

66807748

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

G6807748



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807748

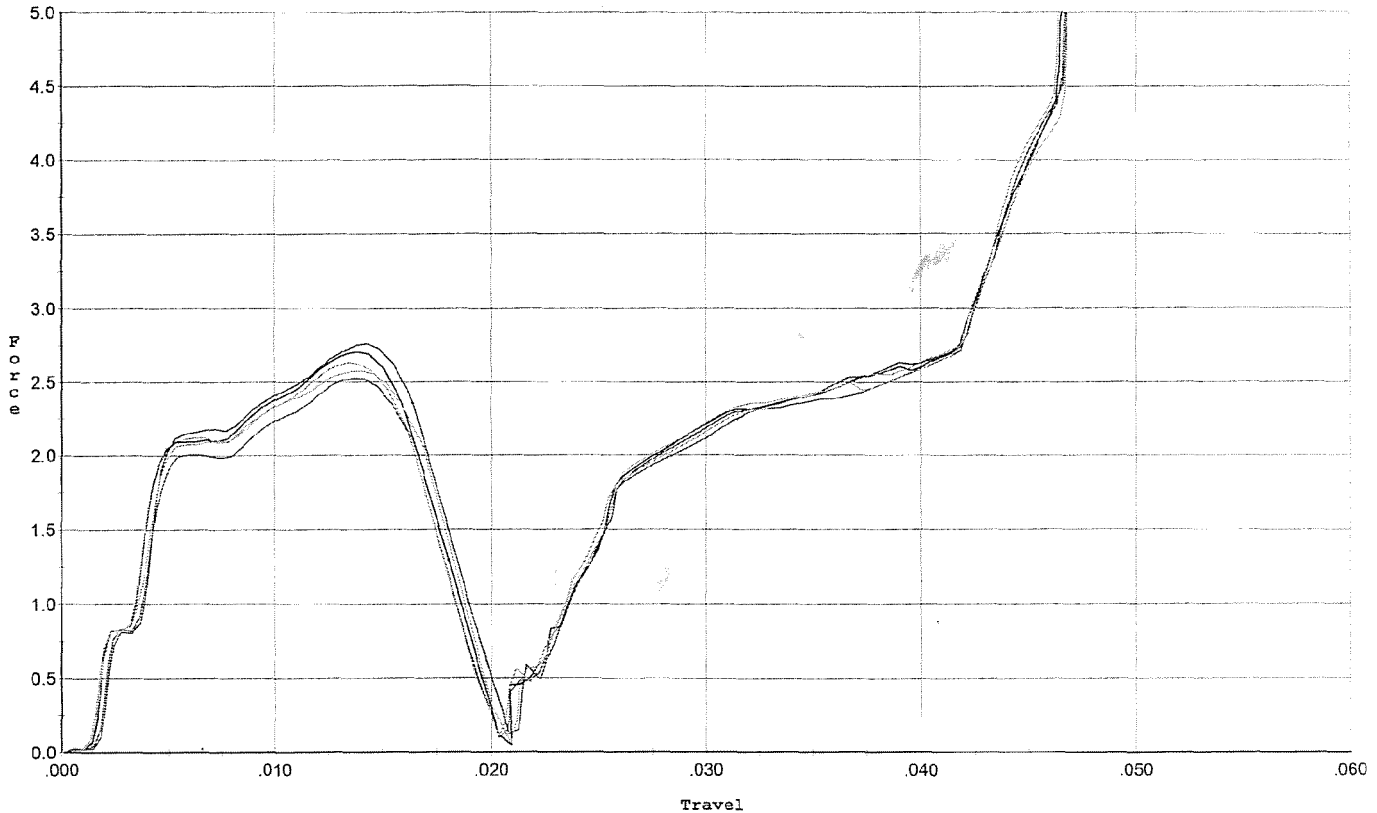
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		2-27-09	RP
430	ASSEMBLE TO STOCK		2-27-09	RP
440	PROOF		2-27-09	RP
460	CHECK HEADSPACE	MAGNA - FLUX	2-27-09	RP
470	DIS-ASSEMBLE ACTION		2-27-09	RP
472	SERIALIZE BOLT HANDLE		3-2-09	RP
480	MAGNAFLUX BBL ACTION	OPERATOR	3/5/09	RP
490	MAGNAFLUX BOLT		3/5/09	RP
500	ROLLMARK CALIBER		3/5/09	RP
510	DRILL AND TAP SIGHT HOLES		3-2-09	SP
520	GOFF BLAST BBL / REC		3/6	WON
540	APPLY COATINGS (BARREL ACTION)		8/11	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-12-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-12-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-12-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-16-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>5</u> <u>5</u>	3-20-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-20-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3-20-09	NW
	J) ASSEMBLE STOCK		3-16-09	NW
	K) ASSEMBLE SWIVEL STUDS		3-20-09	NW
	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	3-18-09	SPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-18-09	RP
670	FINAL INSPECTION A) HEADSPACE		3-20-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.46</u> <u>2.43</u> <u>2.39</u> <u>2.43</u>	3-19-09	TL
	C) FUNCTION		3-20-09	NW
690	PACK		3-20-09	TL

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



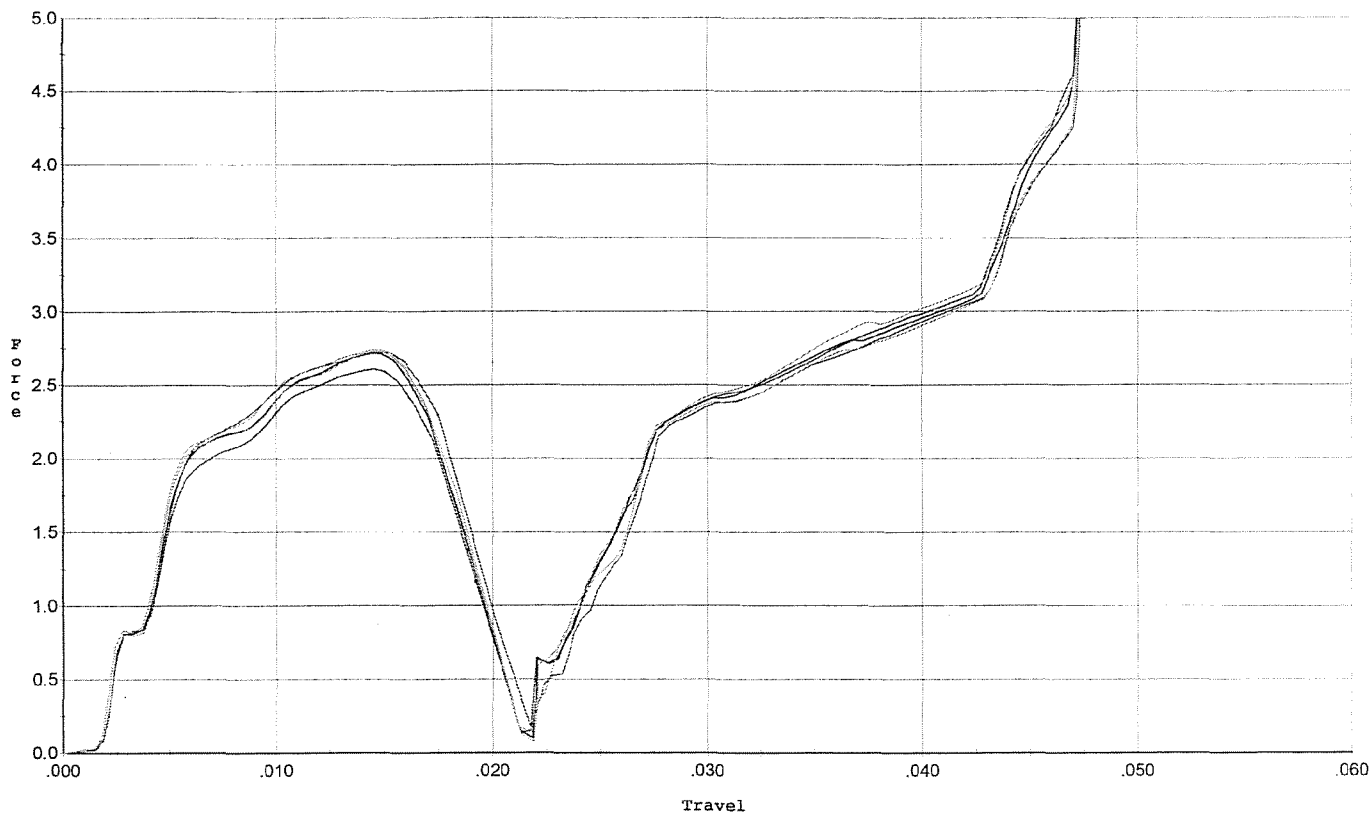
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.759	0.016	0.002	0.033	0.029		Set Trigger
2	2.707	0.018	0.00	0.032	0.032		Set Trigger
3	2.526	0.016	0.00	0.033	0.027		Set Trigger
4	2.575	0.017	0.00	0.033	0.029		Set Trigger
5	2.634	0.016	0.00	0.033	0.029		Set Trigger

A.2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



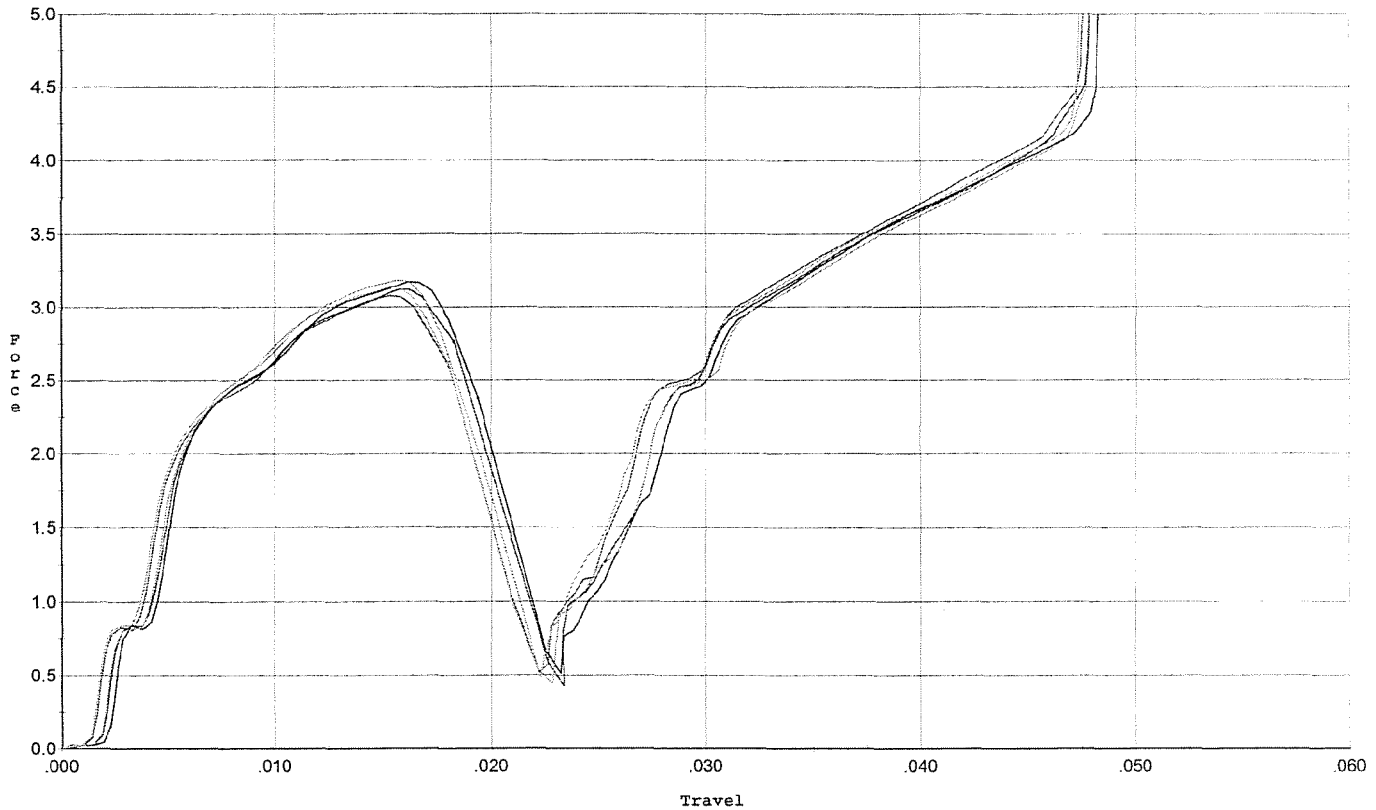
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.608	0.019	0.002	0.032	0.032		Set Trigger
2	2.718	0.019	0.002	0.032	0.033		Set Trigger
3	2.721	0.018	0.00	0.032	0.031		Set Trigger
4	2.742	0.018	0.00	0.032	0.033		Set Trigger
5	2.728	0.019	0.00	0.032	0.033		Set Trigger

A-2.70

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



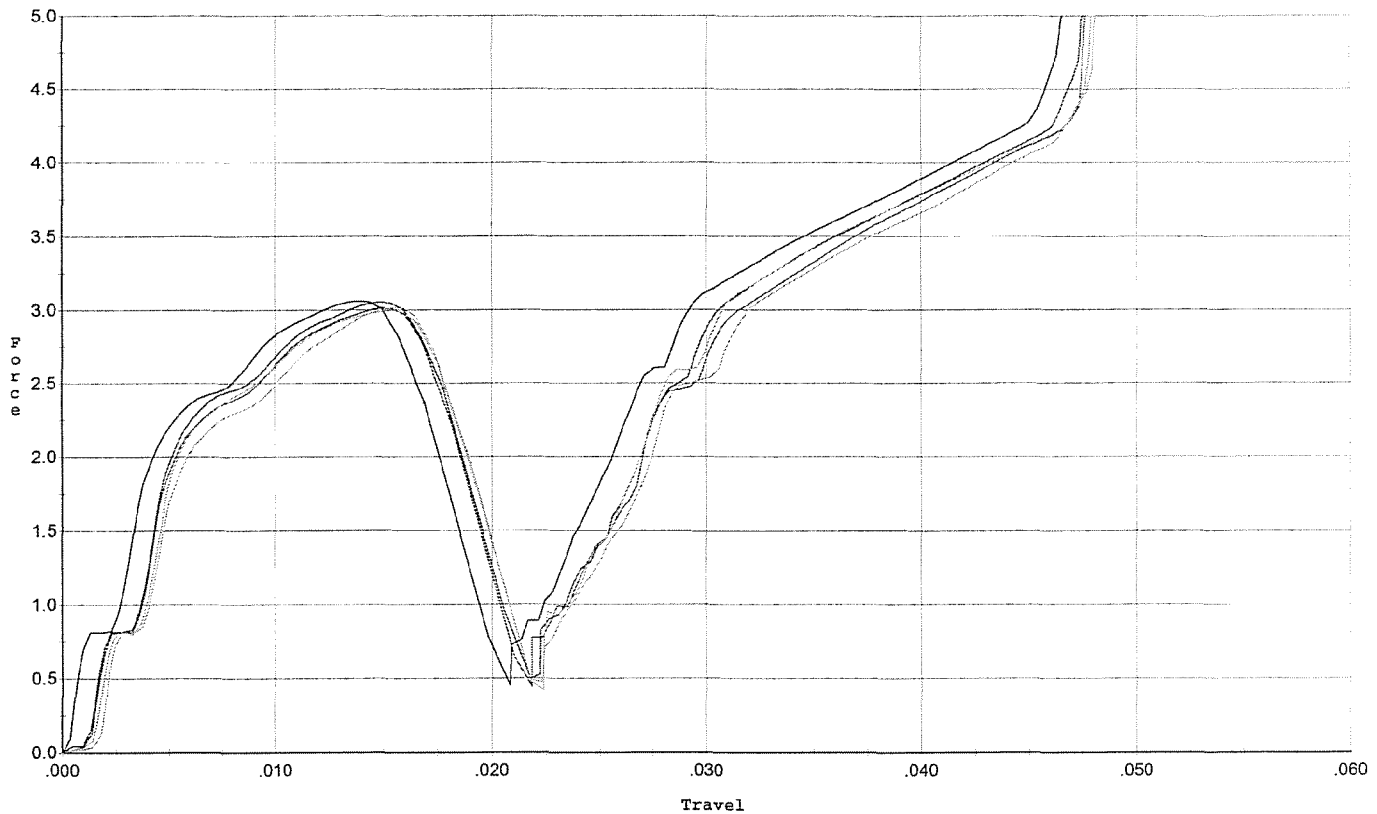
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.123	0.018	0.00	0.031	0.037		Set Trigger
2	3.174	0.019	0.00	0.031	0.039		Set Trigger
3	3.082	0.018	0.00	0.031	0.036		Set Trigger
4	3.136	0.018	0.00	0.031	0.037		Set Trigger
5	3.183	0.019	0.00	0.031	0.040		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



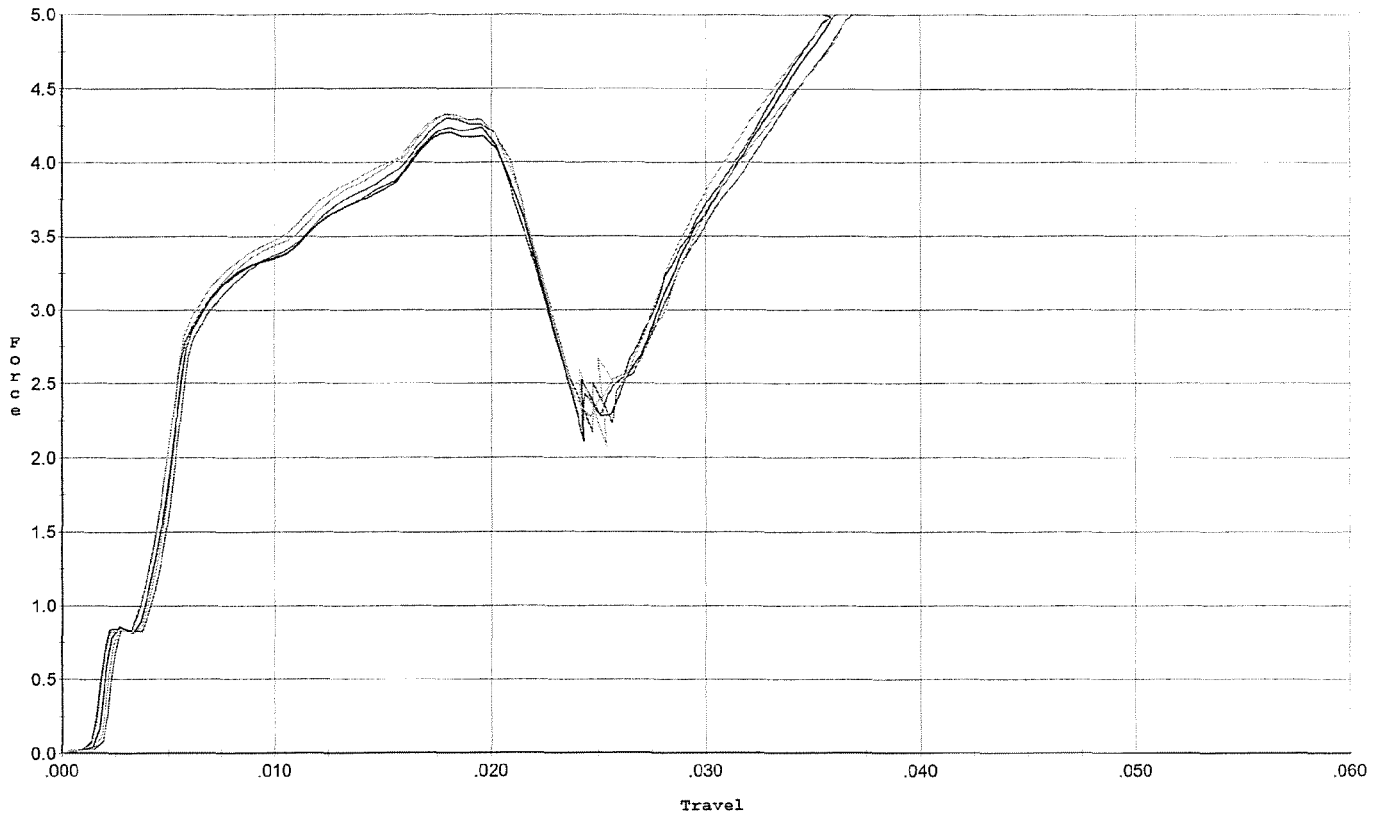
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.053	0.018	0.00	0.031	0.036		Set Trigger
2	3.060	0.017	0.00	0.031	0.036		Set Trigger
3	3.014	0.018	0.00	0.031	0.036		Set Trigger
4	2.998	0.019	0.00	0.031	0.038		Set Trigger
5	3.015	0.019	0.00	0.031	0.036		Set Trigger

A-3.02

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



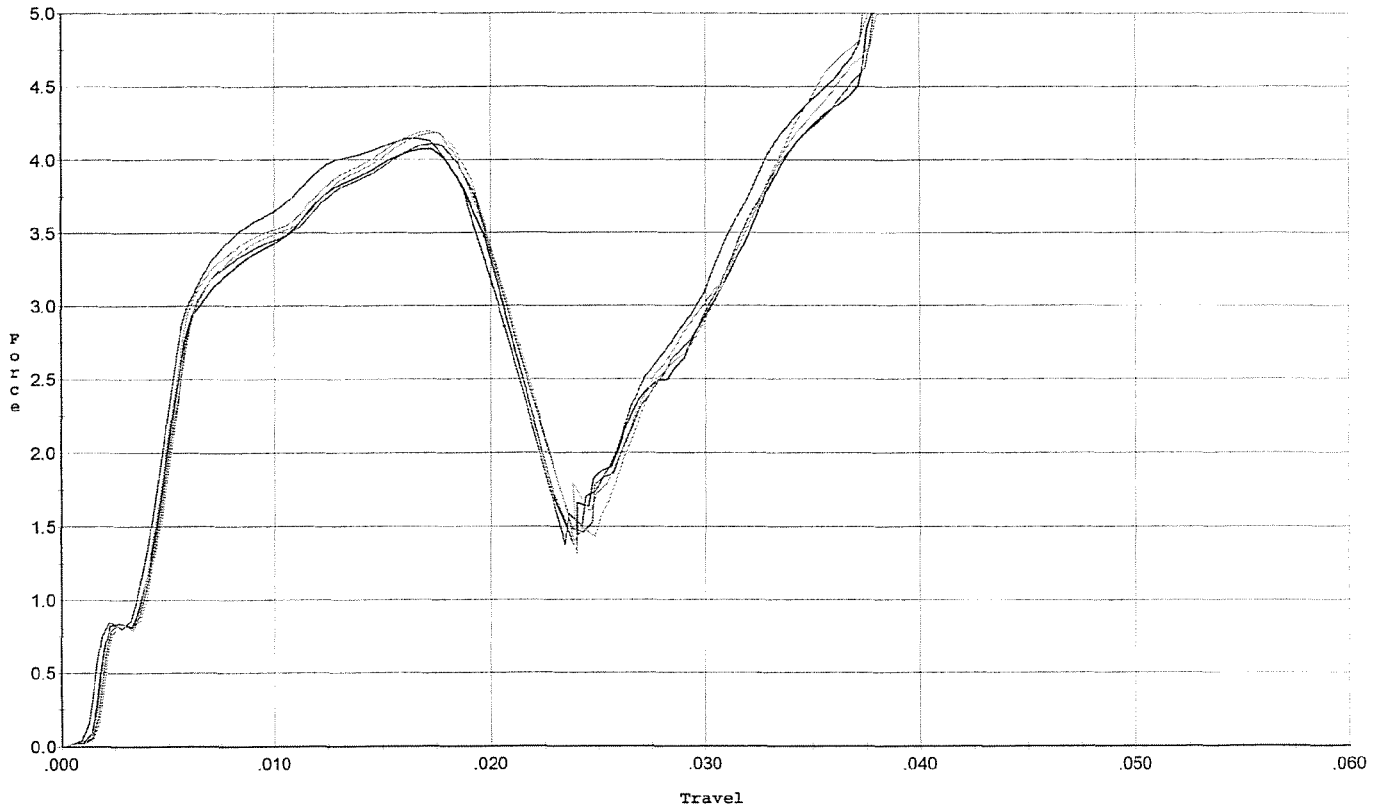
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.239	0.022	0.00	0.014	0.060		Set Trigger
2	4.204	0.021	0.00	0.014	0.058		Set Trigger
3	4.299	0.021	0.004	0.015	0.057		Set Trigger
4	4.326	0.021	0.00	0.014	0.059		Set Trigger
5	4.333	0.021	0.00	0.015	0.058		Set Trigger

A-4-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



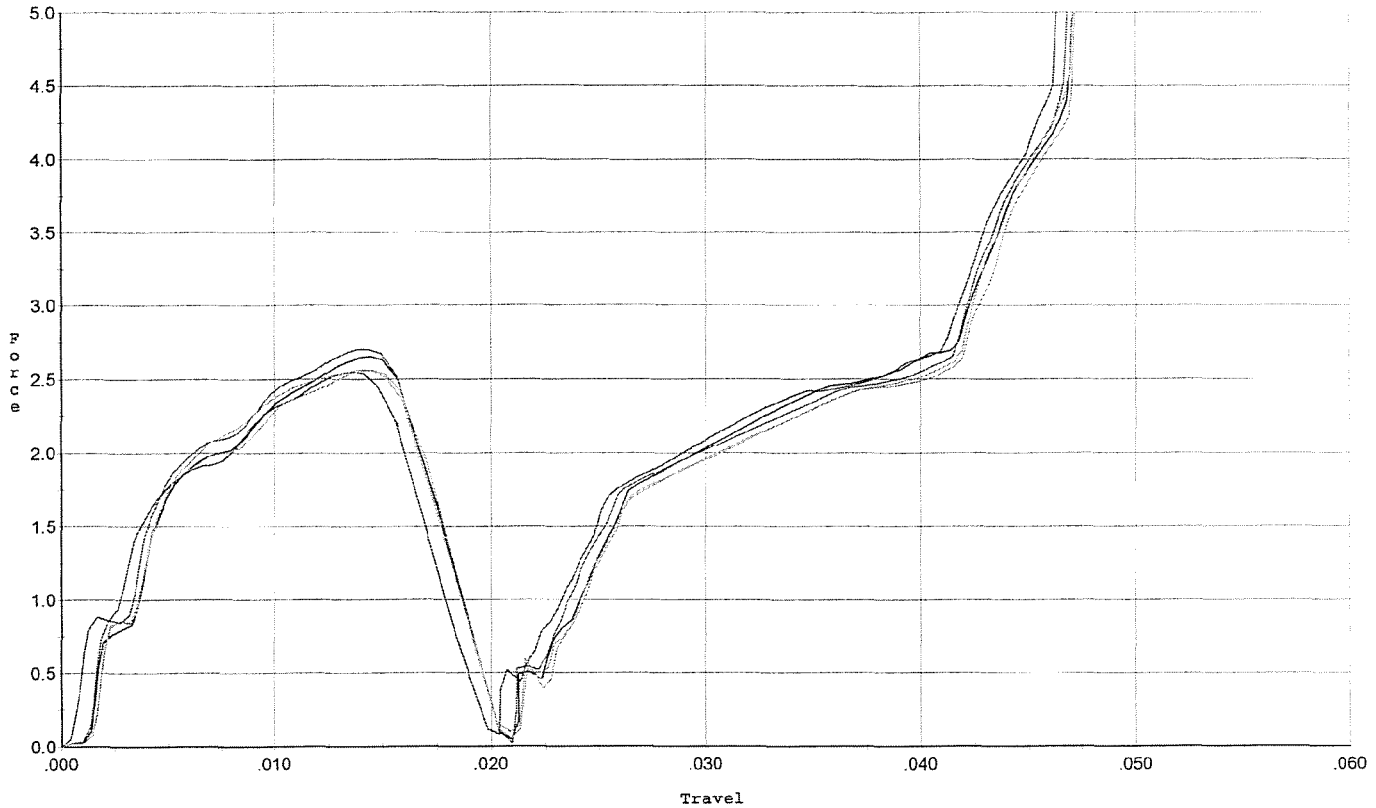
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.145	0.021	0.00	0.025	0.057		Set Trigger
2	4.073	0.020	0.00	0.026	0.052		Set Trigger
3	4.109	0.019	0.00	0.026	0.051		Set Trigger
4	4.180	0.021	0.00	0.025	0.057		Set Trigger
5	4.199	0.019	0.00	0.026	0.053		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



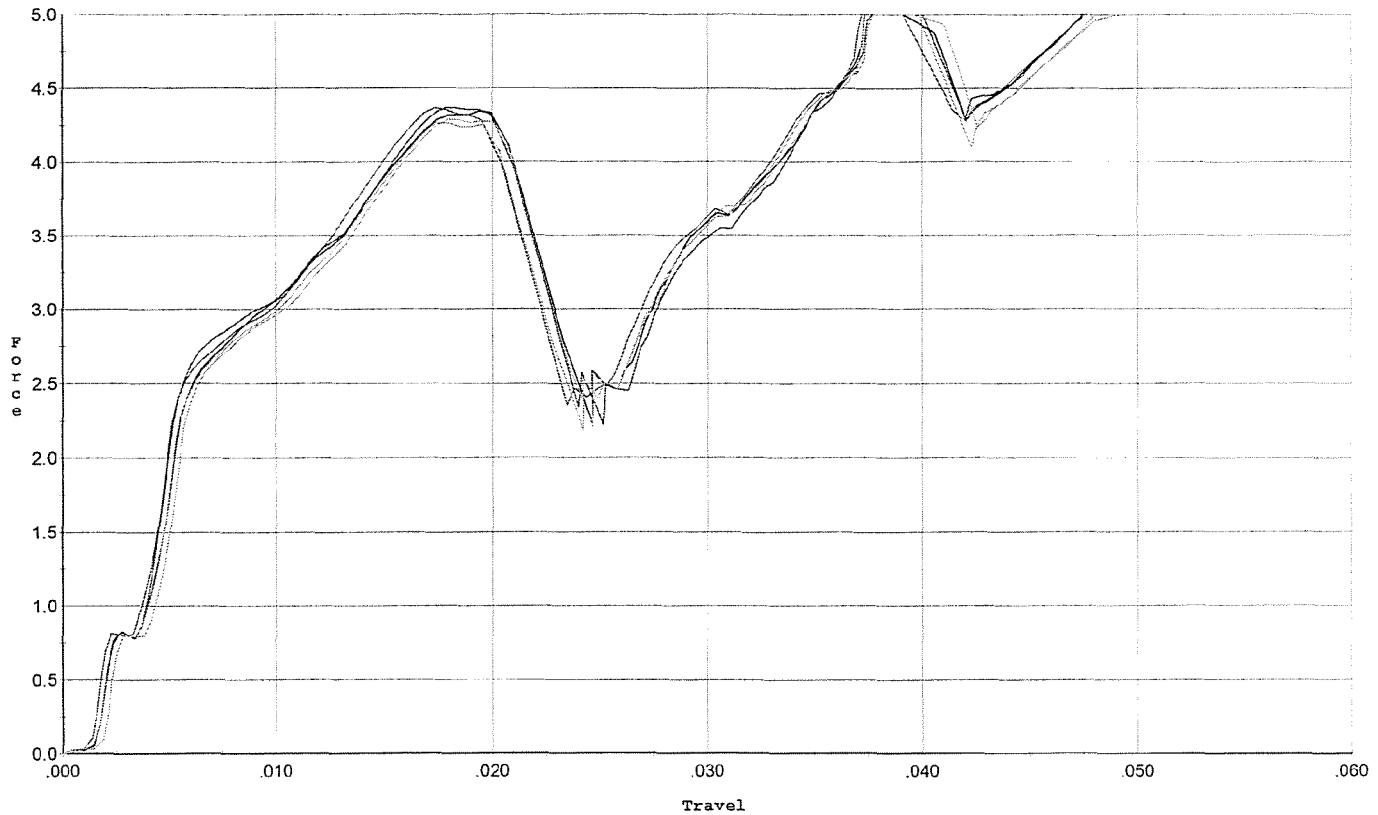
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.016	0.00	0.033	0.027		Set Trigger
2	2.654	0.017	0.00	0.033	0.030		Set Trigger
3	2.703	0.018	0.00	0.033	0.031		Set Trigger
4	2.568	0.018	0.00	0.034	0.031		Set Trigger
5	2.562	0.017	0.00	0.034	0.029		Set Trigger

A 2.60

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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	4.370	0.021	0.00	0.027	0.056		Set Trigger
2	4.342	0.021	0.00	0.026	0.055		Set Trigger
3	4.364	0.020	0.00	0.027	0.055		Set Trigger
4	4.289	0.021	0.004	0.027	0.054		Set Trigger
5	4.267	0.020	0.00	0.027	0.053		Set Trigger

A. 4.32