

G6784577

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

- INSTRUCTION BOOK 3518

BM FORM

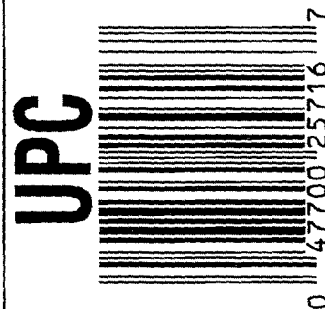


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6784577



GUN SERIAL #

G6784577

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPJ
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPJ
460	CHECK HEADSPACE		9-29-08	SPJ
470	DIS-ASSEMBLE ACTION		9-29-08	SPJ
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	9-29-08	RTE
475	DRILL AND TAP SIGHT HOLES	ULI 02 2008	10/1/08	FR
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	10/2/08	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	Rt
520	GOFF BLAST BBL / REC		10/3/08	DS
542	APPLY COATINGS (BARREL ACTION)		10 8	c
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-3-08	BBN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

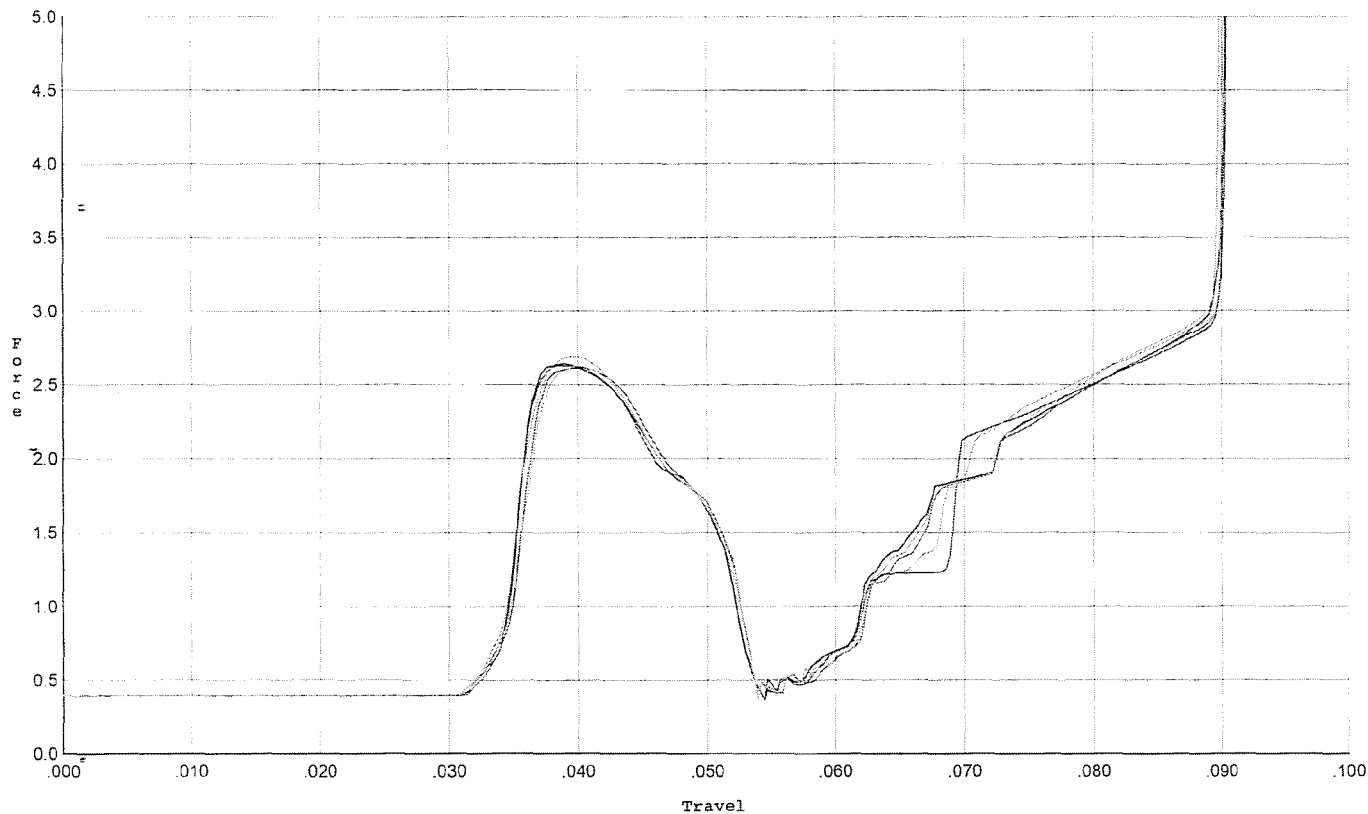
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>49</u> <u>49</u> <u>39</u>	11-6-08	R. QD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-6-08	R. QD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-6-08	R. QD
	J) ASSEMBLE STOCK		10-31-08	PCW
	K) ASSEMBLE SWIVEL STUDS		11-6-08	R. QD
	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	11-3-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-3-08	R. QD
670	FINAL INSPECTION A) HEADSPACE		11-6-08	R. QD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.71</u> <u>2.73</u> <u>2.71</u> <u>2.73</u>	11-5-08	FM
	C) FUNCTION		11-6-08	R. QD
690	PACK		11/10/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



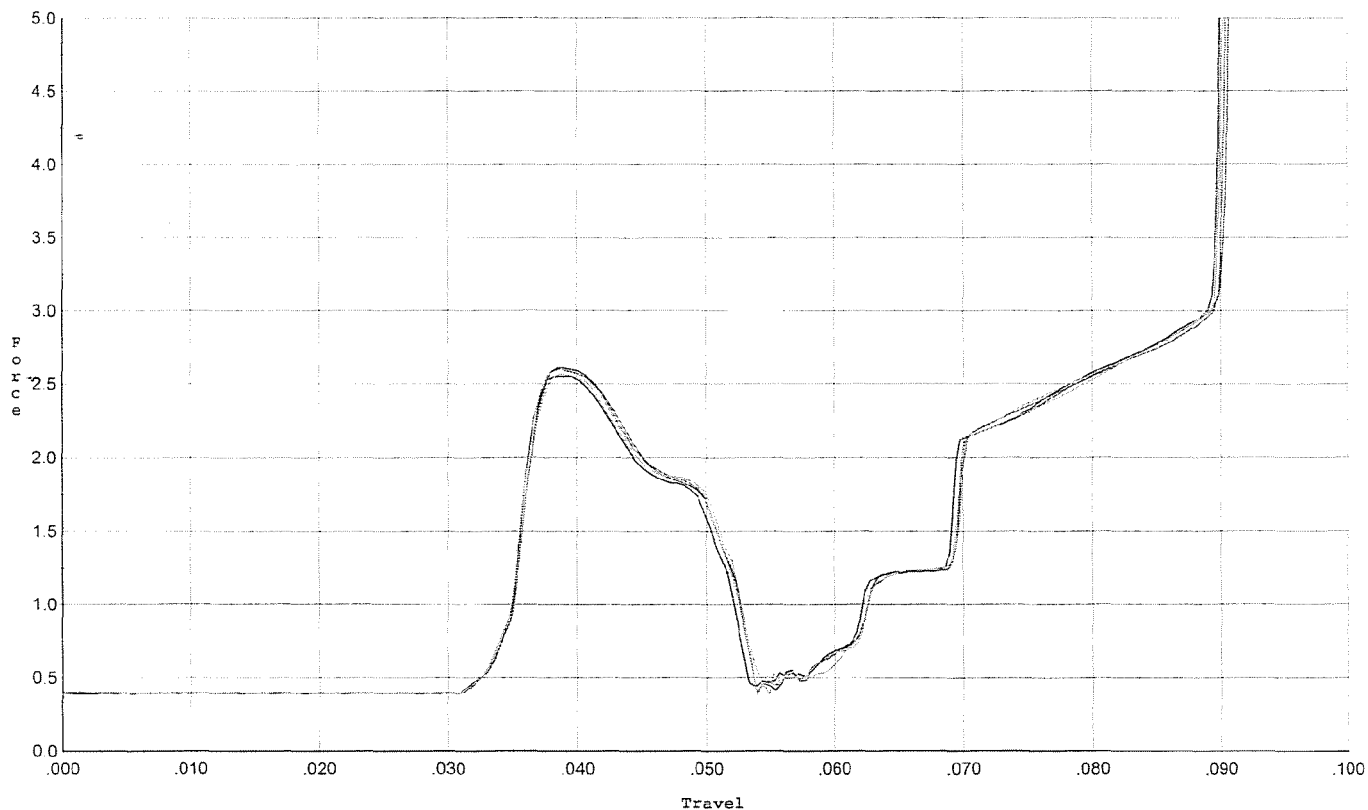
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.629	0.051	0.032	0.043	0.050		Set Trigger
2	2.640	0.051	0.033	0.043	0.050		Set Trigger
3	2.610	0.052	0.034	0.042	0.051		Set Trigger
4	2.624	0.052	0.033	0.042	0.051		Set Trigger
5	2.691	0.052	0.033	0.042	0.052		Set Trigger

Aug 2.63

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



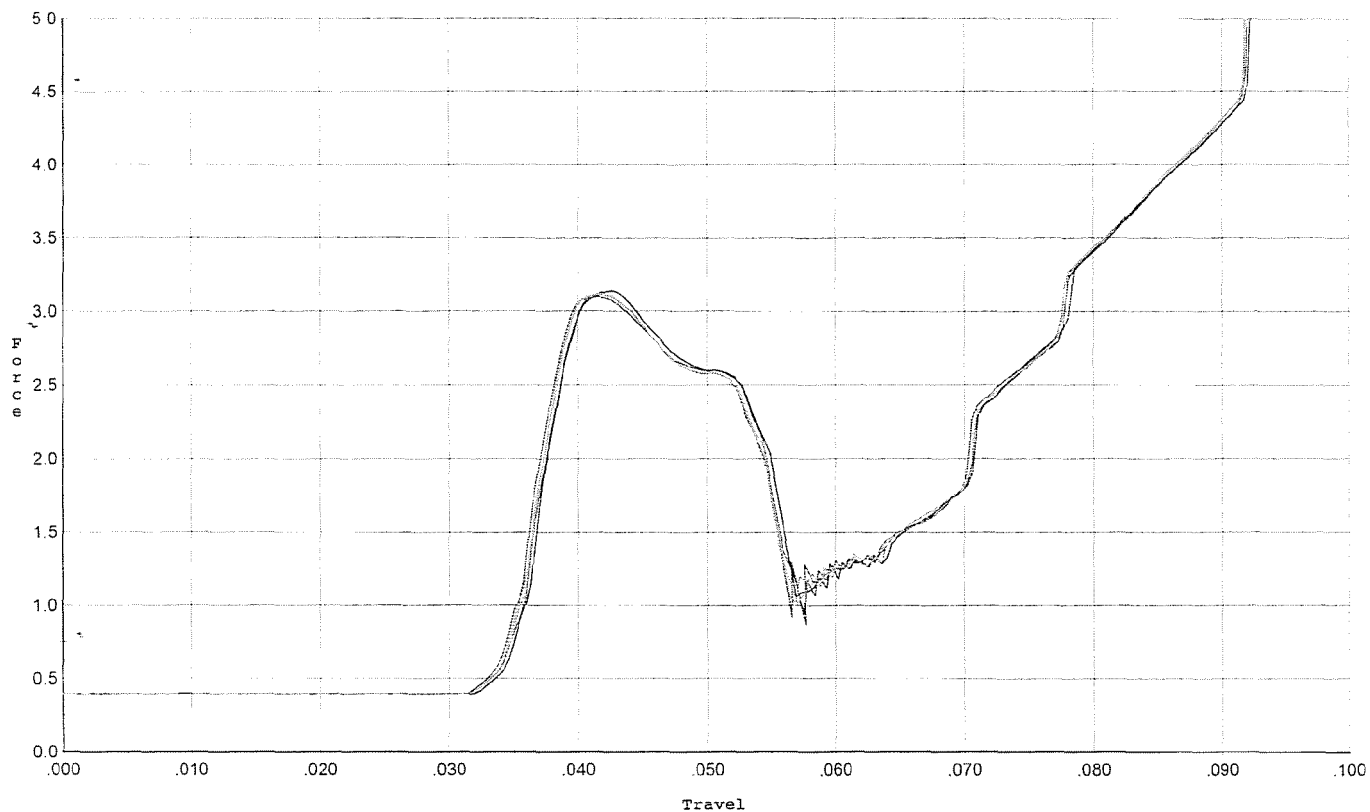
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.609	0.052	0.034	0.042	0.049		Set Trigger
2	2.551	0.052	0.034	0.043	0.048		Set Trigger
3	2.600	0.052	0.034	0.042	0.049		Set Trigger
4	2.599	0.052	0.034	0.042	0.050		Set Trigger
5	2.566	0.052	0.034	0.042	0.049		Set Trigger

Aug 2.58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



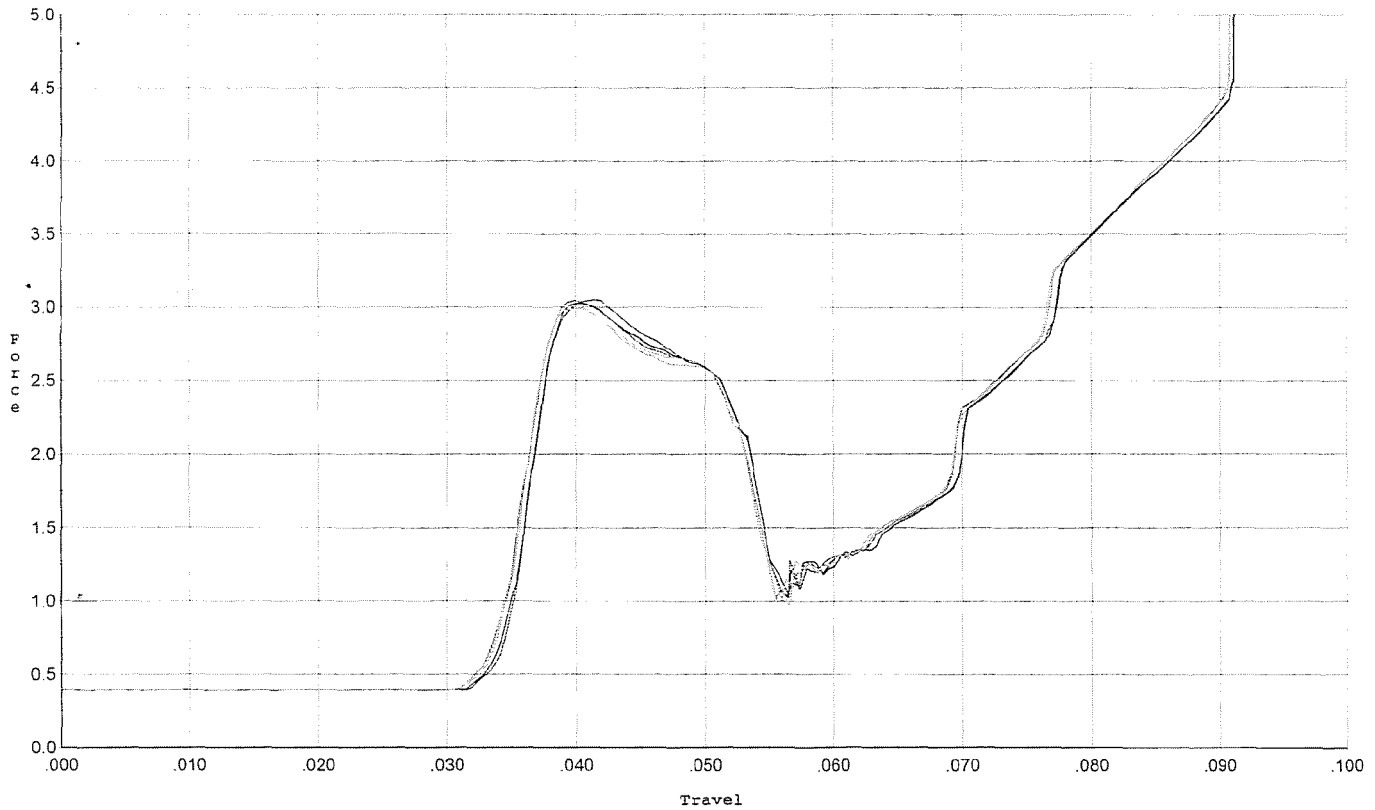
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.109	0.054	0.034	0.040	0.063		Set Trigger
2	3.139	0.055	0.035	0.040	0.065		Set Trigger
3	3.095	0.055	0.034	0.039	0.064		Set Trigger
4	3.114	0.054	0.034	0.040	0.064		Set Trigger
5	3.120	0.054	0.034	0.040	0.064		Set Trigger

Aug 3.11

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



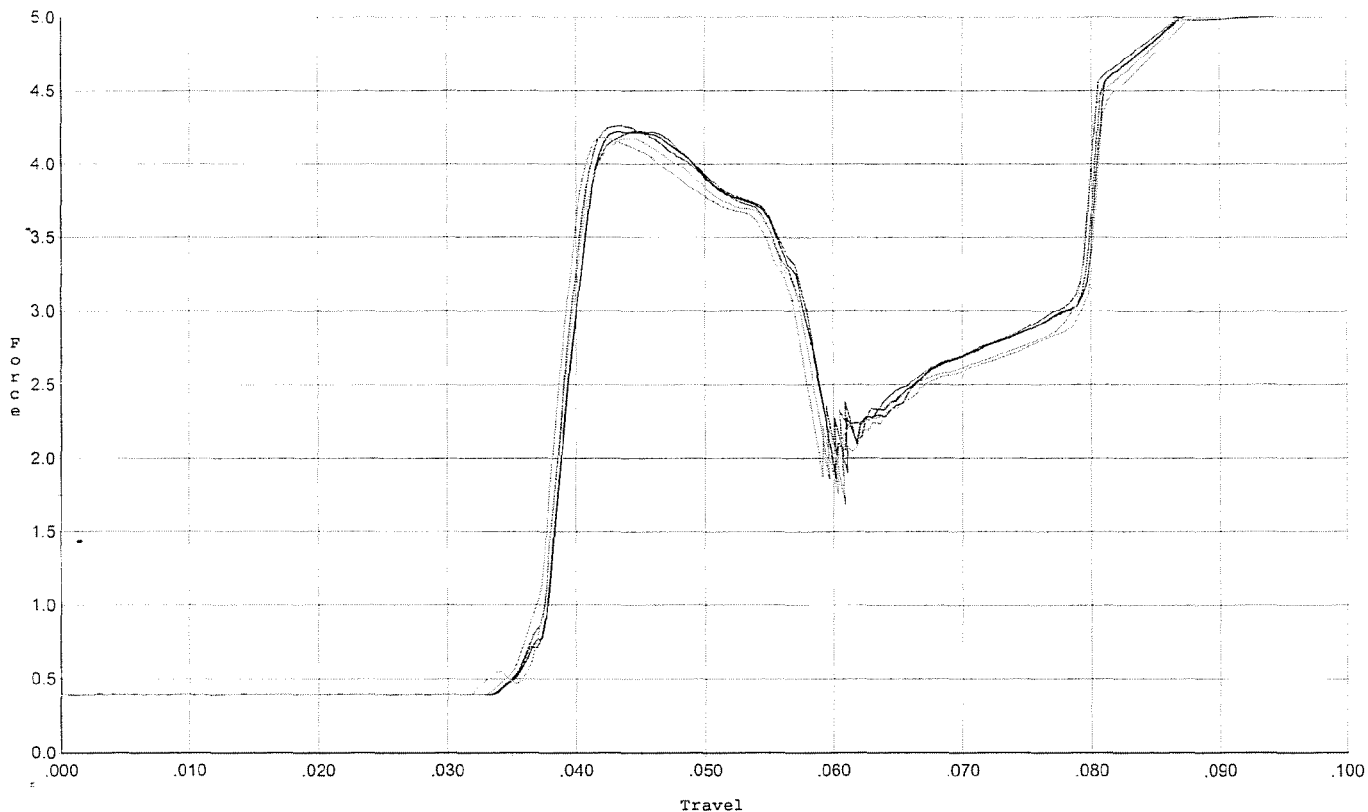
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.047	0.053	0.034	0.039	0.062		Set Trigger
2	3.024	0.053	0.034	0.040	0.062		Set Trigger
3	3.043	0.054	0.033	0.039	0.064		Set Trigger
4	2.991	0.054	0.033	0.039	0.063		Set Trigger
5	3.006	0.053	0.033	0.040	0.061		Set Trigger

Aug 3.02

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



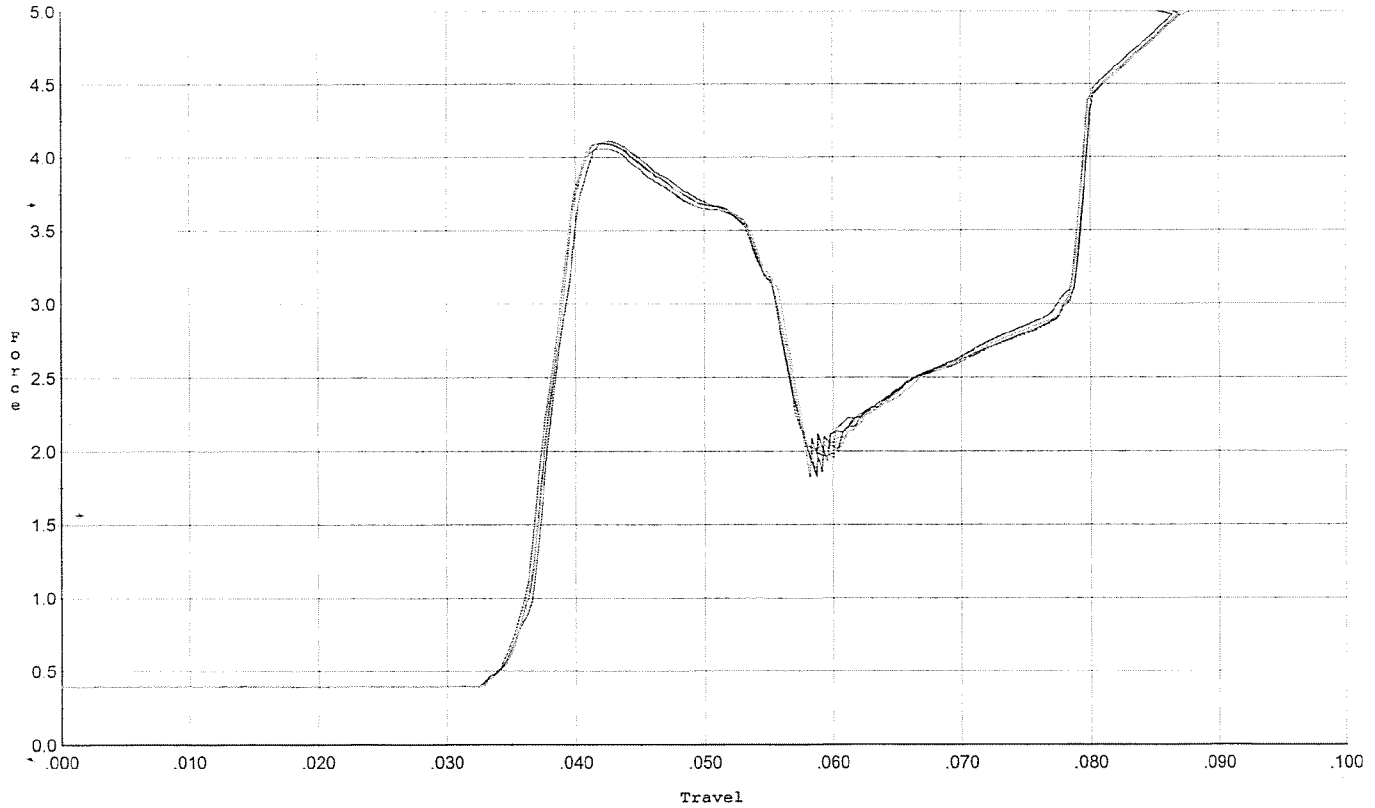
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.225	0.058	0.036	0.038	0.090		Set Trigger
2	4.217	0.058	0.036	0.038	0.090		Set Trigger
3	4.258	0.057	0.036	0.039	0.089		Set Trigger
4	4.175	0.057	0.036	0.039	0.088		Set Trigger
5	4.179	0.057	0.036	0.038	0.088		Set Trigger

Avg 4.21

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



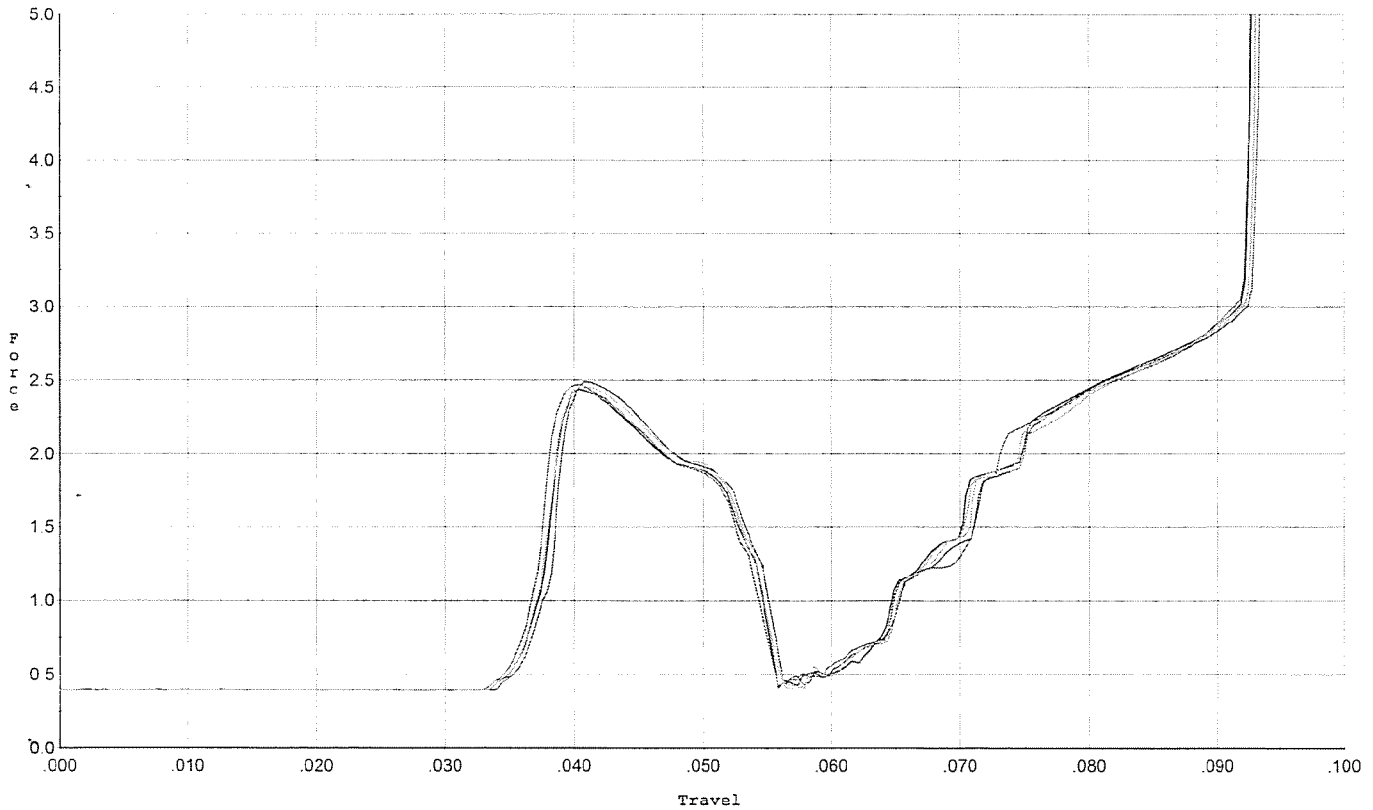
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.111	0.056	0.035	0.038	0.084		Set Trigger
2	4.095	0.055	0.035	0.038	0.082		Set Trigger
3	4.059	0.055	0.035	0.038	0.083		Set Trigger
4	4.106	0.056	0.035	0.038	0.084		Set Trigger
5	4.105	0.056	0.035	0.038	0.085		Set Trigger

Avg 4.09

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



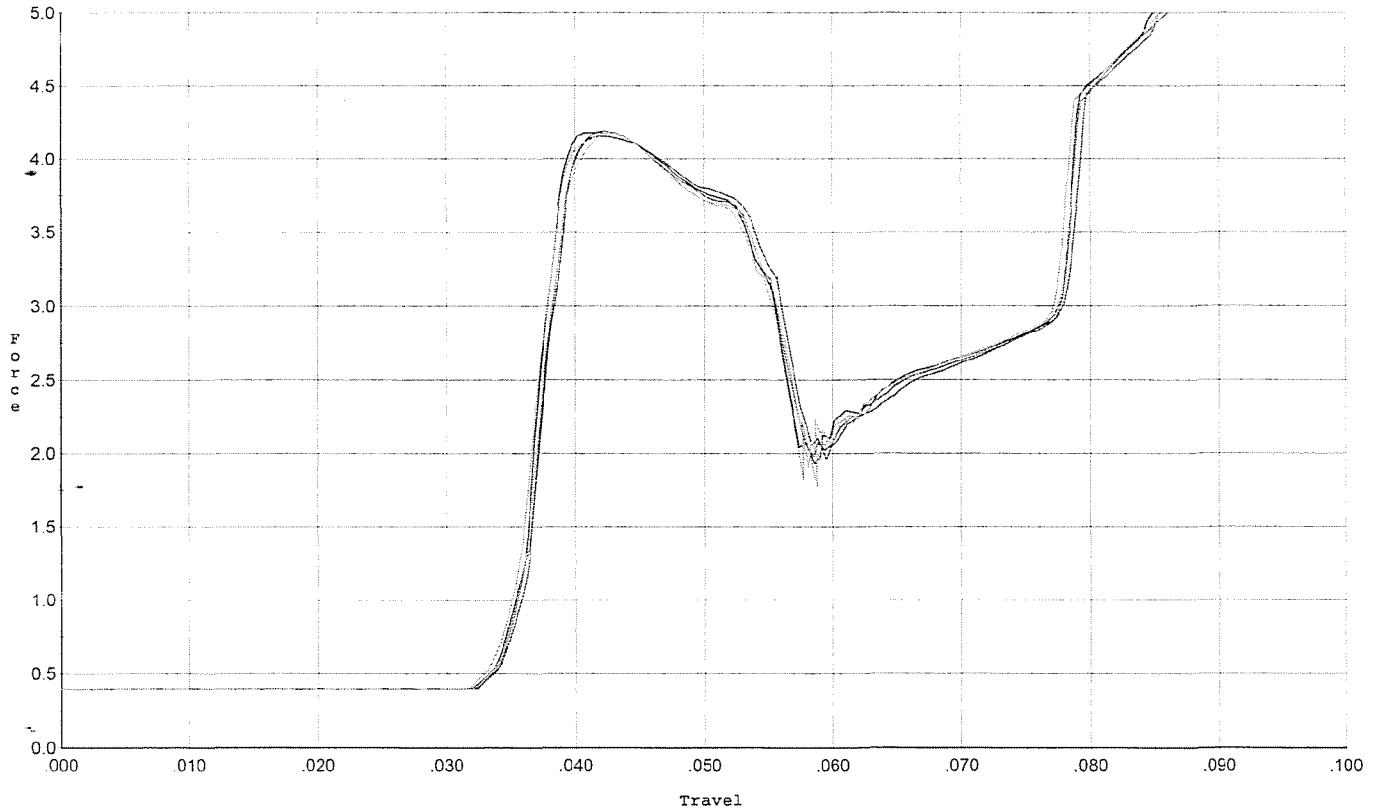
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.488	0.055	0.036	0.043	0.050		Set Trigger
2	2.440	0.054	0.036	0.043	0.049		Set Trigger
3	2.470	0.055	0.035	0.043	0.050		Set Trigger
4	2.464	0.054	0.036	0.043	0.049		Set Trigger
5	2.431	0.054	0.036	0.043	0.049		Set Trigger

Aug 2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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	4.154	0.056	0.035	0.038	0.087		Set Trigger
2	4.180	0.055	0.034	0.037	0.087		Set Trigger
3	4.191	0.055	0.034	0.038	0.086		Set Trigger
4	4.179	0.056	0.034	0.038	0.088		Set Trigger
5	4.186	0.056	0.034	0.037	0.087		Set Trigger

Aug 4.17