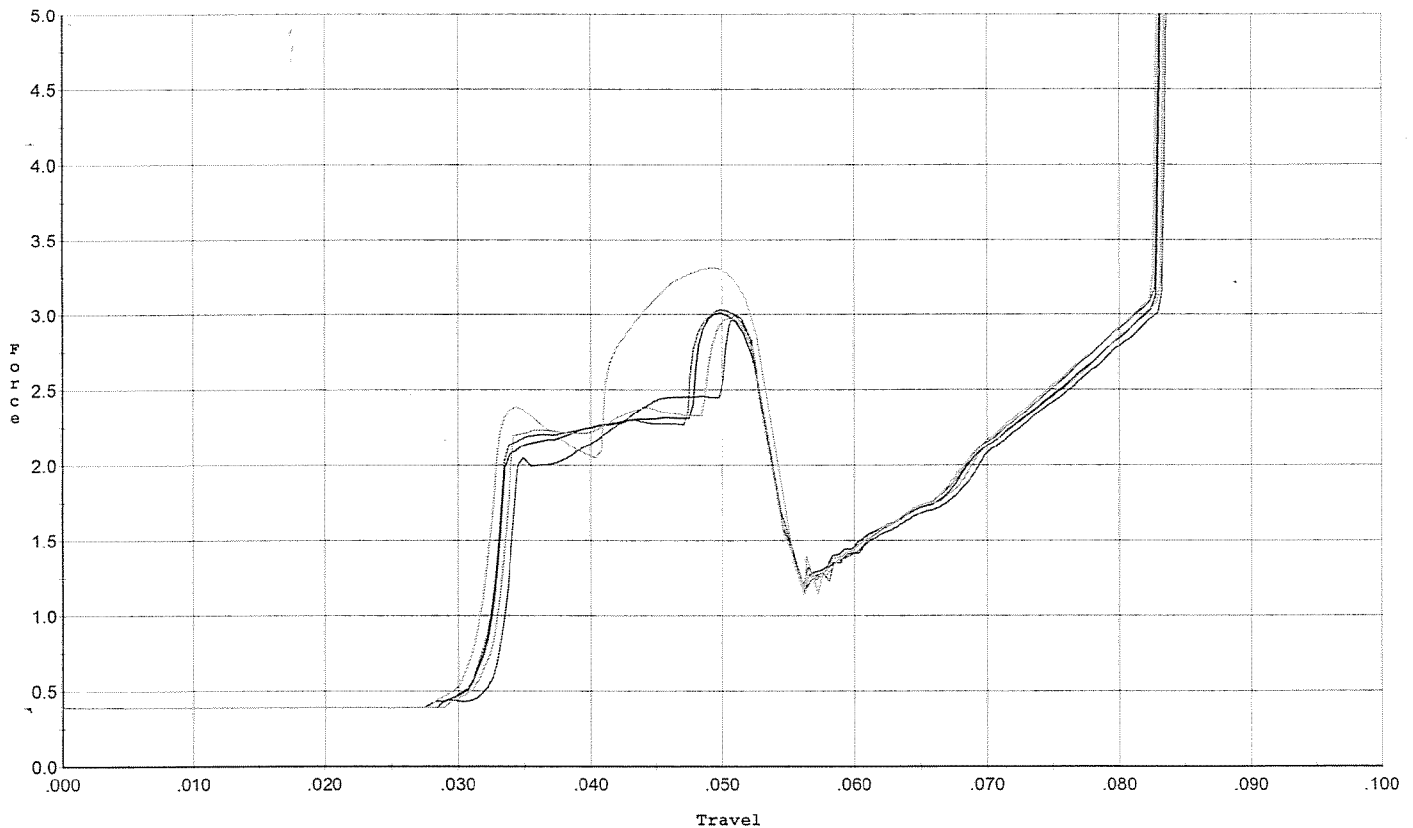
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.745	0.053	0.033	0.035	0.054		Set Trigger
2	2.911	0.053	0.035	0.036	0.056		Set Trigger
3	2.605	0.053	0.034	0.035	0.052		Set Trigger
4	2.692	0.052	0.033	0.035	0.055		Set Trigger
5	2.458	0.053	0.034	0.035	0.051		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



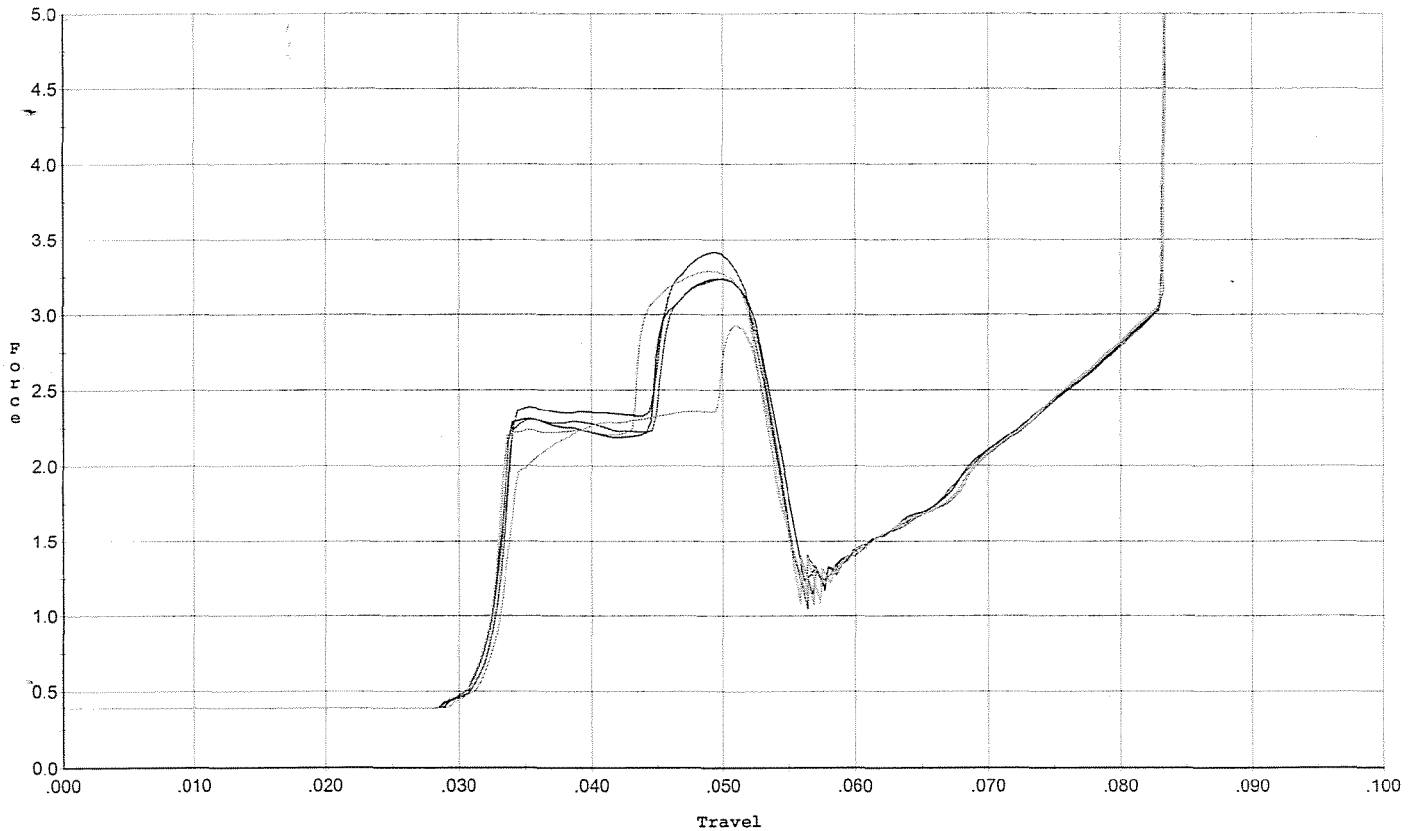
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.003	0.052	0.033	0.034	0.059		Set Trigger
2	3.008	0.052	0.031	0.033	0.062		Set Trigger
3	3.035	0.052	0.031	0.033	0.062		Set Trigger
4	3.313	0.053	0.031	0.033	0.070		Set Trigger
5	2.972	0.052	0.032	0.034	0.061		Set Trigger

A-3.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



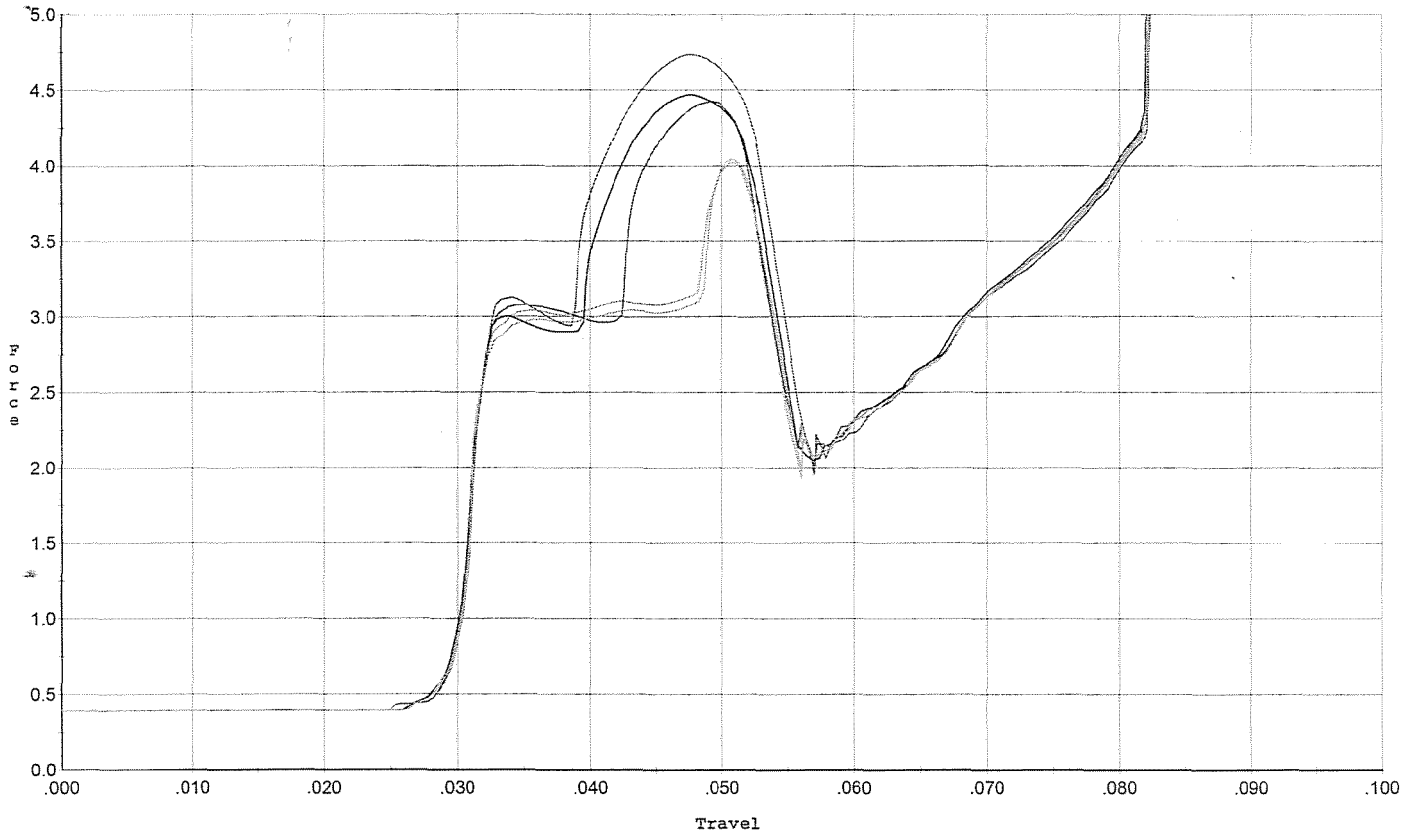
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.418	0.053	0.032	0.034	0.068		Set Trigger
2	3.237	0.054	0.031	0.033	0.069		Set Trigger
3	3.239	0.053	0.031	0.033	0.066		Set Trigger
4	2.931	0.054	0.032	0.034	0.061		Set Trigger
5	3.293	0.052	0.031	0.033	0.066		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



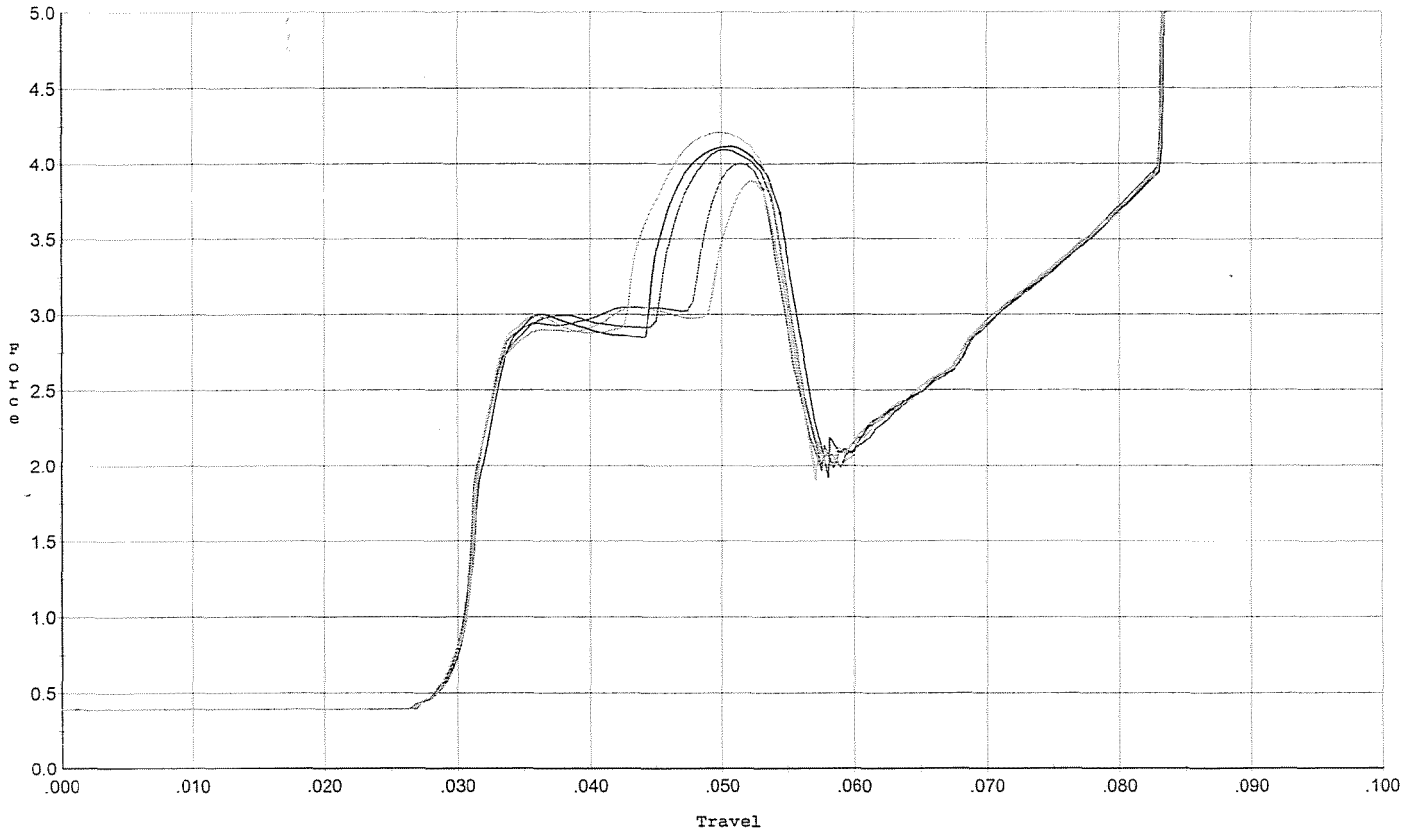
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.426	0.052	0.029	0.031	0.089		Set Trigger
2	4.470	0.053	0.029	0.031	0.095		Set Trigger
3	4.734	0.053	0.029	0.031	0.100		Set Trigger
4	4.046	0.054	0.029	0.031	0.085		Set Trigger
5	4.025	0.052	0.029	0.031	0.083		Set Trigger

A-434

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



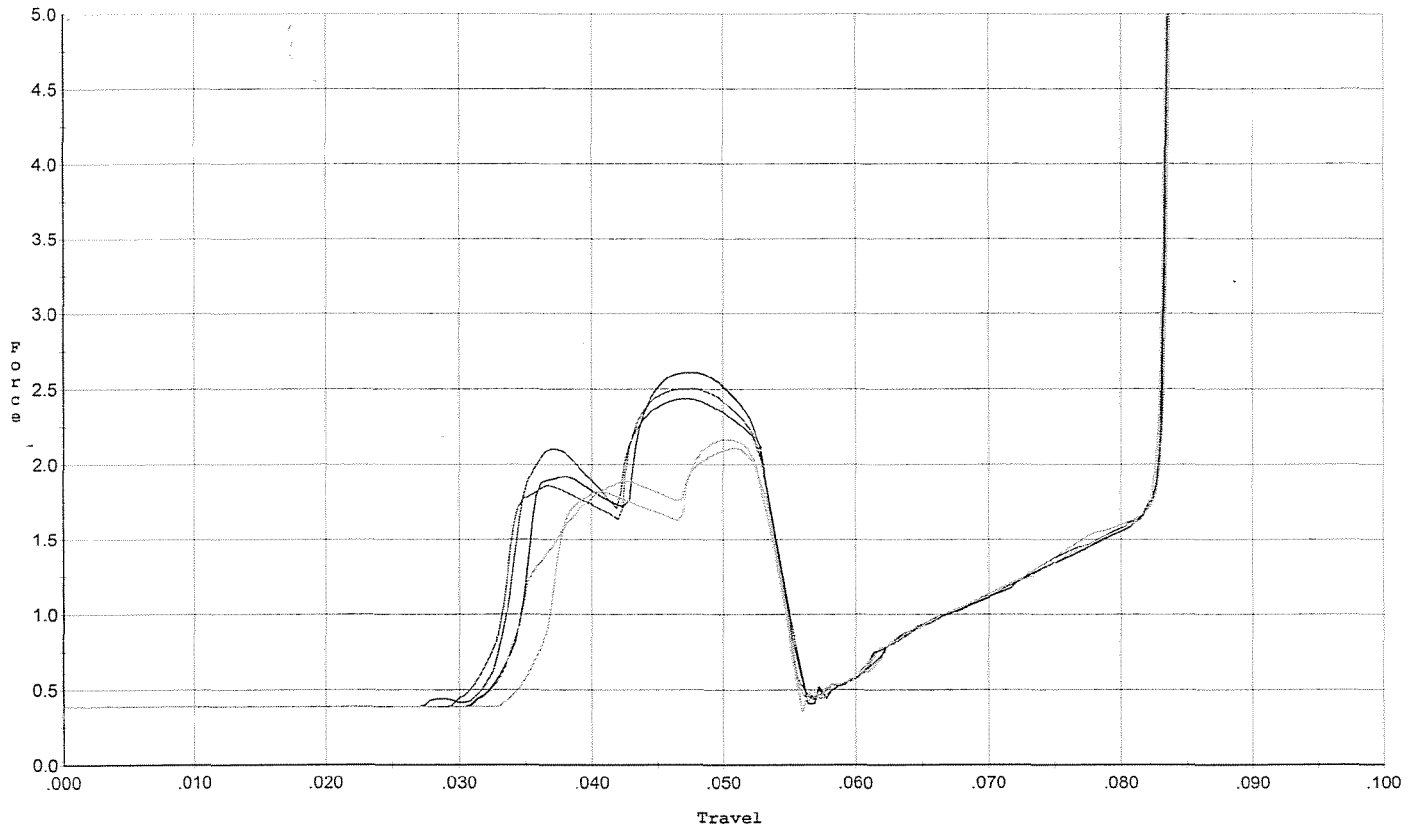
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.095	0.054	0.029	0.031	0.089		Set Trigger
2	4.115	0.054	0.030	0.031	0.091		Set Trigger
3	4.001	0.053	0.029	0.031	0.085		Set Trigger
4	4.209	0.054	0.029	0.031	0.091		Set Trigger
5	3.883	0.055	0.030	0.031	0.086		Set Trigger

A-4.06

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



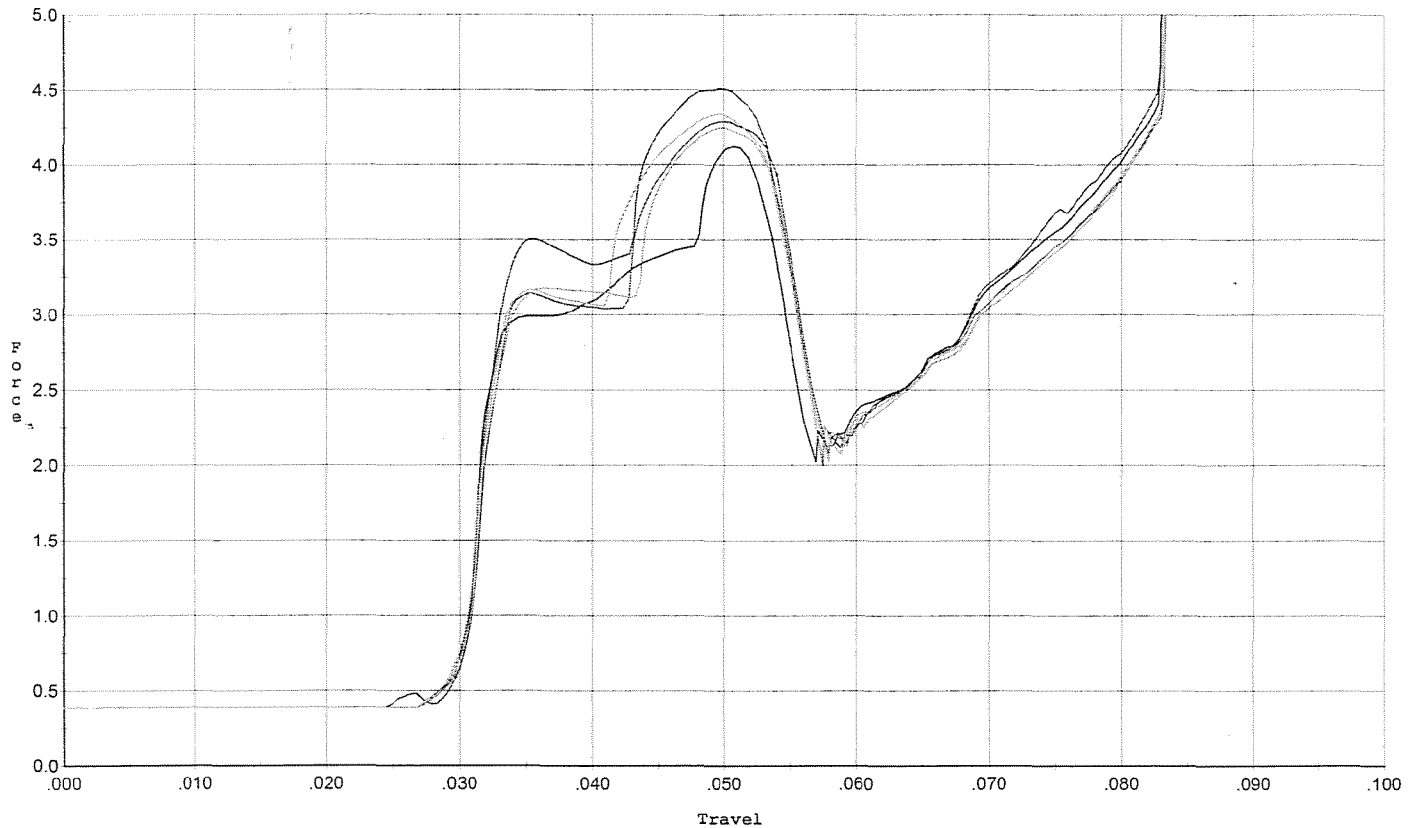
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.053	0.032	0.035	0.055		Set Trigger
2	2.611	0.053	0.033	0.035	0.054		Set Trigger
3	2.502	0.053	0.032	0.034	0.055		Set Trigger
4	2.166	0.054	0.035	0.036	0.046		Set Trigger
5	2.108	0.053	0.033	0.036	0.048		Set Trigger

A-236

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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	4.512	0.055	0.029	0.031	0.102		Set Trigger
2	4.123	0.054	0.030	0.031	0.089		Set Trigger
3	4.289	0.054	0.030	0.031	0.095		Set Trigger
4	4.342	0.055	0.030	0.031	0.099		Set Trigger
5	4.247	0.054	0.030	0.031	0.095		Set Trigger

A-430