

6679 4801



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



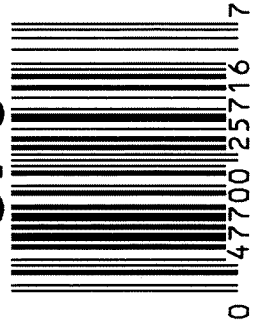
owner registration sticker



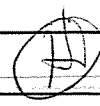
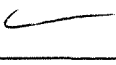
ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794801

UPC



GUN SERIAL # G 6794801

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	KJZ
430	ASSEMBLE TO STOCK		3-6-09	KJZ
440	PROOF		3-6-09	TL
460	CHECK HEADSPACE		3-6-09	TL
470	DIS-ASSEMBLE ACTION		3-6-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-9-09	KJZ
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/13/09	
490	MAGNAFLUX BOLT		3/13/09	MR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	BT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-26-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

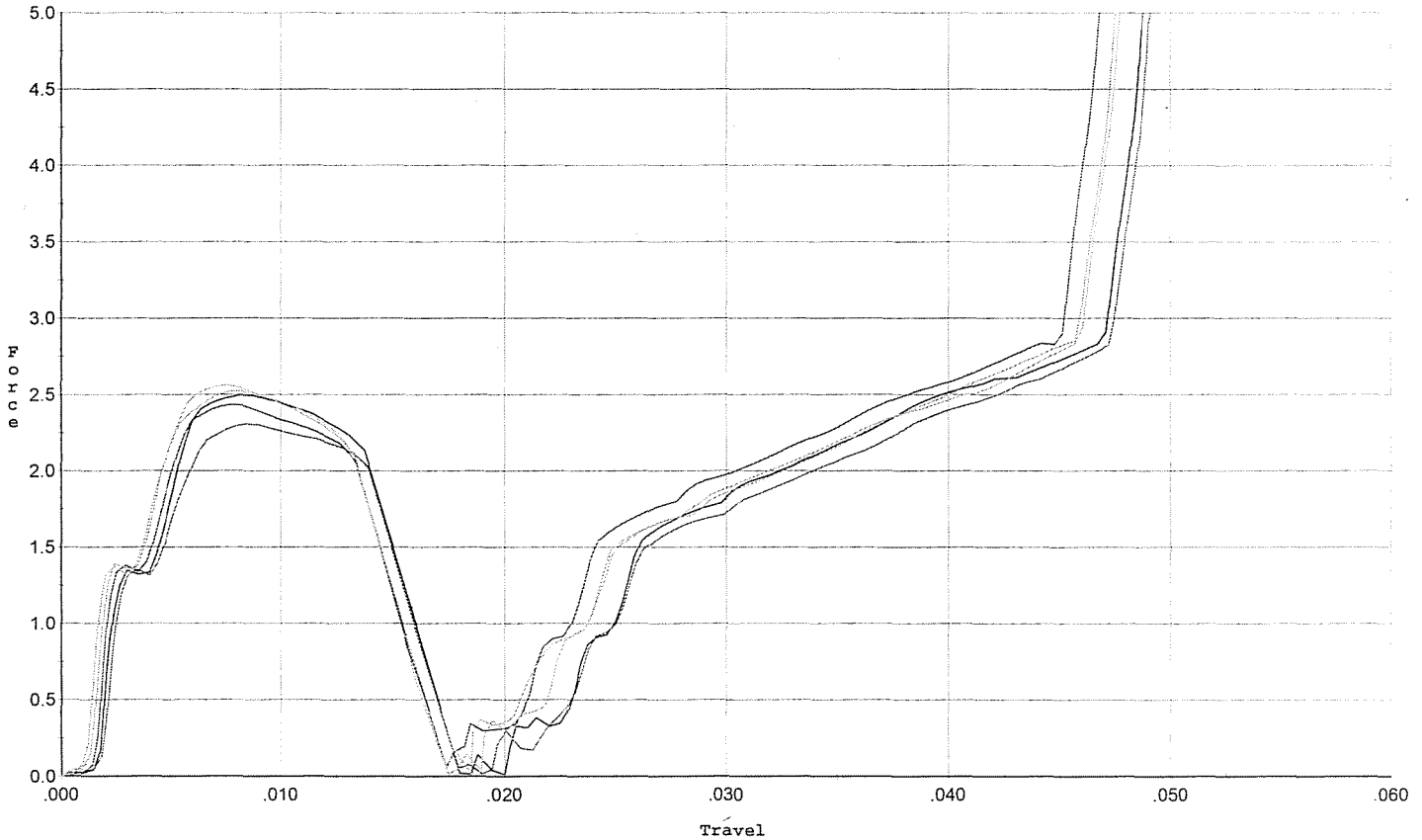
BARBER - M24 0075616		2 LBS MIN 10 LBS MAX	30	30	40	3-30-09	LN		
560	F) SAFETY ON FORCE								
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	6	50	50	3-30-09	LN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.023	3-30-09	LN		
	J) ASSEMBLE STOCK					3-26-09	LN		
	K) ASSEMBLE SWIVEL STUDS					3-31-09	LN		
	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		PASS	FAIL		3-27-09	TL		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION	N/A					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					3-27-09	WN		
670	FINAL INSPECTION A) HEADSPACE					3-30-09	LN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.30	2.31	2.30	2.31	2.35	3-27-09	TL
	C) FUNCTION					3-30-09	LN		
690	PACK					4/13/09	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



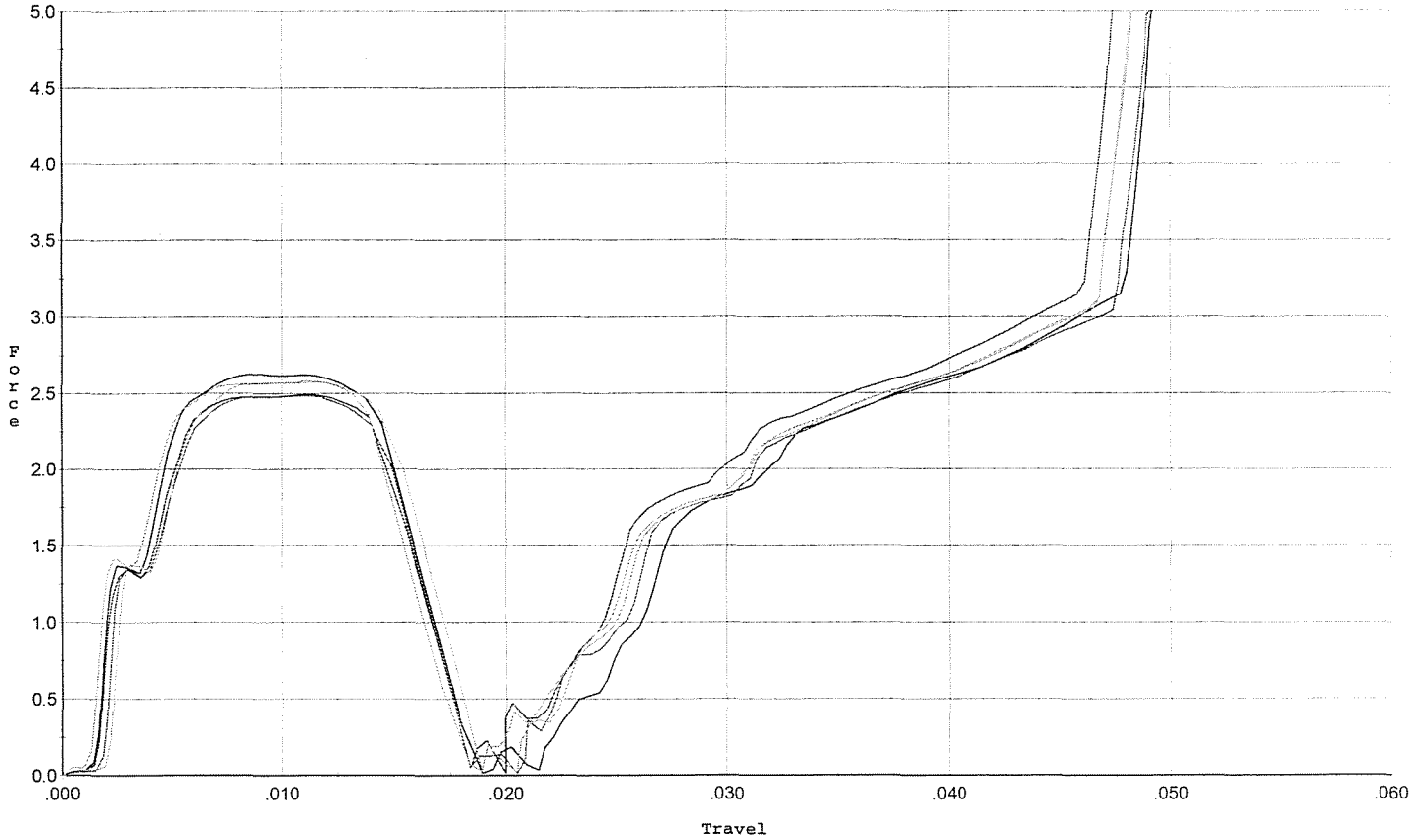
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.435	0.013	0.00	0.036	0.022		Set Trigger
2	2.497	0.016	0.00	0.037	0.027		Set Trigger
3	2.306	0.014	0.00	0.038	0.022		Set Trigger
4	2.523	0.013	0.00	0.037	0.024		Set Trigger
5	2.562	0.013	0.004	0.037	0.024		Set Trigger

A-2-46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



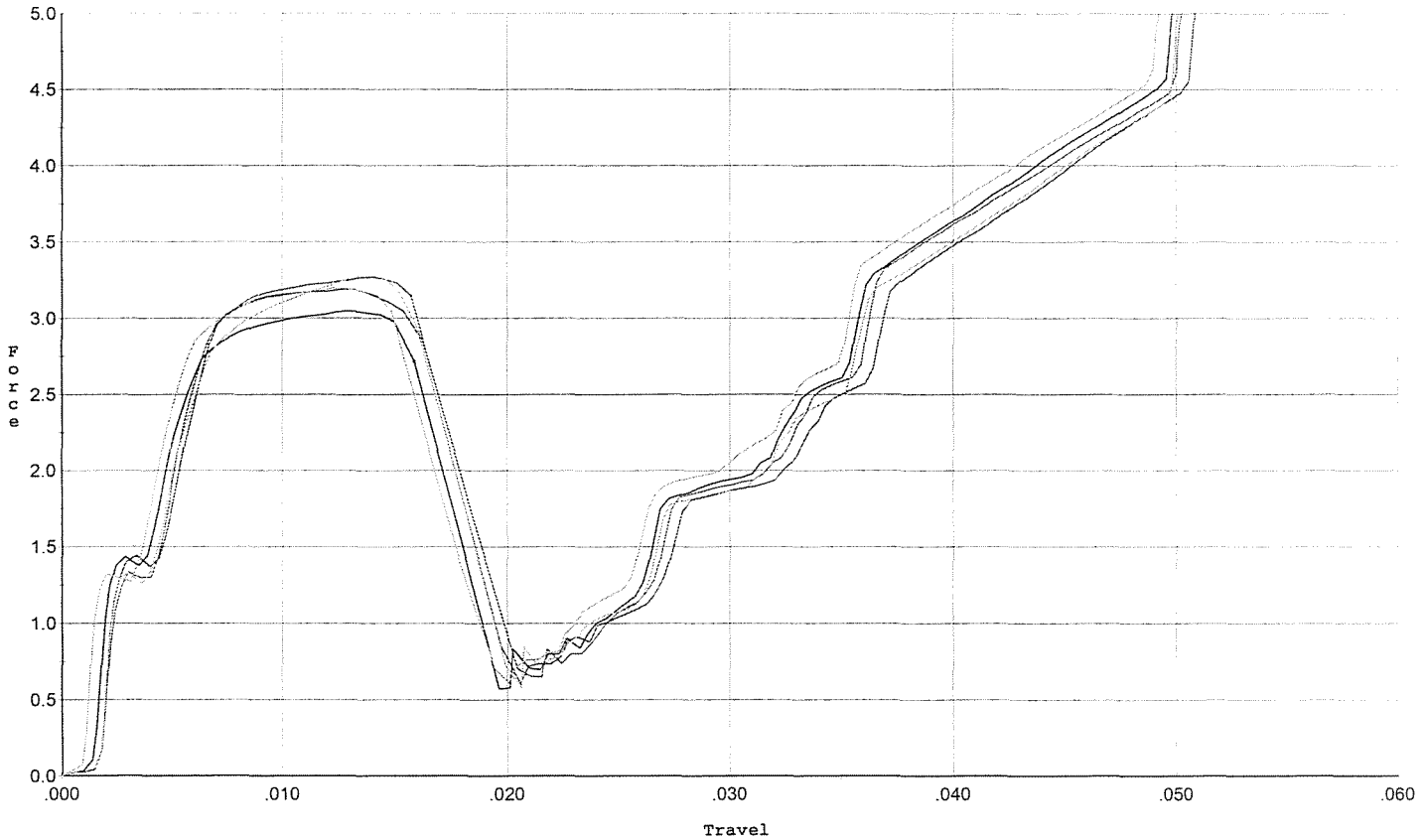
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.016	0.00	0.035	0.027		Set Trigger
2	2.628	0.014	0.004	0.037	0.027		Set Trigger
3	2.483	0.015	0.00	0.037	0.026		Set Trigger
4	2.572	0.015	0.004	0.036	0.028		Set Trigger
5	2.585	0.014	0.00	0.037	0.026		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



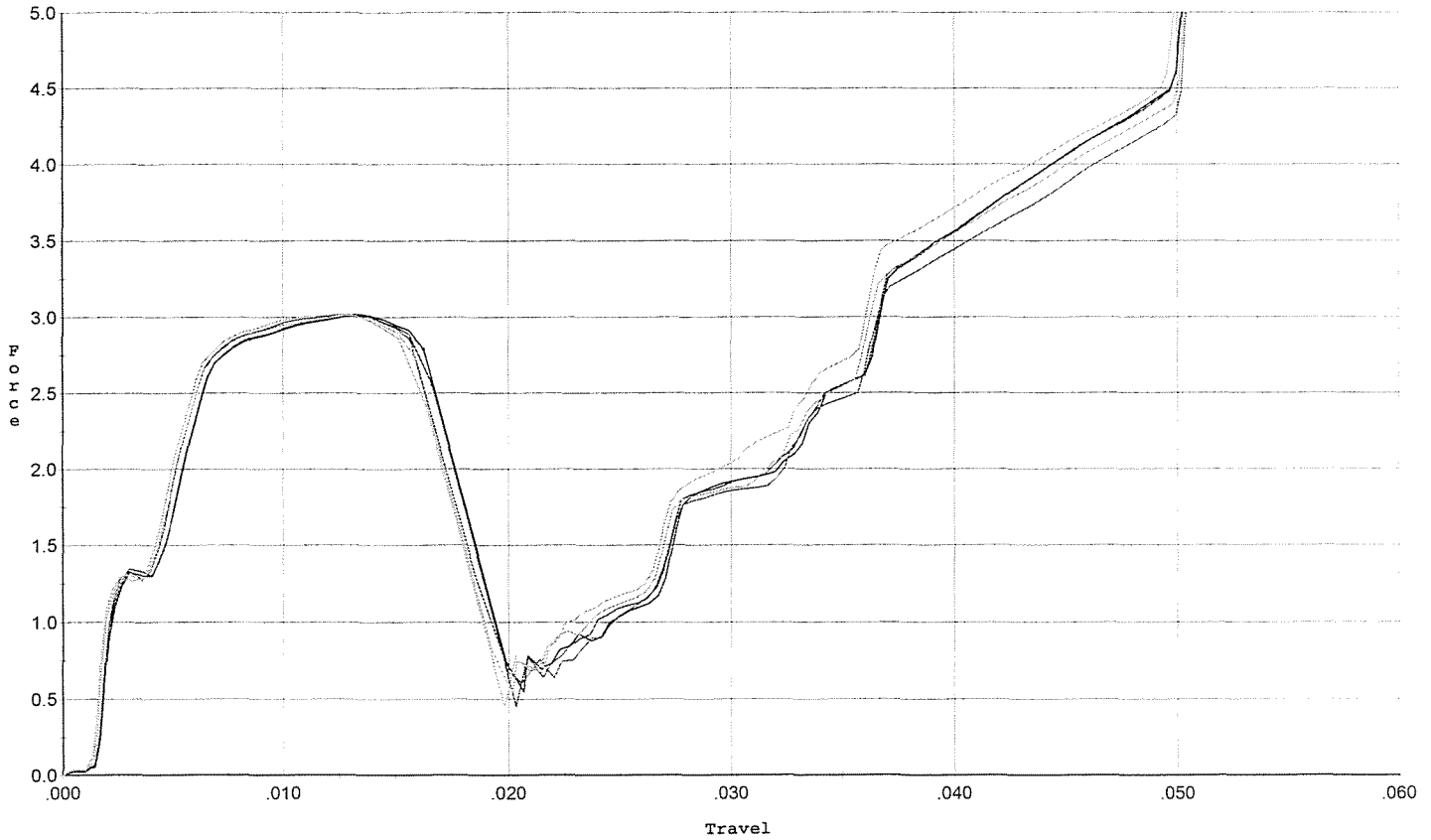
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.191	0.016	0.00	0.036	0.035		Set Trigger
2	3.049	0.016	0.00	0.035	0.034		Set Trigger
3	3.268	0.016	0.00	0.036	0.035		Set Trigger
4	3.279	0.016	0.00	0.035	0.035		Set Trigger
5	3.196	0.015	0.003	0.035	0.033		Set Trigger

A-3.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



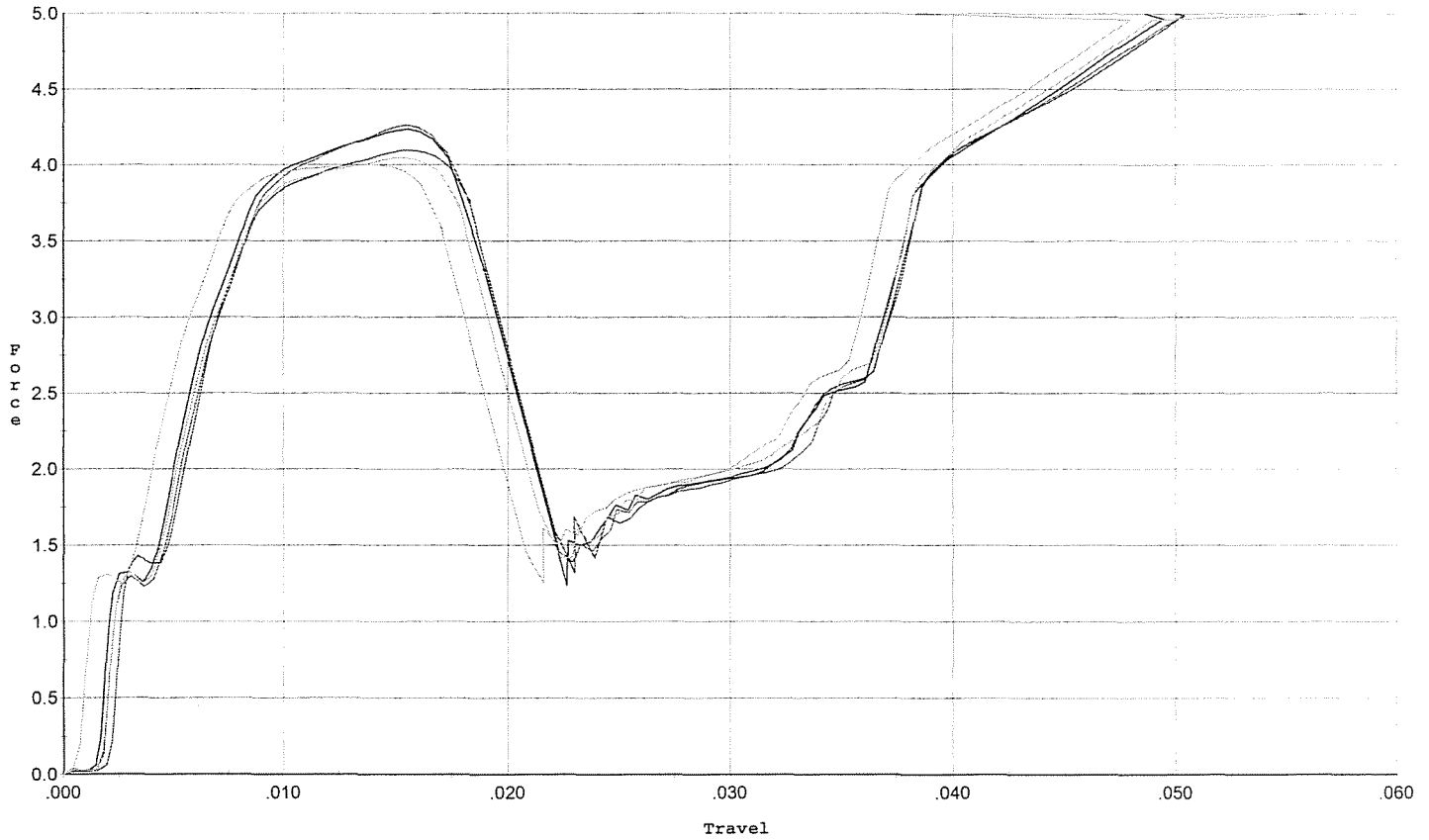
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.010	0.017	0.004	0.036	0.034		Set Trigger
2	3.021	0.016	0.004	0.036	0.034		Set Trigger
3	3.018	0.016	0.00	0.036	0.033		Set Trigger
4	3.020	0.016	0.00	0.035	0.034		Set Trigger
5	3.010	0.016	0.00	0.036	0.033		Set Trigger

A-3.01

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



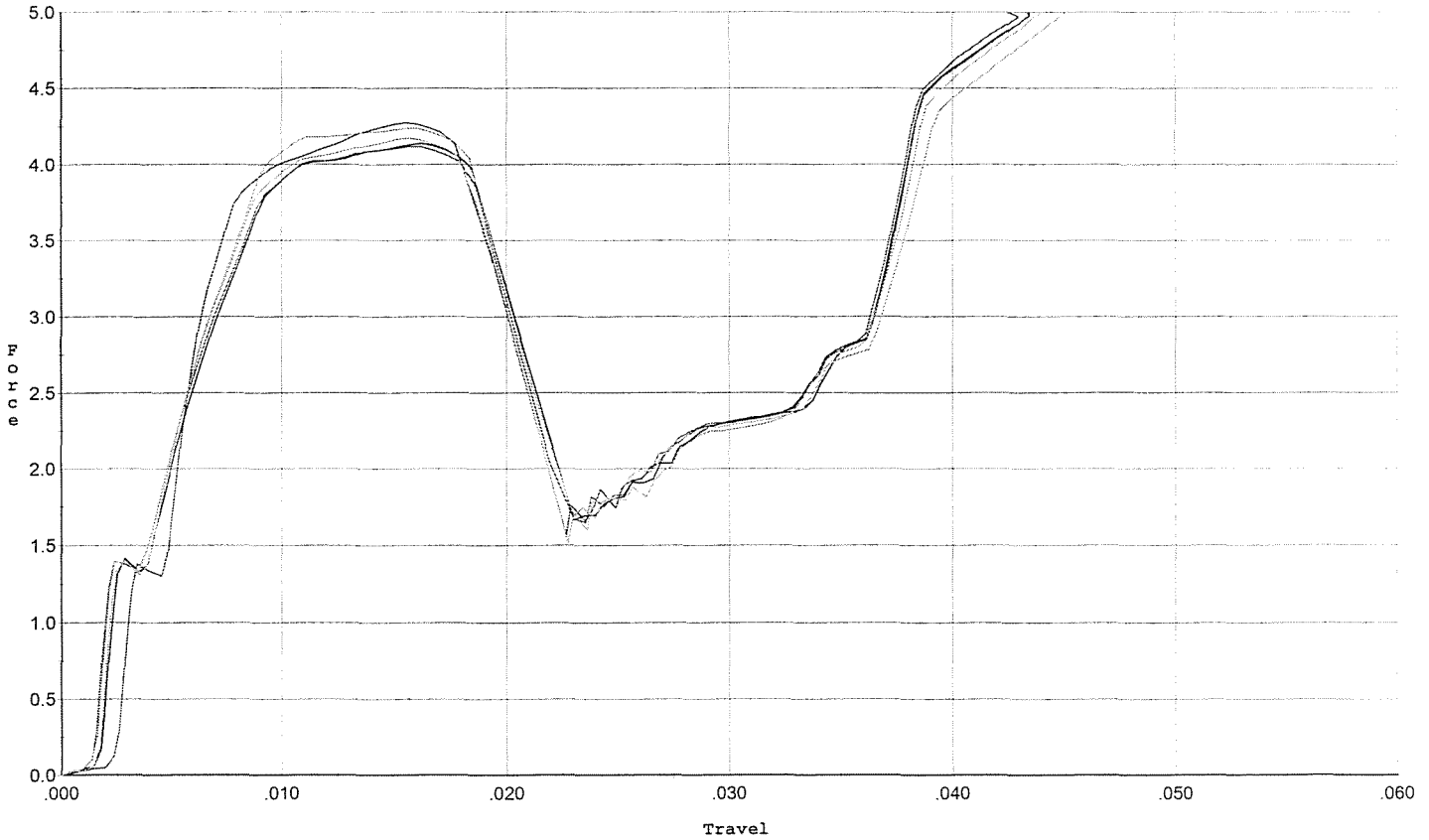
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.094	0.018	0.002	0.034	0.049		Set Trigger
2	4.236	0.019	0.00	0.033	0.052		Set Trigger
3	4.262	0.018	0.002	0.034	0.050		Set Trigger
4	4.046	0.018	0.002	0.034	0.047		Set Trigger
5	4.003	0.017	0.00	0.034	0.048		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



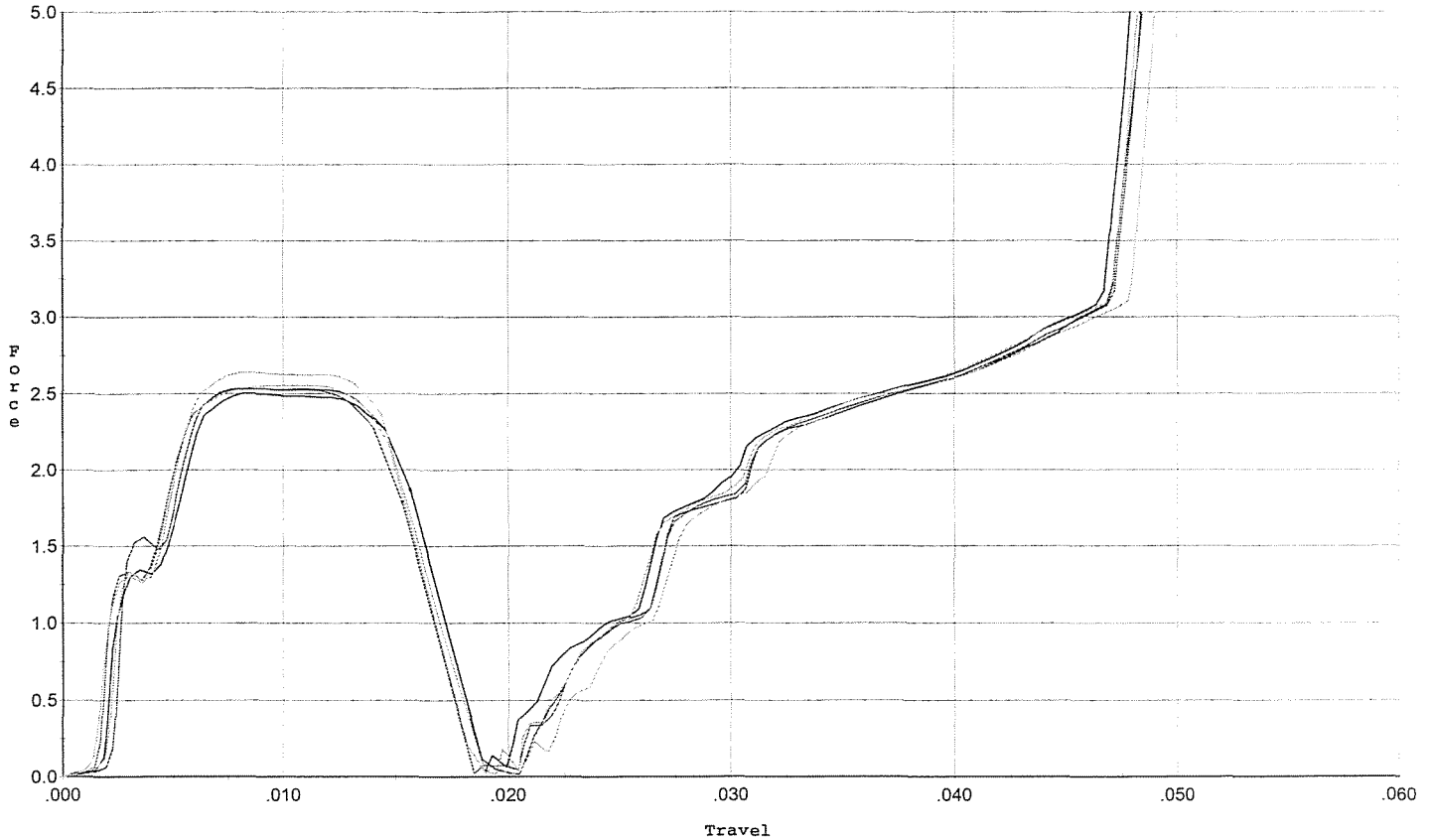
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.275	0.019	0.005	0.032	0.054		Set Trigger
2	4.139	0.018	0.00	0.032	0.051		Set Trigger
3	4.118	0.019	0.004	0.032	0.052		Set Trigger
4	4.175	0.019	0.004	0.032	0.053		Set Trigger
5	4.237	0.018	0.00	0.033	0.052		Set Trigger

A-4.18

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



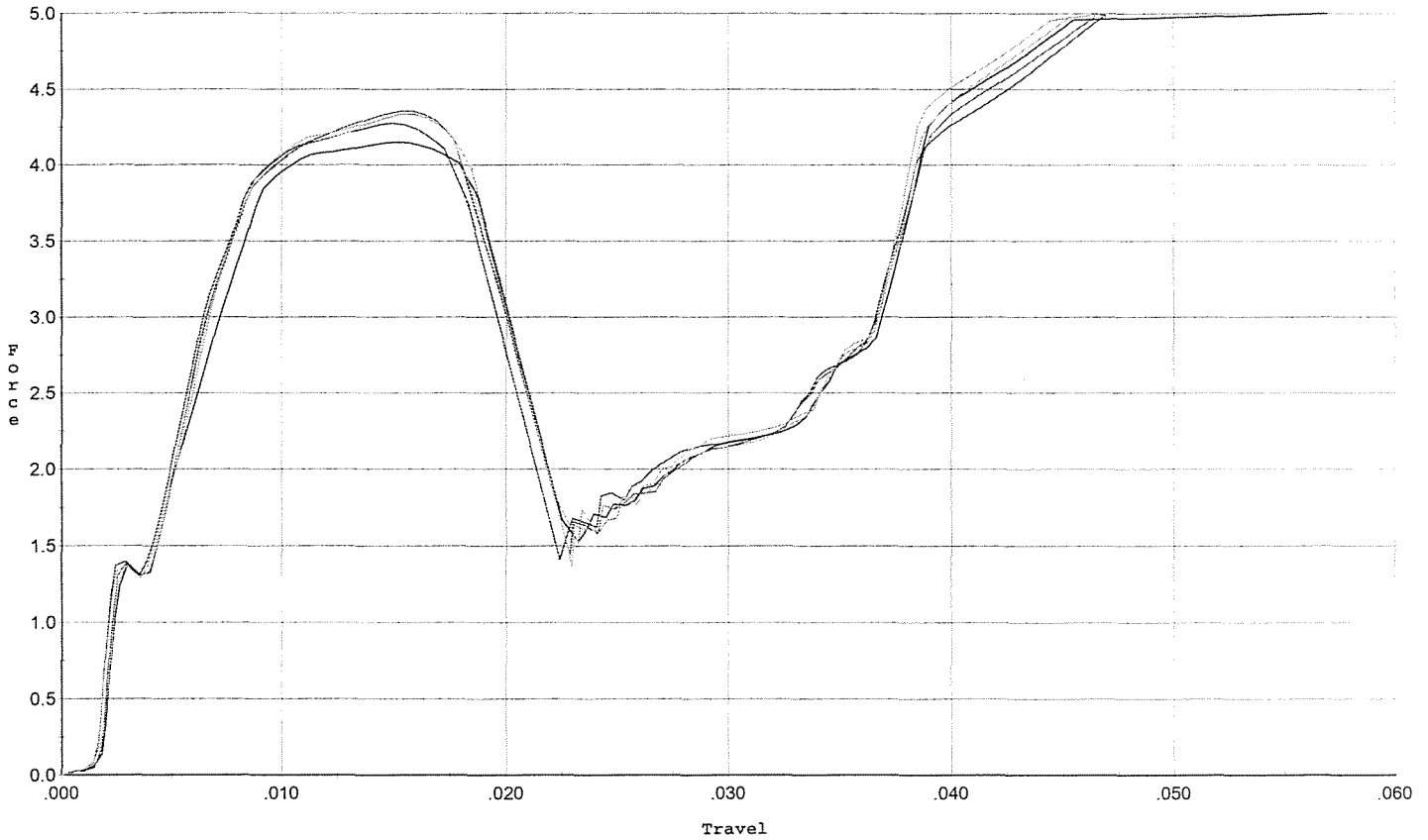
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.540	0.016	0.00	0.036	0.028		Set Trigger
2	2.504	0.016	0.00	0.036	0.027		Set Trigger
3	2.535	0.015	0.00	0.037	0.027		Set Trigger
4	2.553	0.015	0.00	0.037	0.027		Set Trigger
5	2.642	0.014	0.00	0.036	0.026		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.276	0.018	0.00	0.033	0.052		Set Trigger
2	4.150	0.019	0.00	0.033	0.051		Set Trigger
3	4.355	0.020	0.00	0.033	0.055		Set Trigger
4	4.342	0.019	0.00	0.033	0.054		Set Trigger
5	4.335	0.018	0.00	0.033	0.052		Set Trigger

A-4.29