

G6845312

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

- INSTRUCTION BOOK 3518

BM FORM

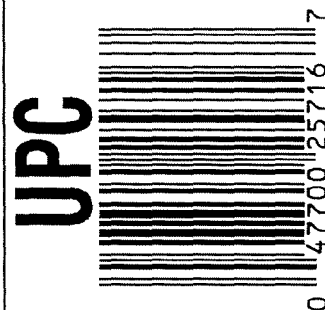


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6845312



GUN SERIAL # G 6845312

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		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)		3-28	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-31-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-31-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-31-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-9-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

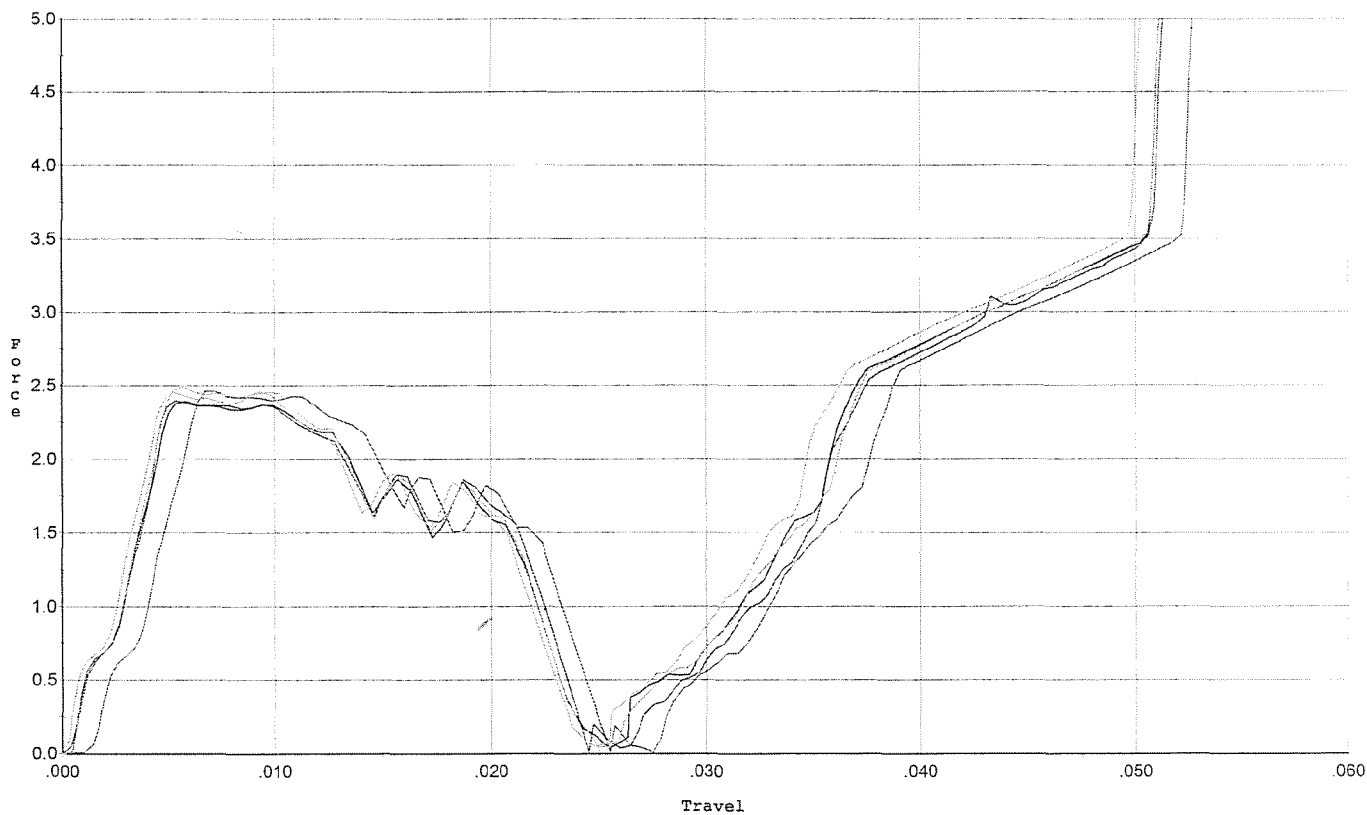
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>4</u> <u>5.5</u>	4-17-09	WW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	4-17-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-17-09	WW
	J) ASSEMBLE STOCK		4-9-09	LJS
	K) ASSEMBLE SWIVEL STUDS		4-17-09	WW
	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	4-14-09	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-14-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-17-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>251</u> <u>234</u> <u>233</u> <u>235</u> <u>232</u>	4-16-09	RP
	C) FUNCTION		4-17-09	WW
690	PACK		6/1/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



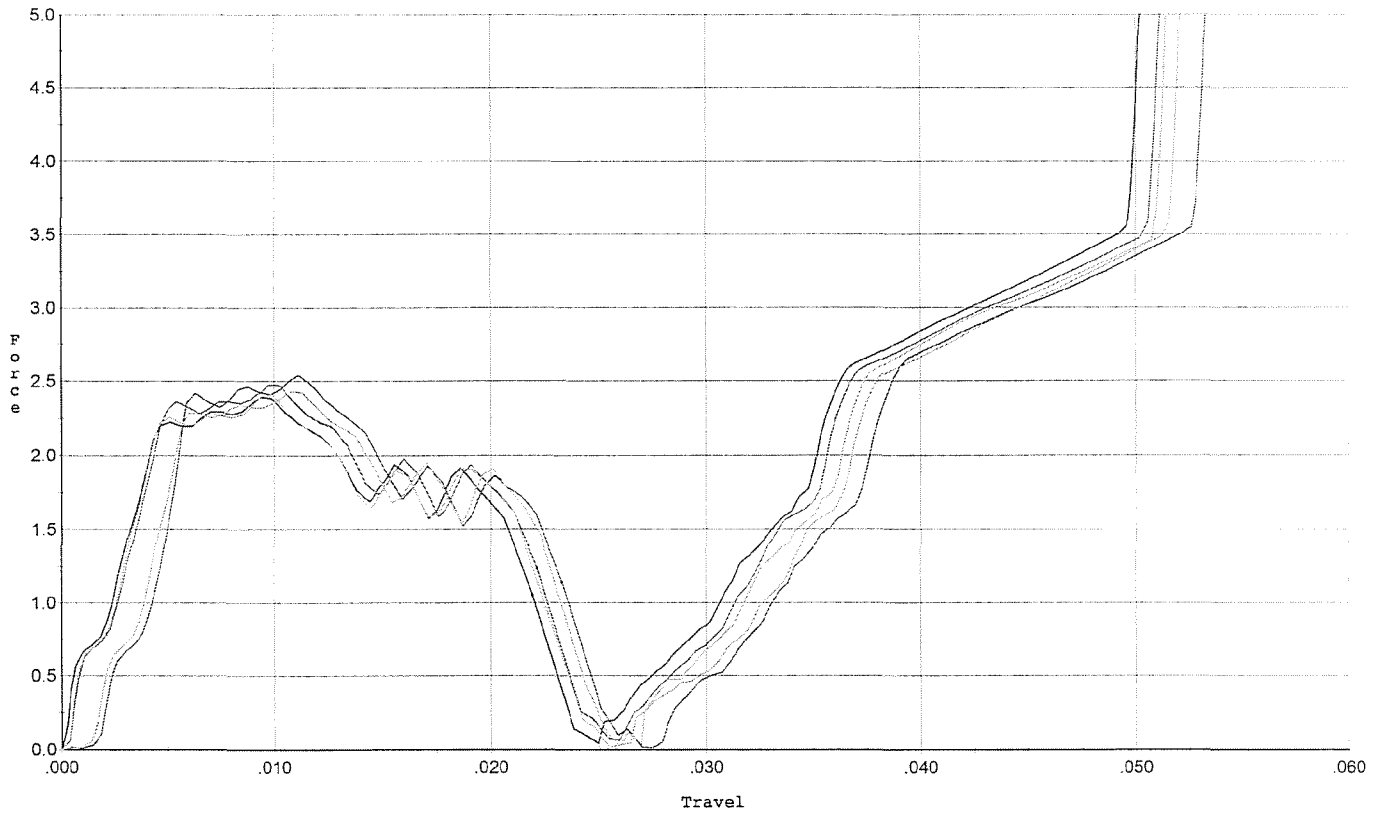
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.401	0.023	0.00	0.035	0.038		Set Trigger
2	2.396	0.022	0.00	0.035	0.036		Set Trigger
3	2.461	0.022	0.00	0.036	0.036		Set Trigger
4	2.460	0.021	0.00	0.034	0.036		Set Trigger
5	2.491	0.021	0.00	0.035	0.037		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



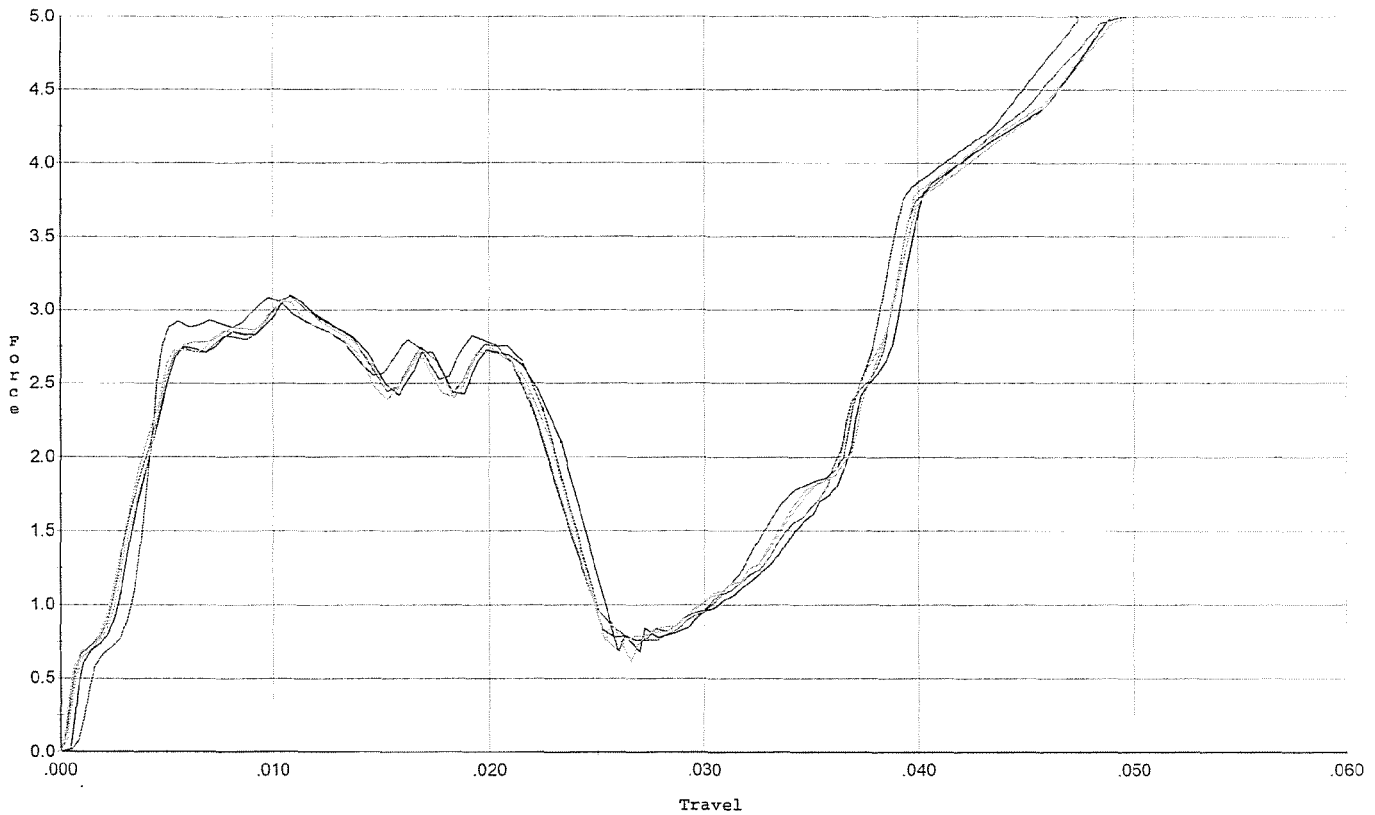
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.539	0.023	0.00	0.036	0.038		Set Trigger
2	2.394	0.022	0.00	0.034	0.038		Set Trigger
3	2.476	0.022	0.00	0.035	0.039		Set Trigger
4	2.415	0.023	0.00	0.035	0.038		Set Trigger
5	2.433	0.022	0.00	0.035	0.037		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



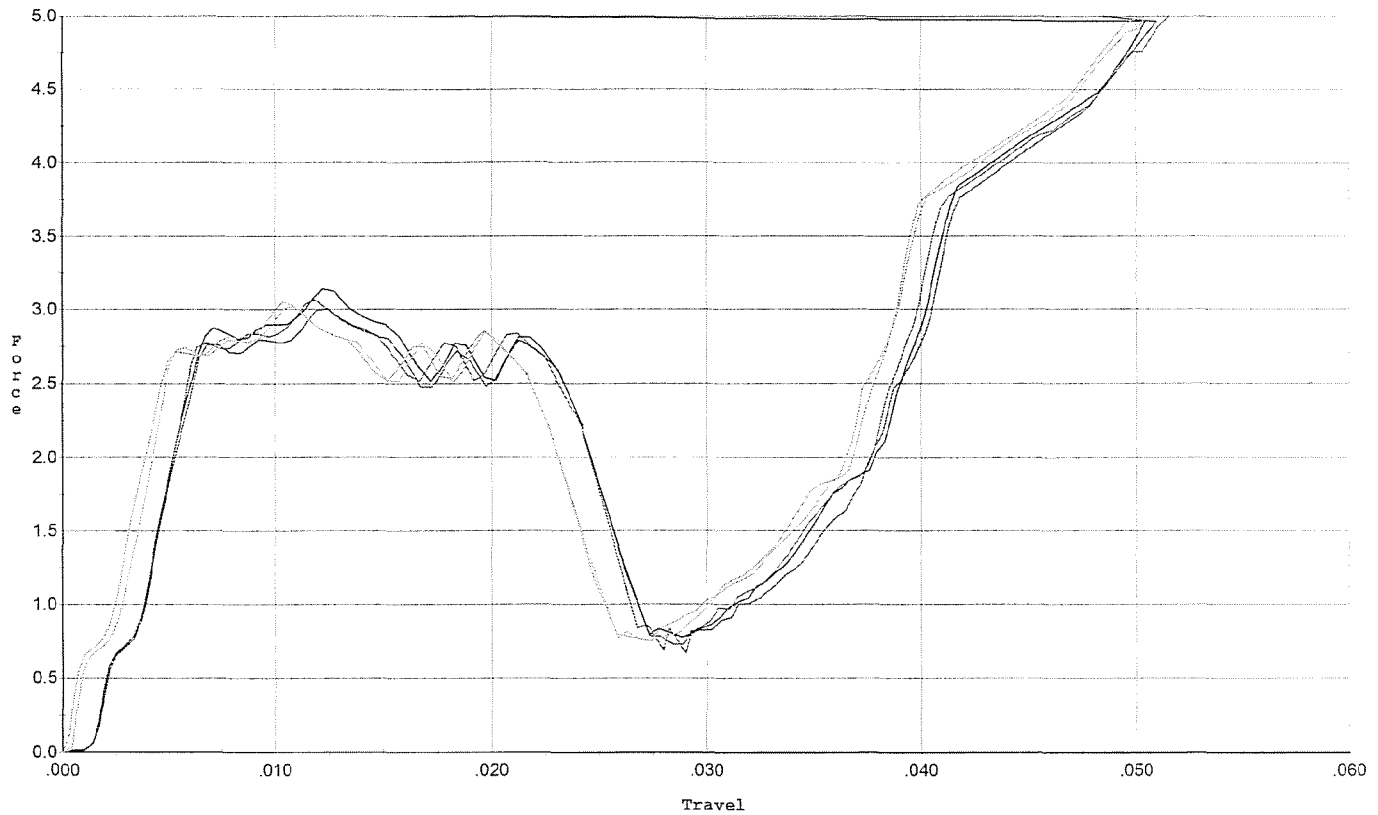
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.083	0.022	0.00	0.033	0.049		Set Trigger
2	3.101	0.023	0.00	0.034	0.052		Set Trigger
3	3.091	0.022	0.00	0.034	0.051		Set Trigger
4	3.059	0.022	0.00	0.034	0.048		Set Trigger
5	3.088	0.023	0.00	0.034	0.051		Set Trigger

A.3.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



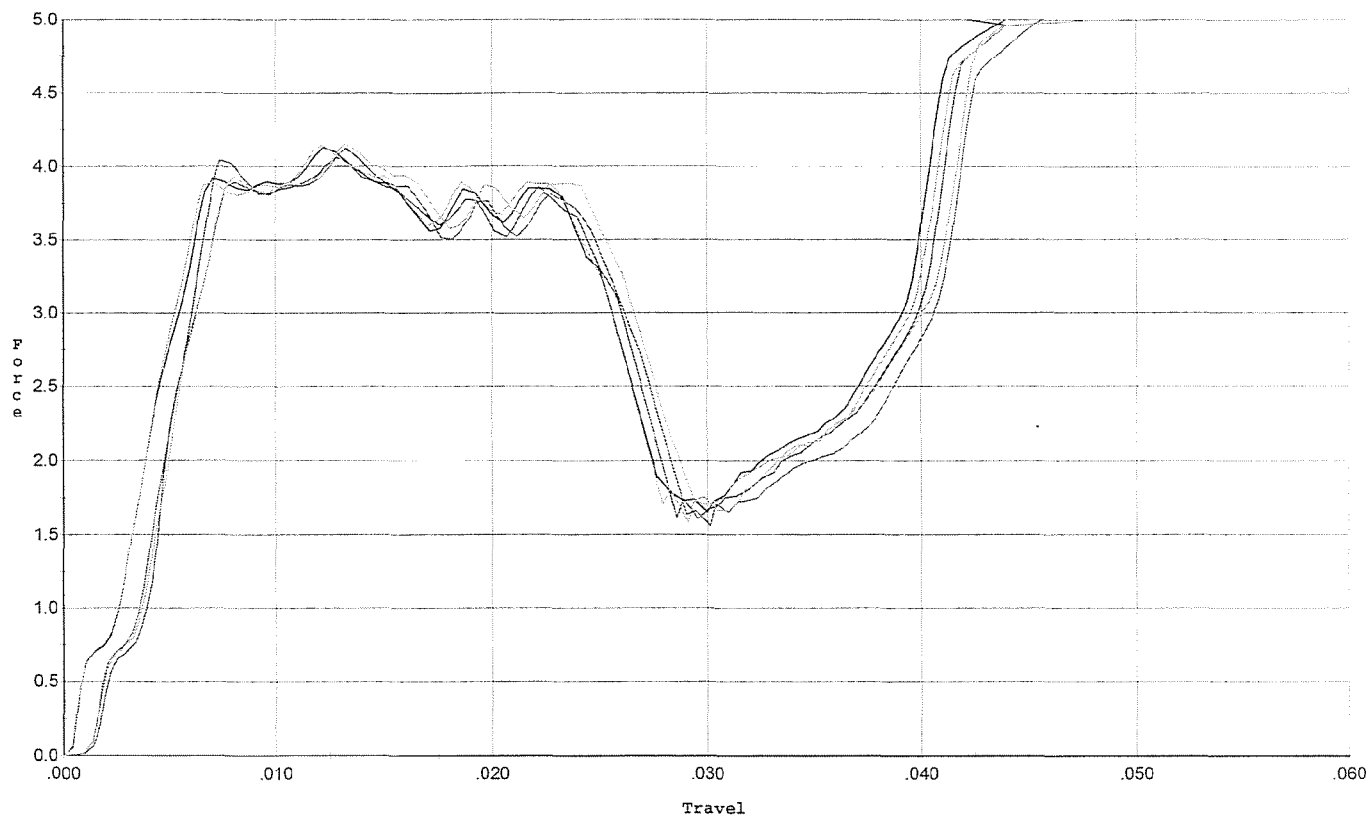
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.003	0.024	0.00	0.034	0.051		Set Trigger
2	3.141	0.024	0.00	0.034	0.053		Set Trigger
3	3.068	0.024	0.00	0.034	0.052		Set Trigger
4	3.019	0.023	0.00	0.034	0.050		Set Trigger
5	3.054	0.023	0.00	0.034	0.051		Set Trigger

A-3.05

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



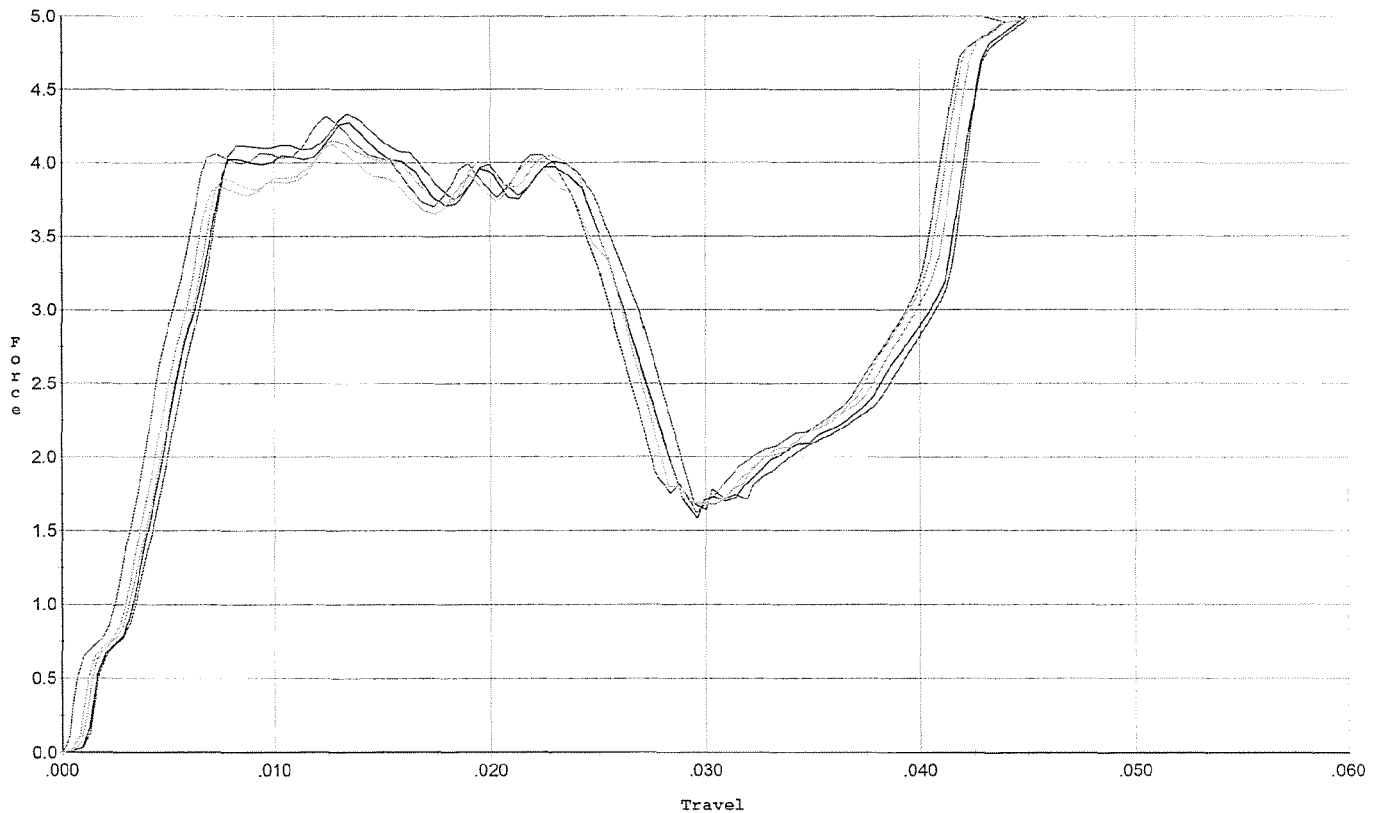
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.063	0.026	0.00	0.030	0.074		Set Trigger
2	4.128	0.025	0.00	0.030	0.075		Set Trigger
3	4.123	0.027	0.00	0.031	0.078		Set Trigger
4	4.155	0.026	0.00	0.030	0.076		Set Trigger
5	4.147	0.025	0.00	0.030	0.076		Set Trigger

A-4.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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



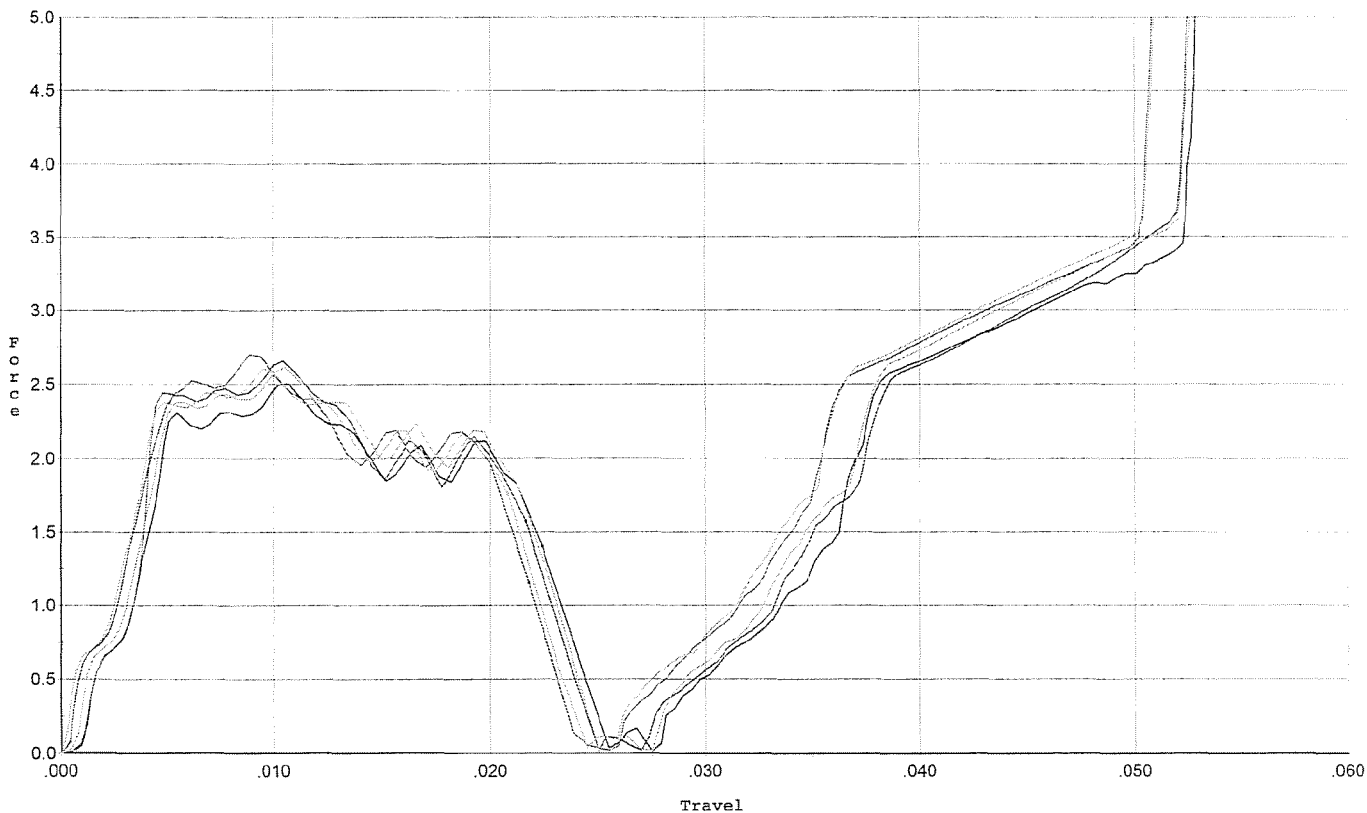
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.338	0.027	0.00	0.030	0.082		Set Trigger
2	4.277	0.025	0.00	0.031	0.076		Set Trigger
3	4.314	0.025	0.00	0.031	0.078		Set Trigger
4	4.128	0.025	0.00	0.030	0.076		Set Trigger
5	4.155	0.025	0.00	0.031	0.076		Set Trigger

A-4.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 4/7/2009

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



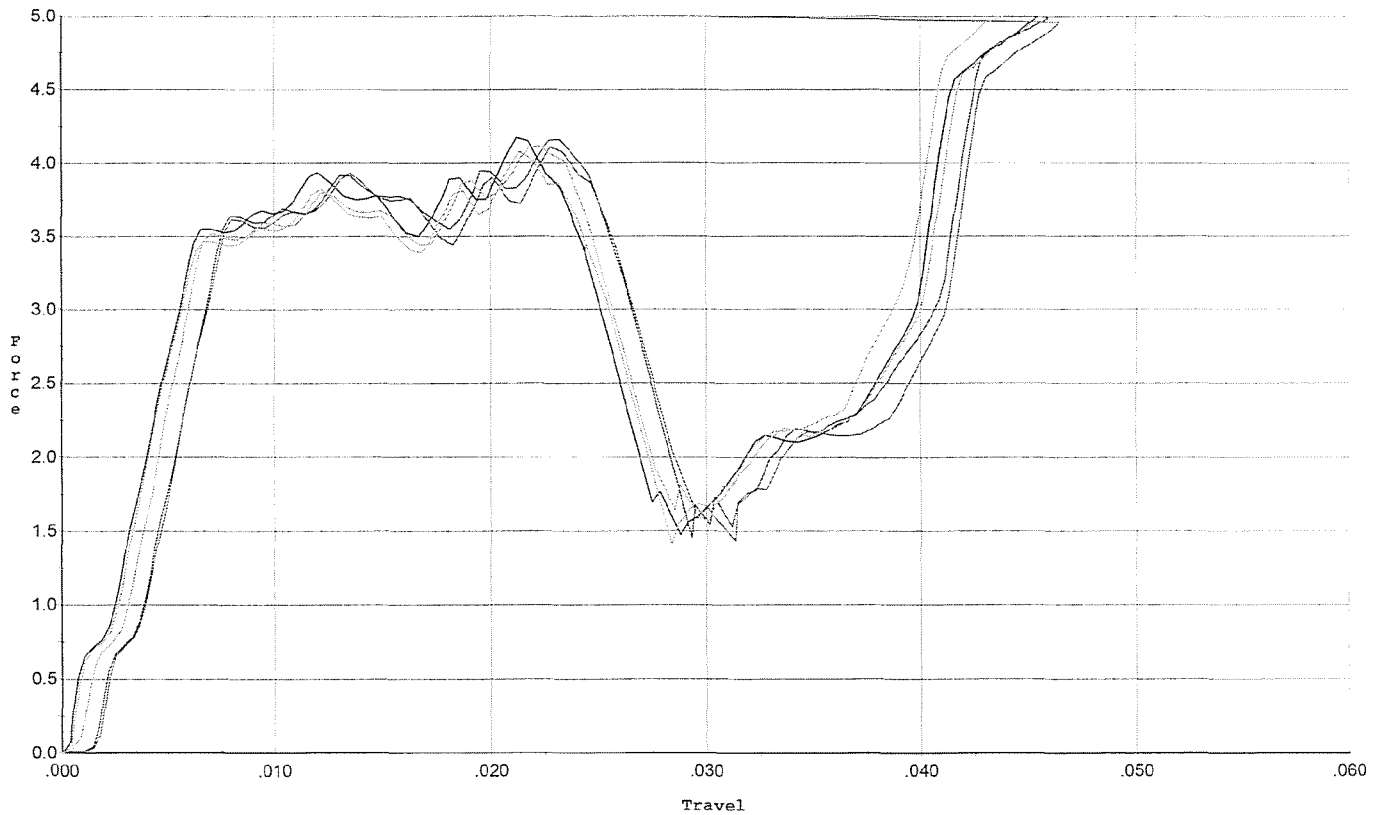
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.660	0.022	0.00	0.036	0.040		Set Trigger
2	2.504	0.022	0.00	0.036	0.039		Set Trigger
3	2.701	0.022	0.00	0.035	0.040		Set Trigger
4	2.607	0.021	0.00	0.034	0.039		Set Trigger
5	2.616	0.023	0.00	0.035	0.042		Set Trigger

A-2-61

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 4/7/2009

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	4.163	0.026	0.00	0.031	0.074		Set Trigger
2	4.174	0.024	0.00	0.031	0.072		Set Trigger
3	4.113	0.026	0.00	0.031	0.073		Set Trigger
4	4.078	0.025	0.00	0.028	0.073		Set Trigger
5	4.114	0.025	0.00	0.031	0.071		Set Trigger

A-4.12