

66807800

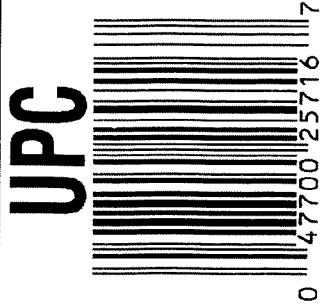
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807800



BM FORM

GUN SERIAL # G6807800

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RPD
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RPD
460	CHECK HEADSPACE	MAGNA-FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RIZ
480	MAGNAFLUX BBL ACTION	OPERA (A)	3/5/09	(A)
490	MAGNAFLUX BOLT		3/5/09	mk
500	ROLLMARK CALIBER		3/5/09	RT
510	DRILL AND TAP SIGHT HOLES		3-2-09	JP
520	GOFF BLAST BBL / REC		3/6	non
540	APPLY COATINGS (BARREL ACTION)		3/16	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	JP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	JP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	JP
	D) OIL FIRING PIN ASSEMBLY		3-16-09	RPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

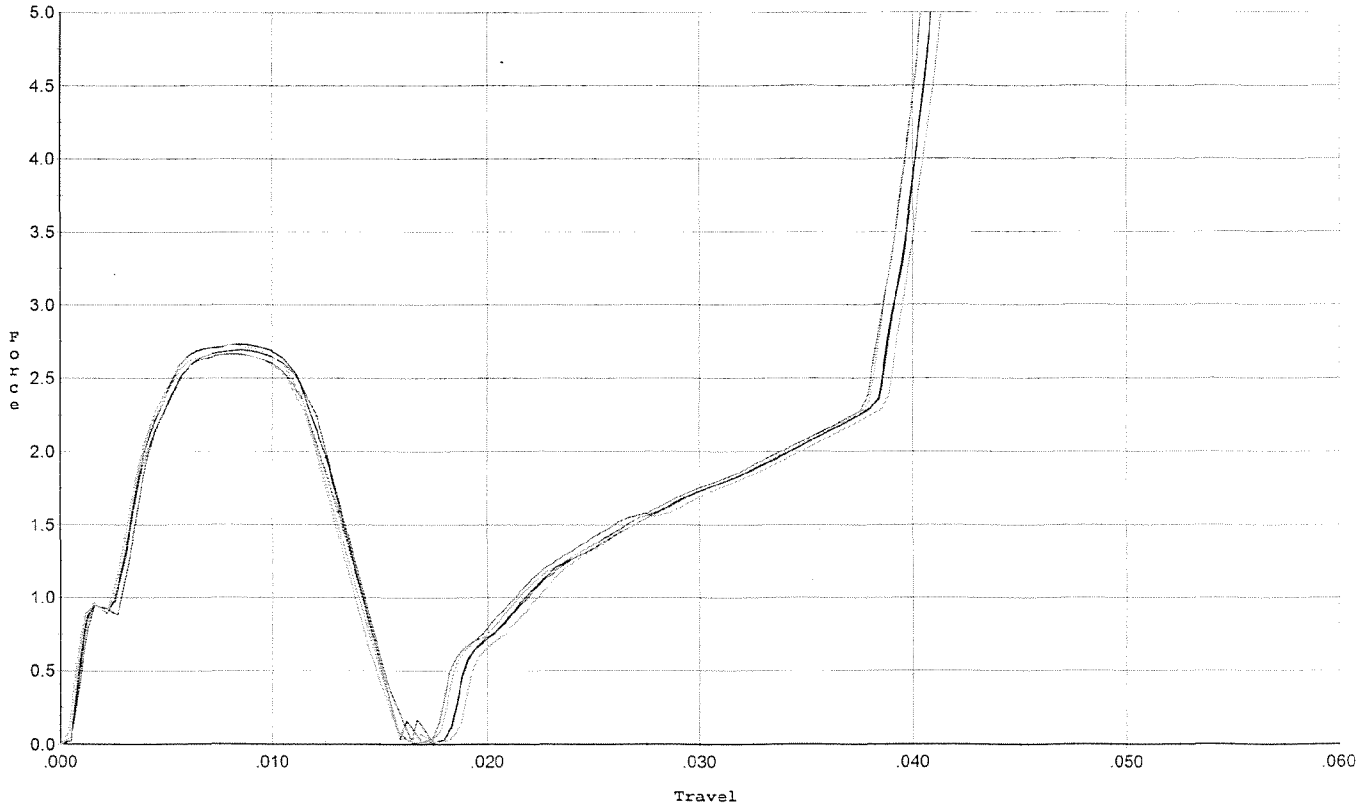
OP #	OPERATION NAME	READINGS	DATE	INITIAL
BARBER - M24 0017748				
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	3-20-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-20-09	NW
	J) ASSEMBLE STOCK		3-16-09	RPD
	K) ASSEMBLE SWIVEL STUDS		3-20-09	NW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	3-19-09	RPD
650	TARGET	<u>PASS</u> FAIL		
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-19-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.45</u> <u>2.50</u> <u>2.40</u> <u>2.37</u>	3-20-09	TC
	C) FUNCTION		3-20-09	NW
690	PACK		3-21-09	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



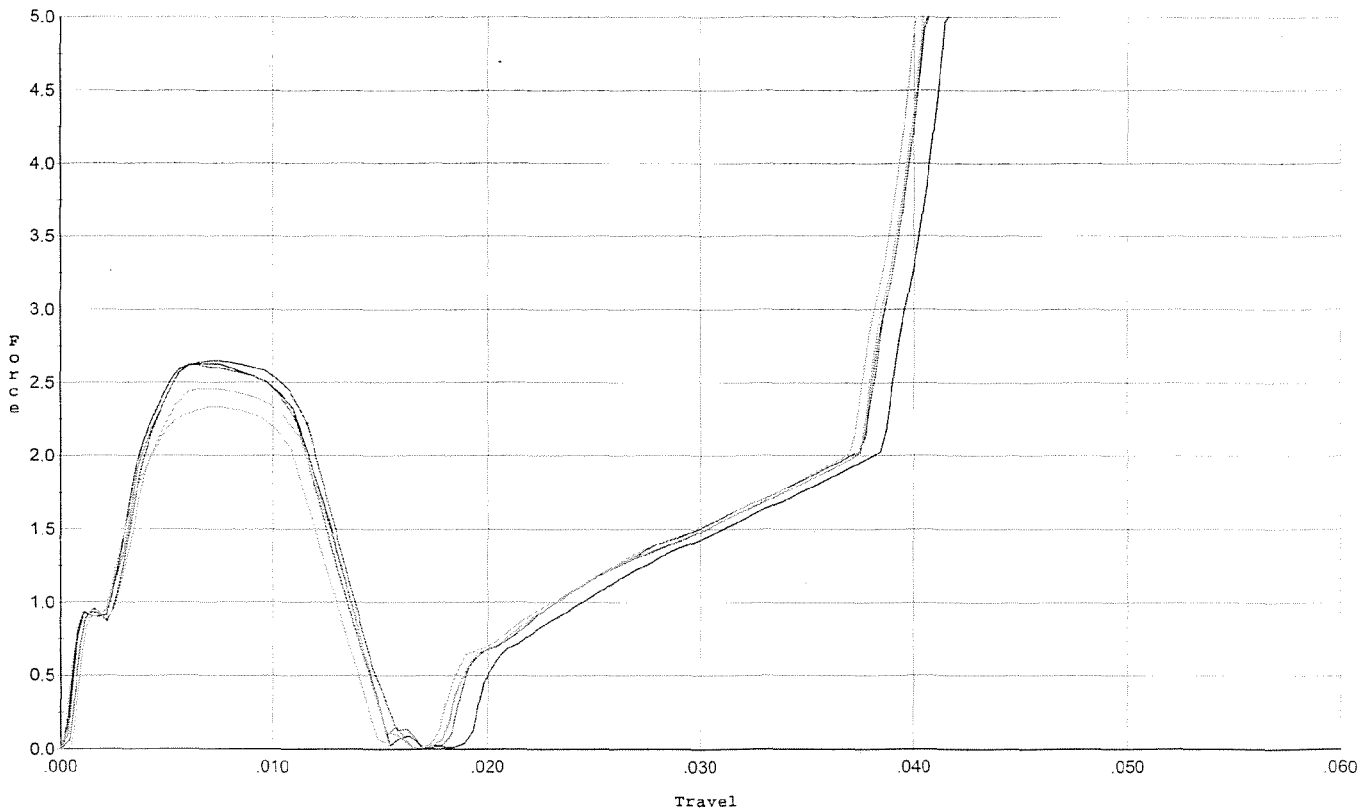
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.689	0.012	0.003	0.032	0.022		Set Trigger
2	2.731	0.013	0.00	0.032	0.023		Set Trigger
3	2.661	0.013	0.00	0.032	0.024		Set Trigger
4	2.668	0.012	0.00	0.033	0.021		Set Trigger
5	2.724	0.011	0.00	0.033	0.021		Set Trigger

A. 2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



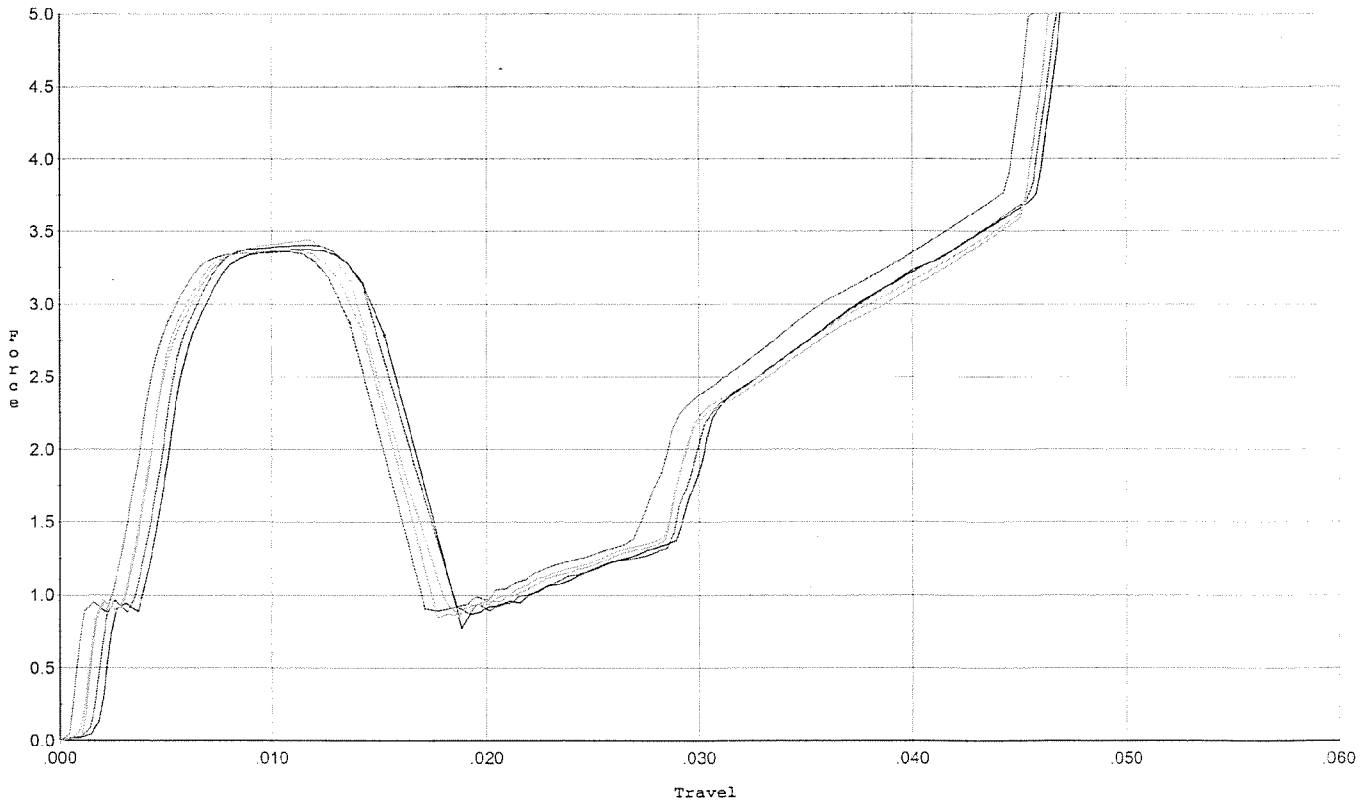
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.648	0.012	0.00	0.033	0.021		Set Trigger
2	2.628	0.013	0.00	0.034	0.023		Set Trigger
3	2.621	0.011	0.002	0.033	0.020		Set Trigger
4	2.333	0.011	0.00	0.033	0.018		Set Trigger
5	2.459	0.013	0.00	0.033	0.022		Set Trigger

A-253

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



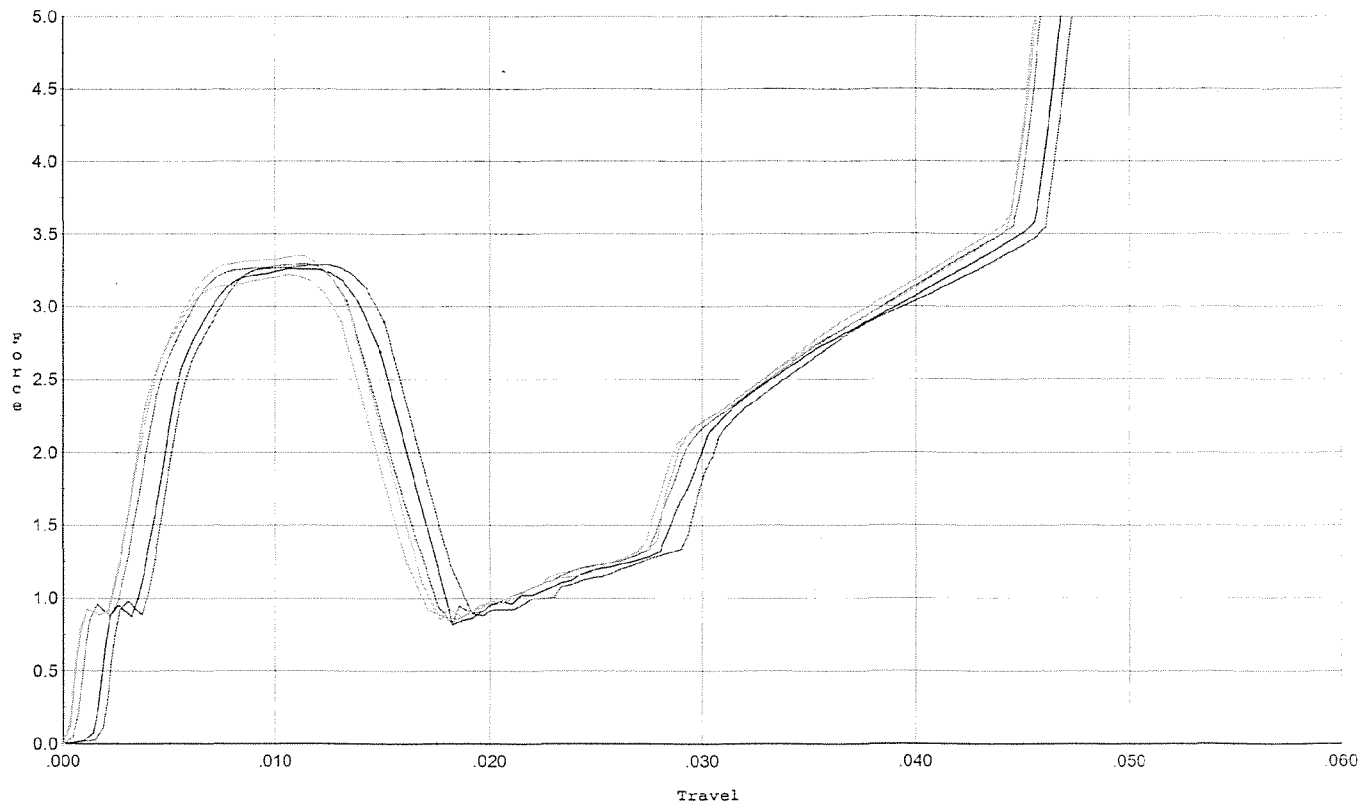
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.403	0.014	0.00	0.034	0.031		Set Trigger
2	3.372	0.015	0.00	0.034	0.033		Set Trigger
3	3.358	0.014	0.00	0.033	0.032		Set Trigger
4	3.440	0.014	0.00	0.034	0.031		Set Trigger
5	3.369	0.014	0.00	0.034	0.032		Set Trigger

A-3.38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



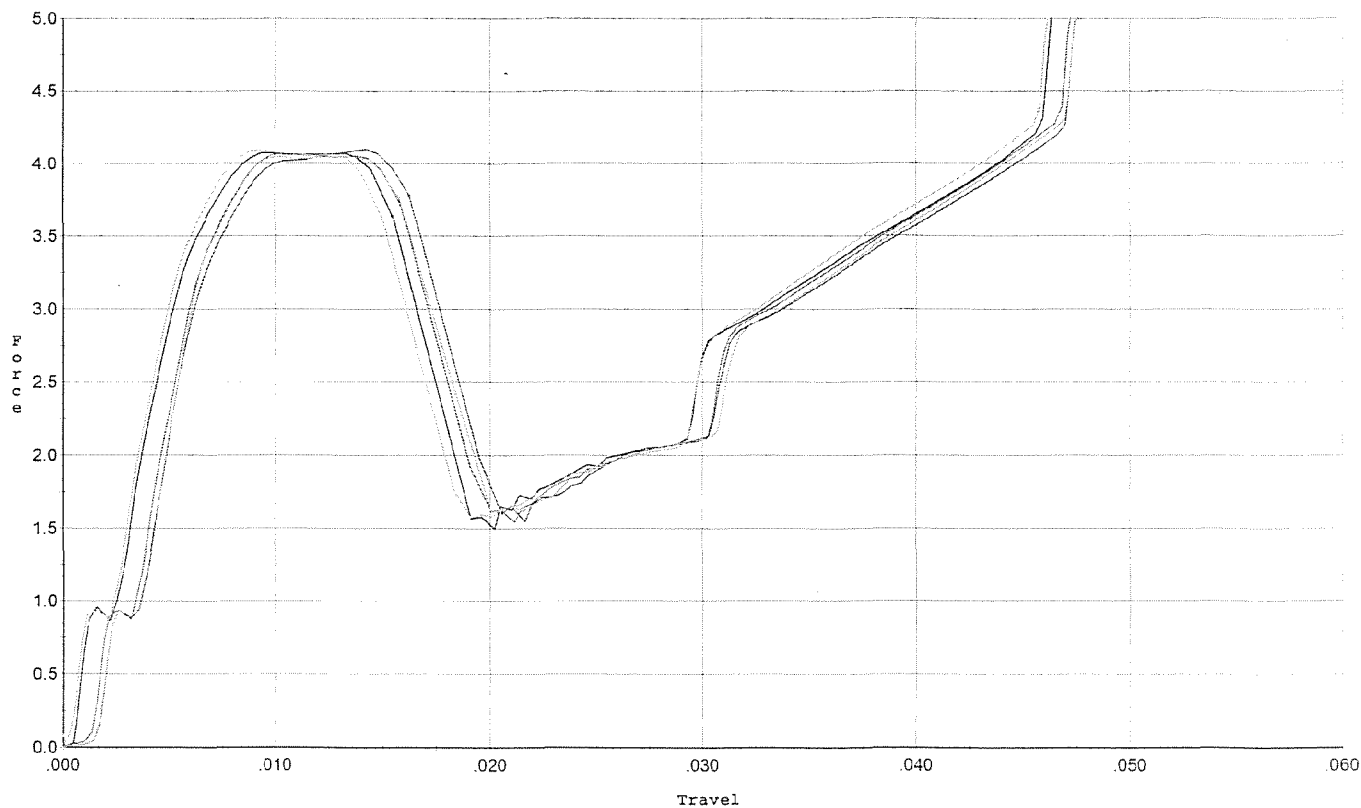
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.287	0.015	0.00	0.034	0.032		Set Trigger
2	3.258	0.015	0.00	0.034	0.032		Set Trigger
3	3.295	0.013	0.00	0.034	0.030		Set Trigger
4	3.347	0.013	0.00	0.034	0.031		Set Trigger
5	3.220	0.013	0.00	0.034	0.030		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



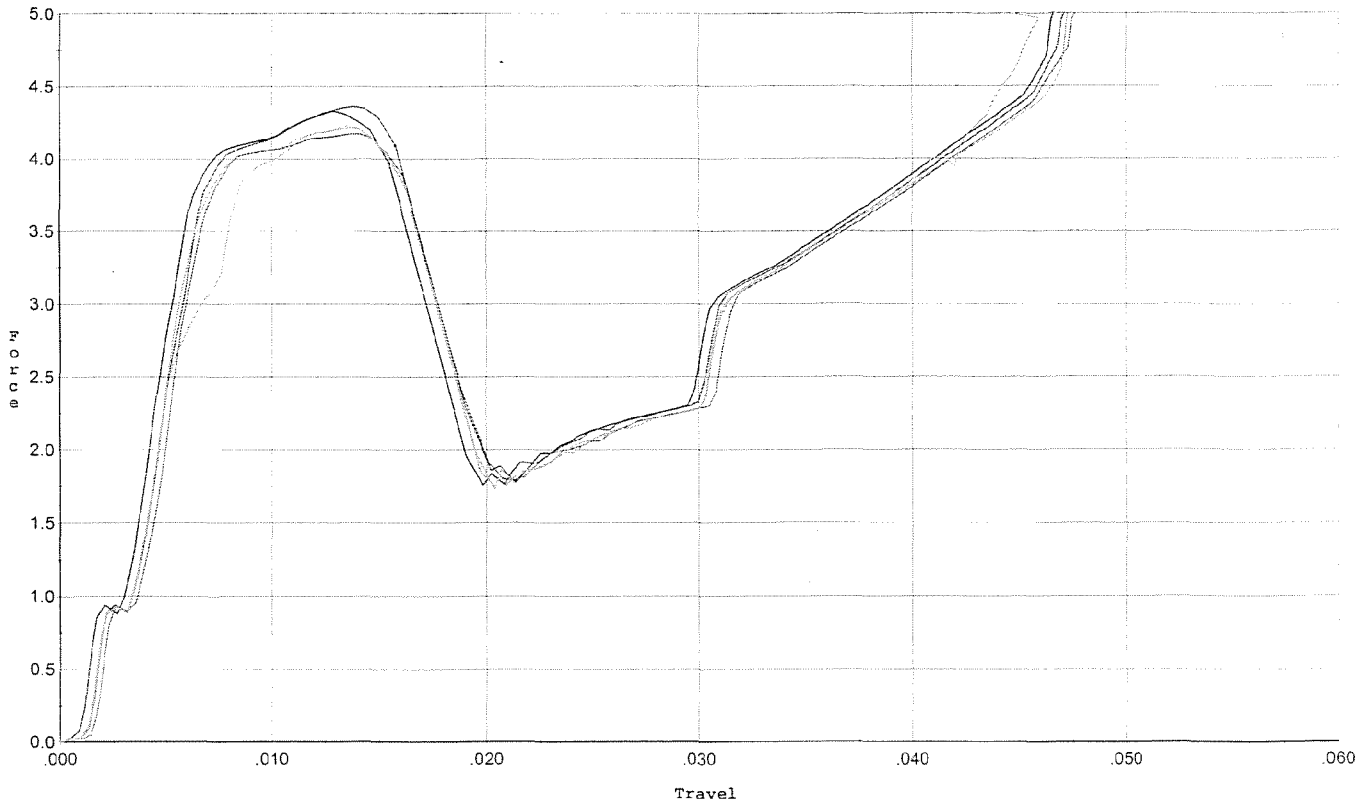
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.099	0.016	0.00	0.031	0.043		Set Trigger
2	4.074	0.015	0.00	0.031	0.043		Set Trigger
3	4.069	0.016	0.00	0.031	0.042		Set Trigger
4	4.095	0.015	0.00	0.031	0.042		Set Trigger
5	4.047	0.016	0.00	0.032	0.041		Set Trigger

A. 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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	4.361	0.016	0.00	0.031	0.044		Set Trigger
2	4.331	0.015	0.00	0.030	0.044		Set Trigger
3	4.173	0.016	0.00	0.031	0.043		Set Trigger
4	4.212	0.016	0.00	0.031	0.044		Set Trigger
5	4.228	0.016	0.00	0.031	0.043		Set Trigger

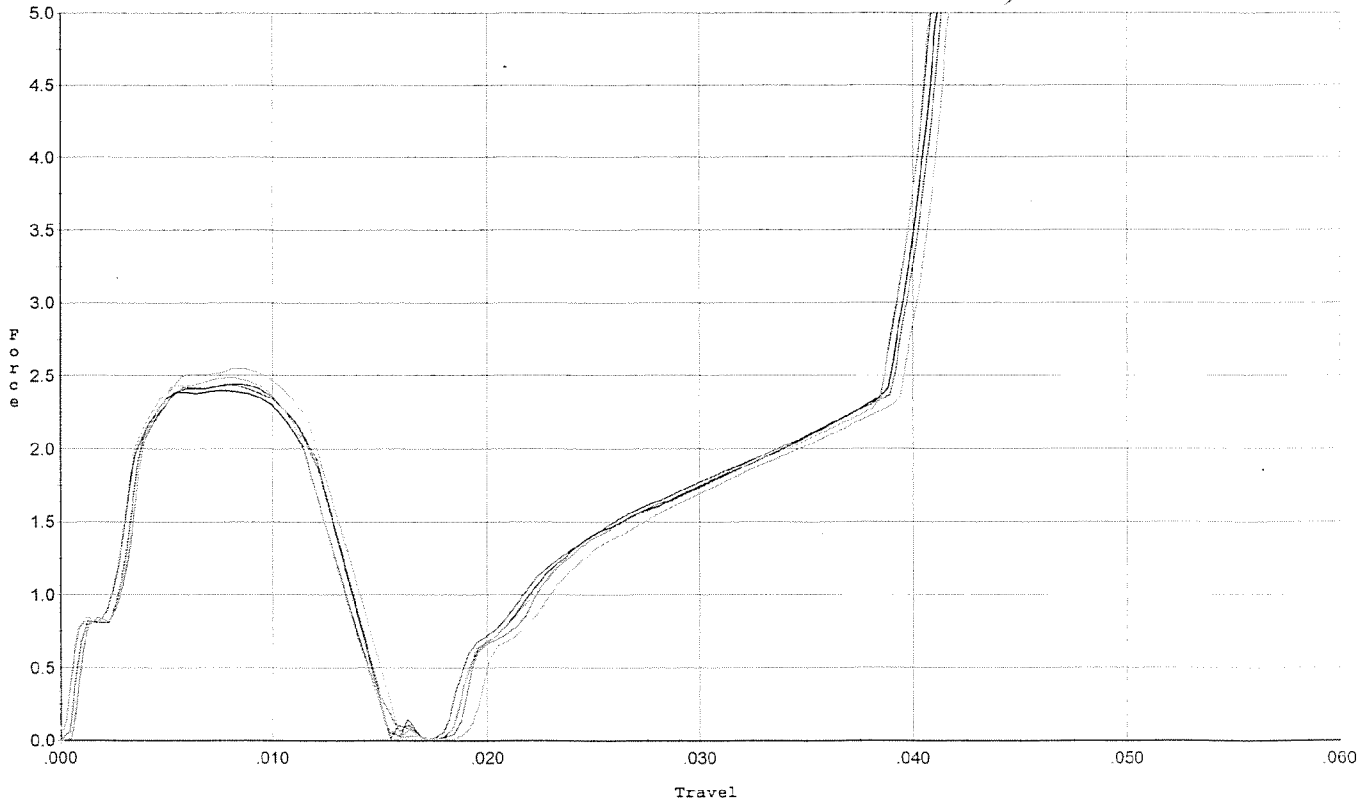
A-4.26

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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

to (cons)



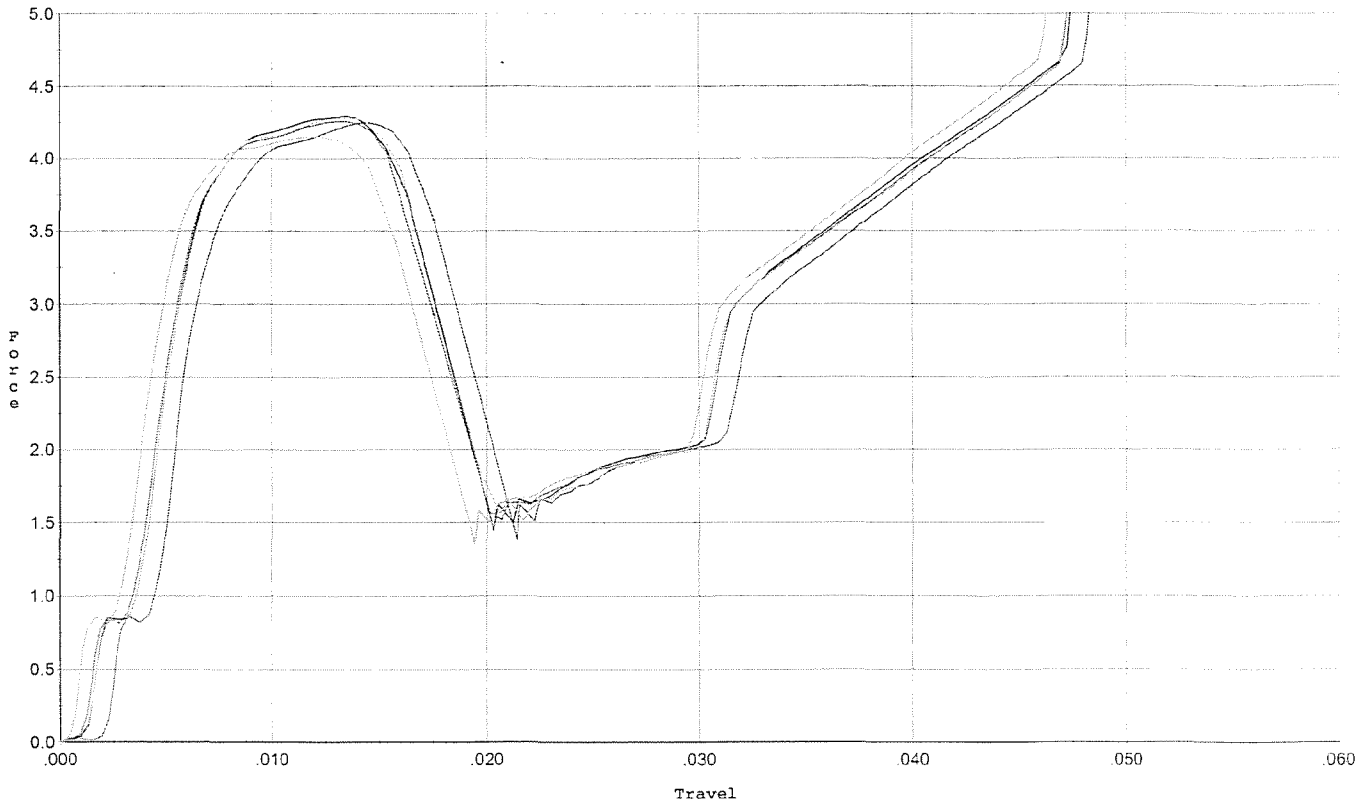
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.444	0.012	0.003	0.033	0.021		Set Trigger
2	2.396	0.011	0.00	0.034	0.020		Set Trigger
3	2.442	0.012	0.00	0.033	0.020		Set Trigger
4	2.485	0.011	0.00	0.033	0.020		Set Trigger
5	2.550	0.014	0.00	0.033	0.024		Set Trigger

A-2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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	4.247	0.018	0.002	0.032	0.046		Set Trigger
2	4.295	0.016	0.004	0.031	0.045		Set Trigger
3	4.257	0.018	0.00	0.031	0.048		Set Trigger
4	4.282	0.016	0.00	0.031	0.044		Set Trigger
5	4.150	0.016	0.00	0.031	0.044		Set Trigger

A - 4.24