

66801439

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

- INSTRUCTION BOOK 3518

BM FORM



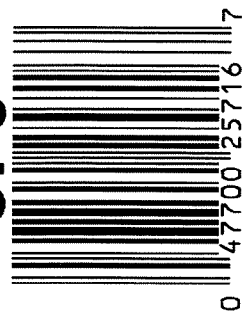
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801439

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801439

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	RT
480	MAGNAFLUX BBL ACTION	(15)	3/9/09	MR
490	MAGNAFLUX BOLT		3/9/09	MR
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TL
540	APPLY COATINGS (BARREL ACTION)		3/18	
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		3-19-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

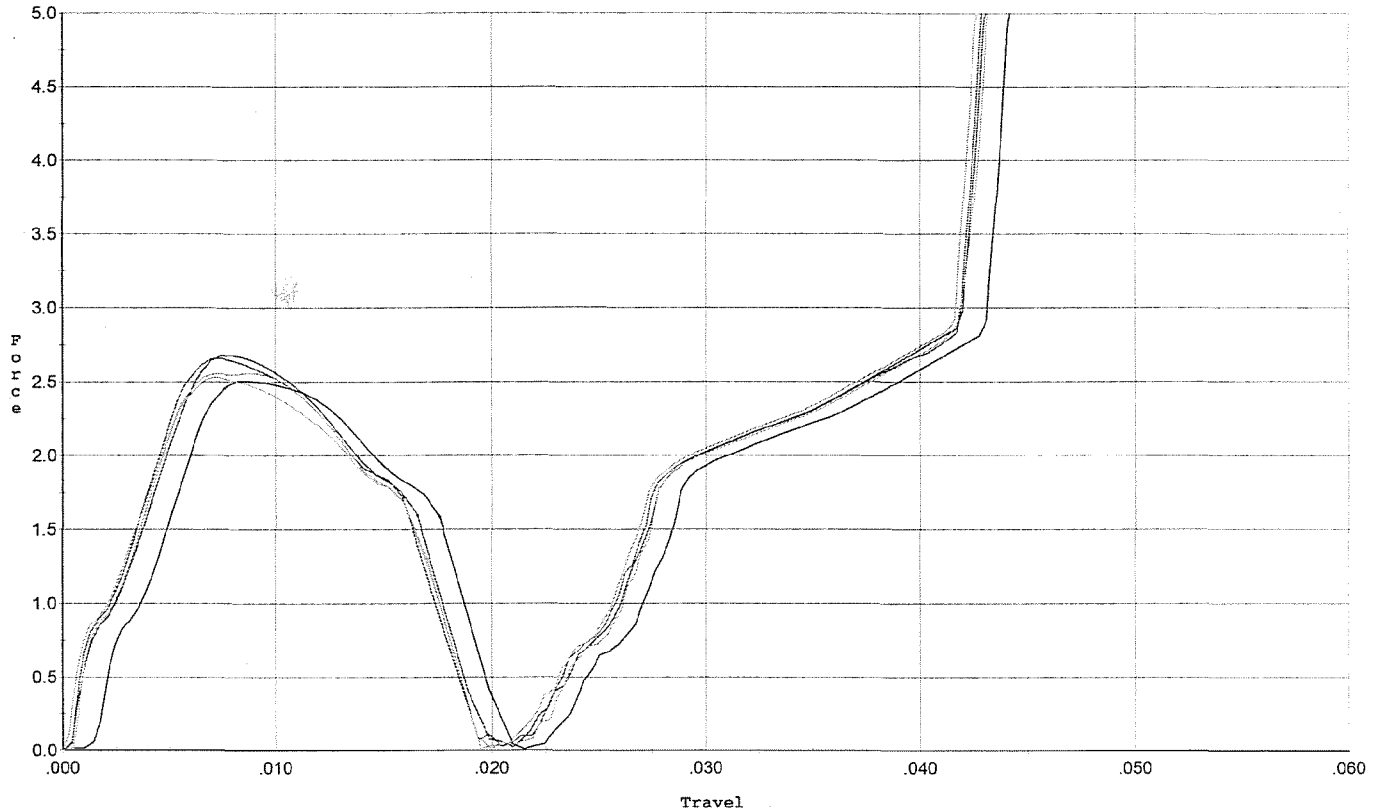
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>4</u>	3-23-09	WZ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-23-09	WZ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	WZ	3-23-09
	J) ASSEMBLE STOCK		3-19-09	RJ
	K) ASSEMBLE SWIVEL STUDS		3-25-09	WZ
	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	3-20-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-20-09	RP
670	FINAL INSPECTION A) HEADSPACE		3/23/09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.42</u> <u>2.38</u> <u>2.47</u> <u>2.37</u>	3-23-09	TL
	C) FUNCTION		3/23/09	WW
690	PACK		3/27/09	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



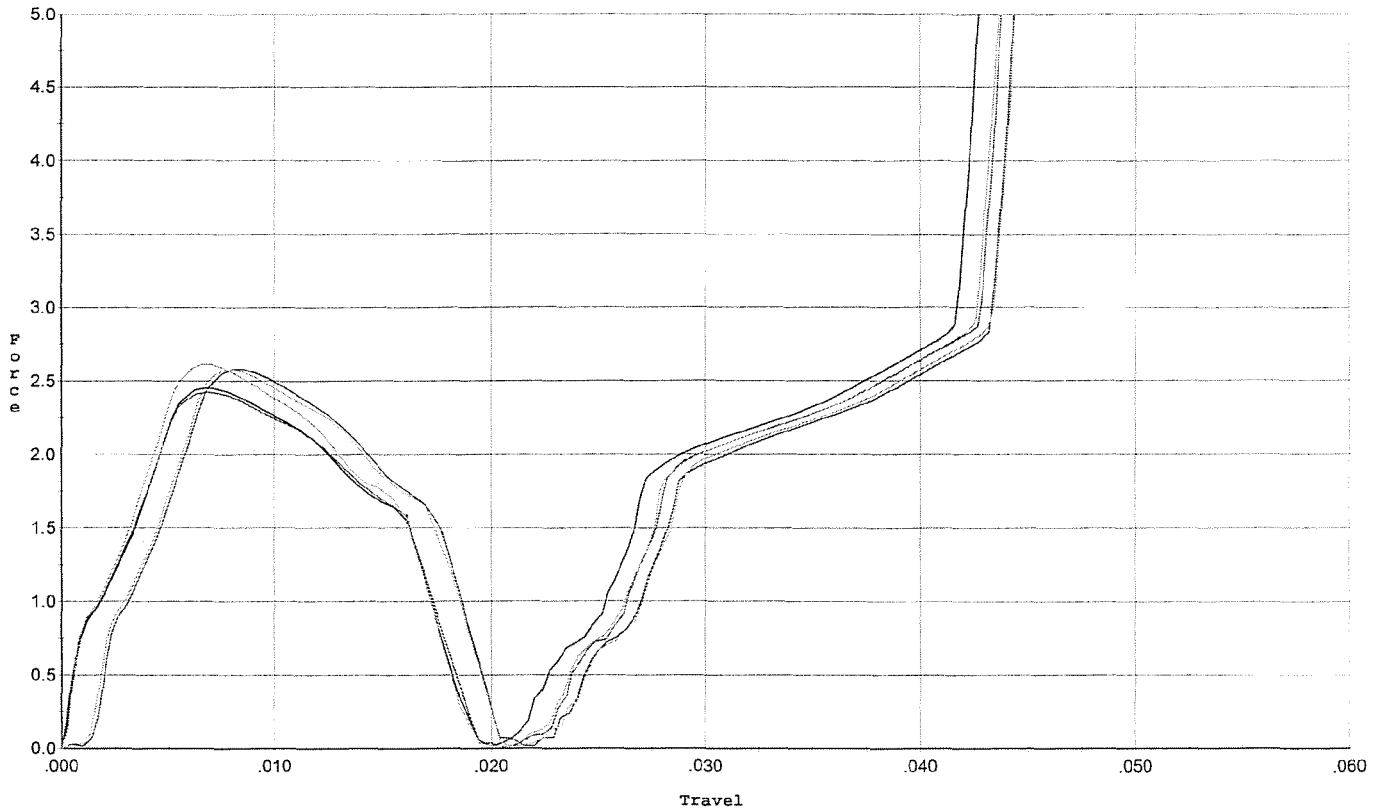
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.681	0.017	0.00	0.031	0.030		Set Trigger
2	2.507	0.018	0.00	0.031	0.029		Set Trigger
3	2.661	0.016	0.00	0.031	0.029		Set Trigger
4	2.531	0.017	0.00	0.031	0.030		Set Trigger
5	2.556	0.017	0.00	0.030	0.031		Set Trigger

A-2.58

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



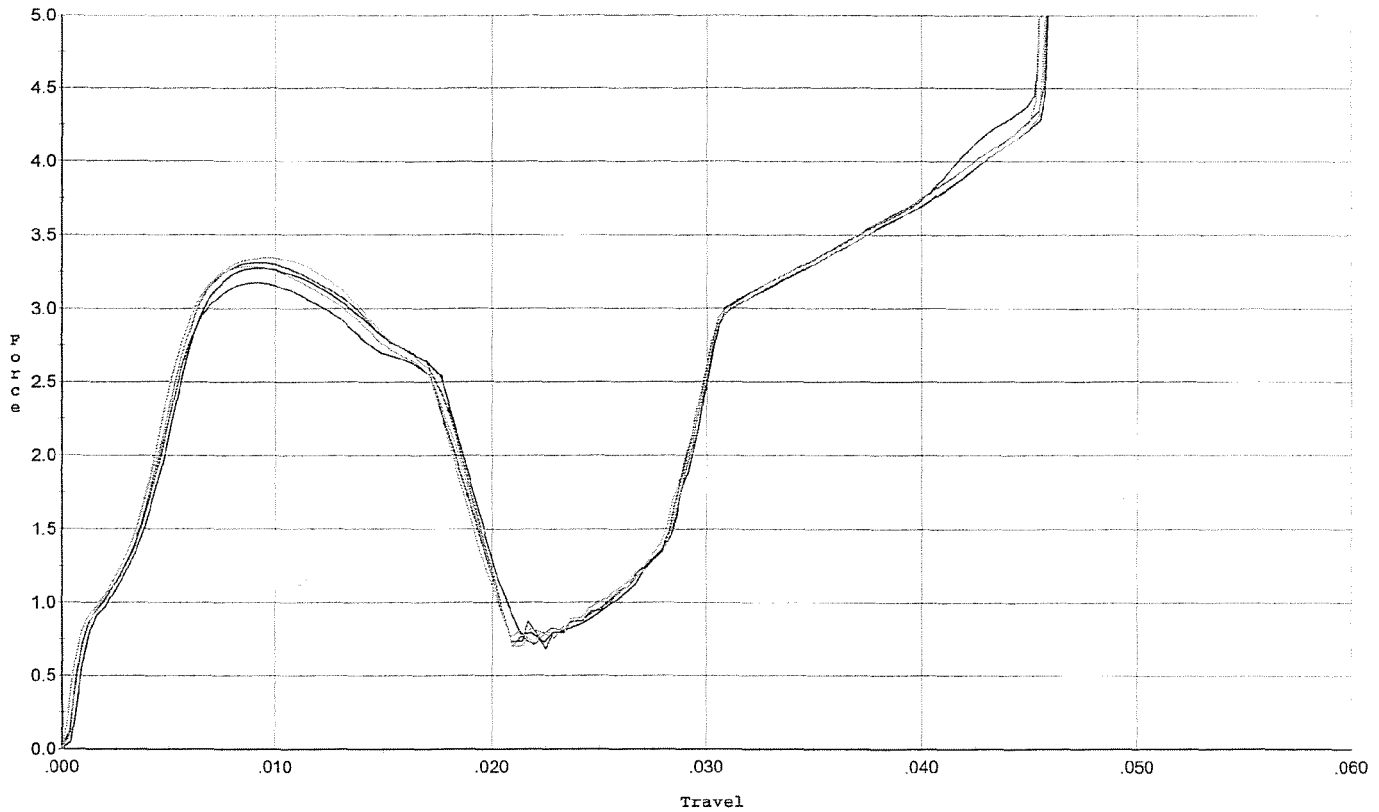
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.579	0.018	0.00	0.031	0.030		Set Trigger
2	2.454	0.016	0.00	0.031	0.028		Set Trigger
3	2.428	0.016	0.00	0.032	0.028		Set Trigger
4	2.580	0.018	0.00	0.031	0.030		Set Trigger
5	2.614	0.016	0.00	0.032	0.029		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: 3.0 lbs ini +/- .75 lb



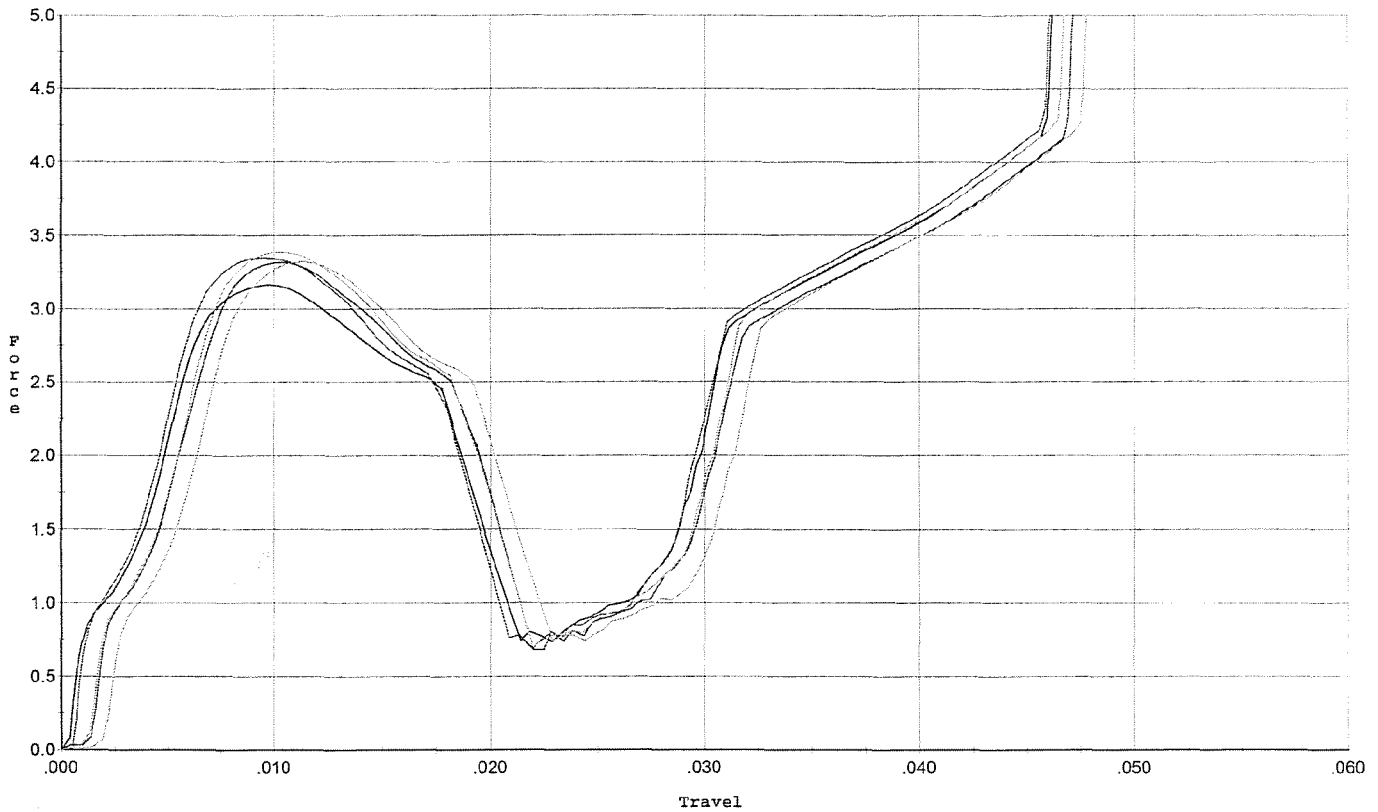
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.176	0.019	0.00	0.030	0.042		Set Trigger
2	3.275	0.018	0.00	0.030	0.040		Set Trigger
3	3.310	0.018	0.00	0.030	0.041		Set Trigger
4	3.346	0.018	0.00	0.030	0.043		Set Trigger
5	3.287	0.017	0.00	0.030	0.039		Set Trigger

A-3-27

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



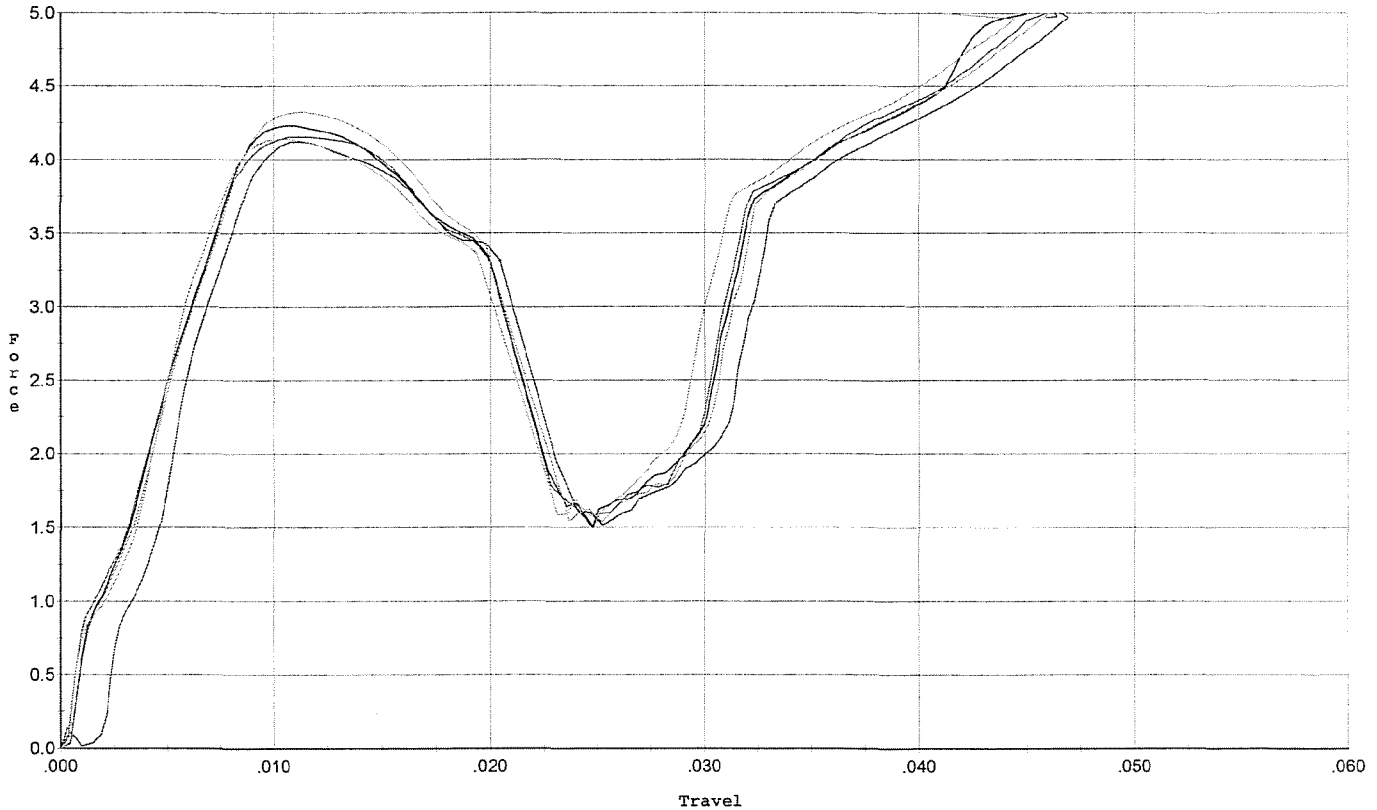
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.317	0.019	0.00	0.031	0.042		Set Trigger
2	3.164	0.018	0.00	0.031	0.039		Set Trigger
3	3.347	0.018	0.00	0.031	0.041		Set Trigger
4	3.385	0.020	0.00	0.031	0.043		Set Trigger
5	3.320	0.019	0.00	0.031	0.040		Set Trigger

A-3-30

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



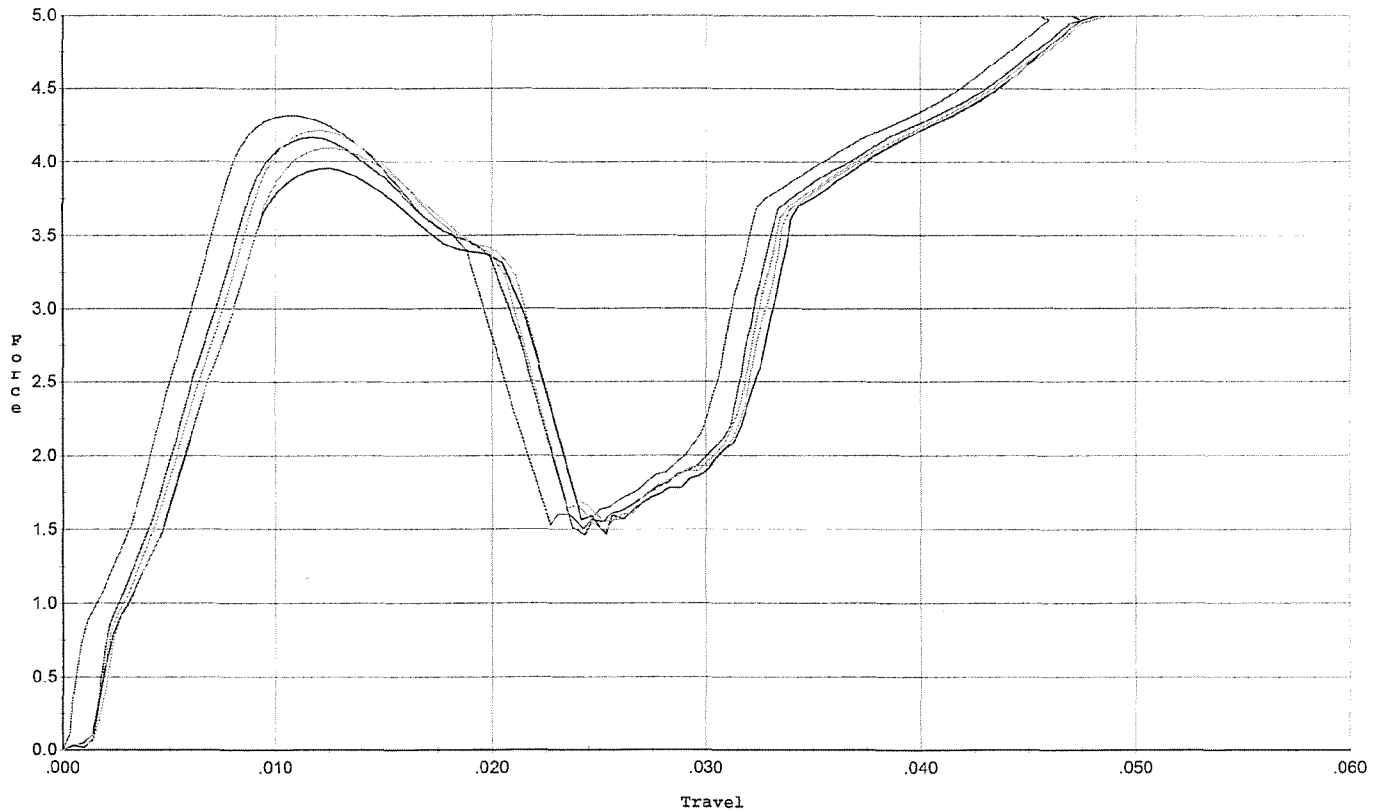
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.122	0.020	0.00	0.029	0.055		Set Trigger
2	4.231	0.020	0.00	0.029	0.057		Set Trigger
3	4.153	0.020	0.00	0.029	0.057		Set Trigger
4	4.139	0.021	0.00	0.028	0.060		Set Trigger
5	4.322	0.020	0.00	0.029	0.057		Set Trigger

A. 4.19

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



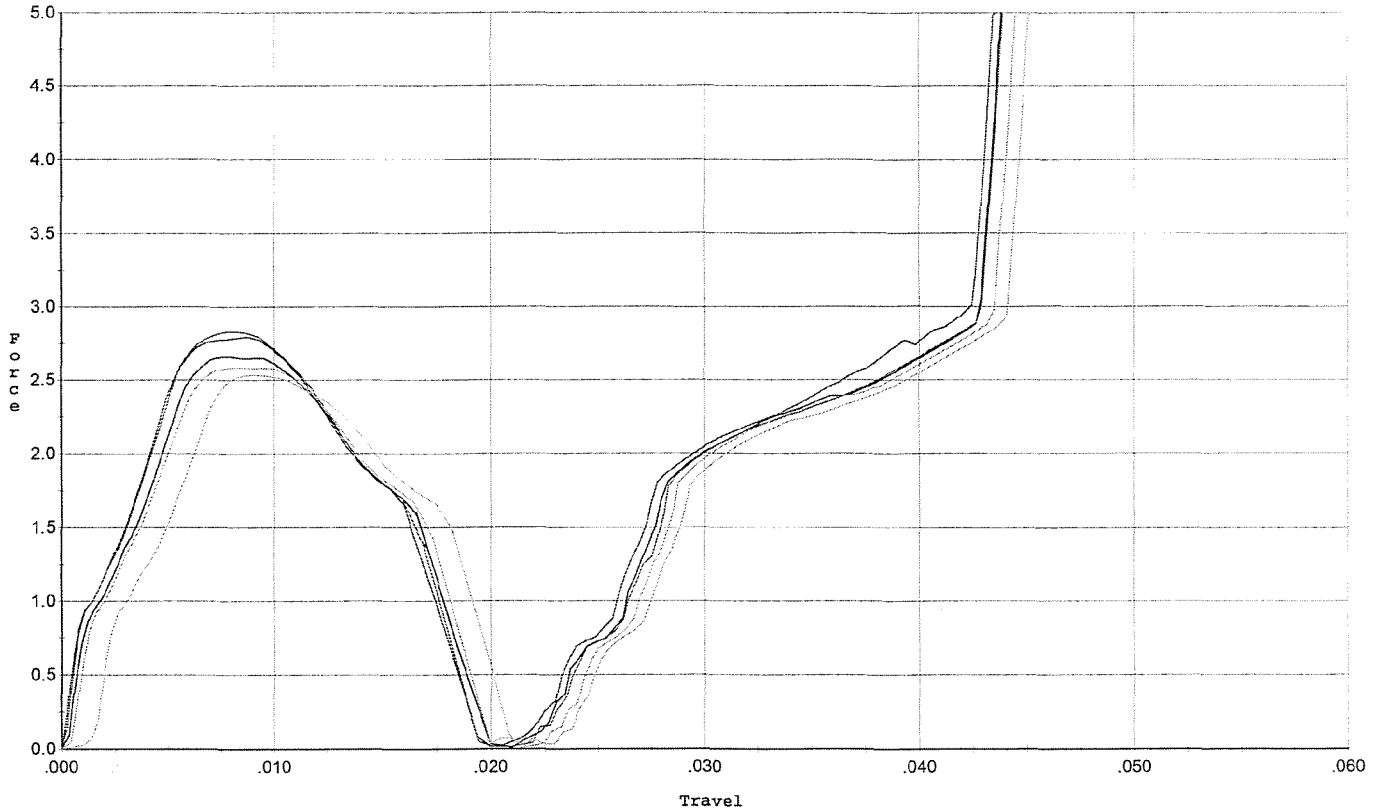
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.164	0.021	0.00	0.029	0.057		Set Trigger
2	3.955	0.022	0.00	0.030	0.055		Set Trigger
3	4.315	0.019	0.00	0.029	0.054		Set Trigger
4	4.213	0.021	0.00	0.030	0.055		Set Trigger
5	4.090	0.021	0.00	0.029	0.055		Set Trigger

A 4.14

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 finl test



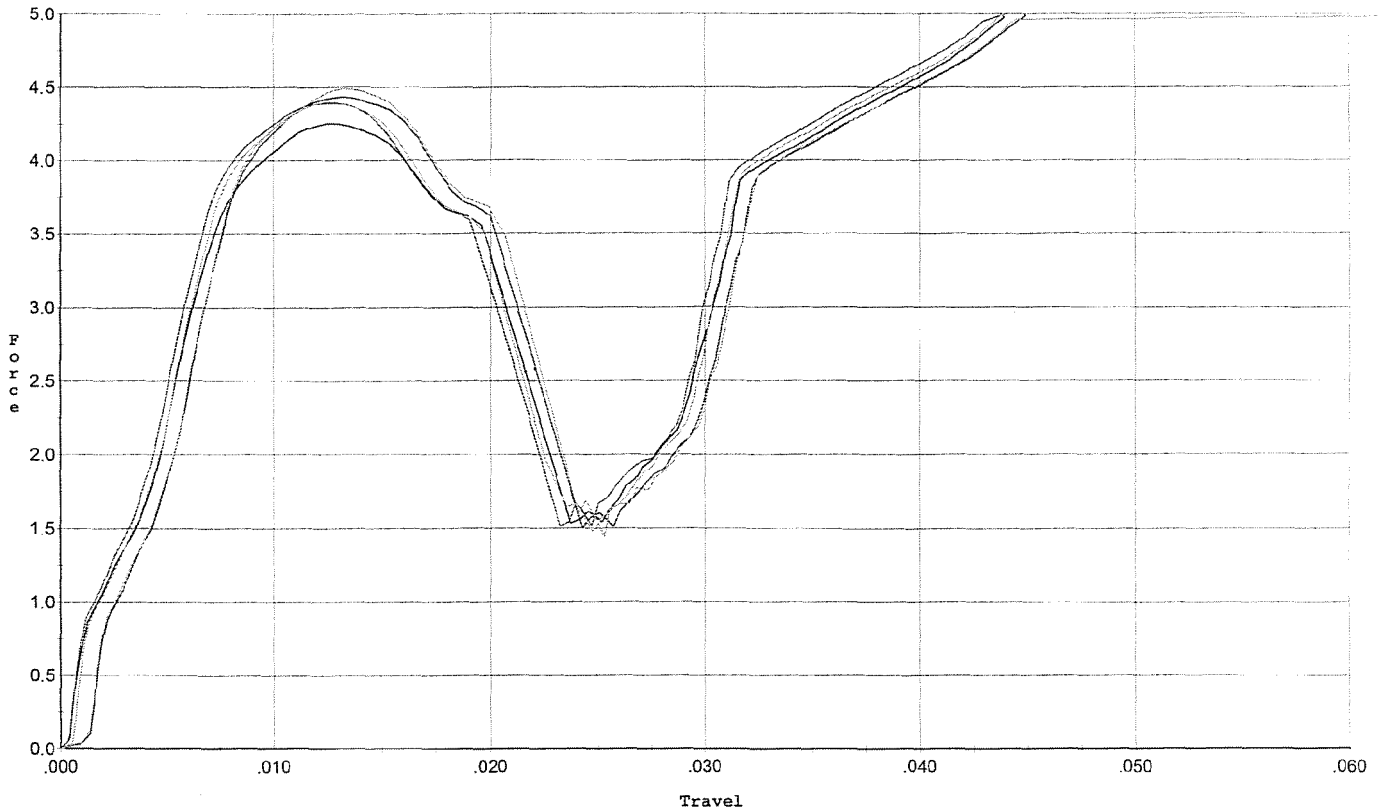
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.794	0.018	0.00	0.031	0.034		Set Trigger
2	2.658	0.017	0.00	0.031	0.030		Set Trigger
3	2.831	0.017	0.00	0.031	0.033		Set Trigger
4	2.535	0.018	0.00	0.031	0.030		Set Trigger
5	2.584	0.017	0.00	0.032	0.031		Set Trigger

A-2-68

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	4.434	0.022	0.00	0.028	0.063		Set Trigger
2	4.253	0.022	0.00	0.028	0.062		Set Trigger
3	4.391	0.021	0.00	0.028	0.062		Set Trigger
4	4.401	0.020	0.00	0.028	0.058		Set Trigger
5	4.489	0.021	0.00	0.028	0.060		Set Trigger

A-4.39