

667945 12

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

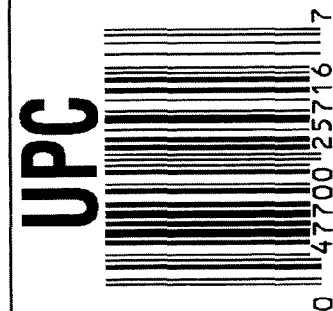
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6794512



GUN SERIAL #

G 6794512

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX 10/28/08	10-28-08	RSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/29/08	RS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-30	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-6-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

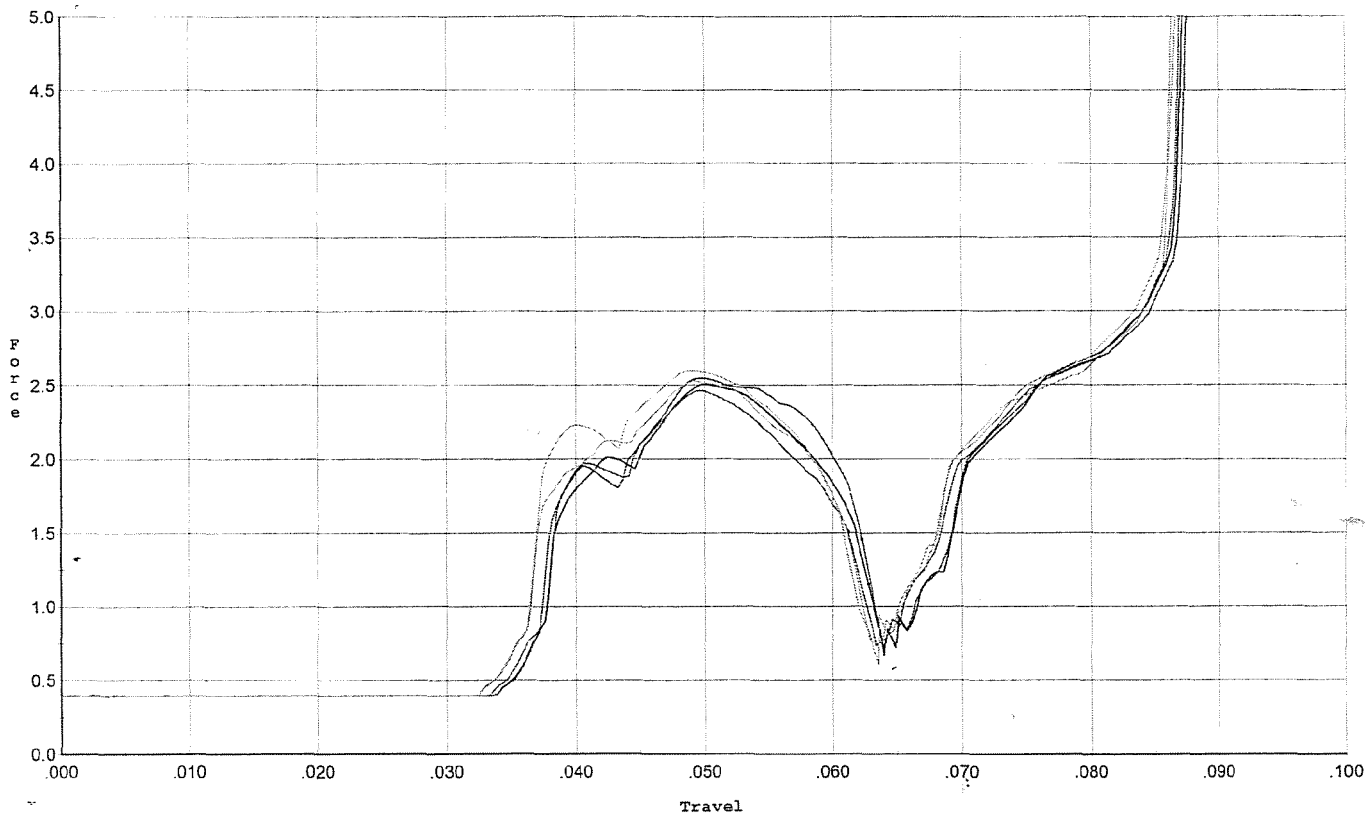
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>39</u> <u>39</u> <u>39</u>	11-10-08	L. J.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-10-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-10-08	L. J.
	J) ASSEMBLE STOCK		11-6-08	RSW
	K) ASSEMBLE SWIVEL STUDS		11-10-08	L. J.
	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	11-7-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-7-08	L. J.
670	FINAL INSPECTION A) HEADSPACE		11-10-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.71</u> <u>2.69</u> <u>2.65</u> <u>2.57</u>	11-7-08	TC
	C) FUNCTION		11-10-08	L. J.
690	PACK		11/11/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



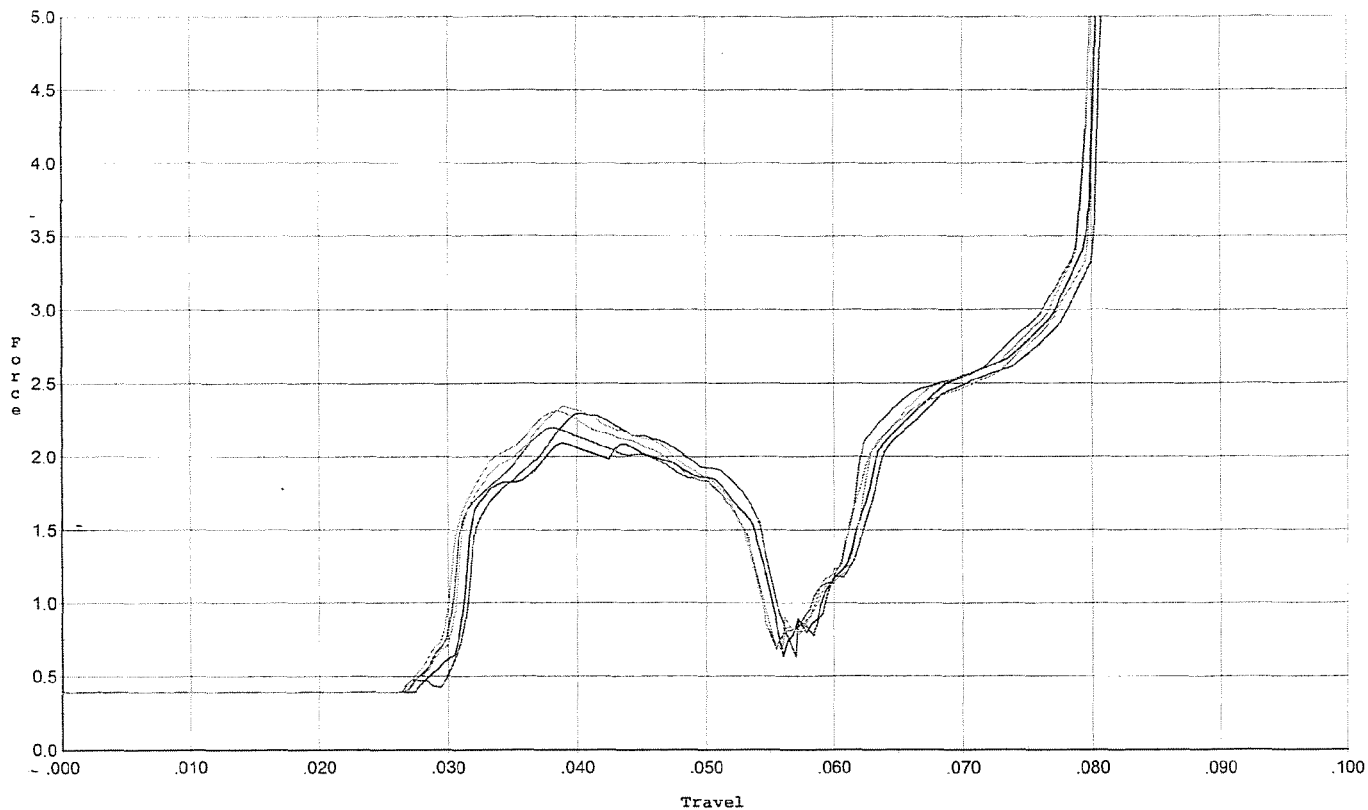
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.547	0.062	0.036	0.032	0.068		Set Trigger
2	2.503	0.063	0.036	0.032	0.067		Set Trigger
3	2.463	0.061	0.035	0.032	0.064		Set Trigger
4	2.593	0.061	0.035	0.033	0.069		Set Trigger
5	2.531	0.061	0.035	0.032	0.068		Set Trigger

A-2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



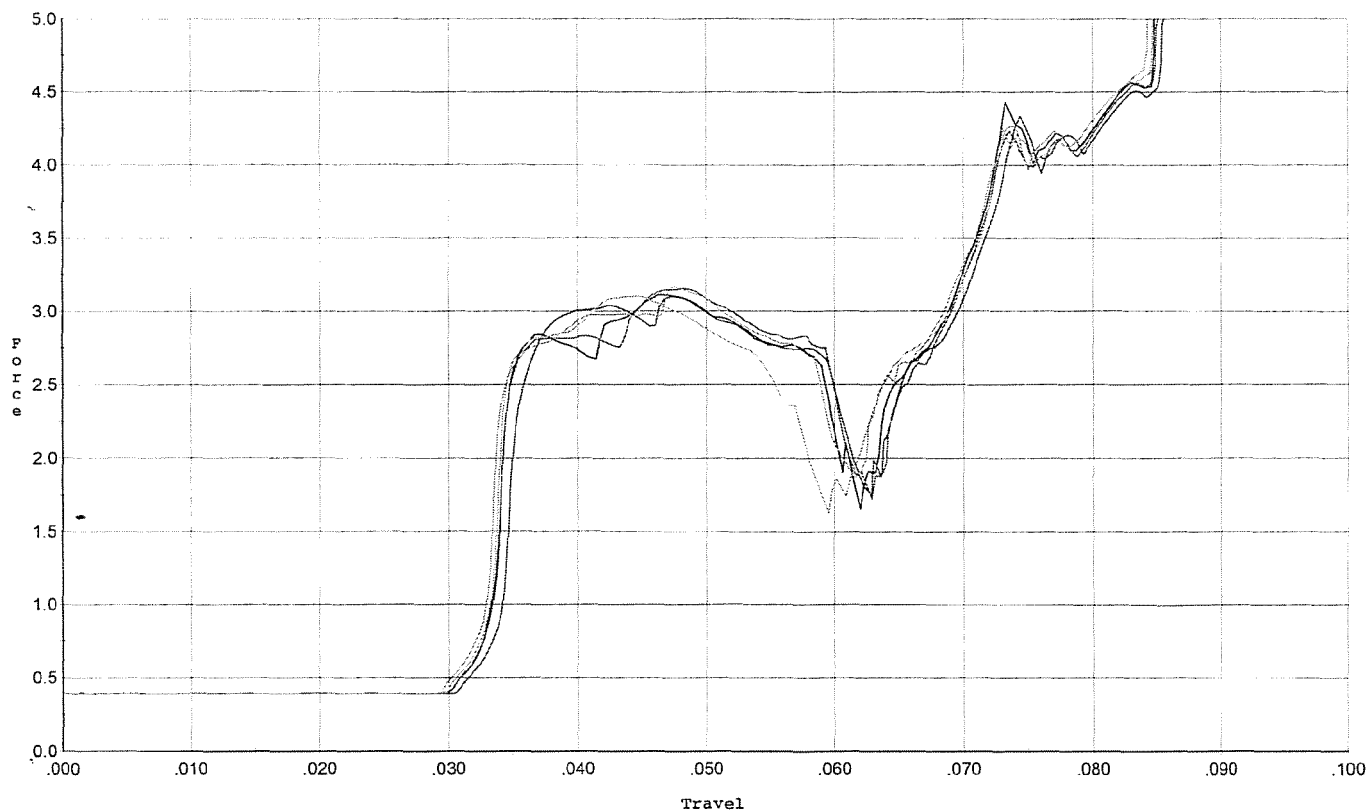
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.297	0.054	0.027	0.032	0.058		Set Trigger
2	2.095	0.055	0.031	0.032	0.056		Set Trigger
3	2.197	0.053	0.027	0.032	0.056		Set Trigger
4	2.343	0.053	0.029	0.032	0.058		Set Trigger
5	2.315	0.053	0.027	0.031	0.058		Set Trigger

A-2-24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



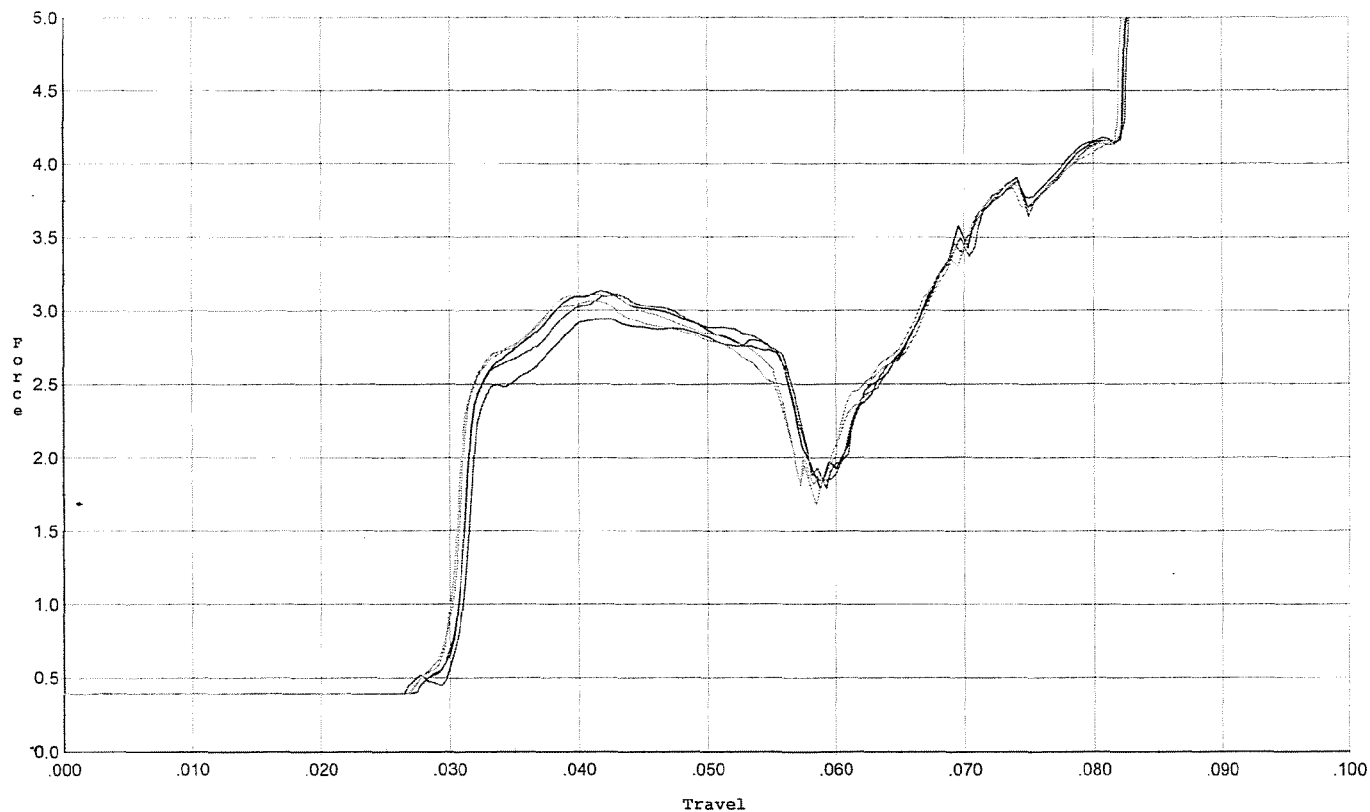
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.100	0.059	0.031	0.031	0.086		Set Trigger
2	3.111	0.059	0.031	0.031	0.086		Set Trigger
3	3.158	0.059	0.031	0.031	0.088		Set Trigger
4	3.102	0.057	0.030	0.033	0.080		Set Trigger
5	3.169	0.058	0.030	0.031	0.087		Set Trigger

A-3.12

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



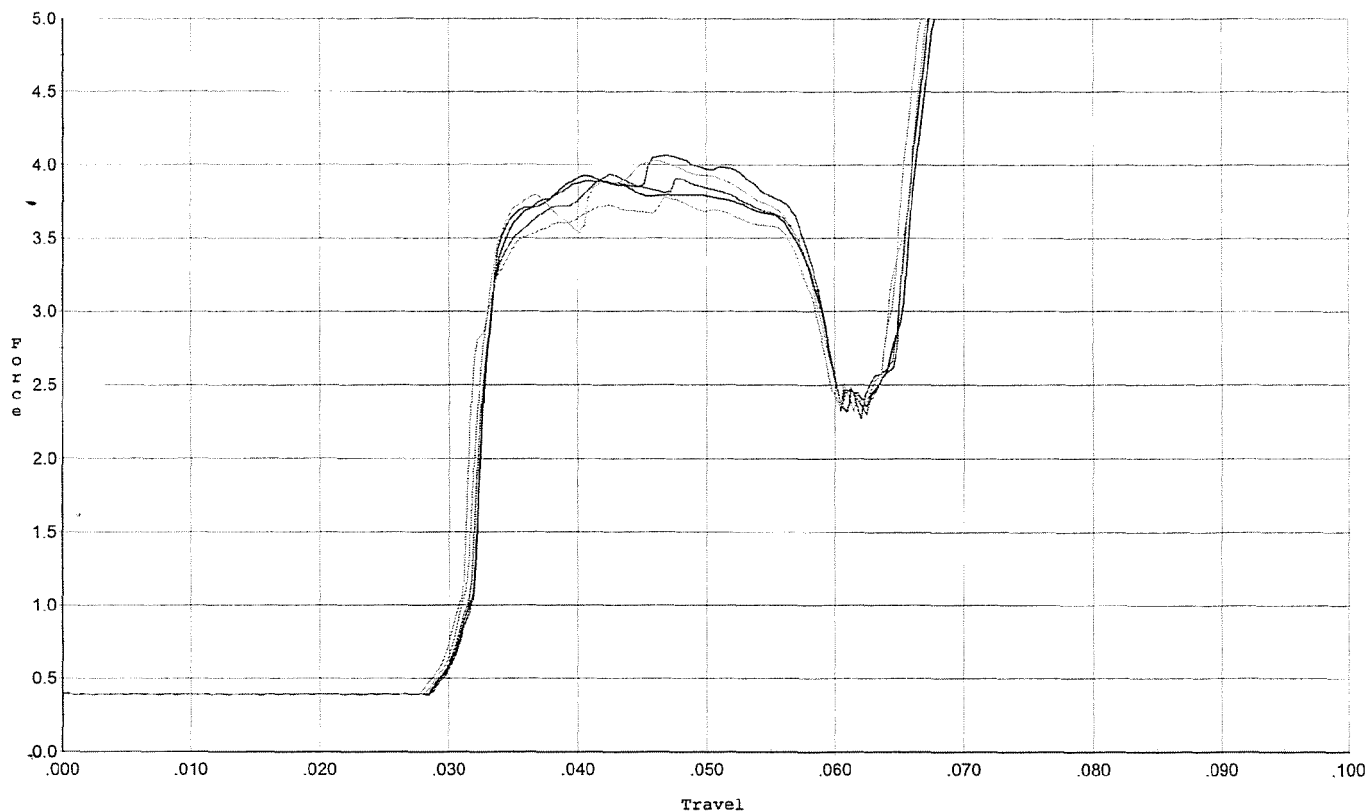
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.942	0.057	0.027	0.031	0.083		Set Trigger
2	3.136	0.056	0.028	0.031	0.084		Set Trigger
3	3.105	0.056	0.028	0.031	0.084		Set Trigger
4	3.106	0.056	0.027	0.030	0.085		Set Trigger
5	3.065	0.056	0.027	0.031	0.083		Set Trigger

A307

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



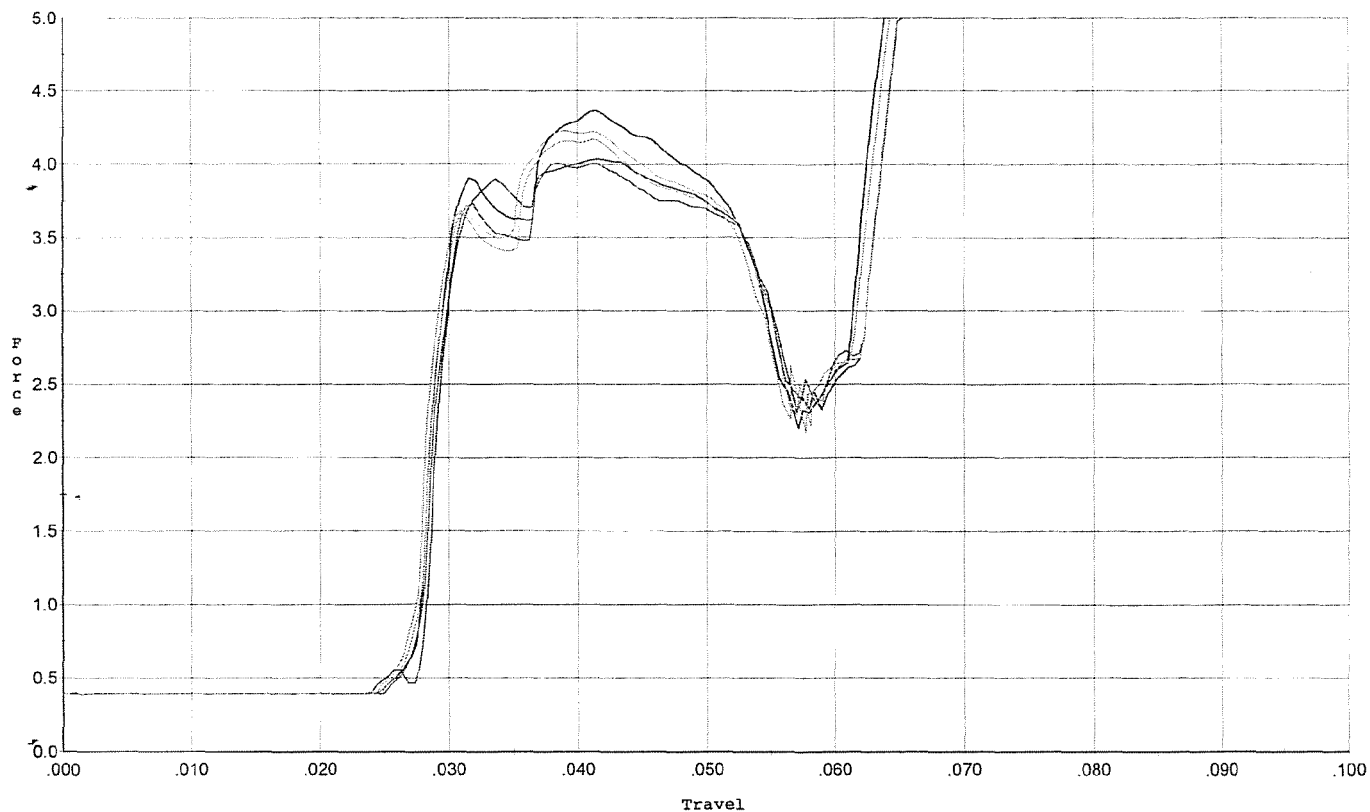
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.064	0.059	0.029	0.014	0.113		Set Trigger
2	3.930	0.059	0.029	0.014	0.111		Set Trigger
3	3.936	0.059	0.029	0.014	0.111		Set Trigger
4	4.028	0.059	0.030	0.013	0.113		Set Trigger
5	3.779	0.058	0.028	0.014	0.108		Set Trigger

A394

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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



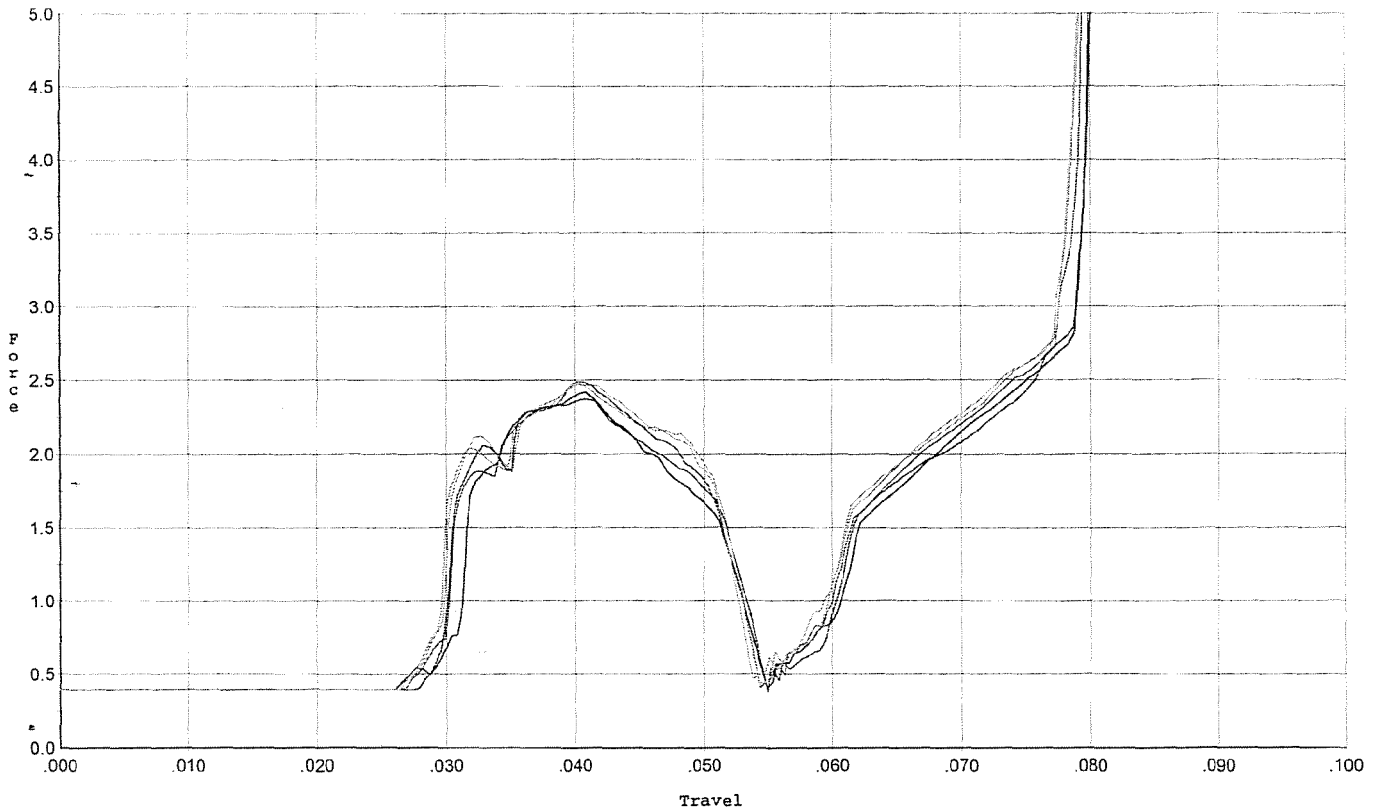
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.033	0.056	0.028	0.015	0.111		Set Trigger
2	4.363	0.054	0.027	0.015	0.111		Set Trigger
3	4.006	0.055	0.027	0.015	0.107		Set Trigger
4	4.226	0.055	0.027	0.015	0.111		Set Trigger
5	4.169	0.055	0.026	0.015	0.109		Set Trigger

A-4.15

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/29/2008

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



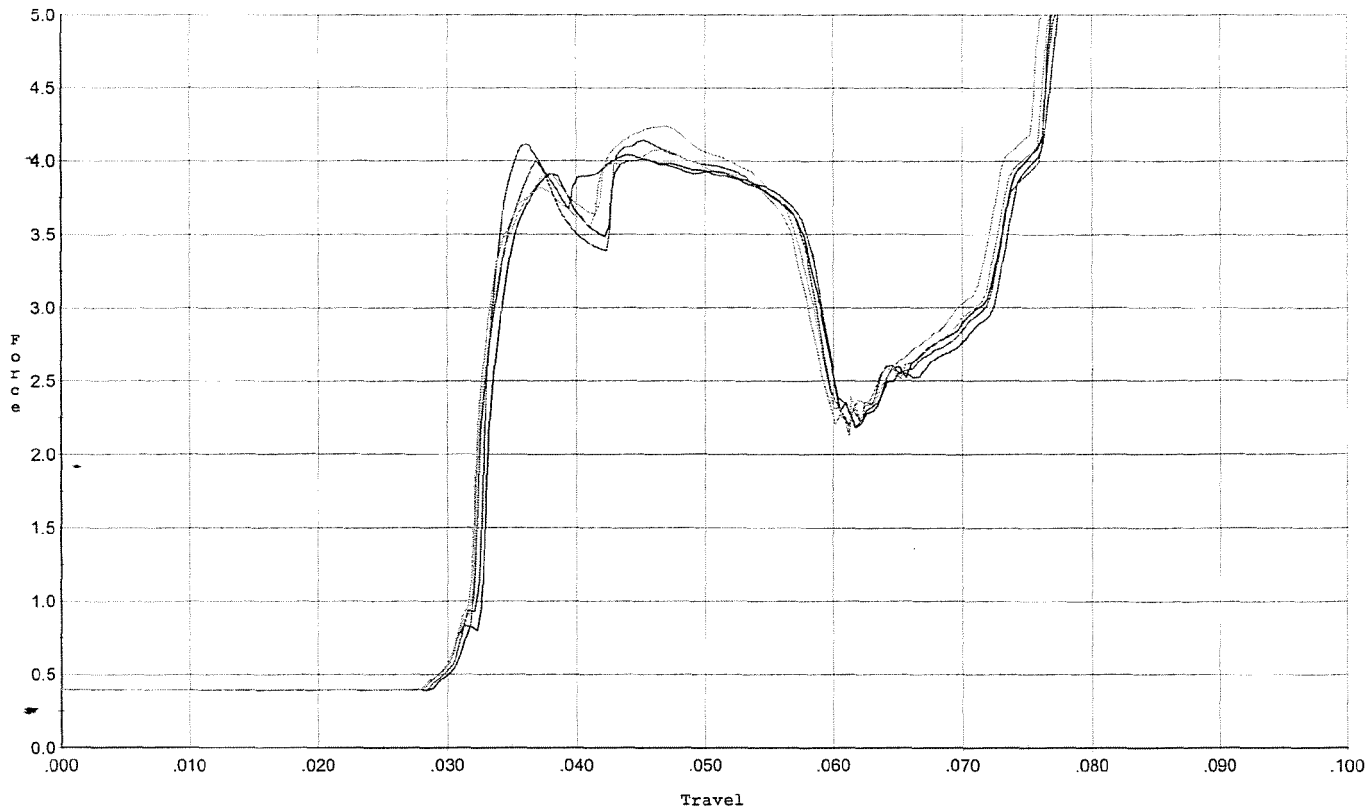
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.372	0.054	0.029	0.032	0.059		Set Trigger
2	2.418	0.054	0.028	0.032	0.057		Set Trigger
3	2.490	0.053	0.029	0.032	0.059		Set Trigger
4	2.477	0.052	0.027	0.032	0.059		Set Trigger
5	2.468	0.053	0.028	0.031	0.061		Set Trigger

A-2.49

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/29/2008

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	4.115	0.058	0.031	0.024	0.112		Set Trigger
2	4.014	0.059	0.031	0.023	0.109		Set Trigger
3	4.145	0.058	0.031	0.024	0.109		Set Trigger
4	4.237	0.058	0.030	0.024	0.112		Set Trigger
5	4.080	0.058	0.030	0.023	0.109		Set Trigger

A 4.11