

G-6801421

BM
FORM

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
- INSTRUCTION BOOK 3518



UPC 0 47700 25716 7	G6801421	ORDER NO. 25716
		BARREL LENGTH 24" CAPACITY 6

UN SERIAL #

G 6801421

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-23-09	RT
475	DRILL AND TAP SIGHT HOLES	MAR 20 2009	3-23-09	JP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/25/09	JP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-29	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	LN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

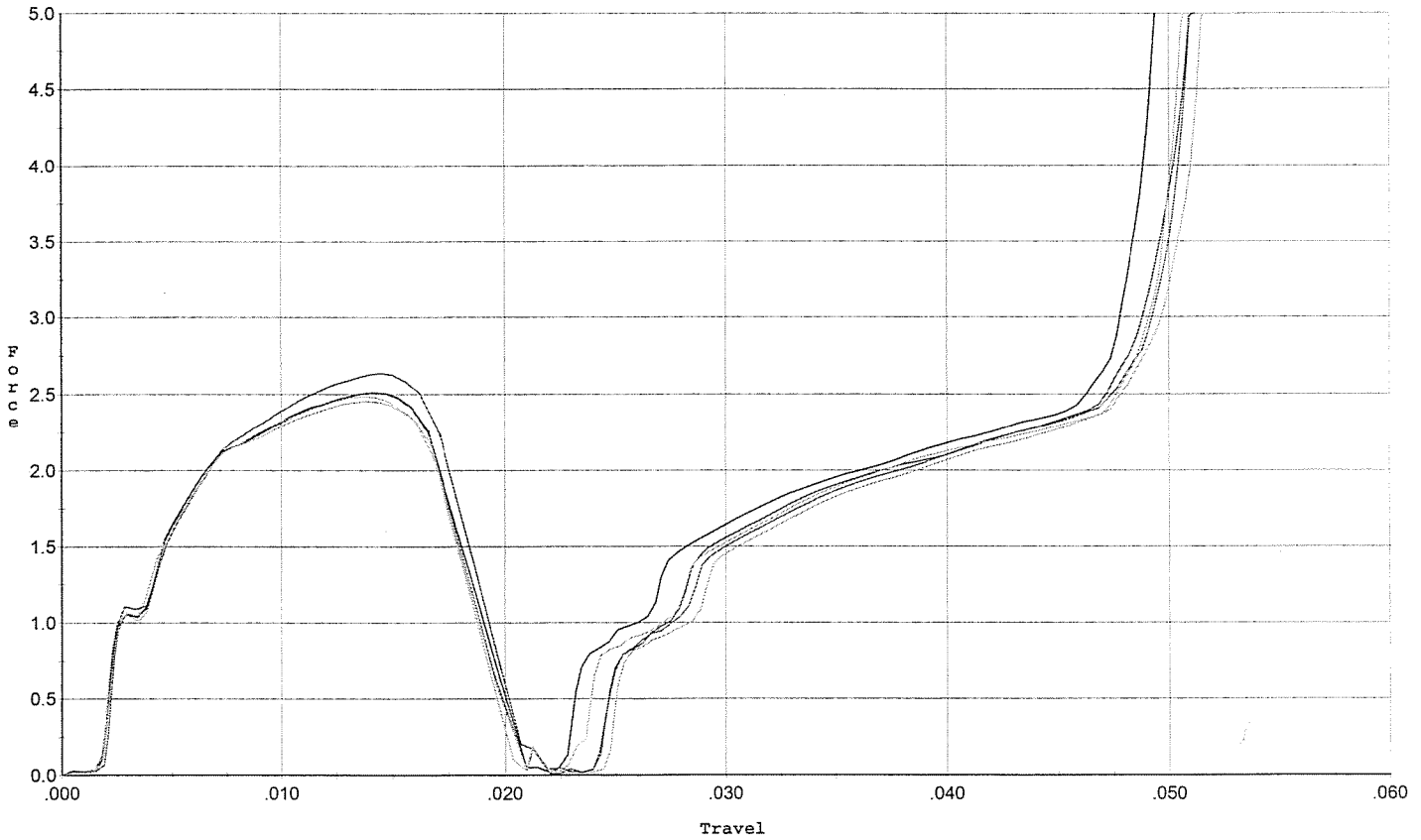
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.3</u> <u>2.3</u> <u>2.3</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.6</u> <u>4.6</u> <u>4.6</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-2-09	WR
	K) ASSEMBLE SWIVEL STUDS		4-17-09	RP
	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> <u>PASS</u> FAIL FAIL	4-9-09	WR
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TGR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.64</u> <u>2.50</u> <u>2.90</u> <u>2.92</u>	4-14-09	WR
	C) FUNCTION		4-17-09	RP
690	PACK		5-29-09	WR

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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



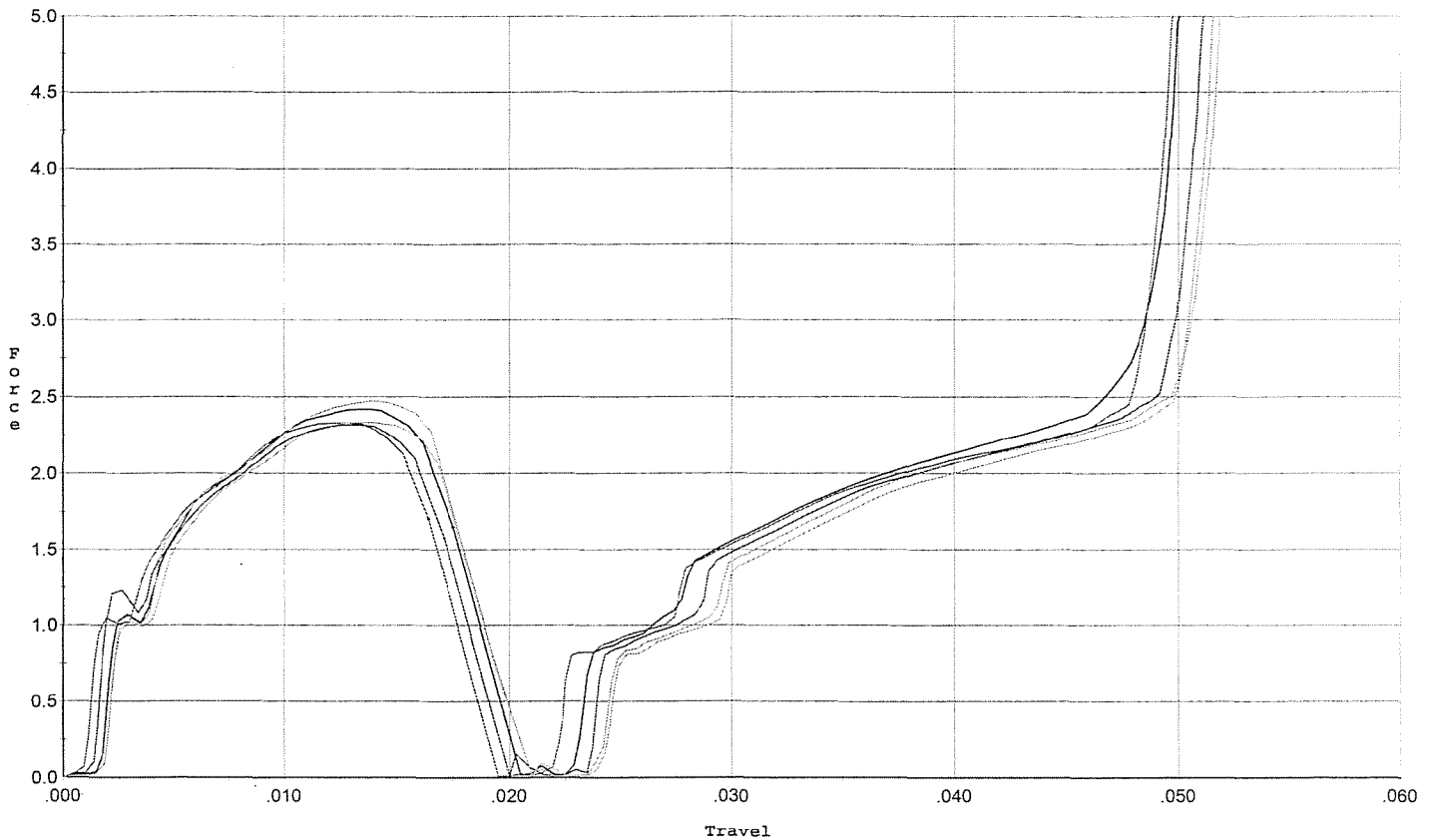
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.636	0.017	0.002	0.037	0.030		Set Trigger
2	2.511	0.017	0.00	0.036	0.028		Set Trigger
3	2.513	0.017	0.00	0.037	0.028		Set Trigger
4	2.487	0.017	0.00	0.037	0.029		Set Trigger
5	2.455	0.017	0.00	0.038	0.028		Set Trigger

A-2-52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



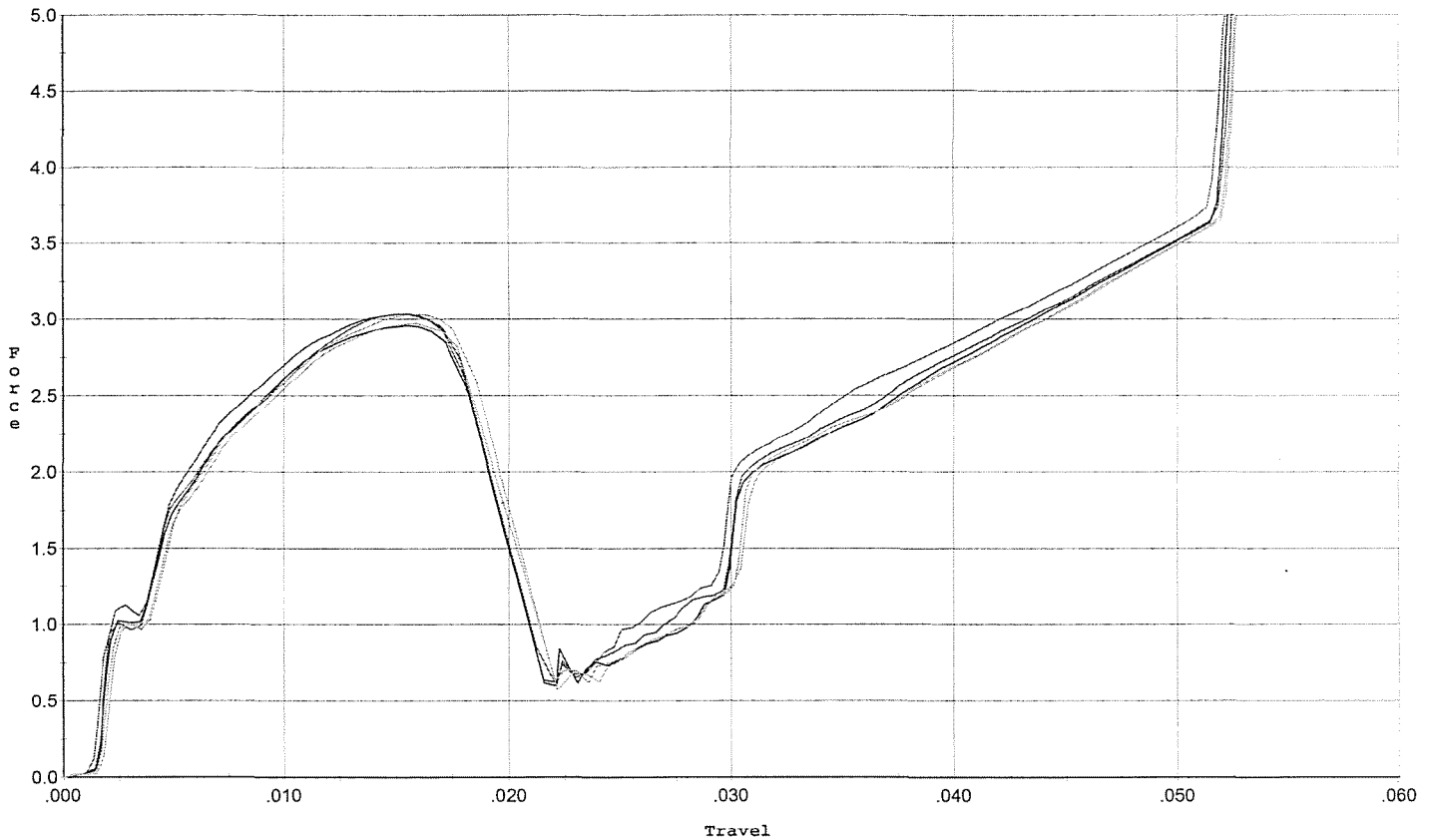
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.316	0.017	0.00	0.038	0.028		Set Trigger
2	2.419	0.017	0.00	0.037	0.029		Set Trigger
3	2.331	0.016	0.00	0.037	0.027		Set Trigger
4	2.333	0.017	0.00	0.039	0.027		Set Trigger
5	2.472	0.017	0.00	0.038	0.028		Set Trigger

A-2-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



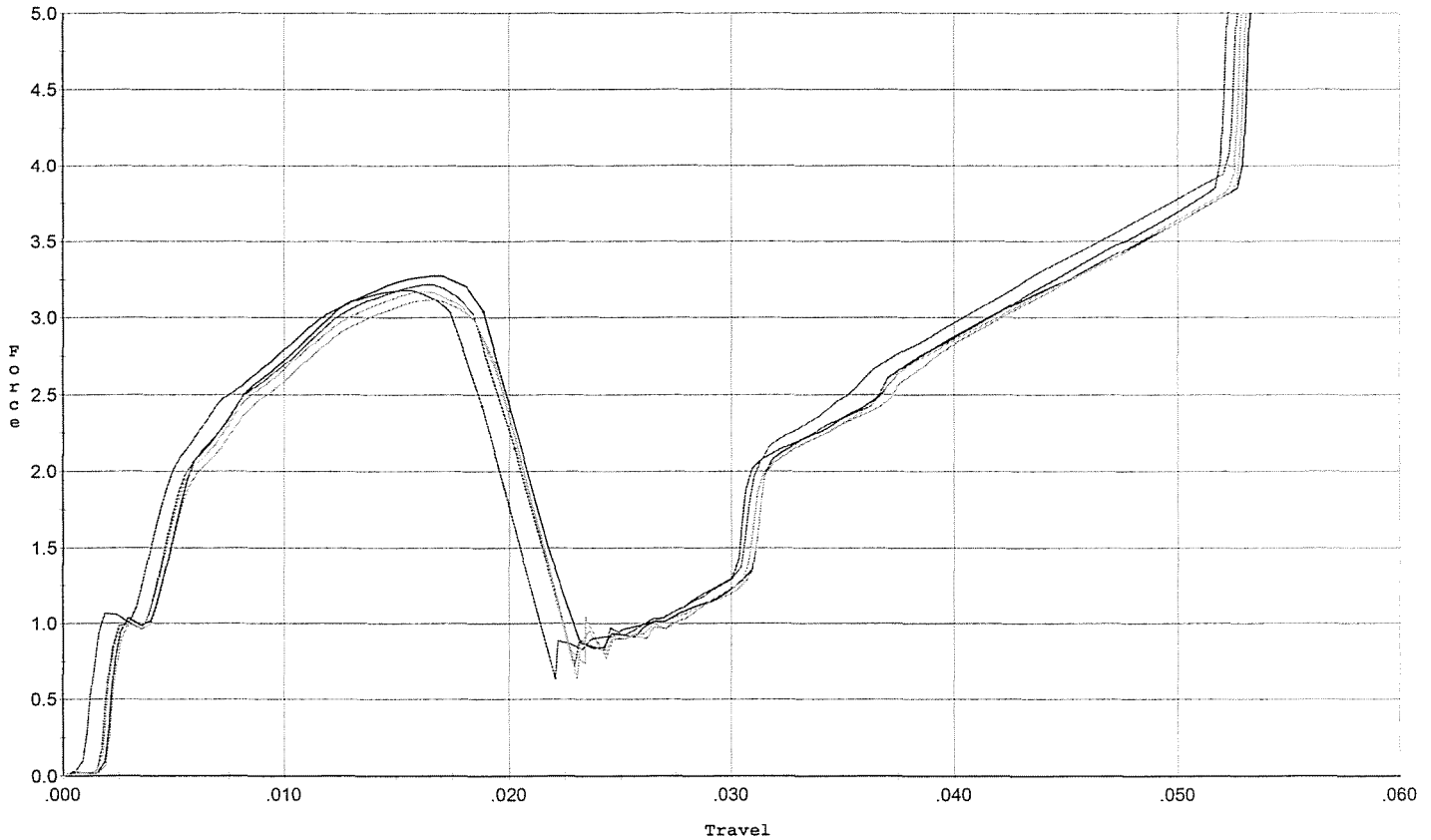
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.036	0.018	0.00	0.036	0.037		Set Trigger
2	2.958	0.018	0.004	0.036	0.036		Set Trigger
3	3.032	0.018	0.00	0.036	0.036		Set Trigger
4	2.968	0.020	0.00	0.036	0.039		Set Trigger
5	3.031	0.019	0.00	0.036	0.037		Set Trigger

A-3.00

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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	3.182	0.019	0.003	0.036	0.041		Set Trigger
2	3.275	0.019	0.002	0.036	0.040		Set Trigger
3	3.218	0.020	0.00	0.035	0.043		Set Trigger
4	3.174	0.019	0.00	0.035	0.041		Set Trigger
5	3.122	0.019	0.002	0.035	0.040		Set Trigger

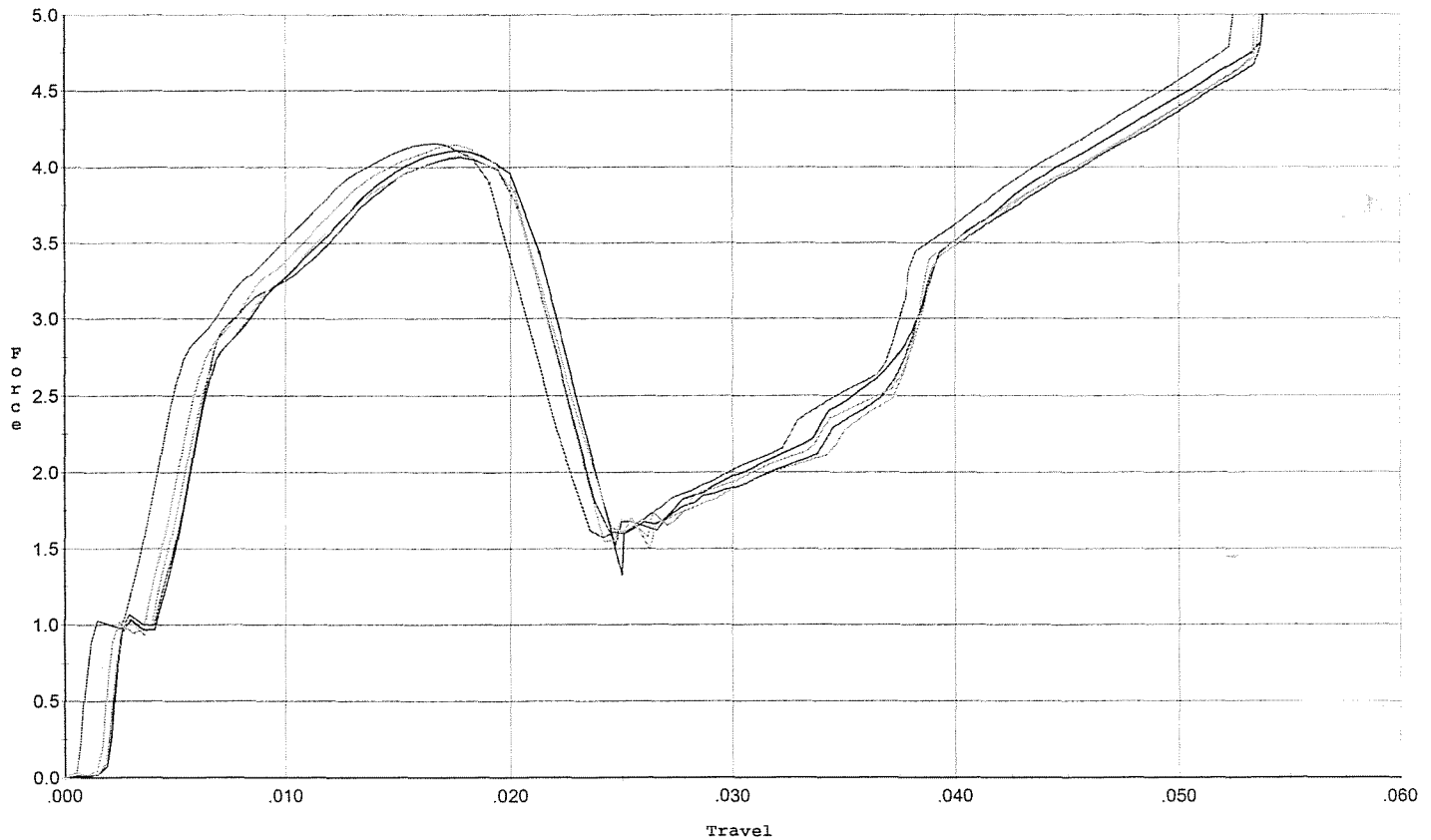
A-3-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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

cm5



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.064	0.020	0.004	0.034	0.053		Set Trigger
2	4.108	0.021	0.002	0.034	0.056		Set Trigger
3	4.157	0.019	0.003	0.033	0.053		Set Trigger
4	4.077	0.020	0.002	0.034	0.053		Set Trigger
5	4.147	0.020	0.00	0.034	0.055		Set Trigger

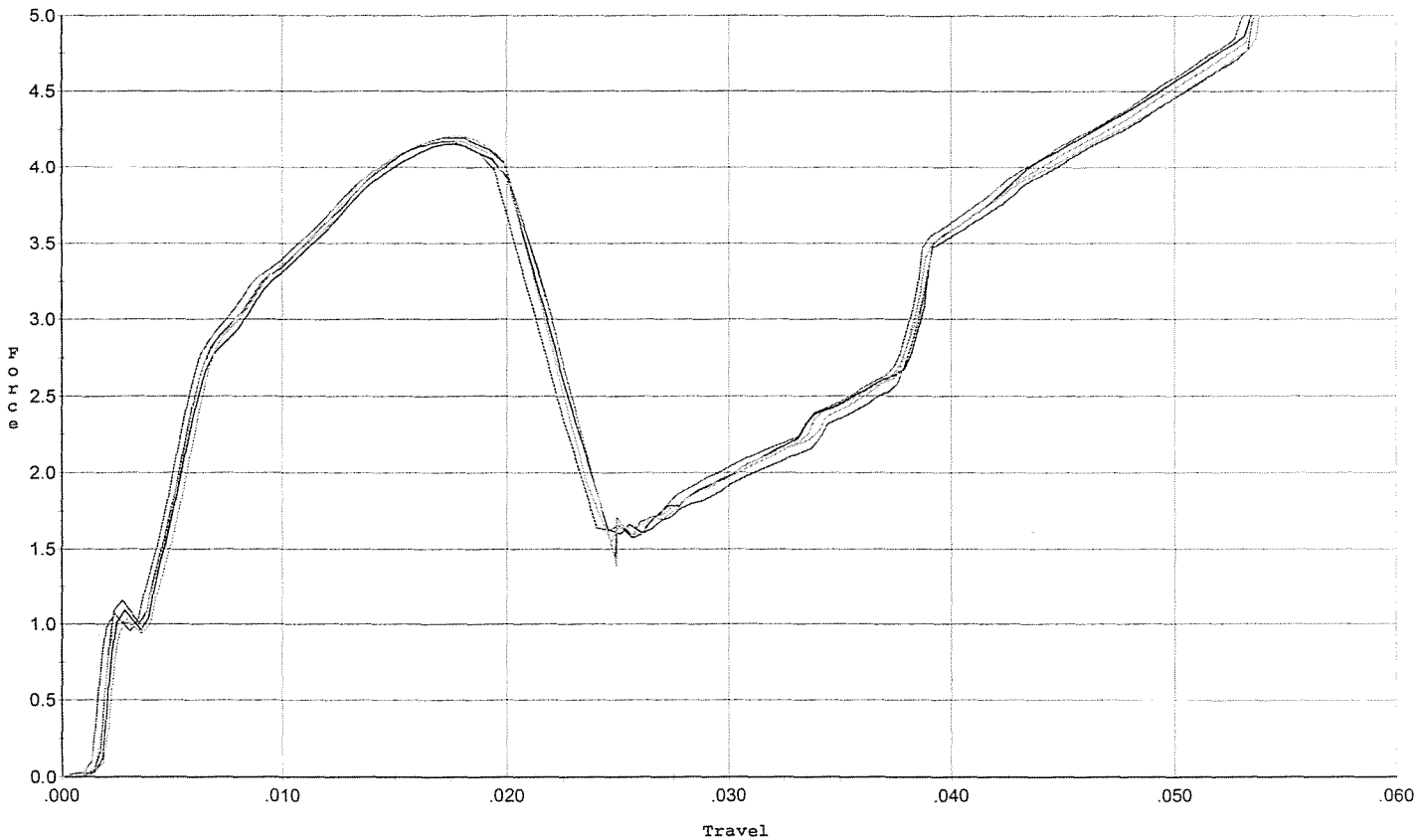
A-4-11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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

A74cr 20 cycles
cm 5



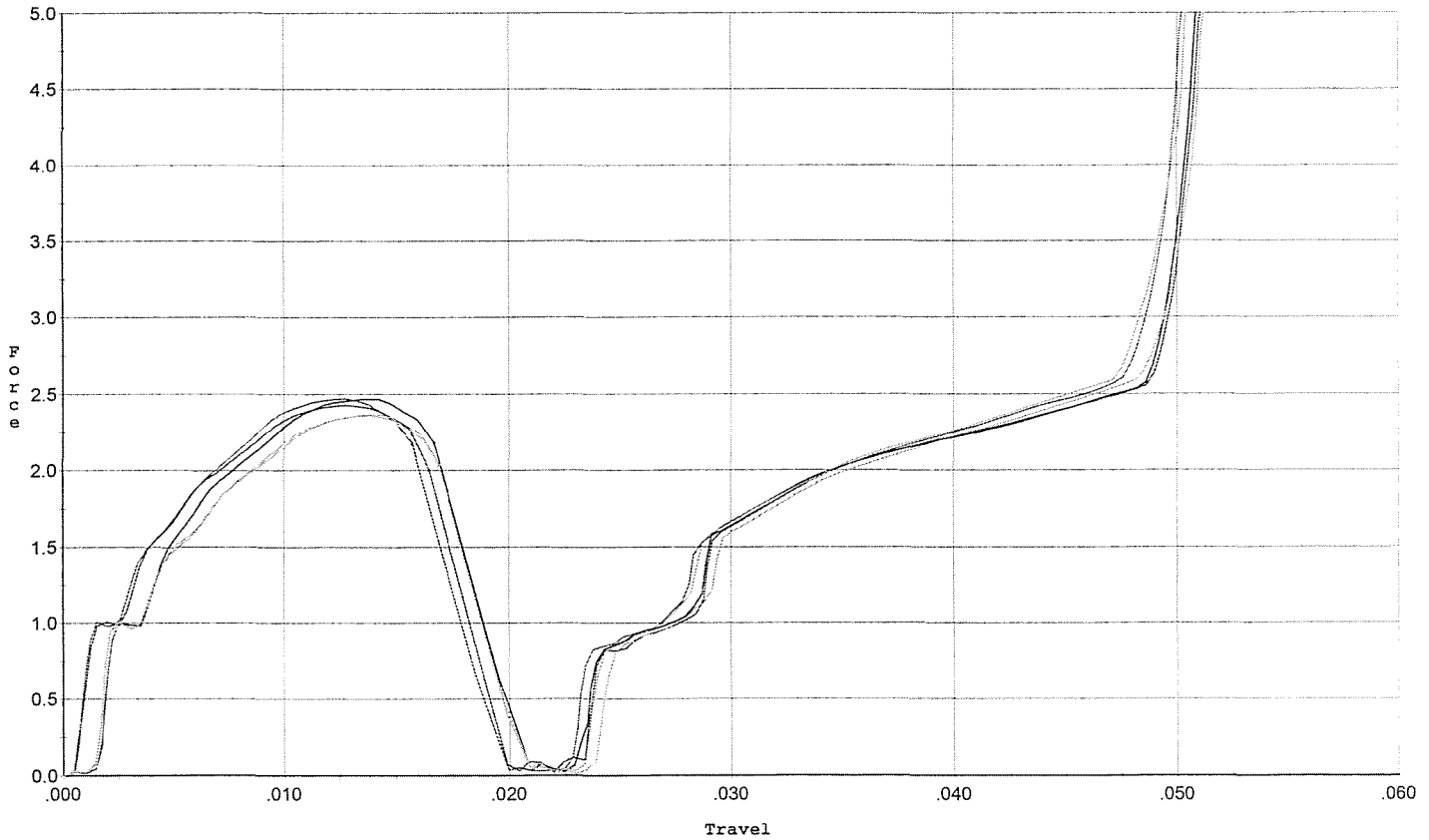
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.193	0.022	0.00	0.034	0.059		Set Trigger
2	4.154	0.020	0.00	0.033	0.053		Set Trigger
3	4.169	0.019	0.00	0.033	0.053		Set Trigger
4	4.177	0.020	0.004	0.034	0.054		Set Trigger
5	4.204	0.022	0.00	0.034	0.057		Set Trigger

A-4-17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/28/2009

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



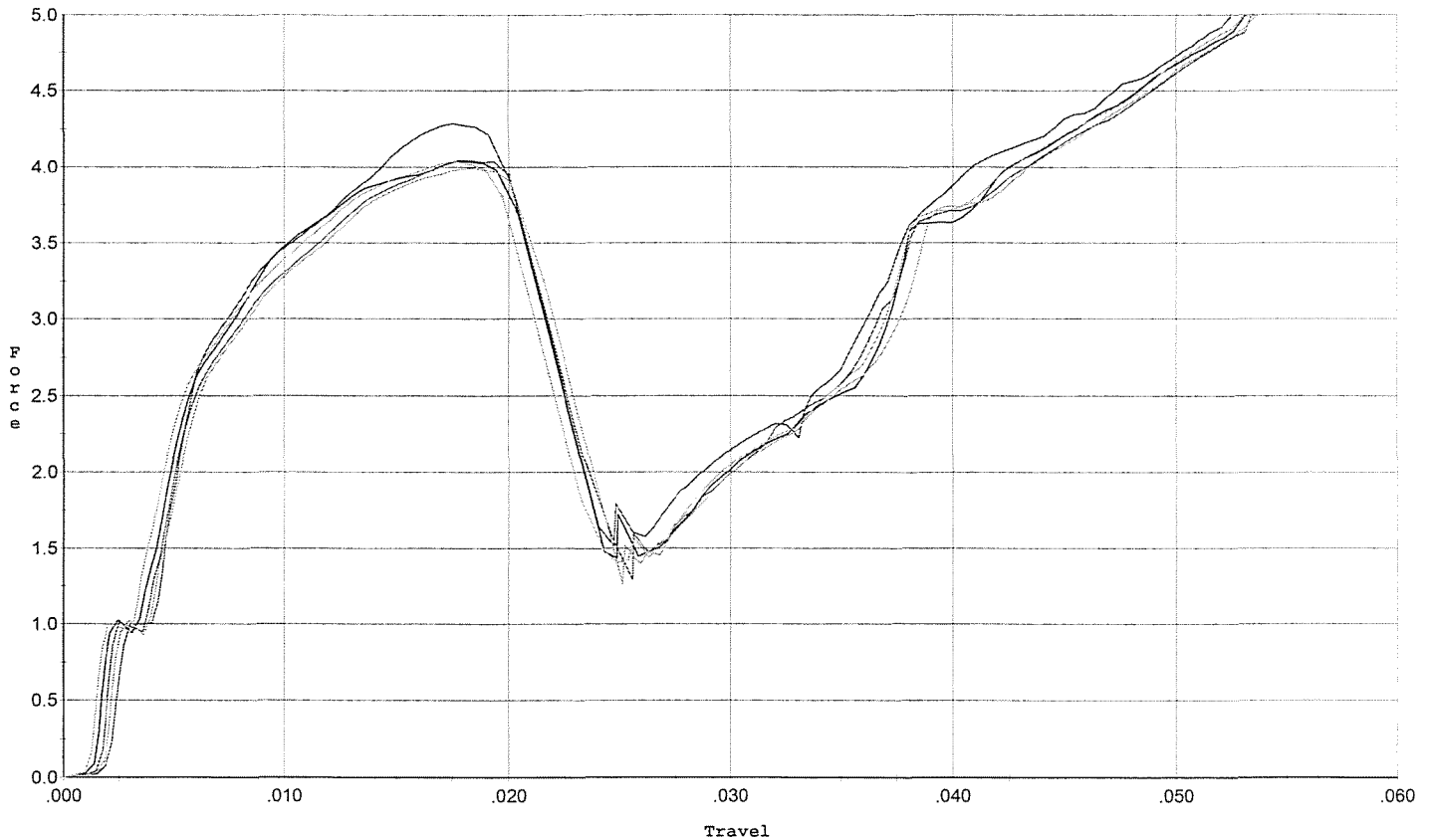
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.430	0.016	0.00	0.038	0.029		Set Trigger
2	2.469	0.017	0.004	0.037	0.028		Set Trigger
3	2.470	0.016	0.00	0.038	0.028		Set Trigger
4	2.361	0.017	0.00	0.038	0.027		Set Trigger
5	2.369	0.017	0.00	0.037	0.027		Set Trigger

A-2-42

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/28/2009

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	4.285	0.020	0.002	0.033	0.054		Set Trigger
2	4.040	0.020	0.00	0.033	0.055		Set Trigger
3	4.046	0.020	0.004	0.033	0.053		Set Trigger
4	4.036	0.020	0.003	0.034	0.053		Set Trigger
5	3.993	0.022	0.00	0.033	0.056		Set Trigger

A - 4.08