

G6810353

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



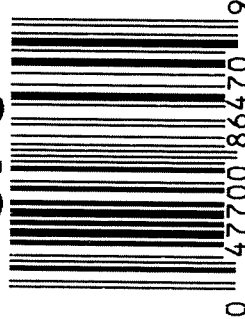
ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6810353

UPC



BM FORM

GUN SERIAL # G 6810353

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-10-09	SP
430	ASSEMBLE TO STOCK		2-10-09	SP
440	PROOF		2-10-09	SP
460	CHECK HEADSPACE		2-10-09	SP
470	DIS-ASSEMBLE ACTION		2-10-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	2-10-09	SP
475	DRILL AND TAP SIGHT HOLES		2-11-09	TK
480	MAGNAFLUX BBL ACTION	OPERATOR	2/13/09	TK
490	MAGNAFLUX BOLT		2/13/09	MR
500	ROLLMARK CALIBER		2/14/09	RT
520	GOFF BLAST BBL / REC		2/16/09	DG
542	APPLY COATINGS (BARREL ACTION)		2/17/09	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		2-25-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

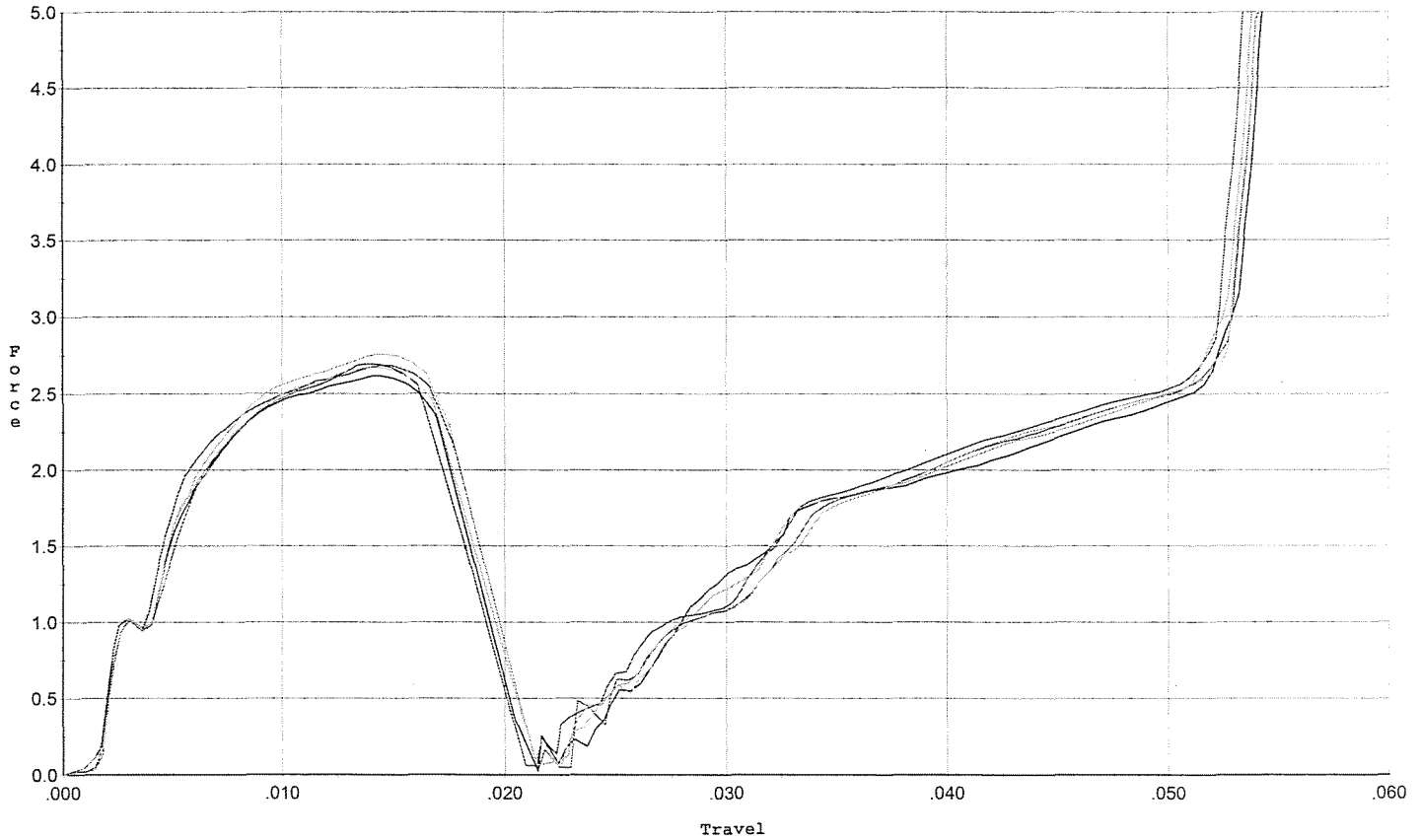
BARBER - M24 0130603			2 LBS MIN	10 LBS MAX			
560	F) SAFETY ON FORCE				<u>7</u>	<u>4.5</u>	<u>7</u>
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN			<u>3</u>	<u>3.5</u>	<u>3</u>
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN			<u>.023</u>	<u>.023</u>	<u>.024</u>
	J) ASSEMBLE STOCK						
	K) ASSEMBLE SWIVEL STUDS						
	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	
	MALFUNCTION						
	MALFUNCTION						
	MALFUNCTION						
	MALFUNCTION						
660	INSPECT FOR LIVE AMMO						
670	FINAL INSPECTION A) HEADSPACE						
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS			<u>2.20</u>	<u>2.21</u>	<u>2.16</u>
	C) FUNCTION						
690	PACK						

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



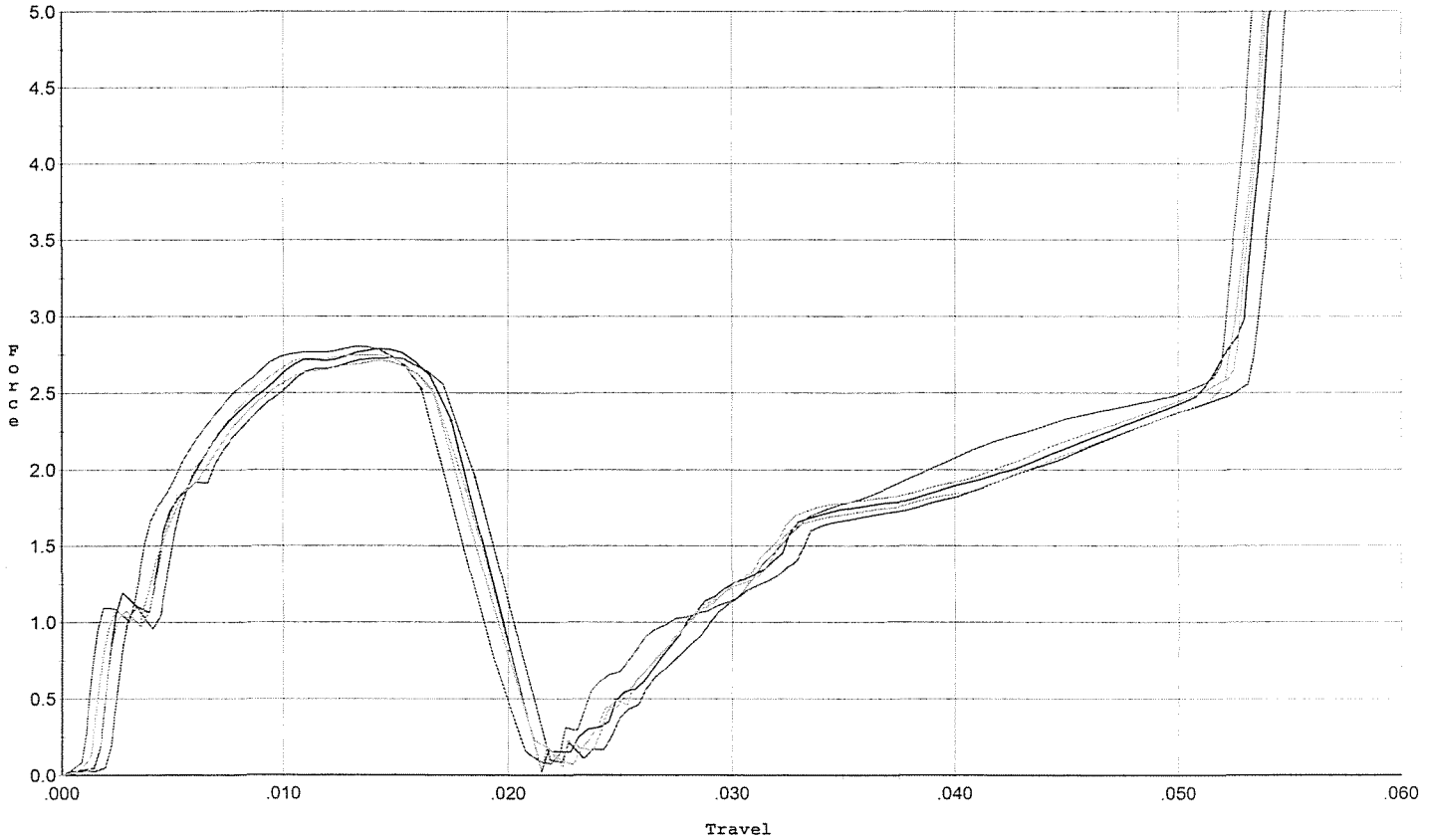
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.694	0.018	0.00	0.039	0.033		Set Trigger
2	2.614	0.017	0.00	0.040	0.030		Set Trigger
3	2.685	0.018	0.00	0.040	0.032		Set Trigger
4	2.674	0.017	0.00	0.040	0.030		Set Trigger
5	2.758	0.018	0.00	0.039	0.032		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



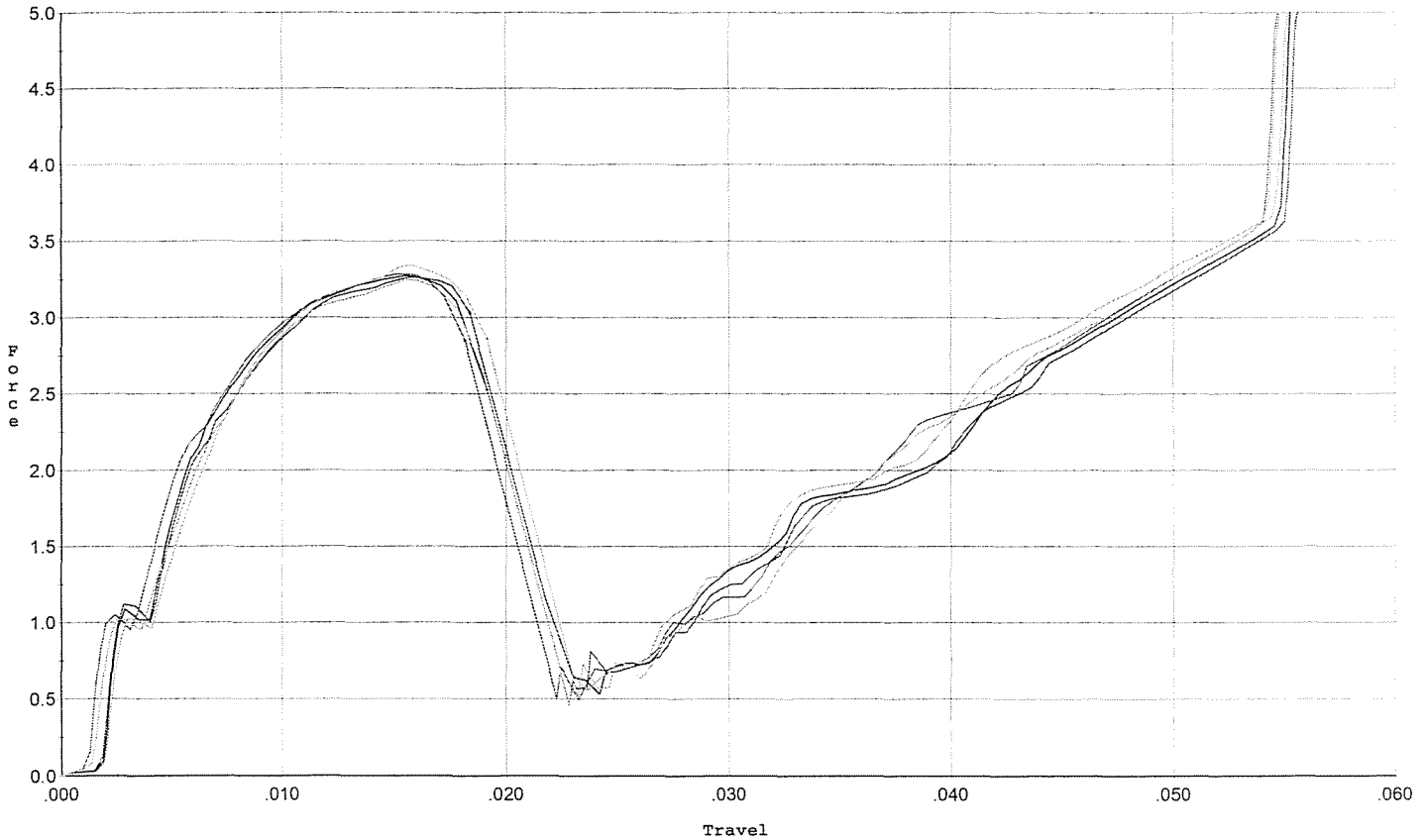
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.732	0.019	0.00	0.040	0.034		Set Trigger
2	2.788	0.017	0.004	0.040	0.033		Set Trigger
3	2.804	0.016	0.003	0.040	0.032		Set Trigger
4	2.747	0.017	0.004	0.040	0.032		Set Trigger
5	2.713	0.018	0.00	0.040	0.034		Set Trigger

A-2-75

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



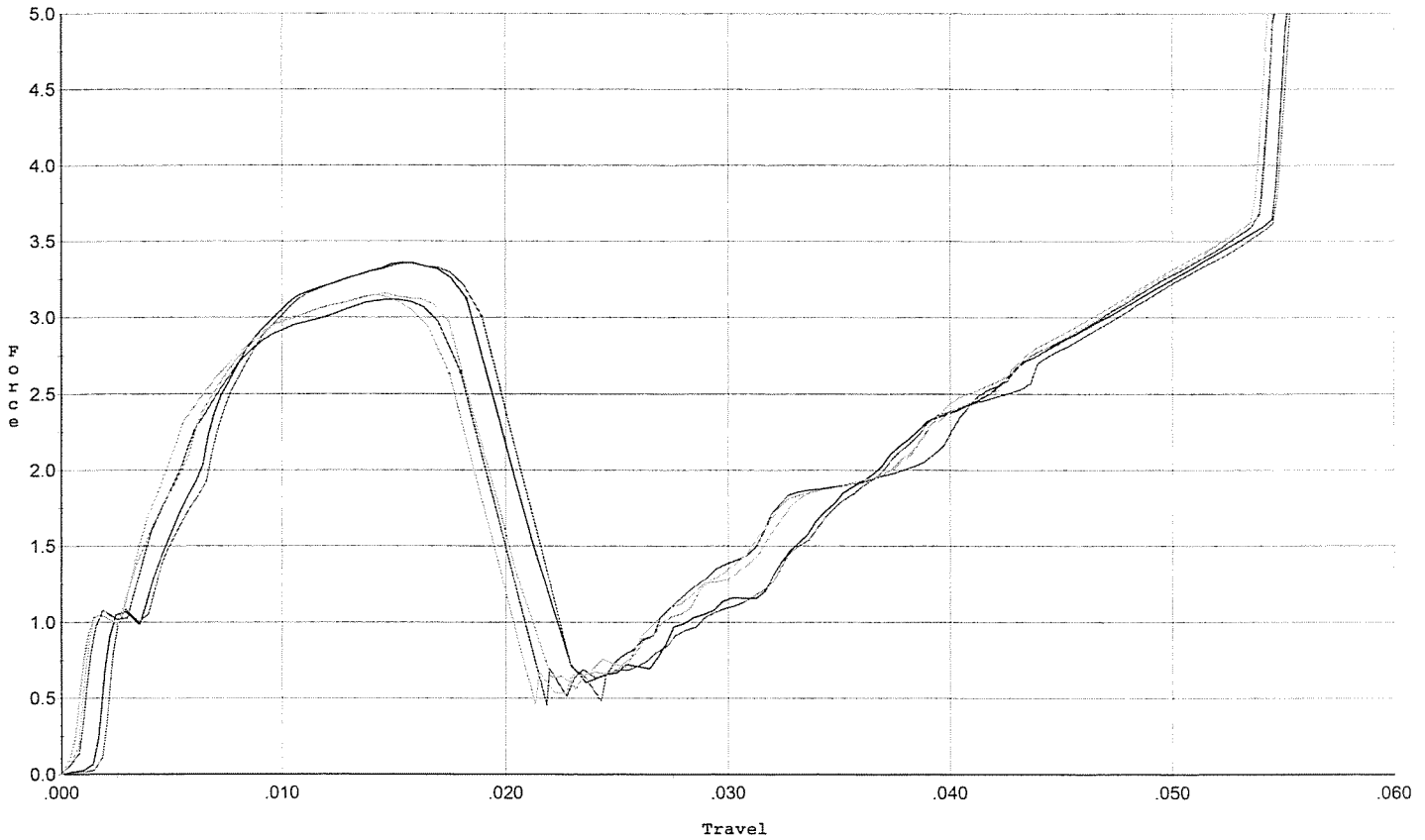
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.262	0.018	0.002	0.039	0.039		Set Trigger
2	3.273	0.019	0.004	0.039	0.041		Set Trigger
3	3.283	0.018	0.00	0.039	0.040		Set Trigger
4	3.338	0.019	0.004	0.038	0.041		Set Trigger
5	3.248	0.019	0.004	0.038	0.041		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



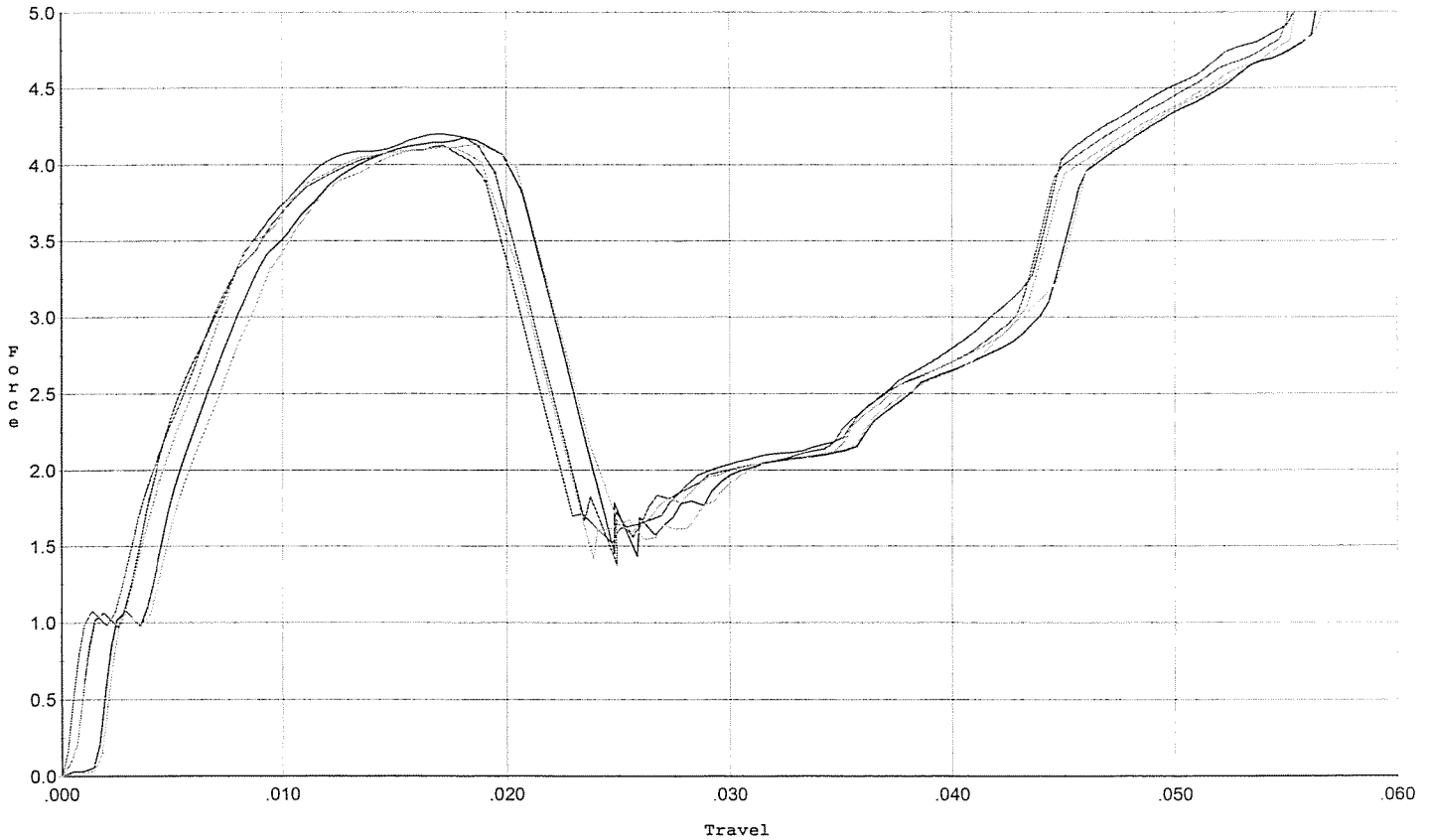
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.116	0.018	0.00	0.039	0.039		Set Trigger
2	3.359	0.018	0.00	0.039	0.041		Set Trigger
3	3.353	0.019	0.00	0.038	0.042		Set Trigger
4	3.147	0.017	0.00	0.039	0.039		Set Trigger
5	3.155	0.017	0.003	0.039	0.039		Set Trigger

A-3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



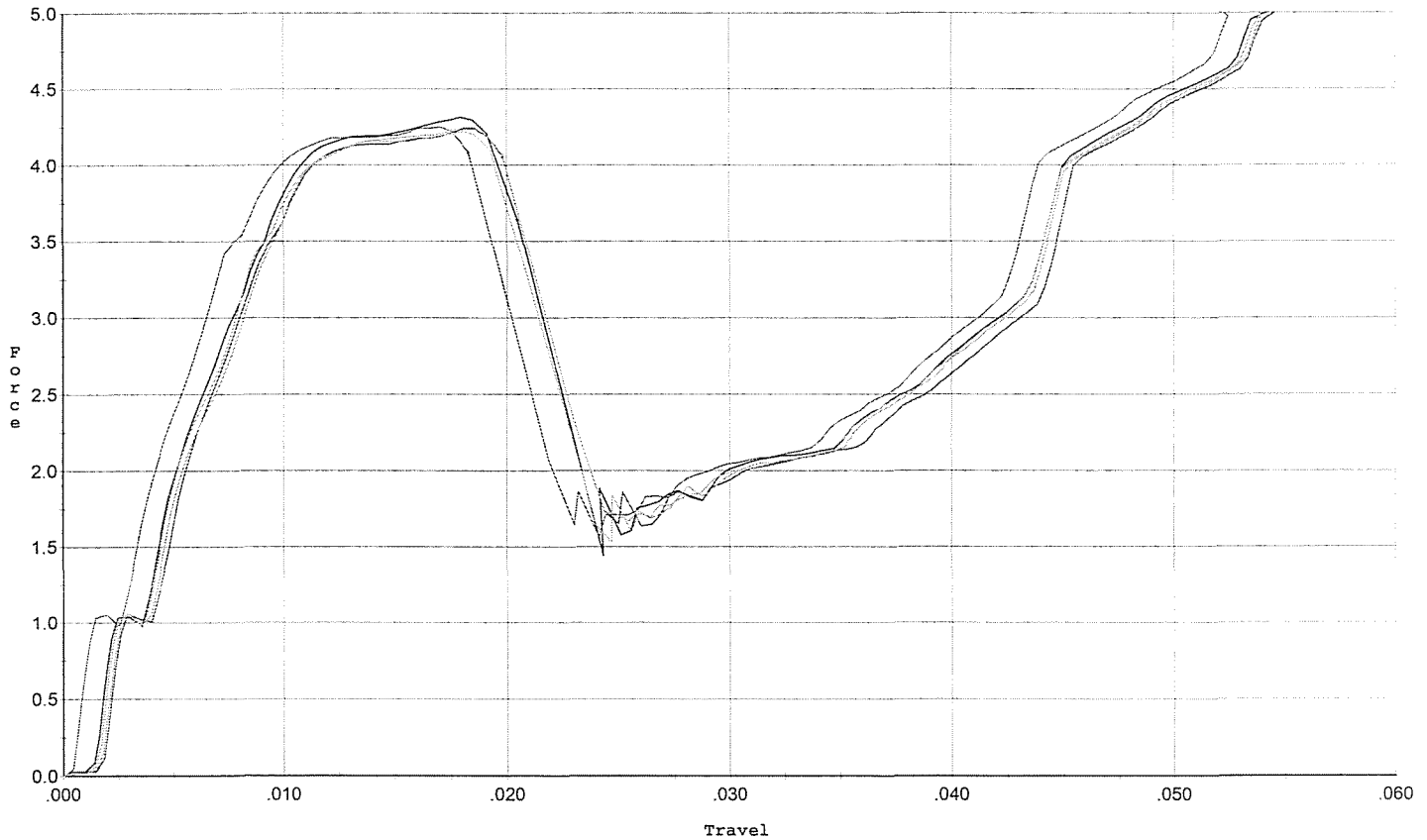
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.199	0.019	0.00	0.036	0.056		Set Trigger
2	4.177	0.021	0.00	0.036	0.057		Set Trigger
3	4.124	0.019	0.00	0.036	0.054		Set Trigger
4	4.131	0.020	0.00	0.036	0.055		Set Trigger
5	4.115	0.020	0.00	0.036	0.057		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



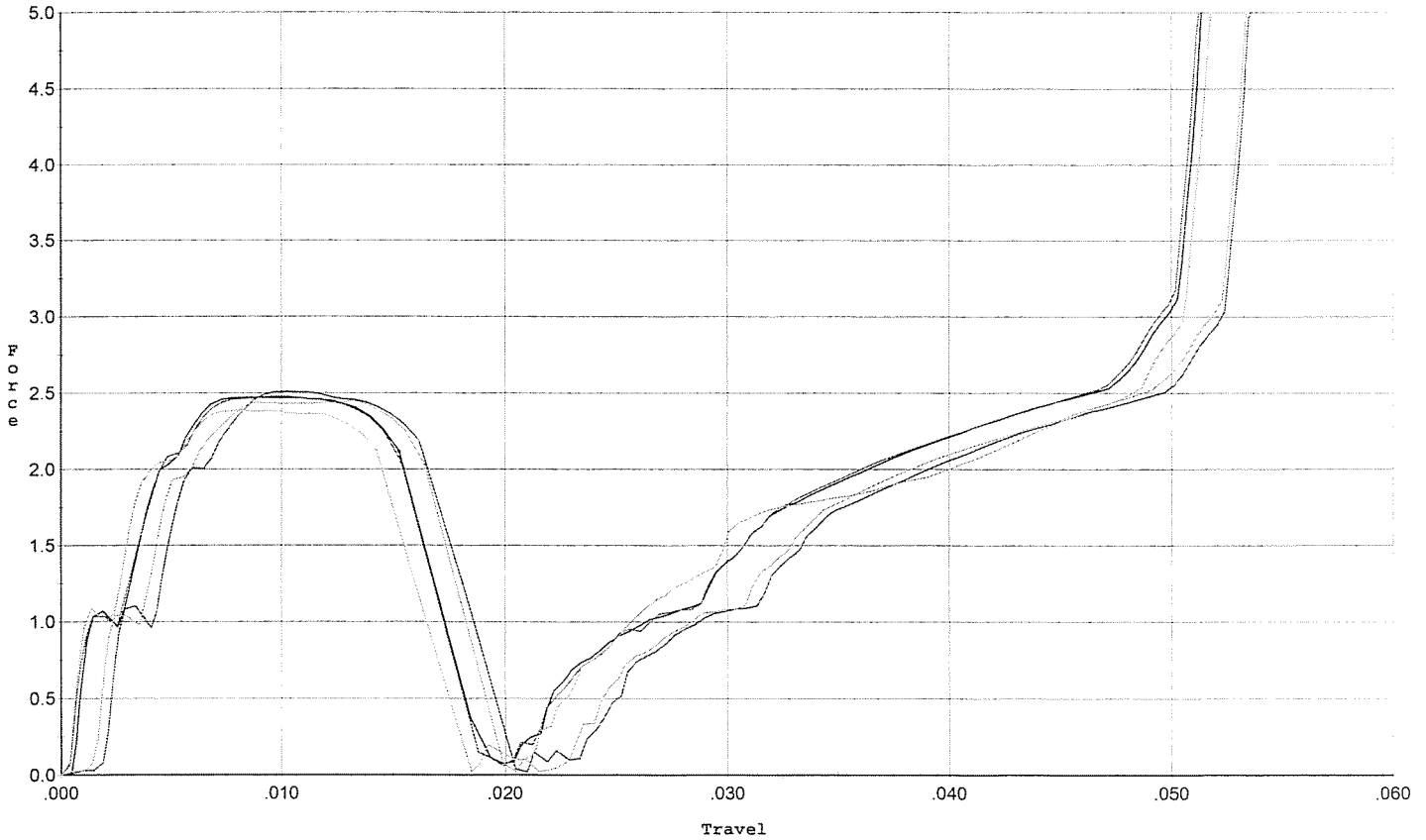
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.239	0.020	0.004	0.036	0.054		Set Trigger
2	4.314	0.020	0.004	0.036	0.057		Set Trigger
3	4.249	0.018	0.00	0.035	0.053		Set Trigger
4	4.220	0.022	0.00	0.036	0.059		Set Trigger
5	4.246	0.020	0.00	0.036	0.054		Set Trigger

A-4.25

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



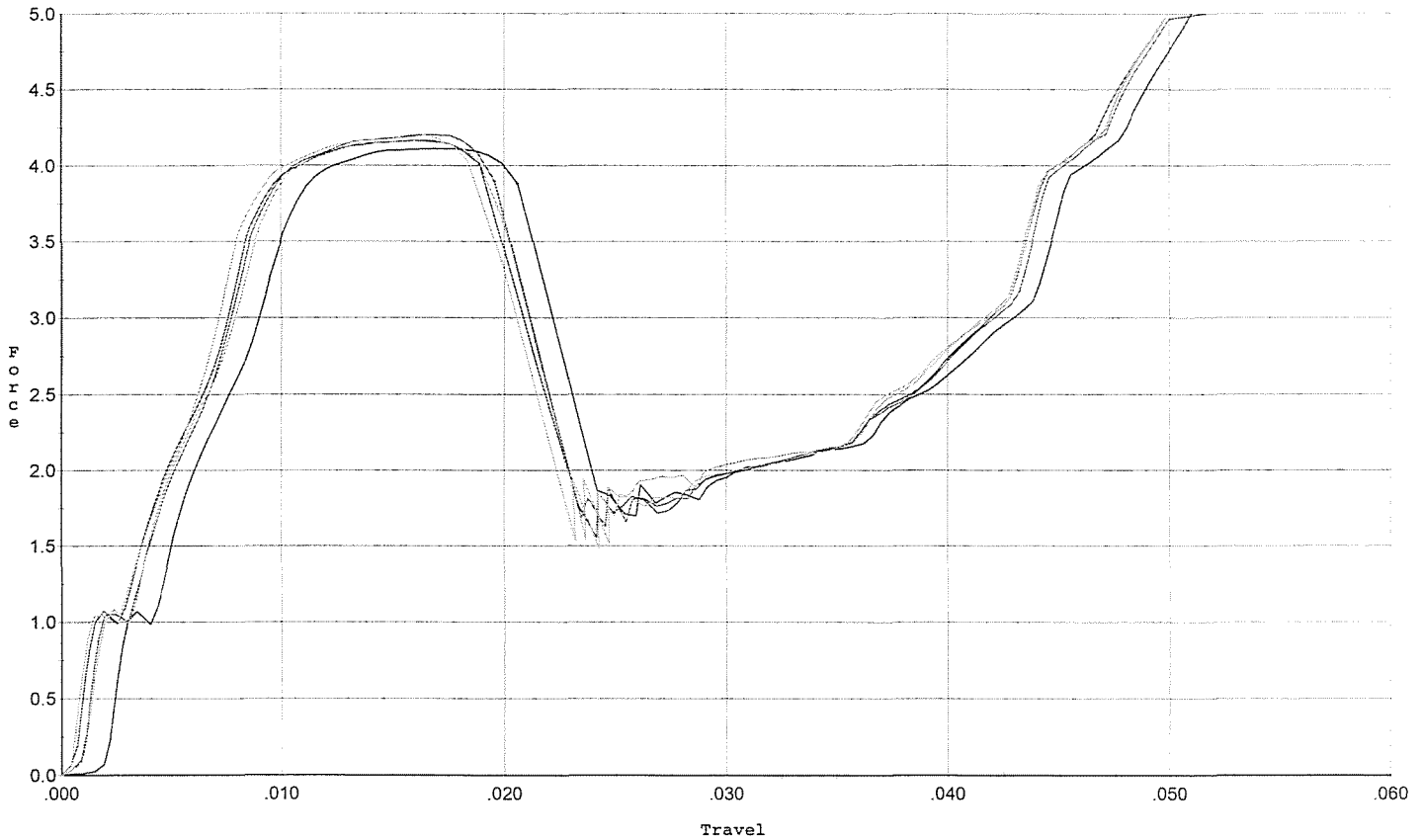
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.510	0.018	0.00	0.040	0.031		Set Trigger
2	2.469	0.015	0.00	0.039	0.028		Set Trigger
3	2.477	0.015	0.003	0.039	0.028		Set Trigger
4	2.386	0.014	0.00	0.041	0.026		Set Trigger
5	2.450	0.016	0.004	0.040	0.029		Set Trigger

A-2-45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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	4.164	0.019	0.00	0.033	0.053		Set Trigger
2	4.110	0.021	0.00	0.033	0.055		Set Trigger
3	4.201	0.020	0.00	0.033	0.055		Set Trigger
4	4.207	0.020	0.00	0.033	0.056		Set Trigger
5	4.169	0.020	0.00	0.033	0.056		Set Trigger

A-4.17