

66794615

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



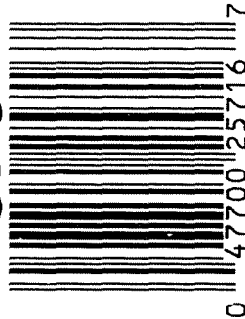
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794615

UPC



GUN SERIAL #

G6794615

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE		10-28-08	RSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/24/08	SP
490	MAGNAFLUX BOLT		10/27/08	MR
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC		10/30/08	DS
542	APPLY COATINGS (BARREL ACTION)		11/3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-5-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	RSN
	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>2.5</u> <u>2.5</u> <u>3.0</u>	11-18-08	LD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-18-08	LD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	11-18-08	LD
	J) ASSEMBLE STOCK		11-10-08	BSW
	K) ASSEMBLE SWIVEL STUDS		11-18-08	LD
	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	11-12-08	LD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-12-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-13-08	LD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.34</u> <u>2.31</u> <u>2.33</u> <u>2.30</u>	11-14-08	TC
	C) FUNCTION		11-18-08	LD
690	PACK		12-2-08	TC

F004-REV 5/2006

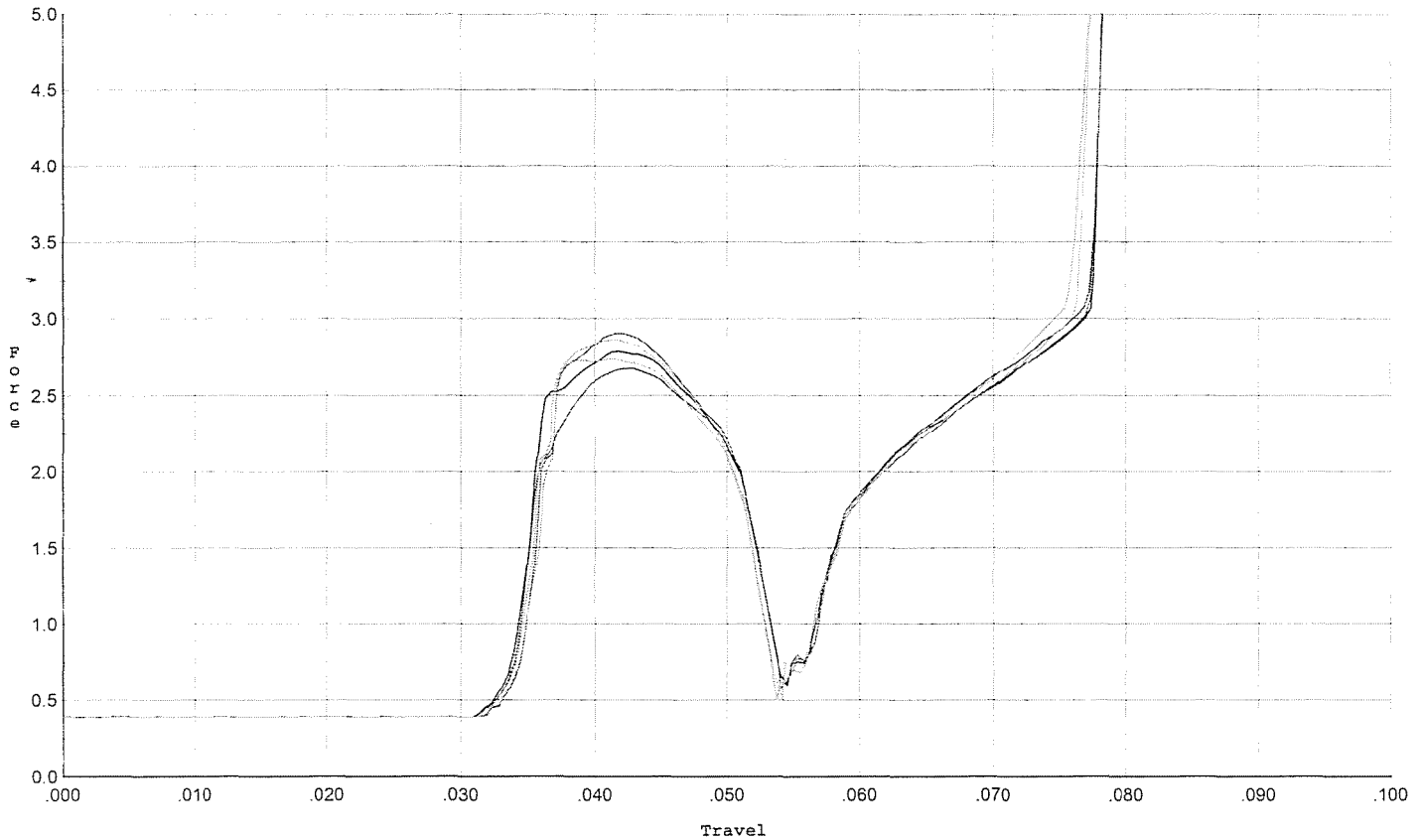
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0073639

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



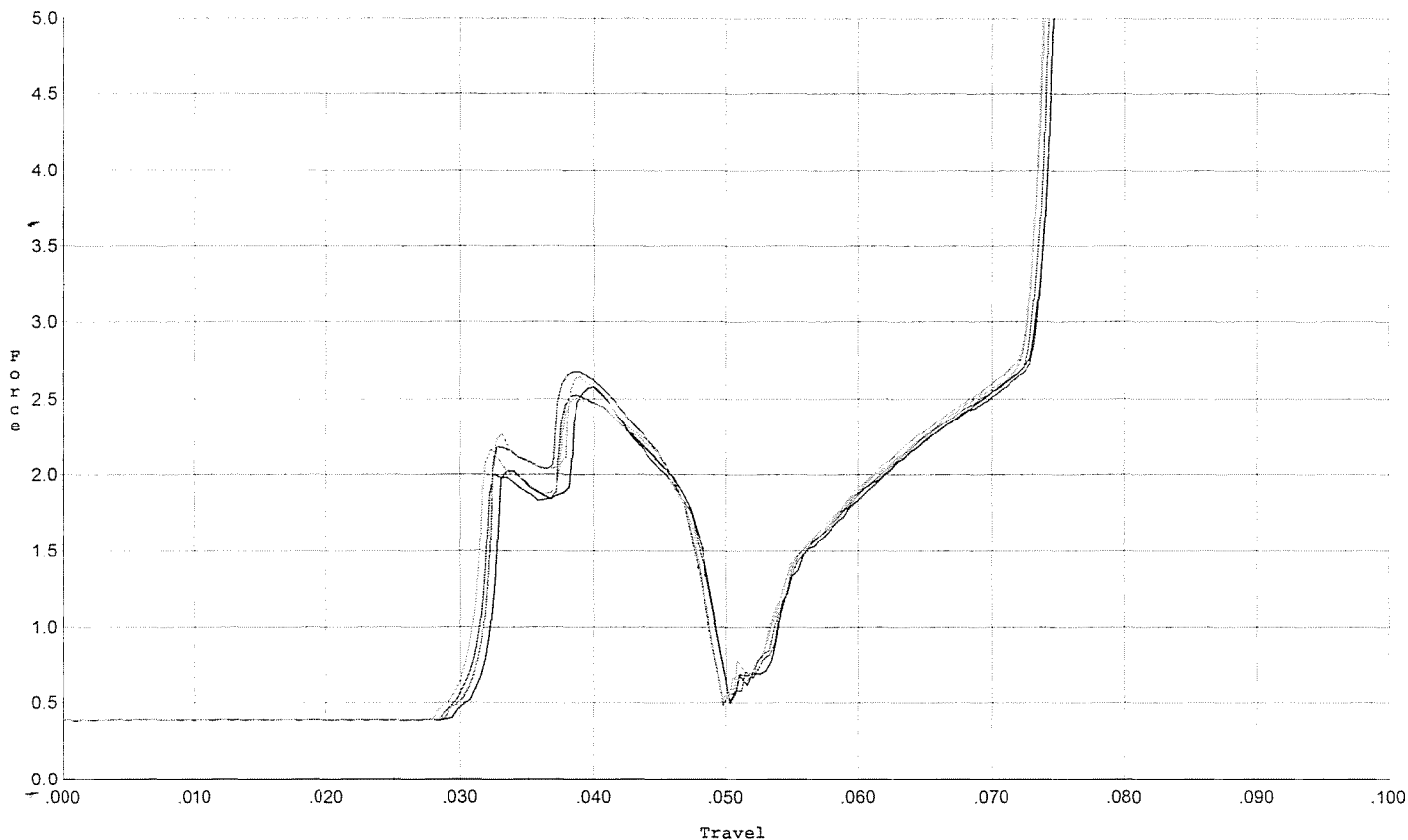
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.678	0.052	0.034	0.033	0.055		Set Trigger
2	2.790	0.052	0.033	0.033	0.057		Set Trigger
3	2.904	0.052	0.033	0.033	0.057		Set Trigger
4	2.862	0.051	0.034	0.032	0.056		Set Trigger
5	2.742	0.051	0.033	0.032	0.054		Set Trigger

A-279

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



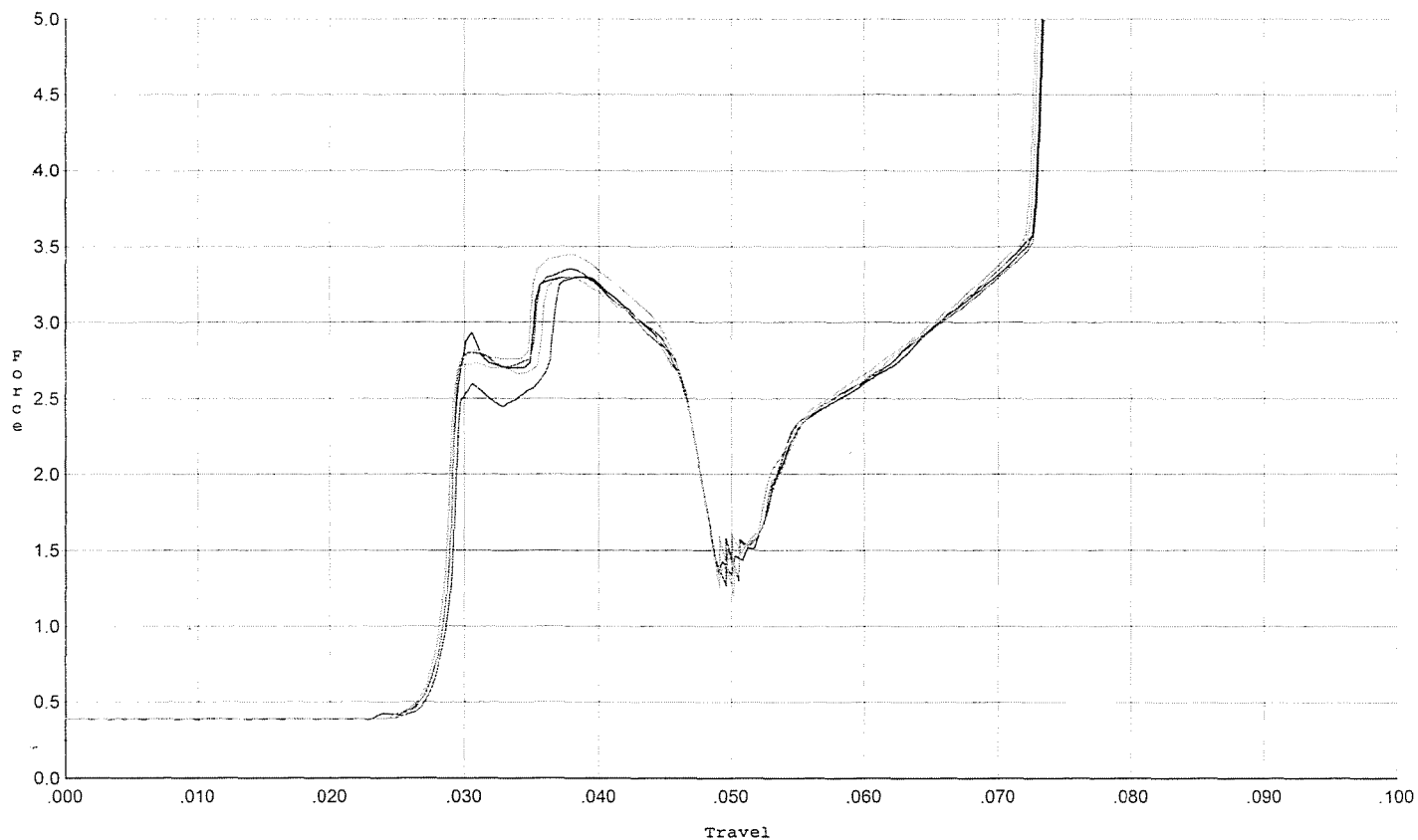
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.524	0.048	0.030	0.032	0.048		Set Trigger
2	2.575	0.048	0.030	0.032	0.046		Set Trigger
3	2.677	0.048	0.029	0.032	0.048		Set Trigger
4	2.506	0.048	0.030	0.031	0.048		Set Trigger
5	2.647	0.048	0.029	0.032	0.048		Set Trigger

A-258

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



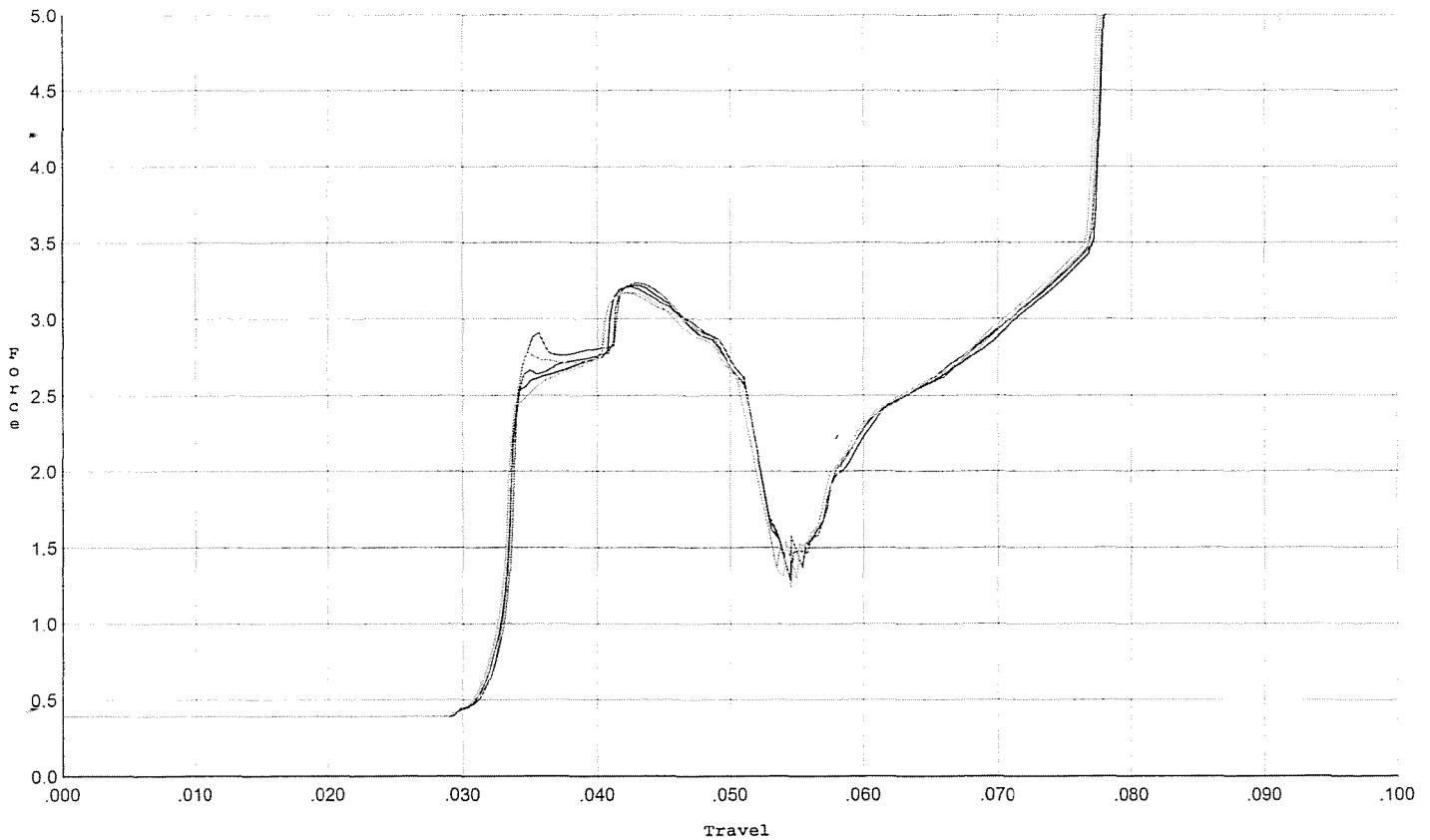
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.303	0.047	0.027	0.029	0.062		Set Trigger
2	3.301	0.047	0.027	0.029	0.065		Set Trigger
3	3.355	0.047	0.027	0.029	0.065		Set Trigger
4	3.303	0.047	0.027	0.029	0.065		Set Trigger
5	3.450	0.047	0.028	0.029	0.066		Set Trigger

A 3-34

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



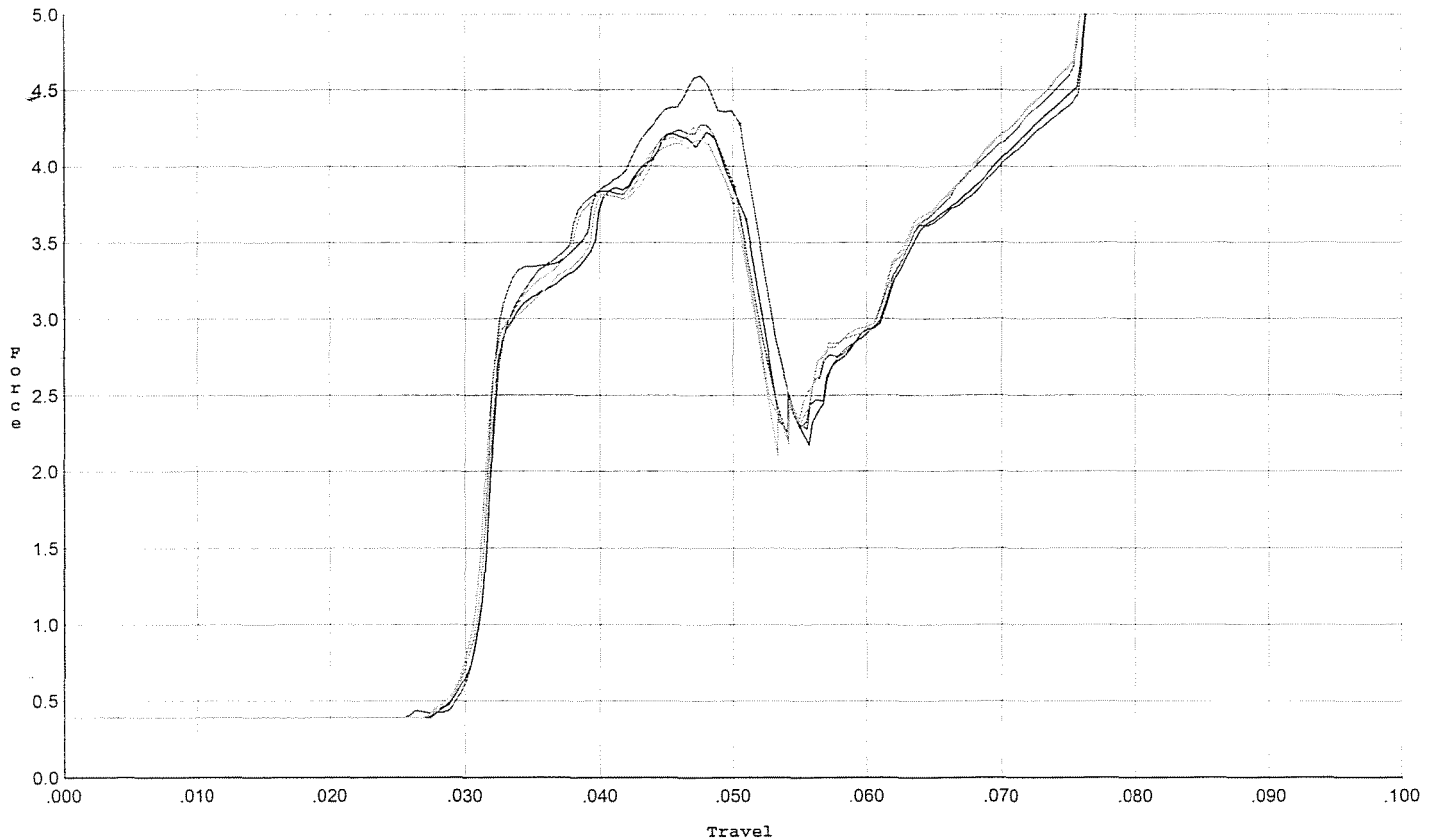
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.212	0.051	0.032	0.032	0.065		Set Trigger
2	3.220	0.051	0.032	0.032	0.065		Set Trigger
3	3.236	0.051	0.032	0.032	0.066		Set Trigger
4	3.174	0.051	0.031	0.032	0.065		Set Trigger
5	3.171	0.051	0.031	0.032	0.065		Set Trigger

A-3-20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/14/2008

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



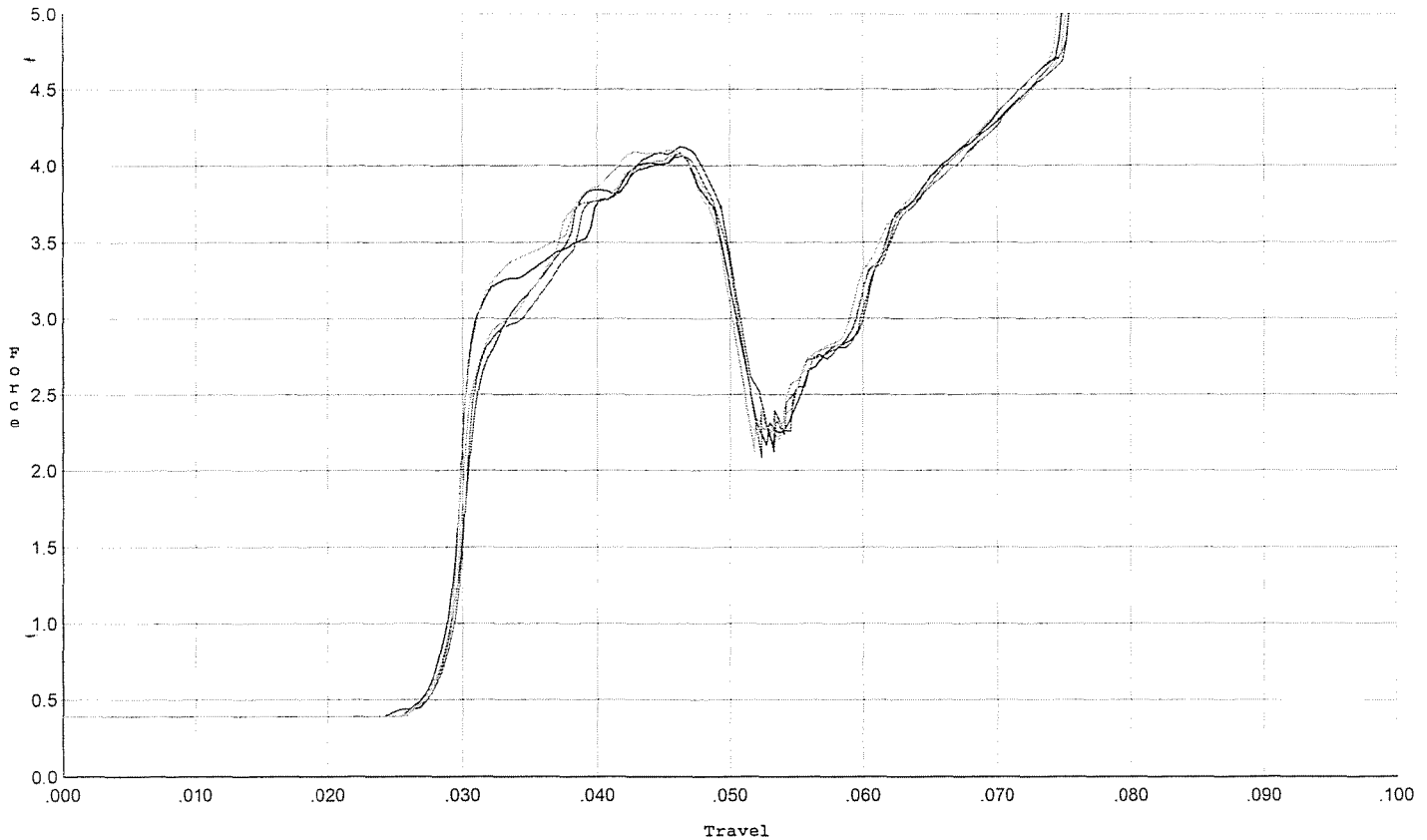
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.593	0.050	0.030	0.029	0.089		Set Trigger
2	4.226	0.051	0.029	0.029	0.085		Set Trigger
3	4.272	0.050	0.029	0.029	0.085		Set Trigger
4	4.177	0.050	0.030	0.029	0.083		Set Trigger
5	4.253	0.051	0.030	0.029	0.086		Set Trigger

A-430

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



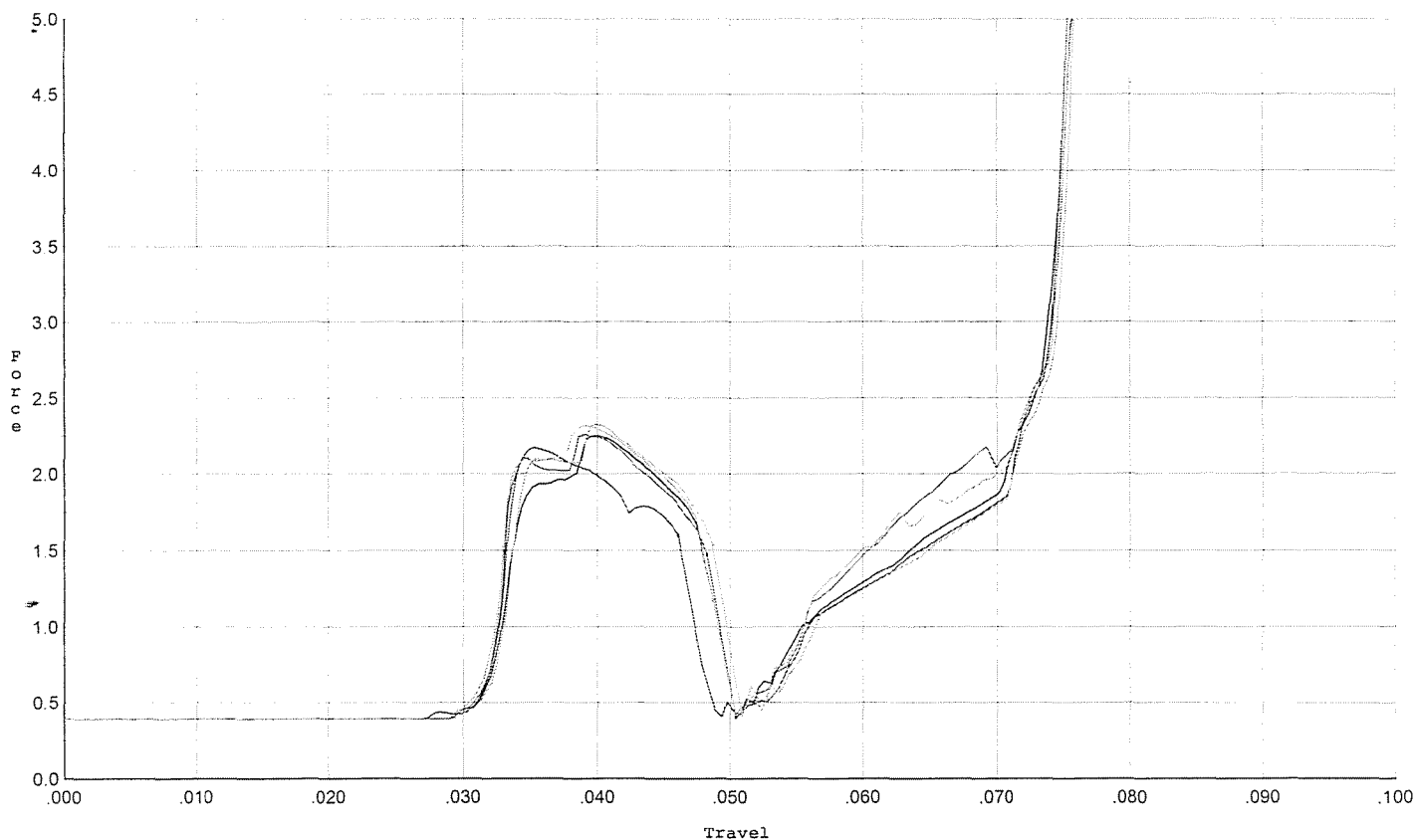
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.123	0.049	0.028	0.029	0.084		Set Trigger
2	4.084	0.049	0.028	0.029	0.083		Set Trigger
3	4.060	0.050	0.028	0.029	0.083		Set Trigger
4	4.105	0.049	0.028	0.029	0.085		Set Trigger
5	4.074	0.049	0.028	0.029	0.082		Set Trigger

A-4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



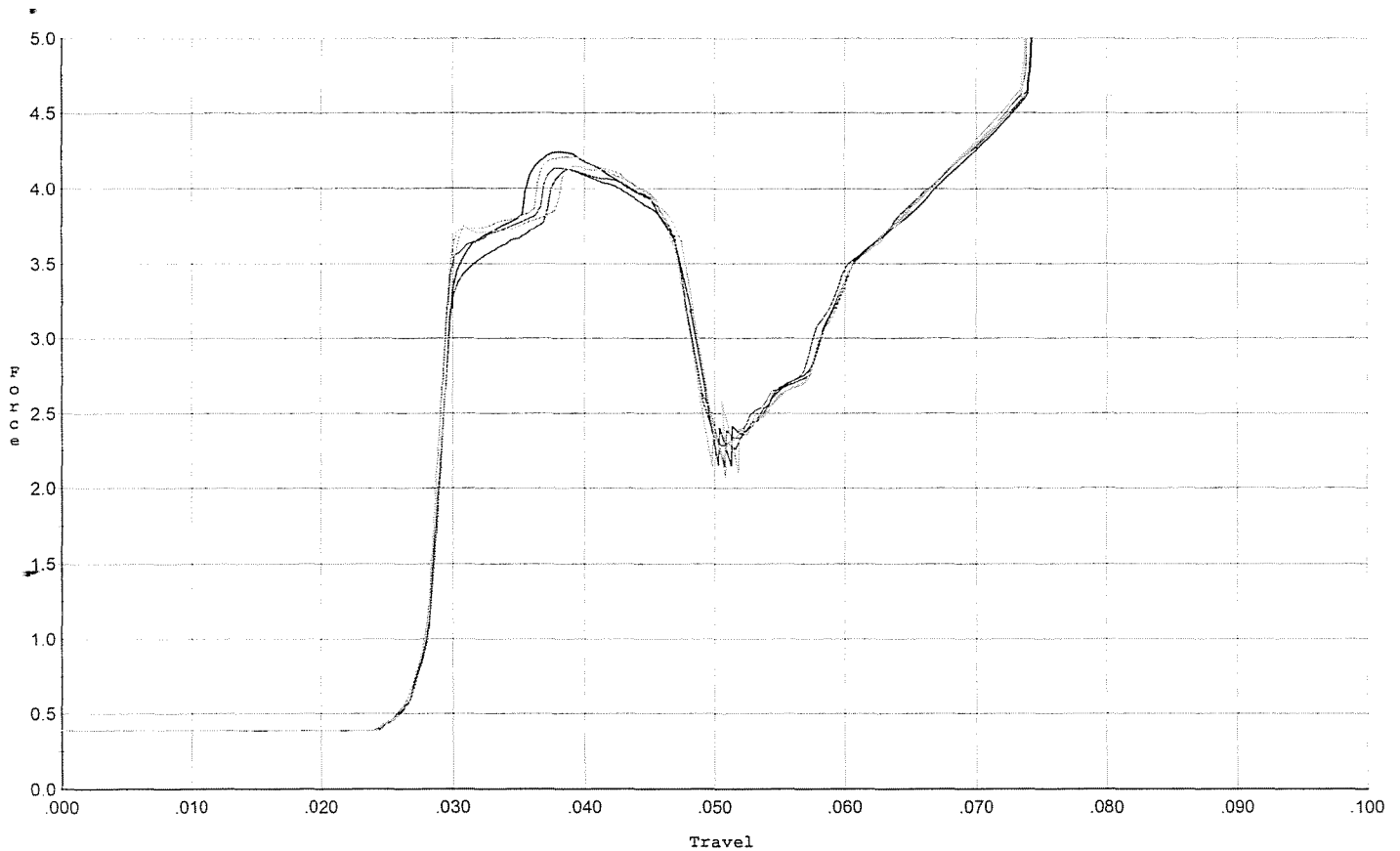
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.171	0.046	0.031	0.034	0.040		Set Trigger
2	2.250	0.049	0.032	0.033	0.044		Set Trigger
3	2.261	0.048	0.031	0.033	0.044		Set Trigger
4	2.318	0.049	0.032	0.033	0.045		Set Trigger
5	2.328	0.049	0.031	0.033	0.046		Set Trigger

A-2.26

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/14/2008

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.129	0.047	0.027	0.029	0.082		Set Trigger
2	4.241	0.048	0.027	0.029	0.087		Set Trigger
3	4.136	0.047	0.027	0.028	0.084		Set Trigger
4	4.149	0.047	0.027	0.028	0.085		Set Trigger
5	4.211	0.047	0.027	0.028	0.085		Set Trigger

A-4.17