

G-6801485

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

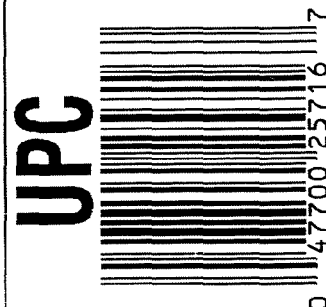
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801485

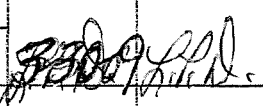


GUN SERIAL #

G 6801485

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION		3/9/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	72
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-27-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
		2.50 LBS +/- .5 LBS		

F004 REV 5/2006

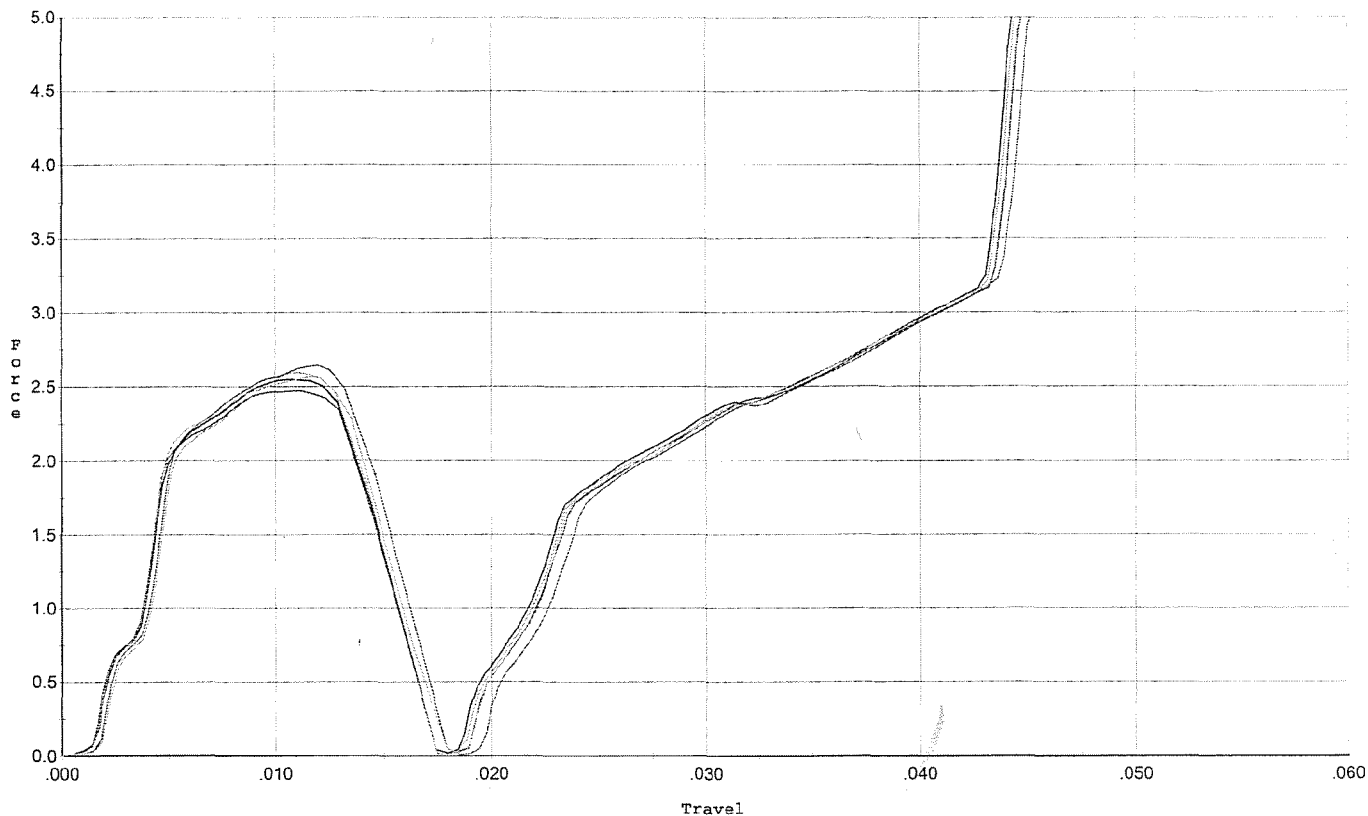
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>4</u>	3-31-09	WV
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4</u> <u>4</u>	3-31-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	3-31-09	WV
	J) ASSEMBLE STOCK		3-31-09	RP
	K) ASSEMBLE SWIVEL STUDS		3-31-09	WV
	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	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-31-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.49</u> <u>2.54</u> <u>2.53</u> <u>2.23</u>	3-31-09	WV
	C) FUNCTION		3-31-09	WV
690	PACK		3-31-09	Fay

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/26/2009

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



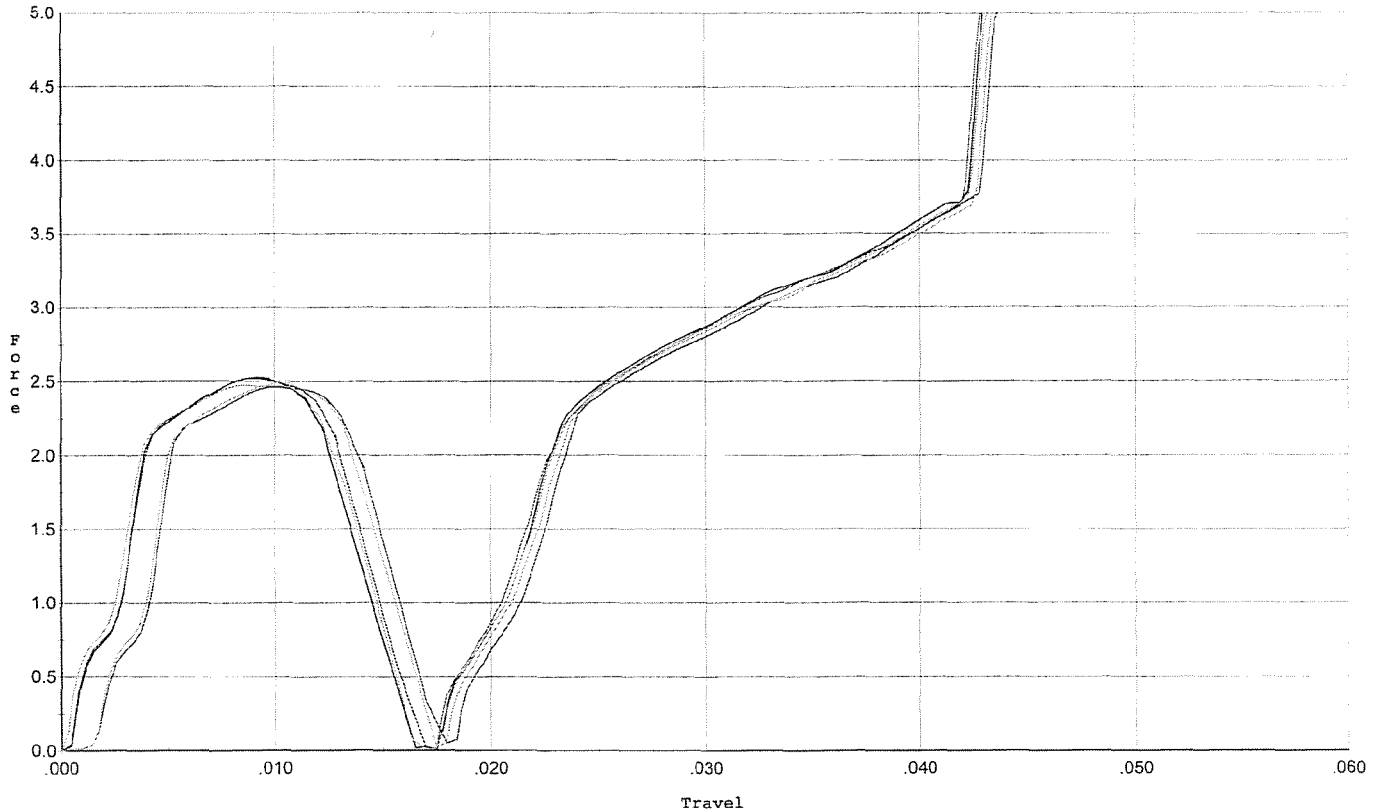
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.469	0.015	0.00	0.034	0.024		Set Trigger
2	2.547	0.014	0.00	0.033	0.024		Set Trigger
3	2.645	0.015	0.00	0.034	0.024		Set Trigger
4	2.564	0.014	0.00	0.034	0.024		Set Trigger
5	2.596	0.014	0.00	0.034	0.022		Set Trigger

A-2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



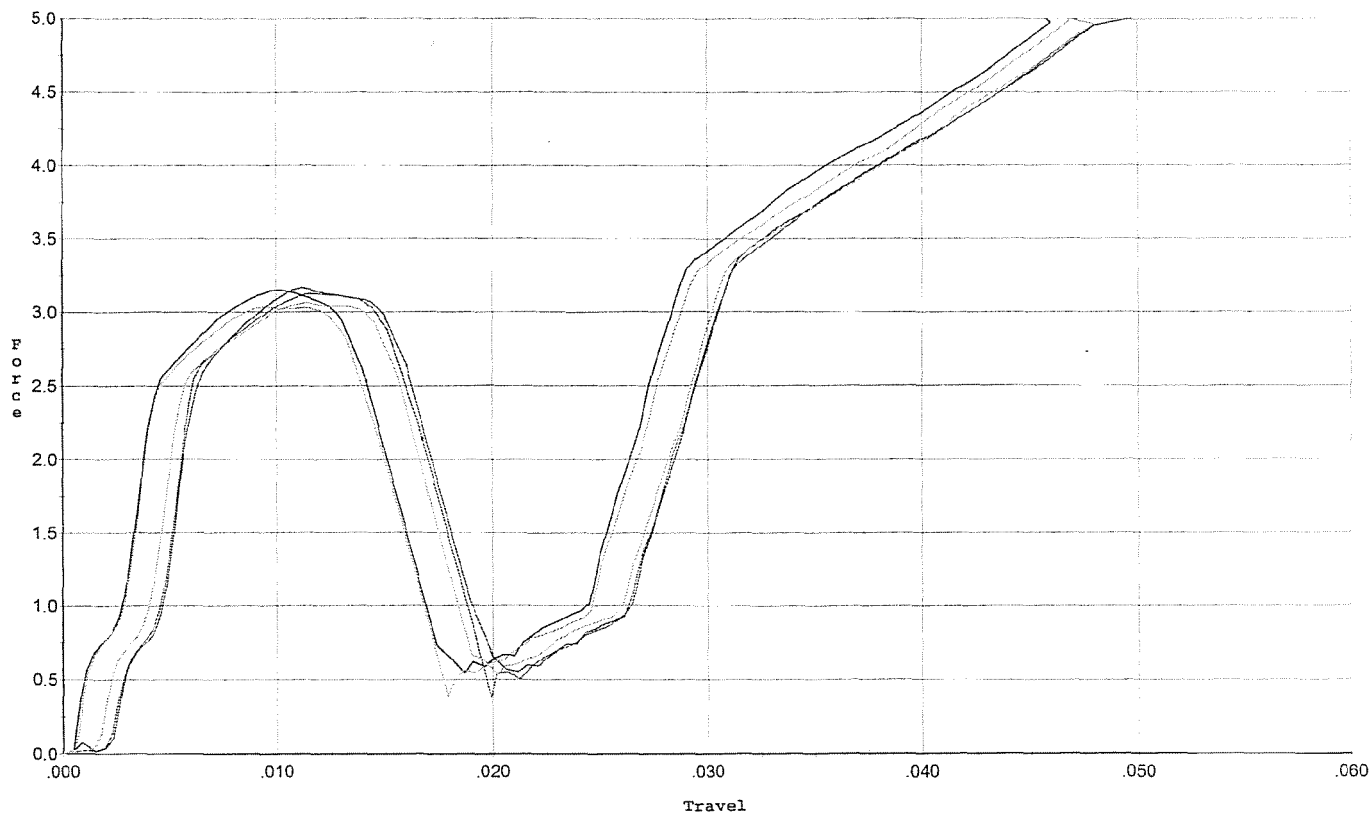
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.014	0.00	0.032	0.022		Set Trigger
2	2.520	0.012	0.00	0.033	0.021		Set Trigger
3	2.529	0.013	0.00	0.032	0.023		Set Trigger
4	2.493	0.015	0.00	0.032	0.024		Set Trigger
5	2.476	0.013	0.00	0.032	0.024		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



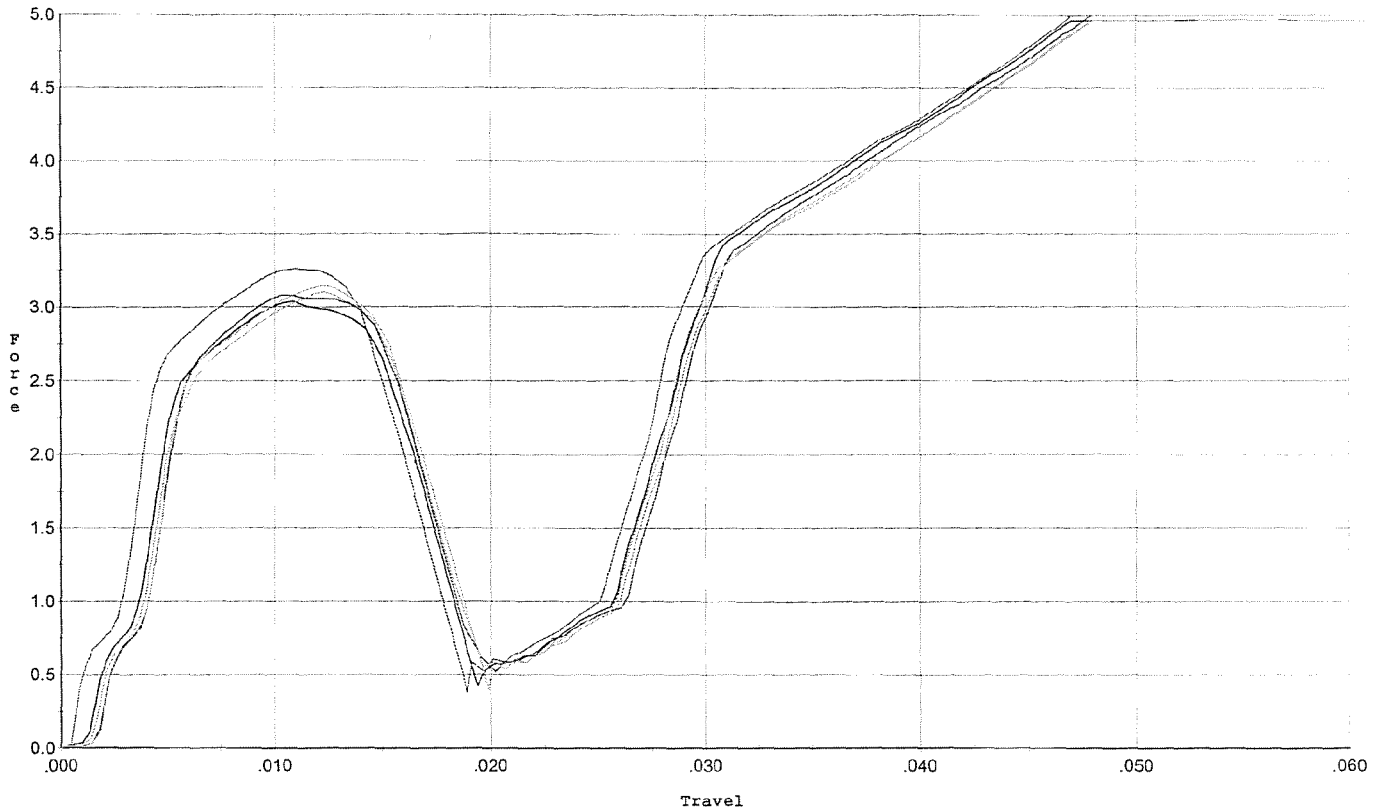
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.168	0.016	0.00	0.034	0.031		Set Trigger
2	3.150	0.014	0.00	0.033	0.030		Set Trigger
3	3.127	0.017	0.00	0.034	0.033		Set Trigger
4	3.065	0.016	0.00	0.034	0.031		Set Trigger
5	3.038	0.015	0.00	0.033	0.031		Set Trigger

A-3-11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



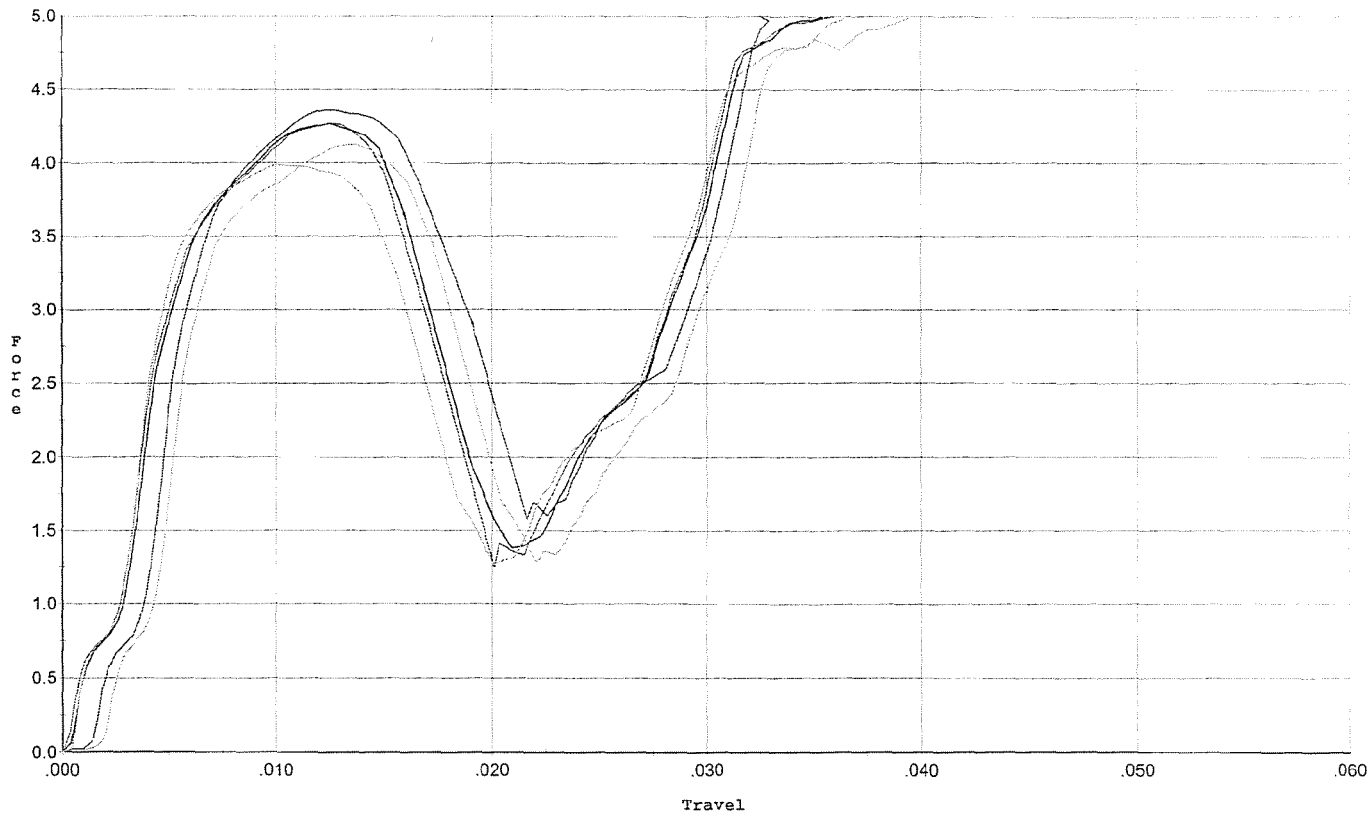
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.080	0.016	0.00	0.034	0.031		Set Trigger
2	3.038	0.017	0.00	0.033	0.033		Set Trigger
3	3.259	0.016	0.00	0.033	0.035		Set Trigger
4	3.101	0.016	0.00	0.034	0.031		Set Trigger
5	3.144	0.017	0.00	0.033	0.034		Set Trigger

A-3-12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



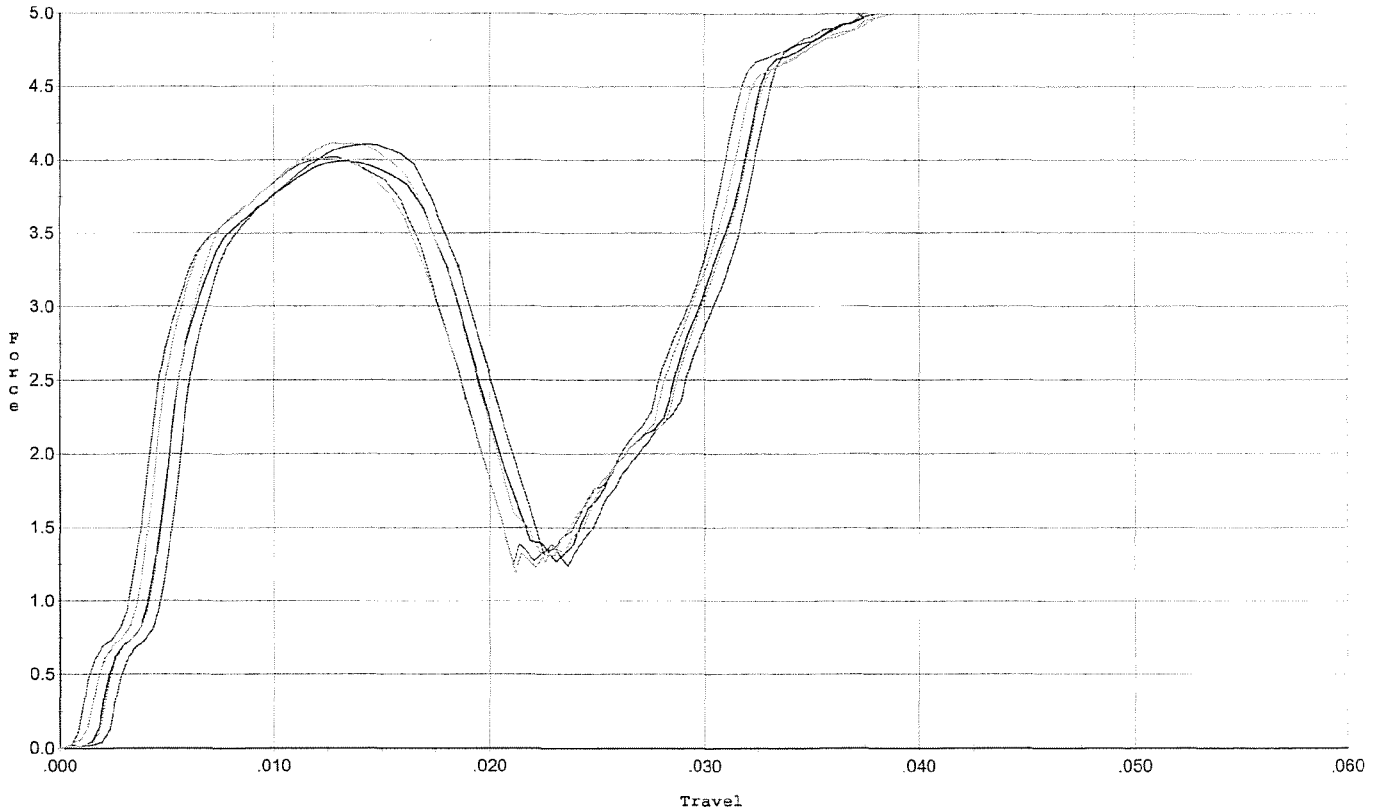
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.360	0.019	0.00	0.030	0.053		Set Trigger
2	4.266	0.016	0.00	0.030	0.045		Set Trigger
3	4.268	0.017	0.00	0.030	0.048		Set Trigger
4	4.124	0.017	0.00	0.031	0.044		Set Trigger
5	3.986	0.016	0.00	0.031	0.042		Set Trigger

A-4-20

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



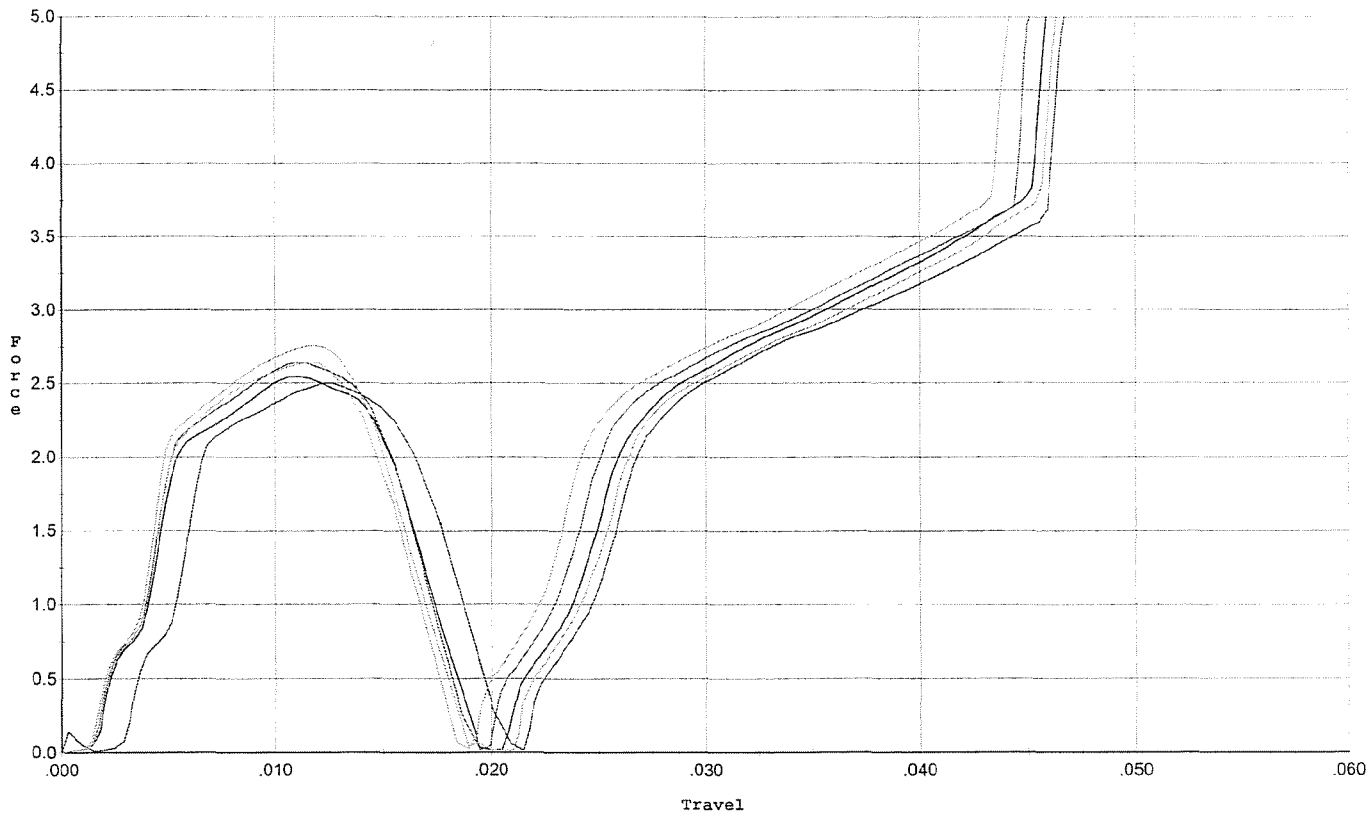
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.106	0.019	0.002	0.031	0.047		Set Trigger
2	3.991	0.018	0.00	0.031	0.046		Set Trigger
3	4.020	0.019	0.00	0.030	0.050		Set Trigger
4	4.115	0.018	0.00	0.031	0.047		Set Trigger
5	4.014	0.019	0.00	0.031	0.049		Set Trigger

A.4.04

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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



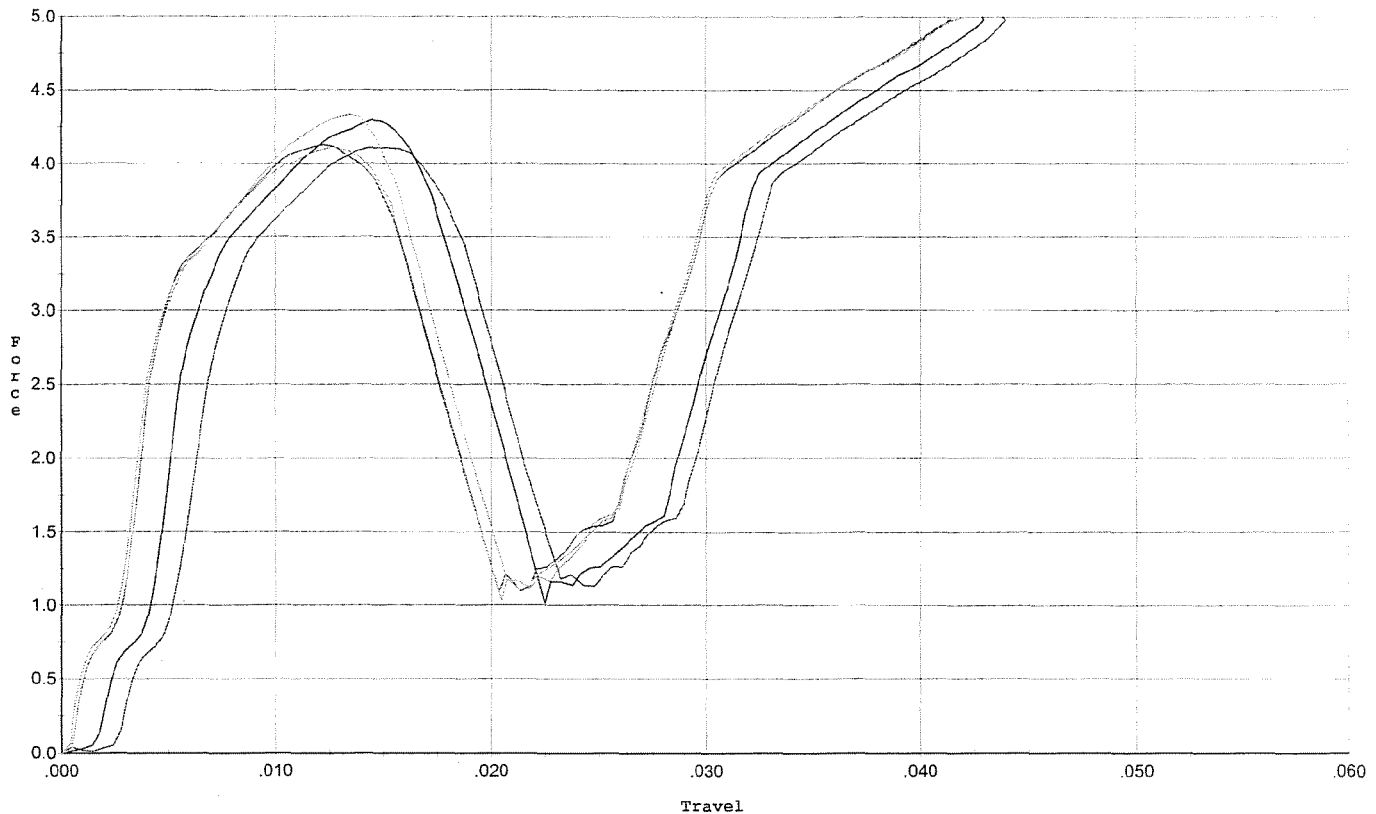
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.018	0.003	0.032	0.027		Set Trigger
2	2.545	0.016	0.00	0.033	0.026		Set Trigger
3	2.642	0.016	0.00	0.032	0.027		Set Trigger
4	2.641	0.015	0.00	0.032	0.026		Set Trigger
5	2.758	0.015	0.00	0.034	0.026		Set Trigger

A-2.61

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/26/2009

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	4.105	0.019	0.003	0.032	0.046		Set Trigger
2	4.299	0.019	0.00	0.031	0.051		Set Trigger
3	4.128	0.016	0.00	0.031	0.042		Set Trigger
4	4.114	0.018	0.00	0.030	0.049		Set Trigger
5	4.331	0.016	0.00	0.030	0.044		Set Trigger

A-4.19