

G680 1455

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

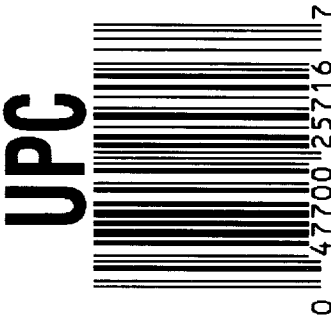
- INSTUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801455



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801455

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	OPERATOR 	3/9/09	
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		3-21-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

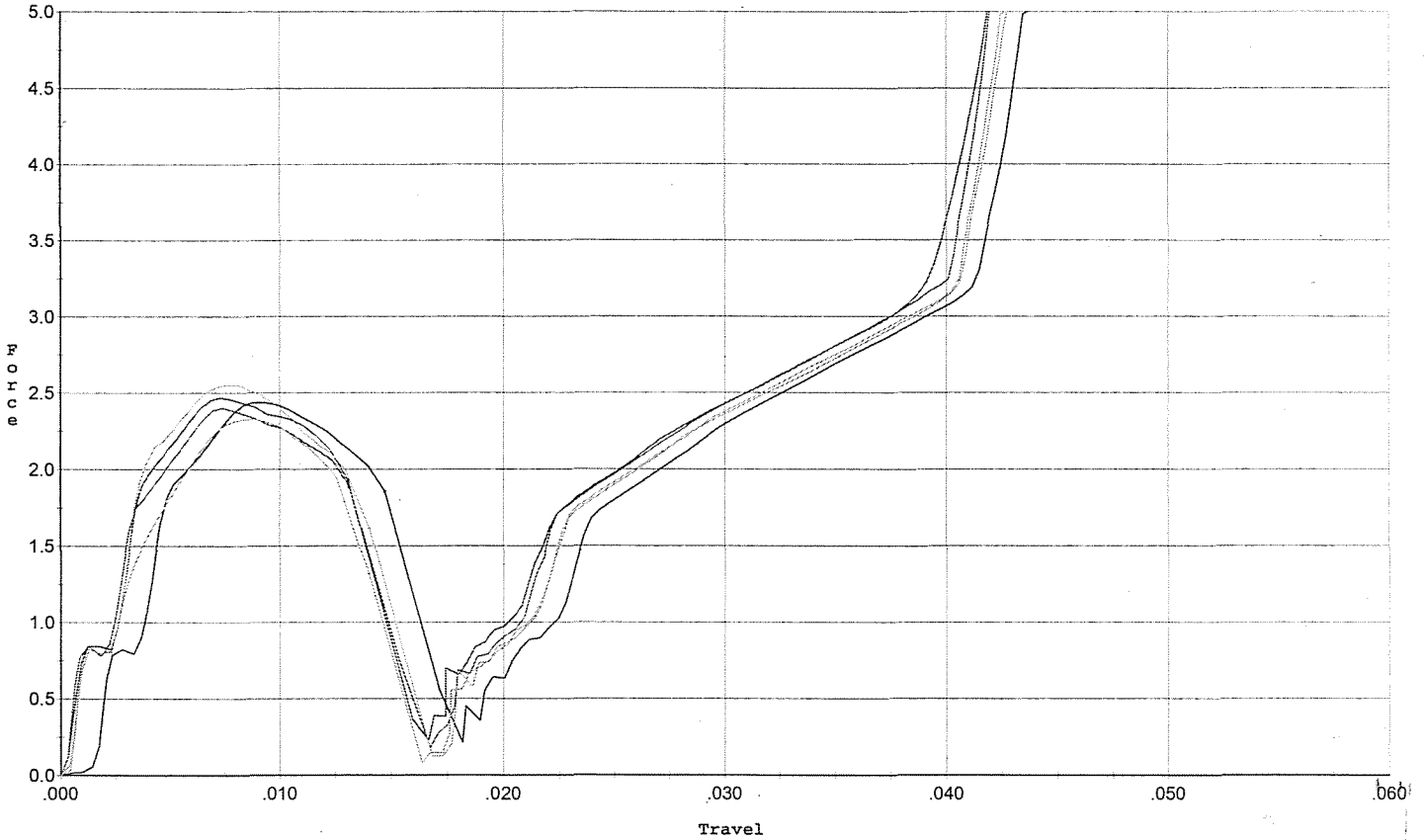
F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.4</u> <u>2.2</u> <u>2.4</u>	<u>3/23/09</u>	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	<u>3/23/09</u>	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	<u>3/23/09</u>	RP
	J) ASSEMBLE STOCK		<u>3/21/09</u>	TL
	K) ASSEMBLE SWIVEL STUDS		<u>3/23/09</u>	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	<u>3-23-09</u>	TL
	MALFUNCTION	CORRECTION	n/a	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>3-23-09</u>	n/a
670	FINAL INSPECTION A) HEADSPACE		<u>3/23/09</u>	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.81</u> <u>2.79</u> <u>2.87</u> <u>2.83</u> <u>2.83</u>	<u>3-23-09</u>	TL
	C) FUNCTION		<u>3/23/09</u>	RP
690	PACK		<u>3/23/09</u>	FM

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



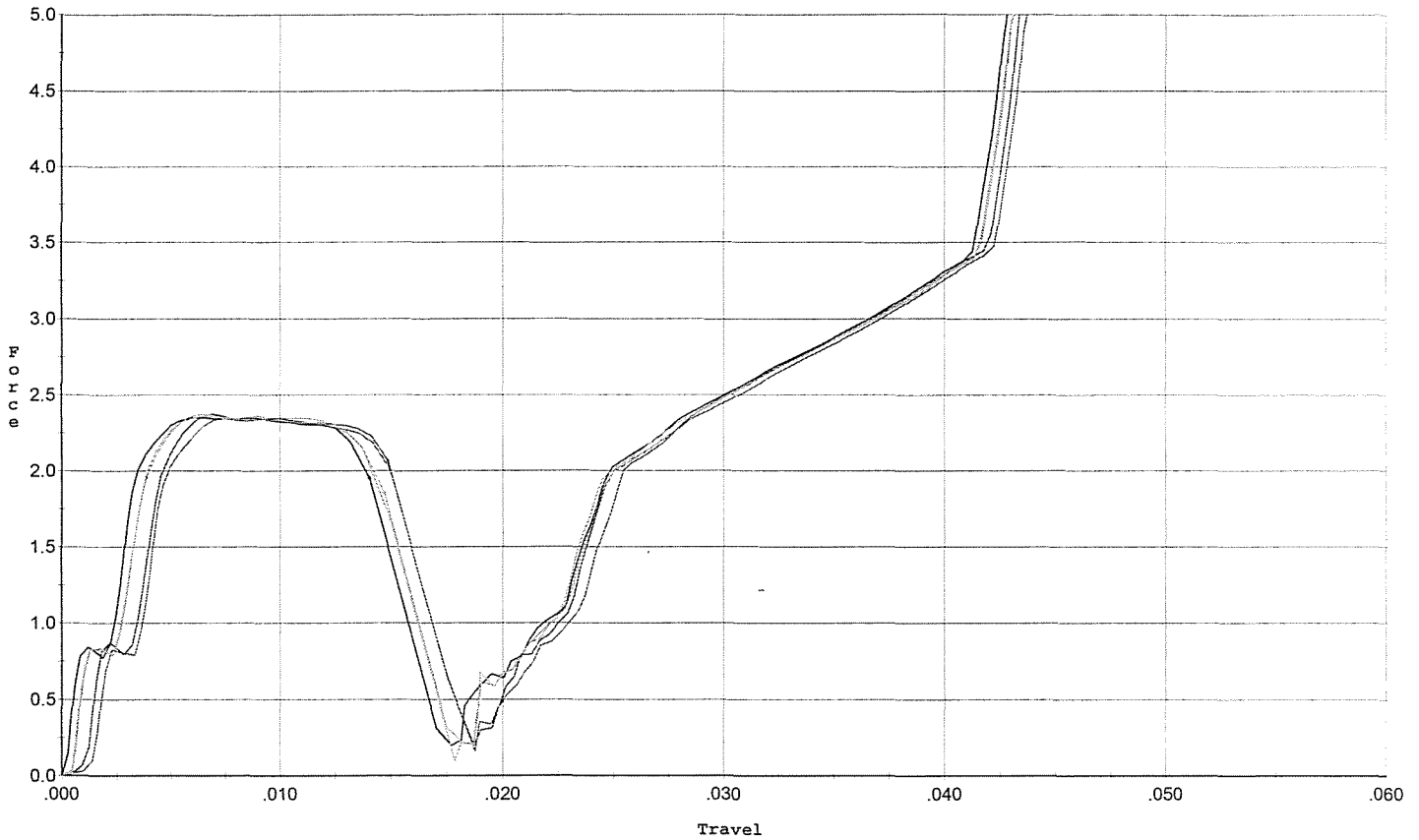
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.465	0.013	0.003	0.032	0.023		Set Trigger
2	2.439	0.015	0.00	0.032	0.023		Set Trigger
3	2.398	0.013	0.00	0.032	0.022		Set Trigger
4	2.552	0.014	0.00	0.032	0.025		Set Trigger
5	2.327	0.014	0.00	0.033	0.022		Set Trigger

A-2-43

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



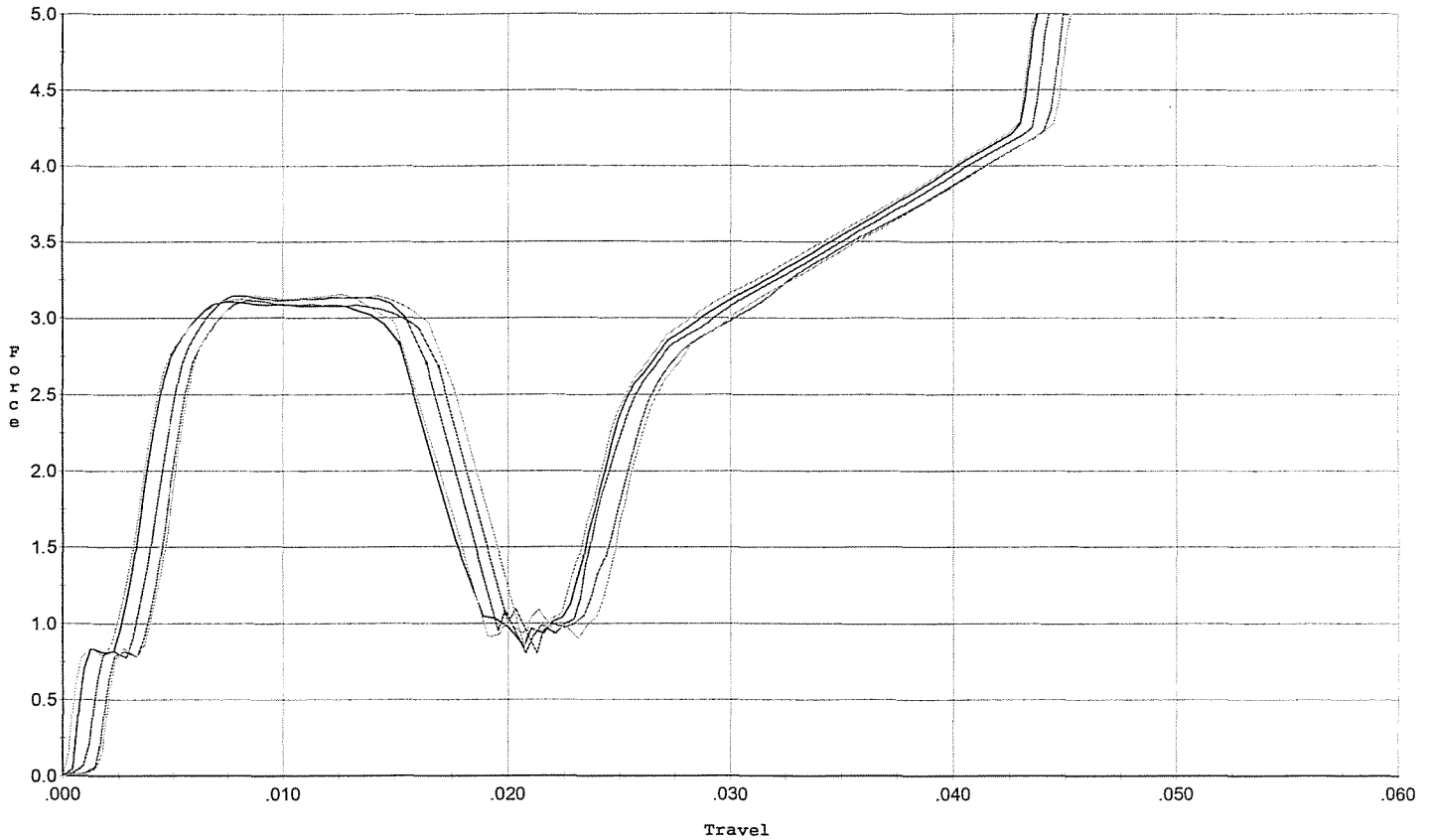
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.374	0.015	0.00	0.032	0.025		Set Trigger
2	2.350	0.014	0.00	0.032	0.025		Set Trigger
3	2.343	0.015	0.004	0.032	0.025		Set Trigger
4	2.358	0.015	0.00	0.032	0.026		Set Trigger
5	2.373	0.015	0.003	0.032	0.026		Set Trigger

A-2-36

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



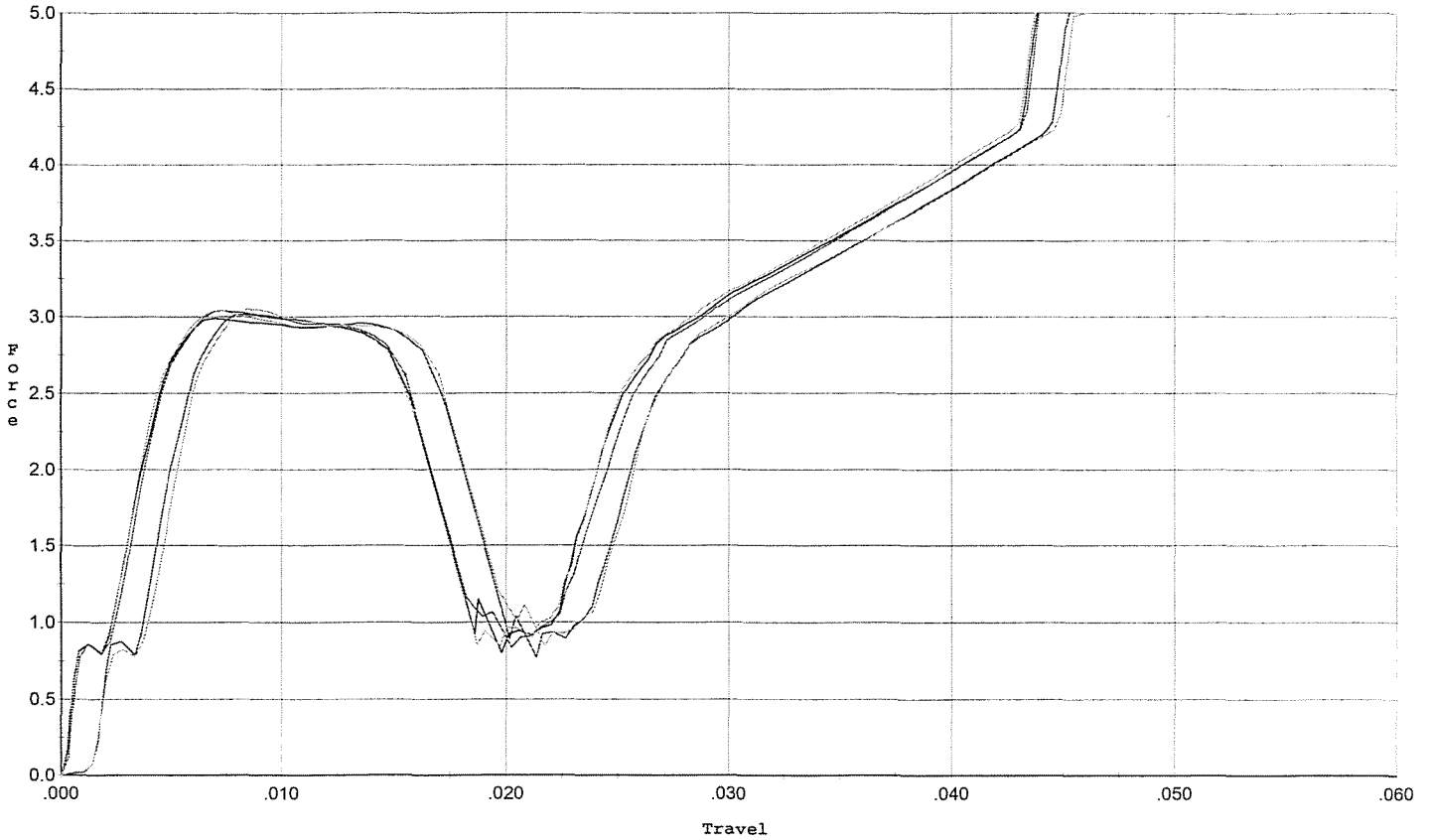
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.145	0.016	0.00	0.029	0.036		Set Trigger
2	3.104	0.015	0.00	0.030	0.034		Set Trigger
3	3.114	0.017	0.00	0.030	0.036		Set Trigger
4	3.155	0.017	0.00	0.029	0.039		Set Trigger
5	3.147	0.018	0.00	0.029	0.038		Set Trigger

A 3.13

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



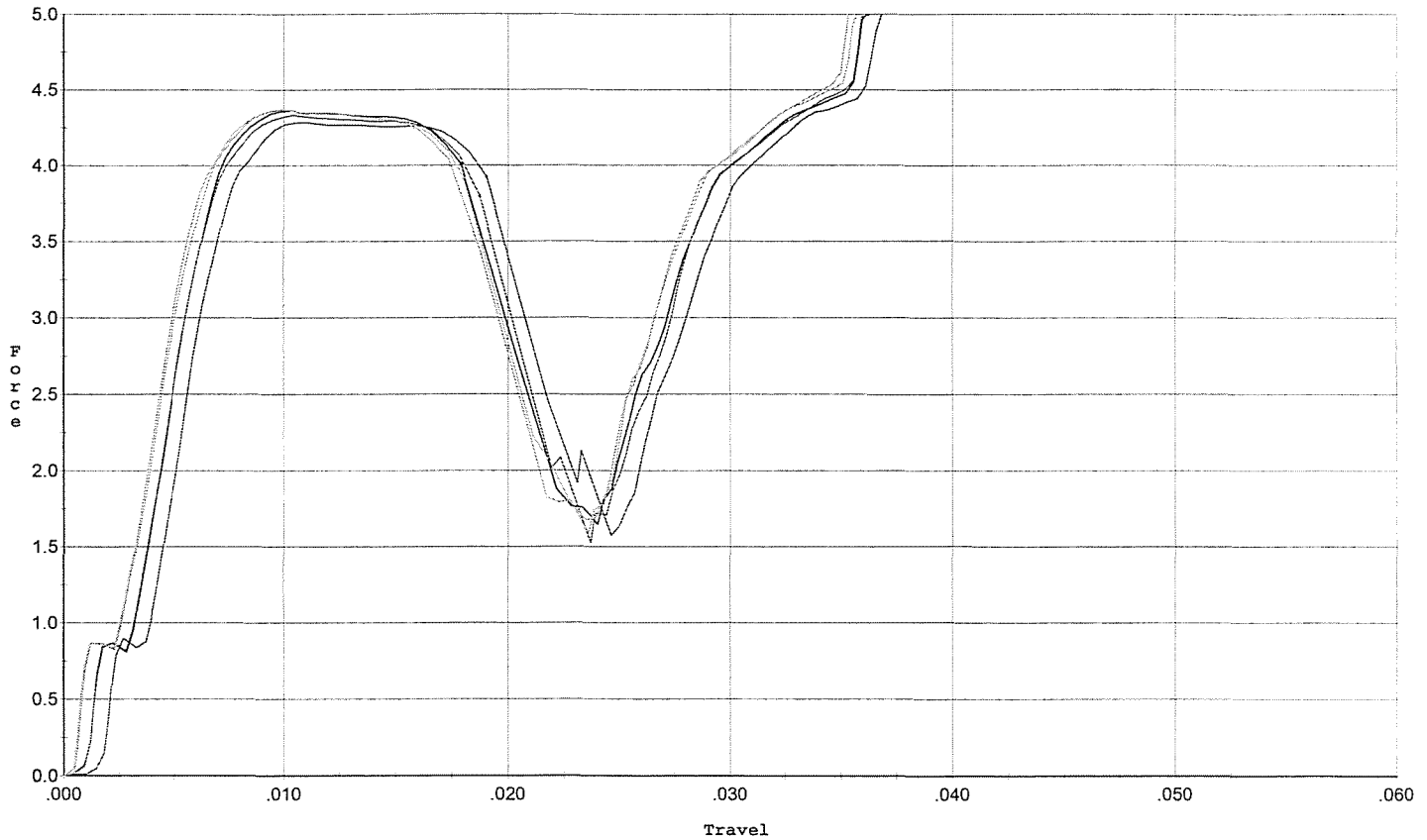
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.016	0.017	0.00	0.030	0.036		Set Trigger
2	2.988	0.016	0.00	0.030	0.035		Set Trigger
3	3.042	0.016	0.00	0.030	0.034		Set Trigger
4	3.042	0.016	0.00	0.030	0.035		Set Trigger
5	3.049	0.017	0.00	0.030	0.035		Set Trigger

A-3.02

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



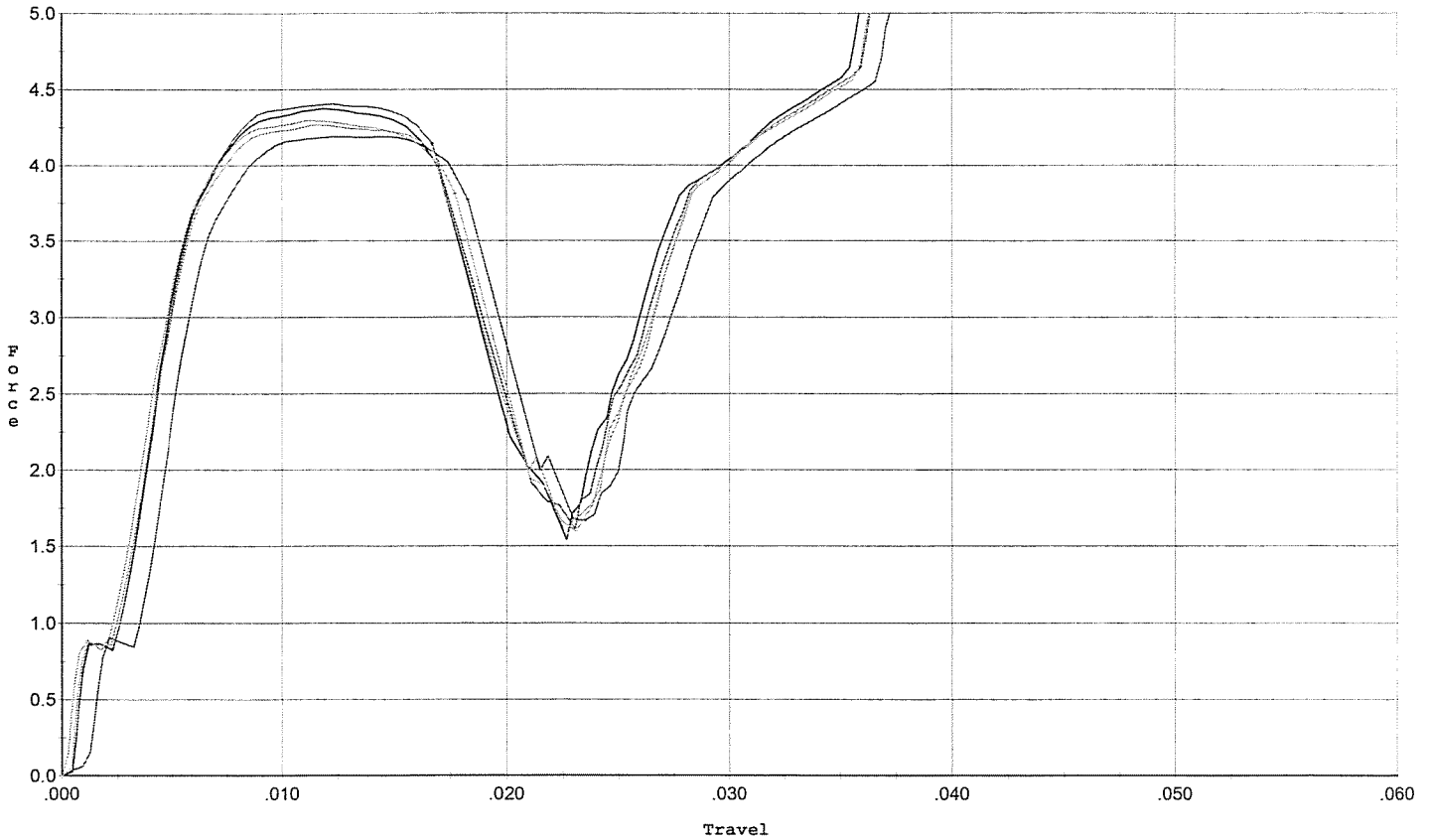
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.285	0.019	0.00	0.016	0.055		Set Trigger
2	4.356	0.018	0.00	0.015	0.053		Set Trigger
3	4.334	0.019	0.00	0.015	0.056		Set Trigger
4	4.368	0.018	0.003	0.015	0.055		Set Trigger
5	4.364	0.019	0.003	0.015	0.058		Set Trigger

A-4.34

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



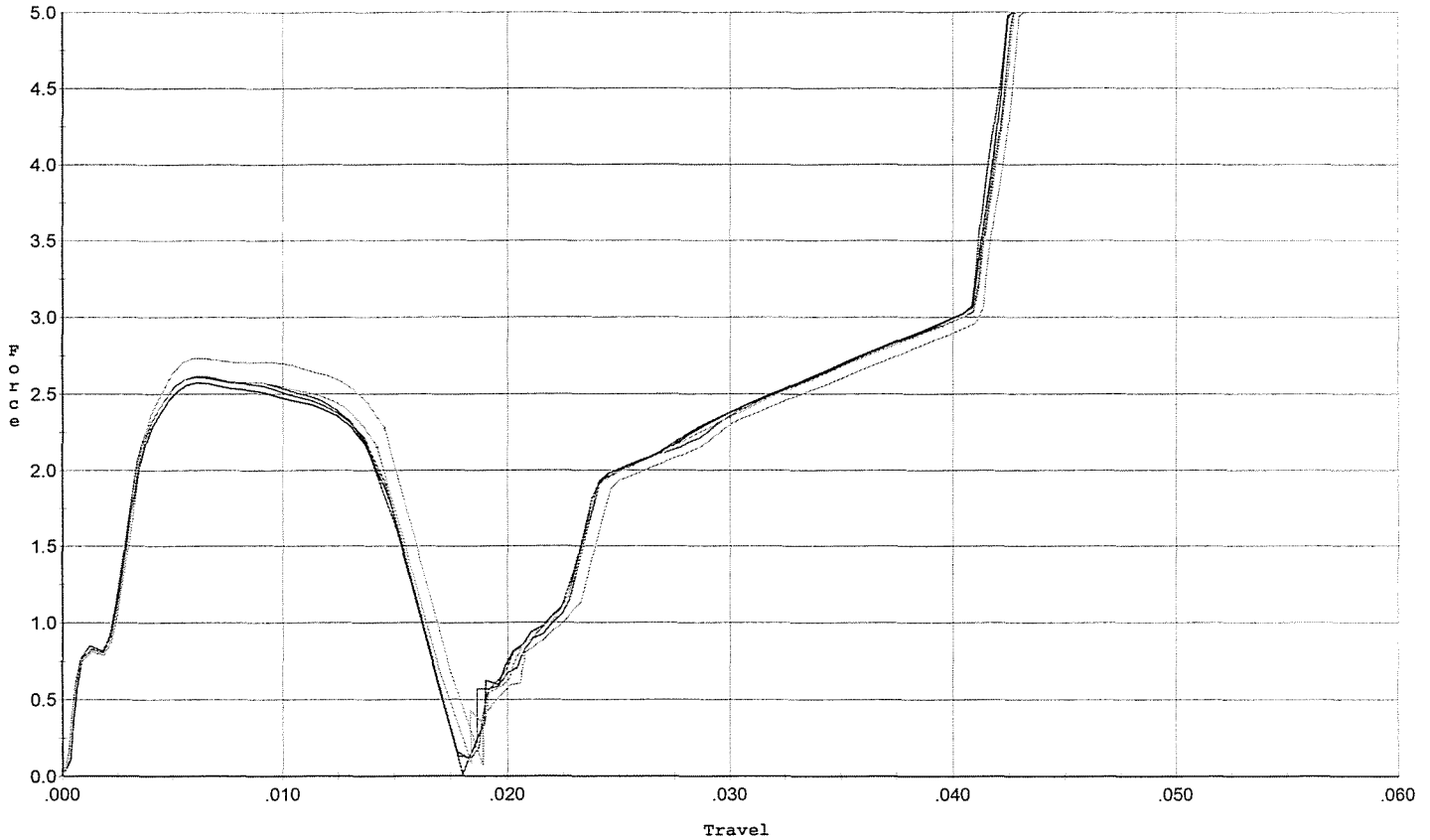
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.190	0.018	0.003	0.017	0.052		Set Trigger
2	4.375	0.017	0.003	0.017	0.051		Set Trigger
3	4.405	0.017	0.00	0.019	0.051		Set Trigger
4	4.293	0.017	0.00	0.020	0.051		Set Trigger
5	4.269	0.018	0.00	0.017	0.053		Set Trigger

A-430

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



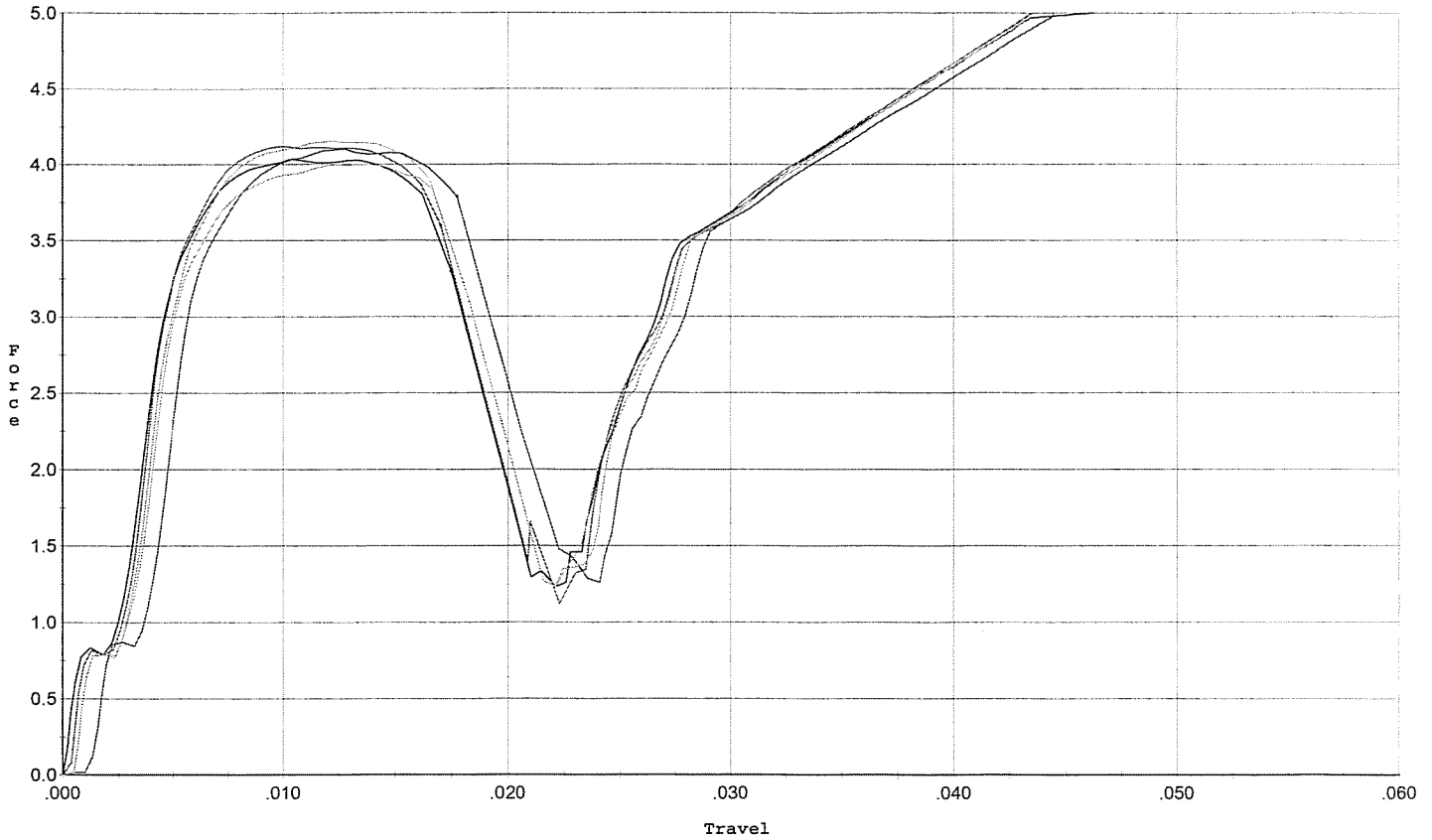
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.615	0.015	0.00	0.031	0.029		Set Trigger
2	2.574	0.015	0.00	0.031	0.028		Set Trigger
3	2.609	0.015	0.00	0.032	0.028		Set Trigger
4	2.619	0.014	0.00	0.032	0.028		Set Trigger
5	2.732	0.015	0.00	0.031	0.030		Set Trigger

A-2.63

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 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	0.018	0.00	0.027	0.049		Set Trigger
2	4.034	0.017	0.00	0.027	0.050		Set Trigger
3	4.117	0.017	0.00	0.027	0.049		Set Trigger
4	4.000	0.018	0.00	0.027	0.051		Set Trigger
5	4.155	0.018	0.00	0.027	0.052		Set Trigger

A-4.08