

G6807668

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

- INSTRUCTION BOOK 3518

BM FORM

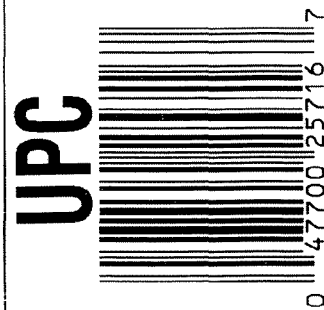


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807668



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 680 7668

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	KTC
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TL
460	CHECK HEADSPACE		3-24-09	TL
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION		3-27-09	Ⓟ
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-24-09	RT
520	GOFF BLAST BBL / REC		3-27	BT
542	APPLY COATINGS (BARREL ACTION)		3-29	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-23-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

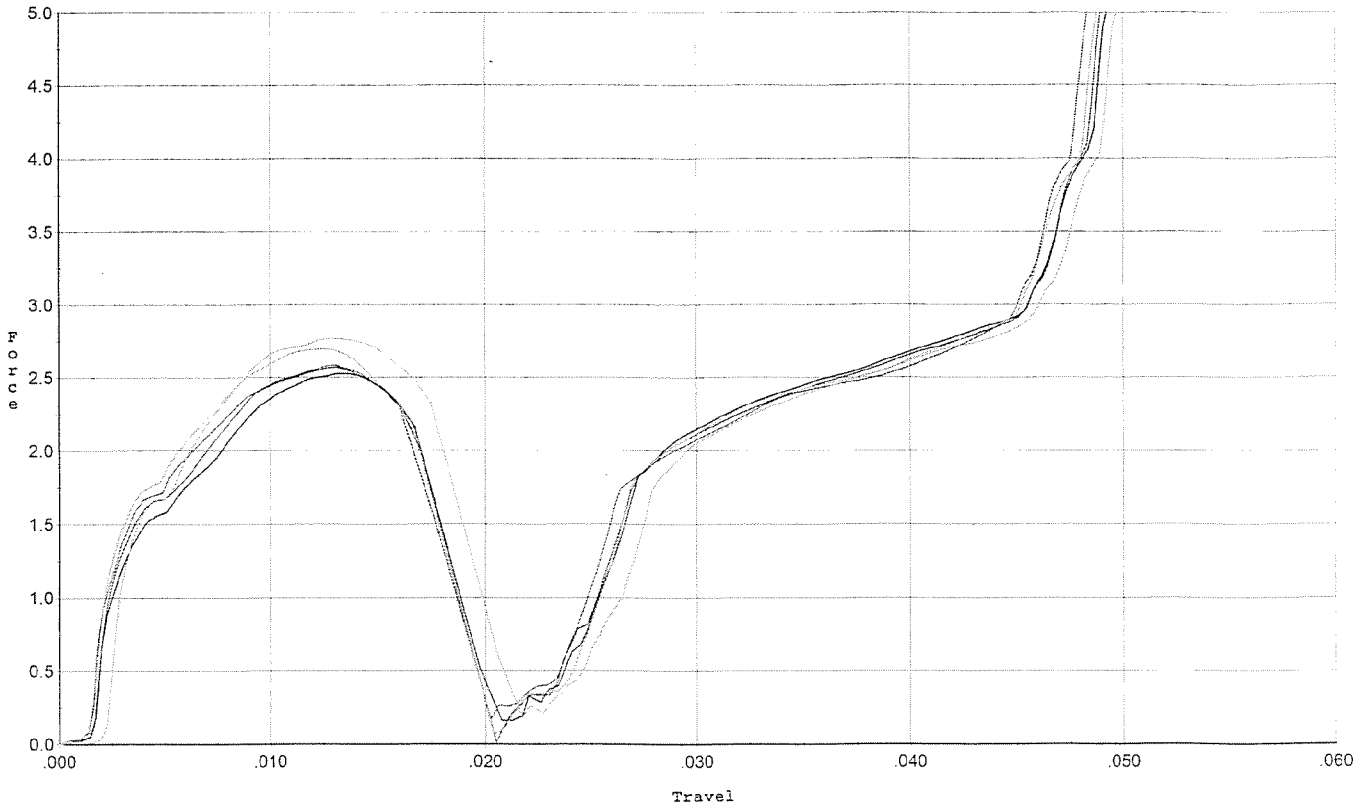
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7</u> <u>7</u> <u>7</u>	4-29-09	WW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	4-29-09	WW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	4-29-09	WW
	J) ASSEMBLE STOCK		4-23-09	RJ
	K) ASSEMBLE SWIVEL STUDS		4-29-09	WW
	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	4-24-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		4-29-09	WW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.58</u> <u>2.40</u> <u>2.39</u> <u>2.39</u>	4-28-09	WW
	C) FUNCTION		4-29-09	WW
690	PACK		5/6/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



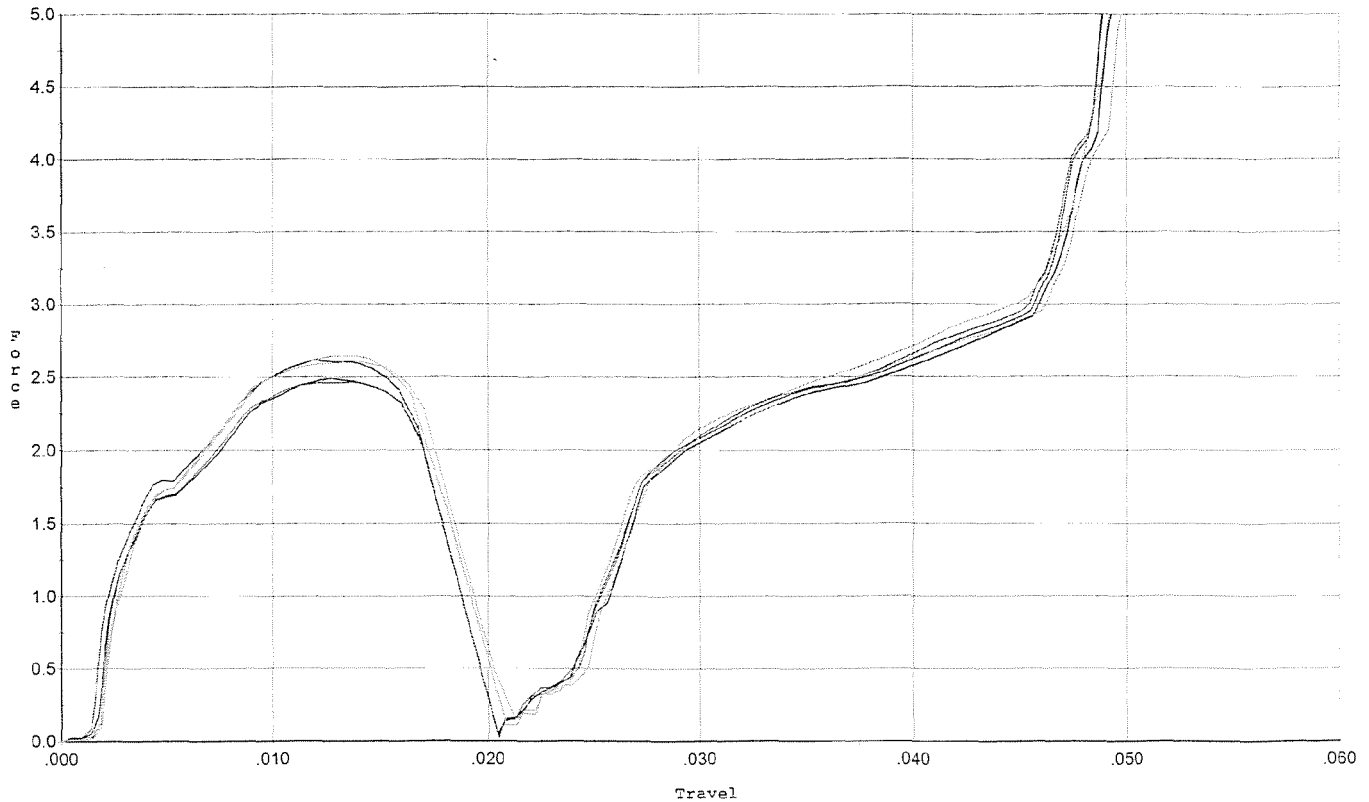
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.572	0.017	0.00	0.035	0.030		Set Trigger
2	2.528	0.017	0.00	0.035	0.029		Set Trigger
3	2.584	0.018	0.00	0.035	0.032		Set Trigger
4	2.769	0.017	0.00	0.035	0.033		Set Trigger
5	2.695	0.017	0.00	0.035	0.032		Set Trigger

A.2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



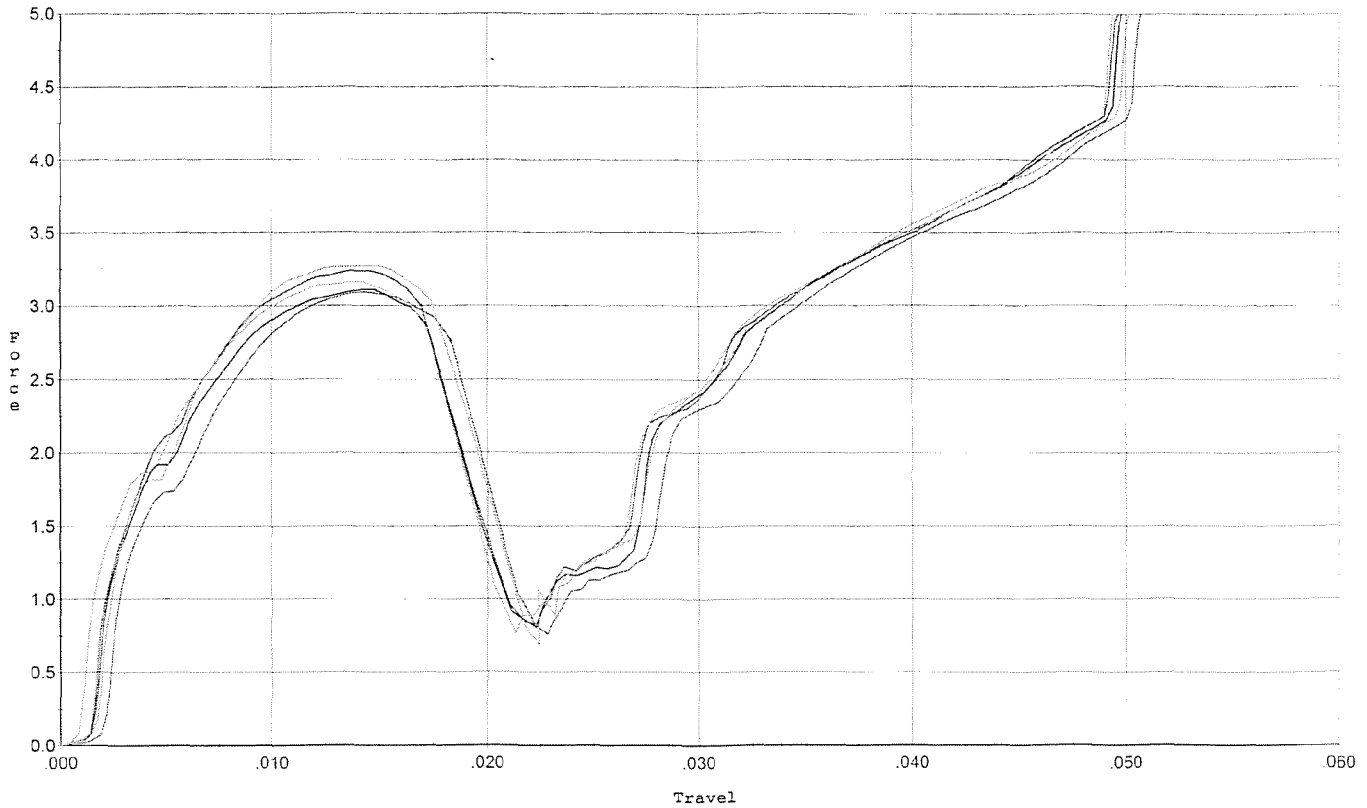
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.615	0.017	0.00	0.035	0.031		Set Trigger
2	2.488	0.017	0.00	0.036	0.029		Set Trigger
3	2.464	0.017	0.002	0.035	0.029		Set Trigger
4	2.610	0.018	0.00	0.035	0.032		Set Trigger
5	2.640	0.017	0.00	0.035	0.031		Set Trigger

A 2.56

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/11/2009

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



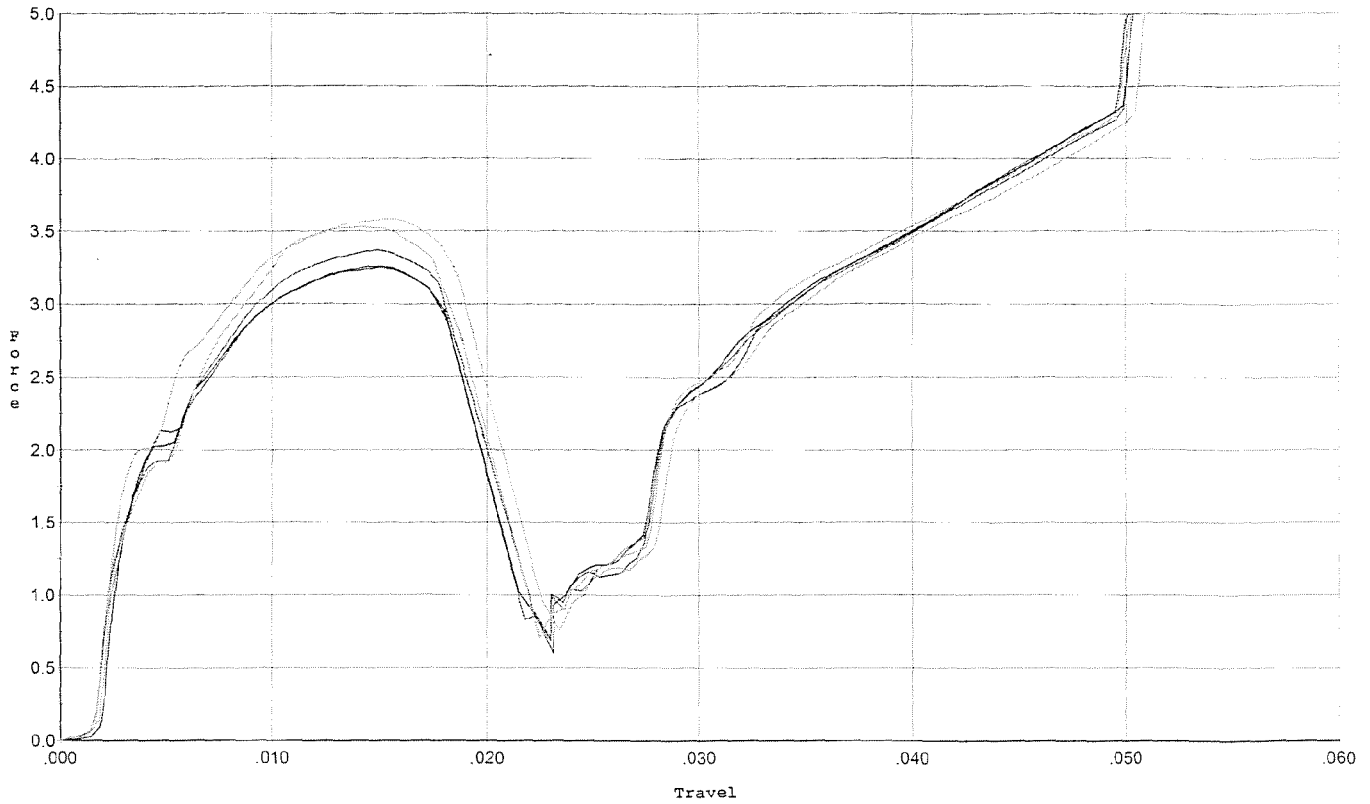
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.236	0.017	0.00	0.033	0.038		Set Trigger
2	3.110	0.017	0.00	0.034	0.037		Set Trigger
3	3.095	0.018	0.00	0.034	0.038		Set Trigger
4	3.162	0.017	0.00	0.033	0.039		Set Trigger
5	3.272	0.019	0.00	0.033	0.043		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/11/2009

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



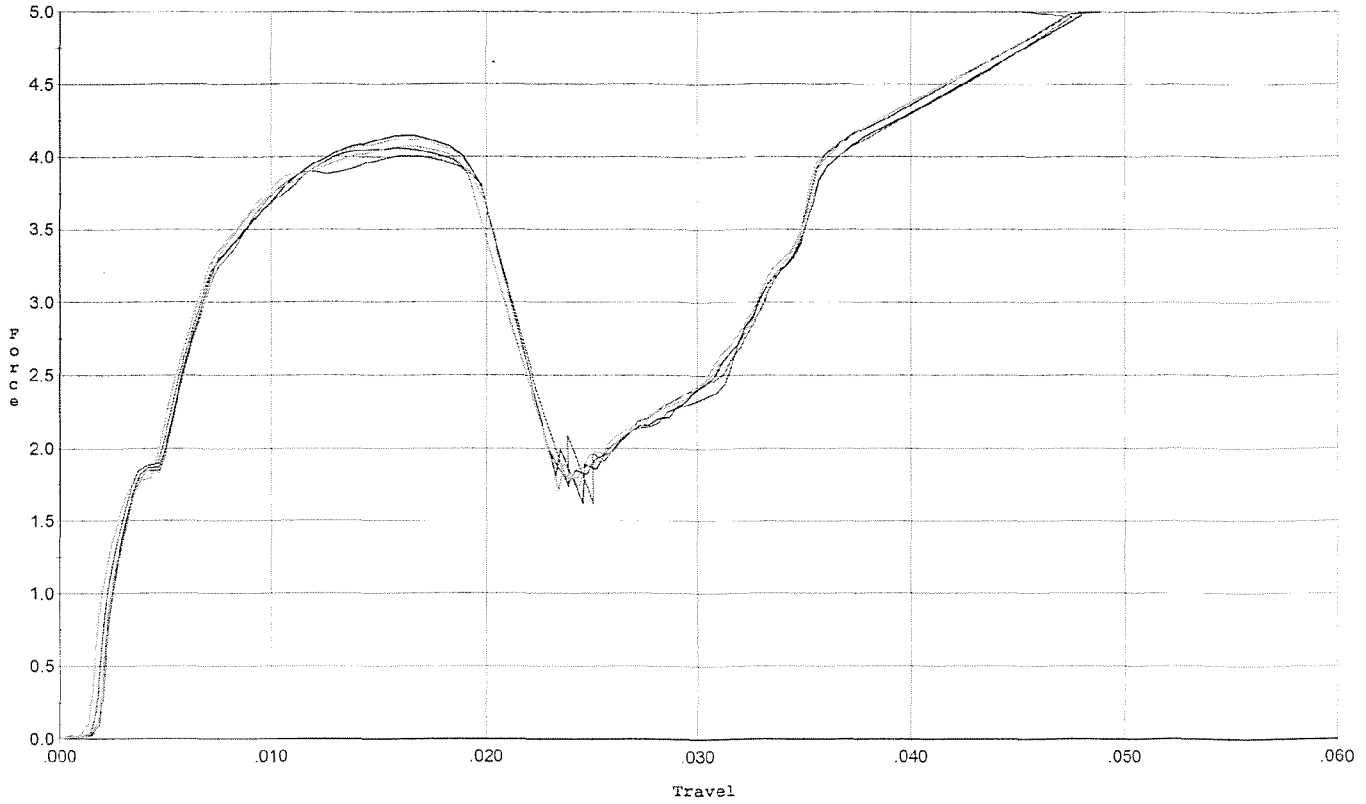
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.257	0.018	0.00	0.033	0.041		Set Trigger
2	3.253	0.018	0.00	0.034	0.040		Set Trigger
3	3.368	0.020	0.00	0.033	0.045		Set Trigger
4	3.580	0.019	0.00	0.033	0.045		Set Trigger
5	3.528	0.019	0.00	0.033	0.046		Set Trigger

A-3-39

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



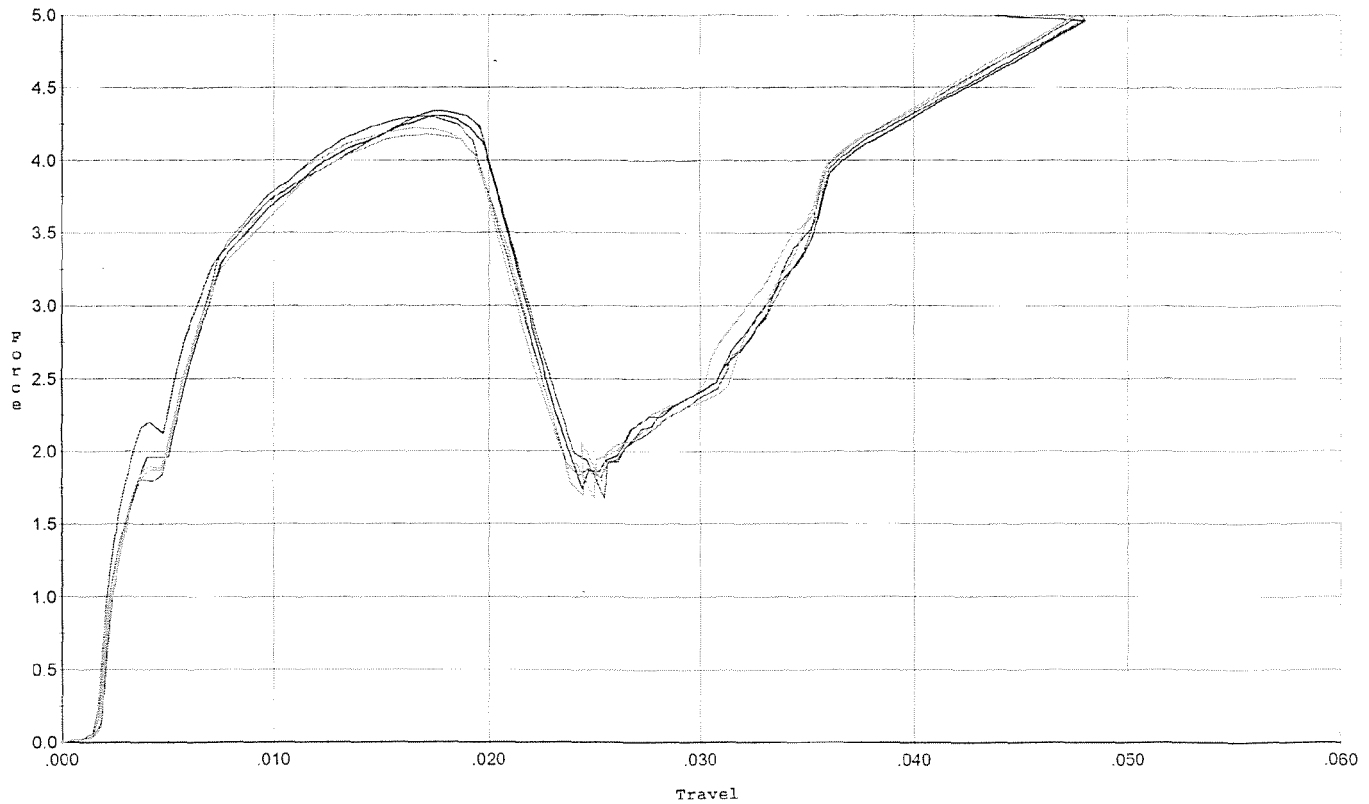
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.062	0.019	0.00	0.032	0.053		Set Trigger
2	4.148	0.020	0.00	0.031	0.055		Set Trigger
3	4.007	0.020	0.00	0.031	0.054		Set Trigger
4	4.074	0.019	0.00	0.031	0.053		Set Trigger
5	4.123	0.020	0.00	0.031	0.055		Set Trigger

A. 4.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



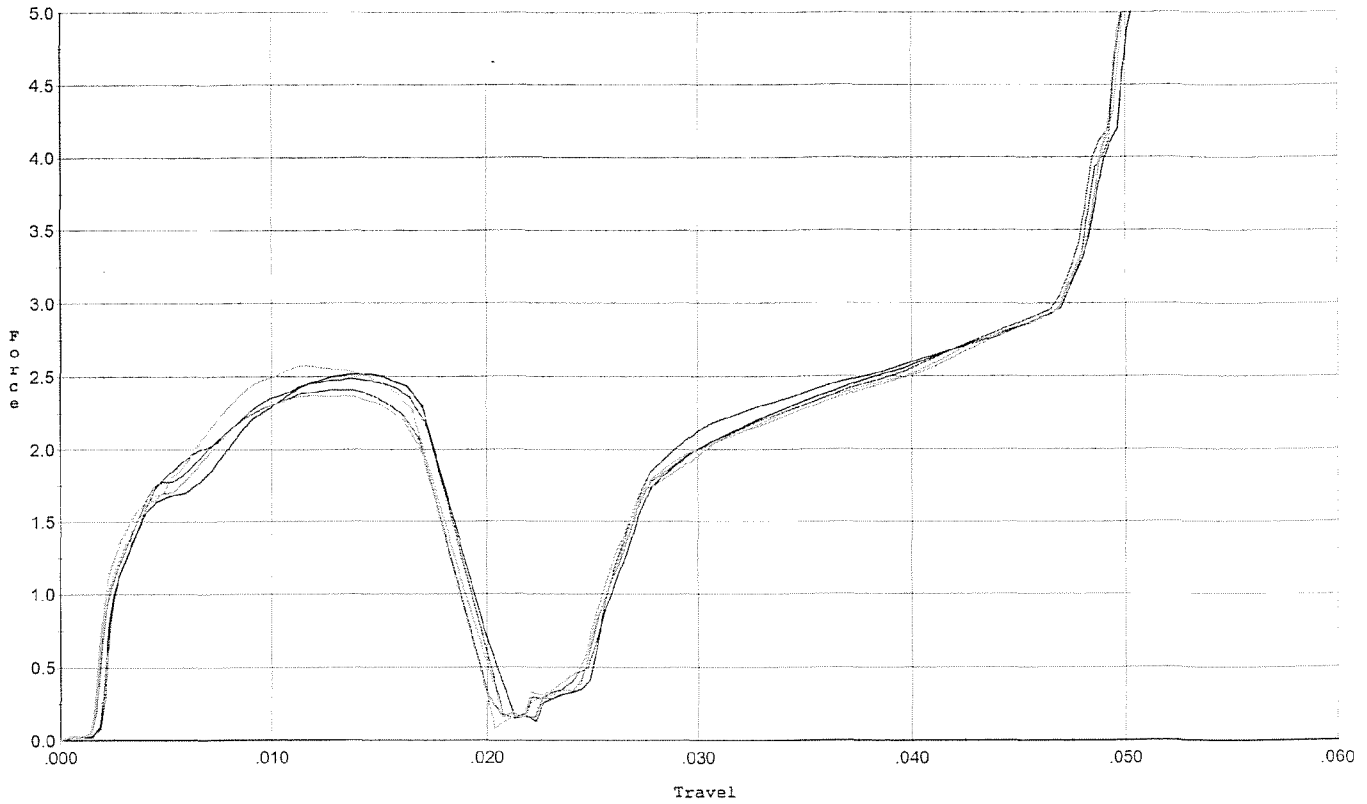
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.337	0.020	0.00	0.031	0.057		Set Trigger
2	4.307	0.020	0.005	0.031	0.056		Set Trigger
3	4.303	0.021	0.00	0.031	0.061		Set Trigger
4	4.225	0.019	0.00	0.031	0.055		Set Trigger
5	4.179	0.021	0.00	0.030	0.058		Set Trigger

A.4.27

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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



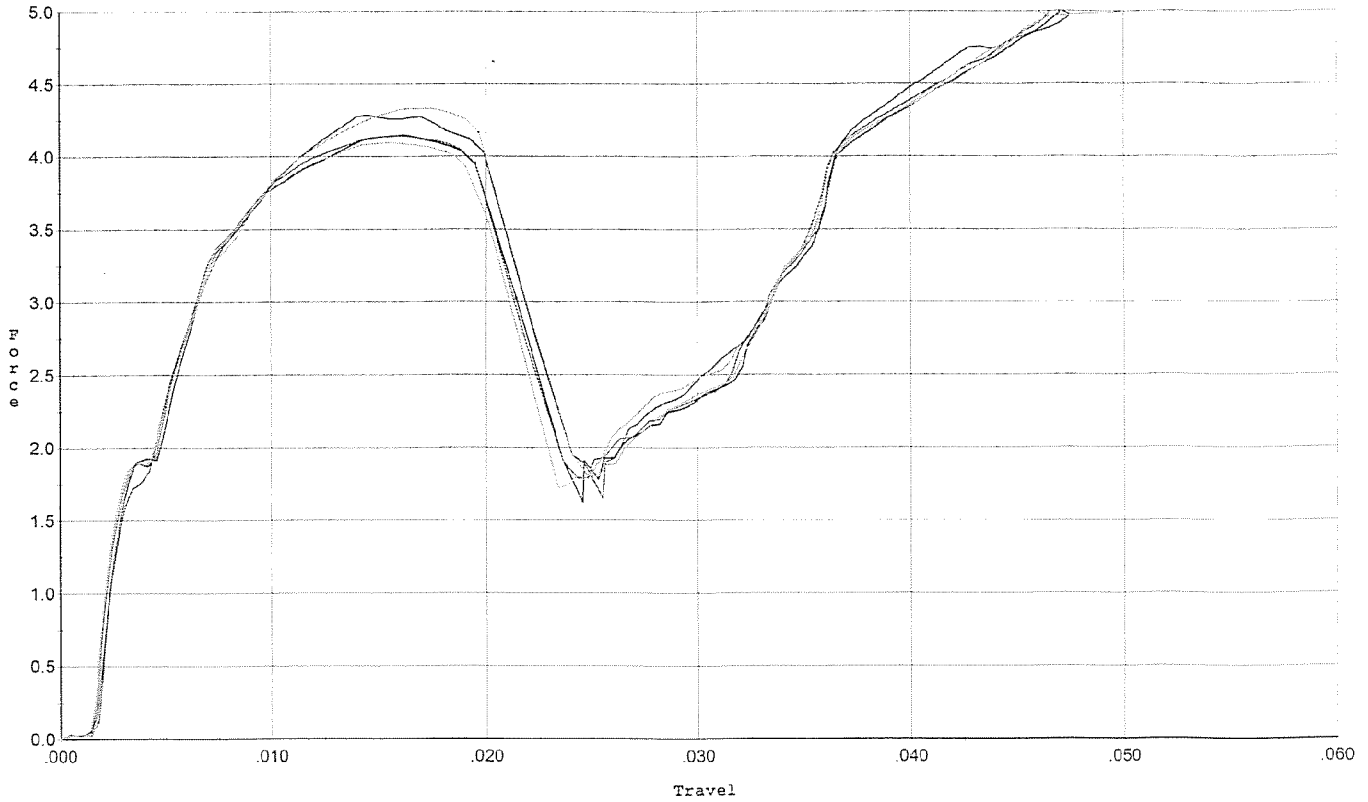
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.487	0.017	0.00	0.036	0.030		Set Trigger
2	2.515	0.017	0.002	0.036	0.029		Set Trigger
3	2.409	0.017	0.00	0.036	0.029		Set Trigger
4	2.577	0.017	0.00	0.036	0.030		Set Trigger
5	2.372	0.017	0.00	0.036	0.029		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/11/2009

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	4.286	0.020	0.00	0.031	0.058		Set Trigger
2	4.148	0.021	0.002	0.031	0.061		Set Trigger
3	4.143	0.019	0.00	0.032	0.056		Set Trigger
4	4.094	0.020	0.00	0.031	0.057		Set Trigger
5	4.332	0.020	0.00	0.031	0.057		Set Trigger

A. 4.20