

G6807685

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

- INSTRUCTION BOOK 3518

BM FORM

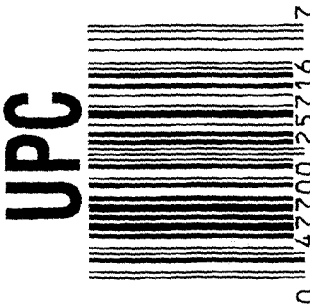


ORDER NO. 25716

BARREL LENGTH 24"

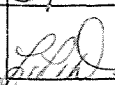
CAPACITY 6

G6807685



GUN SERIAL #

G 6807685

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3-27-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-27-09	RT
520	GOFF BLAST BBL / REC		3-27	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-22-09	
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

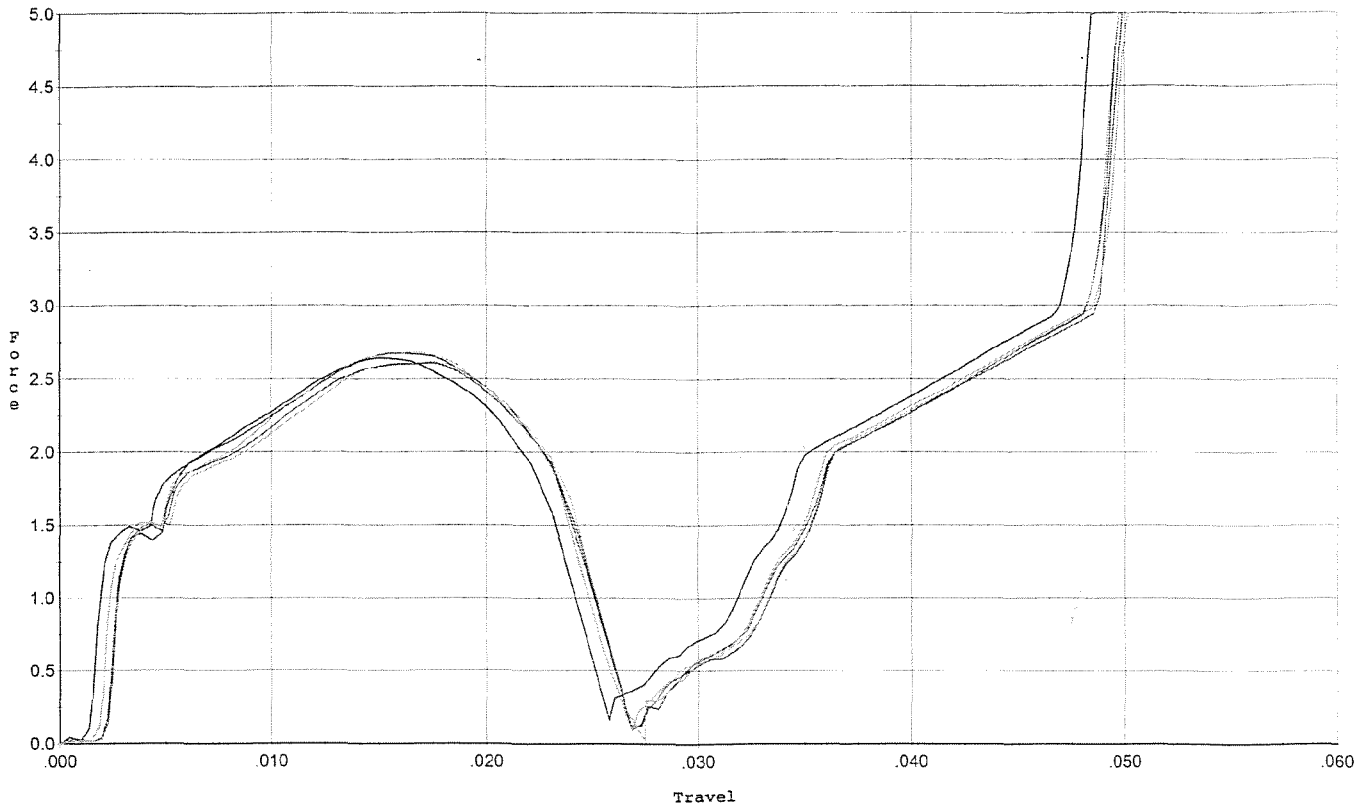
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	5-6-09	LJL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	5-6-09	LJL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	5-6-09	LJL
	J) ASSEMBLE STOCK		4-22-09	LJL
	K) ASSEMBLE SWIVEL STUDS		5-6-09	LJL
	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>FAIL</u> <u>PASS</u> <u>FAIL</u>	4-27-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-27-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE		5-6-09	LJL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u> <u>2.88</u> <u>2.66</u> <u>2.72</u> <u>2.73</u>	4-28-09	WV
	C) FUNCTION		5-6-09	LJL
690	PACK		5-29-09	WV

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



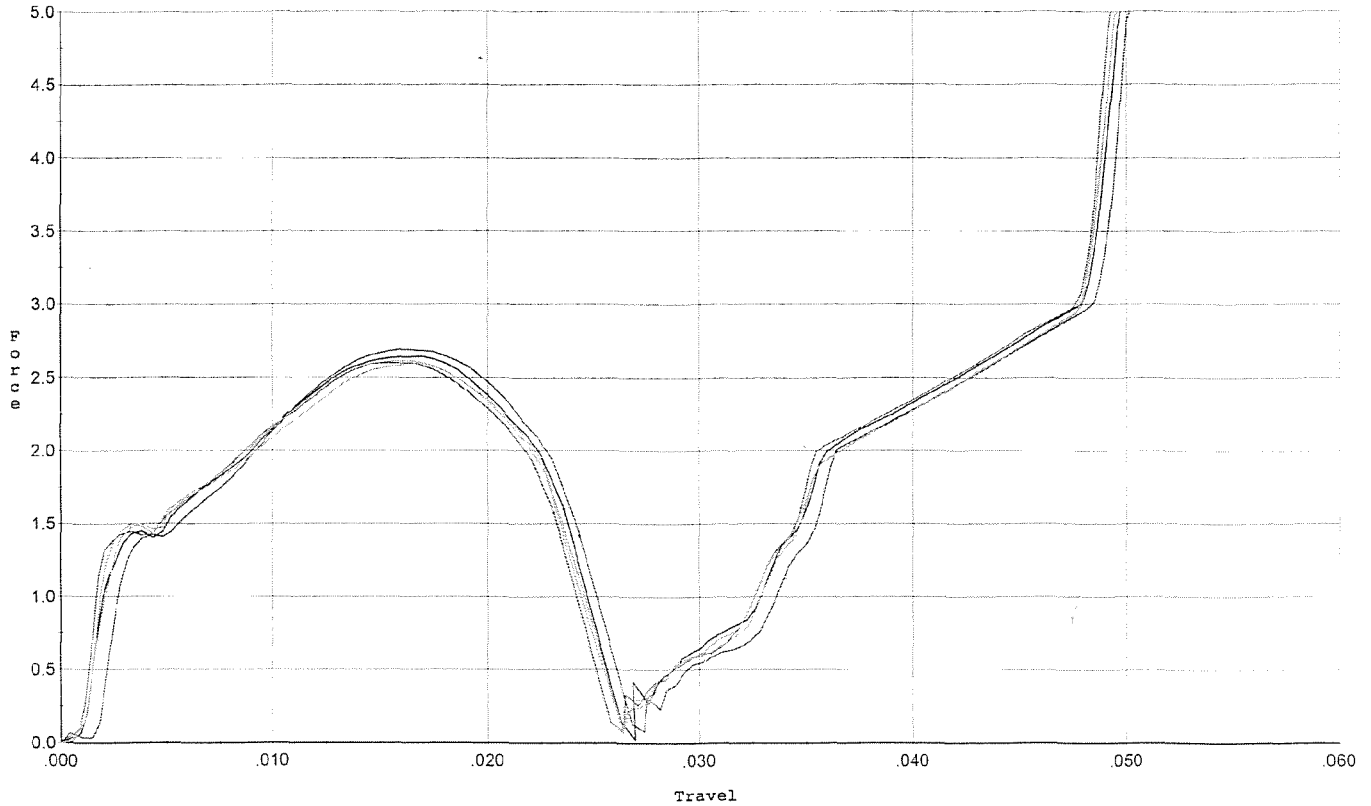
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.677	0.025	0.002	0.032	0.046		Set Trigger
2	2.642	0.023	0.00	0.032	0.044		Set Trigger
3	2.603	0.024	0.002	0.032	0.045		Set Trigger
4	2.615	0.024	0.00	0.032	0.044		Set Trigger
5	2.682	0.023	0.005	0.032	0.044		Set Trigger

Aug 2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



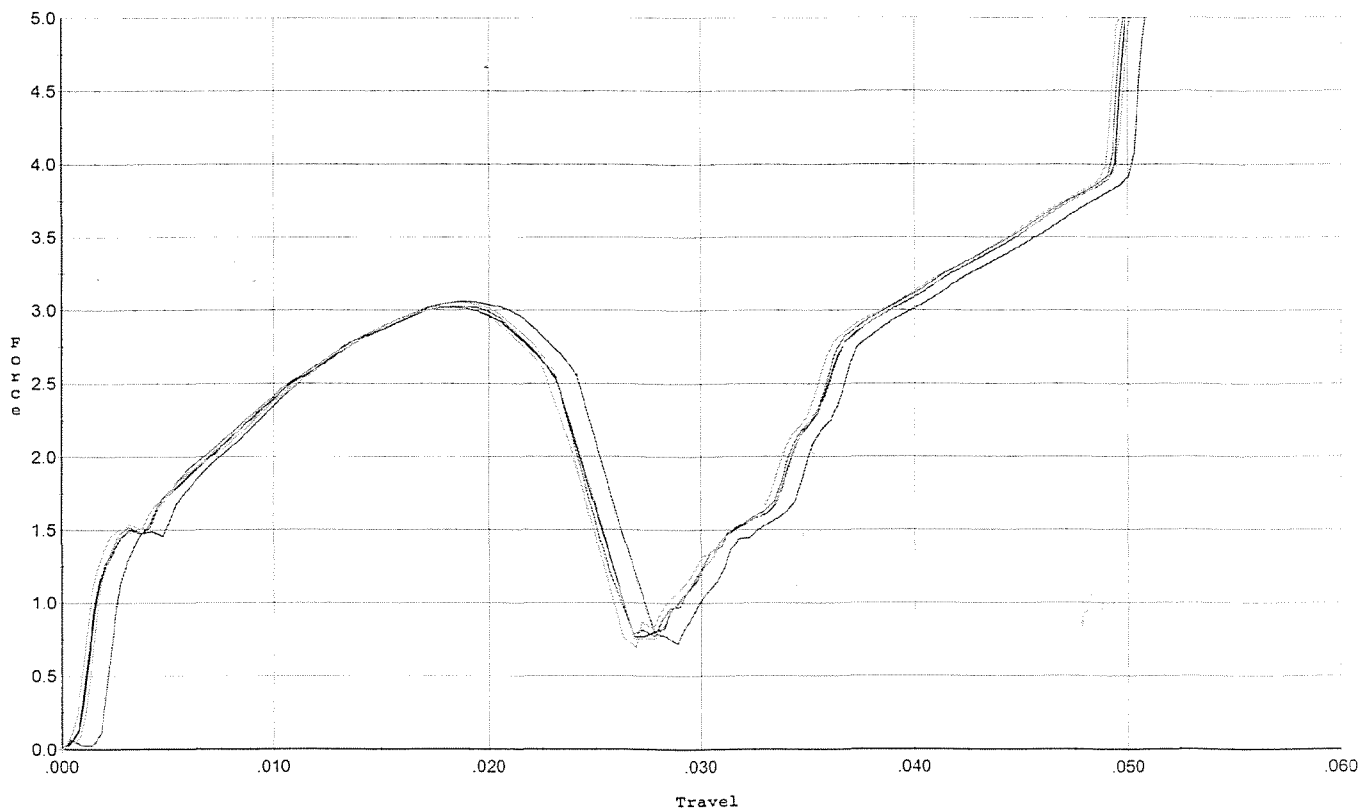
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.692	0.024	0.002	0.032	0.045		Set Trigger
2	2.643	0.024	0.00	0.033	0.044		Set Trigger
3	2.601	0.023	0.00	0.033	0.043		Set Trigger
4	2.598	0.023	0.00	0.033	0.042		Set Trigger
5	2.617	0.024	0.005	0.032	0.045		Set Trigger

Aug 2.64

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



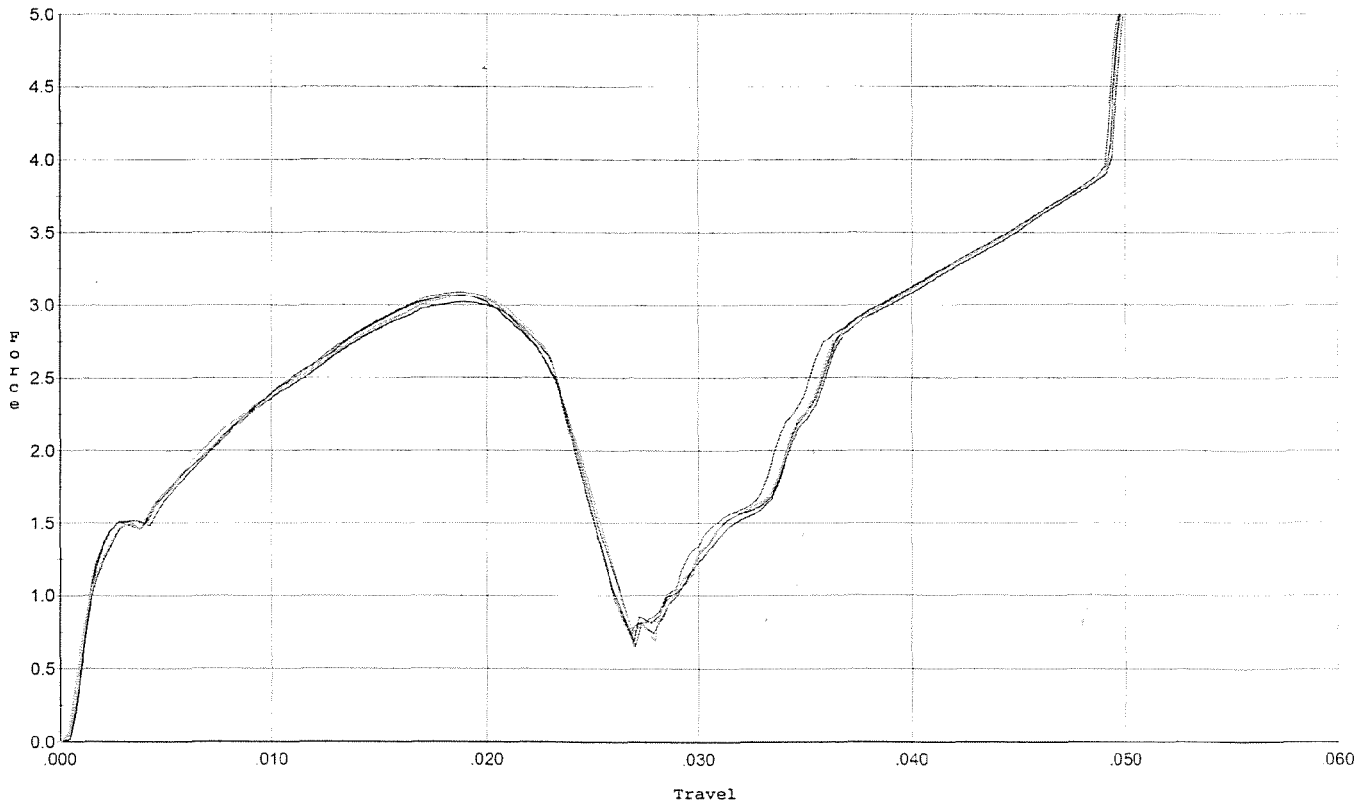
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.061	0.024	0.002	0.031	0.051		Set Trigger
2	3.019	0.023	0.00	0.031	0.050		Set Trigger
3	3.028	0.023	0.00	0.030	0.050		Set Trigger
4	3.015	0.024	0.00	0.030	0.052		Set Trigger
5	3.053	0.025	0.00	0.031	0.053		Set Trigger

Aug 3.03

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



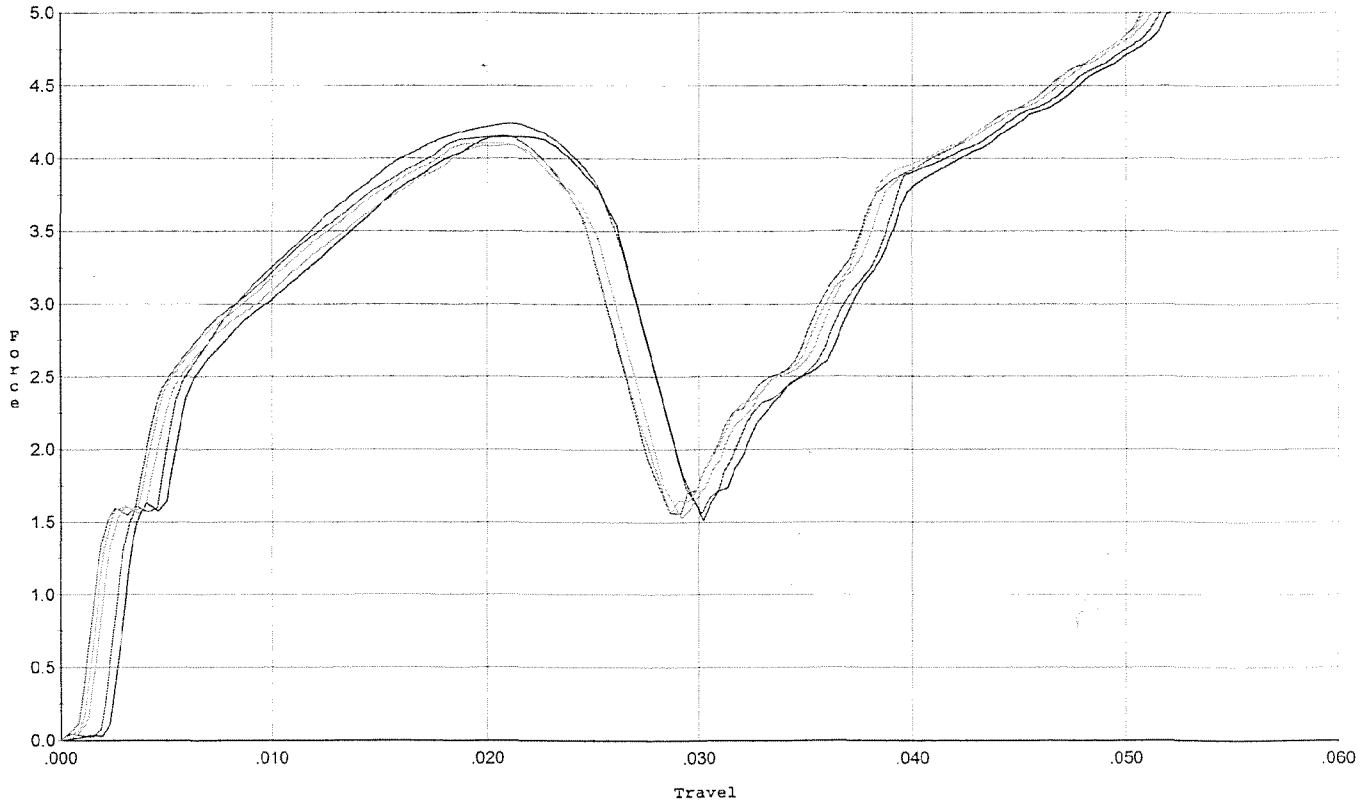
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.023	0.023	0.005	0.031	0.050		Set Trigger
2	3.067	0.023	0.004	0.030	0.050		Set Trigger
3	3.085	0.023	0.004	0.030	0.051		Set Trigger
4	3.074	0.025	0.00	0.030	0.054		Set Trigger
5	3.061	0.025	0.00	0.030	0.053		Set Trigger

Aug 3.06

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



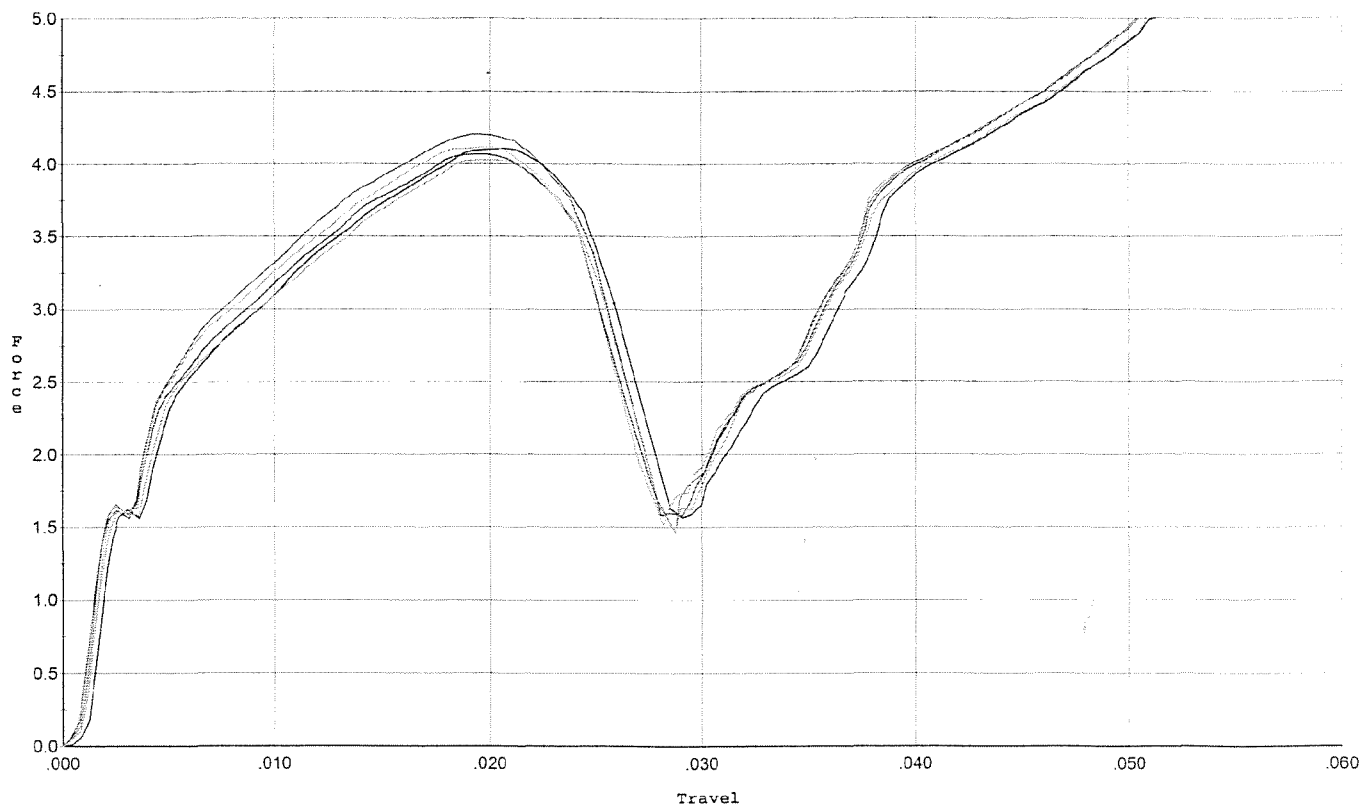
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.245	0.026	0.002	0.024	0.077		Set Trigger
2	4.152	0.026	0.00	0.024	0.073		Set Trigger
3	4.164	0.025	0.00	0.028	0.072		Set Trigger
4	4.109	0.025	0.00	0.027	0.070		Set Trigger
5	4.088	0.025	0.00	0.025	0.071		Set Trigger

Aug 4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

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



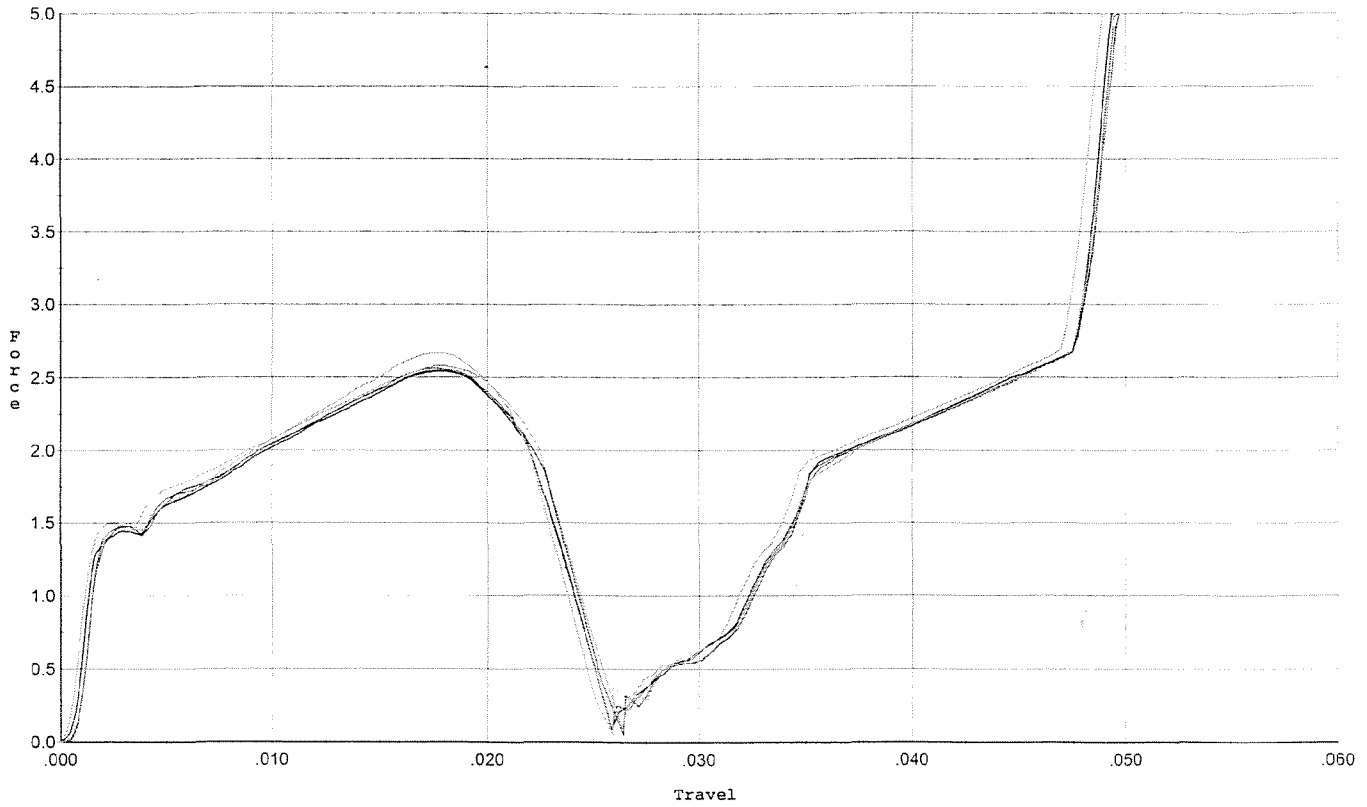
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.068	0.024	0.00	0.028	0.069		Set Trigger
2	4.102	0.026	0.00	0.024	0.073		Set Trigger
3	4.205	0.025	0.00	0.025	0.074		Set Trigger
4	4.112	0.024	0.00	0.028	0.070		Set Trigger
5	4.027	0.025	0.004	0.028	0.071		Set Trigger

Aug 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- 1.0 lbs.



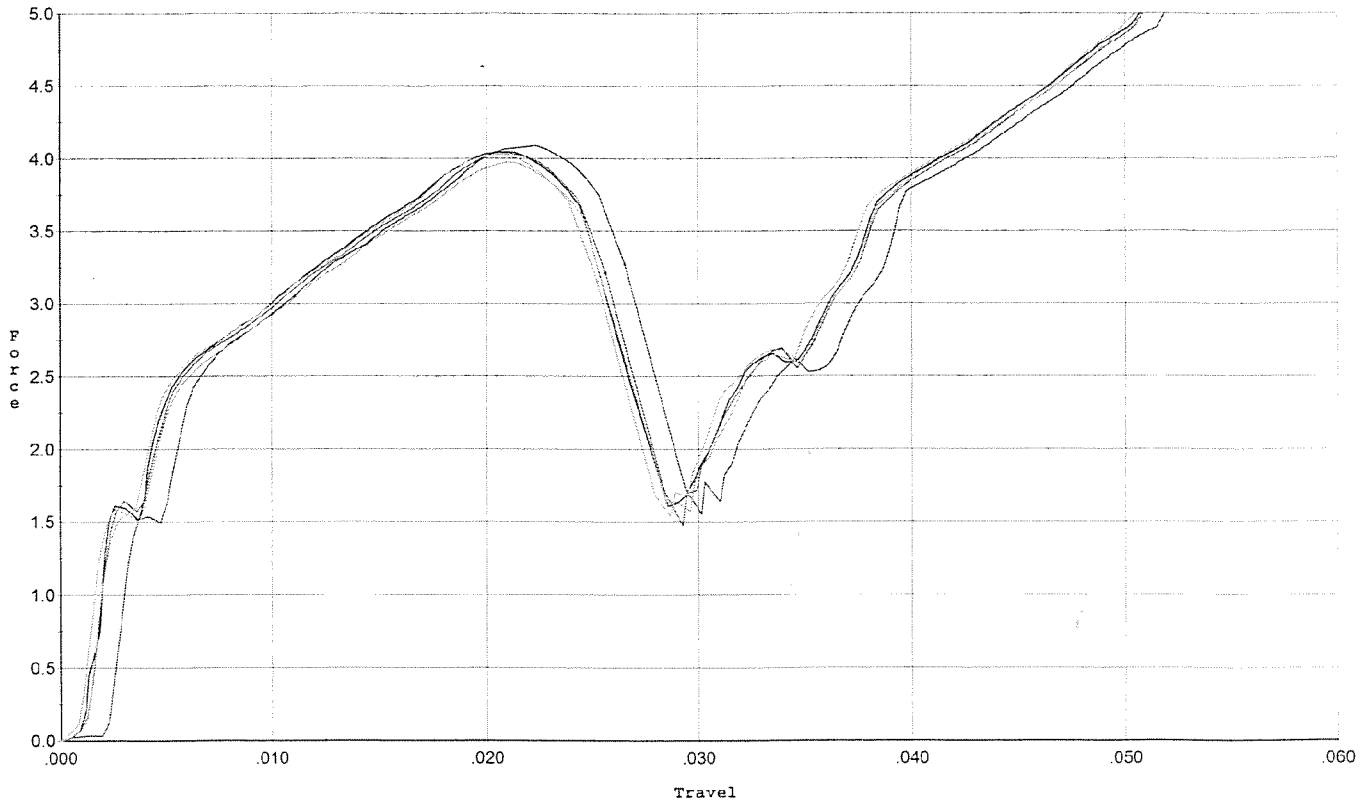
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.541	0.023	0.00	0.033	0.042		Set Trigger
2	2.549	0.024	0.004	0.032	0.043		Set Trigger
3	2.562	0.024	0.004	0.032	0.044		Set Trigger
4	2.666	0.022	0.004	0.032	0.042		Set Trigger
5	2.579	0.022	0.00	0.032	0.042		Set Trigger

AUG 2.57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R.P. 2/14/09

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.089	0.027	0.002	0.024	0.072		Set Trigger
2	4.043	0.024	0.004	0.027	0.068		Set Trigger
3	4.034	0.026	0.00	0.024	0.071		Set Trigger
4	4.026	0.025	0.00	0.025	0.070		Set Trigger
5	3.976	0.025	0.00	0.027	0.066		Set Trigger

Aug 4.03