

G6785082

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

- INSTRUCTION BOOK 3518

BM FORM

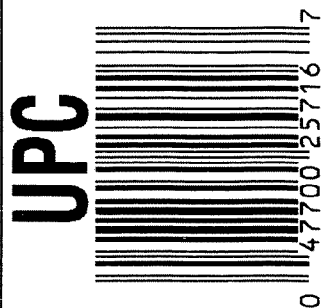


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785082



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6785082

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SP
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	L.P.N.
460	CHECK HEADSPACE		9-19-08	L.P.N.
470	DIS-ASSEMBLE ACTION		9-19-08	SP
472	SERIALIZE BOLT HANDLE		9-20-08	RBN
475	DRILL AND TAP SIGHT HOLES		9-20-08	SP
480	MAGNAFLUX BBL ACTION		9-22-08	BH
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9/23/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		9-24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-16-08	RBN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

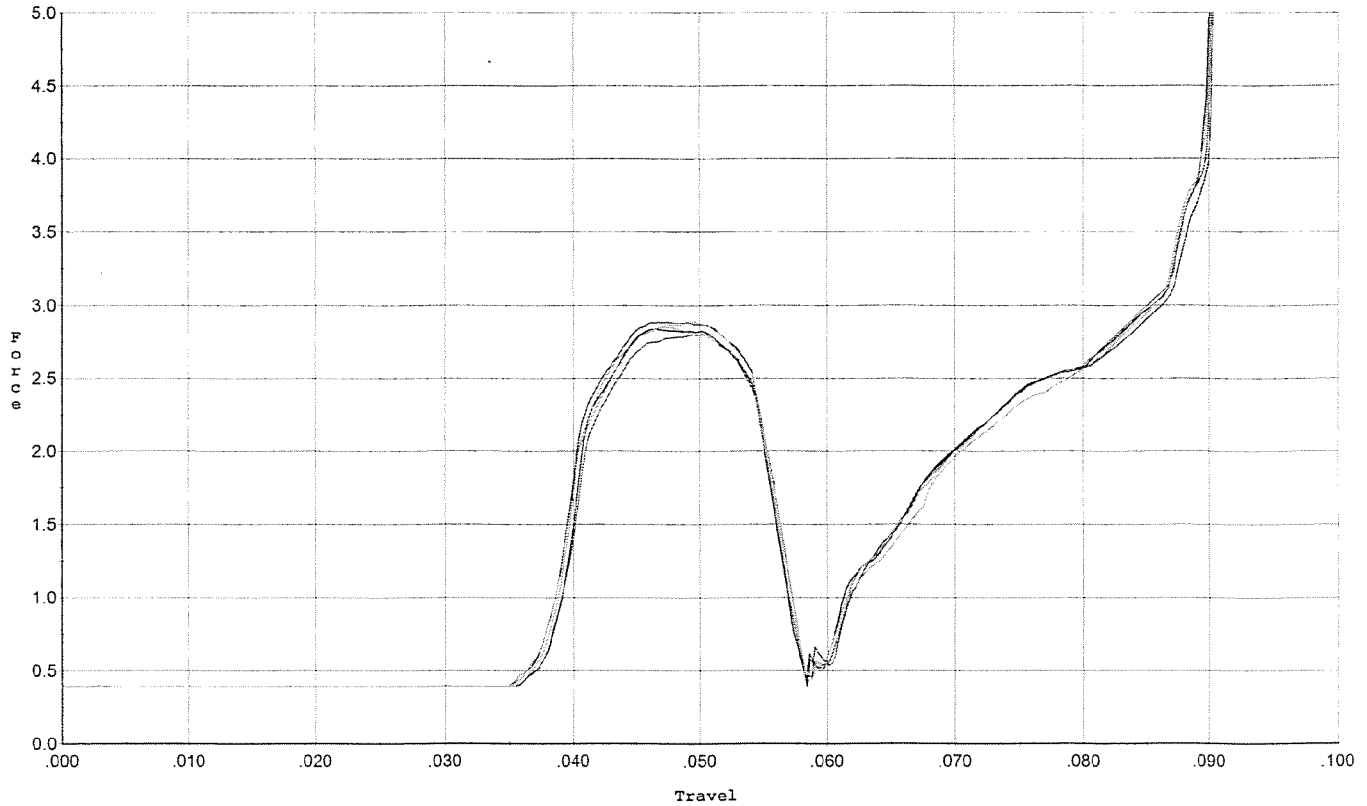
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-27-08	L.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	10-27-08	L.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-27-08	L.D.
	J) ASSEMBLE STOCK		10-16-08	Rsn
	K) ASSEMBLE SWIVEL STUDS		10-27-08	L.D.
	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> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10-23-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-23-08	Rsn
670	FINAL INSPECTION A) HEADSPACE		10-27-08	L.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>239</u> <u>244</u> <u>244</u> <u>234</u> <u>234</u>	10-27-08	Rsn
	C) FUNCTION		10-27-08	L.D.
690	PACK		10/29/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



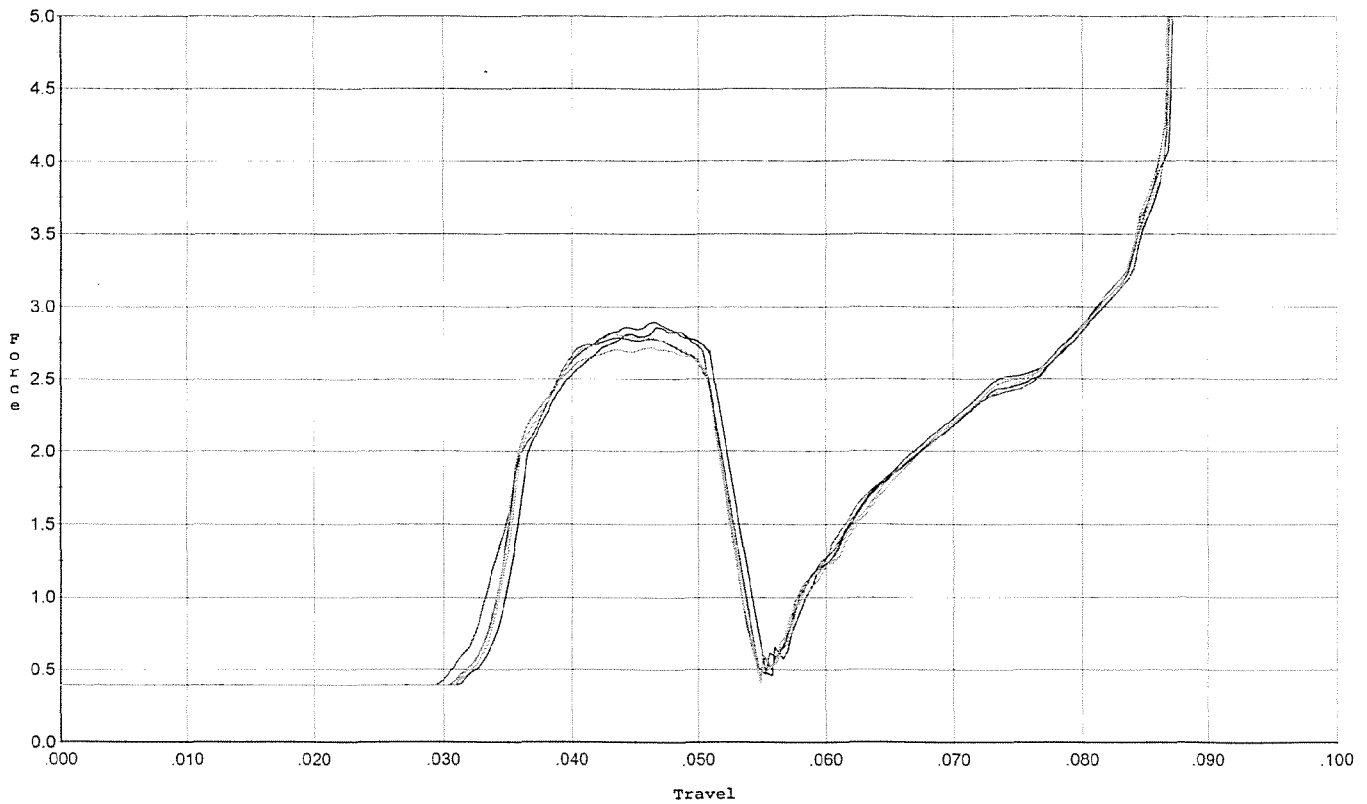
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.888	0.056	0.037	0.039	0.060		Set Trigger
2	2.838	0.054	0.038	0.040	0.056		Set Trigger
3	2.802	0.054	0.038	0.040	0.055		Set Trigger
4	2.896	0.056	0.038	0.039	0.059		Set Trigger
5	2.853	0.054	0.037	0.040	0.057		Set Trigger

A - 2.85

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



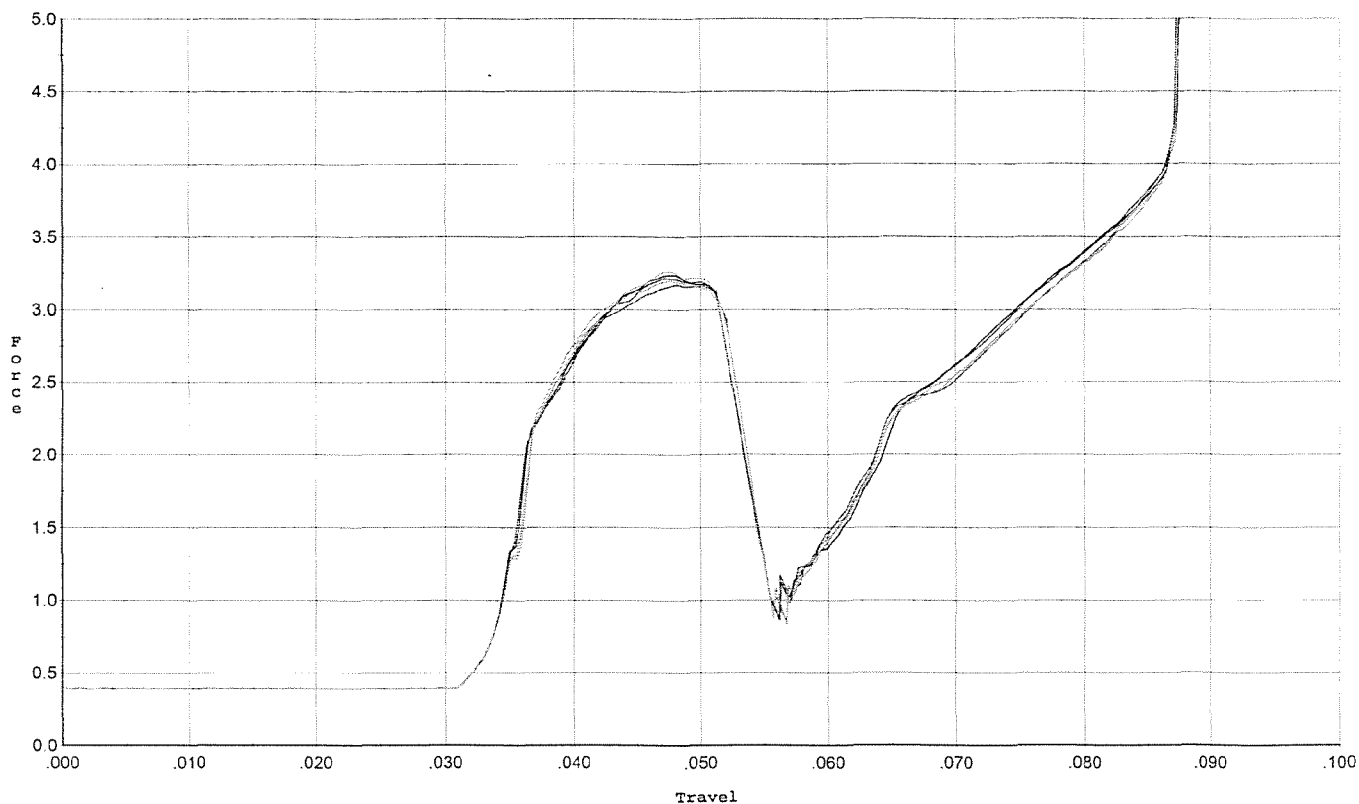
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.896	0.052	0.031	0.038	0.060		Set Trigger
2	2.858	0.051	0.034	0.038	0.057		Set Trigger
3	2.787	0.051	0.033	0.038	0.057		Set Trigger
4	2.814	0.051	0.033	0.039	0.056		Set Trigger
5	2.723	0.051	0.033	0.038	0.056		Set Trigger

A-2-81

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/13/2008

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



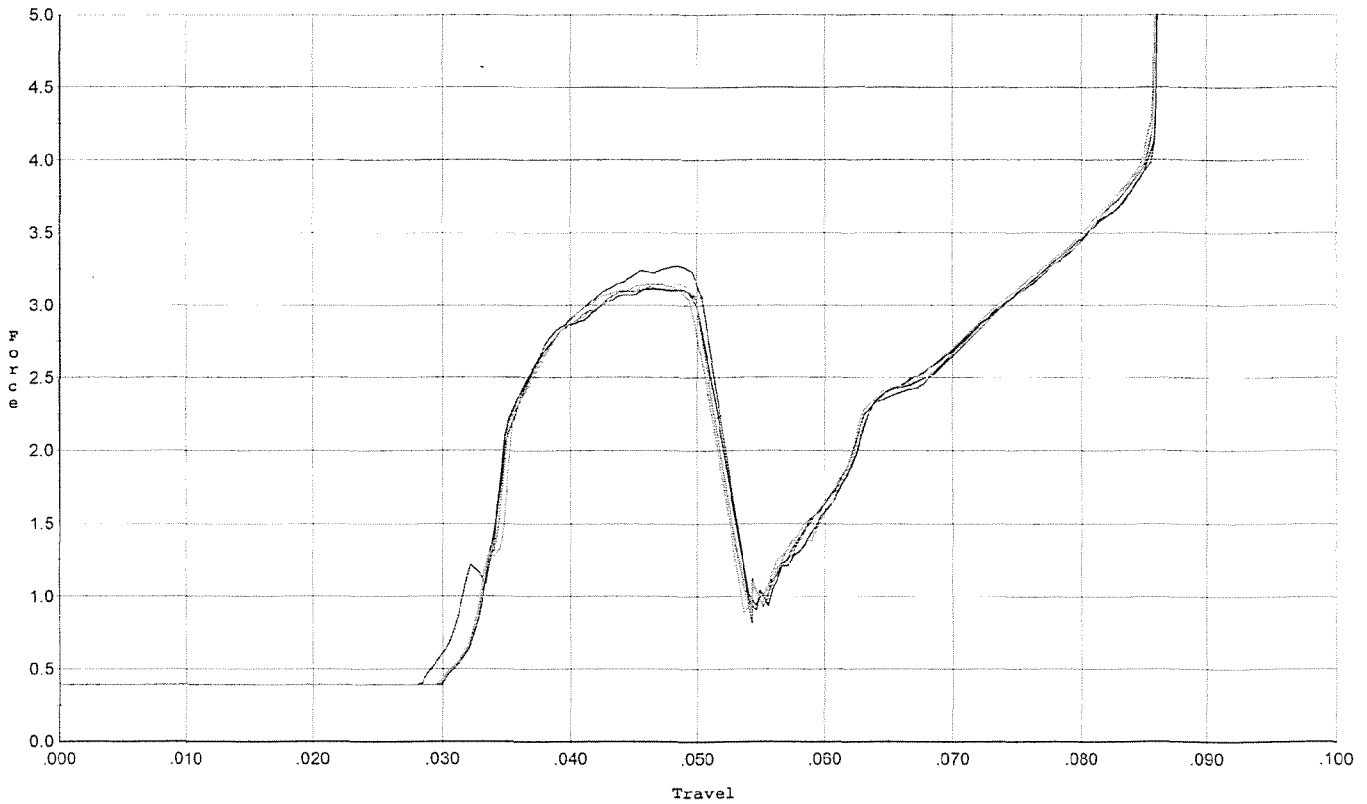
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.215	0.051	0.033	0.038	0.063		Set Trigger
2	3.235	0.051	0.032	0.037	0.063		Set Trigger
3	3.172	0.052	0.033	0.037	0.064		Set Trigger
4	3.199	0.051	0.033	0.037	0.063		Set Trigger
5	3.259	0.052	0.033	0.037	0.065		Set Trigger

A-3-21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



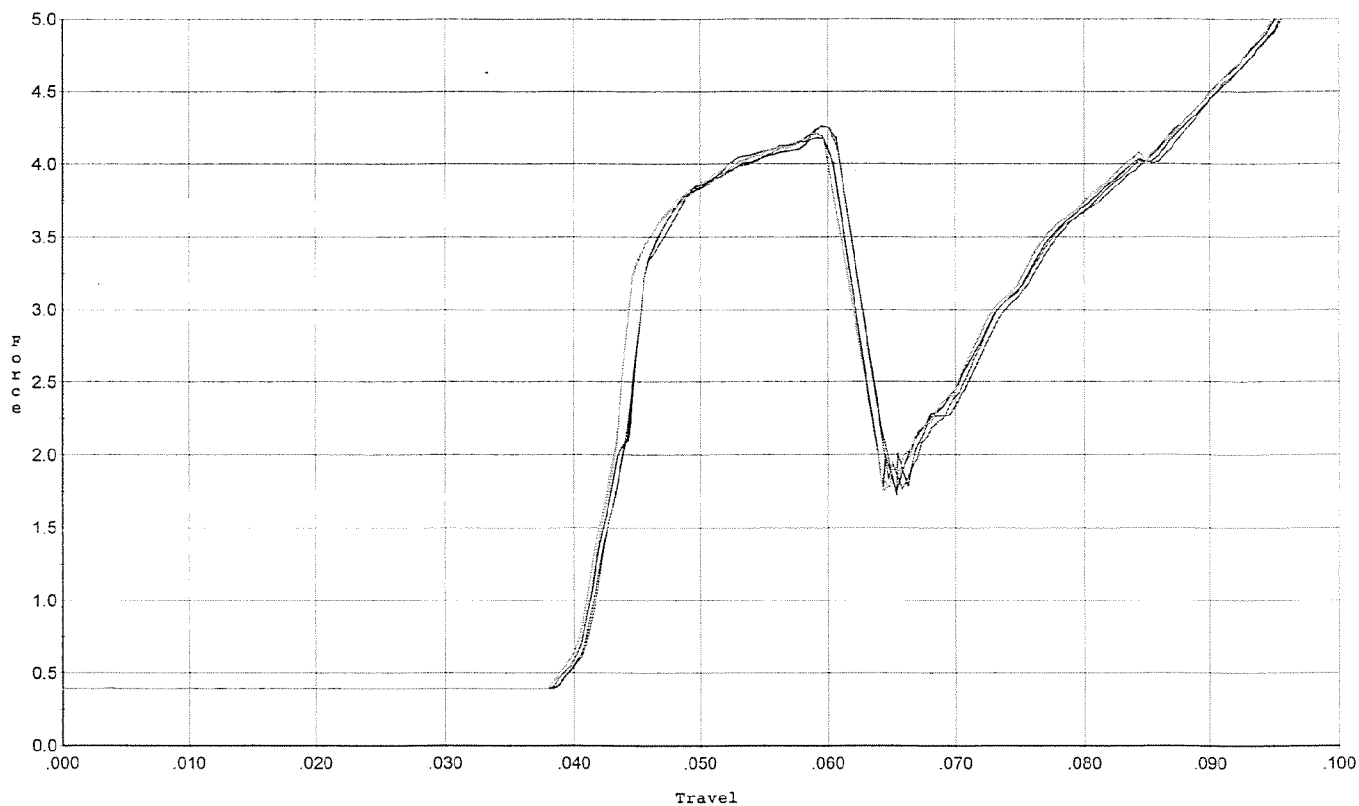
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.271	0.050	0.029	0.037	0.065		Set Trigger
2	3.110	0.052	0.030	0.037	0.064		Set Trigger
3	3.126	0.050	0.030	0.037	0.062		Set Trigger
4	3.151	0.050	0.030	0.037	0.062		Set Trigger
5	3.141	0.051	0.032	0.037	0.063		Set Trigger

A-3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



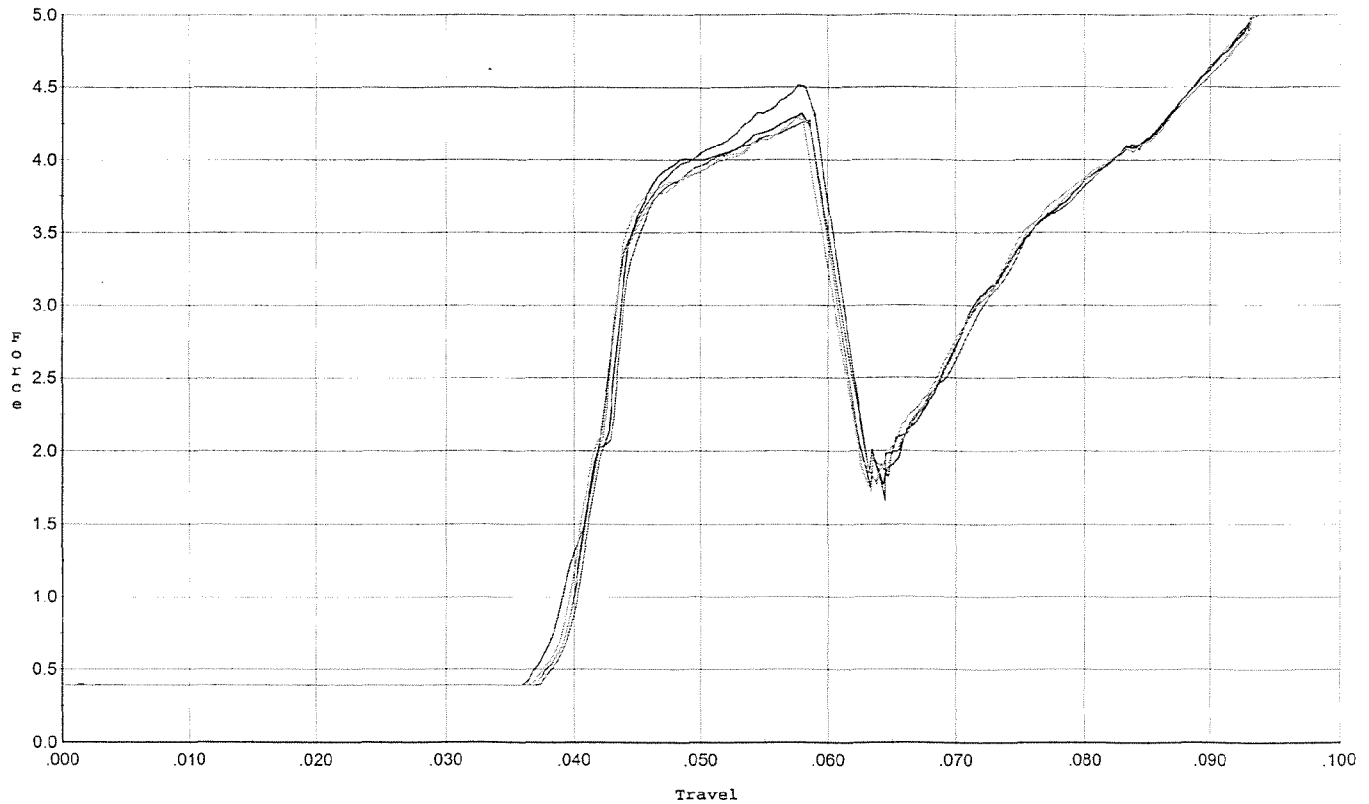
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.263	0.061	0.041	0.038	0.089		Set Trigger
2	4.182	0.060	0.039	0.038	0.088		Set Trigger
3	4.261	0.061	0.039	0.038	0.089		Set Trigger
4	4.209	0.062	0.039	0.037	0.091		Set Trigger
5	4.210	0.062	0.040	0.037	0.091		Set Trigger

A-4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



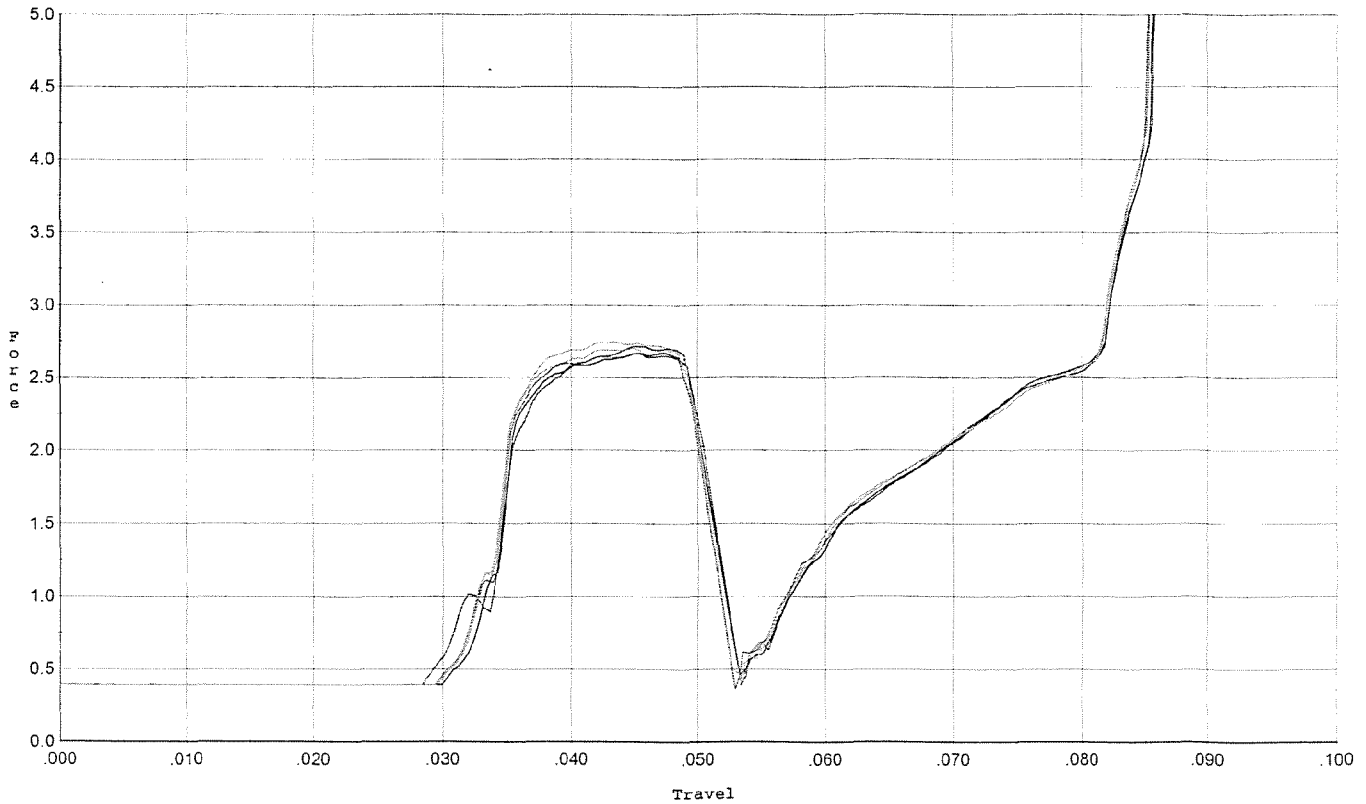
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.514	0.059	0.037	0.037	0.092		Set Trigger
2	4.318	0.059	0.038	0.038	0.088		Set Trigger
3	4.269	0.059	0.038	0.038	0.086		Set Trigger
4	4.305	0.059	0.038	0.037	0.087		Set Trigger
5	4.289	0.058	0.037	0.038	0.086		Set Trigger

A-4-33

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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



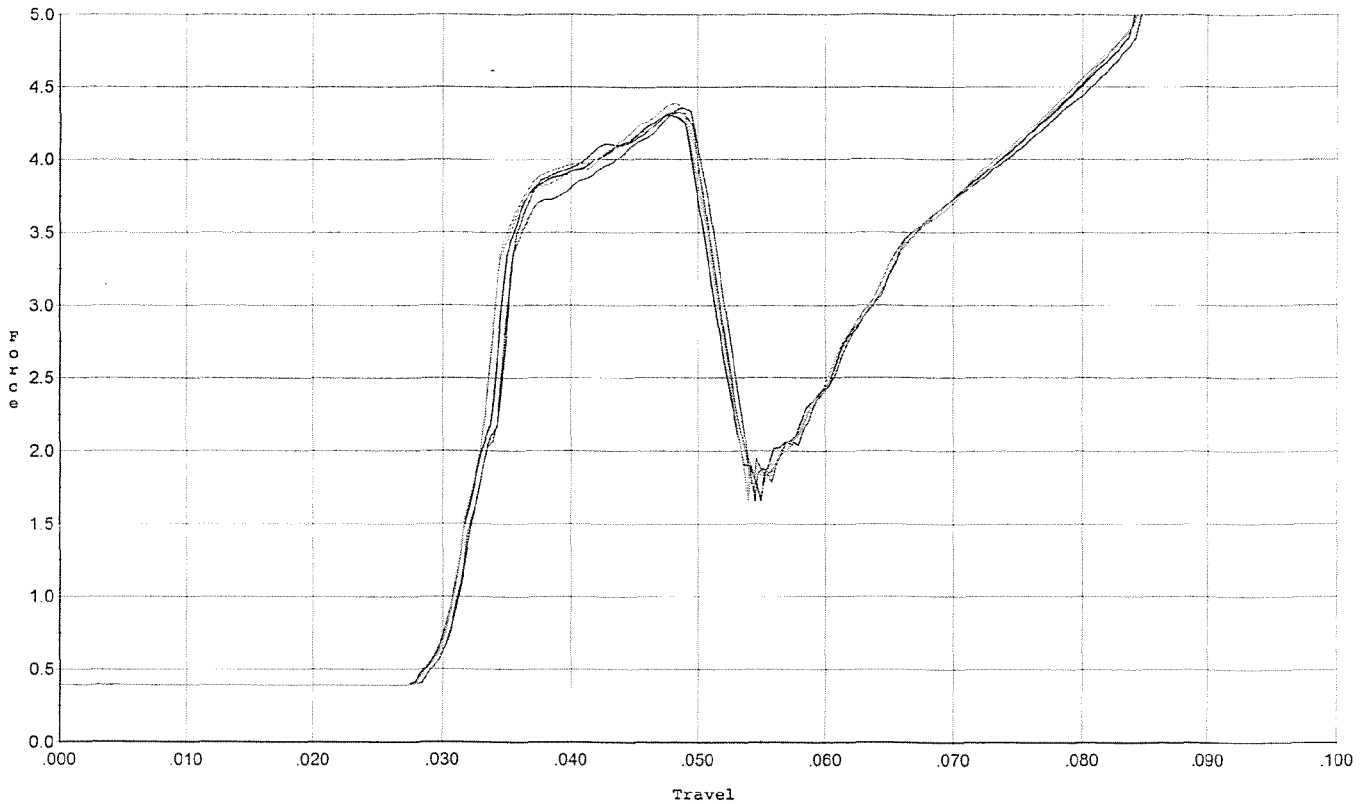
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.713	0.050	0.030	0.038	0.056		Set Trigger
2	2.669	0.051	0.032	0.038	0.056		Set Trigger
3	2.664	0.049	0.032	0.038	0.054		Set Trigger
4	2.701	0.049	0.030	0.038	0.054		Set Trigger
5	2.748	0.049	0.032	0.038	0.055		Set Trigger

A-2.69

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/13/2008

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	4.355	0.051	0.029	0.034	0.086		Set Trigger
2	4.301	0.049	0.028	0.034	0.082		Set Trigger
3	4.323	0.050	0.029	0.034	0.081		Set Trigger
4	4.327	0.051	0.028	0.034	0.086		Set Trigger
5	4.385	0.050	0.028	0.034	0.085		Set Trigger

A - 4.33