

G6794794

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



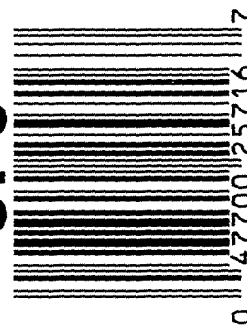
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794794

UPC



GUN SERIAL #

G 6794794

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RT
430	ASSEMBLE TO STOCK		3-6-09	RT
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE		3-6-09	RT
475	DRILL AND TAP SIGHT HOLES		3-6-09	JP
480	MAGNAFLUX BBL ACTION	(48)	3/9/09	(P)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	no
542	APPLY COATINGS (BARREL ACTION)		5-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	L N.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

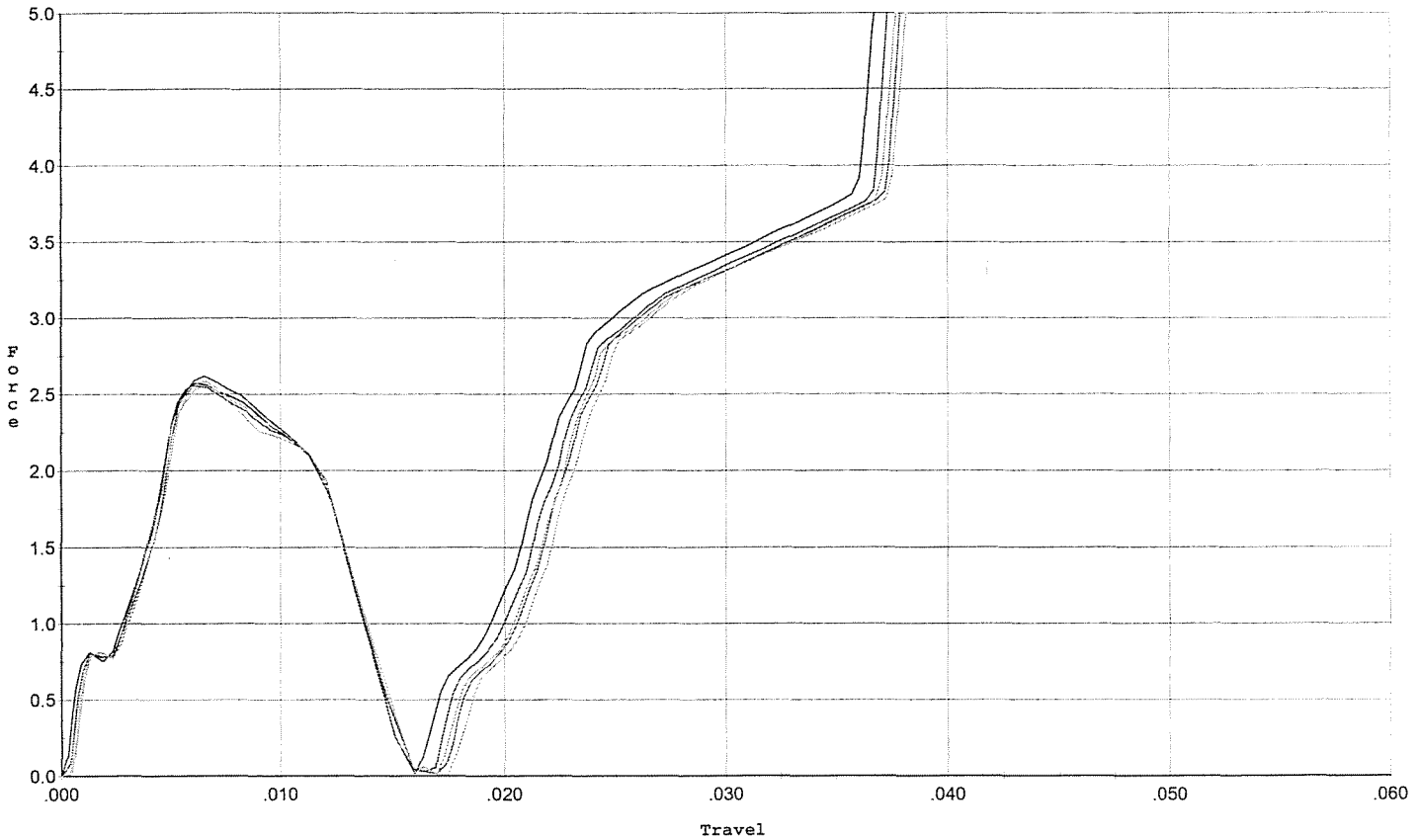
BARBER - M24 0075532		2 LBS MIN 10 LBS MAX	<u>5.5</u>	<u>5.5</u>	<u>5.5</u>	3-25-09	WV		
560	F) SAFETY ON FORCE								
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4</u>	<u>4</u>	<u>4</u>	3-25-09	WV		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.023</u>	<u>.024</u>	3-25-09	WV		
	J) ASSEMBLE STOCK					3-23-09	RJ		
	K) ASSEMBLE SWIVEL STUDS					3-27-09	RJ		
	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		3-24-09	TL		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					3-24-09	WV		
670	FINAL INSPECTION A) HEADSPACE					3-25-09	WV		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u>	<u>2.77</u>	<u>2.72</u>	<u>2.59</u>	<u>2.70</u>	3-24-09	TL
	C) FUNCTION					3-25-09	WV		
690	PACK					3-25-09	FM		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



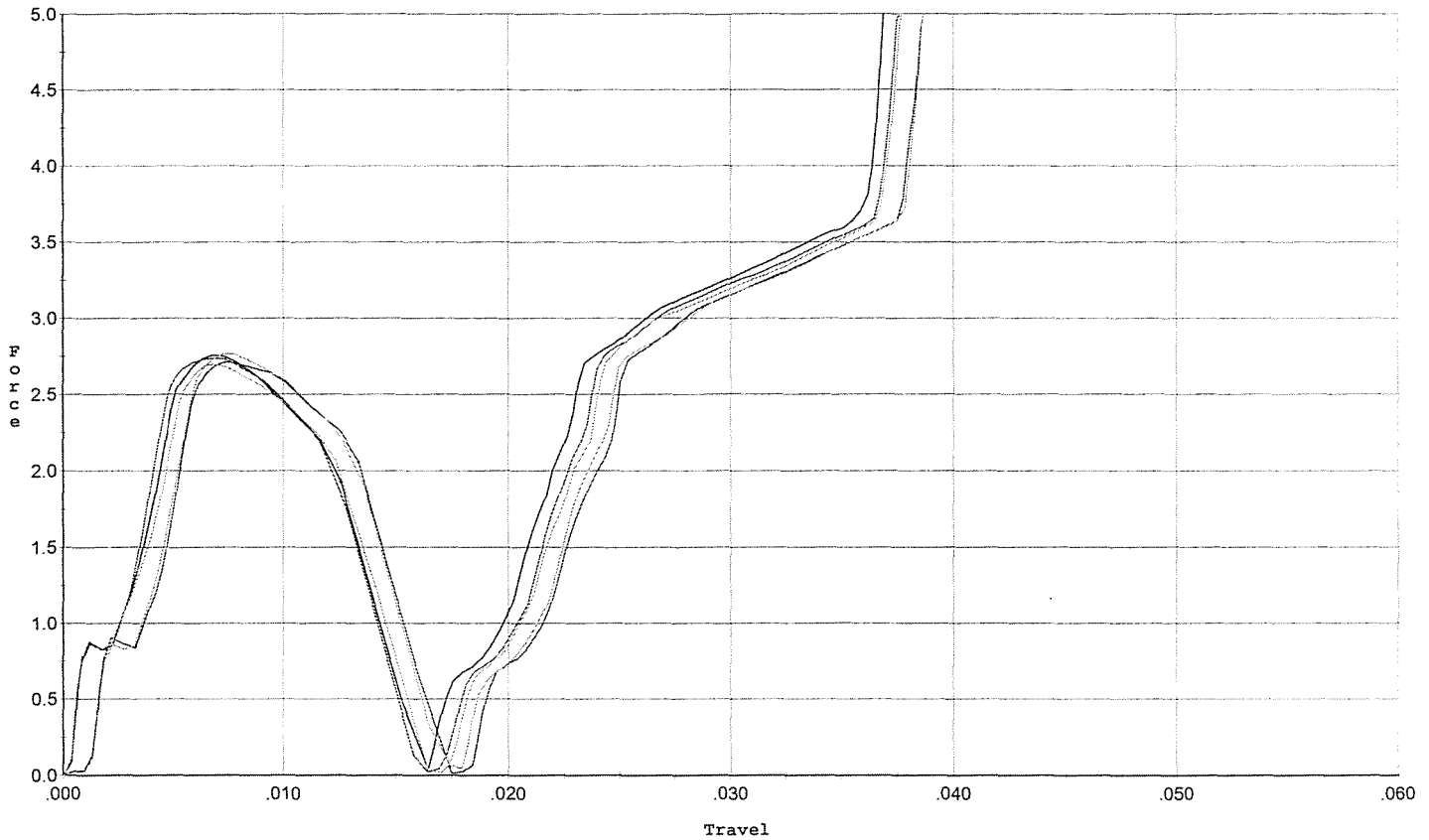
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.618	0.012	0.00	0.027	0.020		Set Trigger
2	2.570	0.012	0.00	0.027	0.021		Set Trigger
3	2.554	0.012	0.003	0.028	0.020		Set Trigger
4	2.585	0.012	0.00	0.028	0.020		Set Trigger
5	2.556	0.012	0.00	0.028	0.020		Set Trigger

A 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



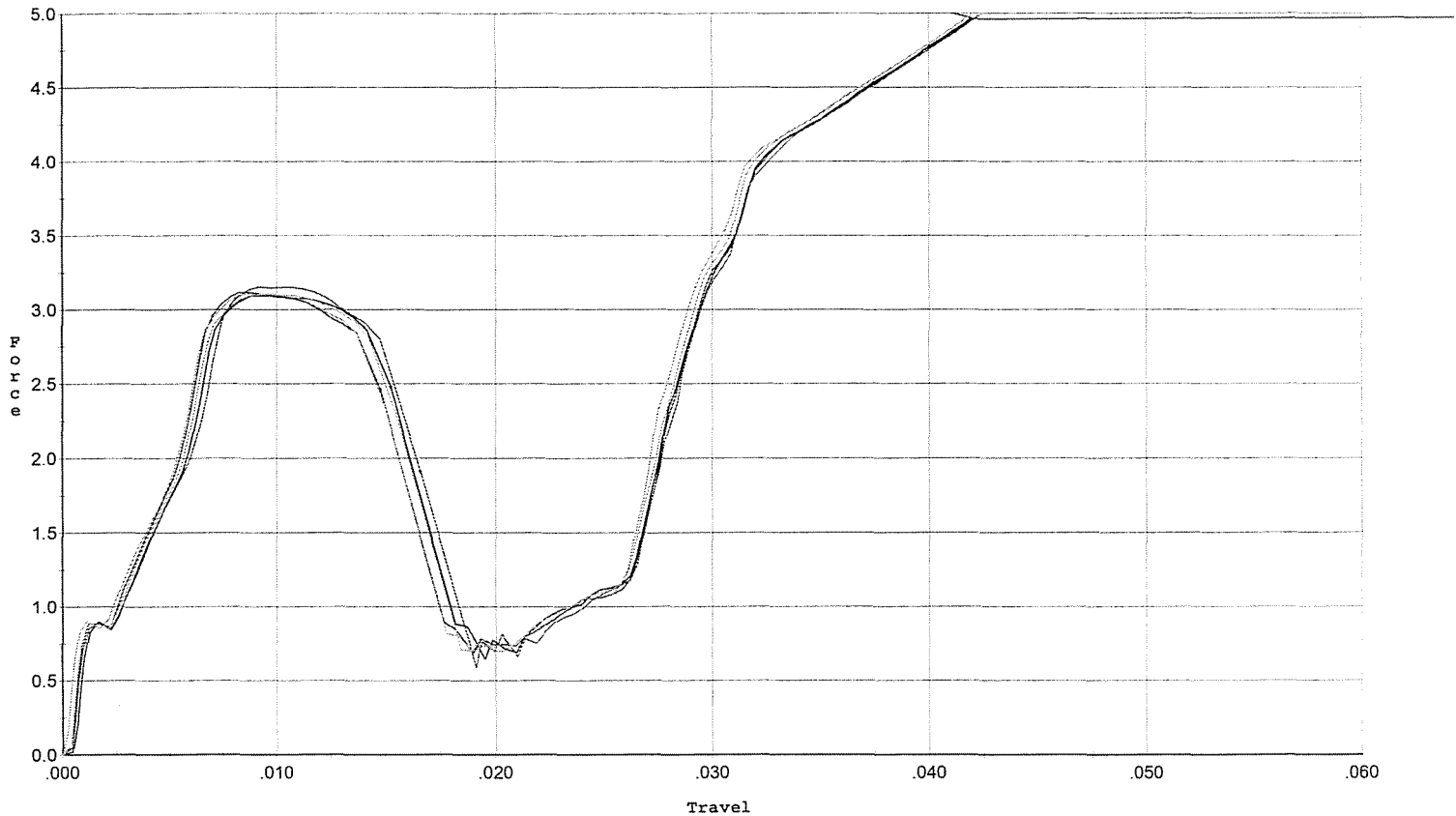
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.714	0.013	0.004	0.028	0.023		Set Trigger
2	2.757	0.013	0.00	0.026	0.023		Set Trigger
3	2.735	0.013	0.00	0.027	0.023		Set Trigger
4	2.696	0.014	0.00	0.027	0.025		Set Trigger
5	2.767	0.014	0.00	0.028	0.023		Set Trigger

A-2.73

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



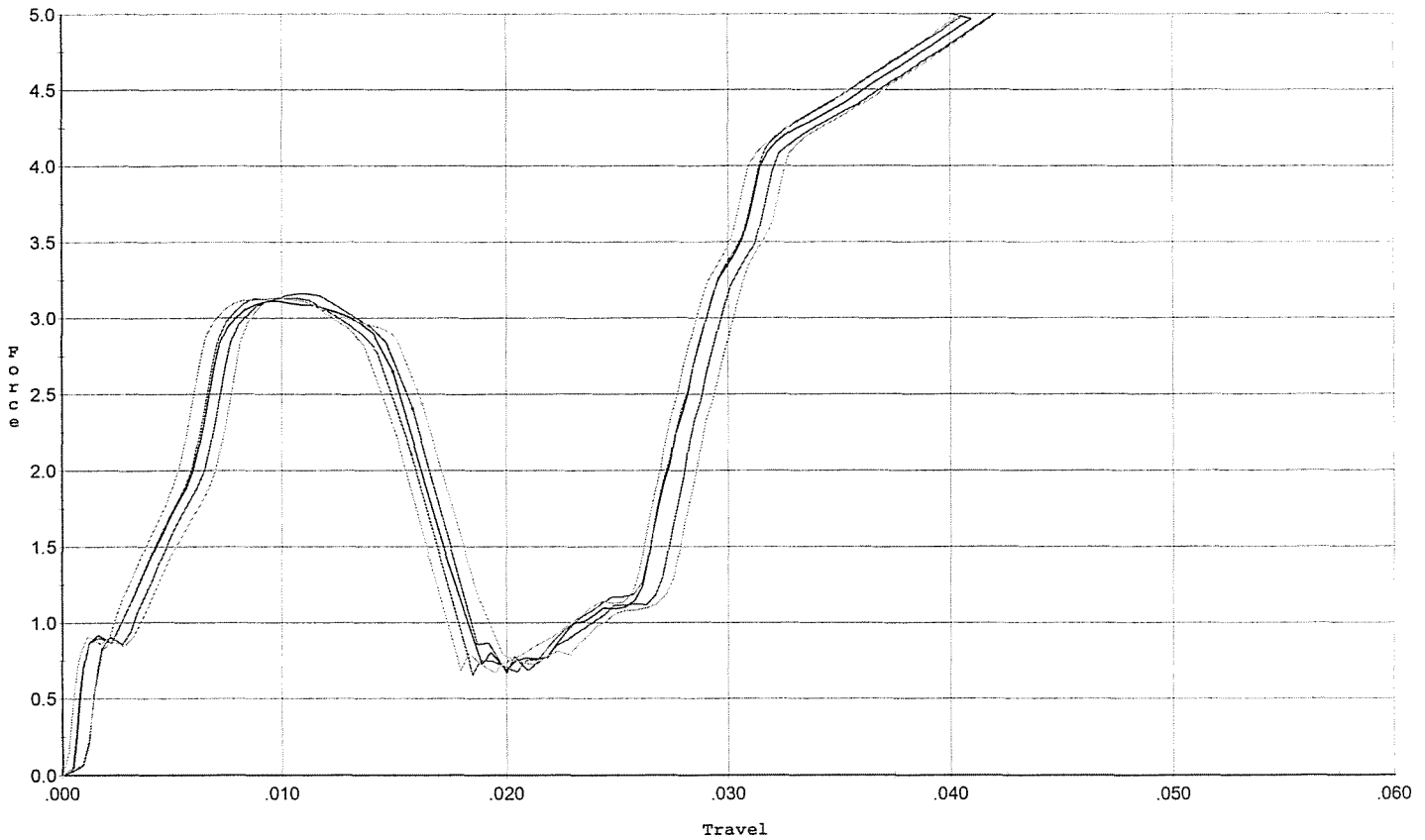
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.115	0.015	0.003	0.030	0.031		Set Trigger
2	3.093	0.015	0.00	0.030	0.031		Set Trigger
3	3.154	0.017	0.00	0.030	0.034		Set Trigger
4	3.107	0.016	0.003	0.030	0.032		Set Trigger
5	3.107	0.015	0.00	0.030	0.031		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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



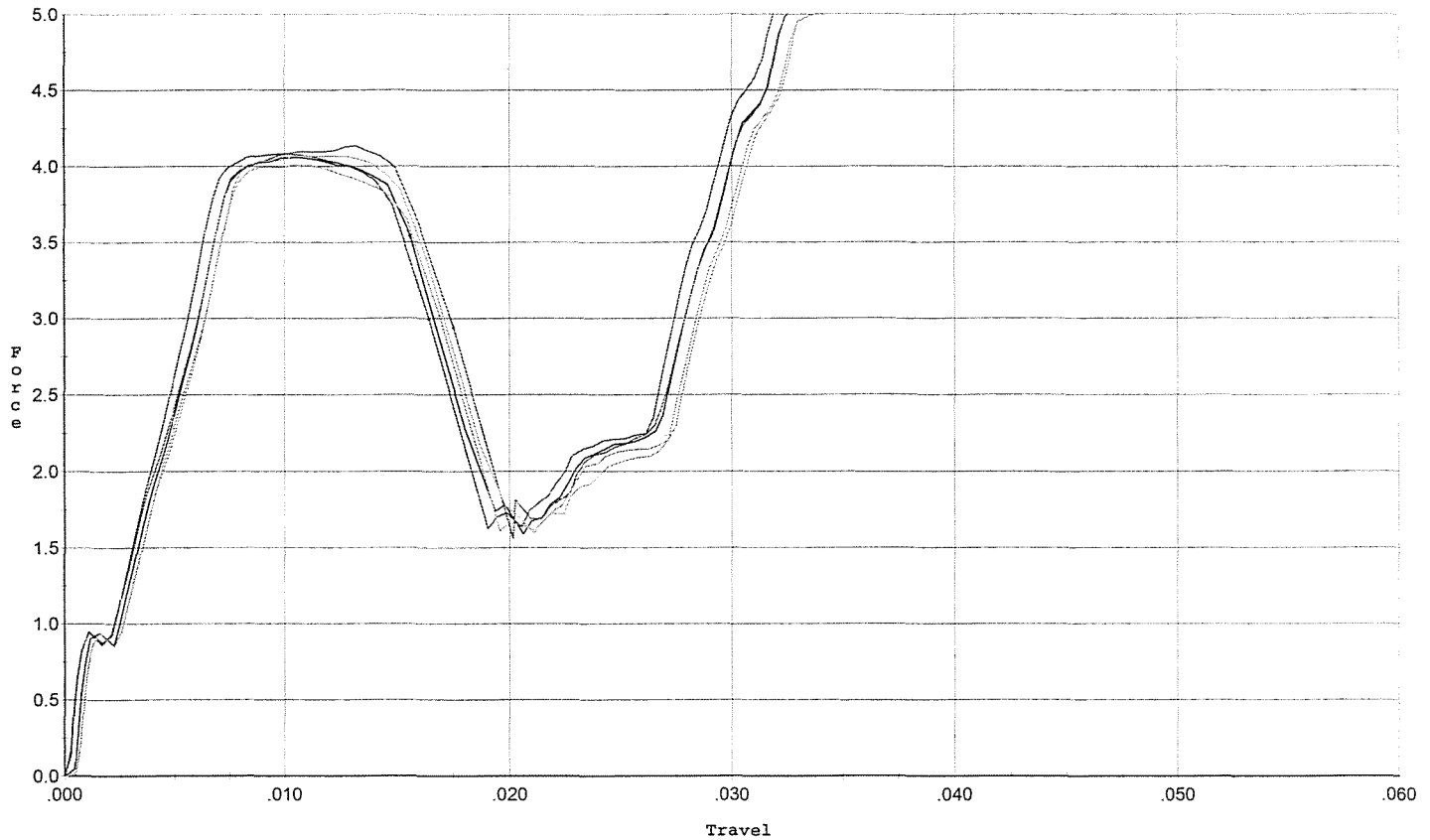
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.158	0.016	0.00	0.030	0.032		Set Trigger
2	3.112	0.015	0.00	0.030	0.031		Set Trigger
3	3.132	0.016	0.00	0.030	0.032		Set Trigger
4	3.133	0.016	0.00	0.030	0.032		Set Trigger
5	3.133	0.015	0.00	0.029	0.032		Set Trigger

A-3.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



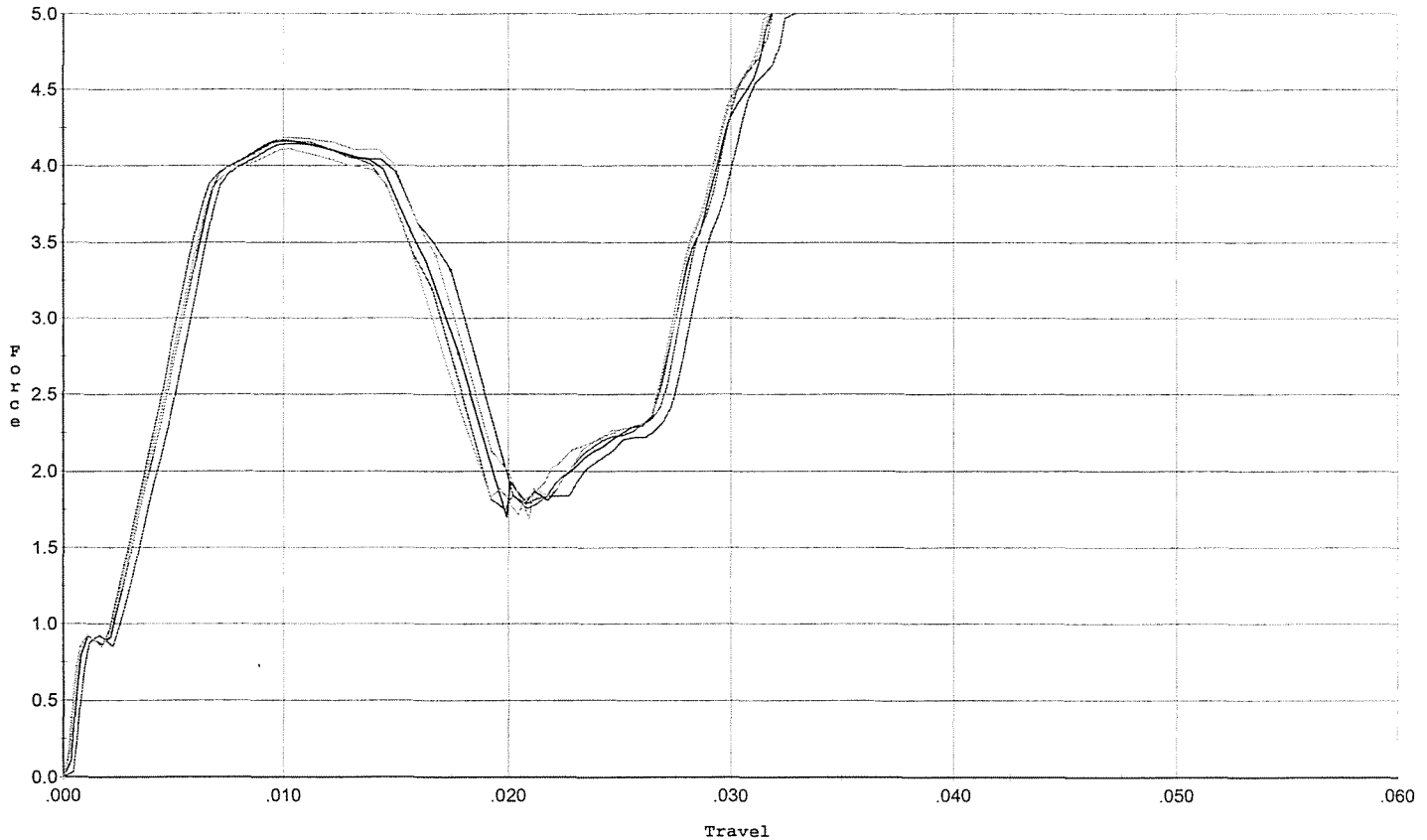
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.081	0.016	0.00	0.026	0.045		Set Trigger
2	4.058	0.016	0.00	0.027	0.042		Set Trigger
3	4.134	0.018	0.00	0.027	0.049		Set Trigger
4	4.072	0.016	0.00	0.027	0.044		Set Trigger
5	4.012	0.017	0.00	0.027	0.045		Set Trigger

A-4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



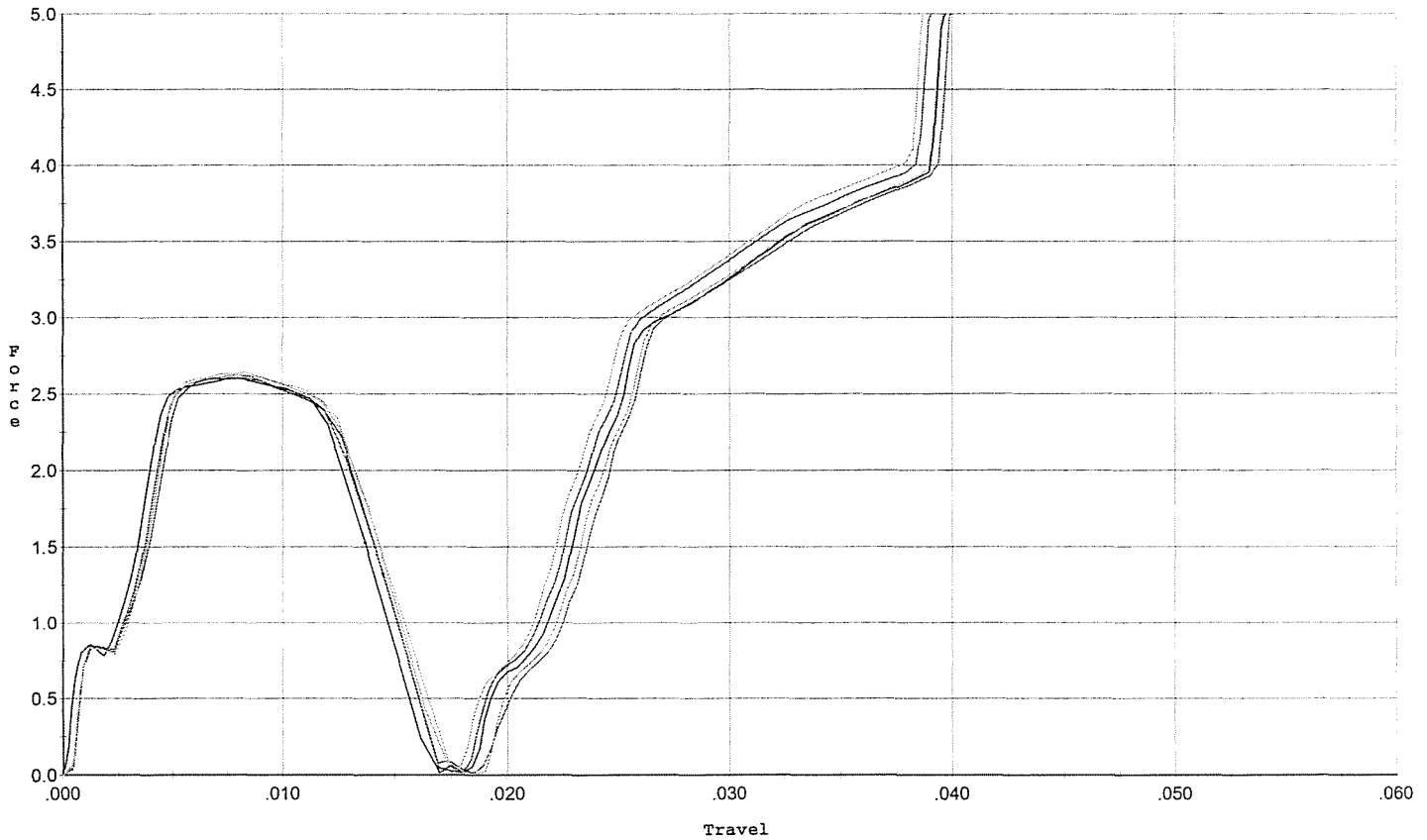
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.144	0.017	0.00	0.024	0.049		Set Trigger
2	4.164	0.018	0.00	0.023	0.050		Set Trigger
3	4.168	0.017	0.00	0.024	0.047		Set Trigger
4	4.112	0.016	0.00	0.024	0.044		Set Trigger
5	4.185	0.017	0.00	0.023	0.048		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



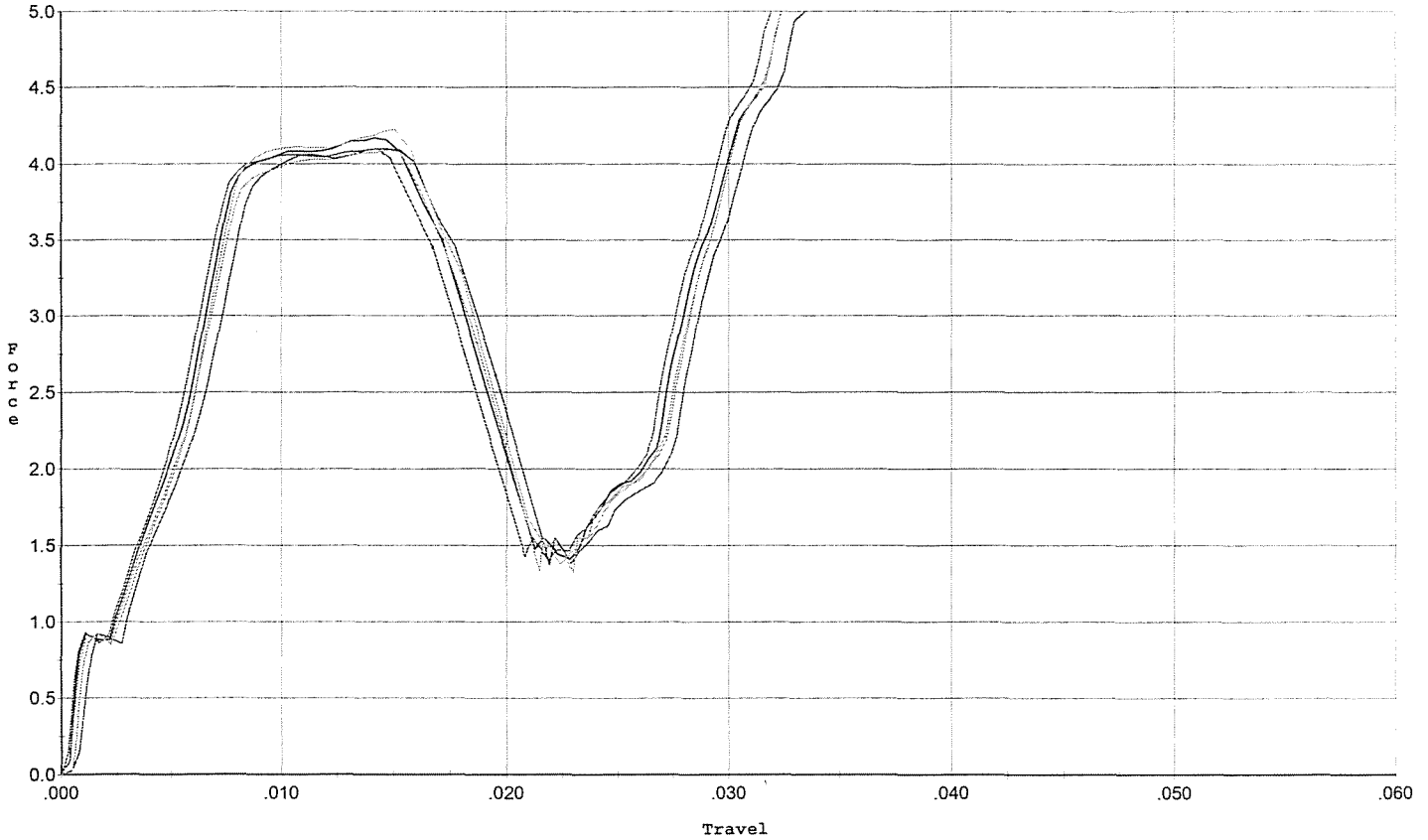
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.602	0.014	0.003	0.028	0.026		Set Trigger
2	2.603	0.014	0.00	0.029	0.025		Set Trigger
3	2.626	0.014	0.003	0.029	0.026		Set Trigger
4	2.625	0.014	0.003	0.027	0.025		Set Trigger
5	2.636	0.016	0.003	0.028	0.028		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/18/2009

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	4.099	0.020	0.003	0.026	0.052		Set Trigger
2	4.169	0.017	0.002	0.026	0.047		Set Trigger
3	4.098	0.017	0.00	0.026	0.046		Set Trigger
4	4.225	0.018	0.002	0.026	0.050		Set Trigger
5	4.091	0.019	0.00	0.026	0.050		Set Trigger

A.4.13