

G6801340

Oxford.
NO. 752 1/3
JUN

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

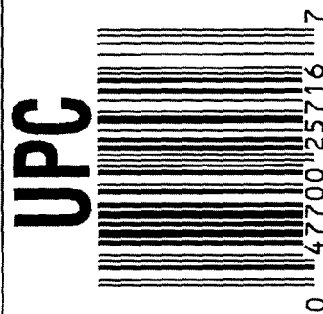
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801340



GUN SERIAL # G 6801340

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	RT
460	CHECK HEADSPACE		3-6-09	RT
470	DIS-ASSEMBLE ACTION		3-6-09	RT
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	3-9-09	RT
475	DRILL AND TAP SIGHT HOLES		3-9-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	3/13/09	(H)
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		3-25-09	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		3-24-09	L. J.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

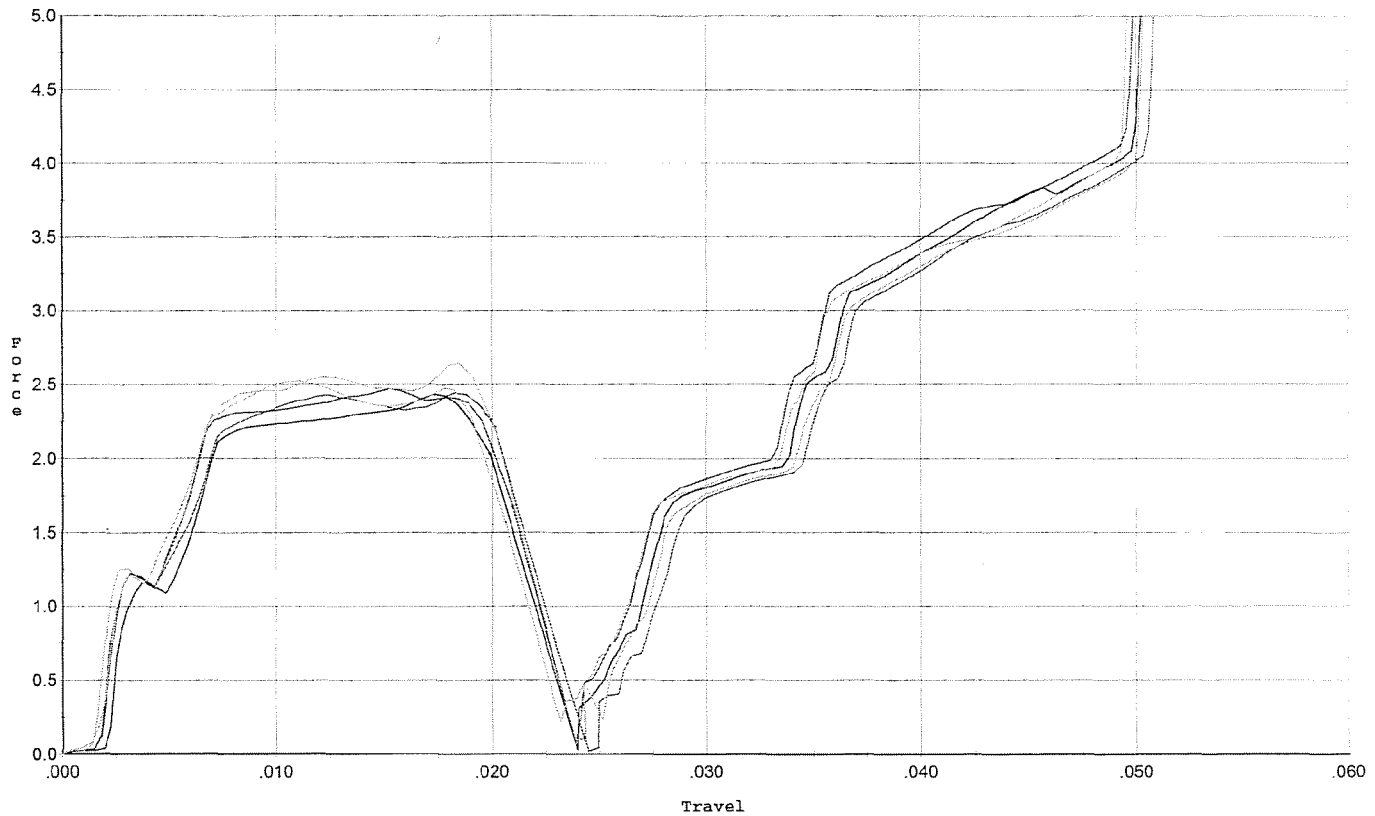
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>30</u>	3-31-09	ZD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	3-31-09	ZD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-31-09	ZD
	J) ASSEMBLE STOCK		3-24-09	RR
	K) ASSEMBLE SWIVEL STUDS		3-31-09	ZD
	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	3-27-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	WR
670	FINAL INSPECTION A) HEADSPACE		3-31-09	ZD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.45</u> <u>2.48</u> <u>2.50</u> <u>2.49</u>	3-31-09	TC
	C) FUNCTION		3-31-09	ZD
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



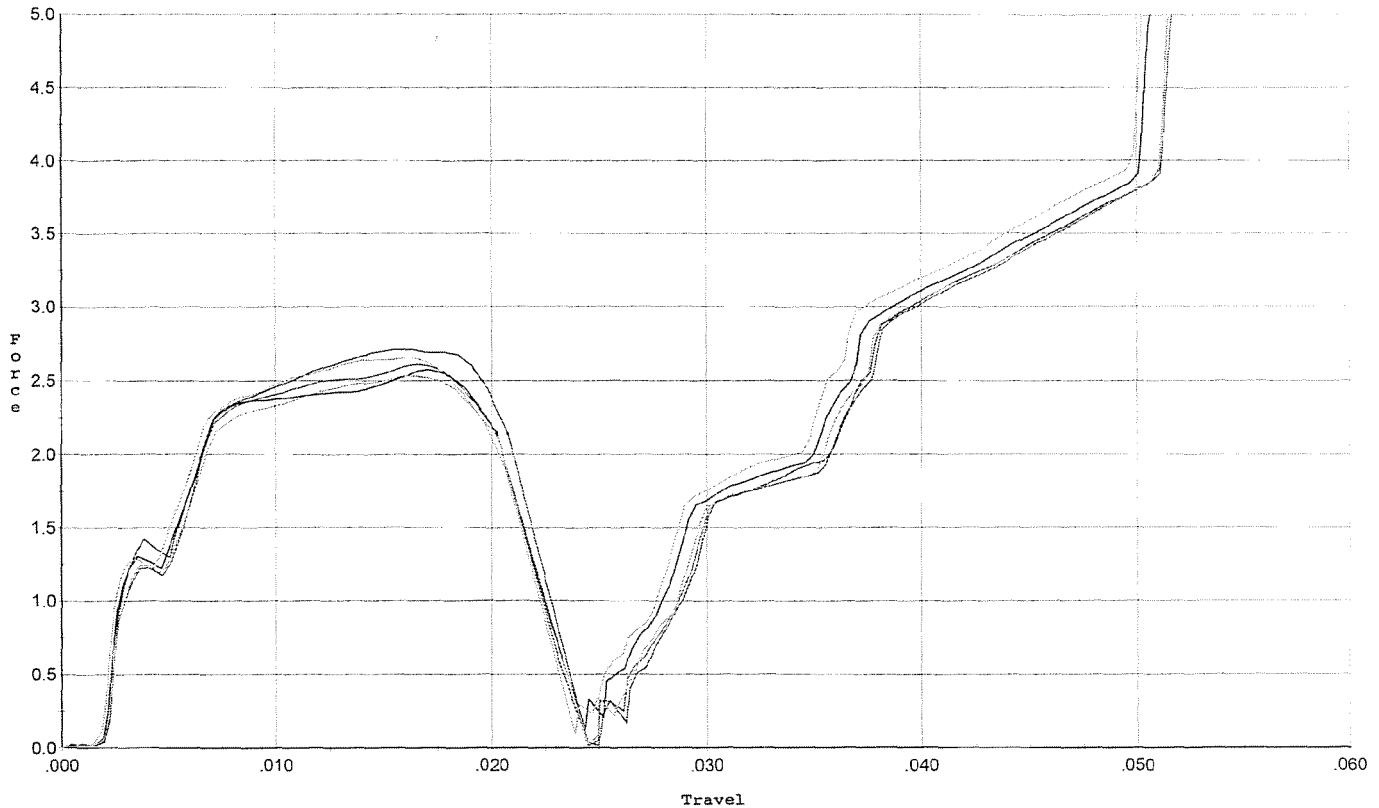
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.468	0.021	0.002	0.033	0.038		Set Trigger
2	2.429	0.020	0.005	0.034	0.034		Set Trigger
3	2.439	0.020	0.005	0.034	0.036		Set Trigger
4	2.522	0.021	0.004	0.033	0.038		Set Trigger
5	2.645	0.020	0.005	0.034	0.038		Set Trigger

A-2.50

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



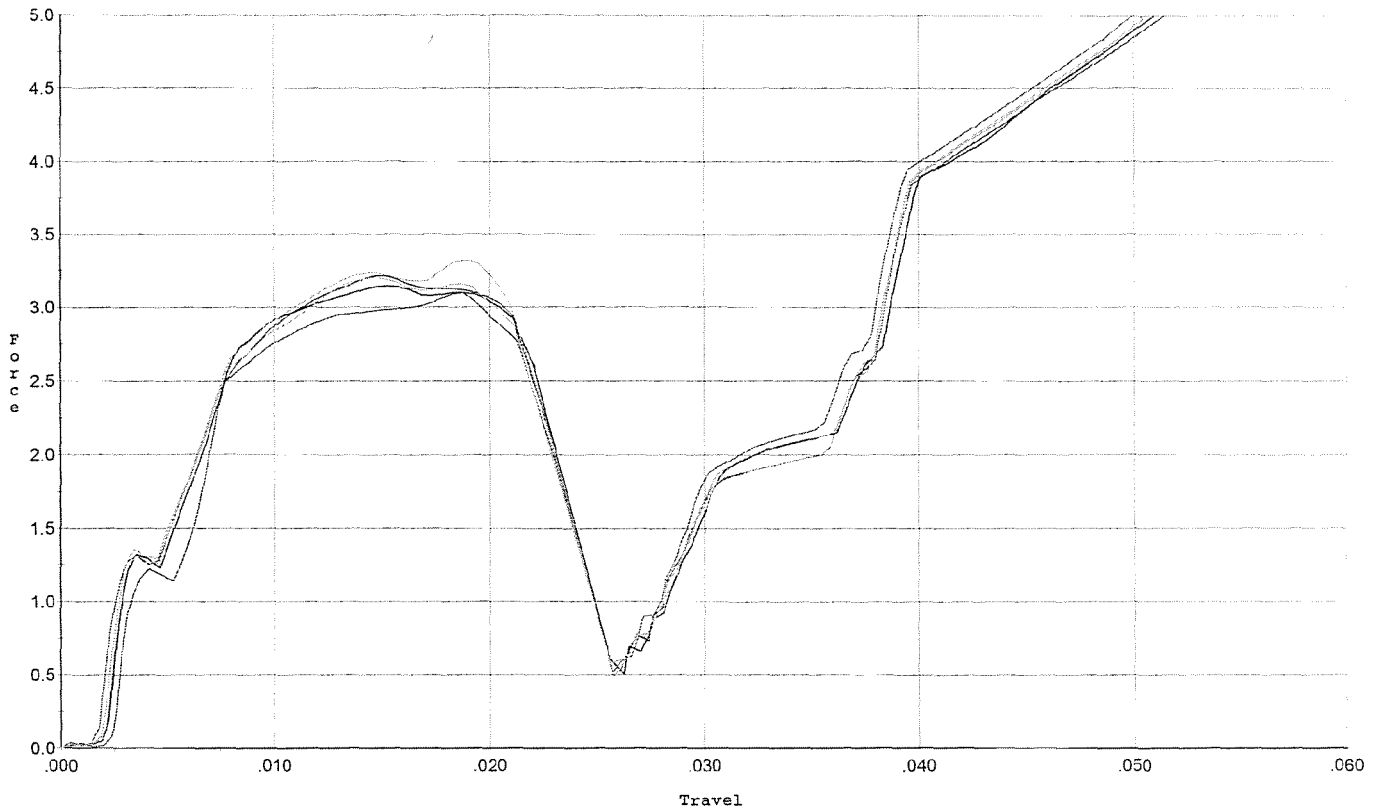
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.710	0.021	0.005	0.035	0.040		Set Trigger
2	2.574	0.020	0.002	0.034	0.037		Set Trigger
3	2.612	0.020	0.002	0.035	0.037		Set Trigger
4	2.653	0.021	0.00	0.033	0.039		Set Trigger
5	2.534	0.020	0.002	0.035	0.036		Set Trigger

A.2.61

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



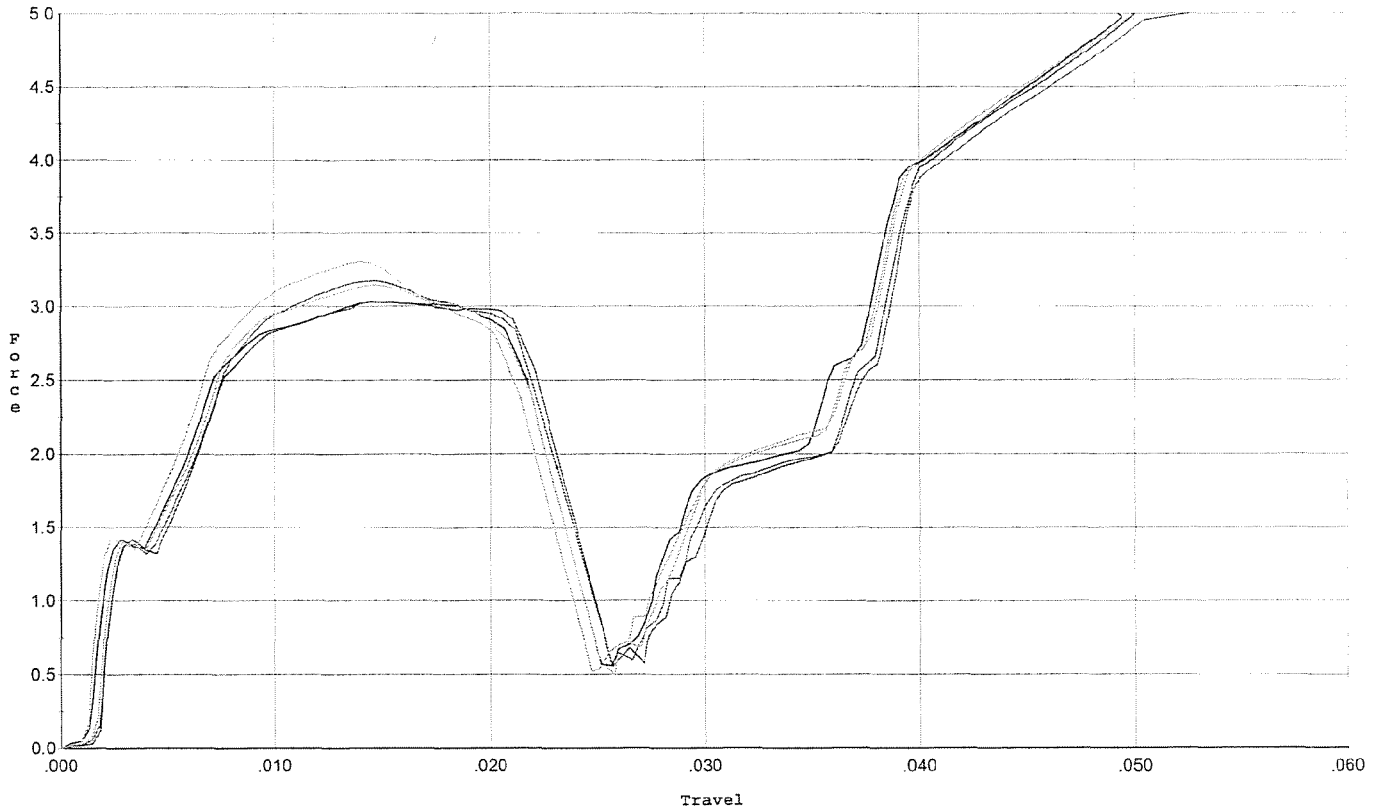
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.215	0.023	0.002	0.033	0.049		Set Trigger
2	3.145	0.022	0.002	0.033	0.048		Set Trigger
3	3.099	0.023	0.00	0.032	0.049		Set Trigger
4	3.204	0.023	0.002	0.033	0.051		Set Trigger
5	3.319	0.022	0.005	0.033	0.050		Set Trigger

H-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



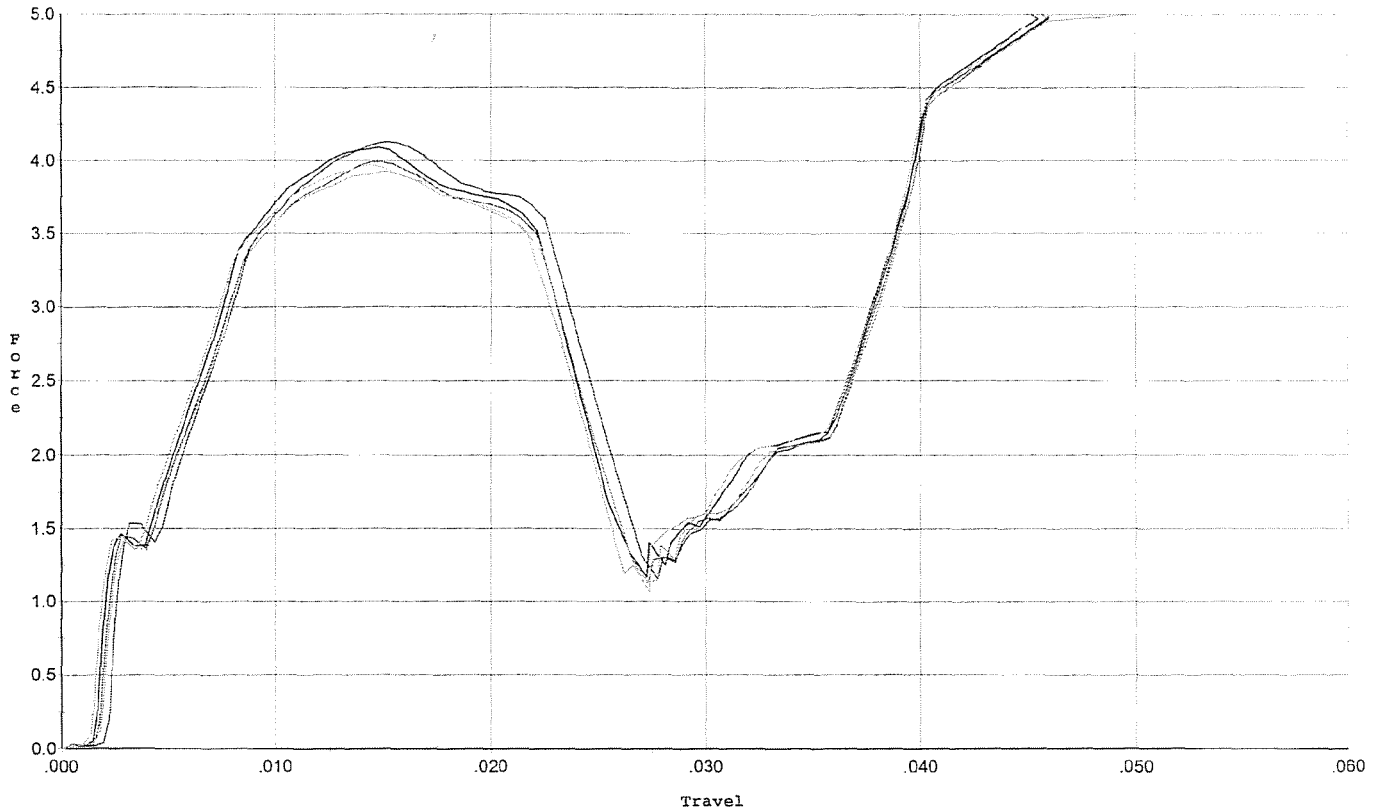
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.031	0.022	0.005	0.033	0.048		Set Trigger
2	3.034	0.022	0.004	0.033	0.048		Set Trigger
3	3.174	0.023	0.00	0.033	0.051		Set Trigger
4	3.145	0.022	0.004	0.033	0.049		Set Trigger
5	3.305	0.021	0.004	0.033	0.050		Set Trigger

A-3-13

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



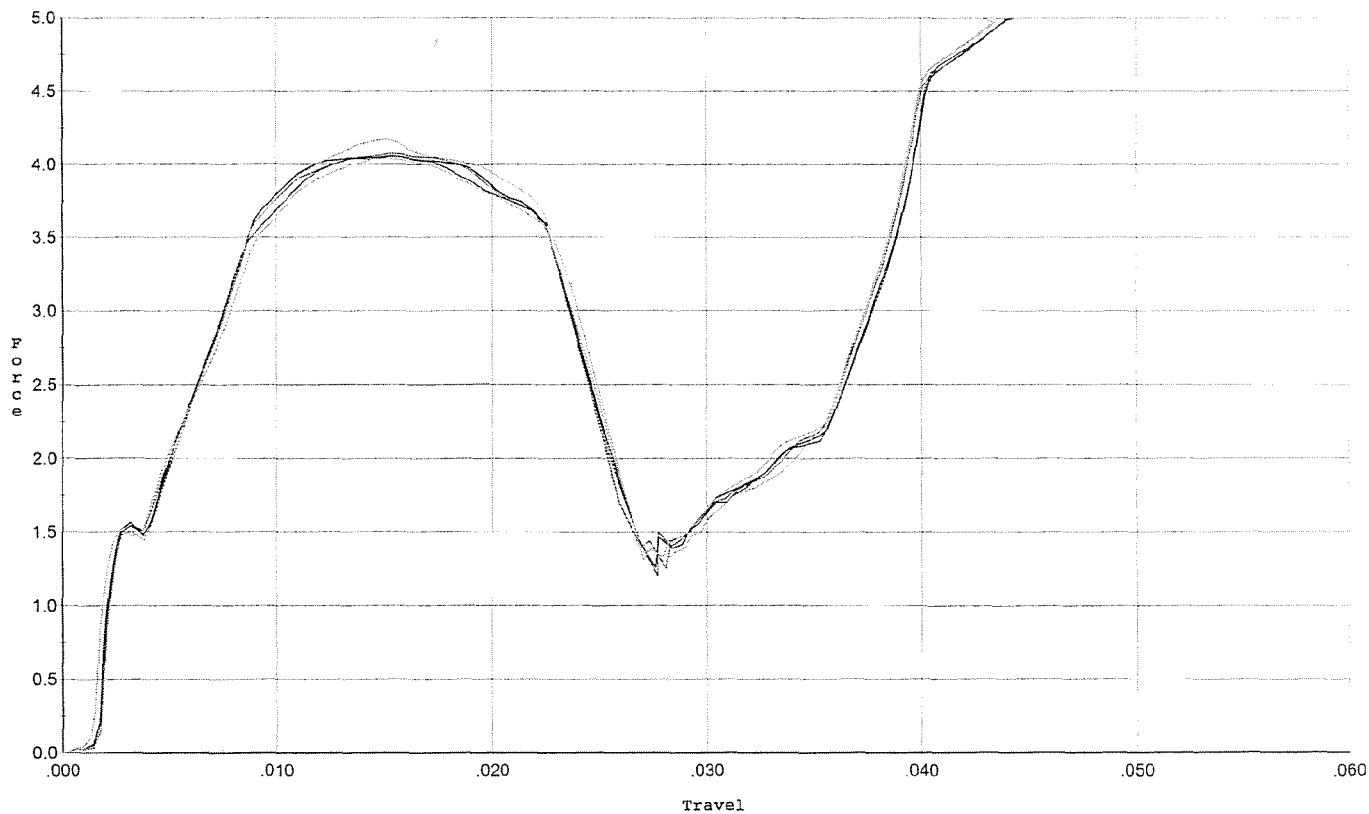
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.023	0.002	0.032	0.062		Set Trigger
2	4.089	0.022	0.004	0.032	0.062		Set Trigger
3	3.991	0.022	0.004	0.032	0.060		Set Trigger
4	3.972	0.023	0.00	0.032	0.064		Set Trigger
5	3.924	0.022	0.004	0.032	0.060		Set Trigger

A-4.02

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



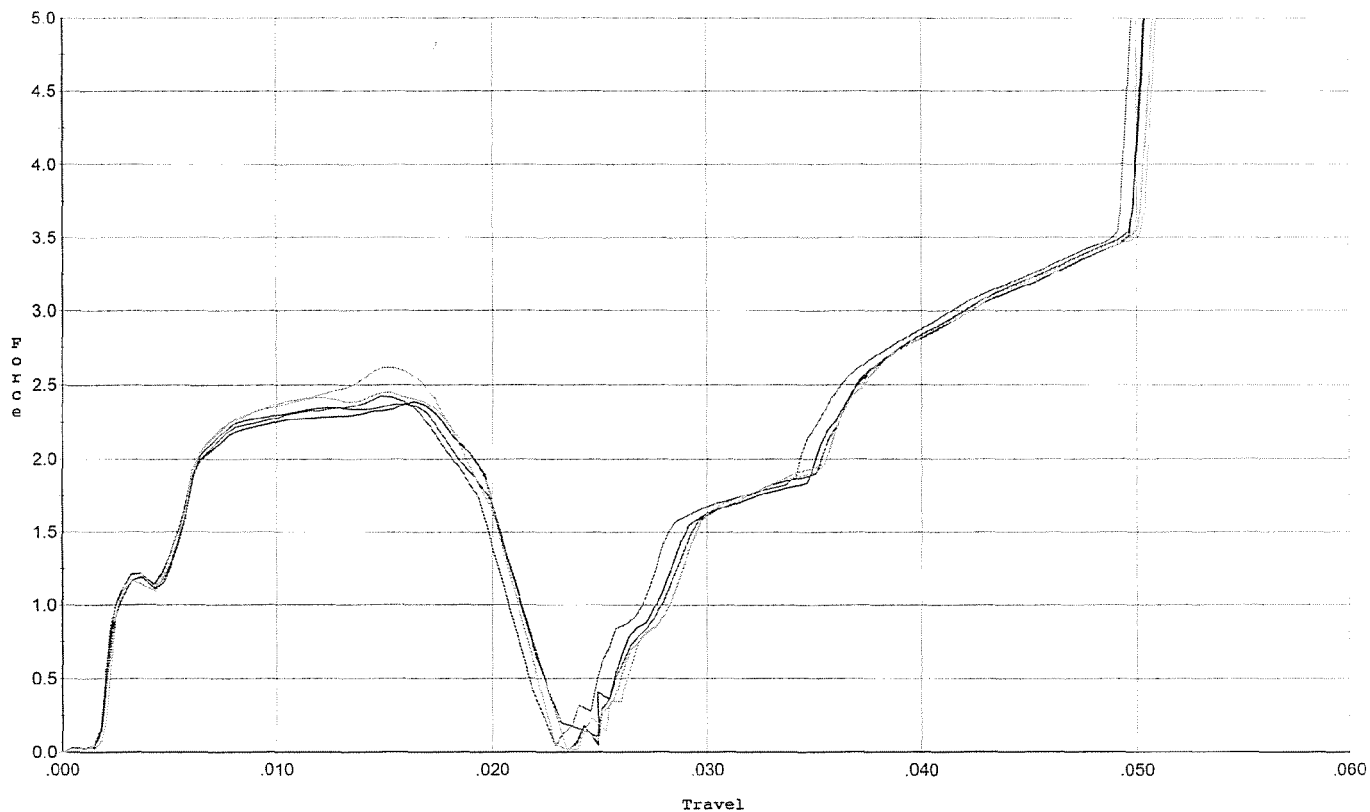
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.052	0.023	0.00	0.032	0.064		Set Trigger
2	4.058	0.023	0.00	0.031	0.064		Set Trigger
3	4.072	0.023	0.00	0.031	0.064		Set Trigger
4	4.036	0.025	0.00	0.030	0.069		Set Trigger
5	4.171	0.024	0.00	0.031	0.068		Set Trigger

A-4.07

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



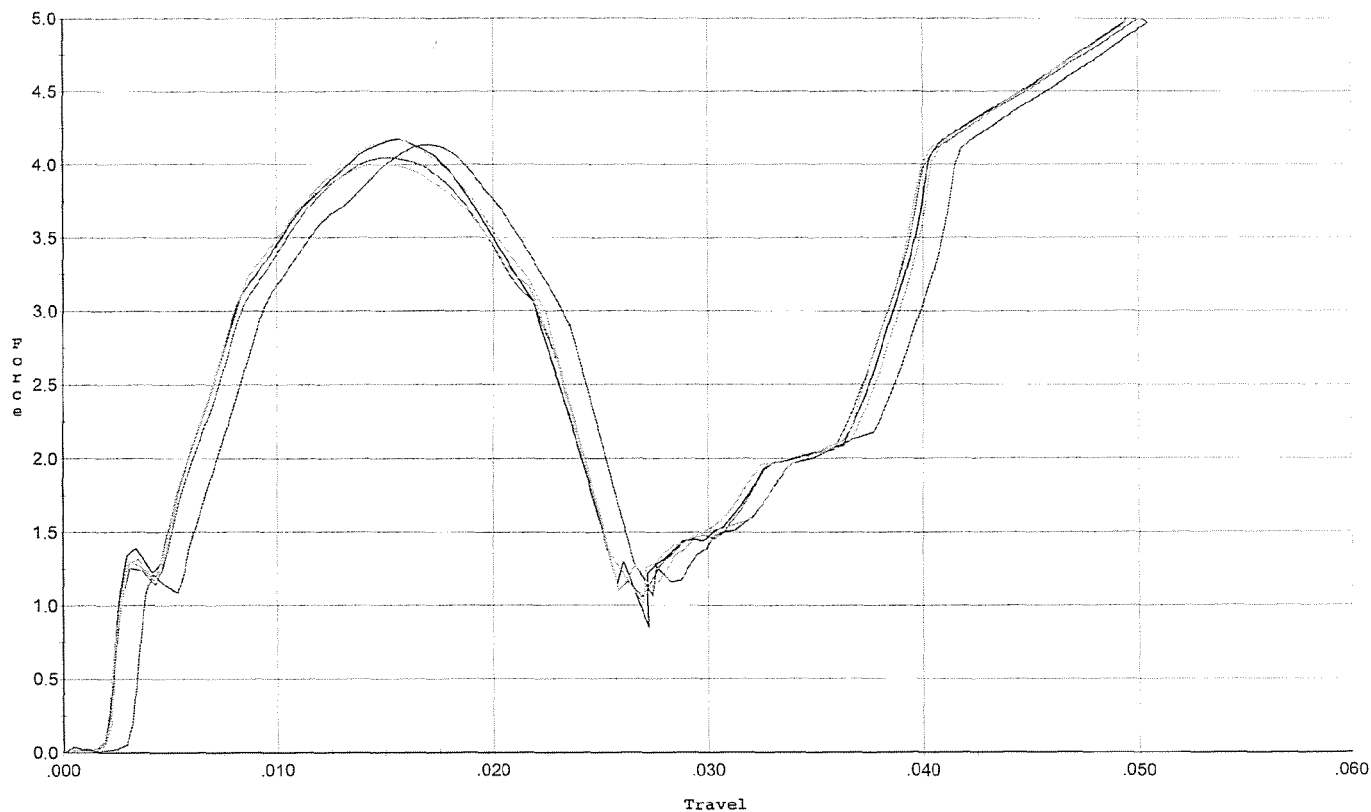
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.371	0.020	0.00	0.035	0.034		Set Trigger
2	2.389	0.020	0.00	0.035	0.034		Set Trigger
3	2.425	0.019	0.00	0.034	0.033		Set Trigger
4	2.447	0.020	0.005	0.035	0.034		Set Trigger
5	2.617	0.020	0.005	0.035	0.036		Set Trigger

A-2-45

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	4.138	0.024	0.003	0.032	0.059		Set Trigger
2	4.171	0.024	0.002	0.032	0.062		Set Trigger
3	4.046	0.023	0.005	0.032	0.059		Set Trigger
4	4.001	0.023	0.005	0.032	0.060		Set Trigger
5	4.177	0.022	0.00	0.032	0.059		Set Trigger

A-4-10