

G6801336

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

— INSTRUCTION BOOK 3518

BM FORM

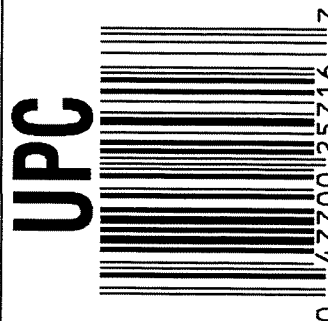


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6801336



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801336

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SP
460	CHECK HEADSPACE		3-20-09	SP
470	DIS-ASSEMBLE ACTION		3-20-09	SP
472	SERIALIZE BOLT HANDLE		3-23-09	RT
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/25/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-28	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-7-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

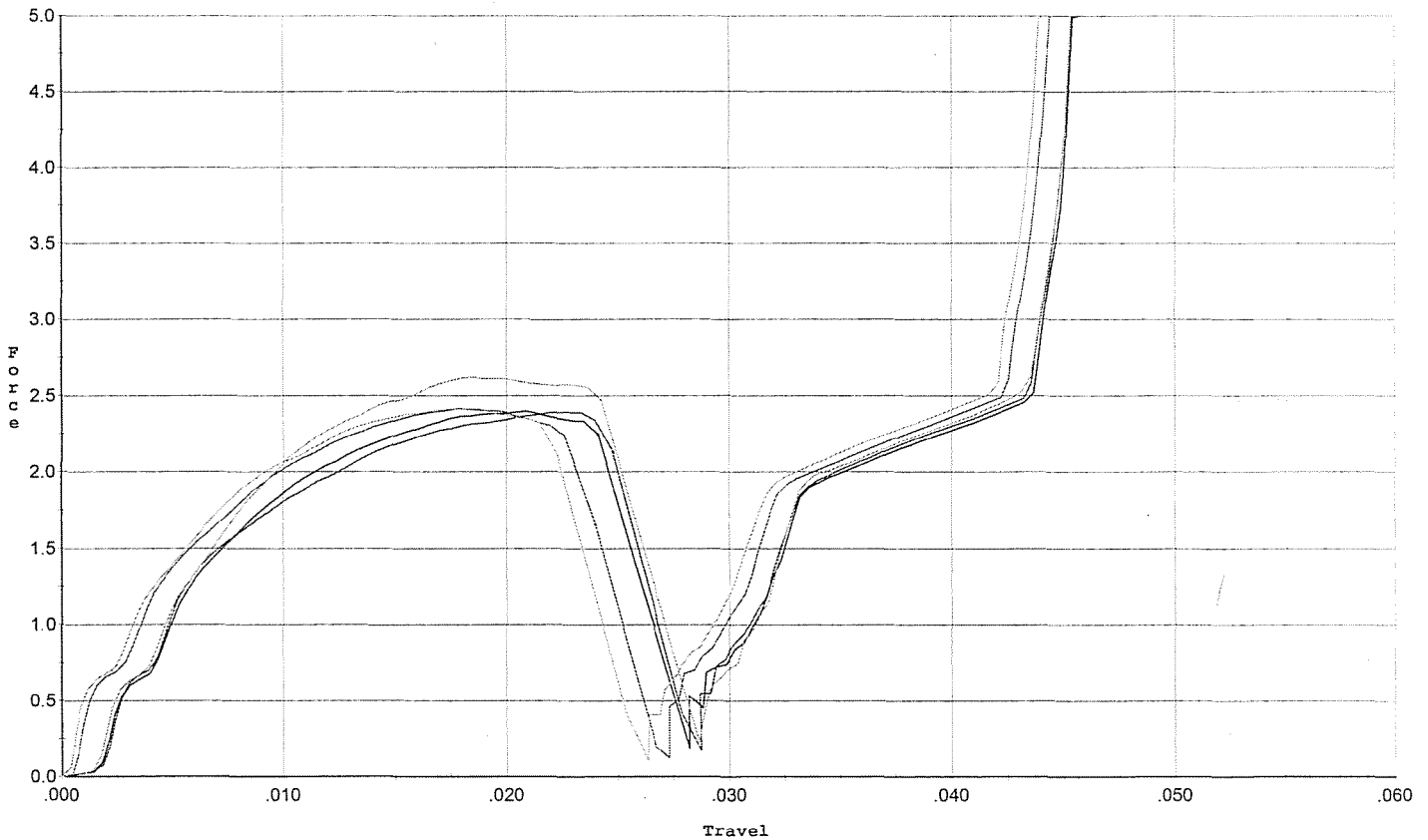
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.6</u> <u>2.7</u> <u>2.7</u>	4/12/09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.3</u> <u>4.6</u> <u>4.4</u>	4/12/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4/12/09	RP
	J) ASSEMBLE STOCK		4-7-09	LD
	K) ASSEMBLE SWIVEL STUDS		4/12/09	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	4-9-09	WZ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TGR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.77</u> <u>2.66</u> <u>2.65</u> <u>2.71</u>	4-14-09	WZ
	C) FUNCTION		4/12/09	RP
690	PACK		4-29-09	WZ

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



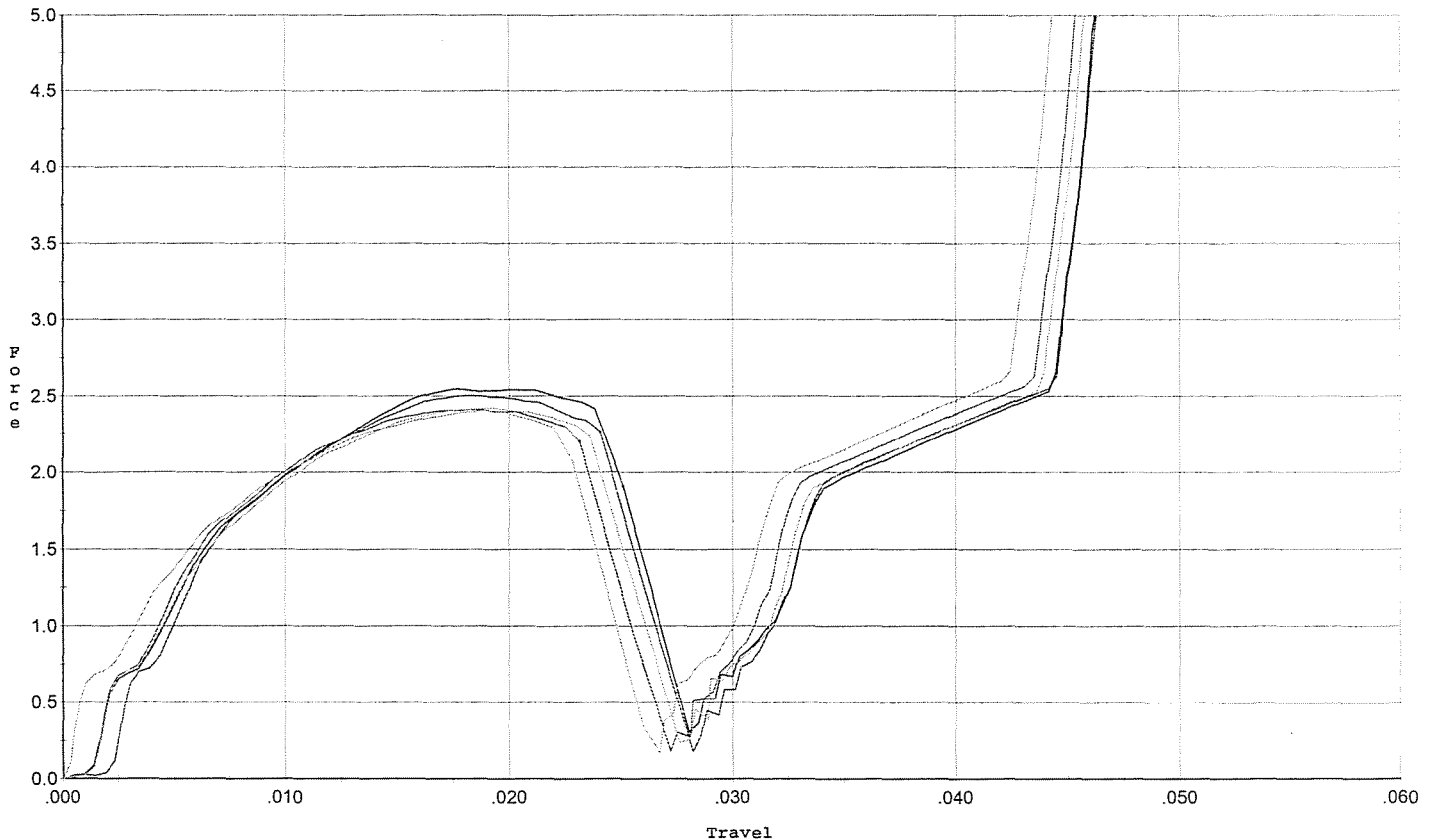
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.392	0.025	0.00	0.023	0.041		Set Trigger
2	2.401	0.024	0.00	0.026	0.040		Set Trigger
3	2.417	0.024	0.00	0.027	0.042		Set Trigger
4	2.413	0.022	0.00	0.028	0.040		Set Trigger
5	2.622	0.024	0.00	0.023	0.044		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



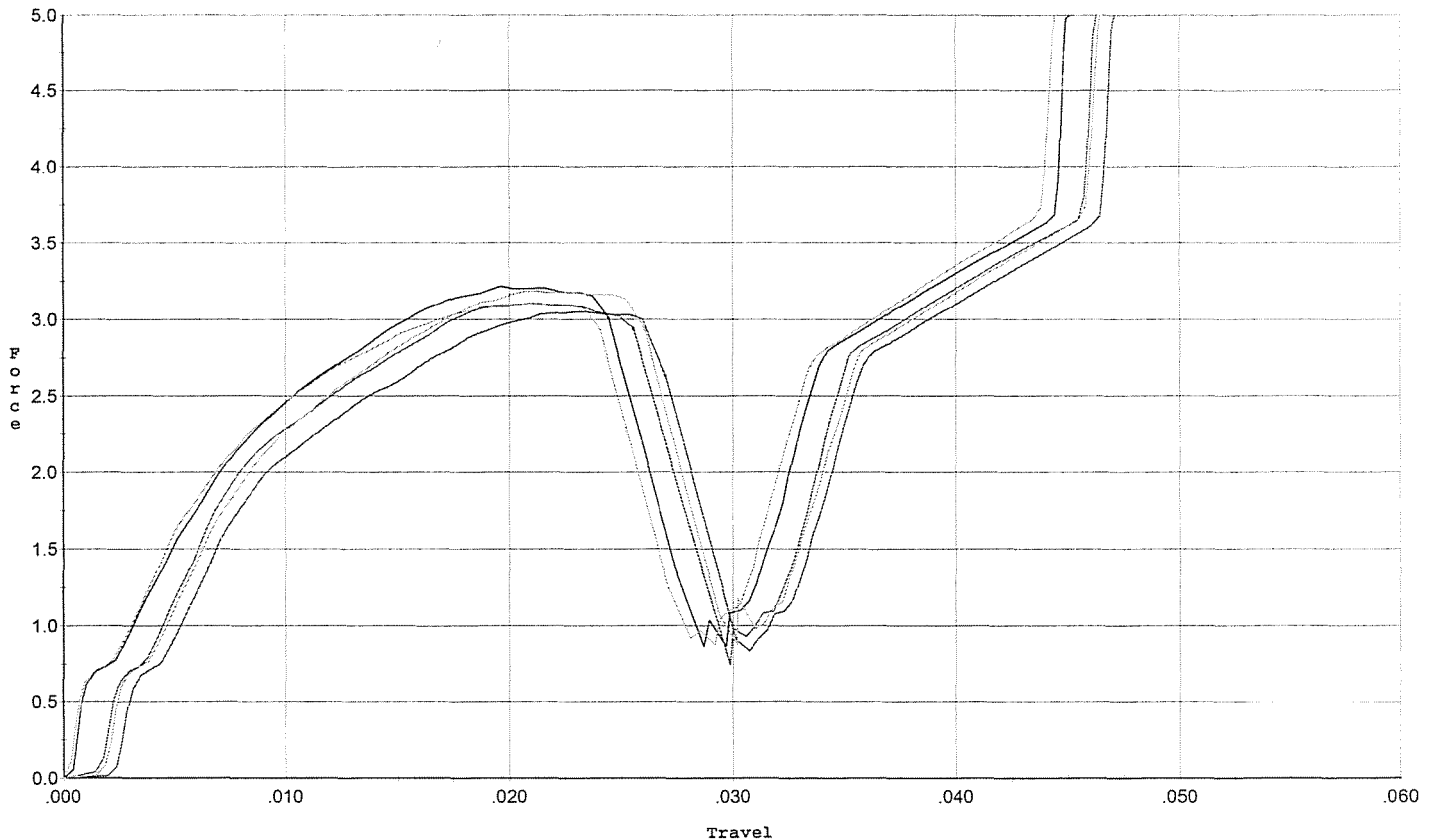
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.505	0.024	0.00	0.029	0.042		Set Trigger
2	2.547	0.025	0.00	0.025	0.045		Set Trigger
3	2.410	0.023	0.00	0.028	0.040		Set Trigger
4	2.421	0.024	0.00	0.028	0.040		Set Trigger
5	2.407	0.023	0.00	0.028	0.040		Set Trigger

A2-45

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



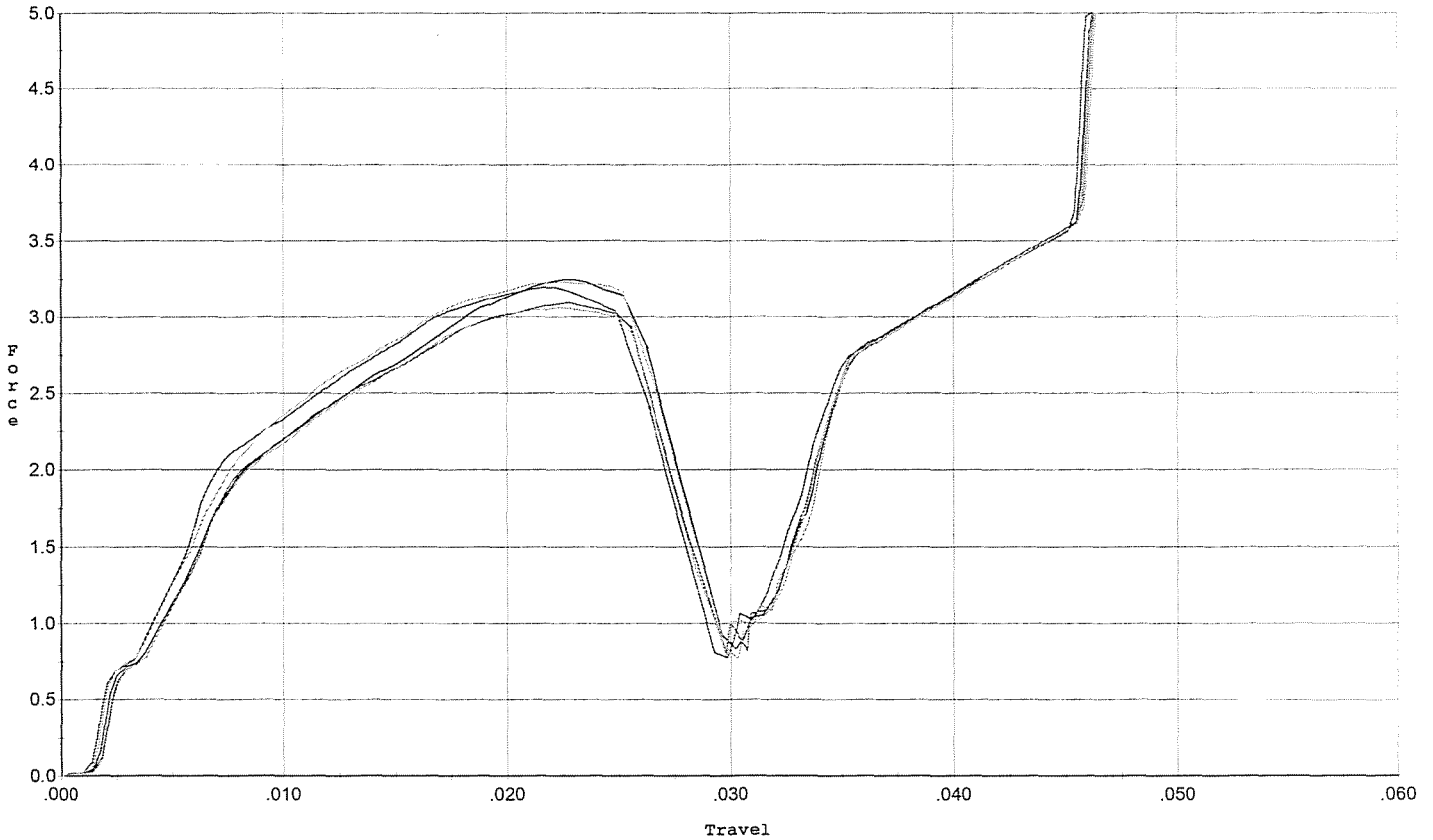
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.052	0.027	0.002	0.021	0.054		Set Trigger
2	3.217	0.024	0.00	0.021	0.055		Set Trigger
3	3.105	0.026	0.00	0.021	0.054		Set Trigger
4	3.185	0.026	0.00	0.021	0.056		Set Trigger
5	3.104	0.024	0.00	0.021	0.053		Set Trigger

A-3-13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



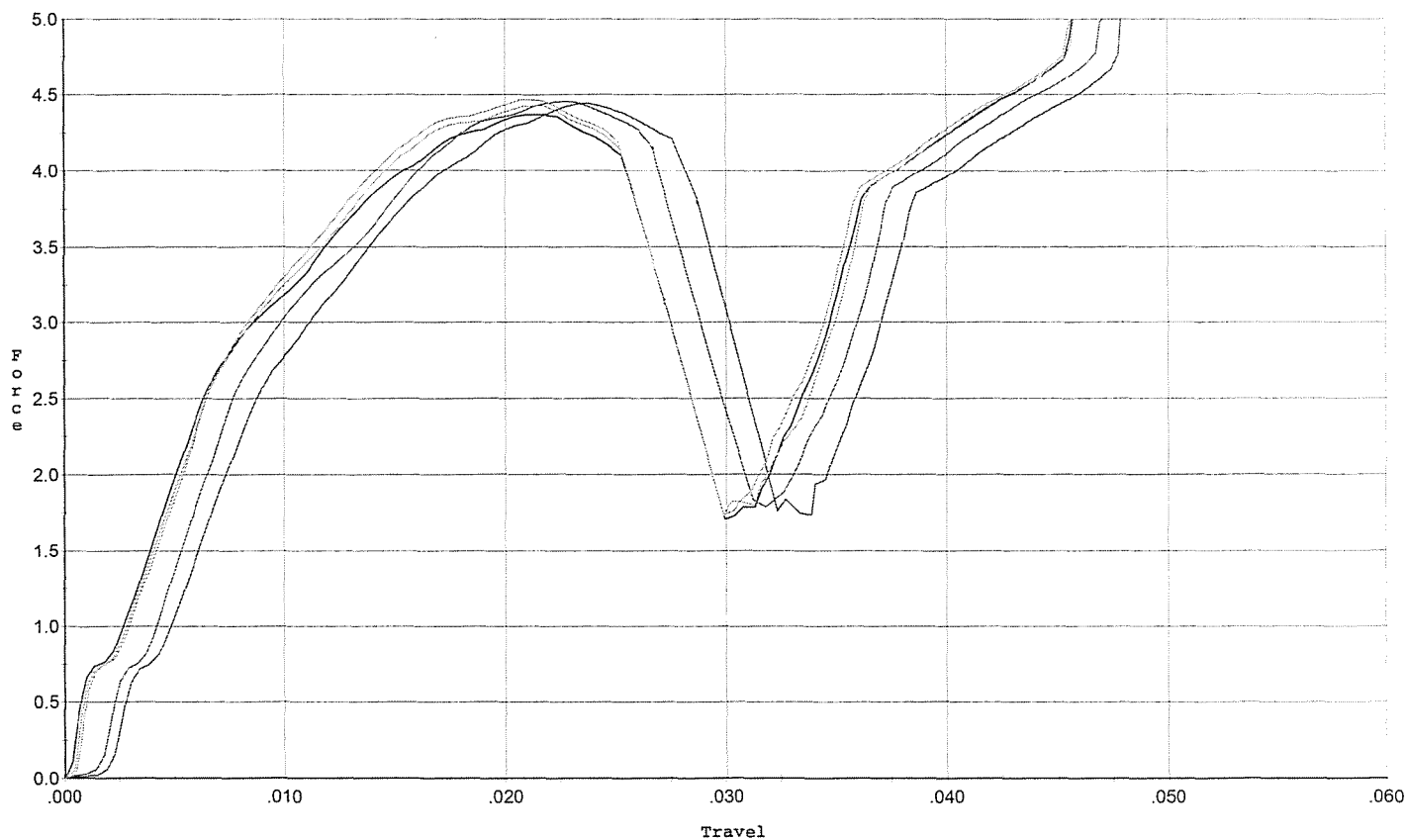
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.196	0.026	0.00	0.021	0.057		Set Trigger
2	3.245	0.026	0.00	0.021	0.056		Set Trigger
3	3.095	0.026	0.00	0.021	0.053		Set Trigger
4	3.228	0.027	0.00	0.021	0.059		Set Trigger
5	3.060	0.026	0.00	0.022	0.053		Set Trigger

A-3-16

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: T Rogowski 04/03/2009

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



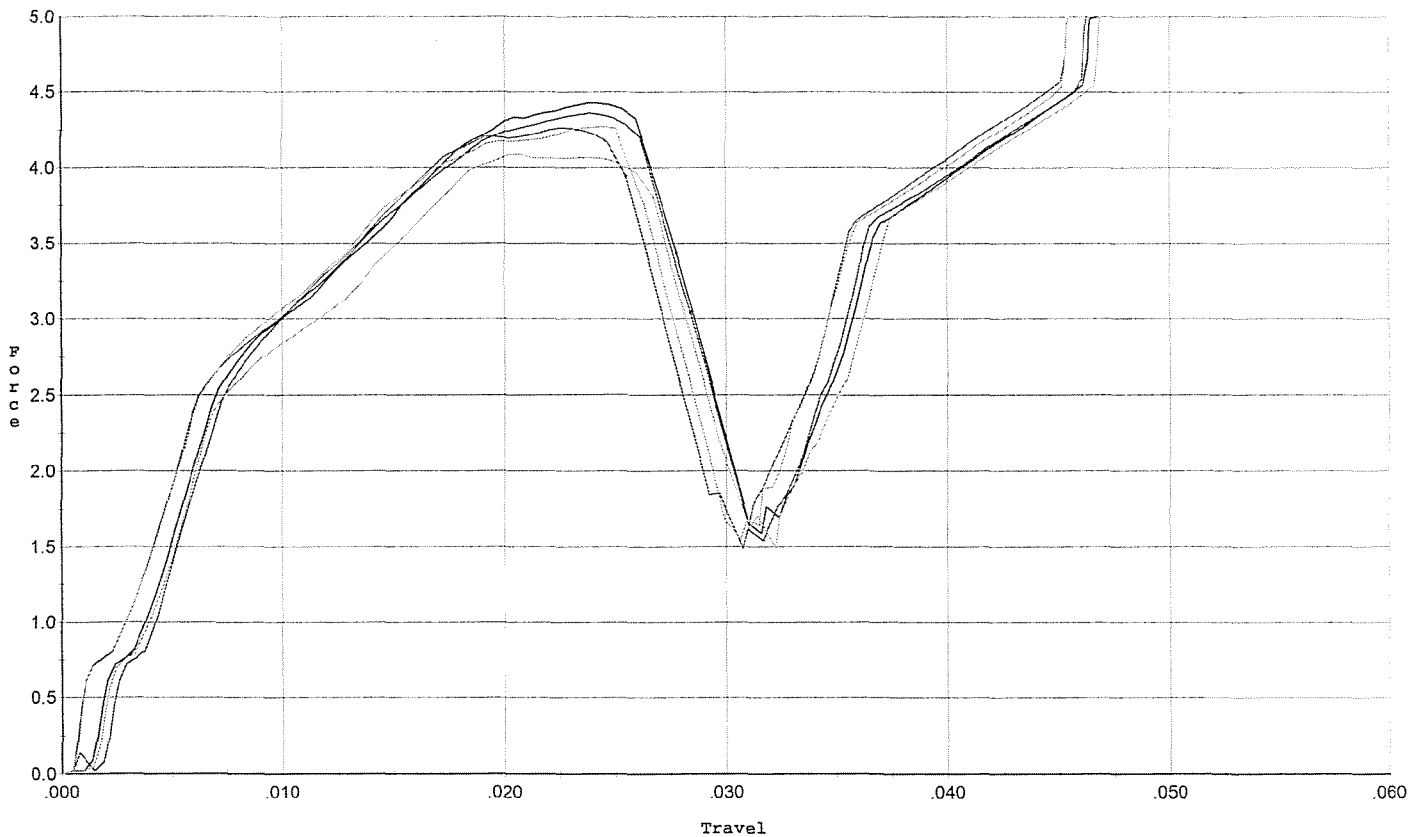
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.442	0.029	0.002	0.017	0.081		Set Trigger
2	4.367	0.027	0.00	0.017	0.081		Set Trigger
3	4.455	0.027	0.00	0.018	0.077		Set Trigger
4	4.423	0.027	0.00	0.017	0.082		Set Trigger
5	4.466	0.027	0.00	0.017	0.082		Set Trigger

A-4.43

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



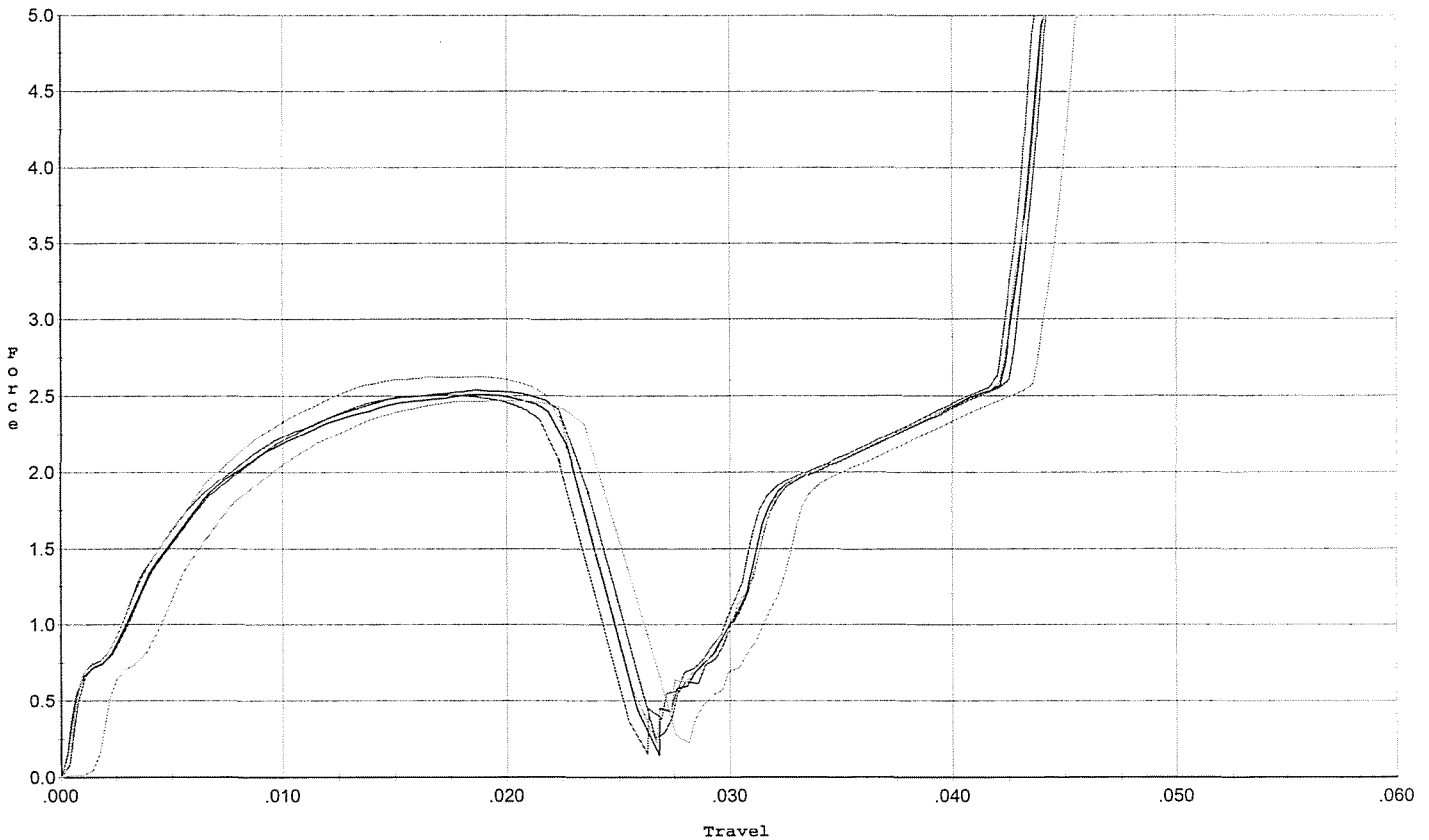
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.358	0.028	0.00	0.017	0.080		Set Trigger
2	4.424	0.028	0.00	0.017	0.080		Set Trigger
3	4.260	0.026	0.00	0.018	0.074		Set Trigger
4	4.088	0.027	0.00	0.018	0.073		Set Trigger
5	4.274	0.026	0.00	0.017	0.076		Set Trigger

A-4.28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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



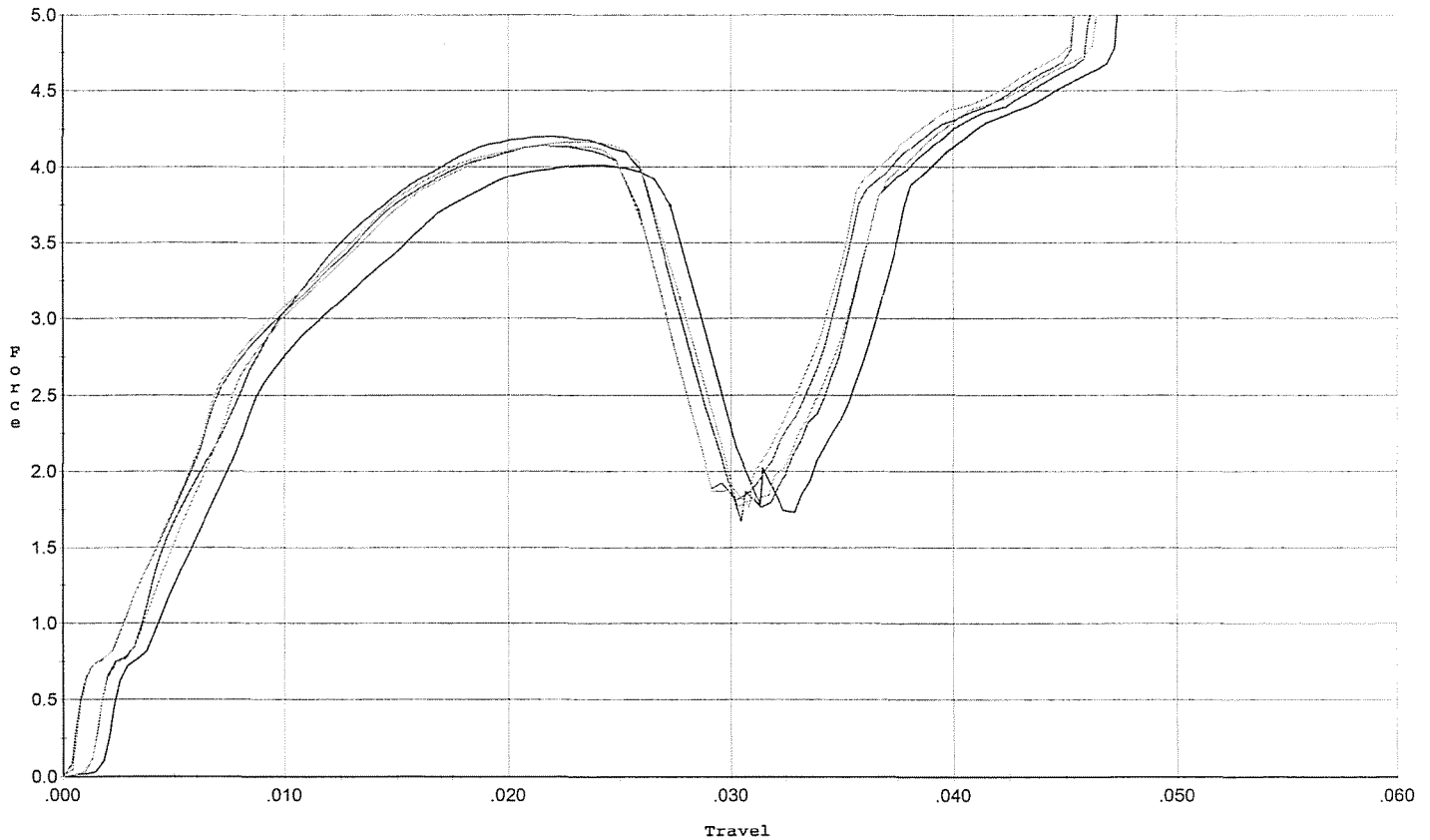
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.539	0.024	0.00	0.027	0.045		Set Trigger
2	2.508	0.023	0.00	0.027	0.043		Set Trigger
3	2.509	0.022	0.00	0.027	0.042		Set Trigger
4	2.471	0.025	0.00	0.028	0.045		Set Trigger
5	2.626	0.022	0.00	0.027	0.044		Set Trigger

A-2-53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: T Rogowski 04/03/2009

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	4.199	0.026	0.00	0.018	0.073		Set Trigger
2	4.010	0.027	0.00	0.018	0.072		Set Trigger
3	4.141	0.026	0.00	0.018	0.073		Set Trigger
4	4.140	0.026	0.00	0.018	0.074		Set Trigger
5	4.165	0.028	0.00	0.018	0.078		Set Trigger

A-4.13