

G6801373

Oxford.

NO. 752 1/3

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

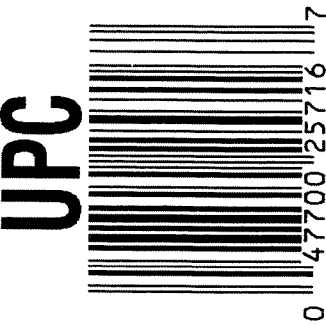
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801373



INSPECTION OF NEW GUNS

GUN SERIAL #

G 6801373

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	RTZ
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	3-6-09	RTZ
475	DRILL AND TAP SIGHT HOLES		3-6-09	SP
480	MAGNAFLUX BBL ACTION		3/6/09	SP
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
520	GOFF BLAST BBL / REC		3/11	man
542	APPLY COATINGS (BARREL ACTION)		3-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-20-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-20-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-20-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

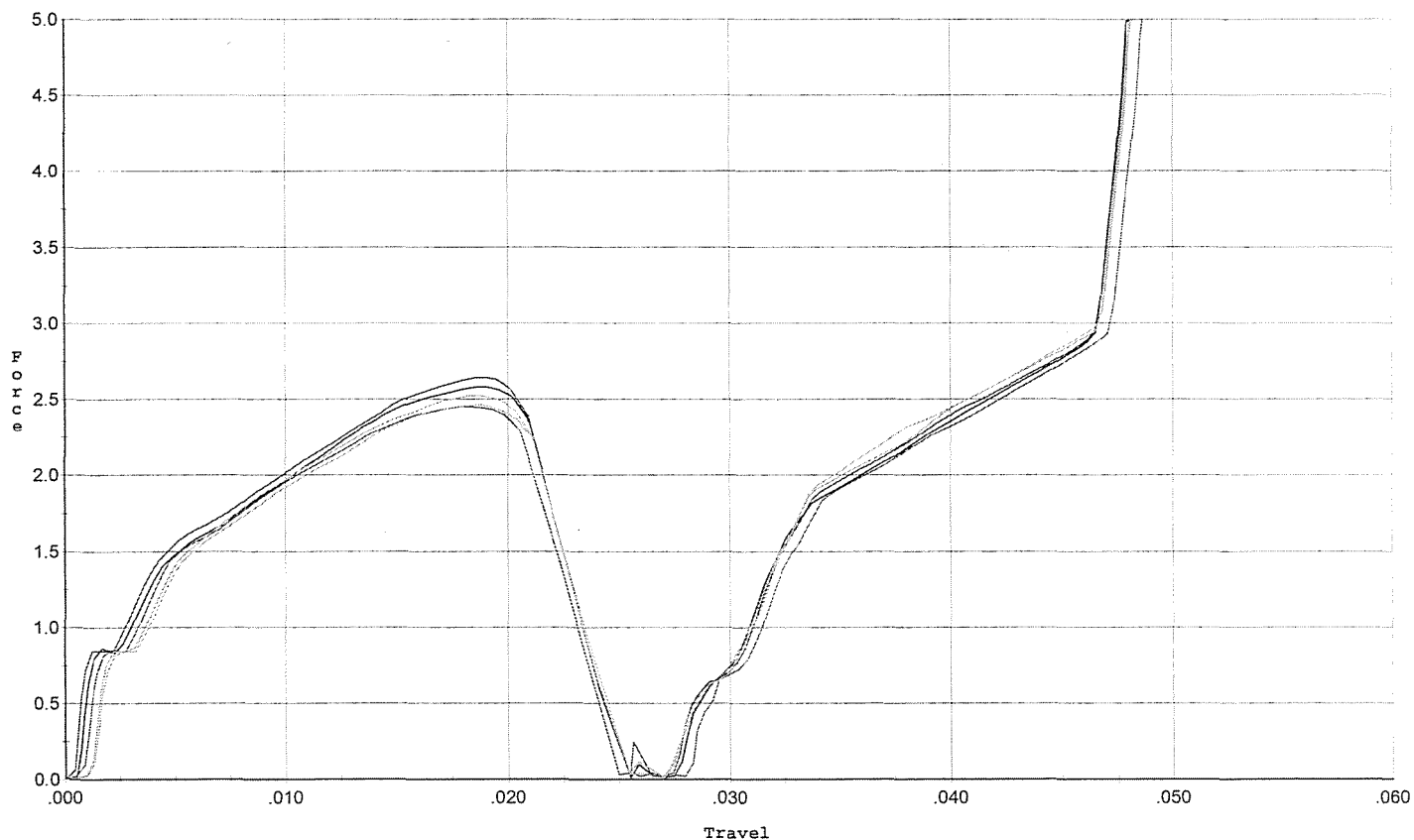
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	3-25-09	WV
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-25-09	WV
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	3-25-09	WV
	J) ASSEMBLE STOCK		3-23-09	WV
	K) ASSEMBLE SWIVEL STUDS		3-30-09	WV
	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	3-24-09	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-09	WV
670	FINAL INSPECTION A) HEADSPACE		3-25-09	WV
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.45</u> <u>2.37</u> <u>2.39</u> <u>2.25</u>	3-24-09	TC
	C) FUNCTION		3-25-09	WV
690	PACK		3/31/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



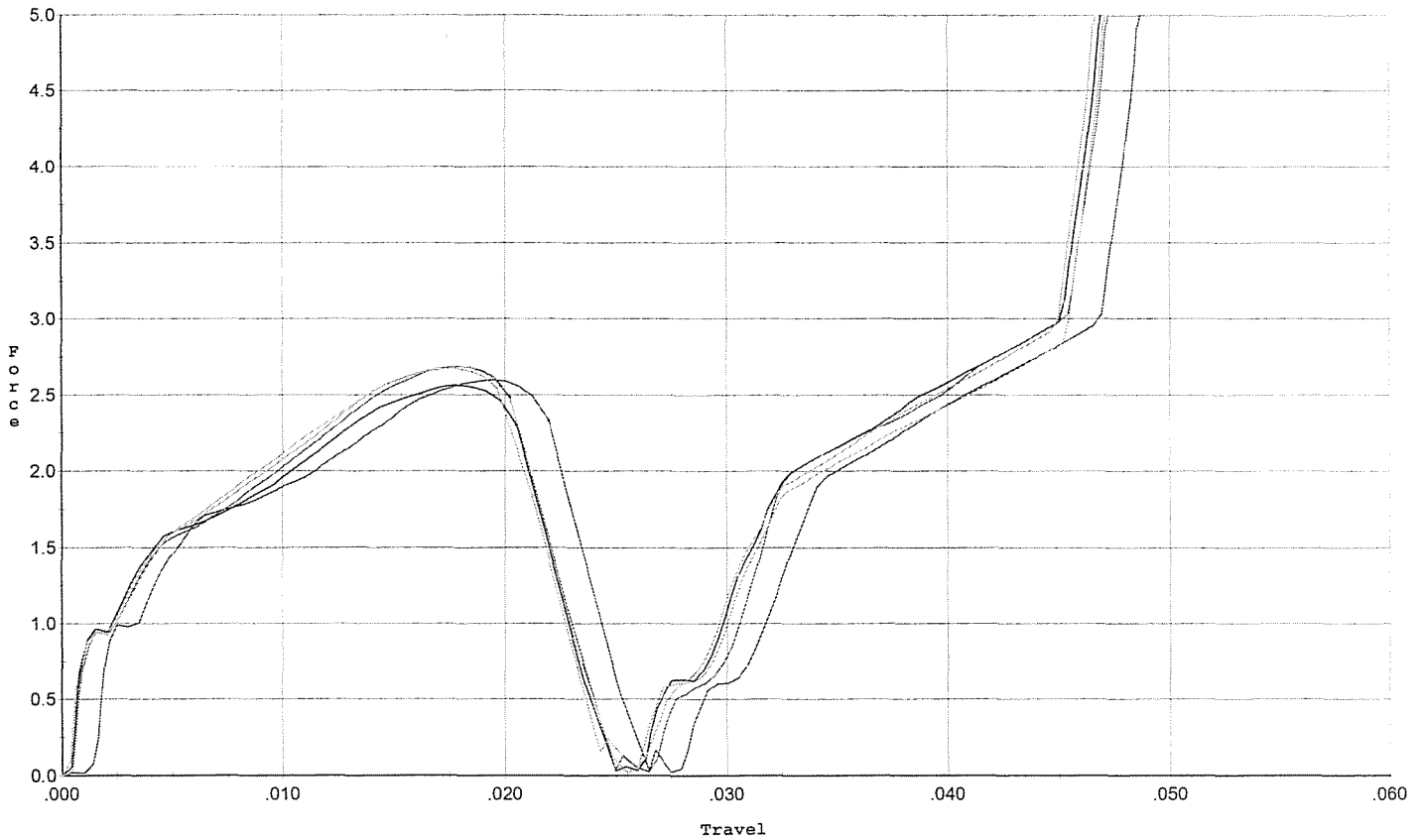
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.021	0.003	0.032	0.038		Set Trigger
2	2.580	0.021	0.00	0.032	0.037		Set Trigger
3	2.450	0.022	0.00	0.032	0.038		Set Trigger
4	2.465	0.021	0.00	0.032	0.036		Set Trigger
5	2.523	0.021	0.00	0.032	0.036		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



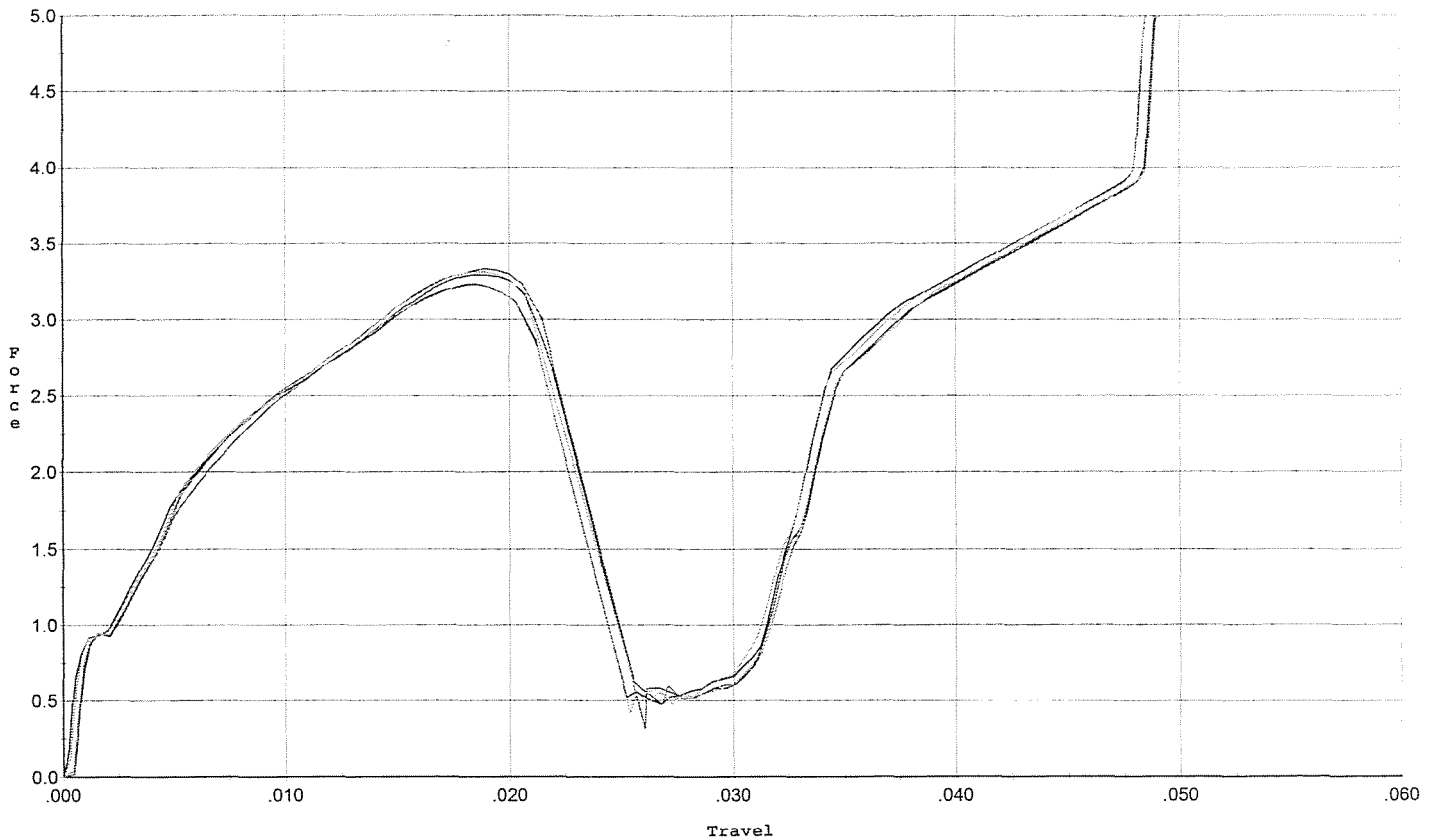
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.598	0.022	0.00	0.032	0.039		Set Trigger
2	2.564	0.020	0.00	0.031	0.037		Set Trigger
3	2.686	0.020	0.00	0.031	0.037		Set Trigger
4	2.690	0.020	0.00	0.031	0.038		Set Trigger
5	2.675	0.021	0.00	0.030	0.040		Set Trigger

A-2.64

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



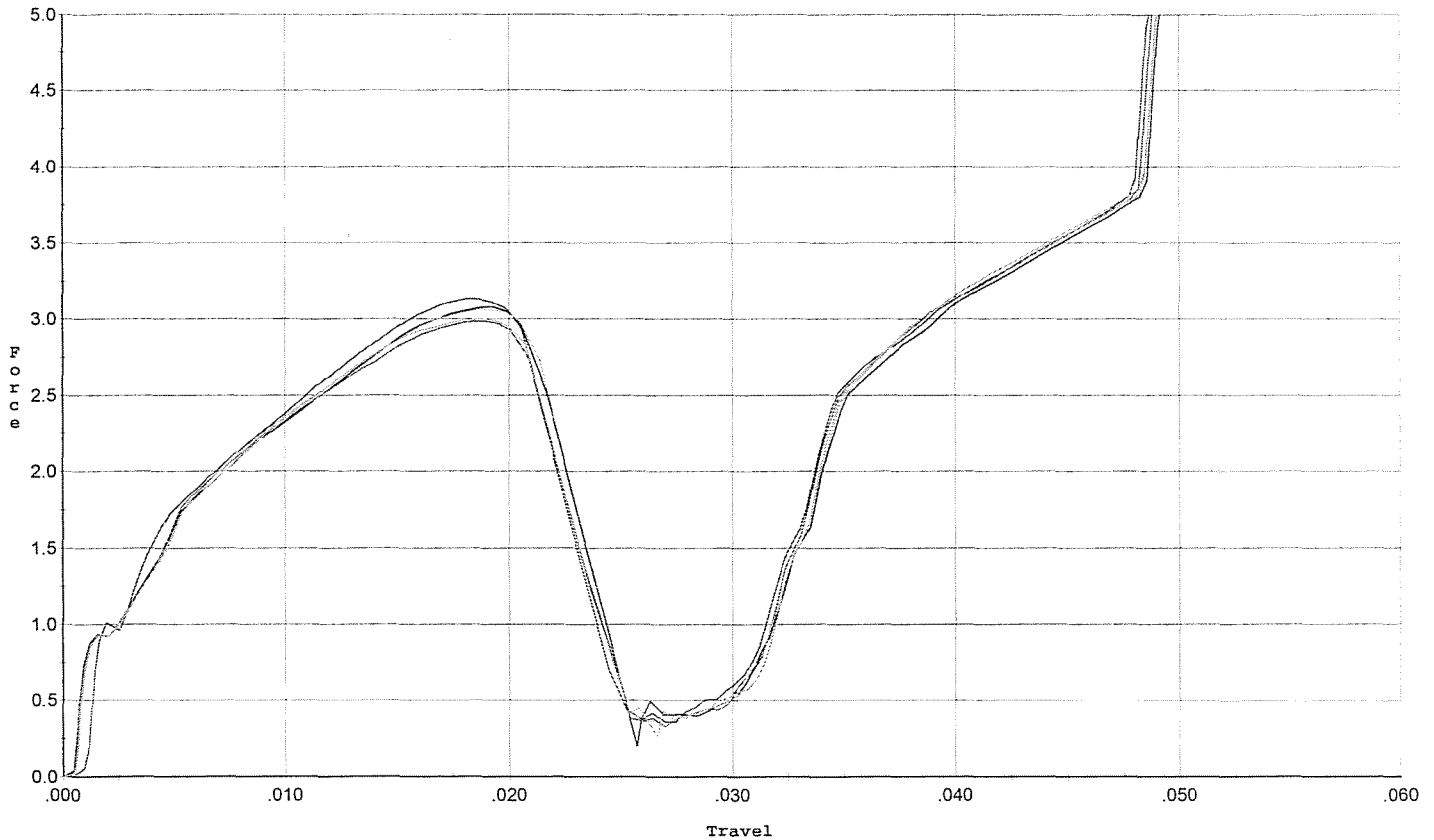
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.296	0.022	0.00	0.031	0.049		Set Trigger
2	3.233	0.021	0.00	0.031	0.047		Set Trigger
3	3.335	0.021	0.00	0.032	0.048		Set Trigger
4	3.240	0.021	0.00	0.031	0.047		Set Trigger
5	3.318	0.023	0.00	0.032	0.051		Set Trigger

A-3-28

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



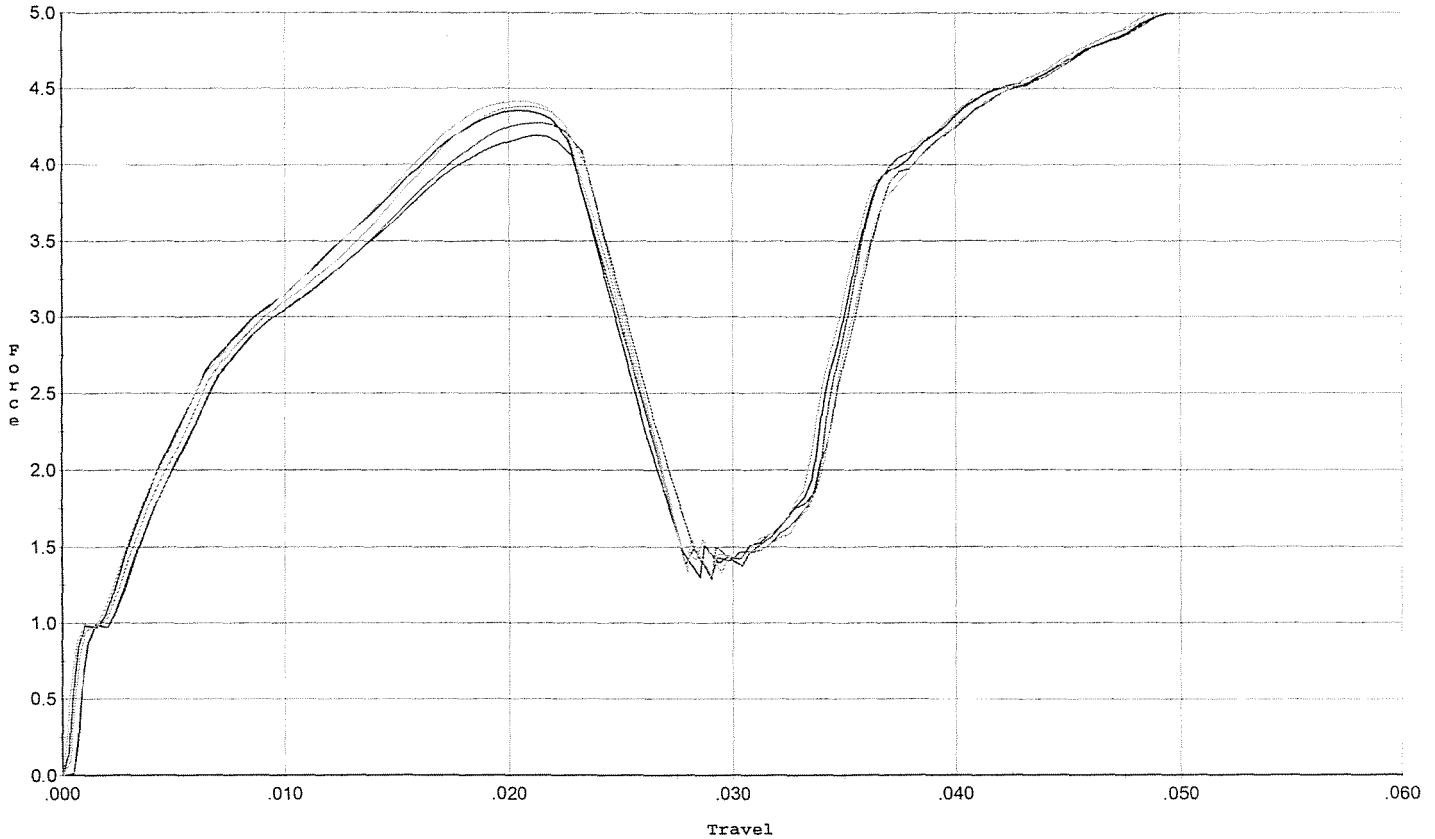
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.136	0.021	0.00	0.032	0.043		Set Trigger
2	3.075	0.022	0.00	0.032	0.045		Set Trigger
3	2.987	0.021	0.00	0.032	0.043		Set Trigger
4	2.999	0.021	0.00	0.032	0.043		Set Trigger
5	3.062	0.021	0.00	0.032	0.045		Set Trigger

A-3.05

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



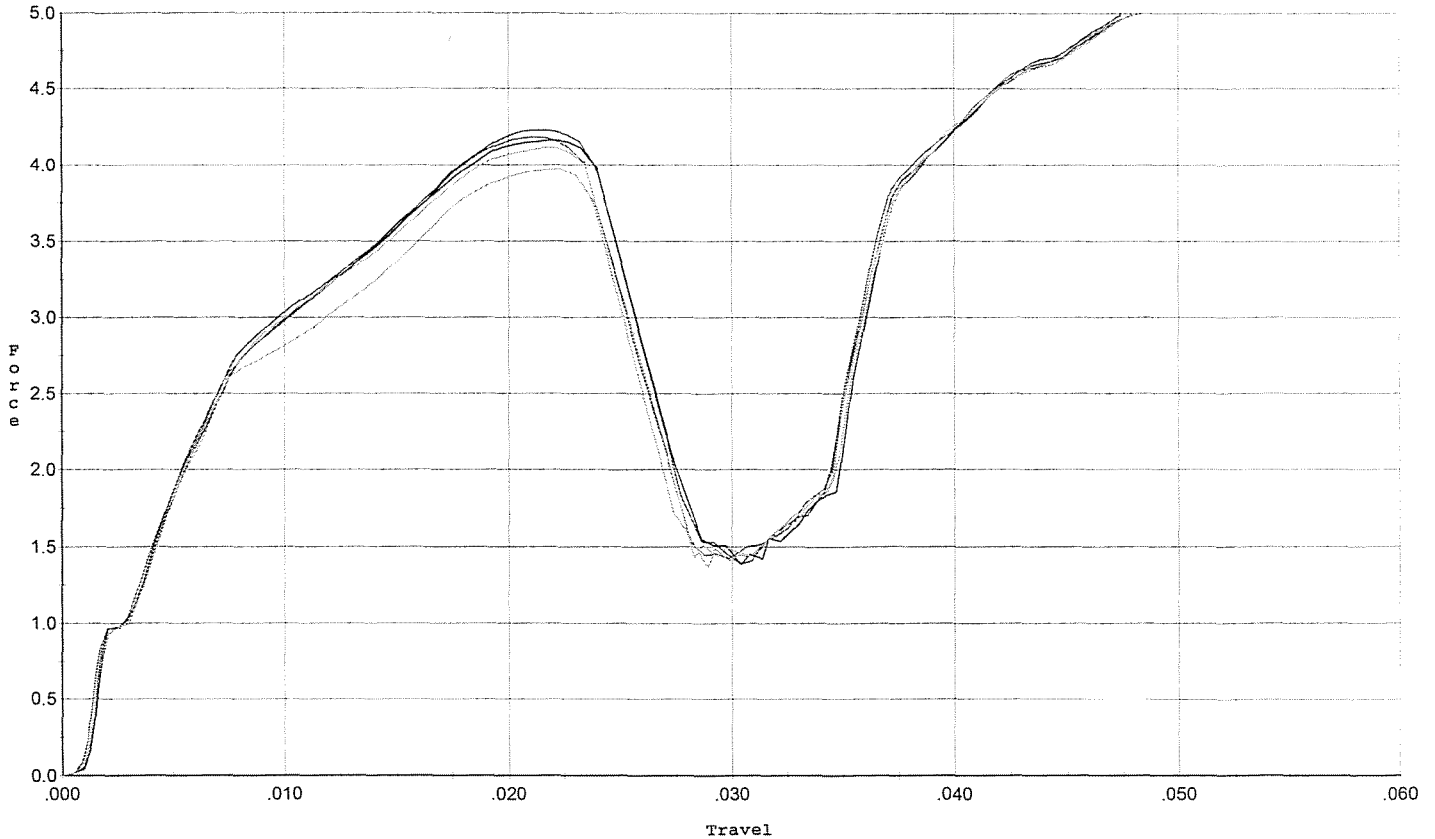
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.192	0.025	0.00	0.028	0.070		Set Trigger
2	4.355	0.023	0.00	0.029	0.066		Set Trigger
3	4.272	0.023	0.00	0.028	0.066		Set Trigger
4	4.417	0.024	0.00	0.028	0.072		Set Trigger
5	4.383	0.023	0.00	0.028	0.068		Set Trigger

AF-4132

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



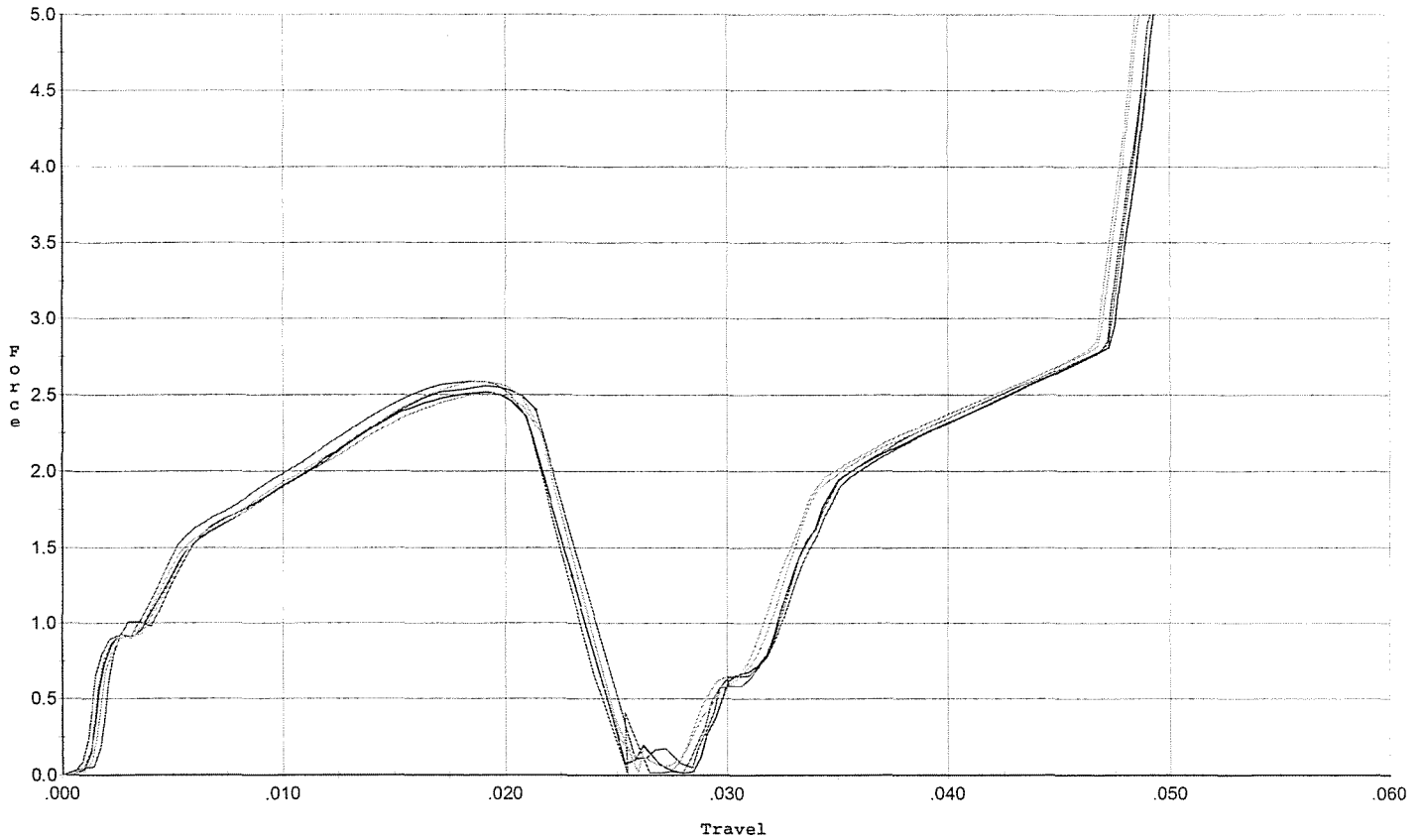
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.226	0.024	0.00	0.024	0.066		Set Trigger
2	4.161	0.024	0.00	0.024	0.065		Set Trigger
3	4.181	0.023	0.00	0.028	0.064		Set Trigger
4	4.115	0.026	0.00	0.026	0.069		Set Trigger
5	3.972	0.024	0.00	0.028	0.062		Set Trigger

A-4-13

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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



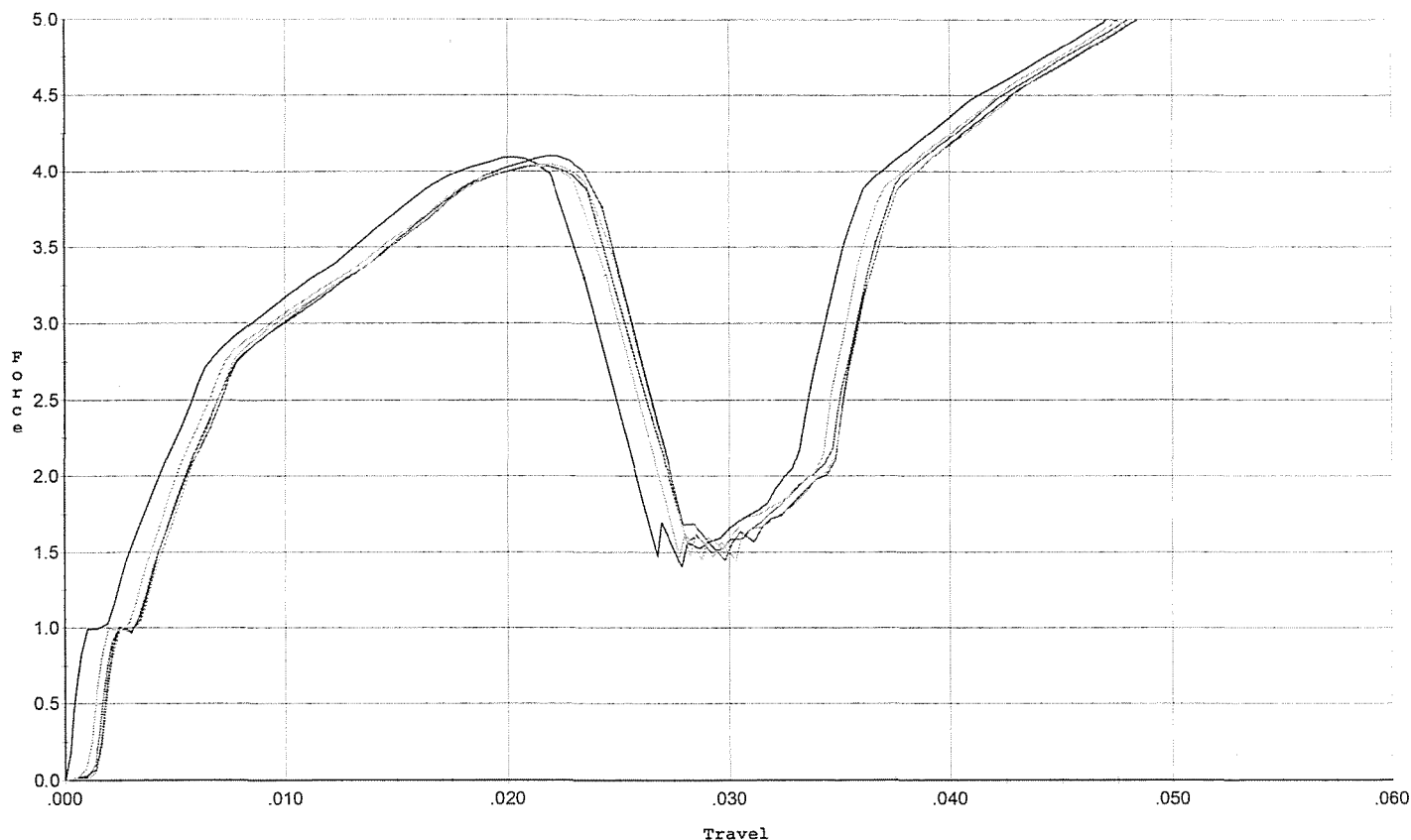
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.559	0.021	0.004	0.032	0.037		Set Trigger
2	2.518	0.023	0.00	0.032	0.039		Set Trigger
3	2.588	0.021	0.00	0.033	0.037		Set Trigger
4	2.586	0.022	0.00	0.032	0.038		Set Trigger
5	2.510	0.022	0.00	0.032	0.037		Set Trigger

A-2-55

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/18/2009

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	4.101	0.024	0.00	0.028	0.066		Set Trigger
2	4.093	0.023	0.00	0.028	0.066		Set Trigger
3	4.037	0.024	0.00	0.028	0.063		Set Trigger
4	4.039	0.024	0.00	0.028	0.067		Set Trigger
5	4.048	0.025	0.00	0.028	0.066		Set Trigger

A-4.06