

G6785020

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

- INSTRUCTION BOOK 3518

BM FORM



G6785020

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6785020

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE		9-30-08	RT
475	DRILL AND TAP SIGHT HOLES		9-30-08	SP
480	MAGNAFLUX BBL ACTION		10/2/08	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/3/08	DB
542	APPLY COATINGS (BARREL ACTION)		10 9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-10-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-10-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-10-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-31-08	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

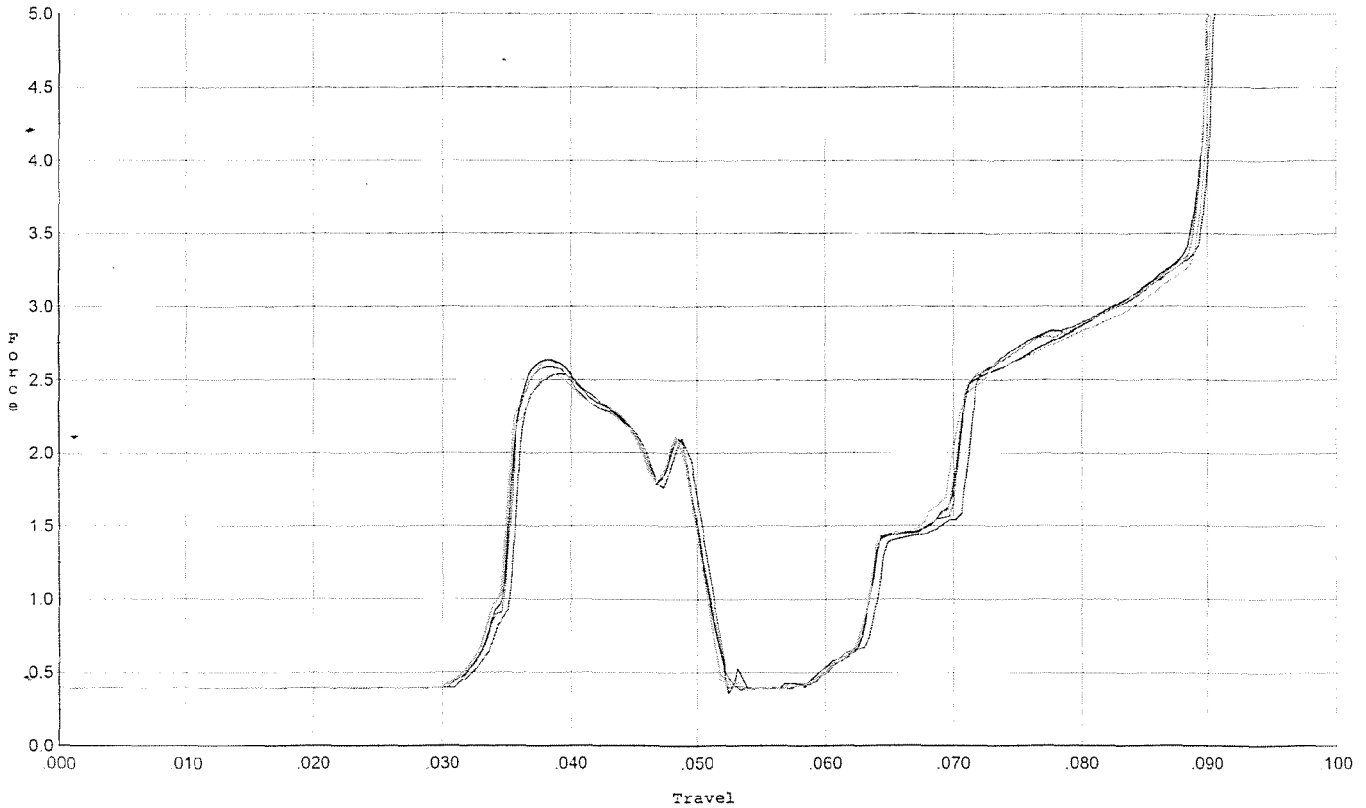
OP #	OPERATION NAME	2 LBS MIN 10 LBS MAX	READINGS			DATE	INITIAL
560	F) SAFETY ON FORCE		<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	11-6-08	R.N.
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u>	<u>5.0</u>	<u>5.0</u>	11-6-08	R.N.
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.024</u>	<u>.024</u>	11-6-08	R.N.
	J) ASSEMBLE STOCK					10-31-08	APD
	K) ASSEMBLE SWIVEL STUDS					11-6-08	R.N.
	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		11-3-08	TC
			<u>PASS</u>	FAIL			
	MALFUNCTION		CORRECTION N/A				
	MALFUNCTION						
	MALFUNCTION						
	MALFUNCTION						
660	INSPECT FOR LIVE AMMO					11-3-08	APD
670	FINAL INSPECTION A) HEADSPACE					11-6-08	R.N.
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u>	<u>2.55</u>	<u>2.56</u> <u>2.55</u> <u>2.51</u>	11-5-08	FM
	C) FUNCTION					11-6-08	R.N.
690	PACK					11/10/08	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



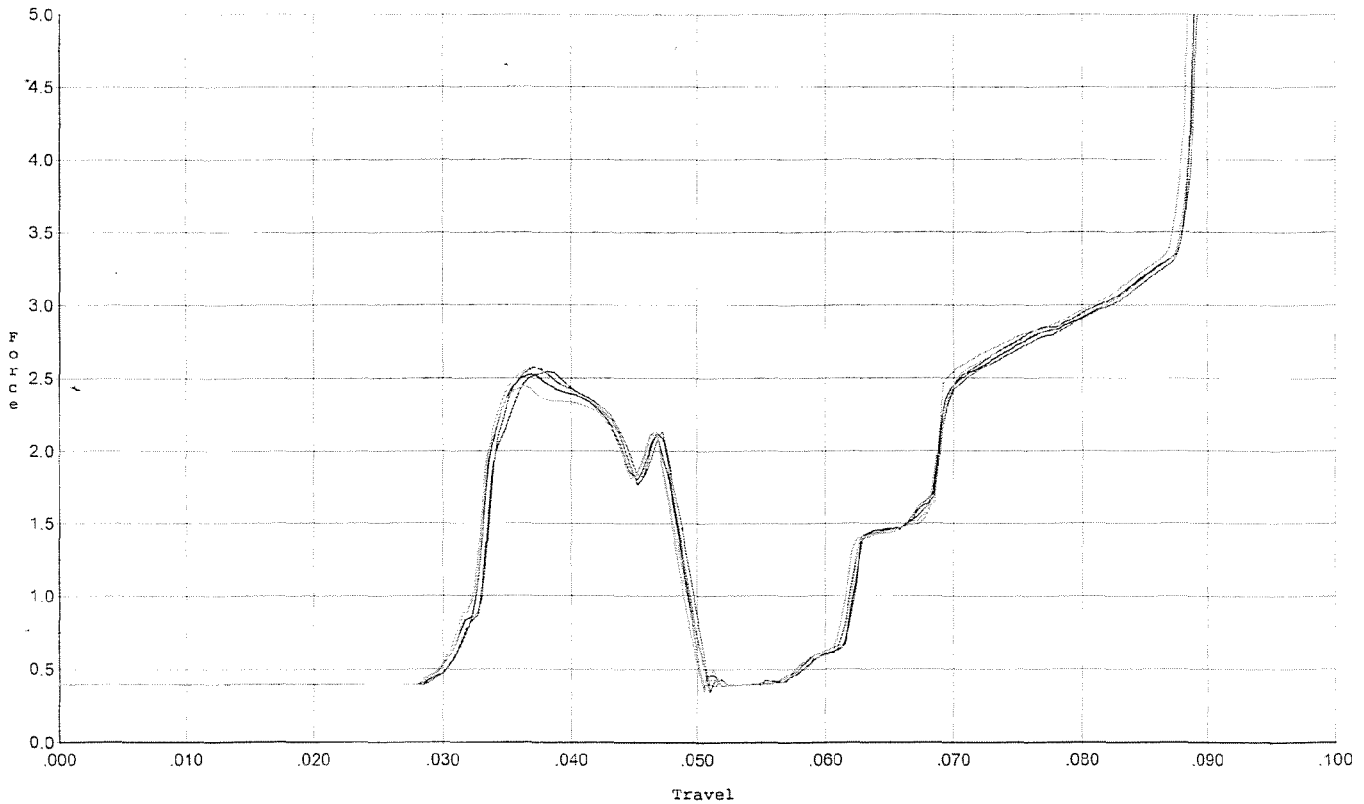
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.541	0.050	0.034	0.045	0.047		Set Trigger
2	2.634	0.049	0.033	0.045	0.047		Set Trigger
3	2.590	0.049	0.033	0.045	0.047		Set Trigger
4	2.540	0.049	0.033	0.045	0.047		Set Trigger
5	2.626	0.049	0.033	0.045	0.048		Set Trigger

Avg 2.58

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



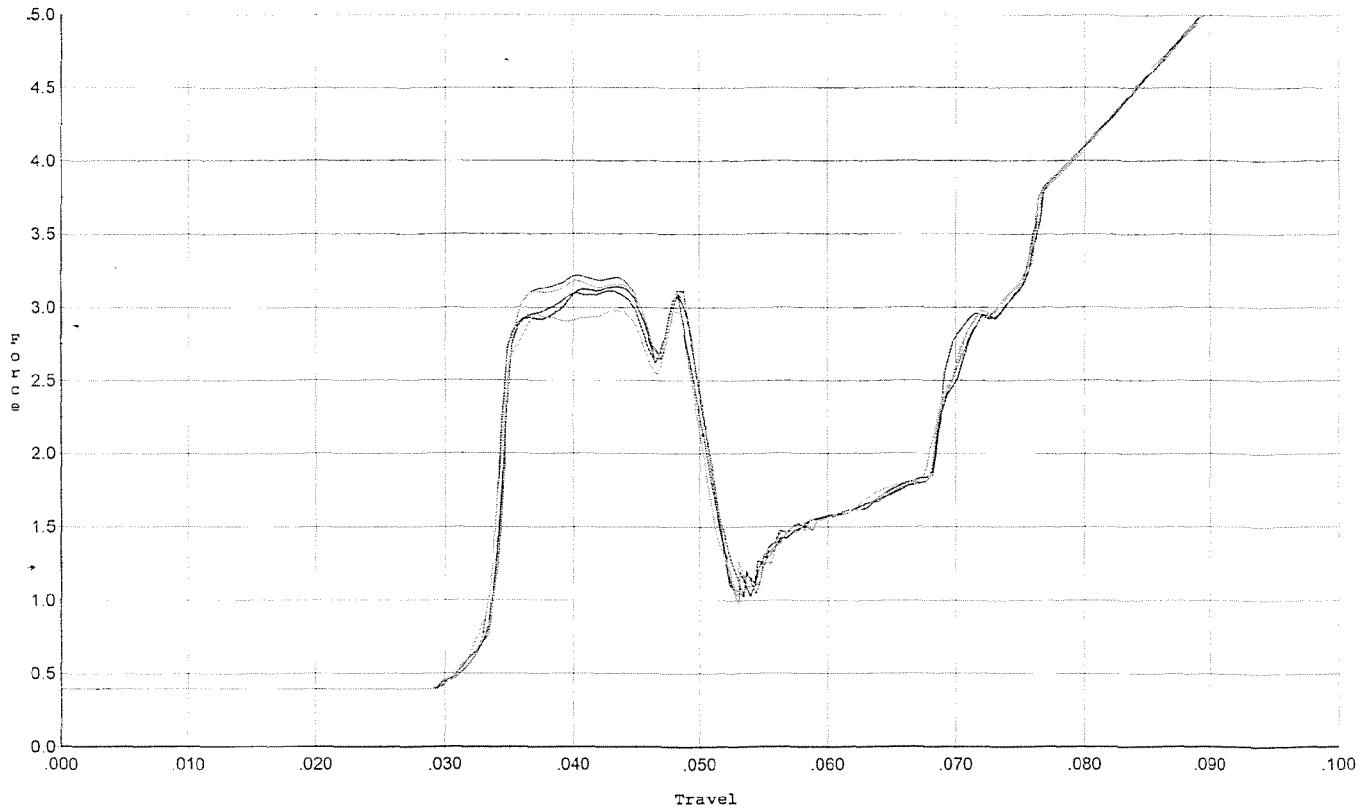
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.547	0.047	0.031	0.045	0.046		Set Trigger
2	2.520	0.048	0.031	0.046	0.047		Set Trigger
3	2.571	0.049	0.031	0.045	0.048		Set Trigger
4	2.574	0.049	0.030	0.045	0.048		Set Trigger
5	2.445	0.047	0.030	0.045	0.046		Set Trigger

Aug 2.53

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



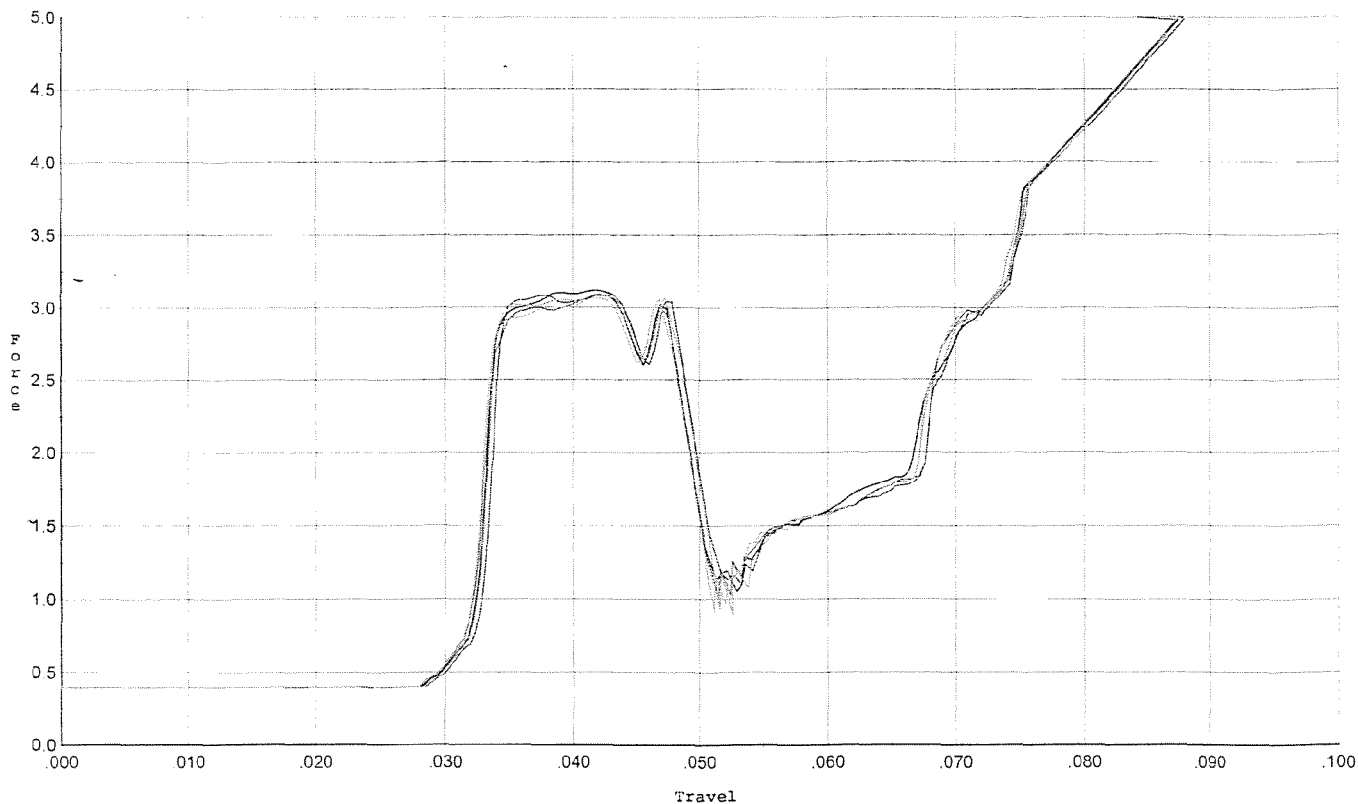
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.112	0.050	0.033	0.041	0.062		Set Trigger
2	3.140	0.049	0.032	0.041	0.060		Set Trigger
3	3.220	0.049	0.033	0.041	0.061		Set Trigger
4	2.980	0.048	0.032	0.042	0.058		Set Trigger
5	3.185	0.049	0.032	0.041	0.061		Set Trigger

AUG 3.12

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



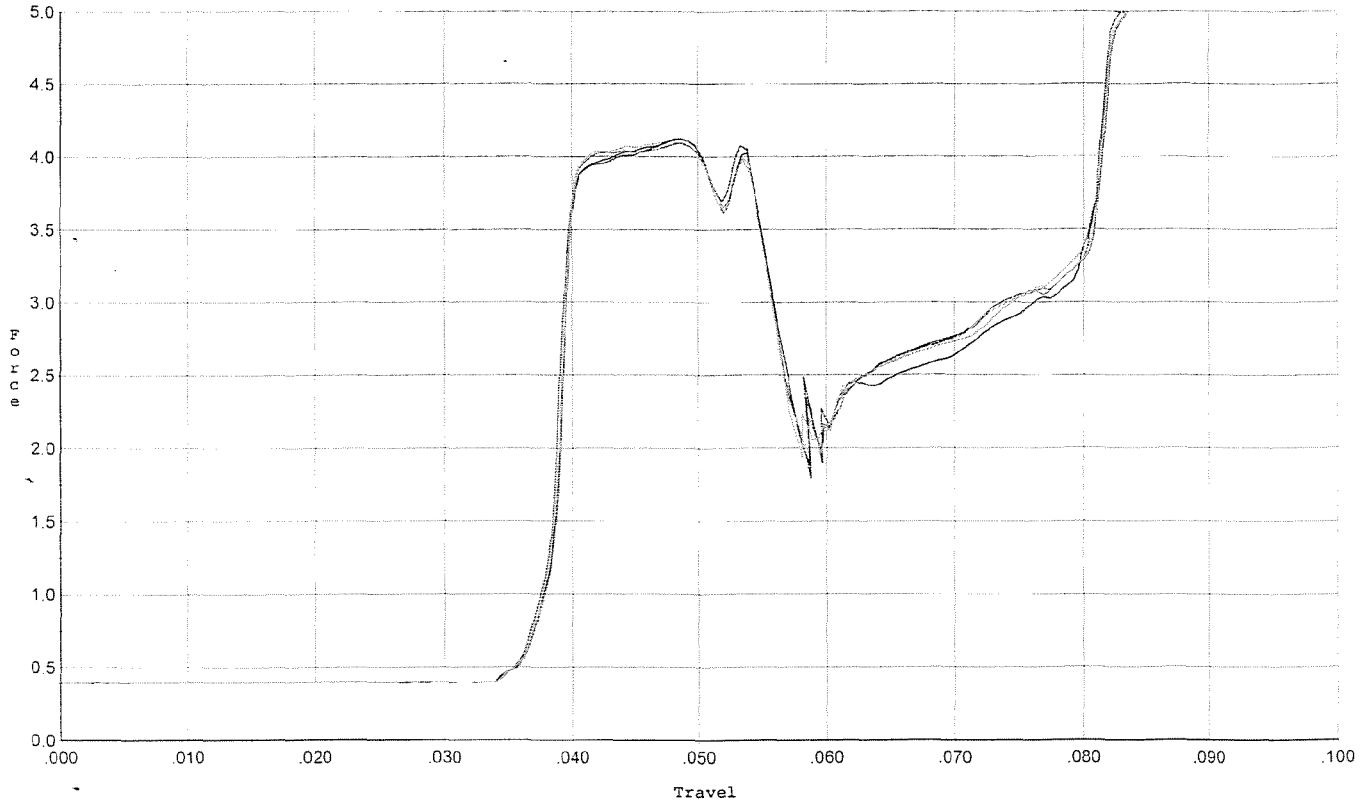
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.097	0.048	0.032	0.041	0.059		Set Trigger
2	3.120	0.047	0.031	0.041	0.059		Set Trigger
3	3.083	0.048	0.031	0.041	0.059		Set Trigger
4	3.065	0.048	0.031	0.041	0.059		Set Trigger
5	3.094	0.048	0.031	0.041	0.060		Set Trigger

Aug 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



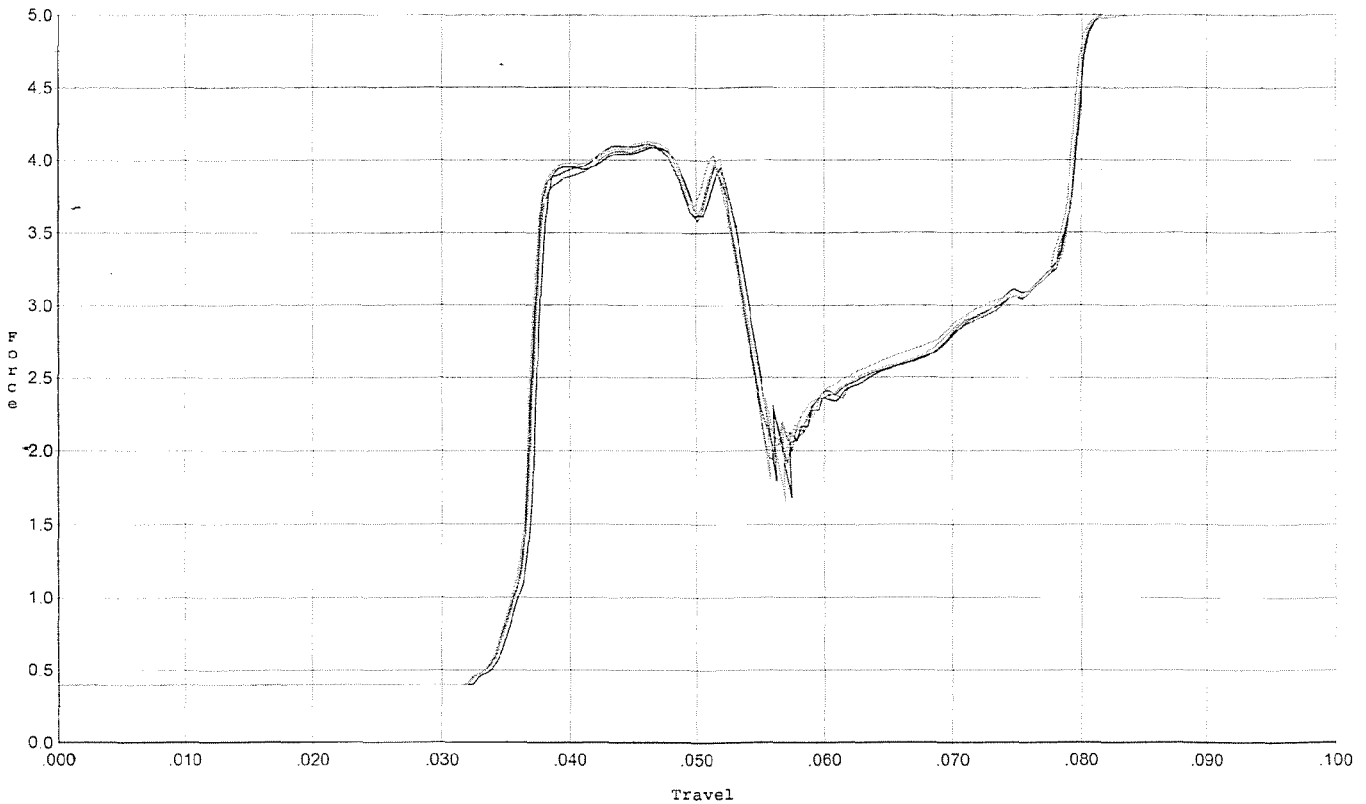
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.128	0.054	0.036	0.037	0.080		Set Trigger
2	4.123	0.054	0.037	0.037	0.080		Set Trigger
3	4.093	0.054	0.037	0.037	0.080		Set Trigger
4	4.084	0.054	0.037	0.037	0.080		Set Trigger
5	4.125	0.054	0.036	0.037	0.080		Set Trigger

Aug 4.11

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



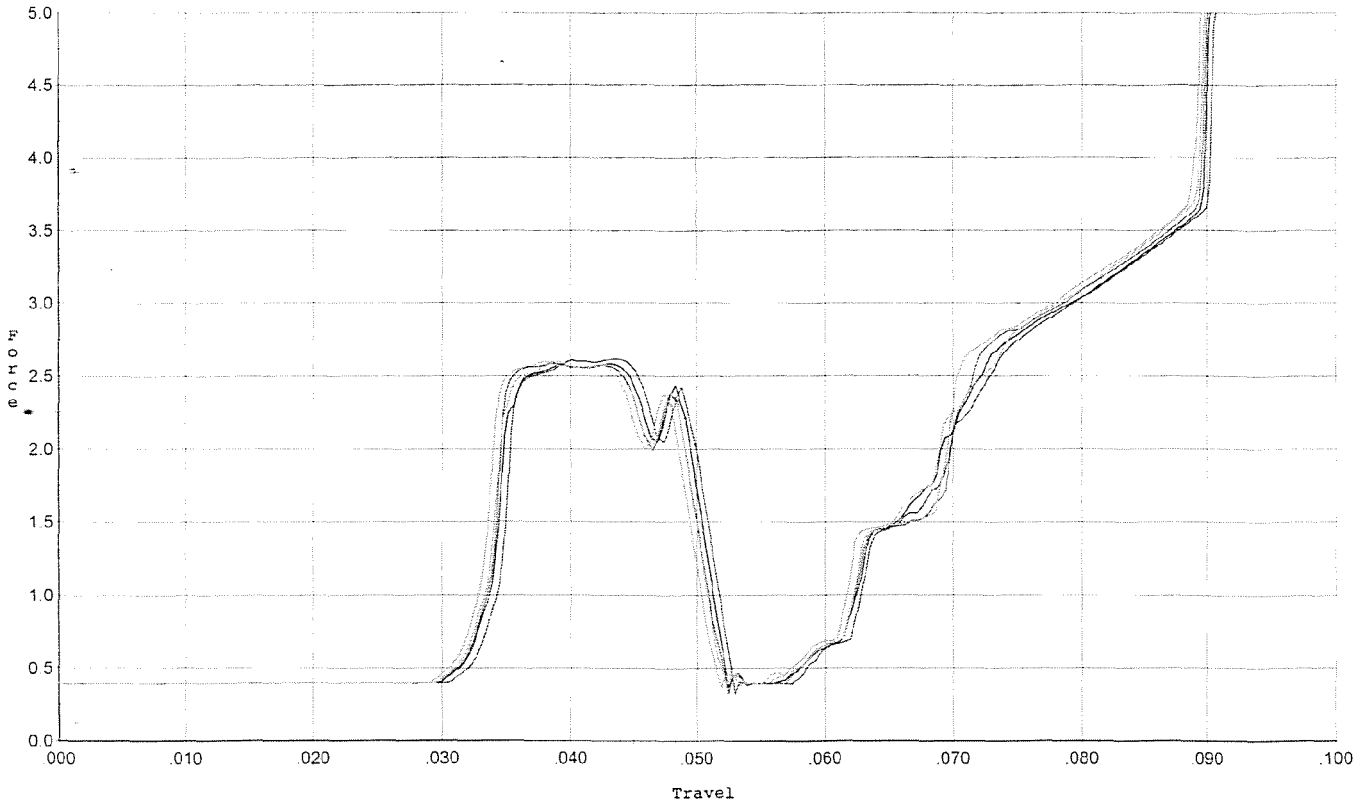
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.106	0.052	0.034	0.036	0.080		Set Trigger
2	4.087	0.053	0.035	0.037	0.081		Set Trigger
3	4.094	0.052	0.034	0.036	0.079		Set Trigger
4	4.119	0.052	0.035	0.036	0.079		Set Trigger
5	4.128	0.053	0.034	0.036	0.081		Set Trigger

AUG 4.10

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R, Putch 10/27/08

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



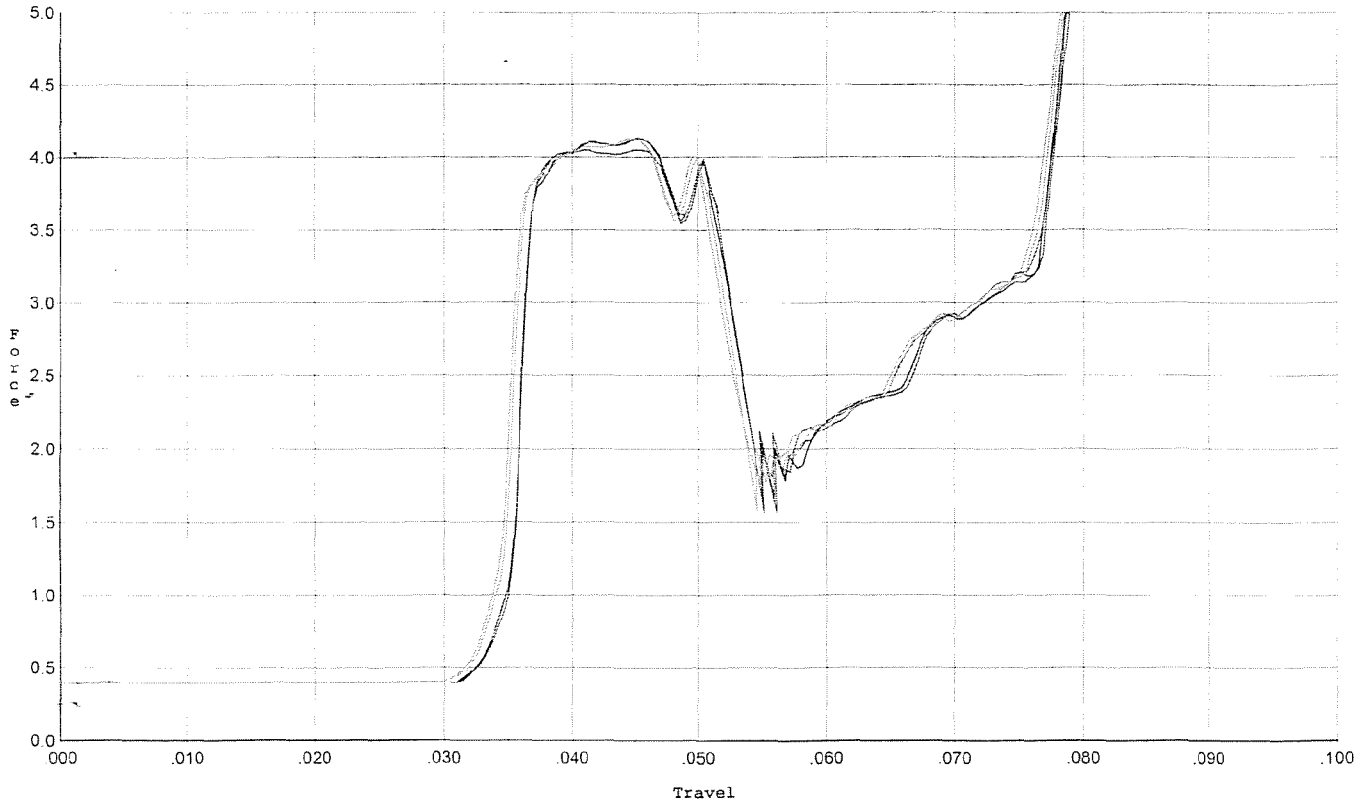
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.622	0.050	0.033	0.044	0.052		Set Trigger
2	2.586	0.049	0.032	0.044	0.052		Set Trigger
3	2.591	0.048	0.032	0.044	0.051		Set Trigger
4	2.601	0.049	0.032	0.044	0.051		Set Trigger
5	2.601	0.048	0.032	0.044	0.051		Set Trigger

Aug 2.60

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R, Putch 10/27/08

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.048	0.051	0.034	0.037	0.079		Set Trigger
2	4.133	0.052	0.033	0.037	0.080		Set Trigger
3	4.132	0.051	0.034	0.037	0.079		Set Trigger
4	4.124	0.051	0.033	0.037	0.079		Set Trigger
5	4.131	0.050	0.033	0.037	0.078		Set Trigger

Aug 4.11