

66807678

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

- INSTRUCTION BOOK 3518



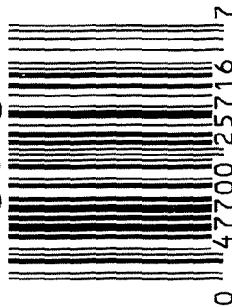
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6807678

UPC



BM FORM

GUN SERIAL #

G 6807678

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	TE
460	CHECK HEADSPACE		3-6-09	TE
470	DIS-ASSEMBLE ACTION		3-6-09	SP
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	3/13/09	RT
490	MAGNAFLUX BOLT		3/13/09	RT
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	RT
542	APPLY COATINGS (BARREL ACTION)		3/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-24-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-24-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-24-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

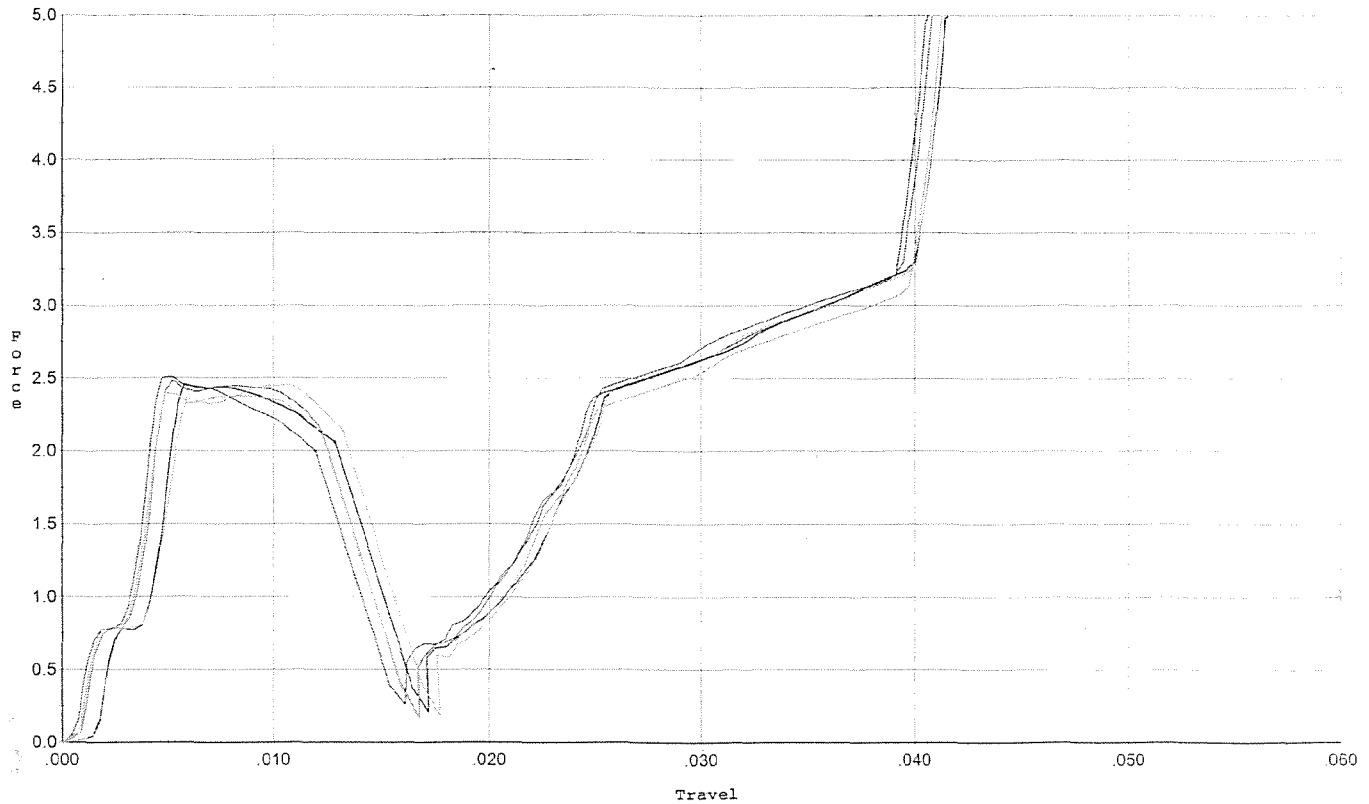
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.9</u> <u>4.9</u> <u>4.9</u>	3-28-09	LN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.9</u> <u>4.9</u> <u>4.9</u>	3-28-09	LN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-28-09	LN
	J) ASSEMBLE STOCK		3-25-09	LN
	K) ASSEMBLE SWIVEL STUDS		3-28-09	LN
	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	3-26-09	WN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE		3-28-09	LN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.63</u> <u>2.69</u> <u>2.69</u> <u>2.72</u>	3-26-09	TL
	C) FUNCTION		3-28-09	LN
690	PACK		3-28-09	TL

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



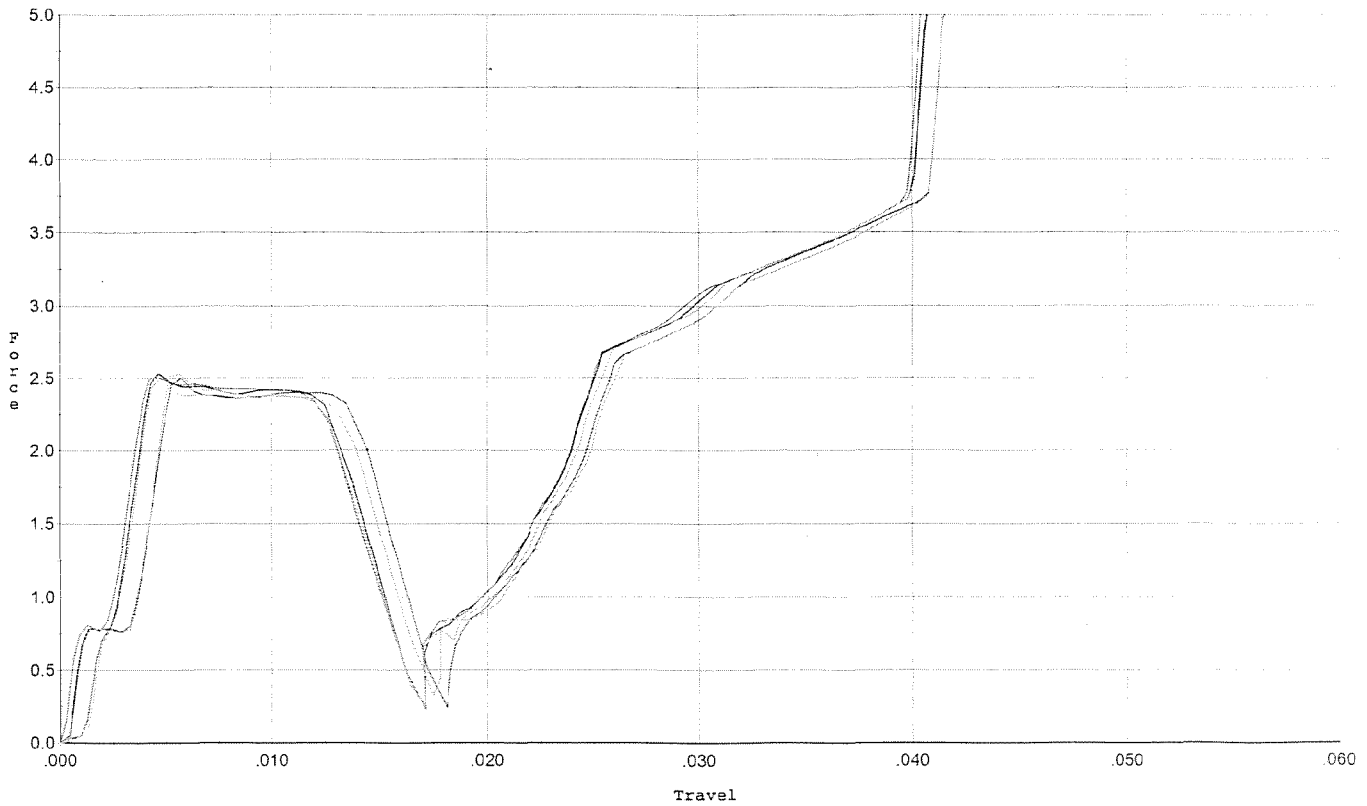
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.507	0.012	0.00	0.031	0.020		Set Trigger
2	2.462	0.013	0.00	0.031	0.020		Set Trigger
3	2.485	0.014	0.00	0.030	0.023		Set Trigger
4	2.455	0.013	0.00	0.031	0.021		Set Trigger
5	2.396	0.014	0.00	0.031	0.023		Set Trigger

A-2.46

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



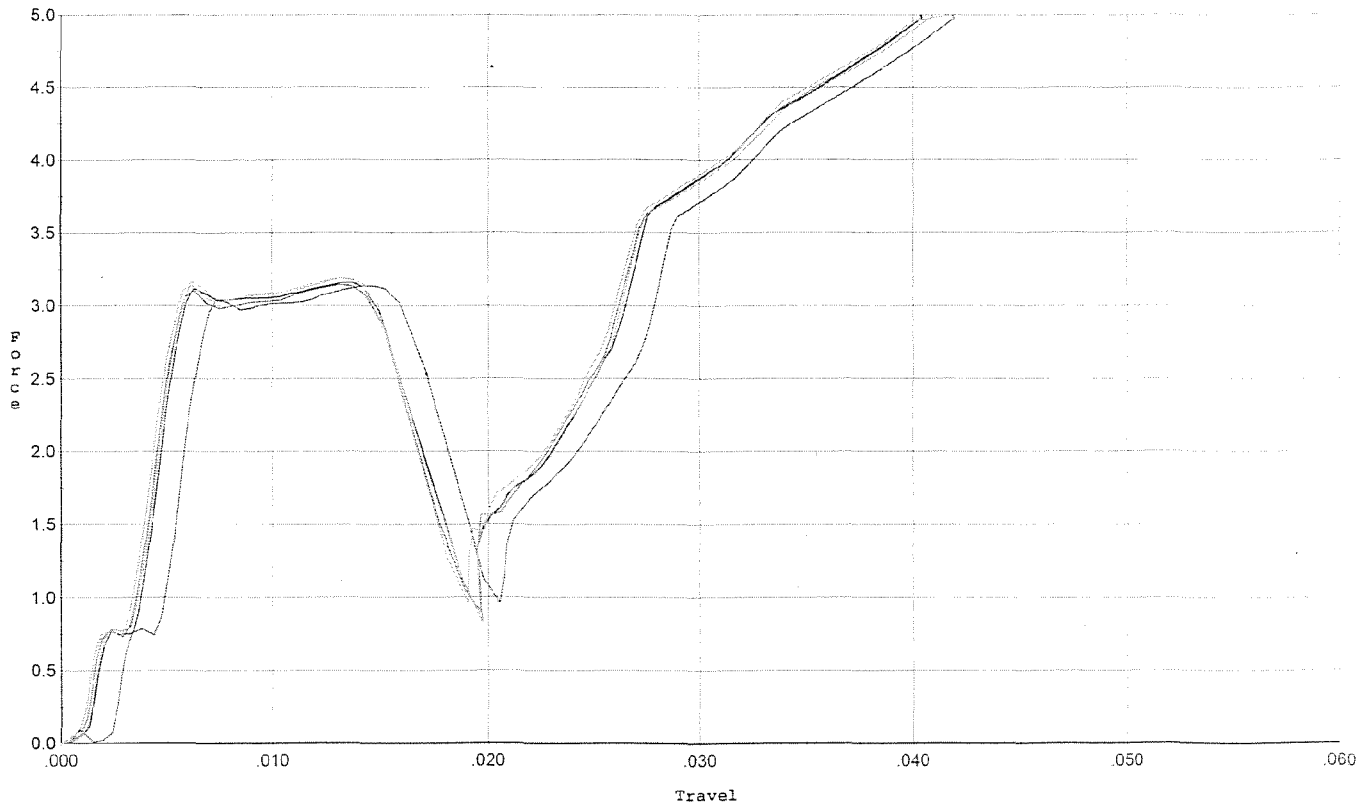
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.497	0.014	0.00	0.030	0.025		Set Trigger
2	2.534	0.014	0.003	0.029	0.025		Set Trigger
3	2.504	0.013	0.00	0.030	0.023		Set Trigger
4	2.497	0.014	0.00	0.030	0.025		Set Trigger
5	2.534	0.014	0.00	0.030	0.023		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



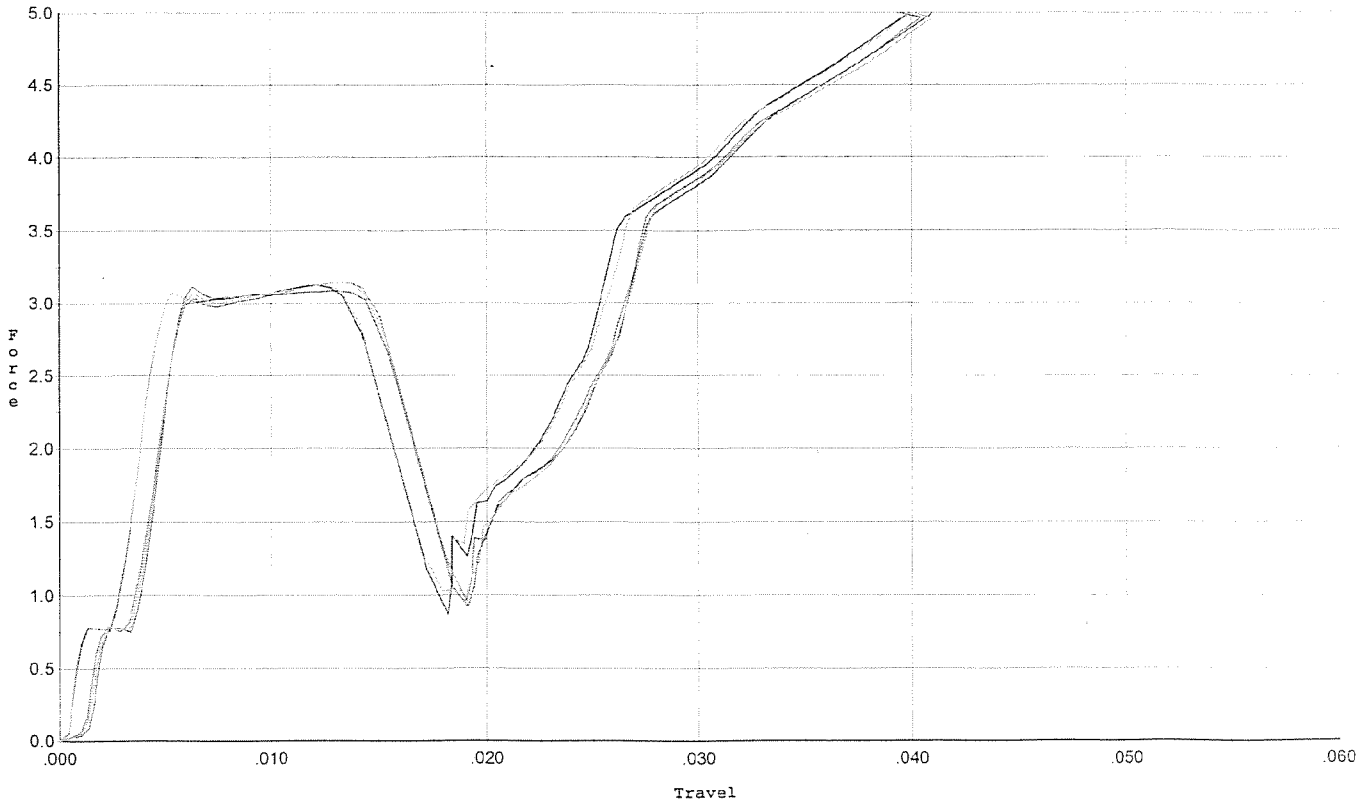
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.132	0.017	0.00	0.028	0.034		Set Trigger
2	3.156	0.015	0.004	0.027	0.032		Set Trigger
3	3.141	0.015	0.00	0.027	0.033		Set Trigger
4	3.188	0.015	0.00	0.027	0.033		Set Trigger
5	3.188	0.015	0.00	0.027	0.032		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



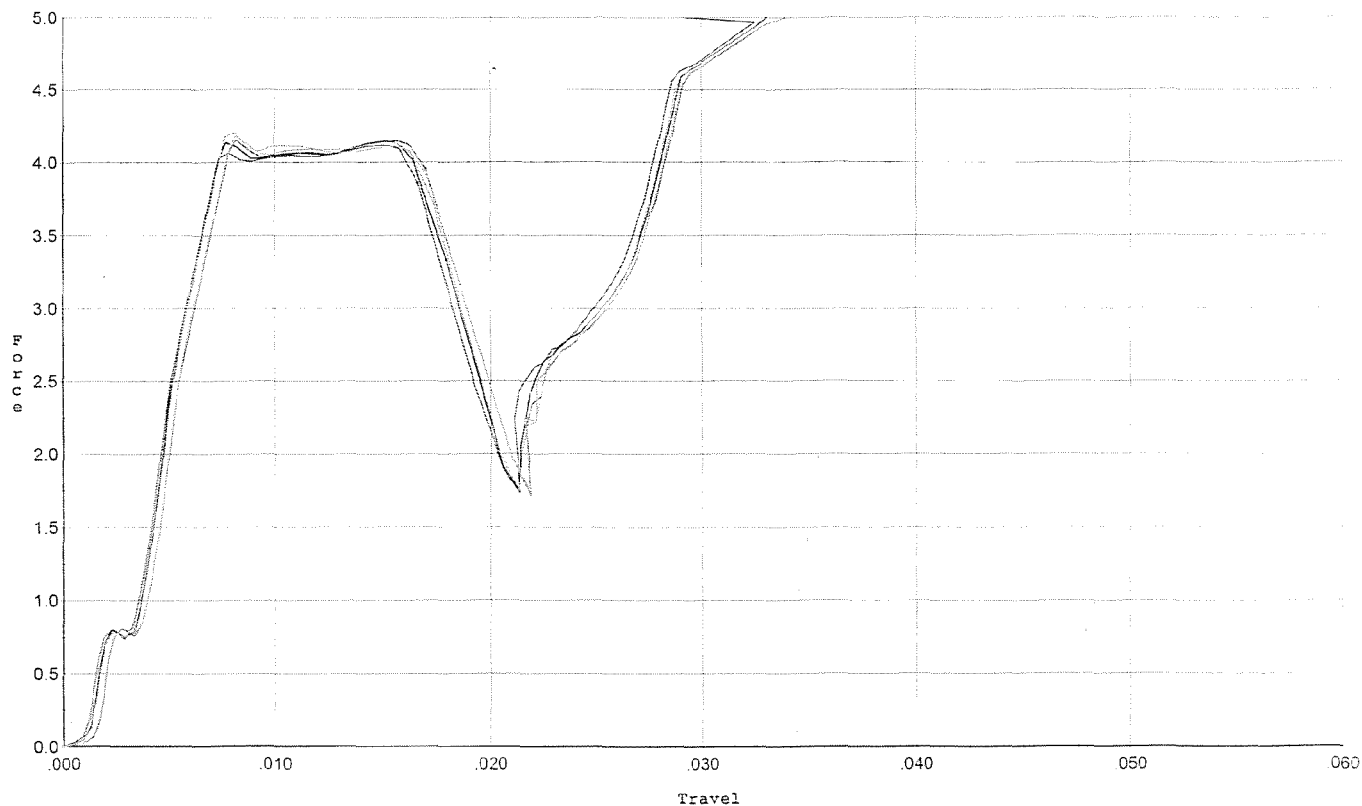
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.112	0.015	0.004	0.027	0.033		Set Trigger
2	3.119	0.014	0.003	0.027	0.032		Set Trigger
3	3.139	0.015	0.00	0.027	0.032		Set Trigger
4	3.128	0.014	0.003	0.027	0.031		Set Trigger
5	3.139	0.015	0.00	0.027	0.032		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



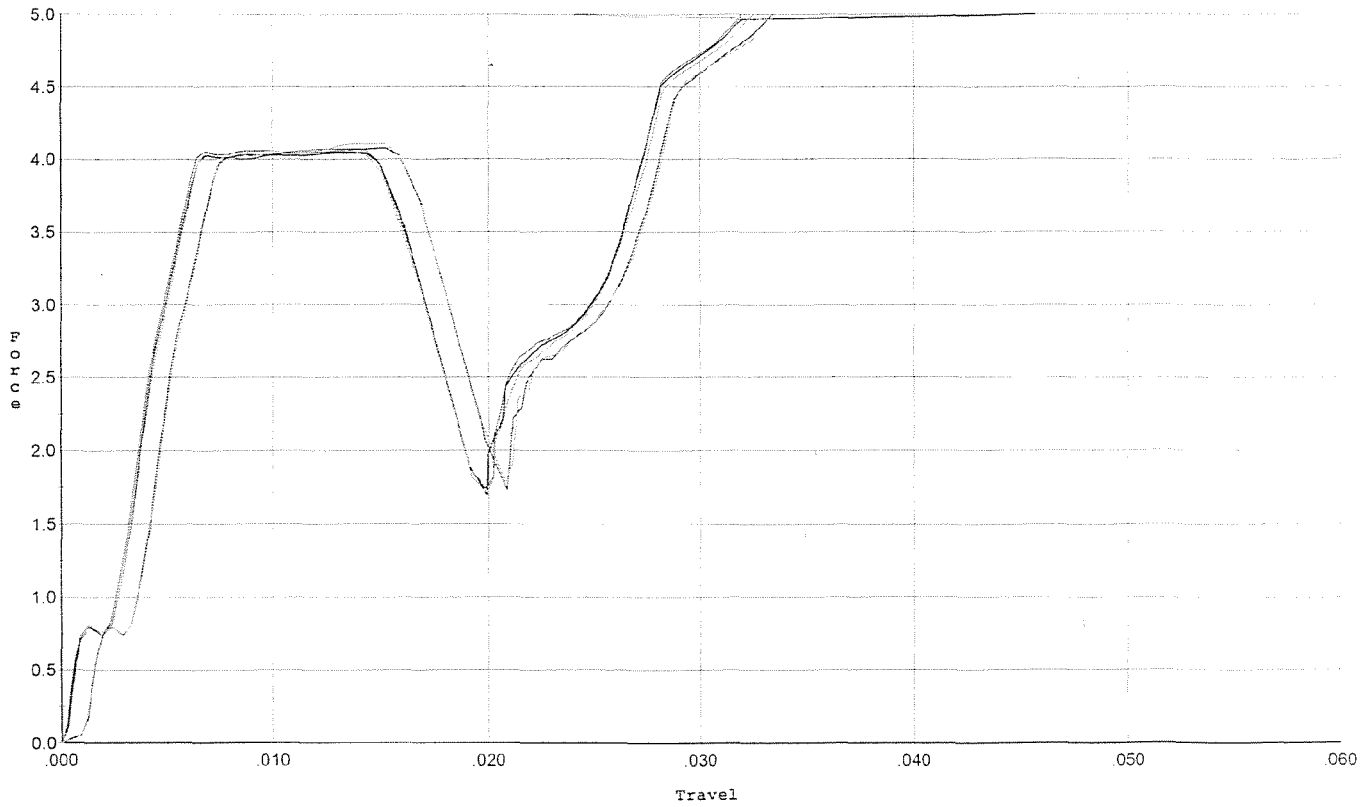
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.118	0.017	0.00	0.025	0.046		Set Trigger
2	4.148	0.018	0.00	0.024	0.049		Set Trigger
3	4.154	0.017	0.00	0.025	0.046		Set Trigger
4	4.178	0.017	0.00	0.025	0.046		Set Trigger
5	4.203	0.017	0.00	0.024	0.048		Set Trigger

A-4.16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



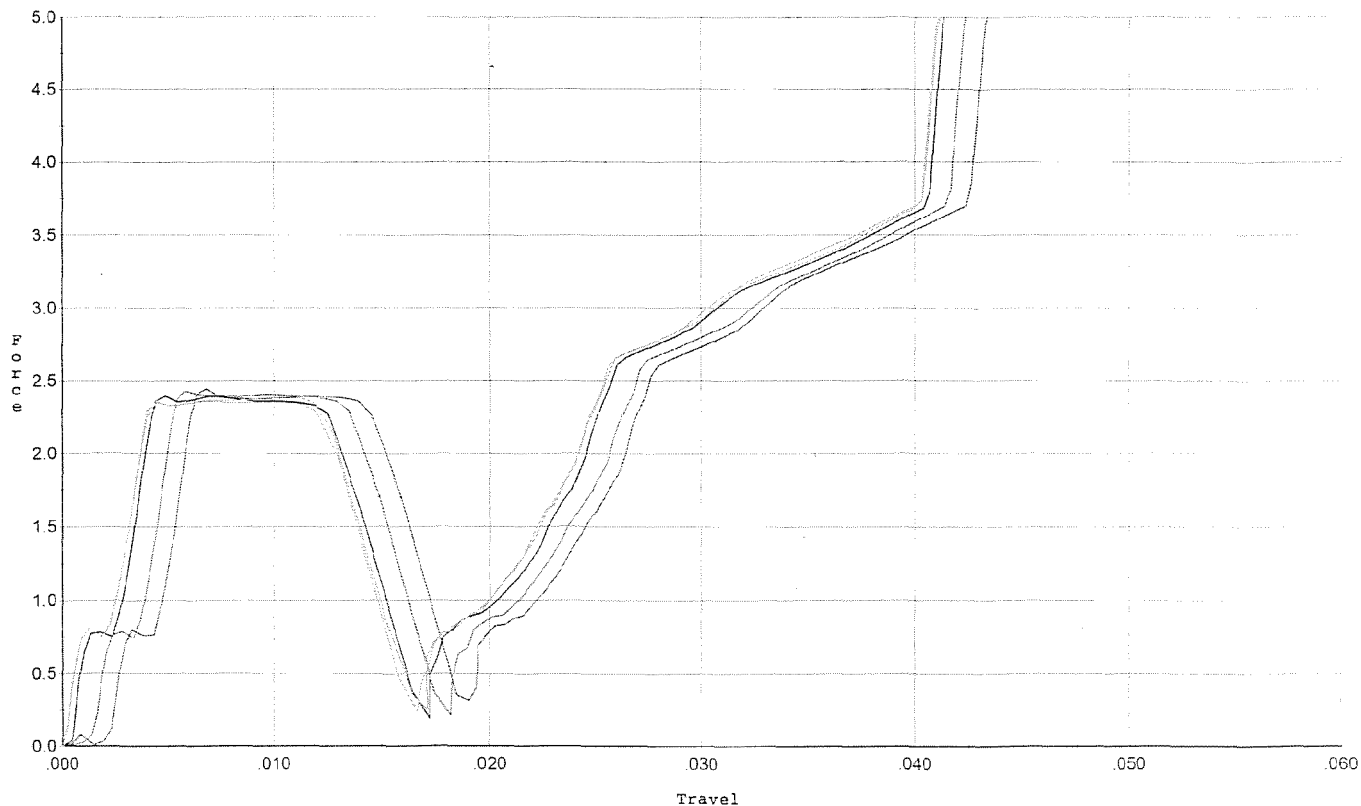
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.074	0.017	0.00	0.025	0.046		Set Trigger
2	4.049	0.016	0.00	0.025	0.046		Set Trigger
3	4.070	0.016	0.00	0.025	0.046		Set Trigger
4	4.106	0.017	0.00	0.025	0.046		Set Trigger
5	4.065	0.017	0.00	0.025	0.046		Set Trigger

A. 4.07

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/24/2009

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



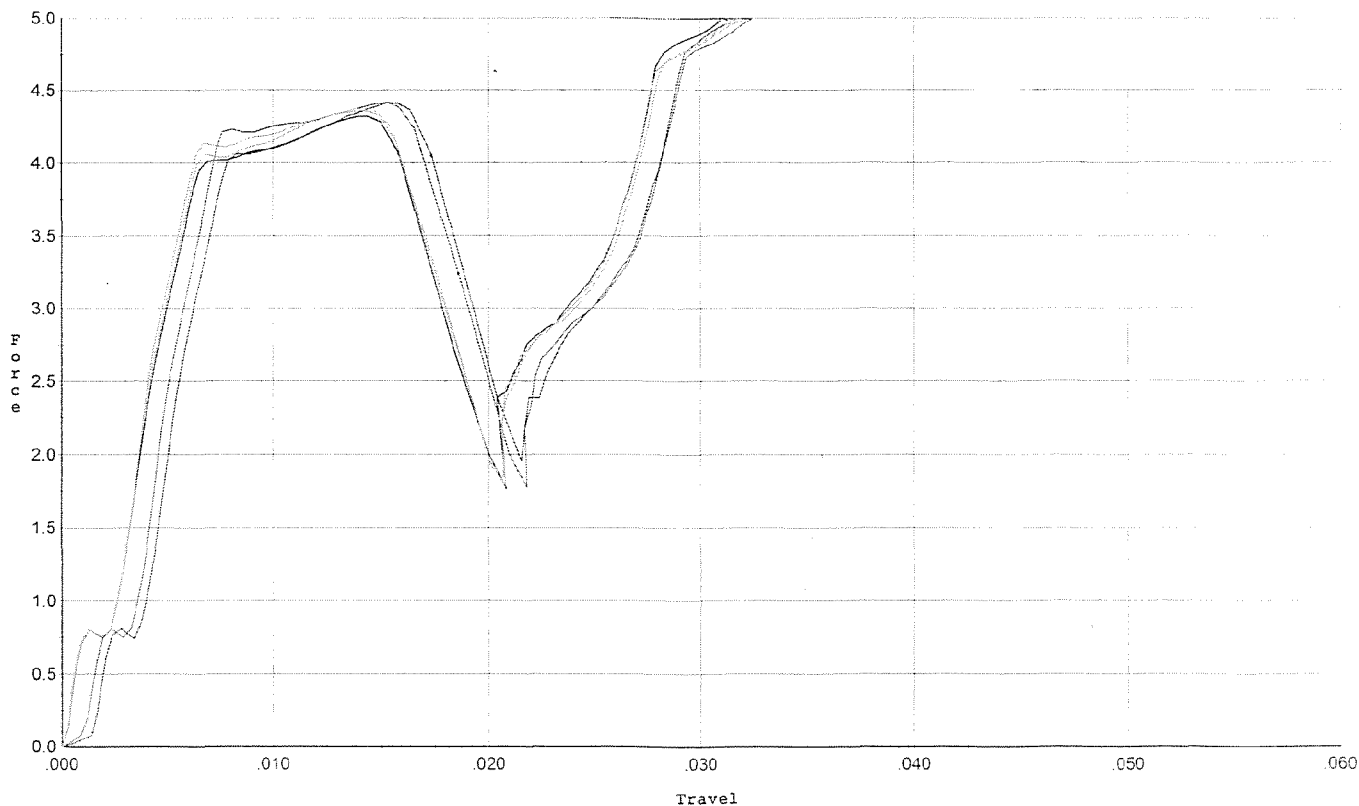
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.444	0.016	0.005	0.031	0.025		Set Trigger
2	2.395	0.014	0.00	0.030	0.025		Set Trigger
3	2.432	0.015	0.00	0.031	0.025		Set Trigger
4	2.363	0.013	0.00	0.030	0.023		Set Trigger
5	2.381	0.013	0.00	0.030	0.023		Set Trigger

A.2.40

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/24/2009

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	4.412	0.017	0.00	0.023	0.048		Set Trigger
2	4.317	0.016	0.00	0.023	0.046		Set Trigger
3	4.415	0.019	0.00	0.024	0.054		Set Trigger
4	4.376	0.018	0.00	0.024	0.052		Set Trigger
5	4.356	0.018	0.00	0.023	0.053		Set Trigger

A-4.37