

G6801487

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

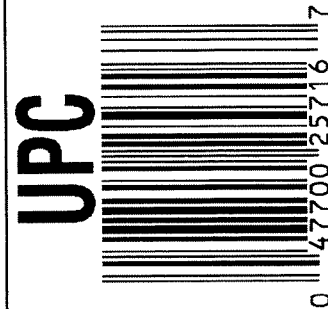
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

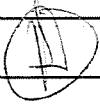
G6801487



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6801487

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	RZ
480	MAGNAFLUX BBL ACTION		3-9-09	(D)
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	RZ
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		3-20-09	L. W.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

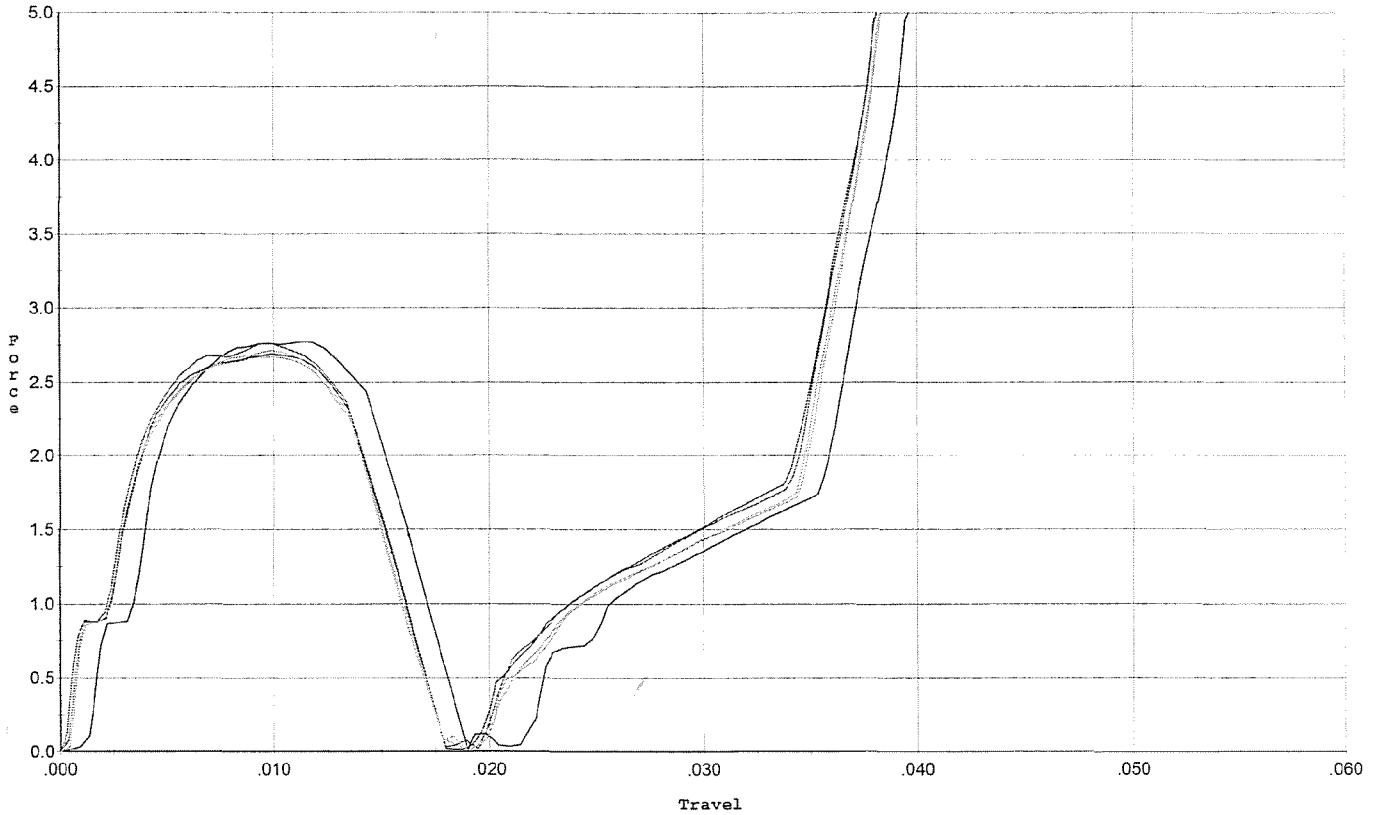
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.2</u> <u>2.2</u> <u>2.2</u>	3/23/09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.4</u> <u>3.4</u> <u>3.4</u>	3/23/09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3/23/09	RP
	J) ASSEMBLE STOCK		3-20-09	N/A
	K) ASSEMBLE SWIVEL STUDS		3-20-09	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	TL
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-23-09	N/A
670	FINAL INSPECTION A) HEADSPACE		3/23/09	RP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.43</u> <u>2.43</u> <u>2.34</u> <u>2.39</u>	3-23-09	TL
	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



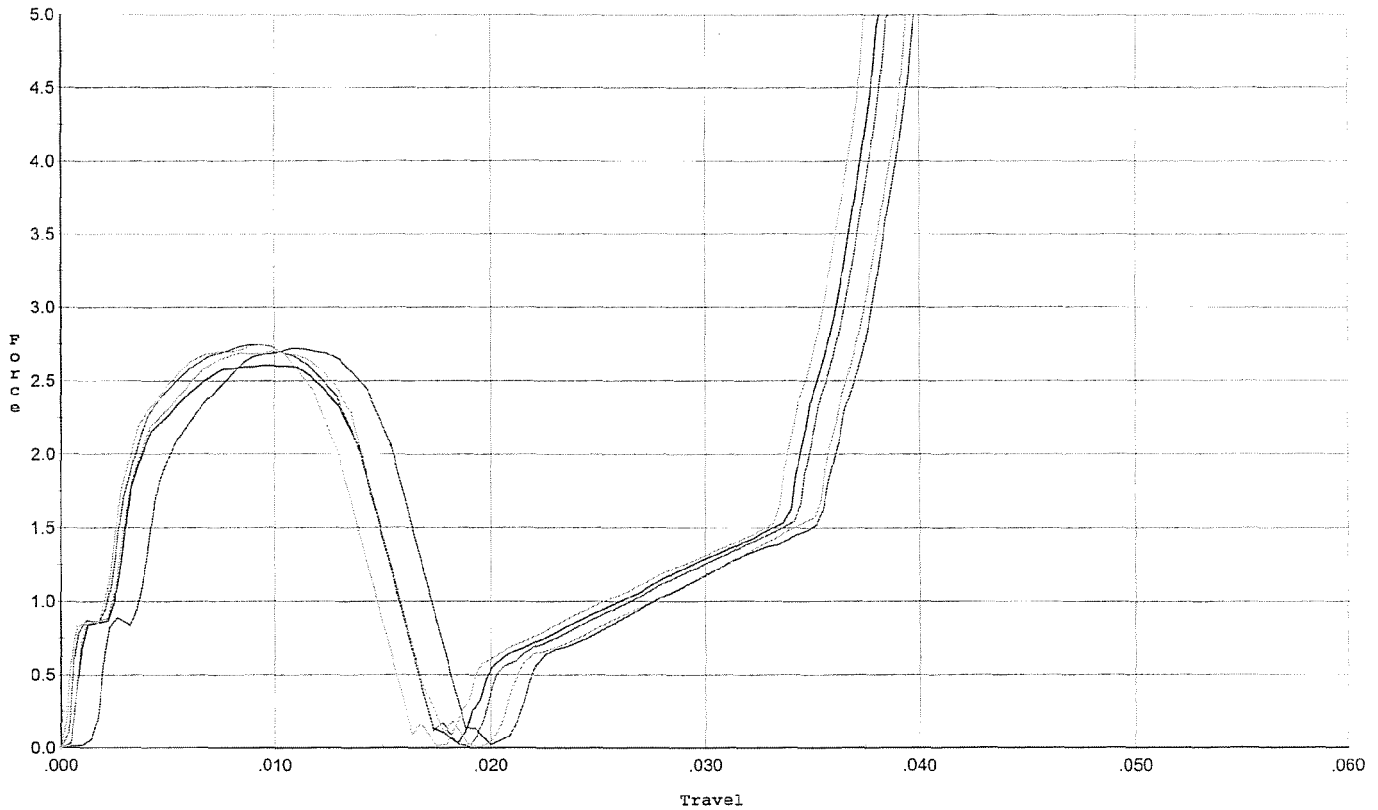
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.692	0.015	0.00	0.028	0.030		Set Trigger
2	2.774	0.016	0.00	0.029	0.030		Set Trigger
3	2.766	0.015	0.00	0.028	0.030		Set Trigger
4	2.673	0.014	0.00	0.029	0.026		Set Trigger
5	2.712	0.014	0.00	0.029	0.026		Set Trigger

A-2.72

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



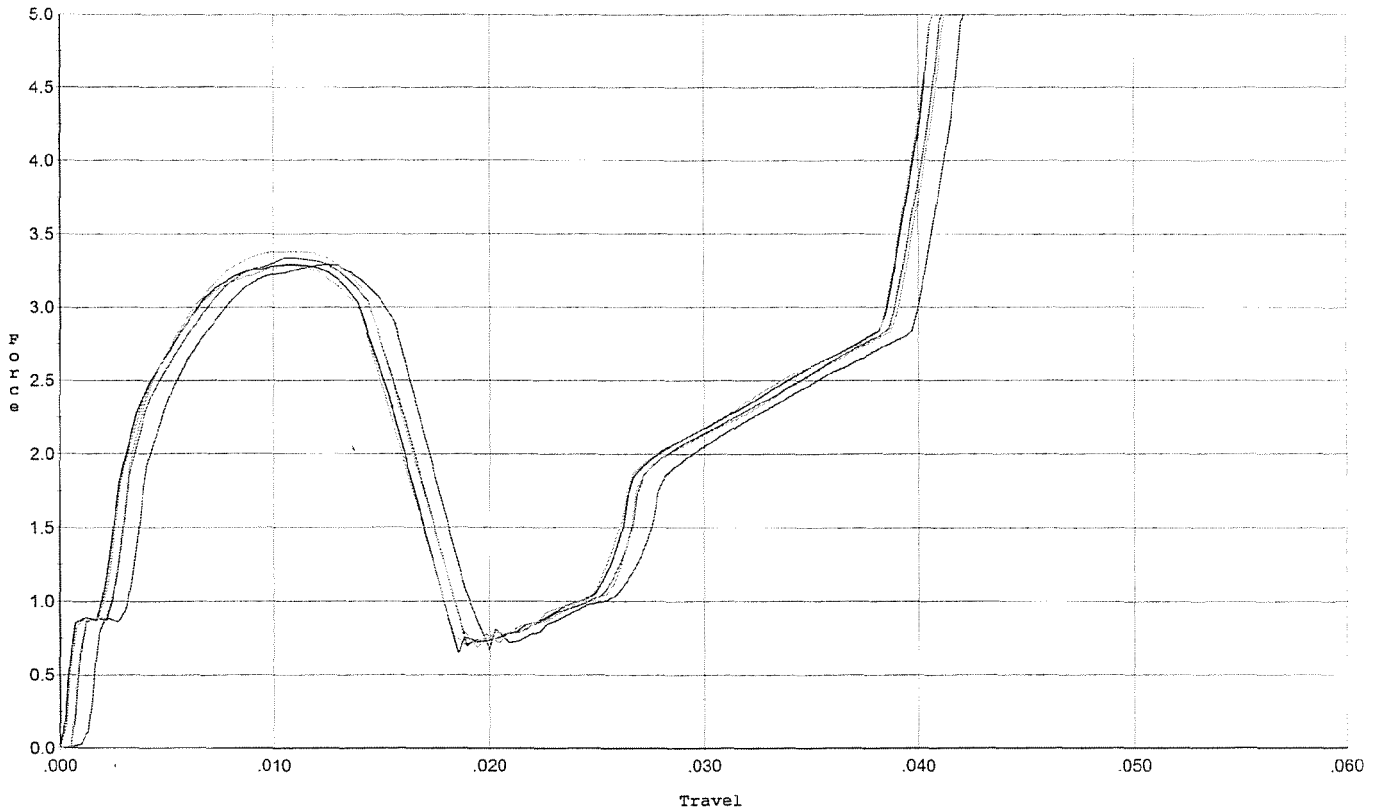
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.720	0.015	0.00	0.029	0.028		Set Trigger
2	2.604	0.014	0.00	0.029	0.026		Set Trigger
3	2.743	0.014	0.00	0.030	0.027		Set Trigger
4	2.746	0.013	0.00	0.030	0.025		Set Trigger
5	2.701	0.014	0.00	0.031	0.026		Set Trigger

A-2-70

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 +/- 1.0 lb



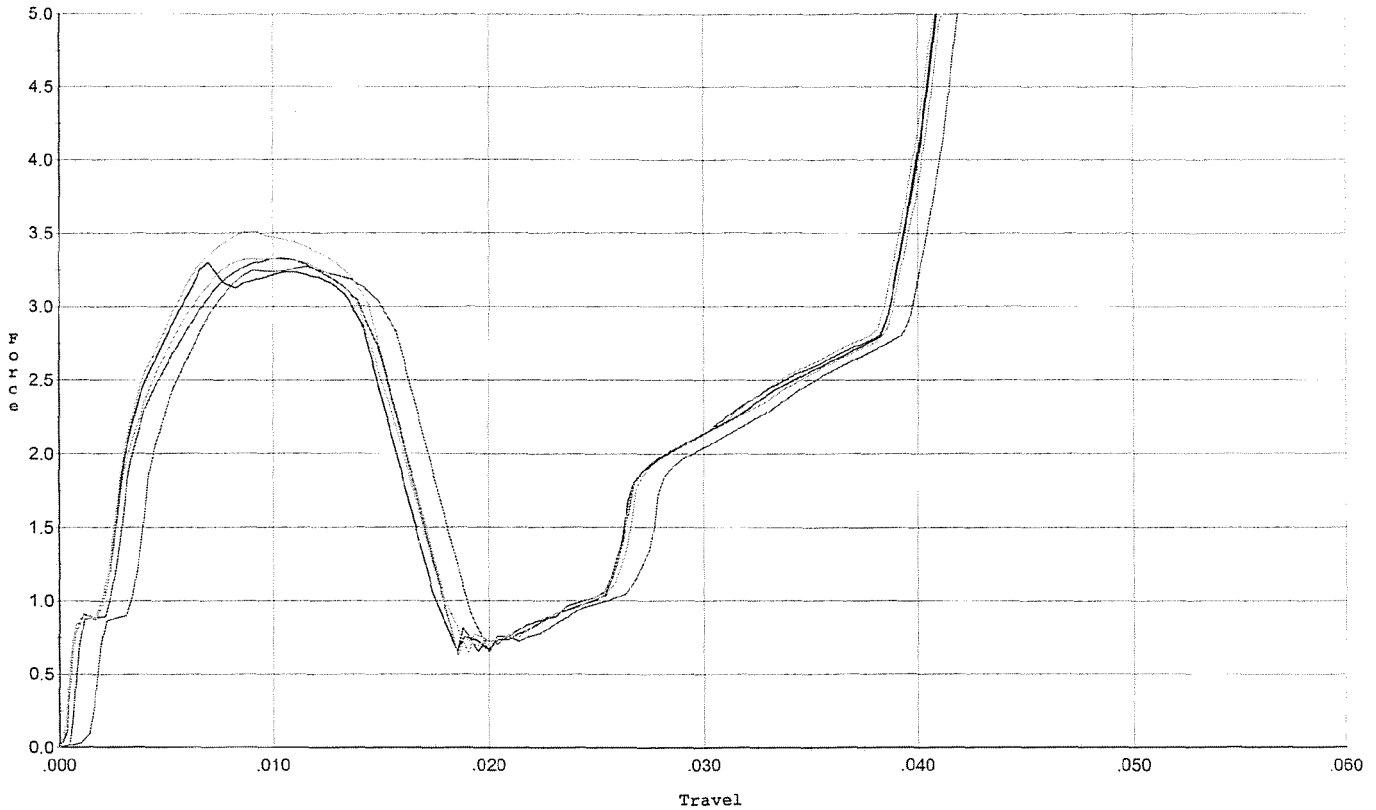
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.289	0.016	0.00	0.029	0.035		Set Trigger
2	3.292	0.015	0.00	0.028	0.036		Set Trigger
3	3.336	0.016	0.00	0.028	0.037		Set Trigger
4	3.382	0.017	0.00	0.028	0.039		Set Trigger
5	3.281	0.016	0.00	0.028	0.037		Set Trigger

A-3.31

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+/- 1.0 lb



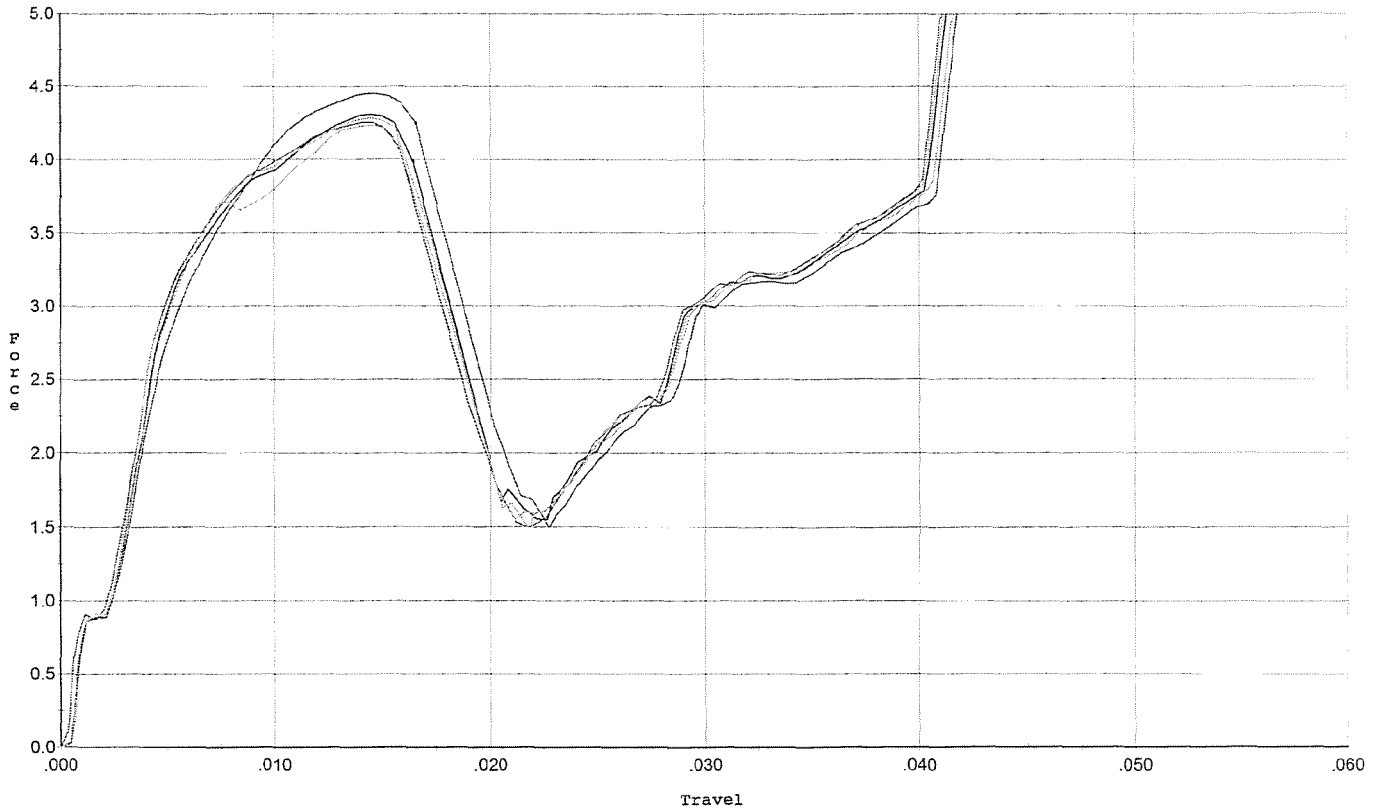
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.329	0.015	0.00	0.029	0.034		Set Trigger
2	3.305	0.014	0.00	0.029	0.033		Set Trigger
3	3.272	0.016	0.00	0.029	0.034		Set Trigger
4	3.326	0.016	0.00	0.028	0.037		Set Trigger
5	3.510	0.014	0.00	0.029	0.036		Set Trigger

A.3.34

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 ini +/- 1.0 lb



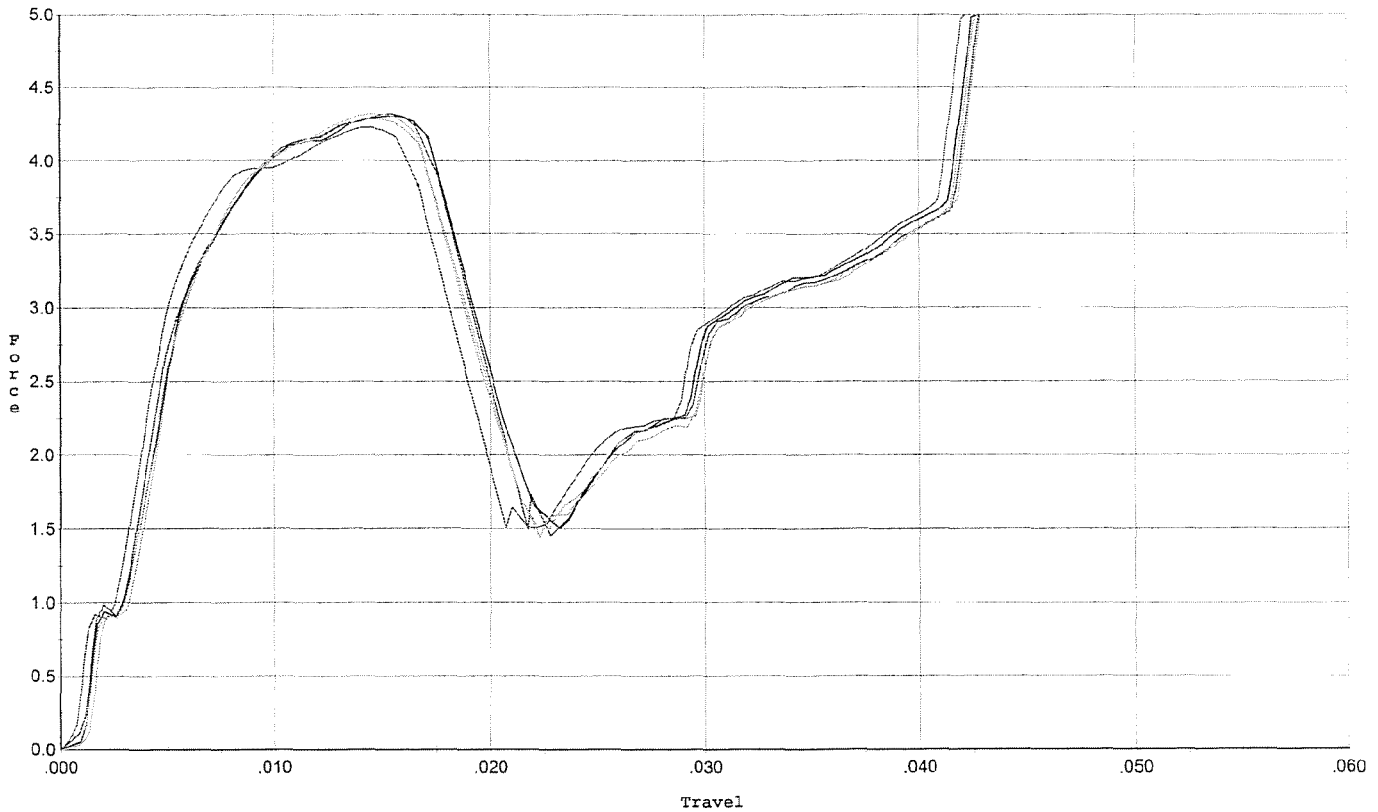
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.448	0.017	0.00	0.025	0.048		Set Trigger
2	4.309	0.016	0.00	0.025	0.047		Set Trigger
3	4.253	0.016	0.00	0.026	0.045		Set Trigger
4	4.233	0.018	0.00	0.026	0.050		Set Trigger
5	4.283	0.017	0.00	0.025	0.049		Set Trigger

A. 4.30

Trigger Profile [lbs,inch]

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

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



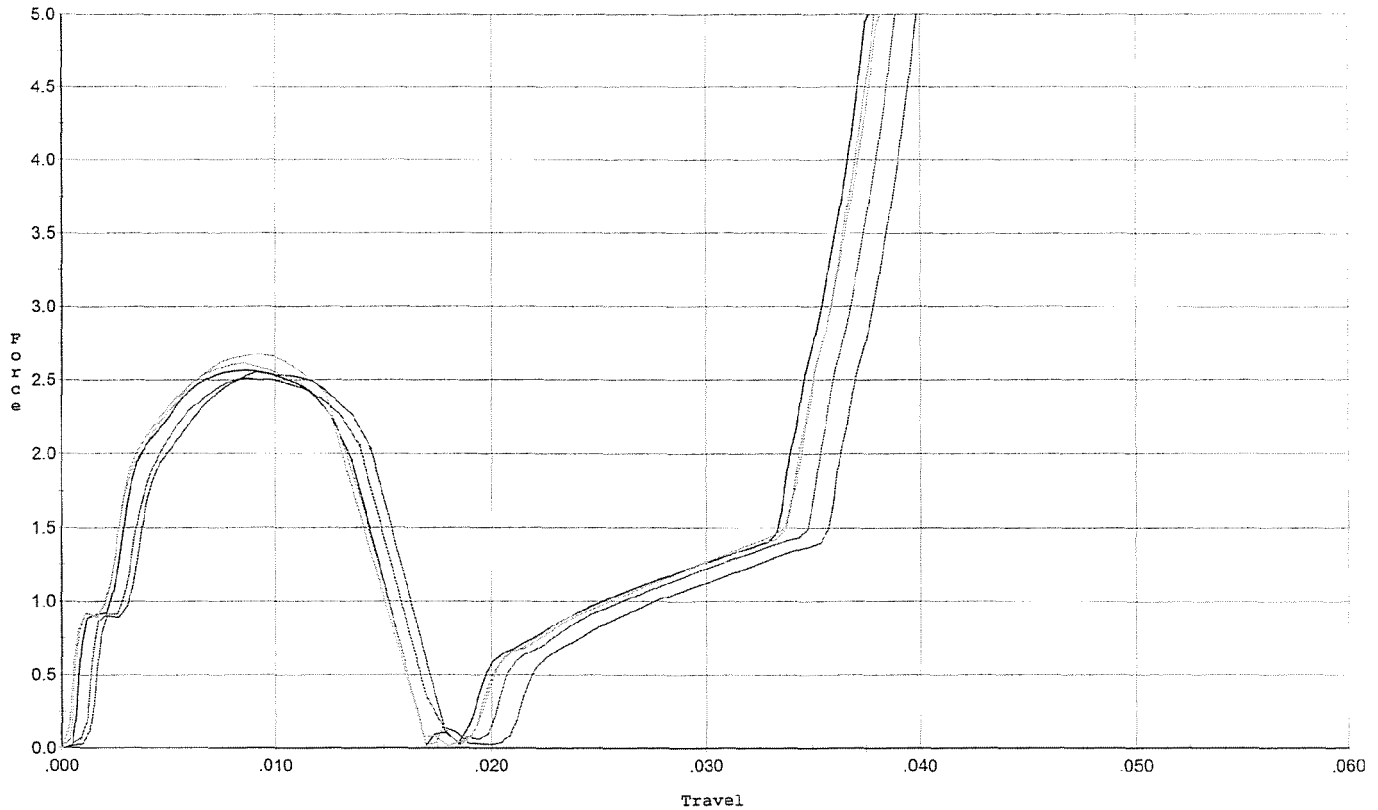
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.317	0.018	0.00	0.026	0.050		Set Trigger
2	4.303	0.017	0.00	0.026	0.049		Set Trigger
3	4.226	0.017	0.00	0.026	0.048		Set Trigger
4	4.320	0.019	0.00	0.026	0.054		Set Trigger
5	4.288	0.017	0.00	0.026	0.047		Set Trigger

A-4.29

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



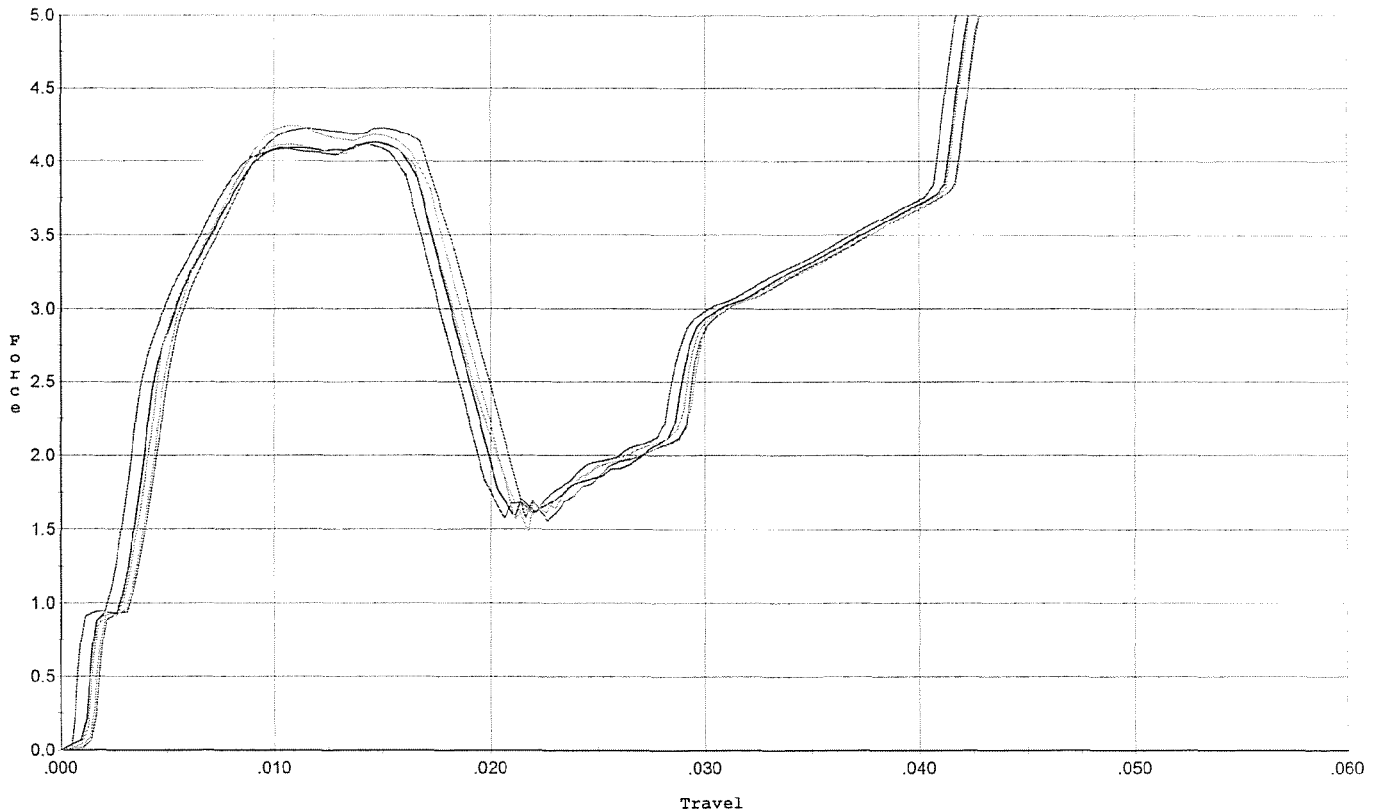
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.553	0.014	0.00	0.031	0.025		Set Trigger
2	2.564	0.014	0.00	0.029	0.025		Set Trigger
3	2.509	0.014	0.00	0.030	0.024		Set Trigger
4	2.614	0.015	0.00	0.030	0.028		Set Trigger
5	2.671	0.014	0.00	0.030	0.027		Set Trigger

A-258

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	4.119	0.016	0.00	0.026	0.046		Set Trigger
2	4.130	0.017	0.00	0.027	0.046		Set Trigger
3	4.224	0.018	0.00	0.026	0.051		Set Trigger
4	4.115	0.016	0.00	0.027	0.046		Set Trigger
5	4.241	0.017	0.00	0.027	0.048		Set Trigger

A. 4.16