

G680 7692

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

- INSTRUCTION BOOK 3518

BM FORM

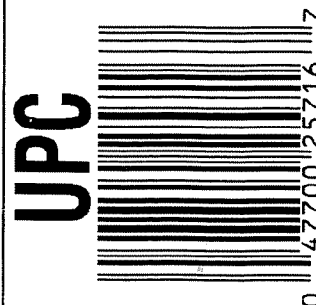


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6807692



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6807692

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	RP
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	RP
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RT
475	DRILL AND TAP SIGHT HOLES		3-23-09	SP
480	MAGNAFLUX BBL ACTION	REATOR (A)	3/25/09	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	BT
542	APPLY COATINGS (BARREL ACTION)		3-29	
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TK
	D) OIL FIRING PIN ASSEMBLY		4-2-09	RP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

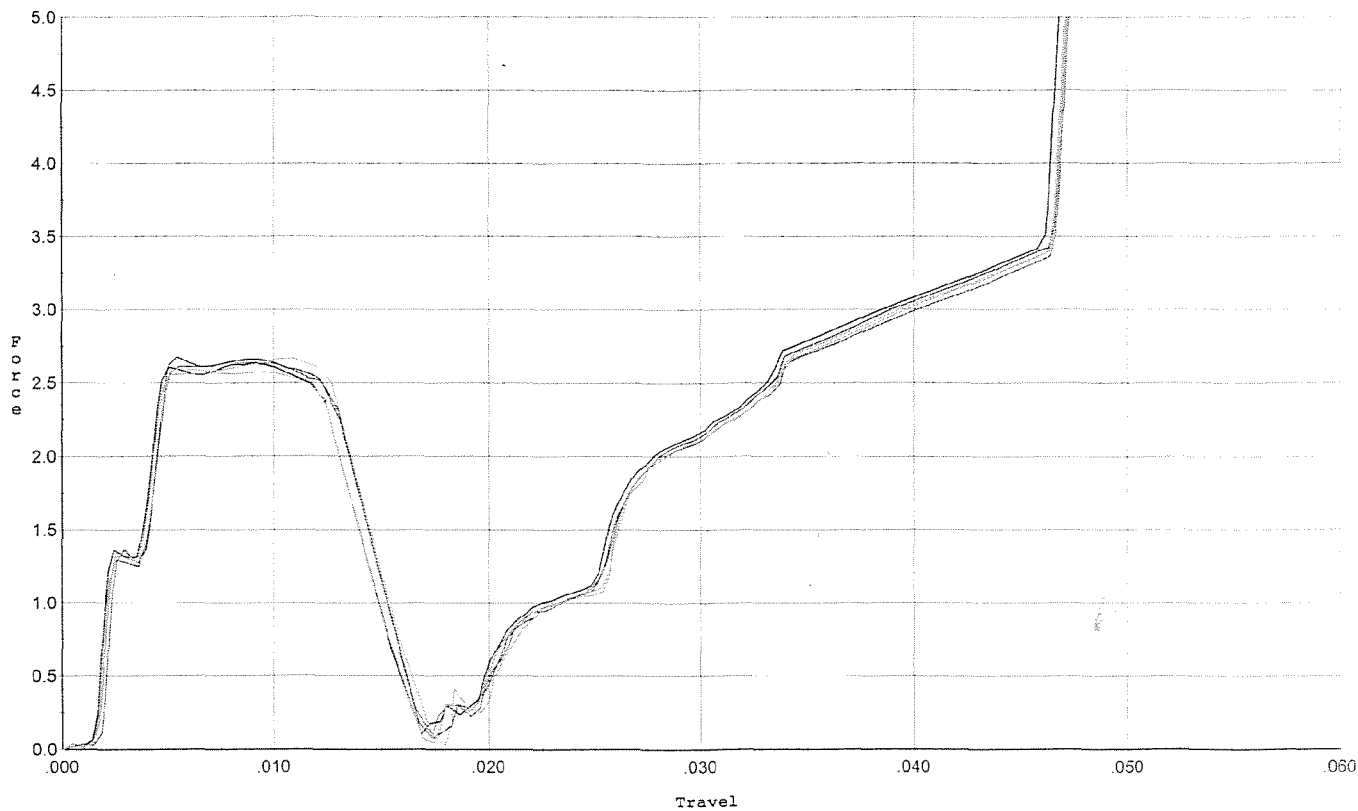
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.5</u> <u>2.5</u> <u>2.5</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.2</u> <u>4.2</u> <u>4.1</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-2-09	RP
	K) ASSEMBLE SWIVEL STUDS		4-17-09	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	PASS FAIL PASS FAIL	4-9-09	WV
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-9-09	TQR
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.61</u> <u>2.63</u> <u>2.64</u> <u>2.52</u>	4-14-09	WV
	C) FUNCTION		4-17-09	RP
690	PACK		5-29-09	WV

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



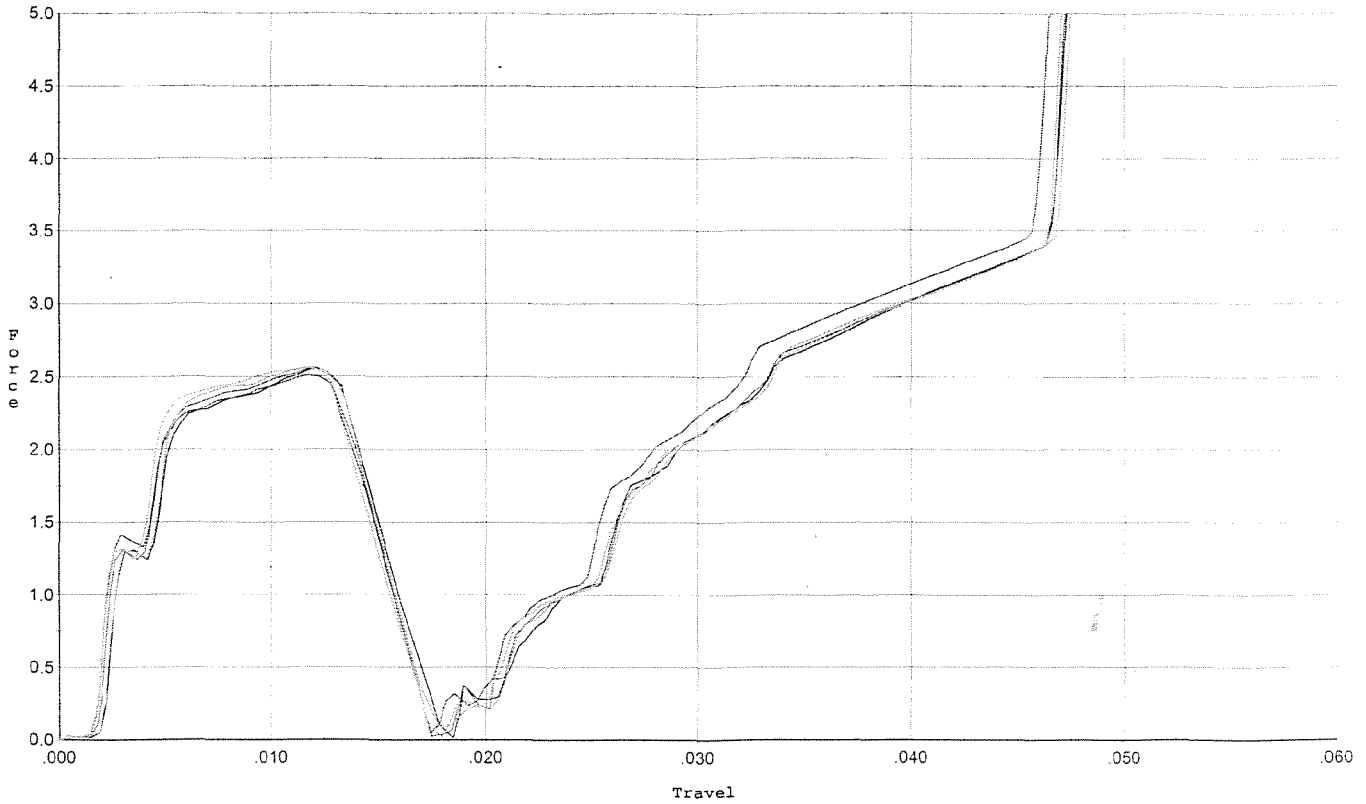
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.674	0.013	0.00	0.036	0.024		Set Trigger
2	2.630	0.012	0.004	0.036	0.023		Set Trigger
3	2.638	0.013	0.004	0.036	0.024		Set Trigger
4	2.665	0.013	0.00	0.036	0.023		Set Trigger
5	2.574	0.012	0.004	0.037	0.022		Set Trigger

A-2-63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



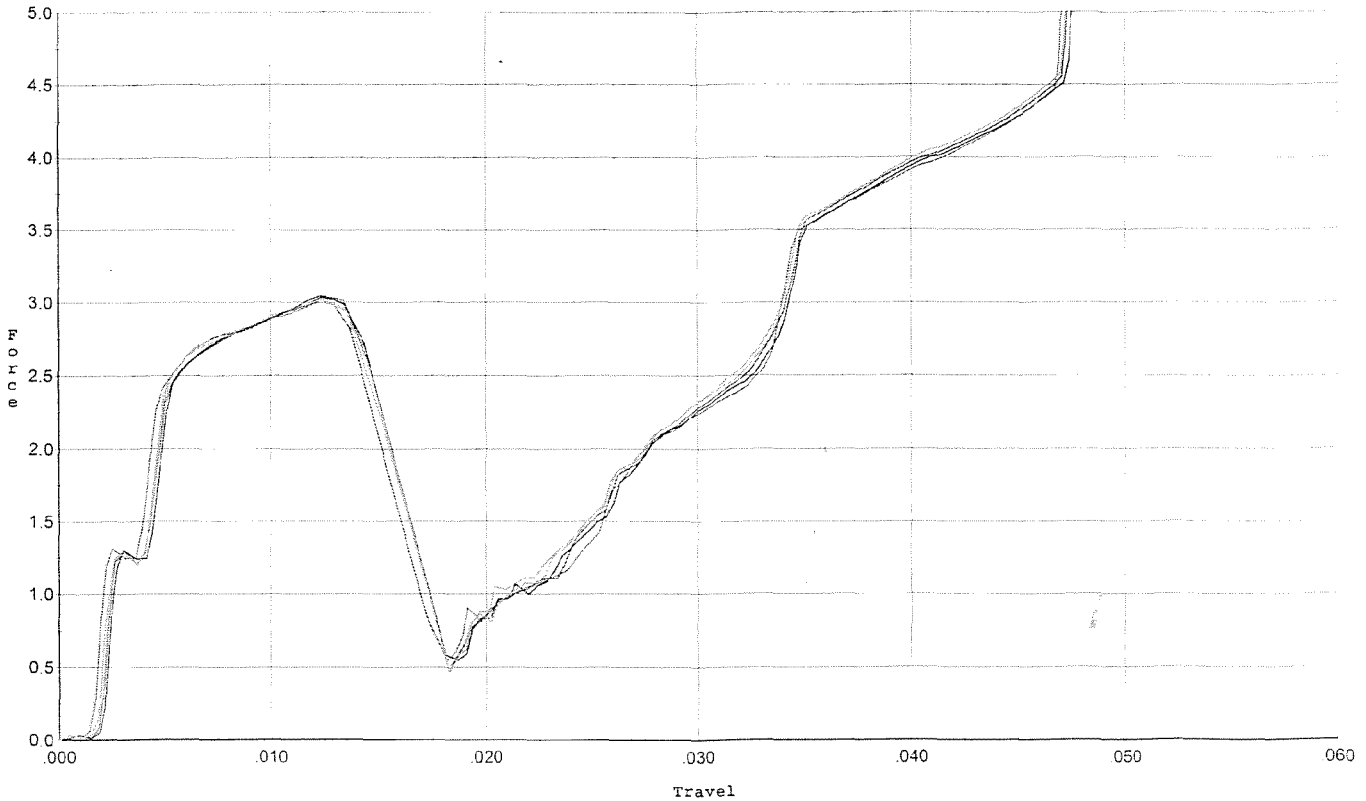
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.516	0.014	0.004	0.035	0.024		Set Trigger
2	2.558	0.013	0.00	0.036	0.022		Set Trigger
3	2.553	0.014	0.002	0.036	0.024		Set Trigger
4	2.563	0.013	0.00	0.036	0.022		Set Trigger
5	2.564	0.013	0.004	0.036	0.023		Set Trigger

A-2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



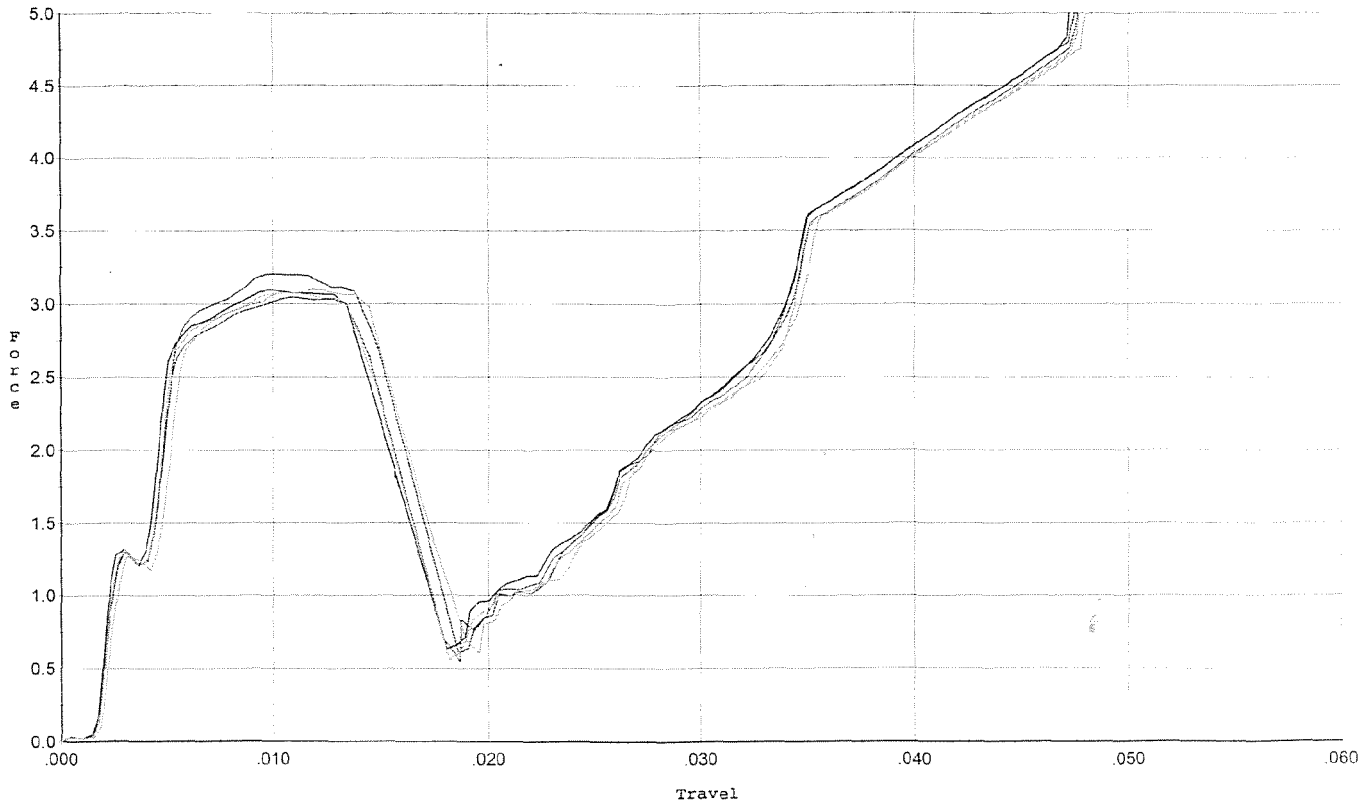
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.047	0.015	0.002	0.034	0.029		Set Trigger
2	3.033	0.014	0.004	0.034	0.028		Set Trigger
3	2.998	0.014	0.004	0.034	0.028		Set Trigger
4	2.999	0.015	0.00	0.034	0.029		Set Trigger
5	3.015	0.015	0.00	0.034	0.030		Set Trigger

A-3.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



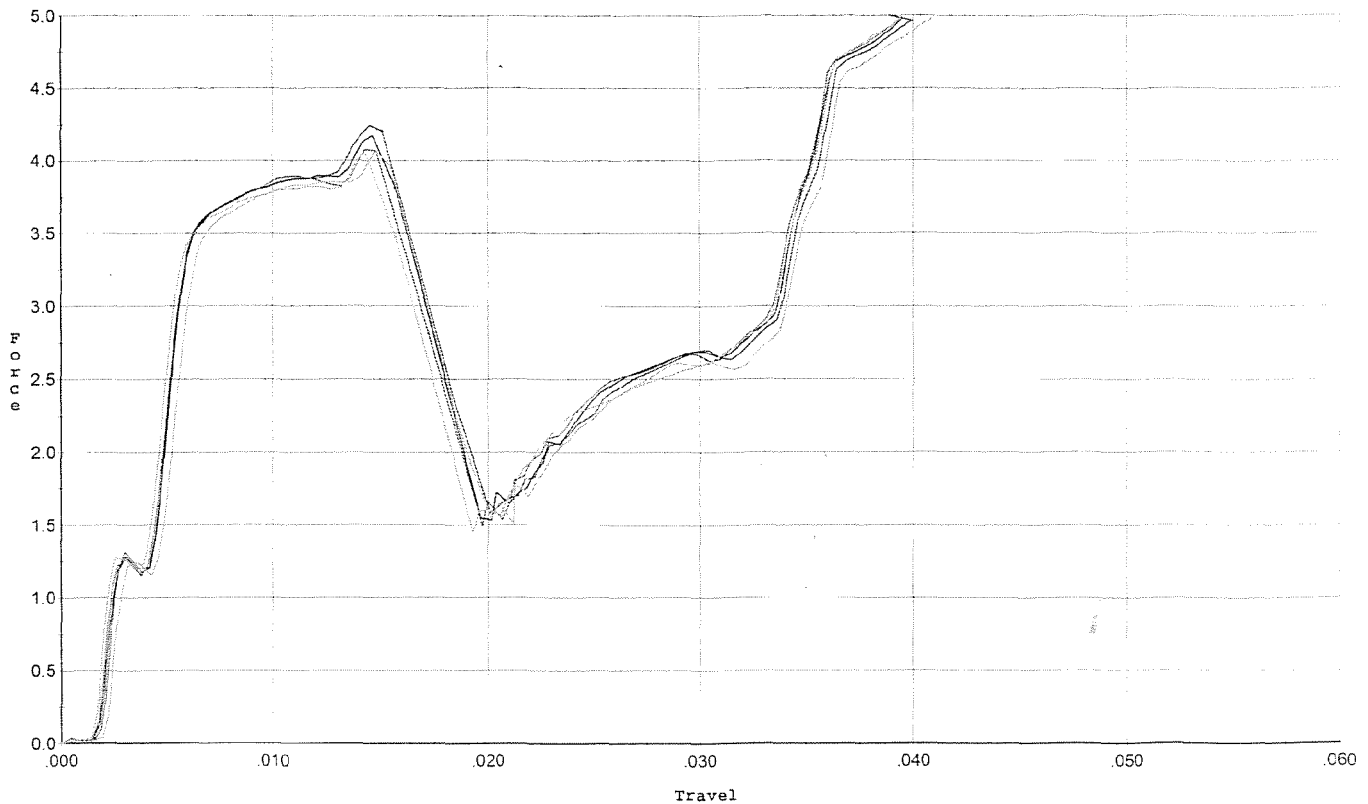
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.204	0.015	0.00	0.034	0.032		Set Trigger
2	3.097	0.016	0.00	0.034	0.032		Set Trigger
3	3.045	0.014	0.00	0.034	0.029		Set Trigger
4	3.073	0.015	0.00	0.034	0.030		Set Trigger
5	3.101	0.014	0.002	0.034	0.030		Set Trigger

A.3.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



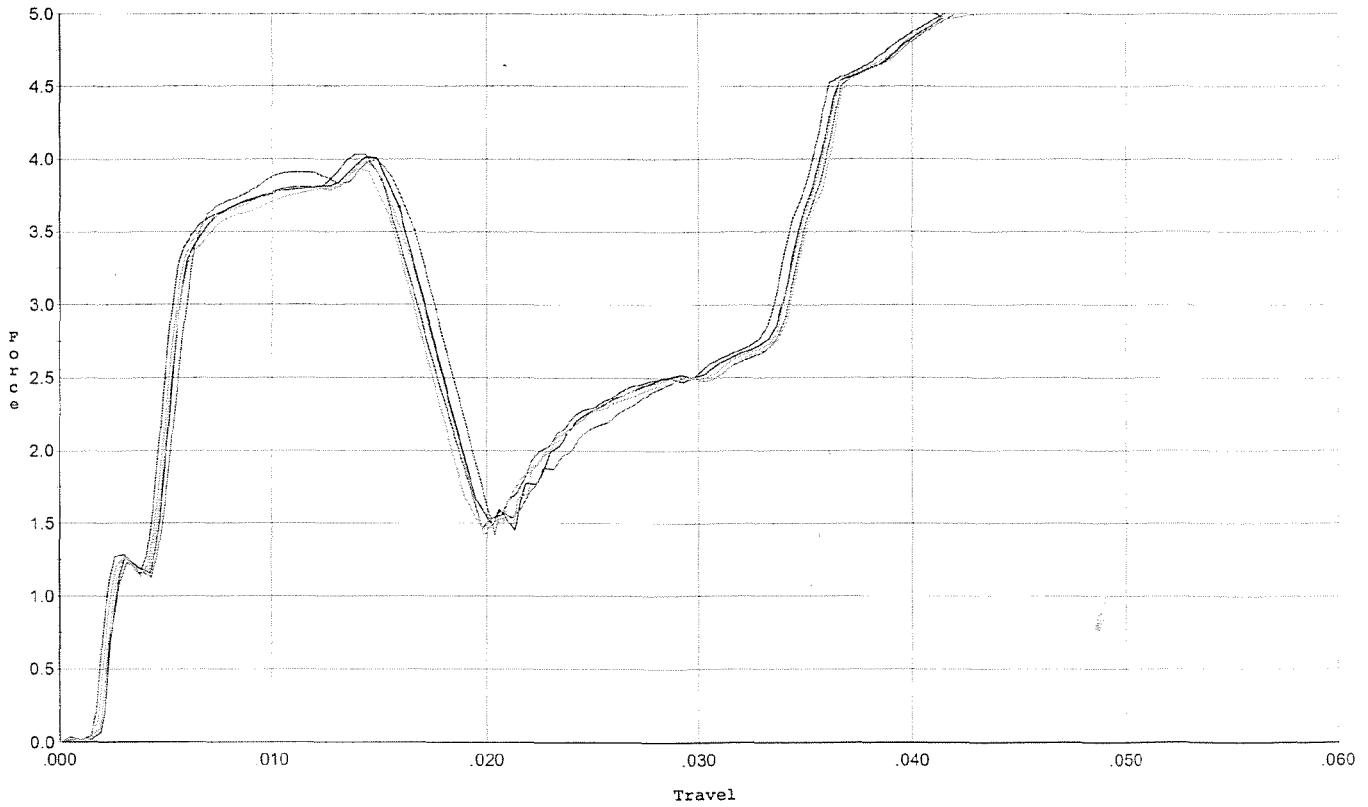
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.242	0.015	0.002	0.032	0.040		Set Trigger
2	4.174	0.016	0.00	0.032	0.041		Set Trigger
3	4.077	0.017	0.00	0.032	0.045		Set Trigger
4	4.058	0.016	0.004	0.032	0.041		Set Trigger
5	4.070	0.015	0.00	0.032	0.039		Set Trigger

A. 4.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



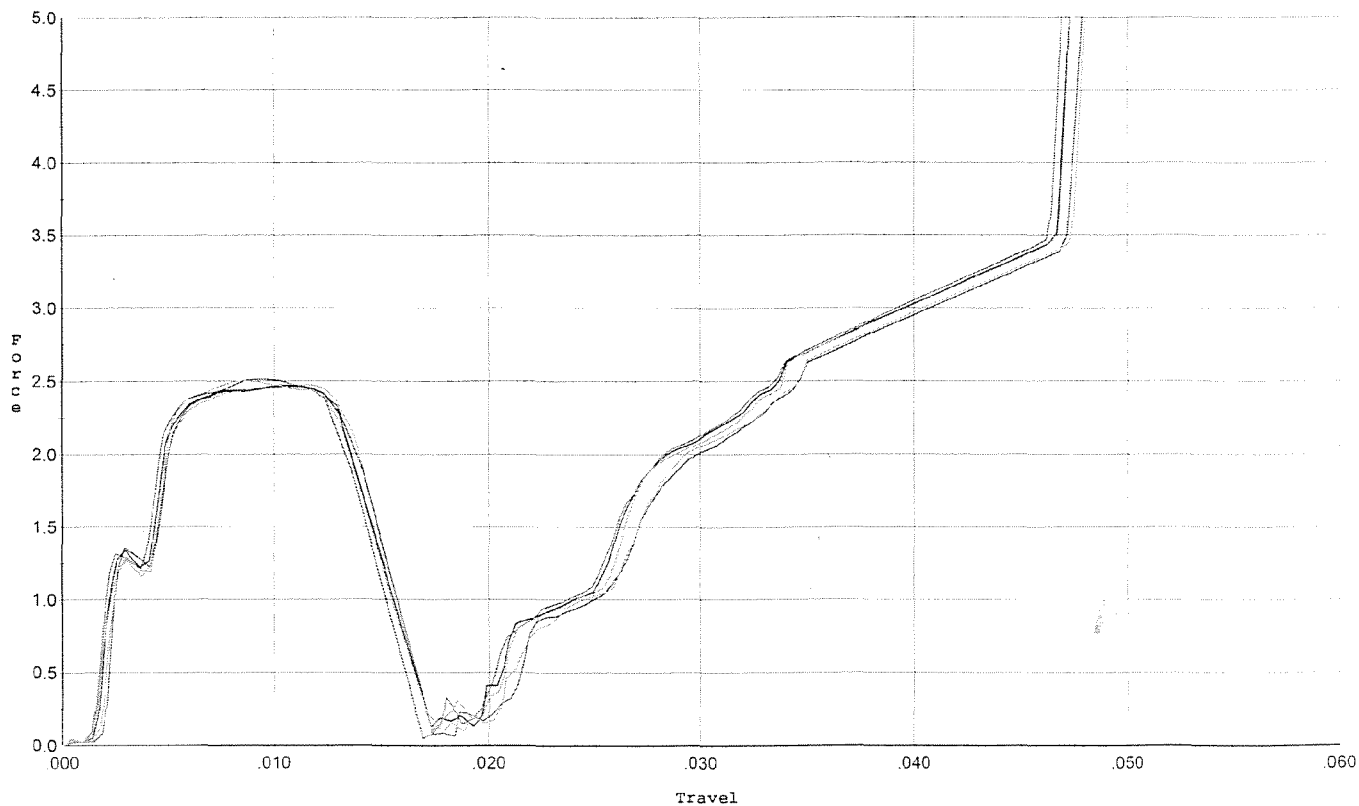
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.031	0.015	0.00	0.032	0.039		Set Trigger
2	4.015	0.016	0.002	0.032	0.040		Set Trigger
3	3.997	0.017	0.005	0.032	0.043		Set Trigger
4	3.988	0.016	0.00	0.032	0.041		Set Trigger
5	3.934	0.016	0.00	0.033	0.039		Set Trigger

A-3.99

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



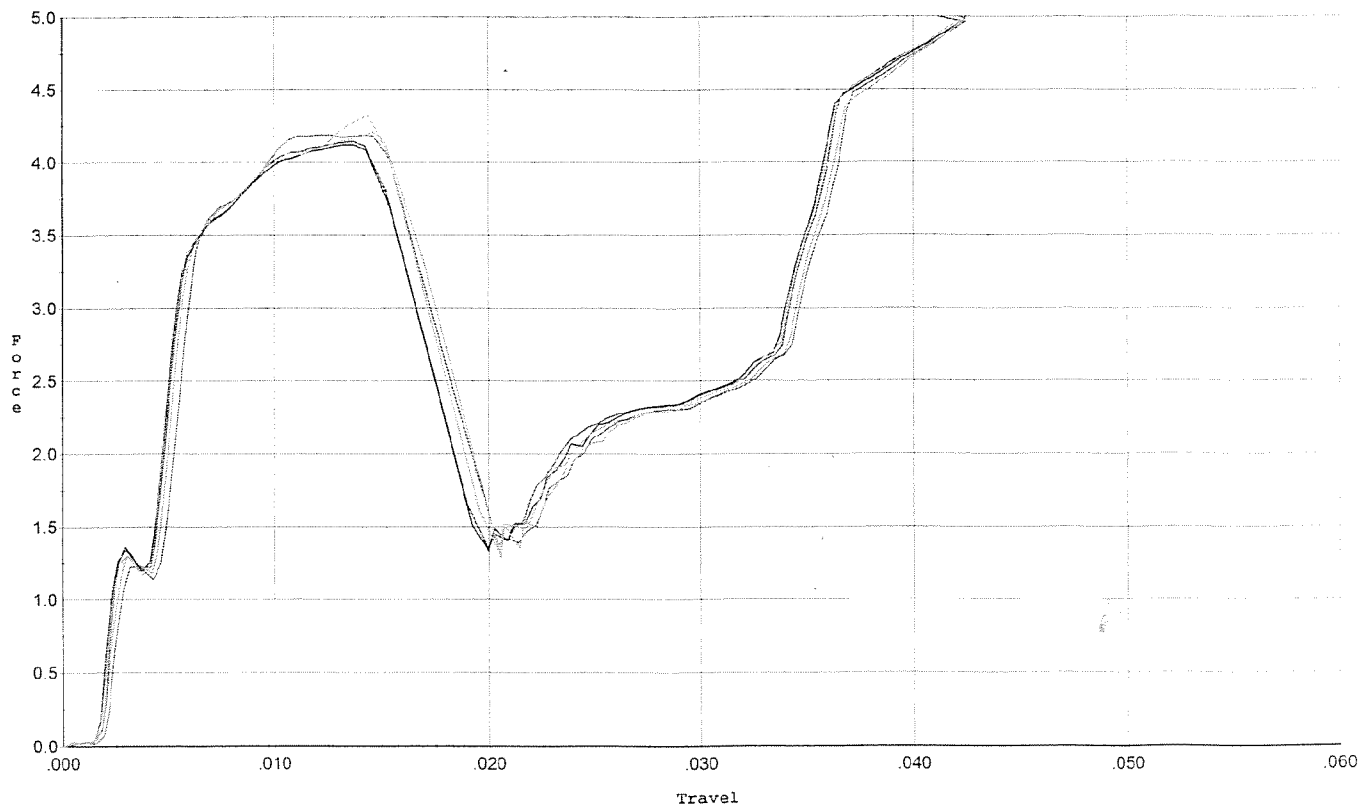
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.462	0.014	0.002	0.036	0.024		Set Trigger
2	2.470	0.013	0.00	0.036	0.022		Set Trigger
3	2.512	0.014	0.004	0.036	0.024		Set Trigger
4	2.477	0.014	0.002	0.036	0.023		Set Trigger
5	2.504	0.013	0.00	0.036	0.022		Set Trigger

A-2.48

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.144	0.015	0.004	0.033	0.040		Set Trigger
2	4.122	0.015	0.00	0.033	0.040		Set Trigger
3	4.187	0.015	0.005	0.033	0.040		Set Trigger
4	4.323	0.015	0.00	0.033	0.041		Set Trigger
5	4.206	0.017	0.004	0.032	0.045		Set Trigger

A-4.19