

G6785024

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

- INSTRUCTION BOOK 3518

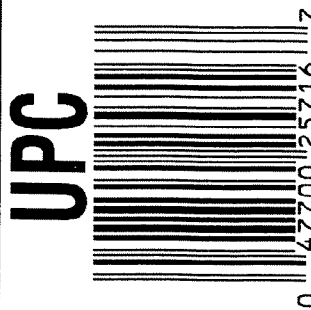


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785024



BM FORM

GUN SERIAL # G 678 5024

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES	2000	9-30-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (K)	10/2/08	(K)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/03/08	DG
542	APPLY COATINGS (BARREL ACTION)		10 9	
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		11-3-08	RBW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

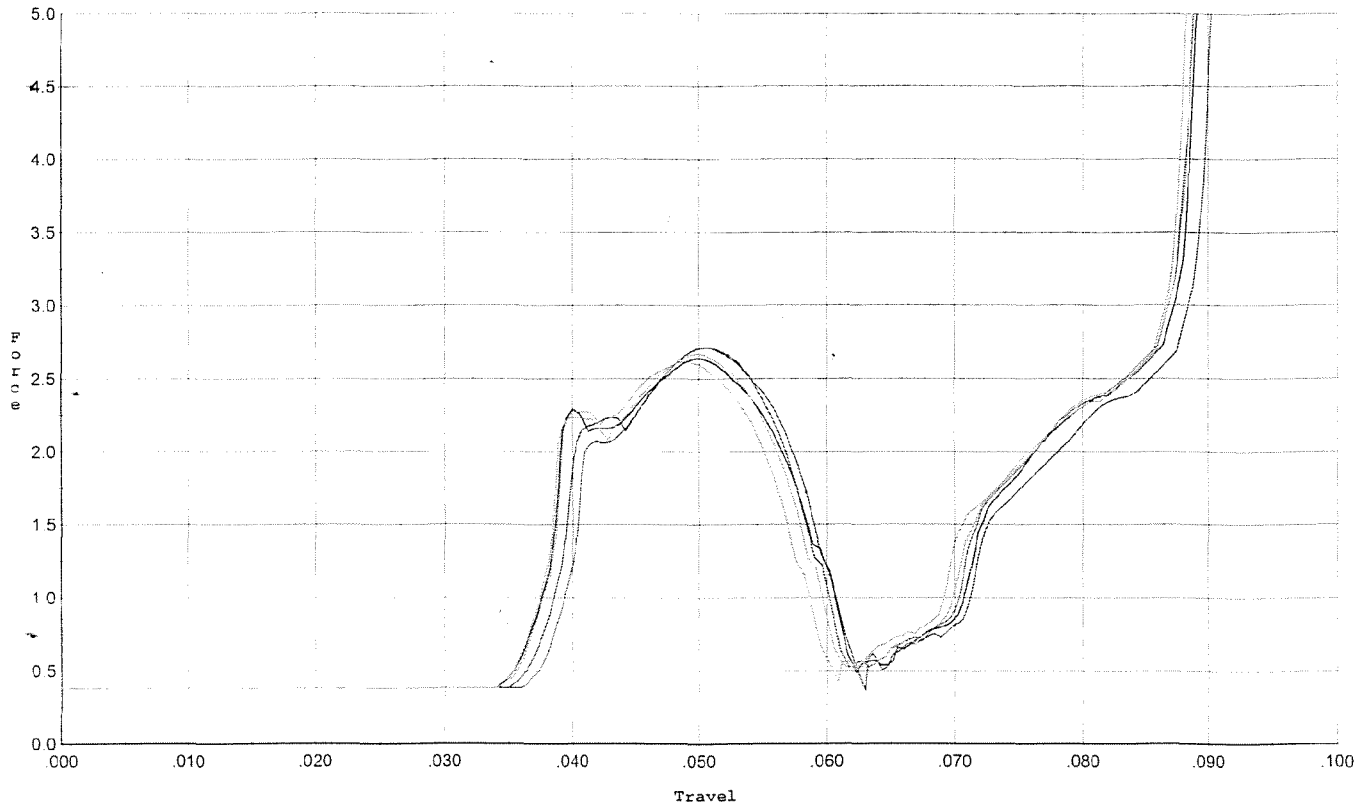
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.9</u> <u>4.0</u> <u>5.0</u>	11-12-08	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>5.0</u> <u>5.0</u>	11-12-08	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>-.023</u> <u>-.023</u> <u>-.023</u>	11-12-08	RP
	J) ASSEMBLE STOCK		11-3-08	RSW
	K) ASSEMBLE SWIVEL STUDS		11-12-08	RP
	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	11-5-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	RP
670	FINAL INSPECTION A) HEADSPACE		11-12-08	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u> <u>2.40</u> <u>2.39</u> <u>2.31</u> <u>2.34</u>	11-5-08	TC
	C) FUNCTION		11-12-08	RP
690	PACK		11/12/08	Fog

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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



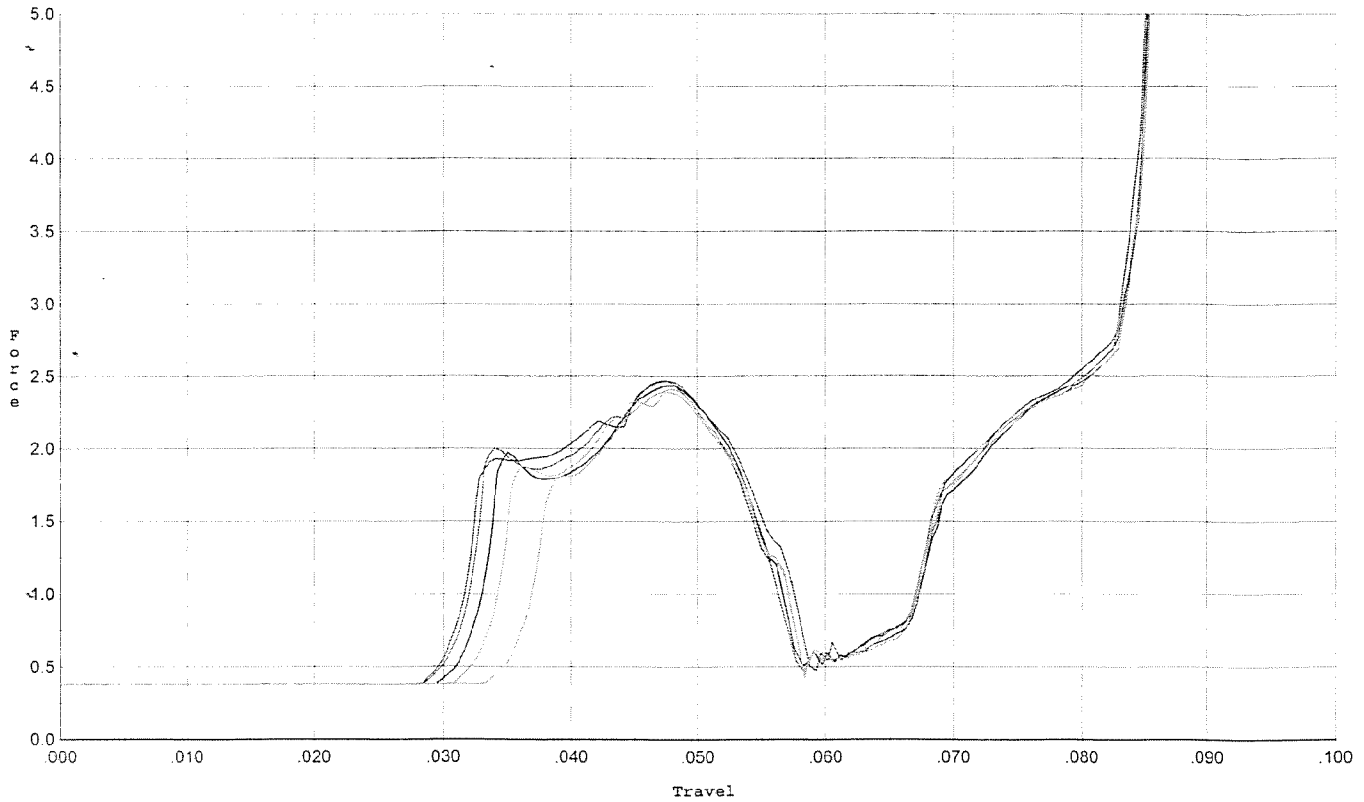
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.713	0.058	0.037	0.038	0.061		Set Trigger
2	2.638	0.060	0.036	0.036	0.064		Set Trigger
3	2.711	0.060	0.038	0.036	0.060		Set Trigger
4	2.672	0.059	0.036	0.036	0.063		Set Trigger
5	2.615	0.058	0.036	0.037	0.060		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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



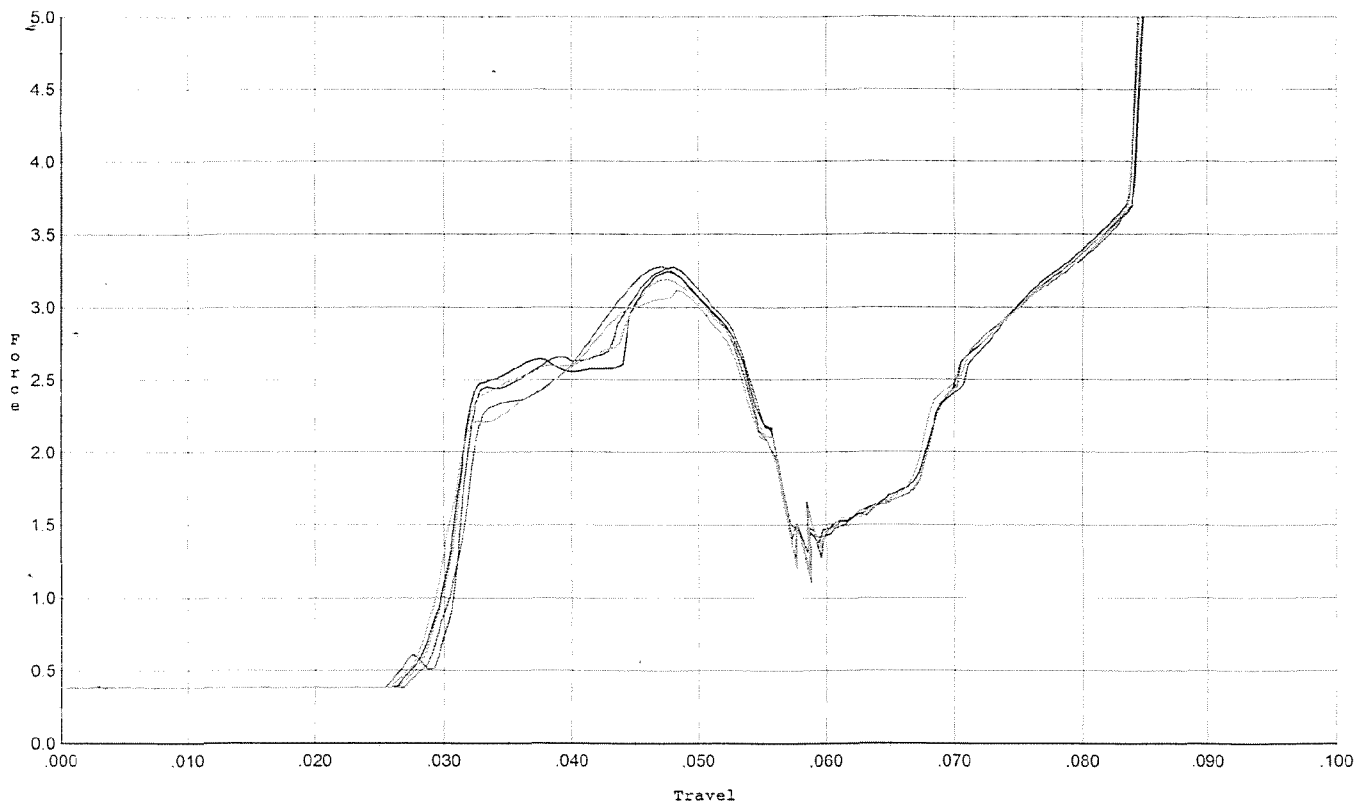
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.466	0.057	0.030	0.033	0.064		Set Trigger
2	2.435	0.056	0.031	0.034	0.059		Set Trigger
3	2.469	0.056	0.030	0.034	0.060		Set Trigger
4	2.412	0.057	0.033	0.035	0.057		Set Trigger
5	2.393	0.057	0.036	0.036	0.053		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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



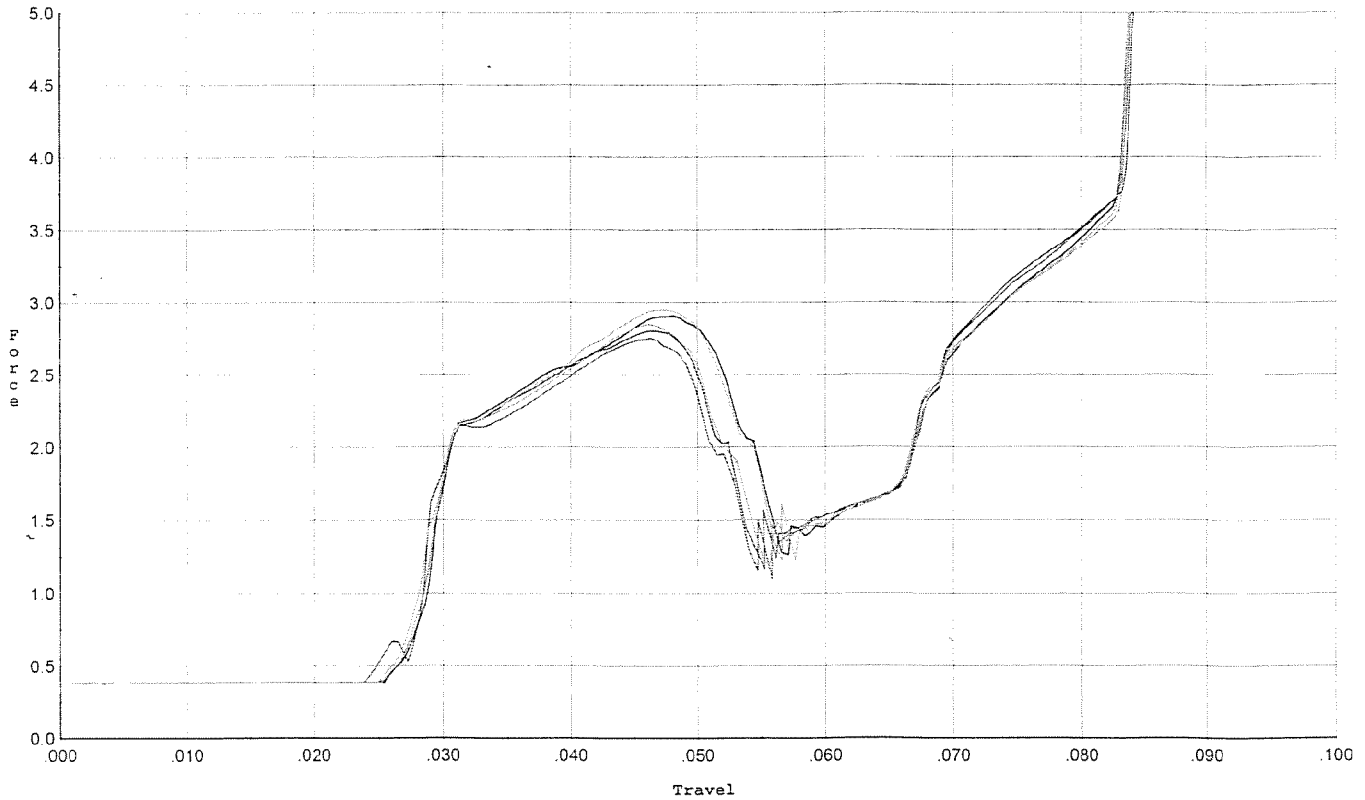
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.275	0.056	0.027	0.032	0.080		Set Trigger
2	3.248	0.056	0.027	0.032	0.080		Set Trigger
3	3.279	0.056	0.029	0.032	0.079		Set Trigger
4	3.192	0.056	0.029	0.032	0.079		Set Trigger
5	3.115	0.056	0.028	0.032	0.079		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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



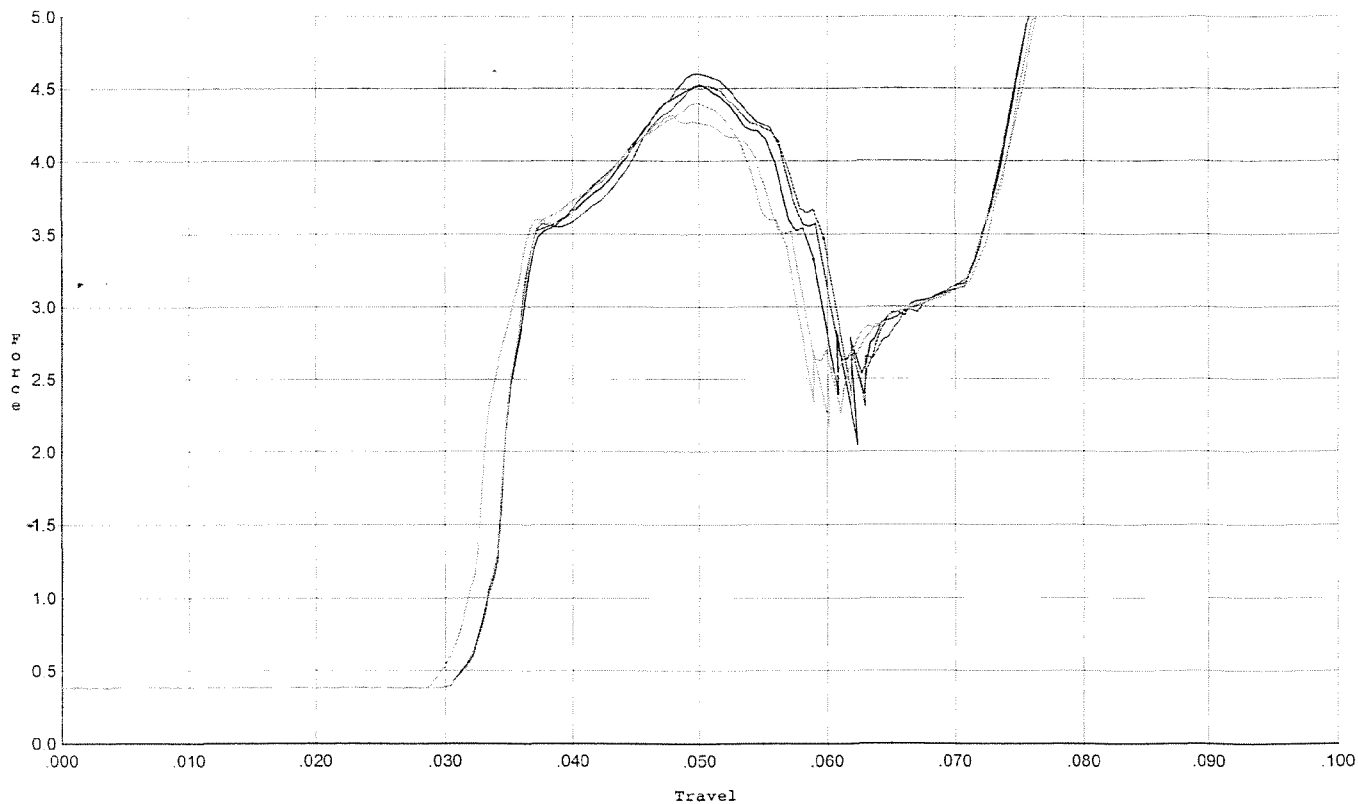
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.804	0.052	0.025	0.035	0.069		Set Trigger
2	2.909	0.054	0.026	0.033	0.075		Set Trigger
3	2.752	0.053	0.027	0.035	0.068		Set Trigger
4	2.949	0.054	0.027	0.033	0.076		Set Trigger
5	2.847	0.053	0.026	0.035	0.070		Set Trigger

A-285

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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



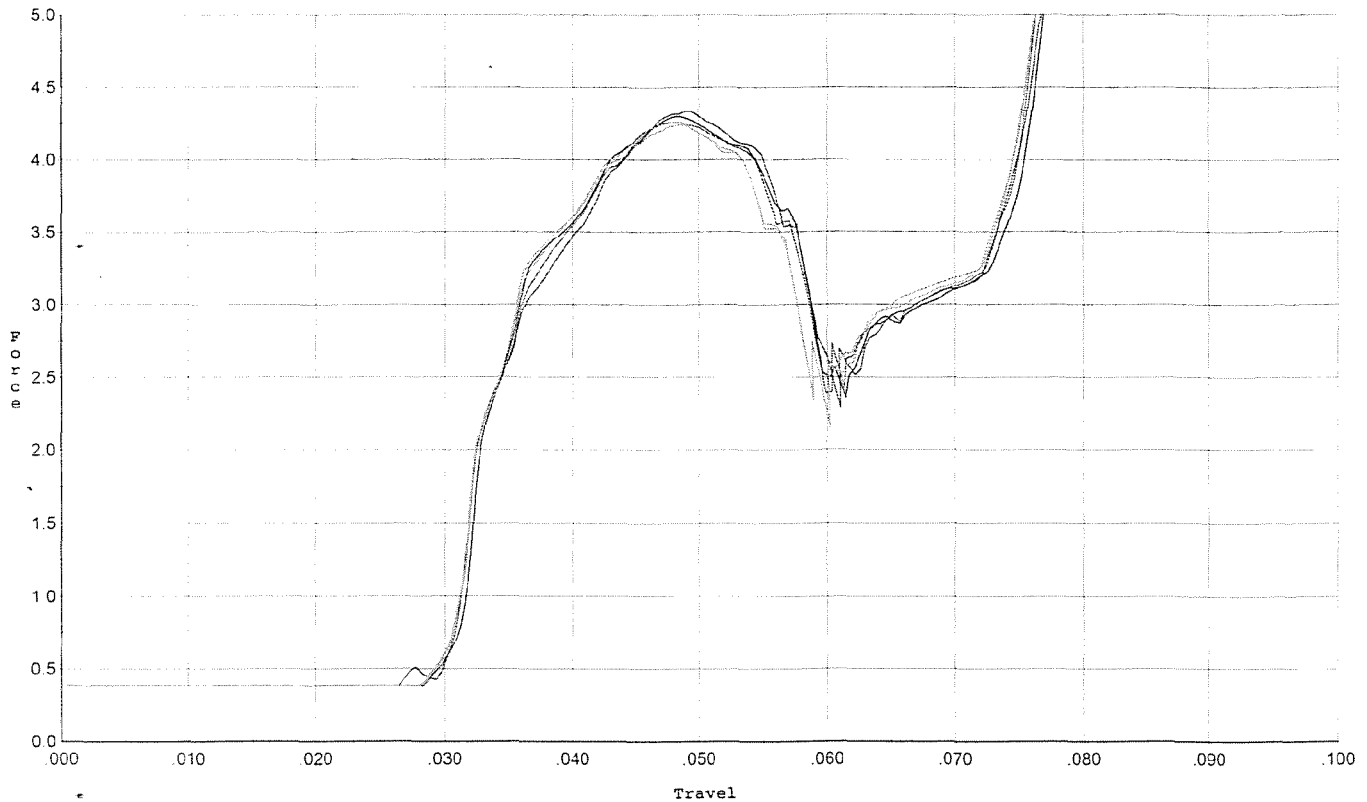
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.602	0.059	0.031	0.021	0.113		Set Trigger
2	4.526	0.059	0.032	0.022	0.110		Set Trigger
3	4.517	0.060	0.032	0.021	0.113		Set Trigger
4	4.400	0.057	0.032	0.024	0.101		Set Trigger
5	4.317	0.057	0.029	0.024	0.107		Set Trigger

A-24-47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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



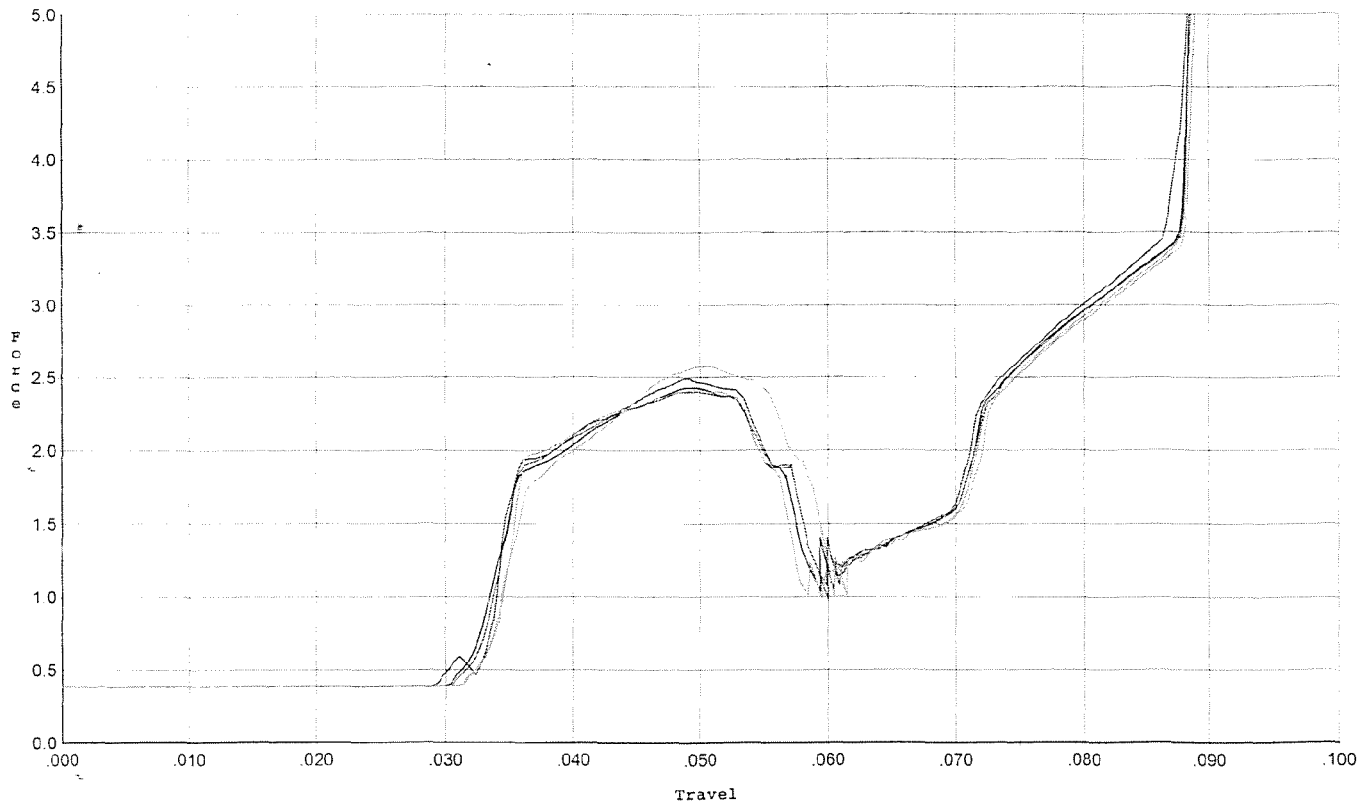
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.332	0.058	0.030	0.023	0.107		Set Trigger
2	4.301	0.058	0.030	0.024	0.107		Set Trigger
3	4.257	0.058	0.029	0.023	0.108		Set Trigger
4	4.258	0.057	0.030	0.024	0.104		Set Trigger
5	4.242	0.057	0.030	0.024	0.104		Set Trigger

A-4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C. Schults 10/28/2008

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

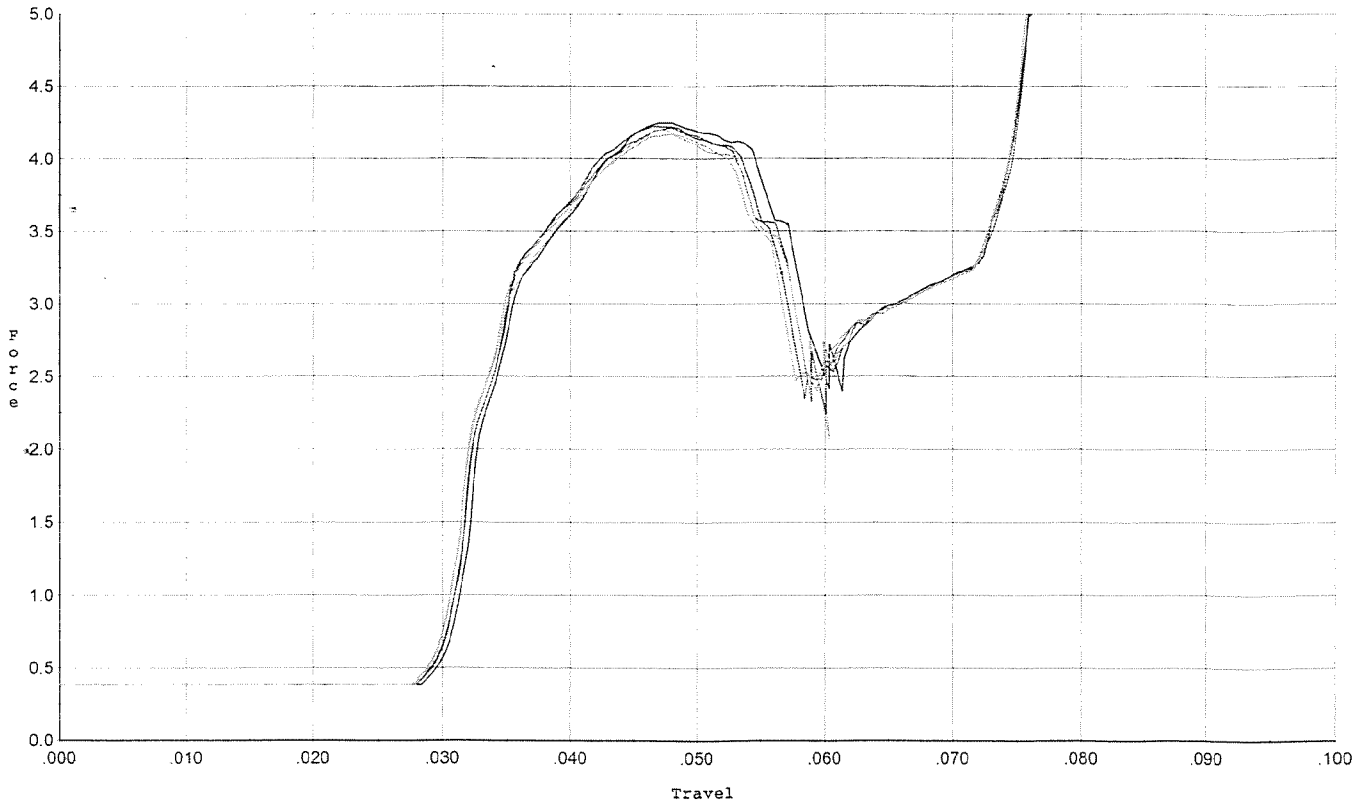


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.057	0.033	0.035	0.064		Set Trigger
2	2.427	0.057	0.031	0.036	0.062		Set Trigger
3	2.401	0.057	0.033	0.036	0.063		Set Trigger
4	2.577	0.059	0.033	0.035	0.067		Set Trigger
5	2.415	0.056	0.032	0.037	0.061		Set Trigger

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C. Schults 10/28/2008

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	4.222	0.057	0.030	0.024	0.106		Set Trigger
2	4.248	0.057	0.030	0.023	0.106		Set Trigger
3	4.212	0.057	0.030	0.024	0.104		Set Trigger
4	4.169	0.056	0.030	0.025	0.102		Set Trigger
5	4.199	0.057	0.029	0.024	0.105		Set Trigger

A-4-21