

66863610

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD

proof of purchase



owner registration sticker



BM FORM

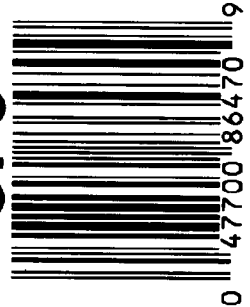
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6863610

UPC



BARBER - M24 0093713 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6863610

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-10-09	SP
430	ASSEMBLE TO STOCK		6-10-09	SP
440	PROOF		6-10-09	SP
460	CHECK HEADSPACE	MAGNA-FLUX	6-10-09	RP
470	DIS-ASSEMBLE ACTION		6-10-09	RP
472	SERIALIZE BOLT HANDLE		6-10-09	RT
480	MAGNAFLUX BBL ACTION	OPERATOR	6/13/09	RT
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6/16/09	RT
510	DRILL AND TAP SIGHT HOLES		6-11-09	SP
520	GOFF BLAST BBL / REC		6/16/09	RTW
540	APPLY COATINGS (BARREL ACTION)		7/2	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-7-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-7-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-7-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-26-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

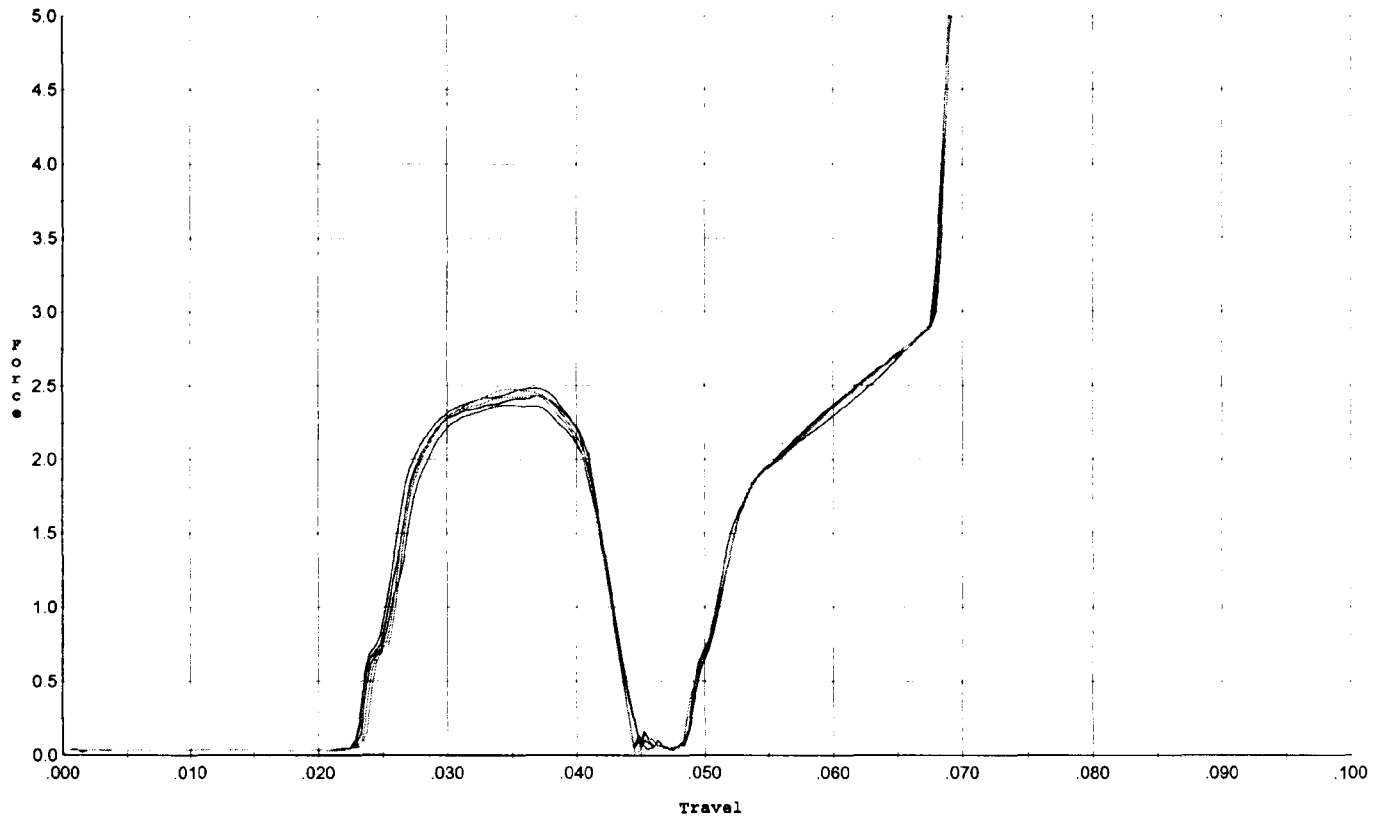
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 009371 F) SAFETY ON FORCE 42 LBS MIN 10 LBS MAX	<u>2°</u> <u>2°</u> <u>2°</u>	8/27/09	RB
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>8°</u> <u>8°</u> <u>8°</u>	8/27/09	RB
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	8/27/09	RB
	J) ASSEMBLE STOCK		8-26-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		8/27/09	RB
	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	8-26-09 8-26-09	RP
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-26-09	L.P.N.
670	FINAL INSPECTION A) HEADSPACE		8/27/09	RB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.43</u> <u>2.39</u> <u>2.33</u> <u>2.30</u>	8/27/09	RB
	C) FUNCTION		8/27/09	RB
690	PACK		8-27-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

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



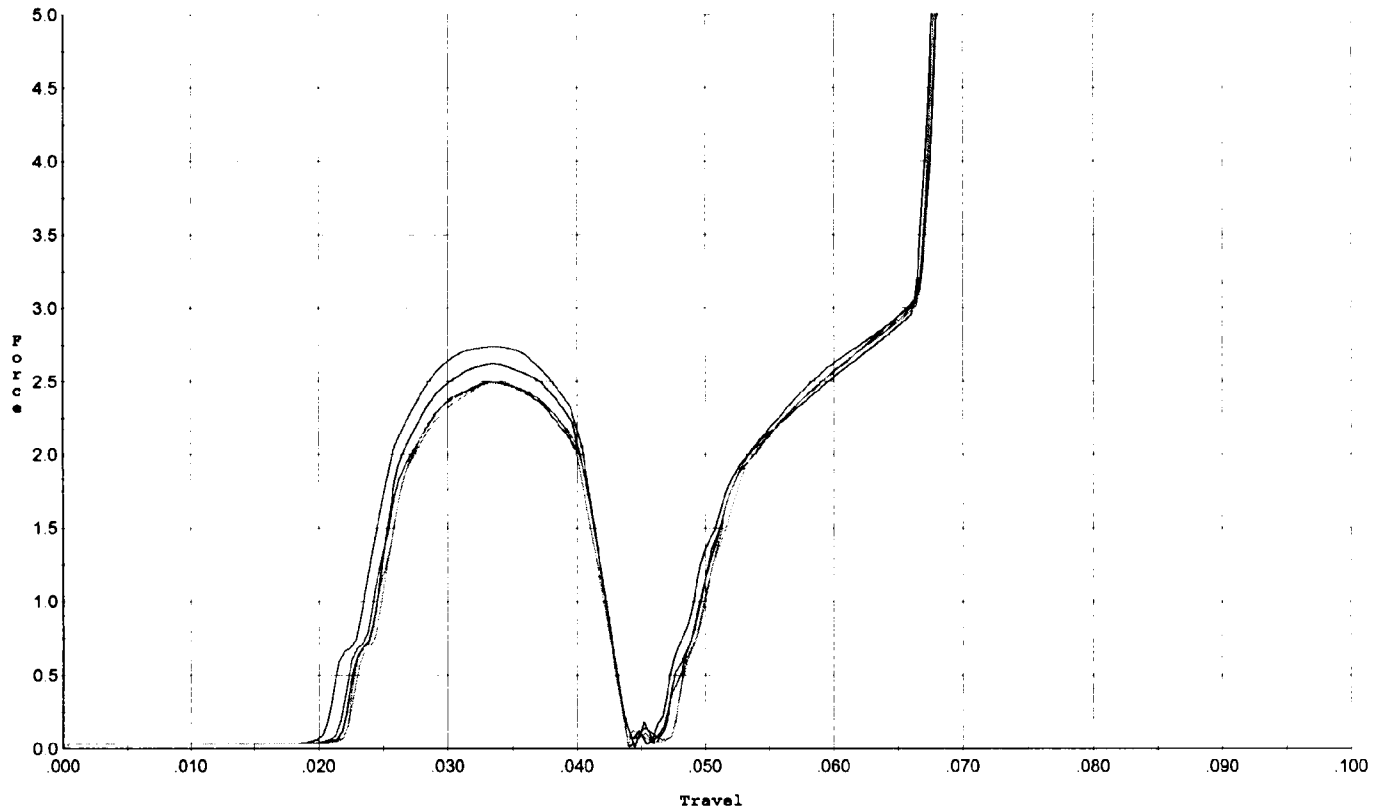
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.485	0.041	0.023	0.031	0.038		Set Trigger
2	2.429	0.041	0.023	0.031	0.037		Set Trigger
3	2.369	0.041	0.023	0.032	0.036		Set Trigger
4	2.431	0.042	0.024	0.031	0.037		Set Trigger
5	2.480	0.041	0.024	0.031	0.037		Set Trigger

A-2.43

Trigger Profile [lbs,Inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

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



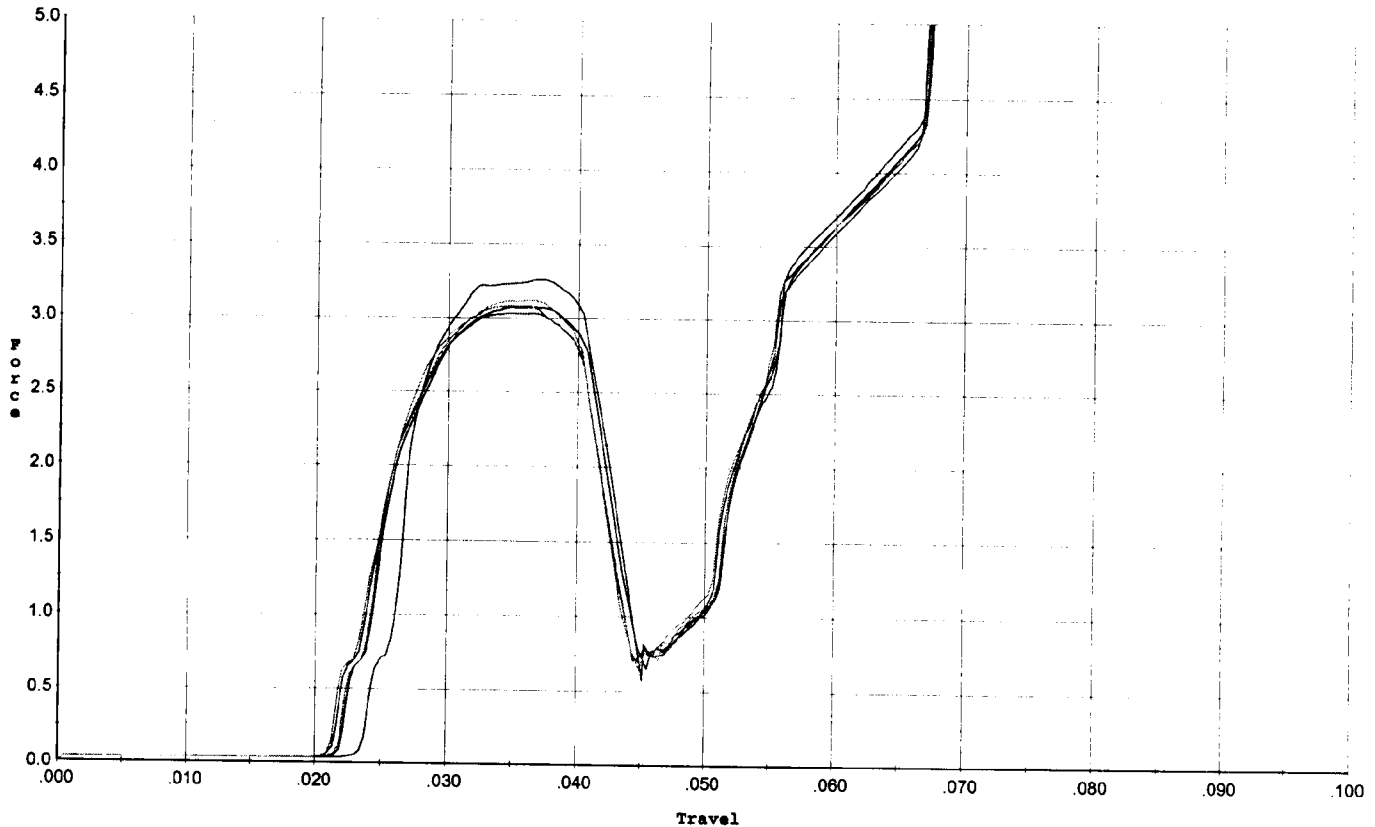
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.739	0.040	0.021	0.030	0.043		Set Trigger
2	2.623	0.041	0.022	0.030	0.040		Set Trigger
3	2.496	0.042	0.022	0.031	0.039		Set Trigger
4	2.491	0.042	0.022	0.030	0.038		Set Trigger
5	2.500	0.041	0.022	0.030	0.038		Set Trigger

A-257

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/14/2009

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



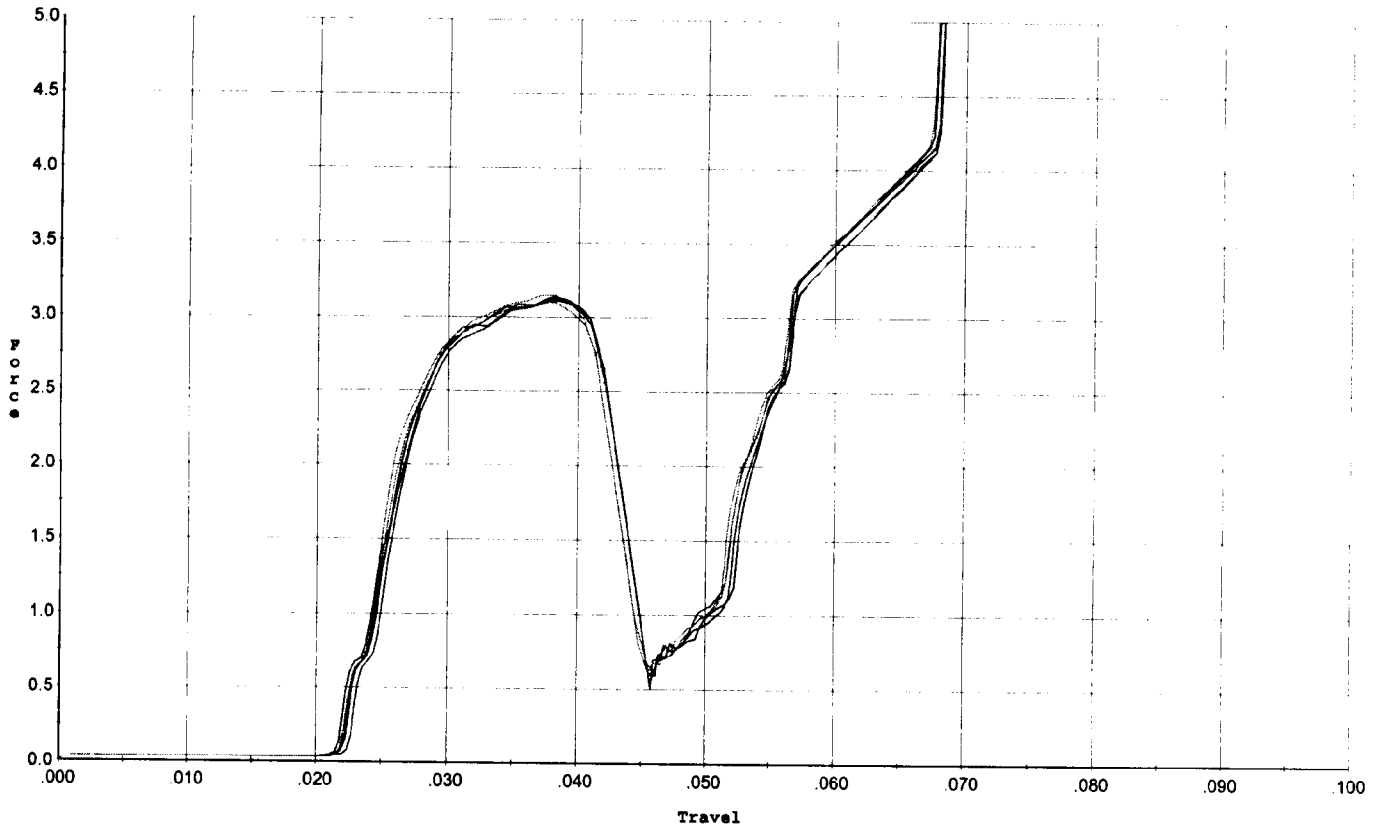
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.263	0.042	0.024	0.028	0.050		Set Trigger
2	3.074	0.041	0.022	0.028	0.048		Set Trigger
3	3.034	0.040	0.022	0.028	0.048		Set Trigger
4	3.123	0.040	0.022	0.029	0.048		Set Trigger
5	3.081	0.040	0.021	0.028	0.049		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/14/2009

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



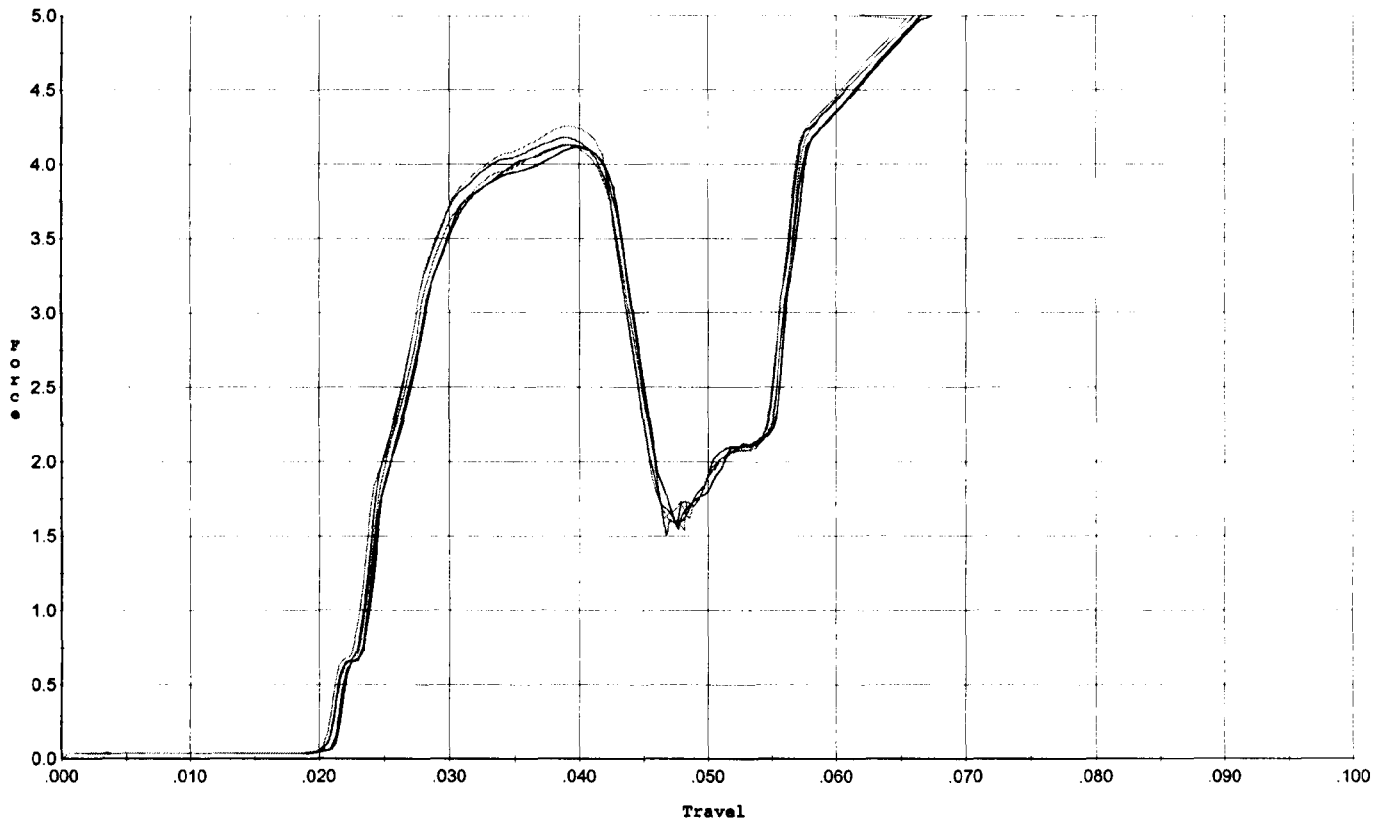
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.118	0.042	0.022	0.028	0.051		Set Trigger
2	3.134	0.042	0.022	0.028	0.051		Set Trigger
3	3.108	0.042	0.023	0.028	0.050		Set Trigger
4	3.102	0.041	0.022	0.029	0.050		Set Trigger
5	3.151	0.041	0.022	0.028	0.051		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: cms 8/14/2009

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



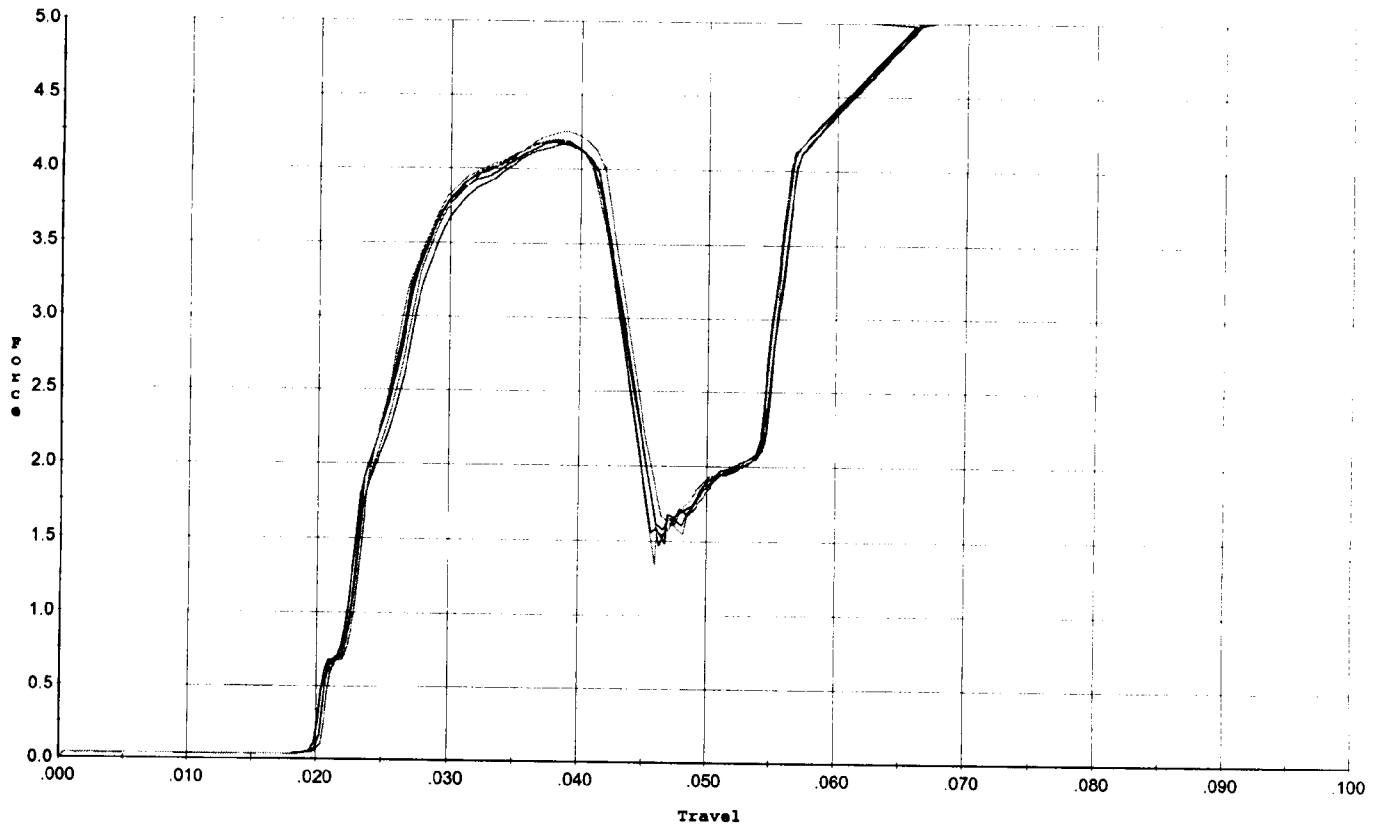
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.129	0.043	0.021	0.026	0.071		Set Trigger
2	4.114	0.043	0.022	0.026	0.070		Set Trigger
3	4.180	0.042	0.021	0.026	0.071		Set Trigger
4	4.260	0.042	0.021	0.026	0.071		Set Trigger
5	4.130	0.042	0.021	0.026	0.070		Set Trigger

A4-16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/14/2009

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



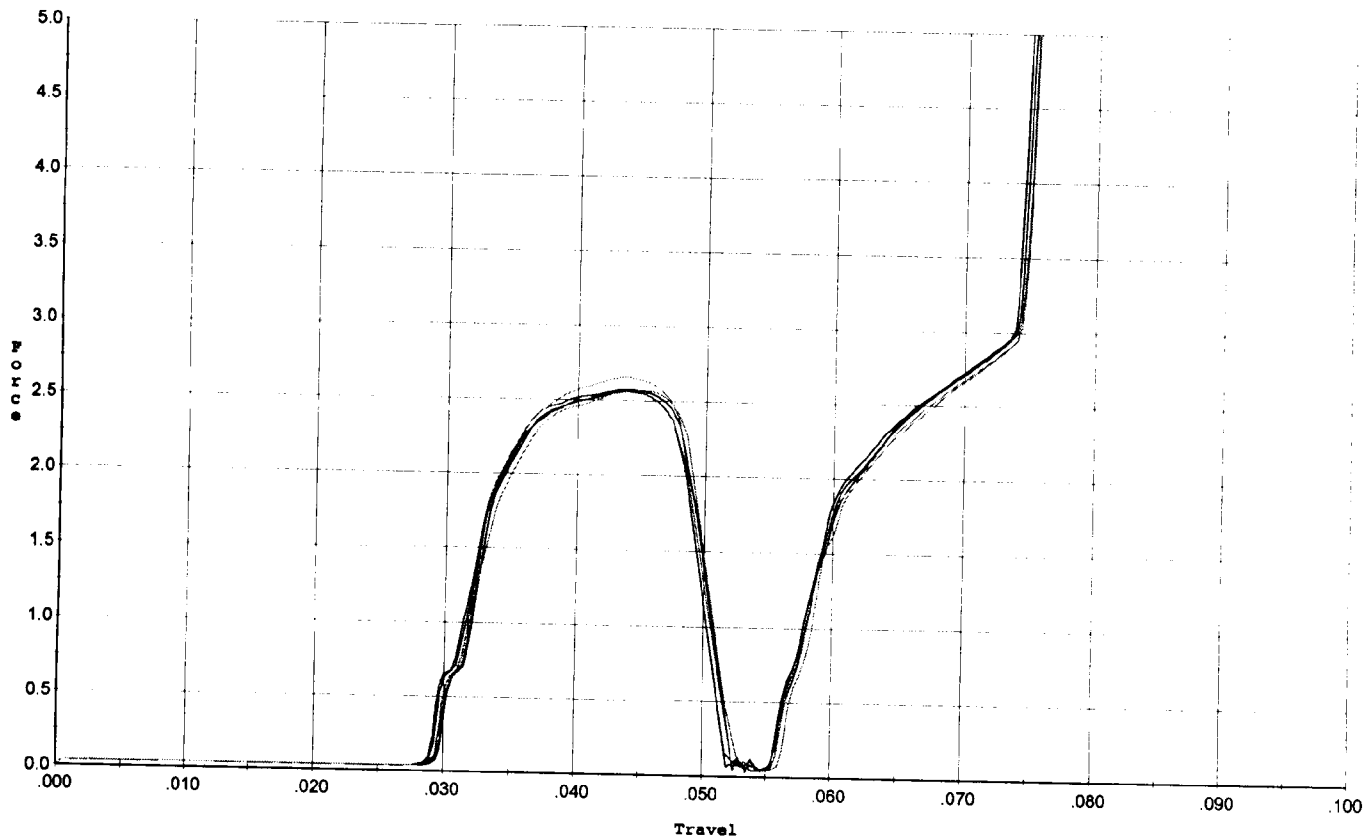
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.179	0.041	0.020	0.026	0.072		Set Trigger
2	4.193	0.042	0.020	0.026	0.072		Set Trigger
3	4.169	0.044	0.020	0.026	0.074		Set Trigger
4	4.199	0.042	0.021	0.026	0.073		Set Trigger
5	4.254	0.042	0.021	0.026	0.073		Set Trigger

A-4-19

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/14/2009

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



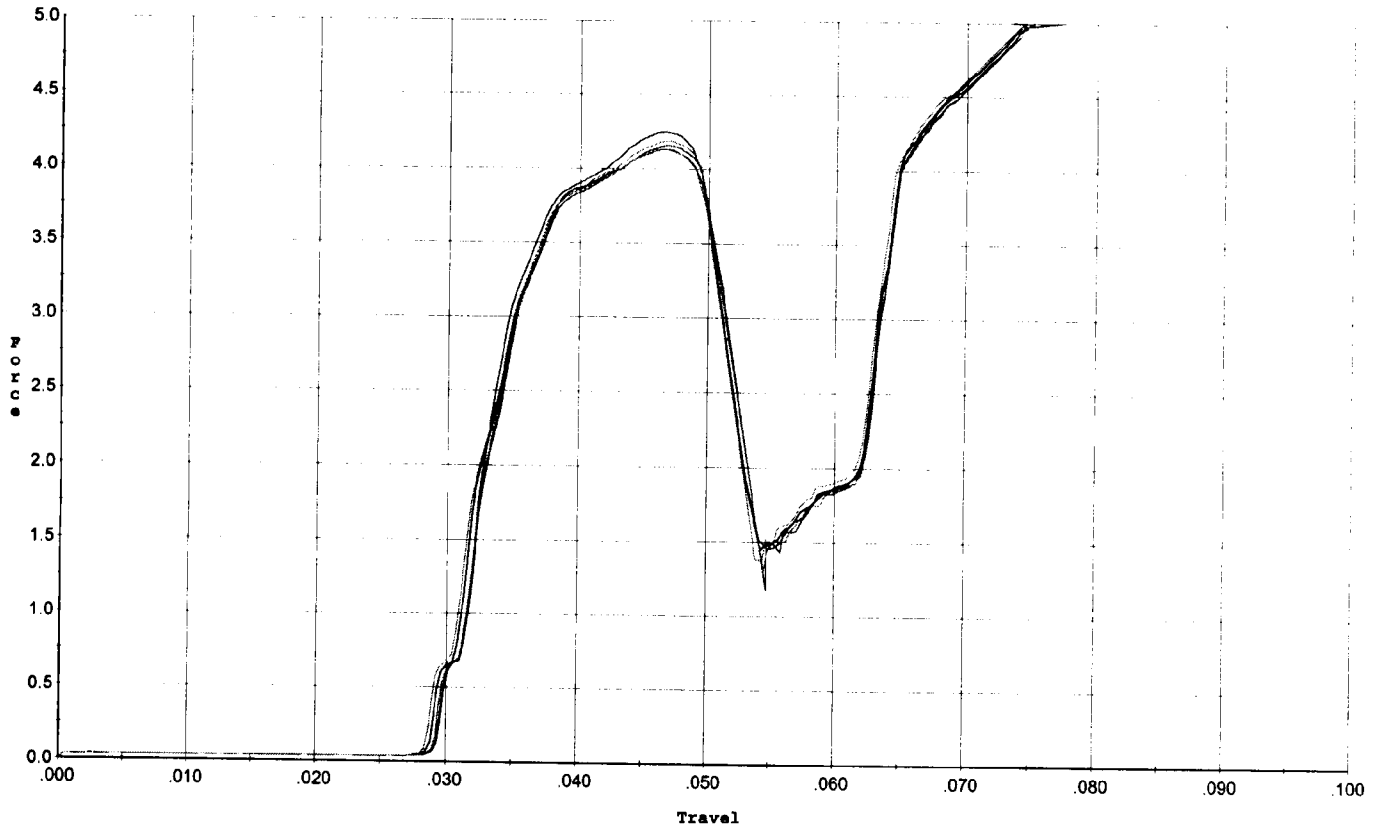
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.576	0.048	0.029	0.032	0.043		Set Trigger
2	2.576	0.049	0.030	0.031	0.043		Set Trigger
3	2.563	0.048	0.029	0.032	0.042		Set Trigger
4	2.657	0.048	0.030	0.032	0.042		Set Trigger
5	2.570	0.049	0.030	0.032	0.042		Set Trigger

A-2.58

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: cms 8/14/2009

Model: M/24
 Serial No: Form #F005
 Trigger: reset 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	4.252	0.049	0.029	0.029	0.071		Set Trigger
2	4.132	0.050	0.029	0.029	0.071		Set Trigger
3	4.158	0.051	0.029	0.029	0.073		Set Trigger
4	4.128	0.050	0.029	0.029	0.072		Set Trigger
5	4.188	0.052	0.029	0.029	0.074		Set Trigger

A 4.17