

6680 1470

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

- INSTRUCTION BOOK 3518

BM FORM

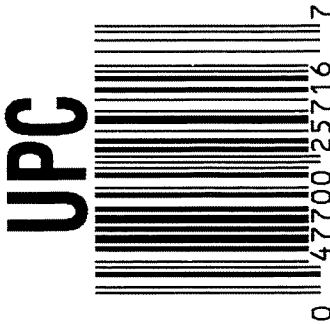


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6801470



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6801470

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	RPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	RPD
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	RT
480	MAGNAFLUX BBL ACTION	(FD)	3/9/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TZ
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-27-09	RPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

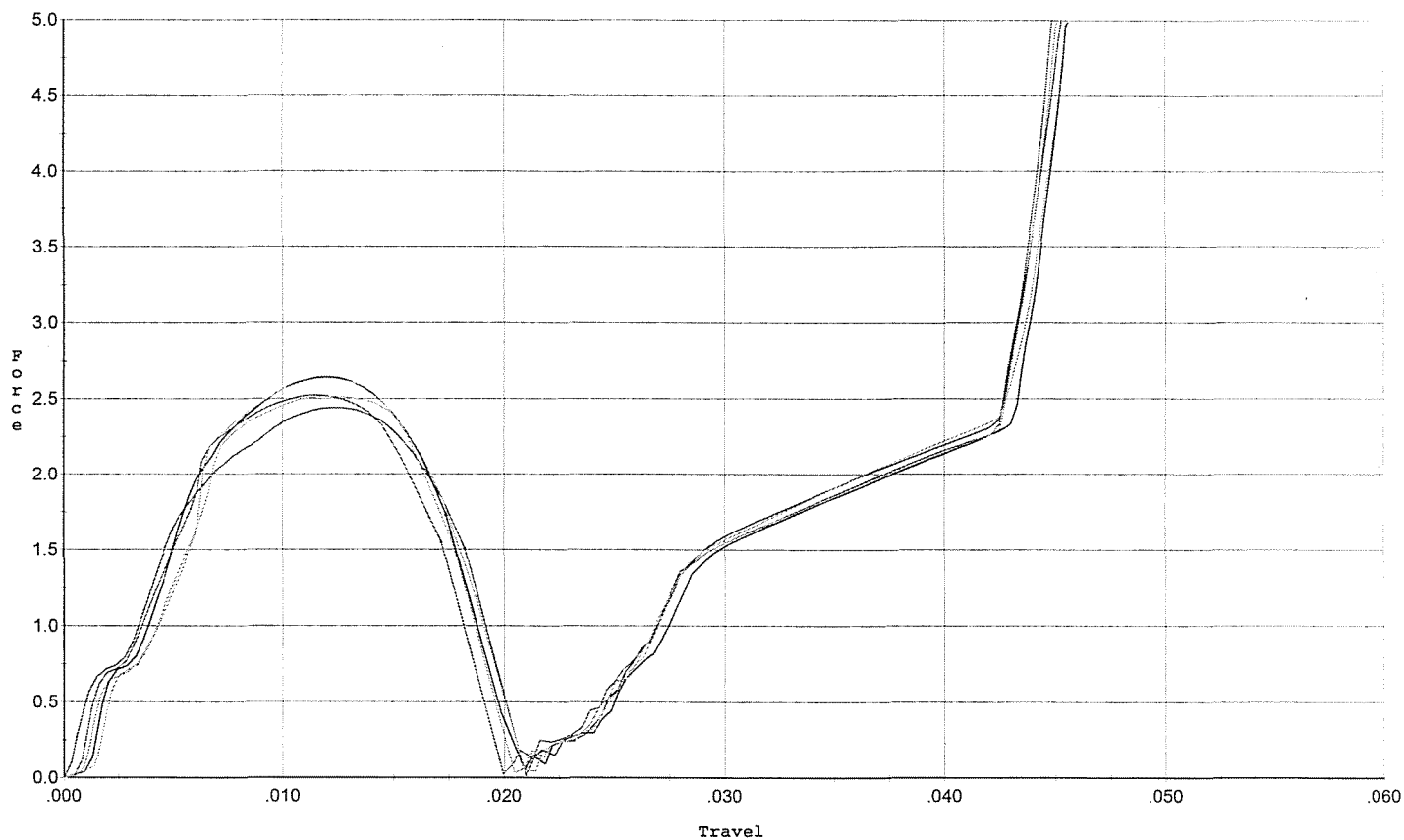
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4</u> <u>4</u> <u>5.5</u>	3-31-09	W W
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-31-09	W W
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	3-31-09	W W
	J) ASSEMBLE STOCK			3-27-09	RP
	K) ASSEMBLE SWIVEL STUDS			3-31-09	W W
	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	3-30-09	RP
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			3-30-09	RP
670	FINAL INSPECTION A) HEADSPACE			3-31-09	W W
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.23</u> <u>2.30</u> <u>2.32</u> <u>2.47</u> <u>2.39</u>	3-31-09	W W
	C) FUNCTION			3-31-09	W W
690	PACK			5-08-09	W W

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



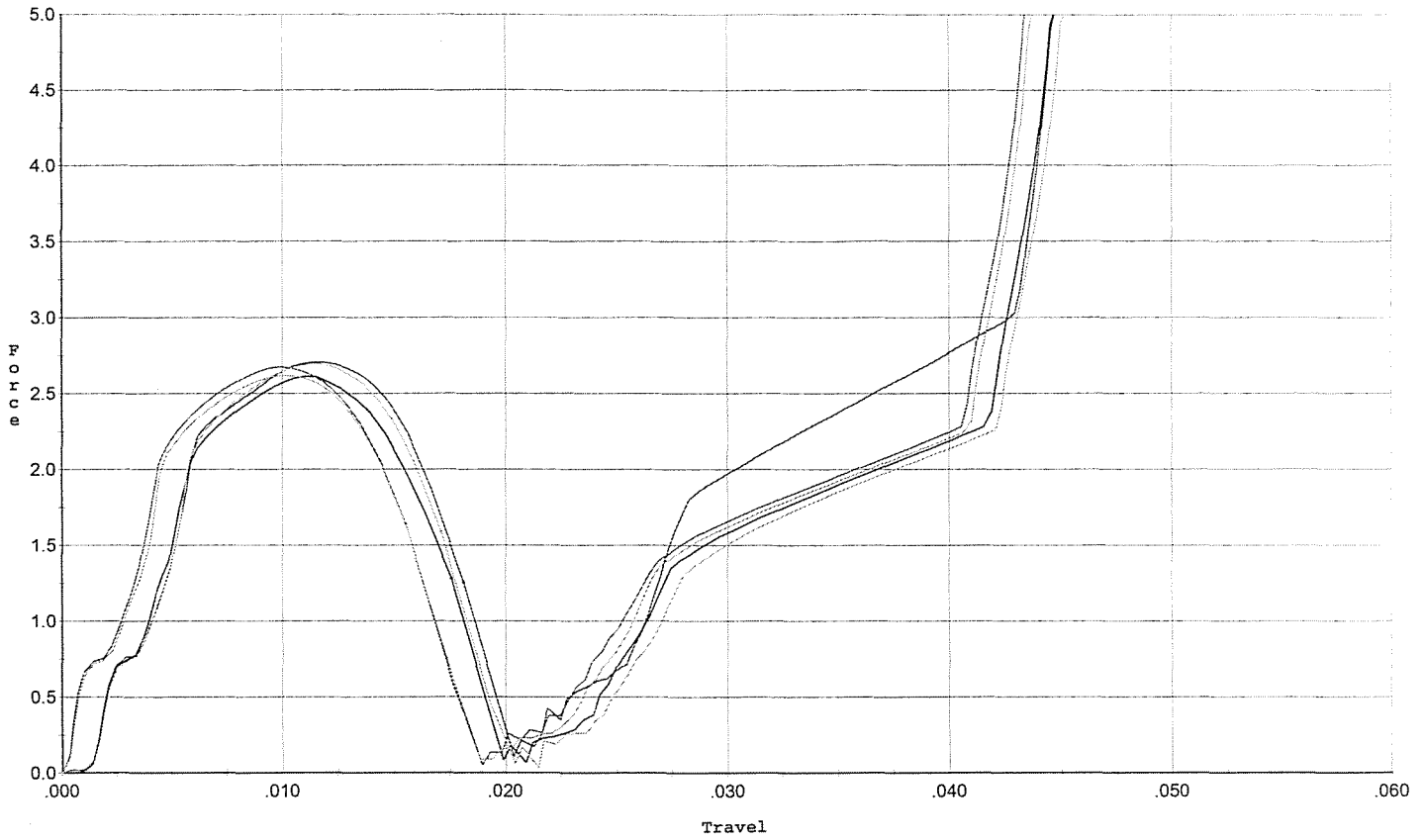
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.439	0.018	0.00	0.032	0.031		Set Trigger
2	2.641	0.017	0.00	0.033	0.030		Set Trigger
3	2.523	0.017	0.00	0.032	0.029		Set Trigger
4	2.515	0.019	0.00	0.032	0.031		Set Trigger
5	2.636	0.018	0.00	0.032	0.030		Set Trigger

1A-2.44

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/27/2009

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



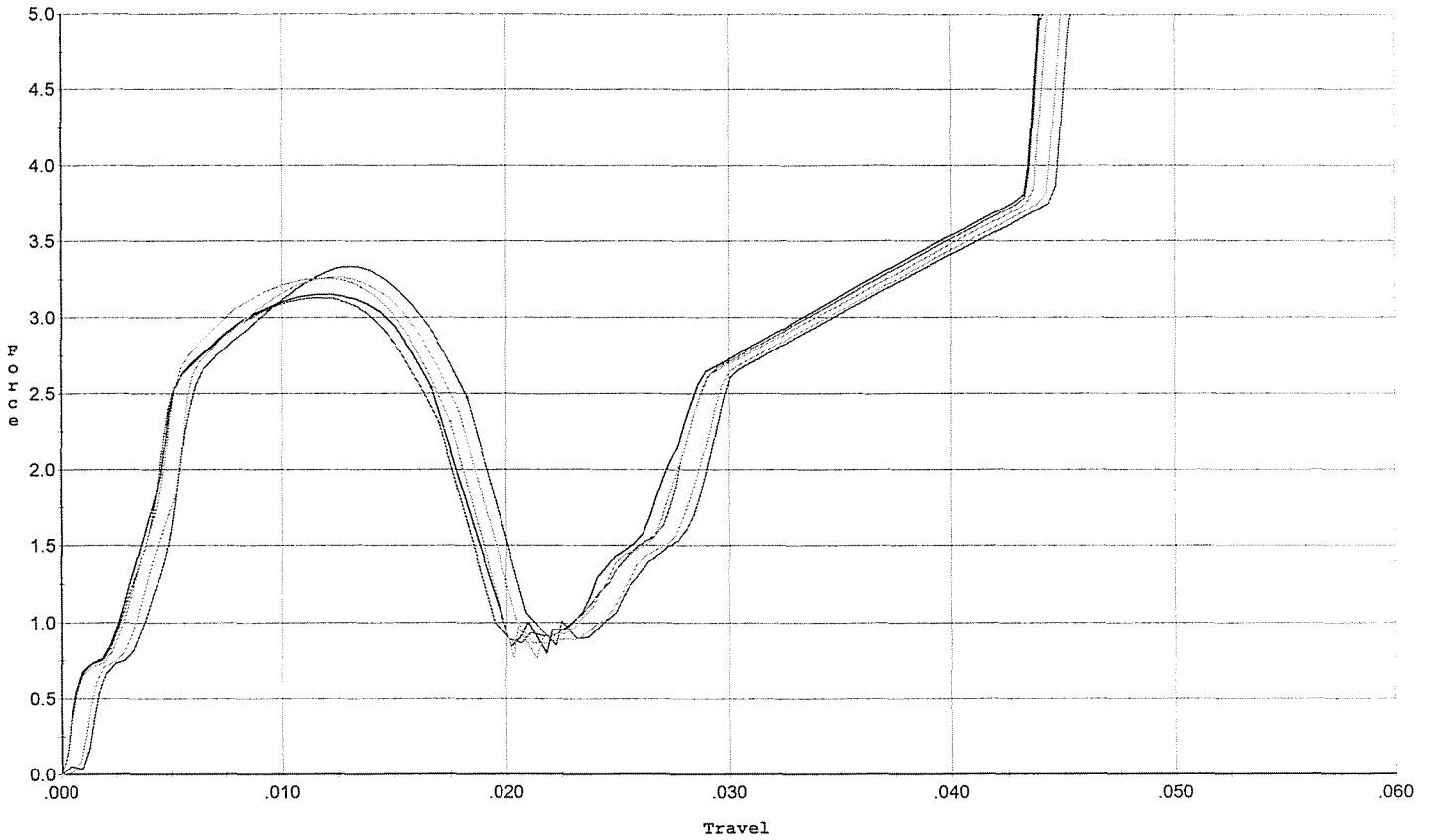
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.706	0.018	0.00	0.031	0.032		Set Trigger
2	2.613	0.018	0.00	0.032	0.029		Set Trigger
3	2.675	0.015	0.00	0.032	0.029		Set Trigger
4	2.698	0.017	0.00	0.033	0.030		Set Trigger
5	2.618	0.016	0.00	0.033	0.028		Set Trigger

A-2.66

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



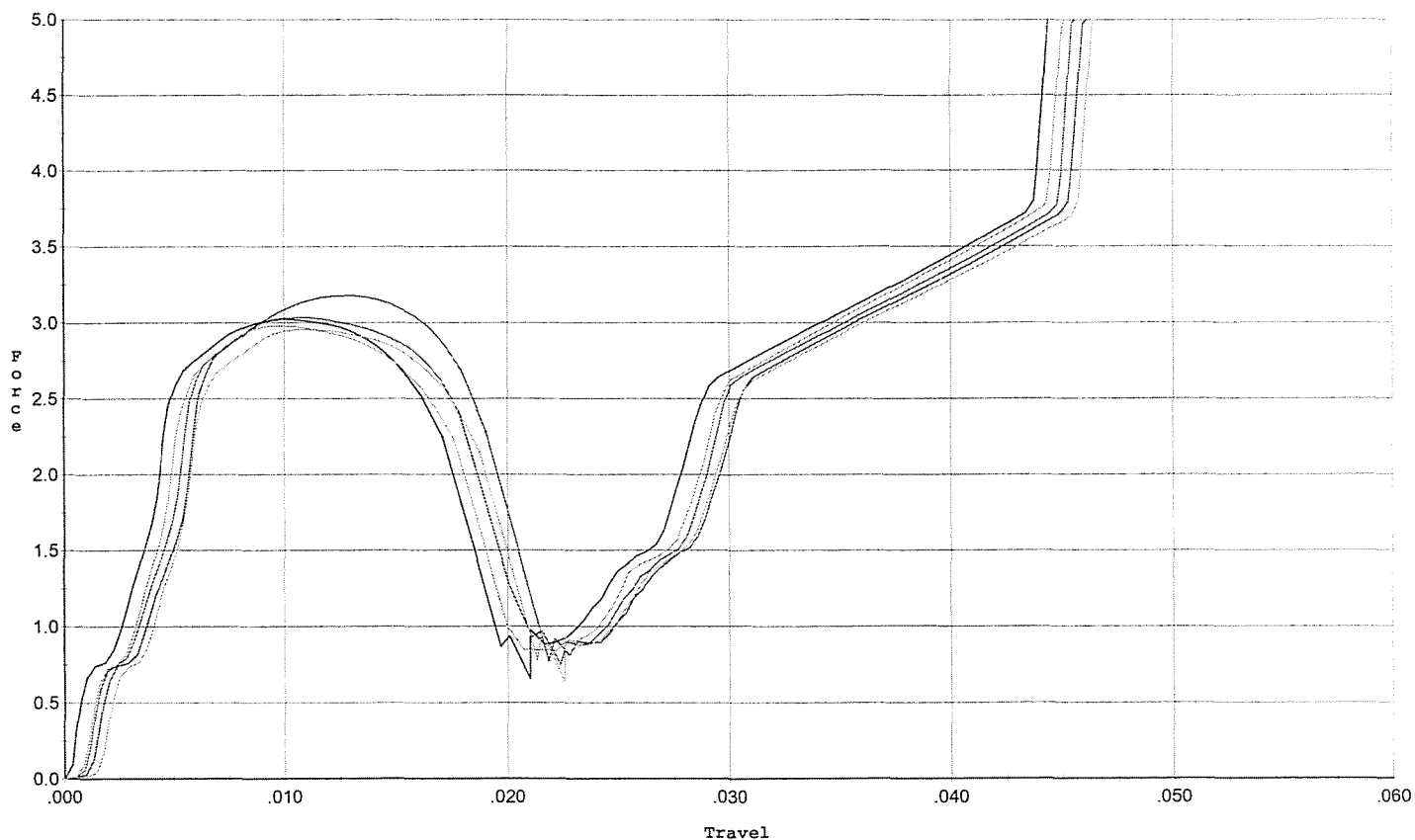
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.336	0.018	0.00	0.029	0.040		Set Trigger
2	3.153	0.017	0.00	0.029	0.037		Set Trigger
3	3.128	0.017	0.00	0.029	0.037		Set Trigger
4	3.266	0.018	0.00	0.030	0.039		Set Trigger
5	3.256	0.017	0.00	0.029	0.039		Set Trigger

A-3-22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



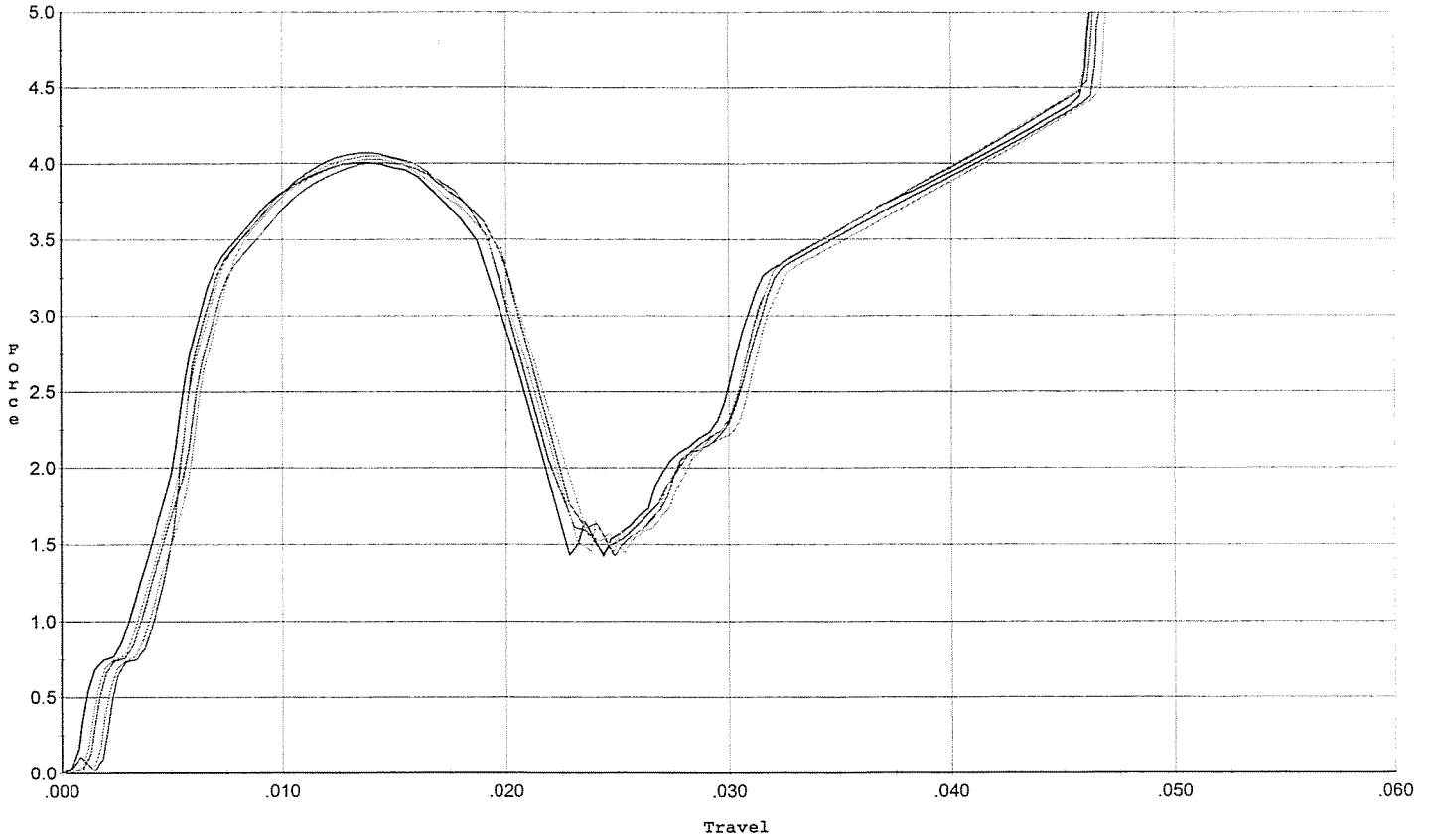
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.177	0.019	0.00	0.030	0.041		Set Trigger
2	3.025	0.017	0.00	0.030	0.037		Set Trigger
3	3.035	0.018	0.00	0.030	0.037		Set Trigger
4	2.955	0.019	0.00	0.031	0.037		Set Trigger
5	2.978	0.018	0.00	0.030	0.037		Set Trigger

A-3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



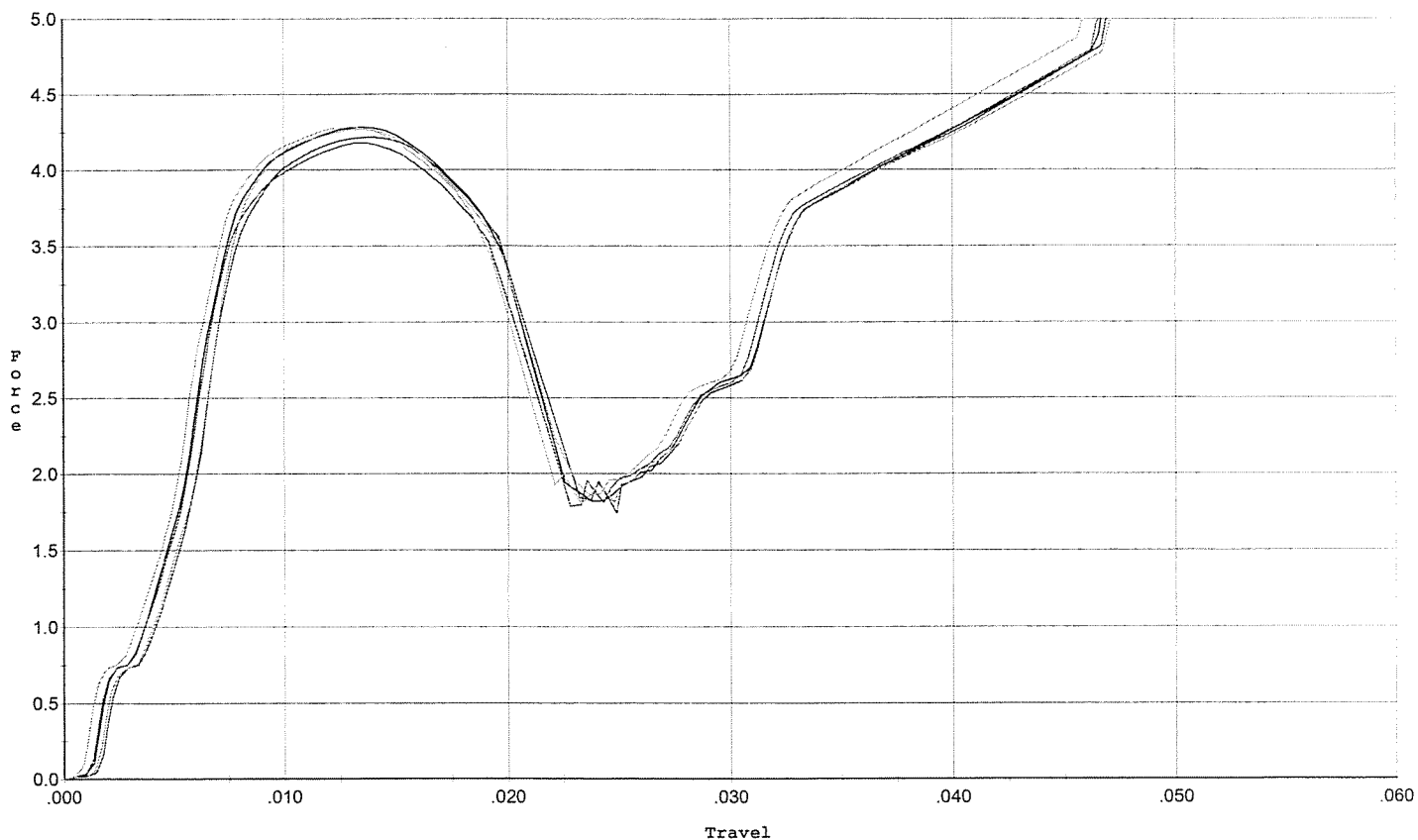
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.072	0.019	0.00	0.029	0.051		Set Trigger
2	4.005	0.020	0.00	0.028	0.055		Set Trigger
3	4.004	0.020	0.00	0.028	0.052		Set Trigger
4	4.028	0.021	0.00	0.028	0.056		Set Trigger
5	4.050	0.020	0.00	0.029	0.052		Set Trigger

A 4.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



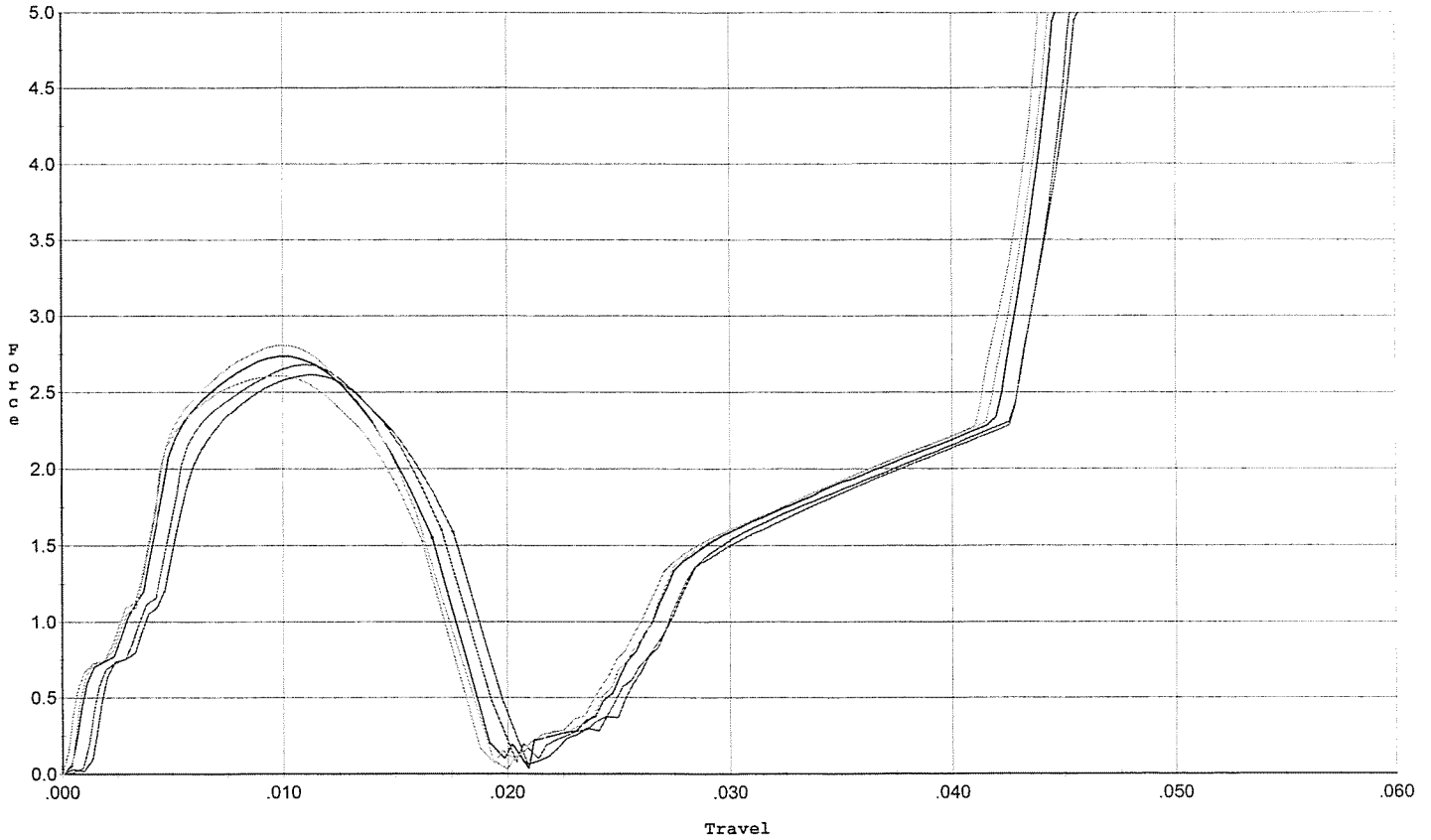
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.214	0.020	0.00	0.028	0.053		Set Trigger
2	4.282	0.020	0.00	0.028	0.055		Set Trigger
3	4.176	0.021	0.00	0.028	0.056		Set Trigger
4	4.284	0.019	0.00	0.027	0.054		Set Trigger
5	4.269	0.020	0.00	0.028	0.054		Set Trigger

A-4.24

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



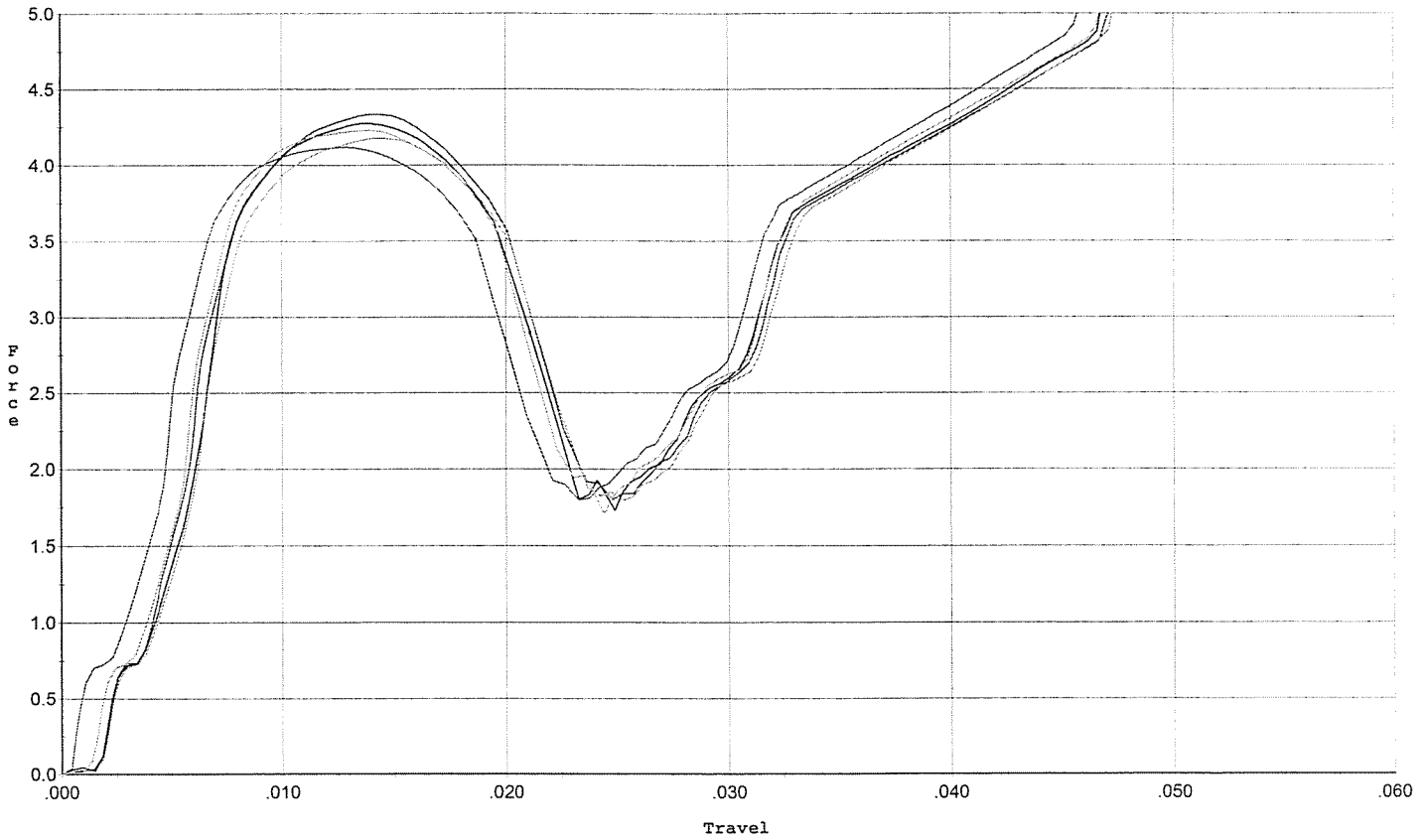
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.613	0.018	0.00	0.033	0.030		Set Trigger
2	2.736	0.017	0.00	0.033	0.031		Set Trigger
3	2.681	0.017	0.00	0.033	0.030		Set Trigger
4	2.808	0.016	0.00	0.033	0.030		Set Trigger
5	2.609	0.016	0.00	0.033	0.029		Set Trigger

A-2-68

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/27/2009

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.334	0.020	0.00	0.028	0.056		Set Trigger
2	4.272	0.021	0.00	0.028	0.057		Set Trigger
3	4.119	0.019	0.00	0.028	0.052		Set Trigger
4	4.227	0.020	0.00	0.028	0.054		Set Trigger
5	4.176	0.020	0.00	0.028	0.054		Set Trigger

A-4.22