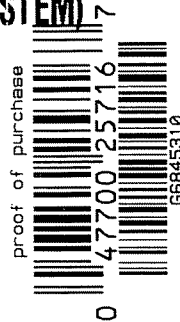


01851893

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

- INSTRUCTION BOOK 3518

BM FORM

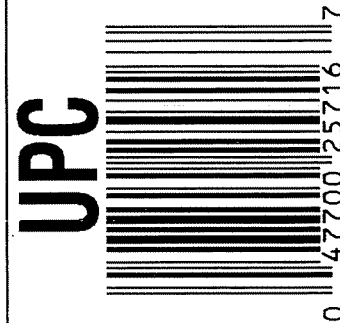


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845310



GUN SERIAL # G 6845310

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-17-09	SPD
430	ASSEMBLE TO STOCK		3-17-09	RP
440	PROOF		3-17-09	SPD
460	CHECK HEADSPACE		3-17-09	SPD
470	DIS-ASSEMBLE ACTION		3-17-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-18-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-18-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/20/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/24/09	RT
520	GOFF BLAST BBL / REC		3-24	BT
542	APPLY COATINGS (BARREL ACTION)		3-27	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-28-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-28-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-28-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-1-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

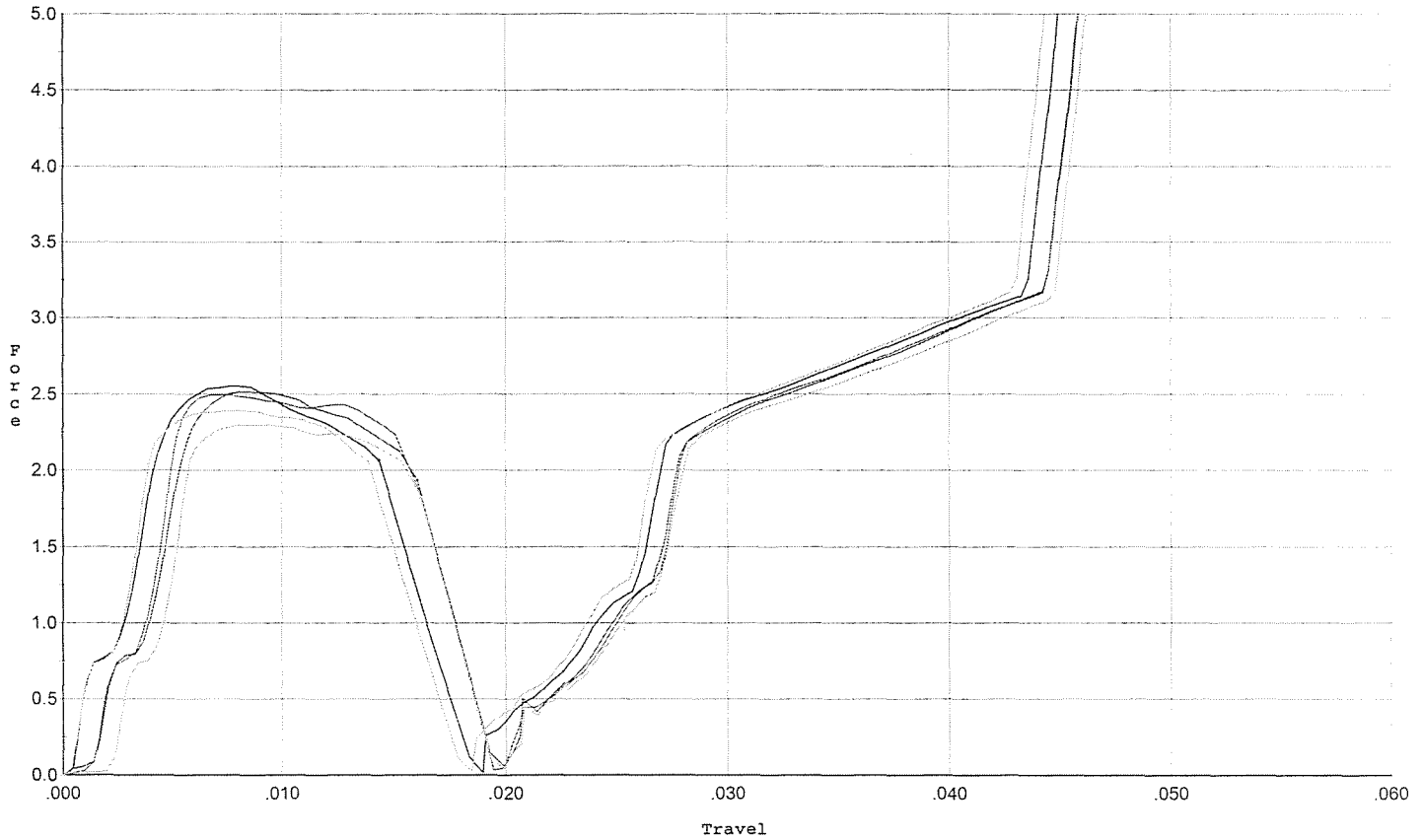
F004 REV 5/2006

560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>4</u> <u>5.5</u>	4-13-09	W/N
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	4-13-09	W/N
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-13-09	W/N
	J) ASSEMBLE STOCK			4-1-09	R.J.
	K) ASSEMBLE SWIVEL STUDS			4-13-09	W/N
	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	4-2-09	TC
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			4-2-09	W/N
670	FINAL INSPECTION A) HEADSPACE			4-13-09	W/N
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u> <u>2.52</u> <u>2.55</u> <u>2.60</u> <u>2.62</u>	4-7-09	RP
	C) FUNCTION			4-13-09	W/N
690	PACK			6/4/09	Fm

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



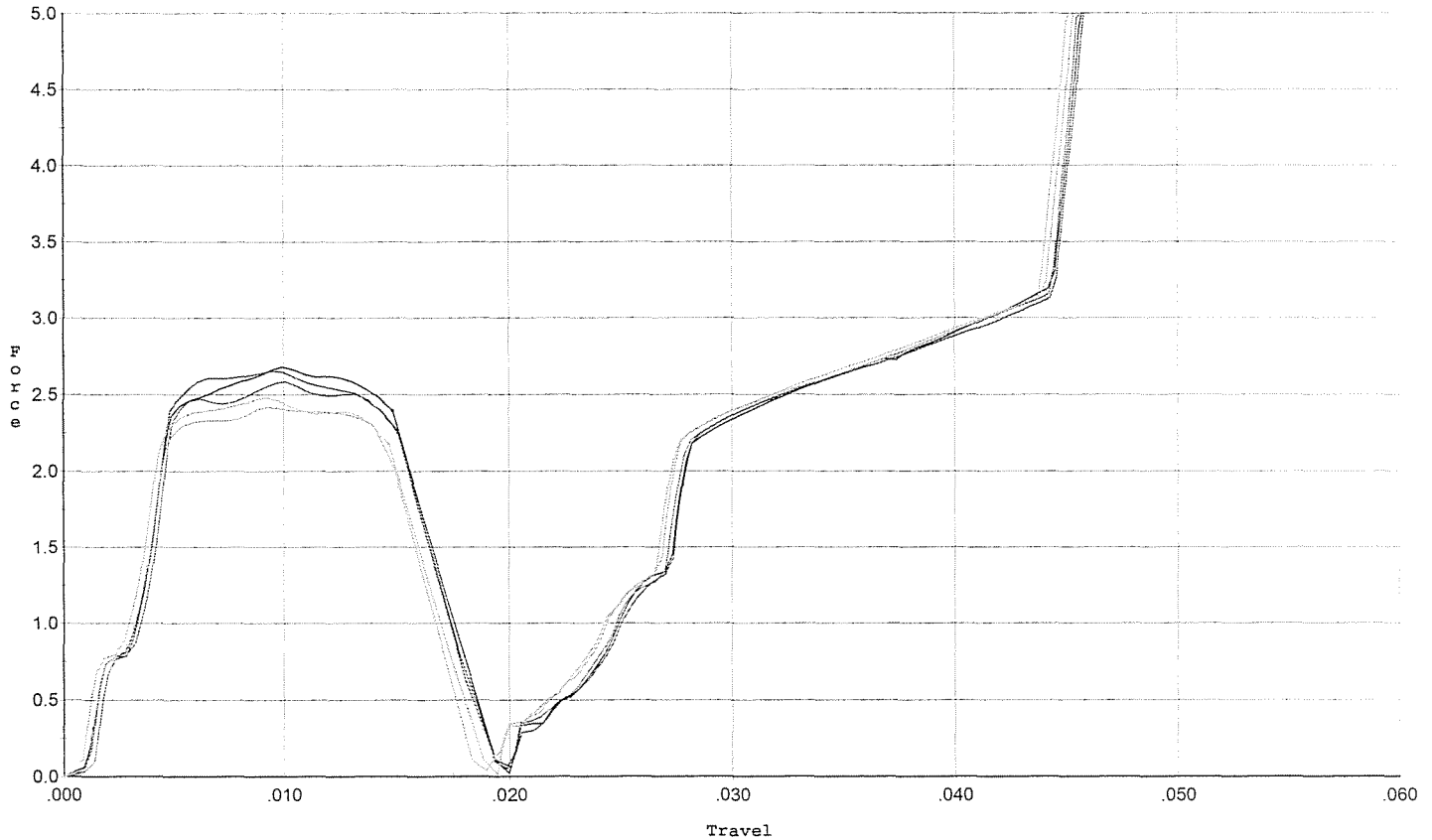
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.515	0.016	0.00	0.033	0.027		Set Trigger
2	2.553	0.014	0.00	0.034	0.026		Set Trigger
3	2.492	0.016	0.00	0.033	0.028		Set Trigger
4	2.296	0.016	0.002	0.033	0.025		Set Trigger
5	2.393	0.014	0.00	0.033	0.024		Set Trigger

A-2.45

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



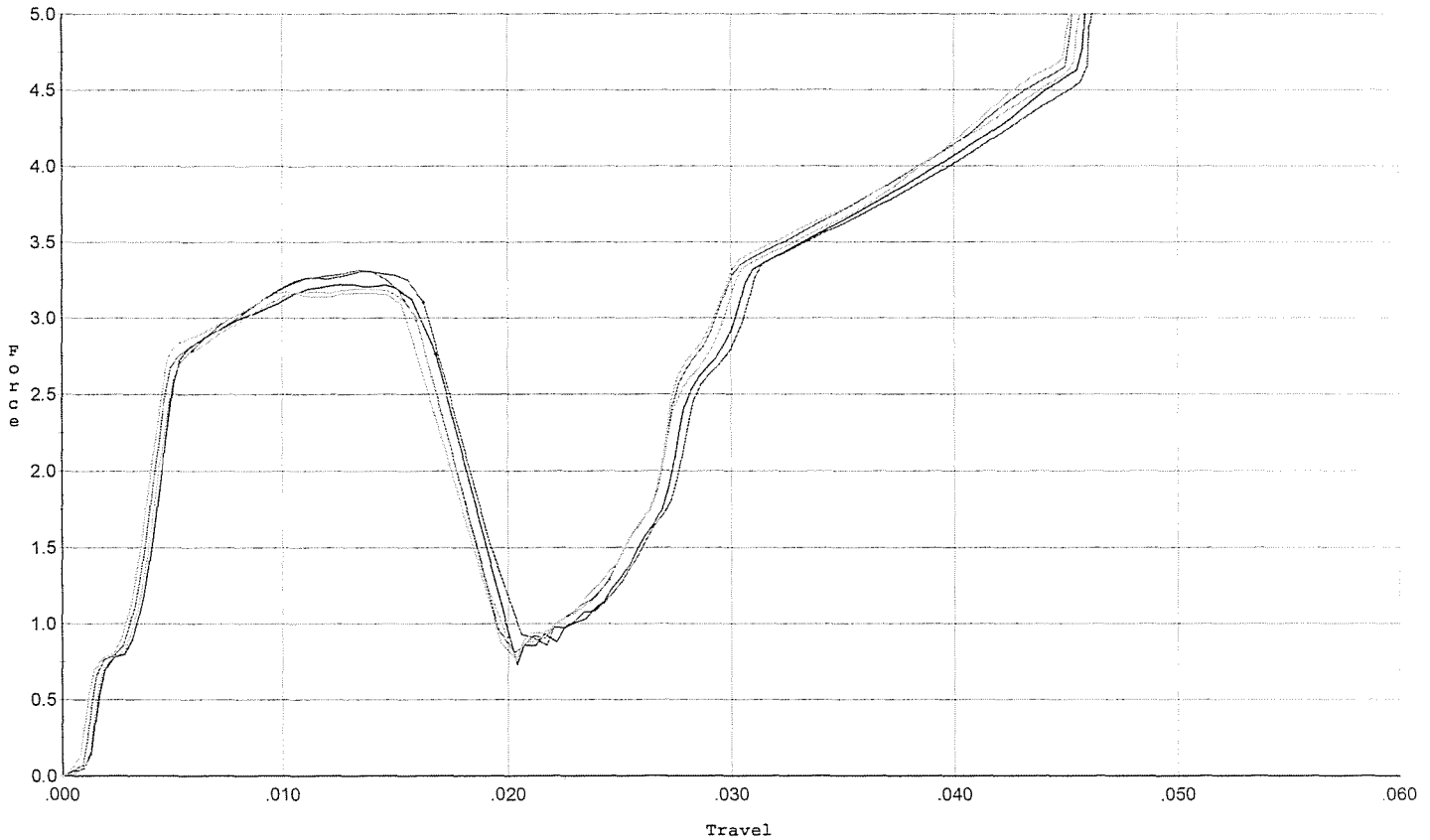
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.653	0.015	0.00	0.033	0.028		Set Trigger
2	2.680	0.015	0.00	0.033	0.028		Set Trigger
3	2.585	0.015	0.00	0.033	0.027		Set Trigger
4	2.481	0.015	0.00	0.033	0.027		Set Trigger
5	2.419	0.015	0.00	0.033	0.026		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: 3.0 lbs ini +/- .75 lb



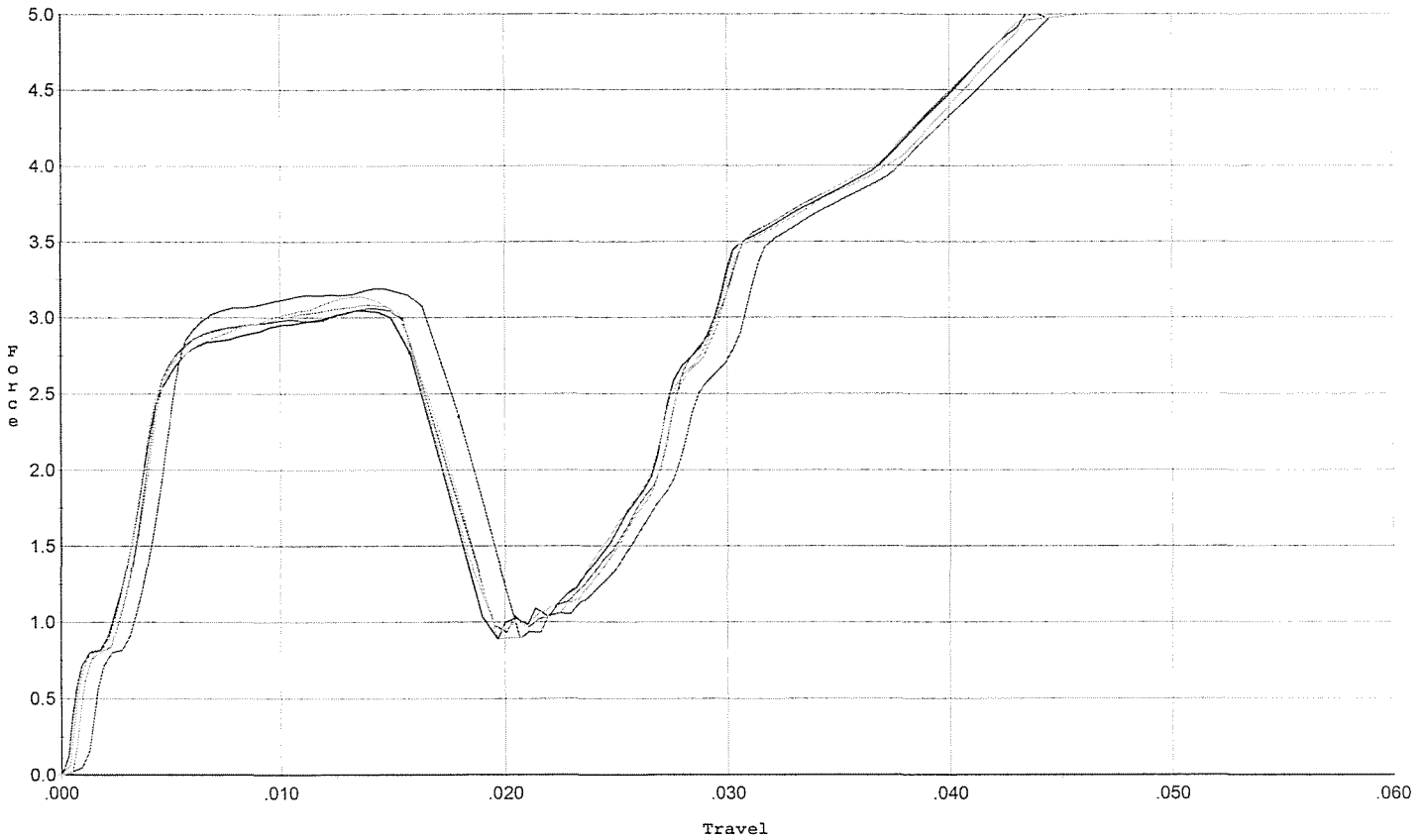
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.307	0.016	0.00	0.030	0.037		Set Trigger
2	3.222	0.017	0.00	0.030	0.037		Set Trigger
3	3.317	0.016	0.00	0.030	0.036		Set Trigger
4	3.174	0.017	0.00	0.030	0.039		Set Trigger
5	3.193	0.016	0.00	0.030	0.035		Set Trigger

A-3-24

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



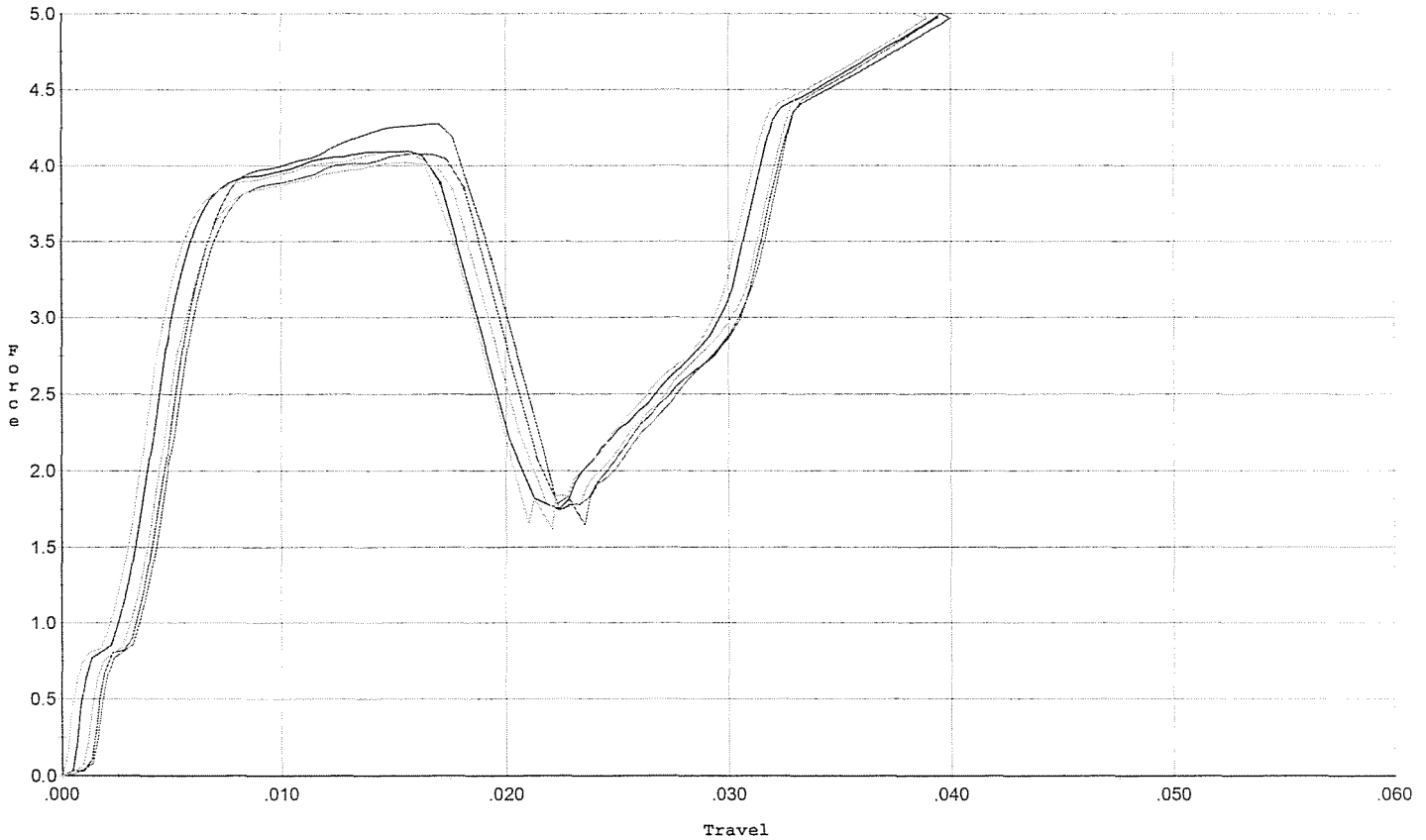
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.190	0.018	0.00	0.031	0.040		Set Trigger
2	3.044	0.016	0.00	0.030	0.035		Set Trigger
3	3.057	0.015	0.00	0.030	0.034		Set Trigger
4	3.133	0.016	0.00	0.030	0.035		Set Trigger
5	3.083	0.017	0.00	0.030	0.038		Set Trigger

A-3-10

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



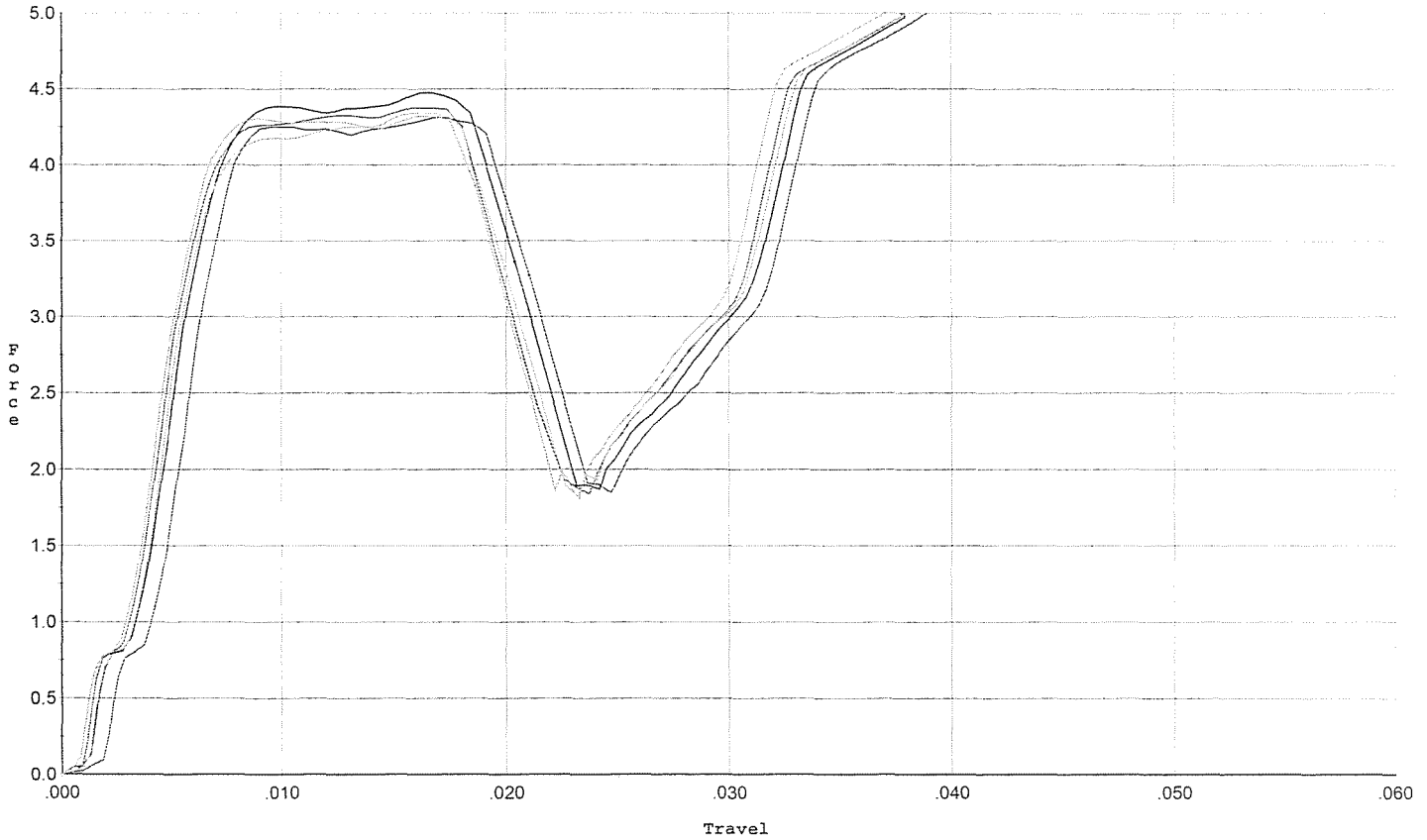
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.277	0.019	0.00	0.028	0.055		Set Trigger
2	4.095	0.017	0.00	0.029	0.049		Set Trigger
3	4.078	0.018	0.00	0.029	0.050		Set Trigger
4	4.088	0.018	0.00	0.029	0.052		Set Trigger
5	4.021	0.018	0.00	0.029	0.049		Set Trigger

A-4.11

Trigger Profile [lbs,inch]

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

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



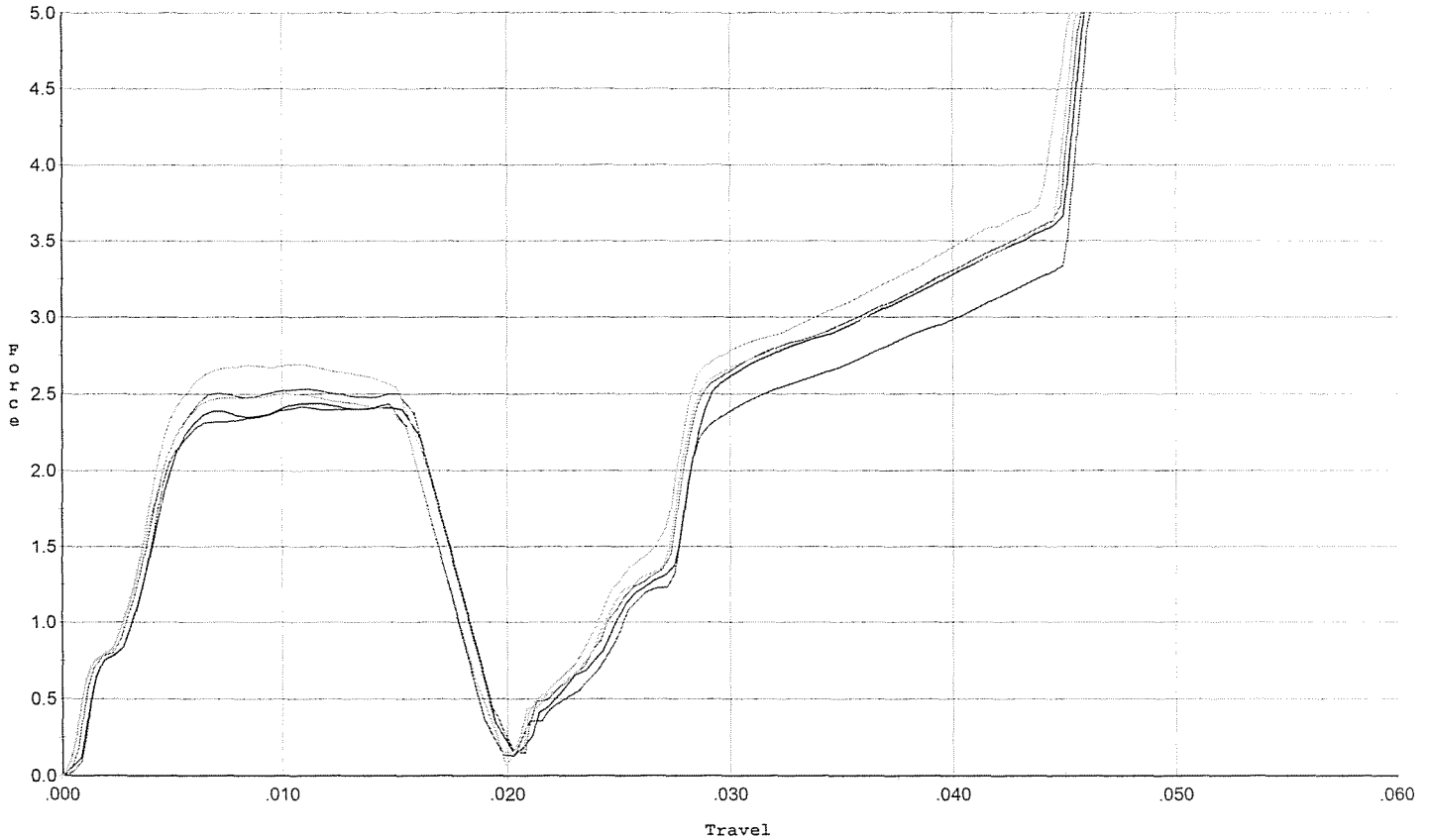
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.317	0.021	0.00	0.028	0.061		Set Trigger
2	4.477	0.020	0.00	0.028	0.062		Set Trigger
3	4.379	0.018	0.00	0.028	0.055		Set Trigger
4	4.323	0.020	0.00	0.028	0.059		Set Trigger
5	4.343	0.019	0.00	0.027	0.057		Set Trigger

A-4.36

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	2.435	0.016	0.00	0.033	0.028		Set Trigger
2	2.439	0.016	0.00	0.032	0.029		Set Trigger
3	2.533	0.016	0.00	0.032	0.030		Set Trigger
4	2.504	0.016	0.00	0.032	0.029		Set Trigger
5	2.693	0.016	0.00	0.032	0.032		Set Trigger

A-2-52