

G680 1355

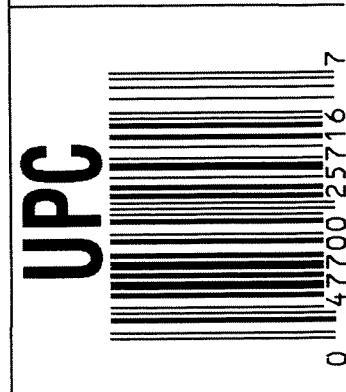
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6801355	



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801355

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	SP
470	DIS-ASSEMBLE ACTION		3-4-09	SP
472	SERIALIZE BOLT HANDLE		3-5-09	RIZ
480	MAGNAFLUX BBL ACTION	(H)	3/9/09	(H)
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/19/09	Rt
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/8	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-19-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-20-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

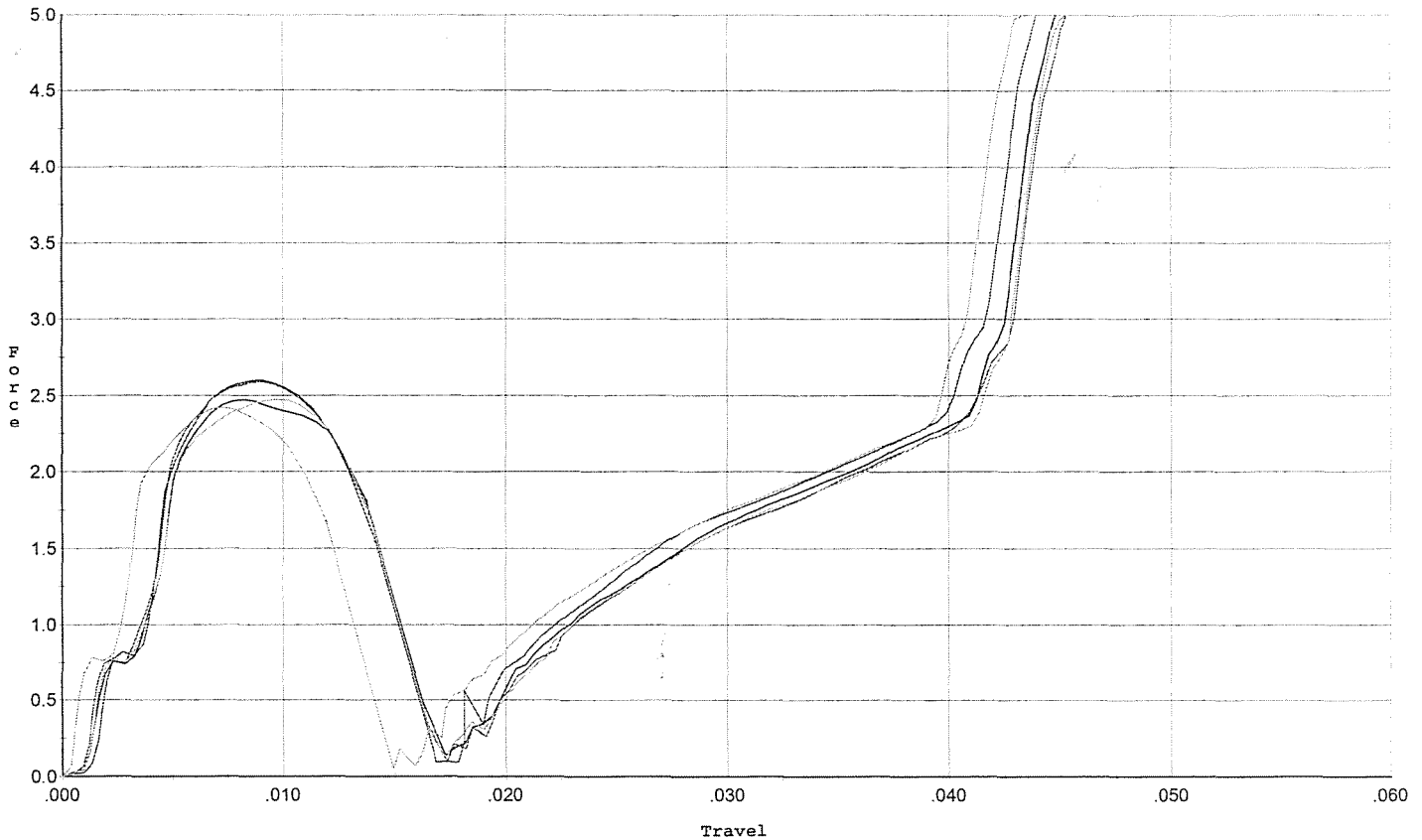
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.3</u> <u>2.2</u> <u>2.3</u>	3/23/09	RP
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.4</u> <u>4.4</u> <u>4.2</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>0.23</u> <u>0.23</u> <u>0.23</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-20-09	RP
	K) ASSEMBLE SWIVEL STUDS		3/23/09	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	3-23-09	TC
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	WU
670	FINAL INSPECTION A) HEADSPACE		3/23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.40</u> <u>2.44</u> <u>2.58</u> <u>2.65</u>	3-23-09	TC
	C) FUNCTION		3-23-09	RP
690	PACK		3/24/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



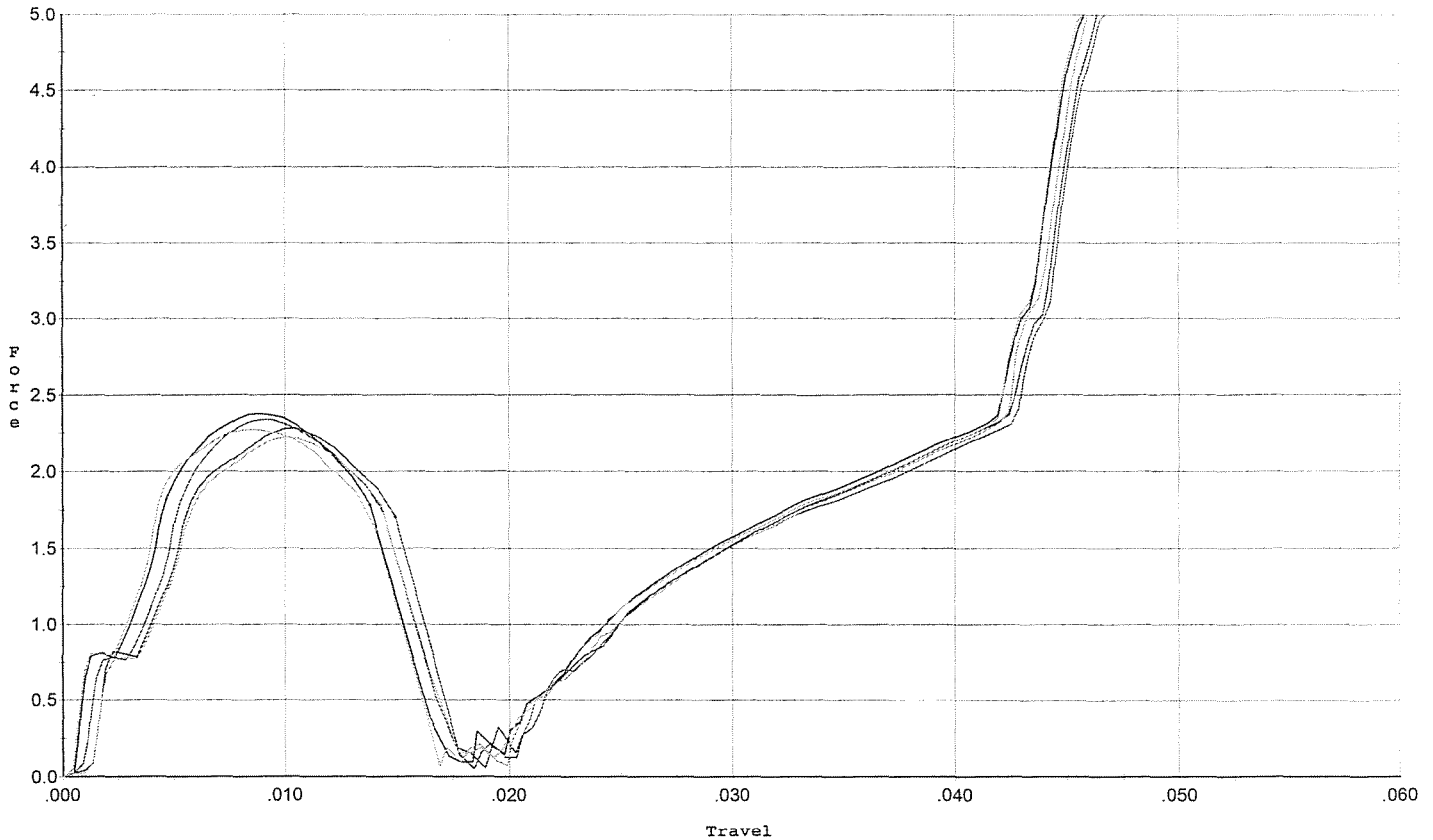
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.600	0.014	0.00	0.034	0.023		Set Trigger
2	2.468	0.014	0.00	0.035	0.022		Set Trigger
3	2.589	0.014	0.00	0.036	0.023		Set Trigger
4	2.476	0.014	0.00	0.036	0.022		Set Trigger
5	2.423	0.012	0.00	0.035	0.020		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



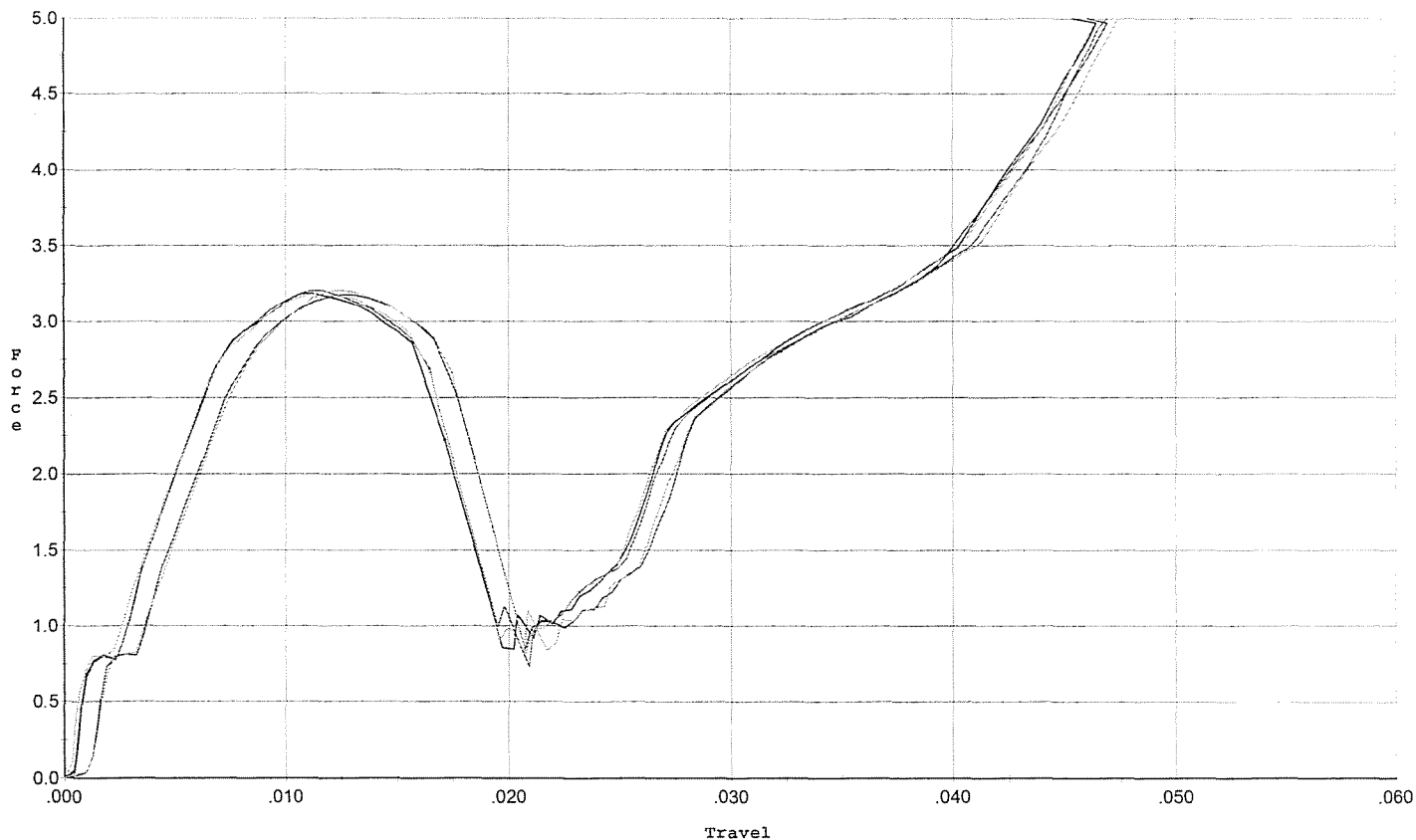
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.281	0.015	0.004	0.036	0.022		Set Trigger
2	2.380	0.014	0.00	0.036	0.022		Set Trigger
3	2.339	0.014	0.00	0.037	0.022		Set Trigger
4	2.277	0.014	0.003	0.036	0.023		Set Trigger
5	2.222	0.014	0.00	0.036	0.021		Set Trigger

A.2.30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



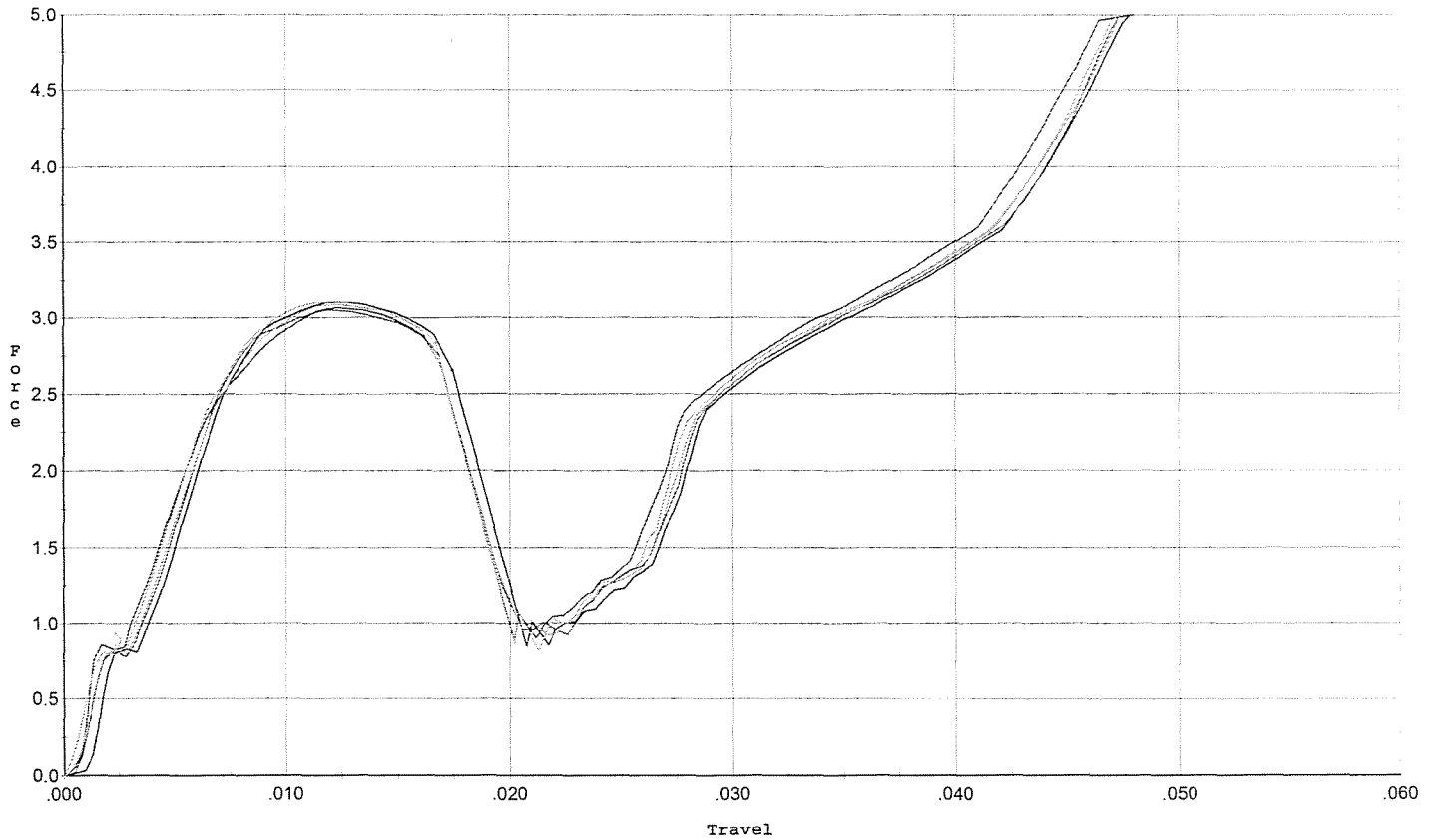
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.018	0.00	0.032	0.037		Set Trigger
2	3.187	0.017	0.00	0.032	0.037		Set Trigger
3	3.204	0.016	0.00	0.033	0.036		Set Trigger
4	3.183	0.016	0.00	0.032	0.036		Set Trigger
5	3.207	0.017	0.00	0.032	0.036		Set Trigger

A.3.19

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



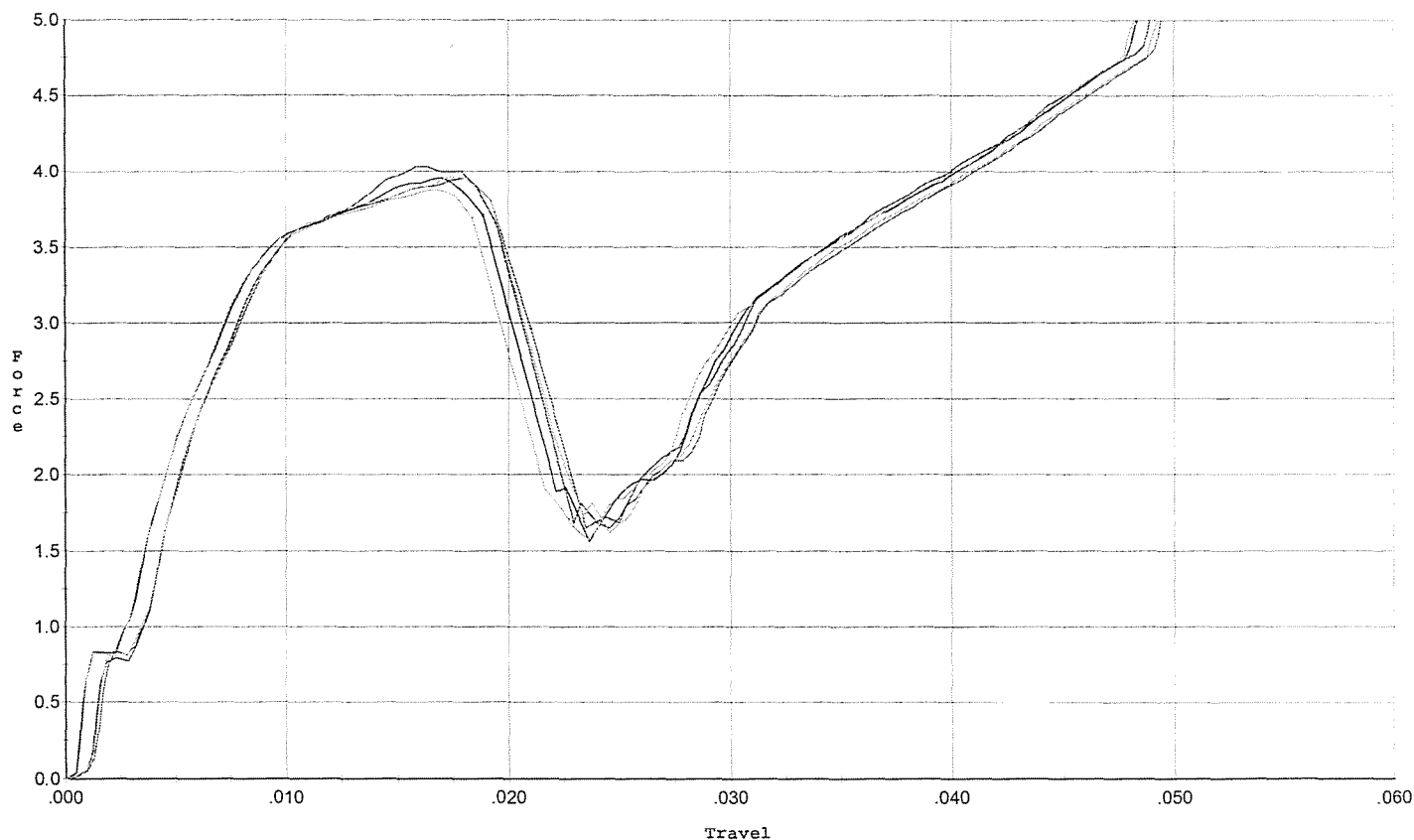
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.065	0.017	0.00	0.032	0.035		Set Trigger
2	3.104	0.017	0.00	0.032	0.036		Set Trigger
3	3.050	0.017	0.00	0.033	0.035		Set Trigger
4	3.101	0.017	0.00	0.032	0.036		Set Trigger
5	3.084	0.017	0.00	0.032	0.035		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



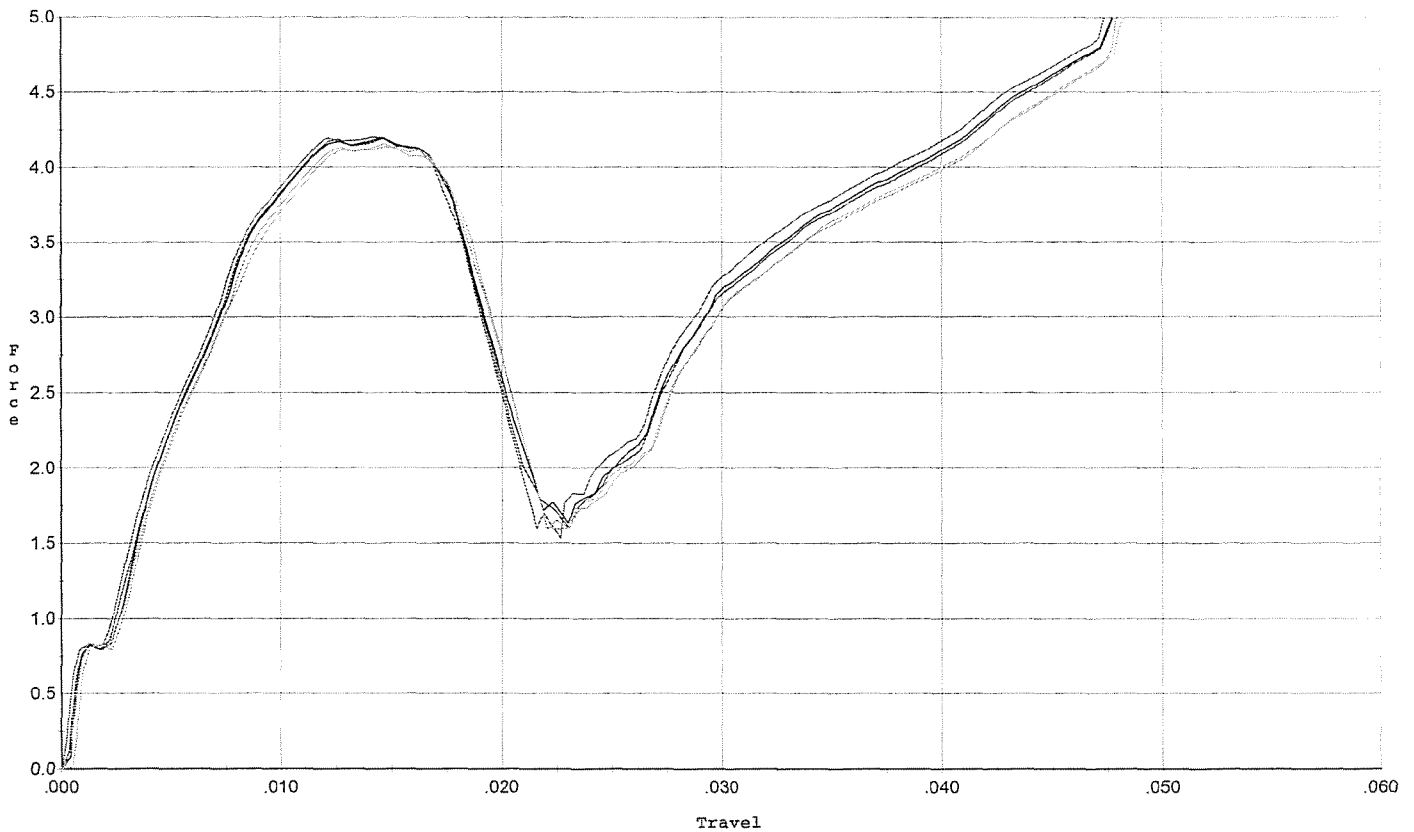
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.030	0.019	0.00	0.030	0.051		Set Trigger
2	3.955	0.019	0.003	0.030	0.050		Set Trigger
3	3.950	0.021	0.00	0.030	0.055		Set Trigger
4	3.966	0.019	0.00	0.030	0.050		Set Trigger
5	3.876	0.018	0.003	0.030	0.048		Set Trigger

A-3.95

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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



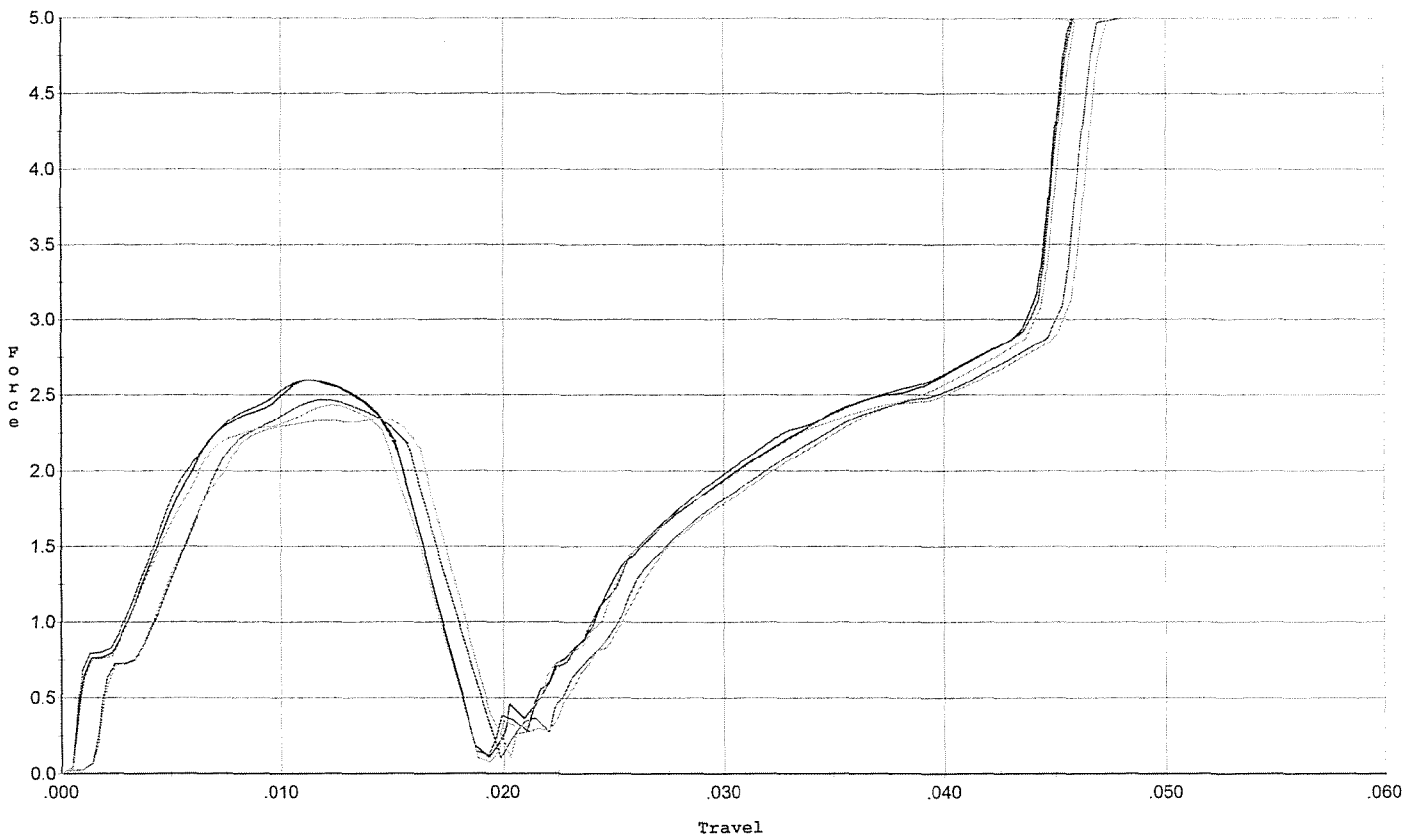
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.192	0.018	0.00	0.030	0.049		Set Trigger
2	4.199	0.018	0.00	0.030	0.049		Set Trigger
3	4.202	0.018	0.00	0.030	0.050		Set Trigger
4	4.138	0.019	0.00	0.030	0.051		Set Trigger
5	4.154	0.019	0.00	0.030	0.052		Set Trigger

A- 4.17

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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	2.600	0.015	0.00	0.034	0.027		Set Trigger
2	2.596	0.015	0.00	0.034	0.027		Set Trigger
3	2.469	0.016	0.00	0.035	0.025		Set Trigger
4	2.435	0.016	0.00	0.034	0.027		Set Trigger
5	2.344	0.016	0.00	0.035	0.026		Set Trigger

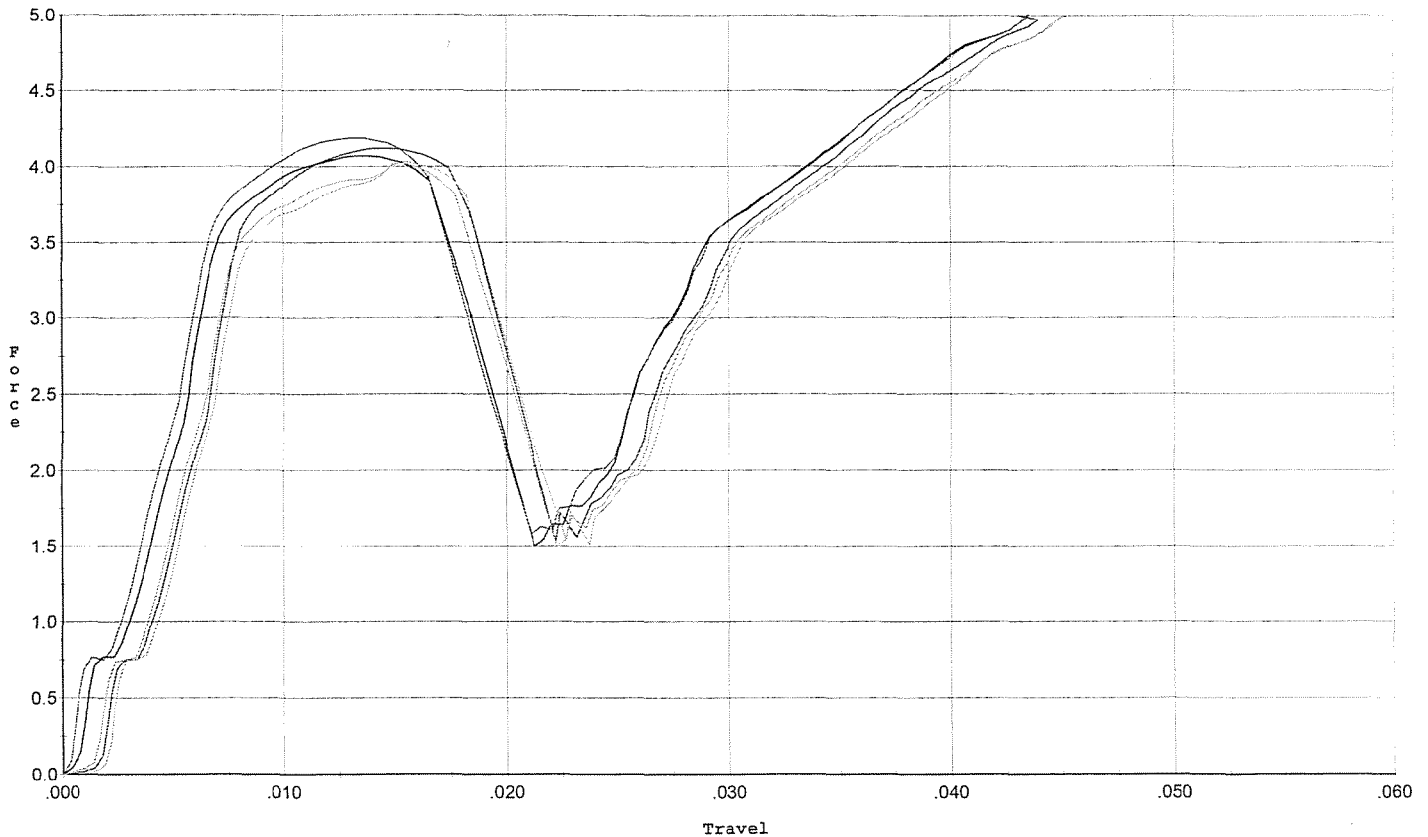
A. 2.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/19/2009

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

~~after~~ for target
+ accuracy
c 1/5



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.119	0.018	0.00	0.029	0.048		Set Trigger
2	4.069	0.018	0.00	0.028	0.050		Set Trigger
3	4.188	0.017	0.00	0.029	0.046		Set Trigger
4	4.037	0.018	0.00	0.029	0.046		Set Trigger
5	4.023	0.020	0.00	0.029	0.050		Set Trigger

A 4.08