

G6785096

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

- INSTRUCTION BOOK 3518

BM FORM

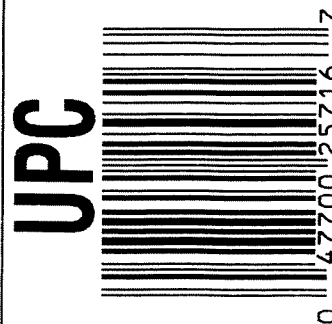


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6785096



GUN SERIAL # G 6785096

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-19-08	SPD
430	ASSEMBLE TO STOCK		9-19-08	SP
440	PROOF		9-19-08	SPD
460	CHECK HEADSPACE		9-19-08	SPD
470	DIS-ASSEMBLE ACTION		9-19-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-7-08	RTZ
475	DRILL AND TAP SIGHT HOLES	2000	10-7-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	10/8/08	(KB)
490	MAGNAFLUX BOLT		9-19-08	RTZ
500	ROLLMARK CALIBER		10/8/08	RT
520	GOFF BLAST BBL / REC		10/9/08	DS
542	APPLY COATINGS (BARREL ACTION)		10/13	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-13-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-13-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-13-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-12-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

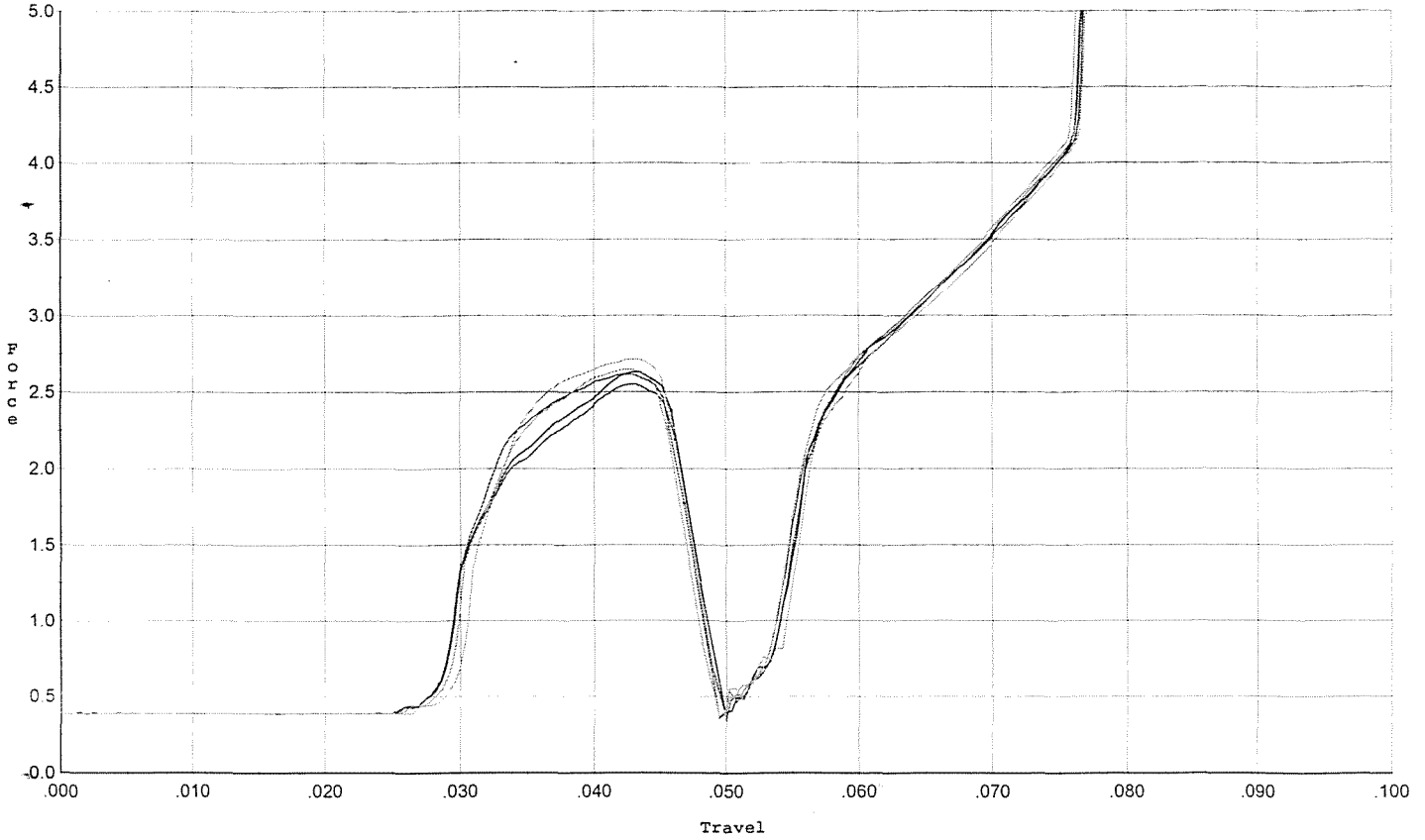
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	4.0	3.5	3.5	11-18-08	LN		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	5.0	5.0	5.0	11-18-08	LN		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.023	11-18-08	LN		
	J) ASSEMBLE STOCK					11-12-08	RTZ		
	K) ASSEMBLE SWIVEL STUDS					11-18-08	LN		
	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		11-13-08	TL		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					11-13-08	JH		
670	FINAL INSPECTION A) HEADSPACE					11-18-08	LN		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.63	2.73	2.69	2.61	2.53	11-14-08	TL
	C) FUNCTION					11-18-08	LN		
690	PACK					12-2-08	TL		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 11/07/2008

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



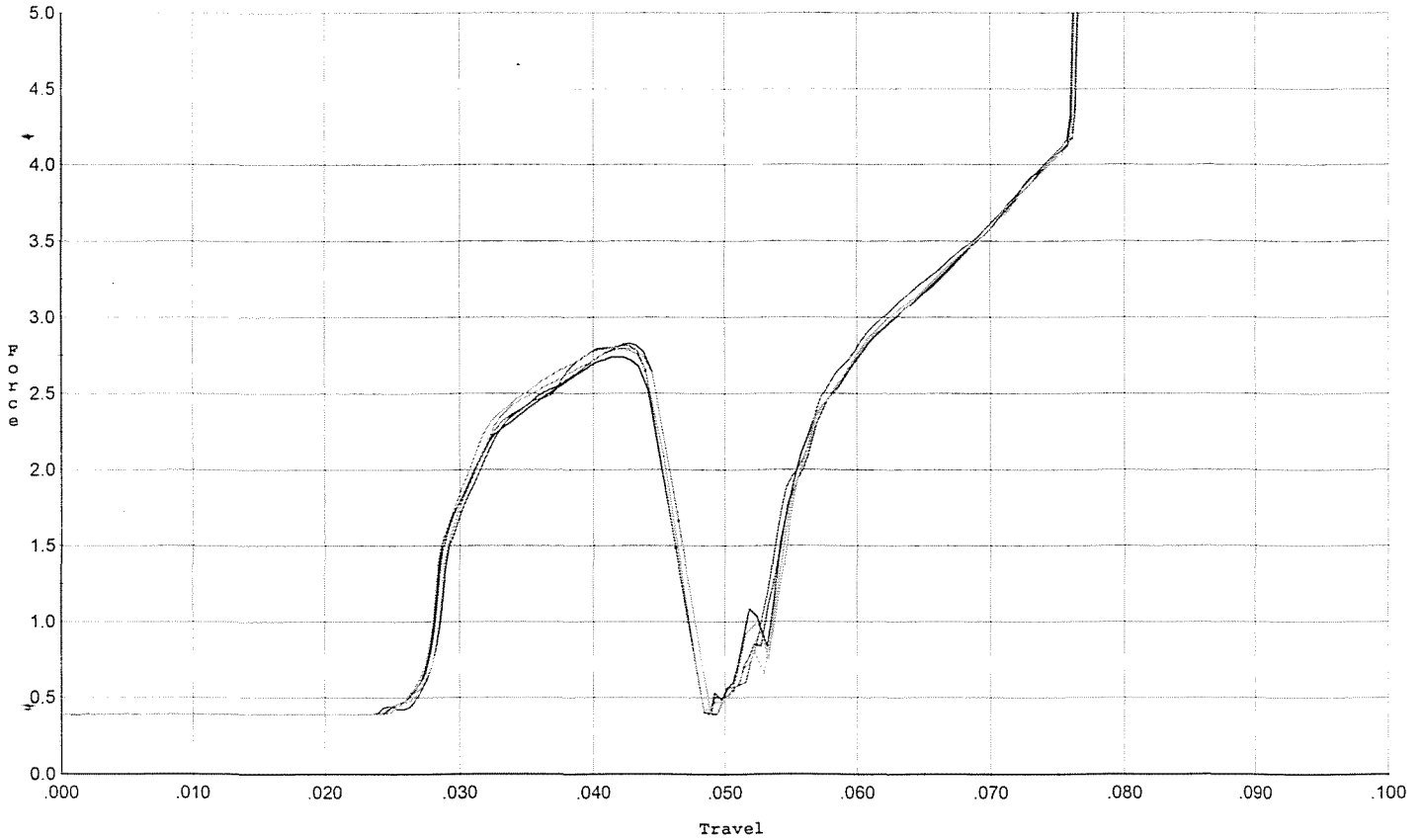
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.553	0.046	0.029	0.034	0.049		Set Trigger
2	2.632	0.046	0.029	0.034	0.049		Set Trigger
3	2.616	0.047	0.029	0.034	0.051		Set Trigger
4	2.713	0.046	0.030	0.034	0.050		Set Trigger
5	2.647	0.046	0.029	0.034	0.049		Set Trigger

A-2.63

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



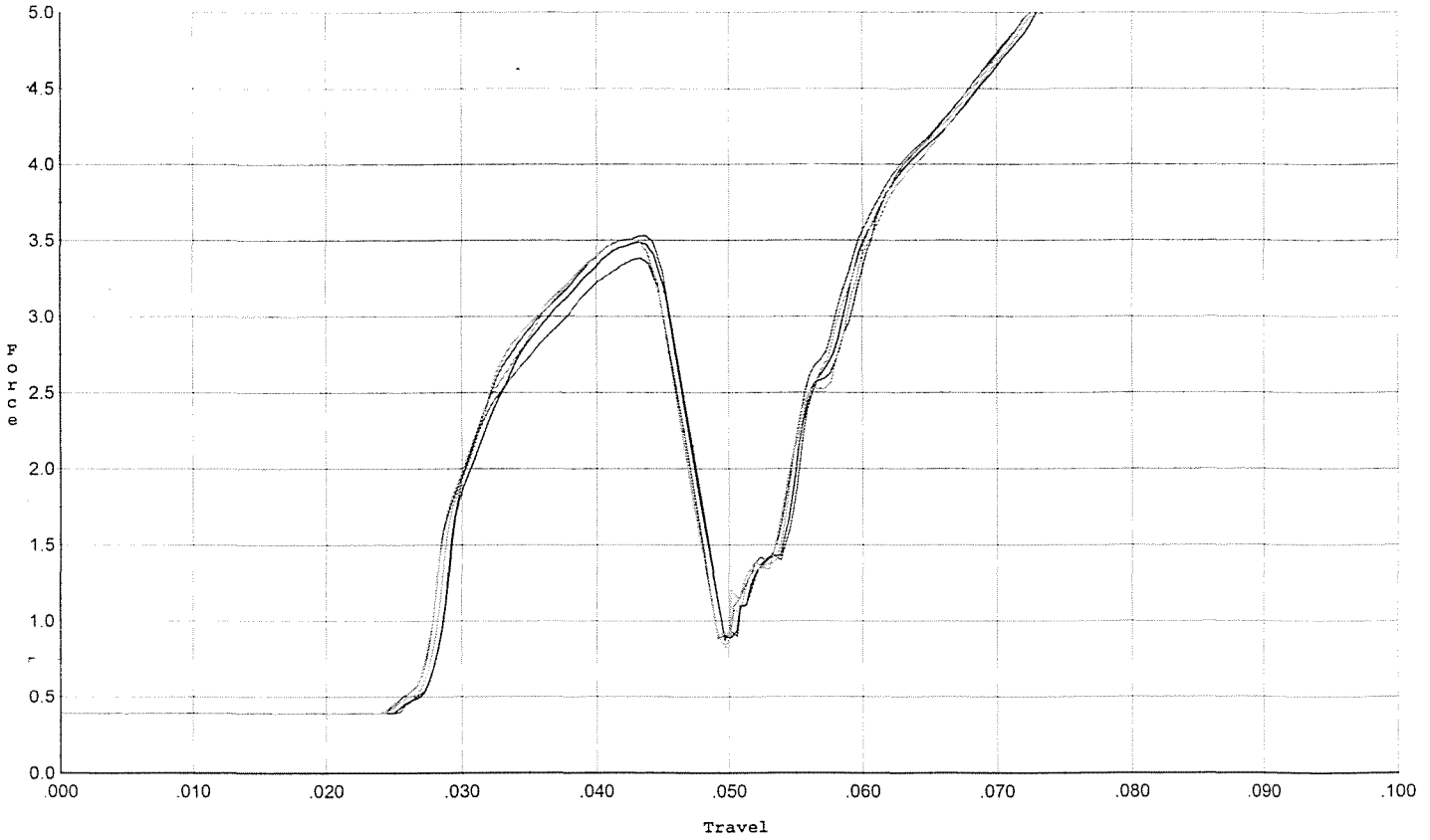
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.830	0.046	0.027	0.033	0.054		Set Trigger
2	2.740	0.046	0.027	0.034	0.053		Set Trigger
3	2.812	0.044	0.027	0.034	0.051		Set Trigger
4	2.795	0.046	0.028	0.034	0.054		Set Trigger
5	2.805	0.045	0.027	0.034	0.054		Set Trigger

A-2-79

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



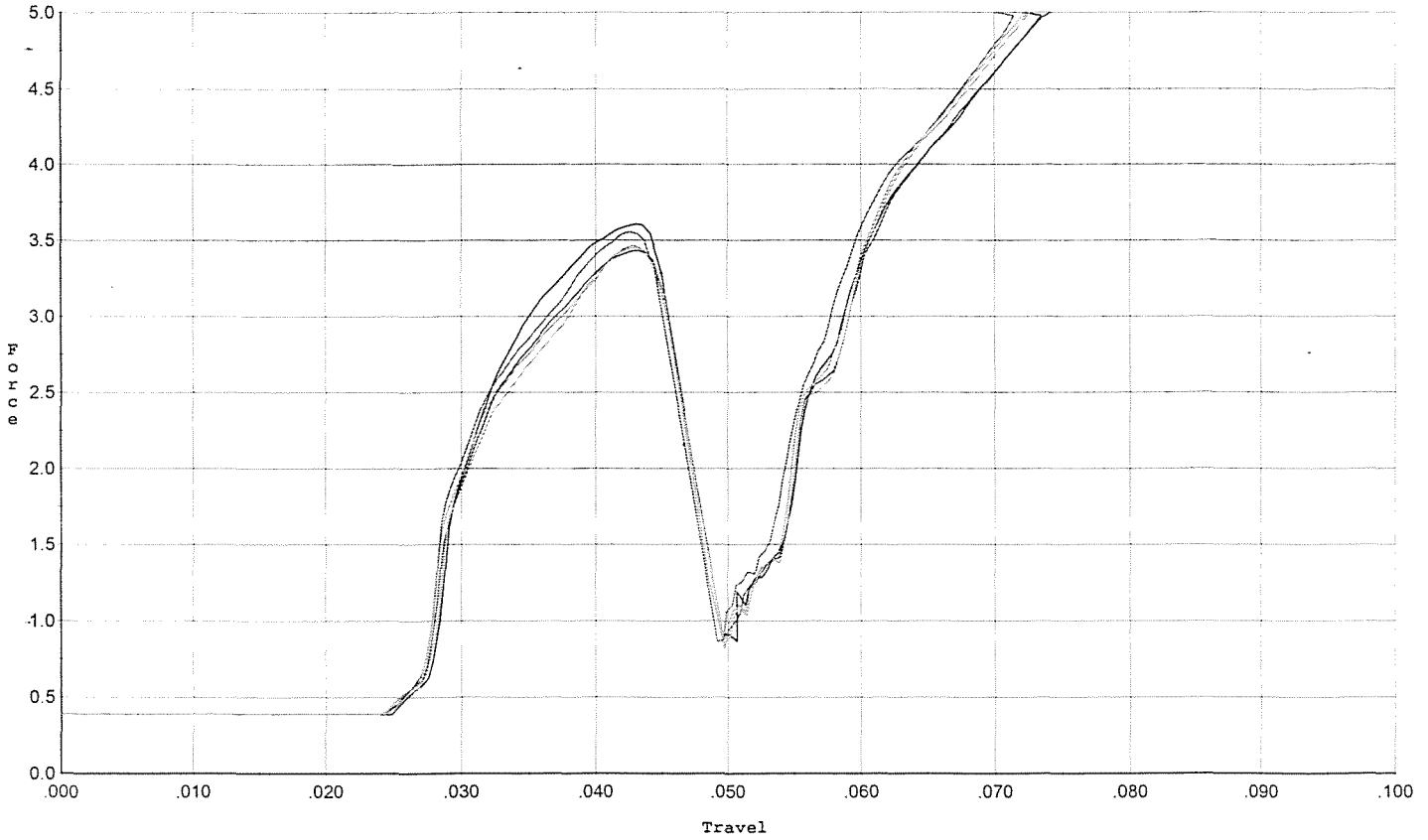
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.531	0.047	0.028	0.032	0.065		Set Trigger
2	3.487	0.045	0.028	0.032	0.061		Set Trigger
3	3.382	0.047	0.027	0.032	0.062		Set Trigger
4	3.509	0.045	0.027	0.032	0.061		Set Trigger
5	3.509	0.045	0.027	0.033	0.061		Set Trigger

A-3.48

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



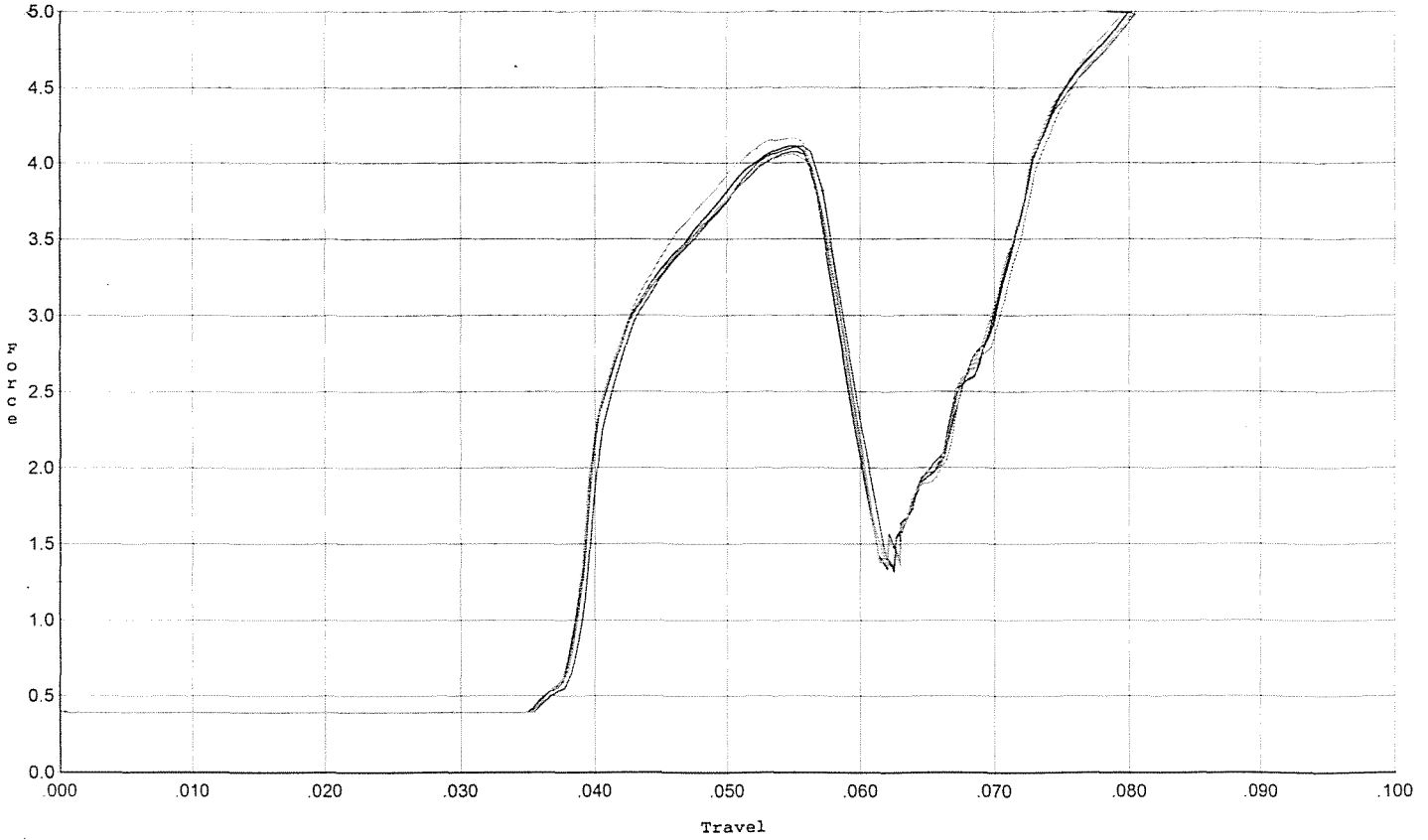
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.434	0.045	0.027	0.033	0.061		Set Trigger
2	3.606	0.045	0.028	0.033	0.063		Set Trigger
3	3.554	0.047	0.027	0.032	0.065		Set Trigger
4	3.450	0.045	0.027	0.032	0.061		Set Trigger
5	3.463	0.045	0.027	0.032	0.062		Set Trigger

A-3.50

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



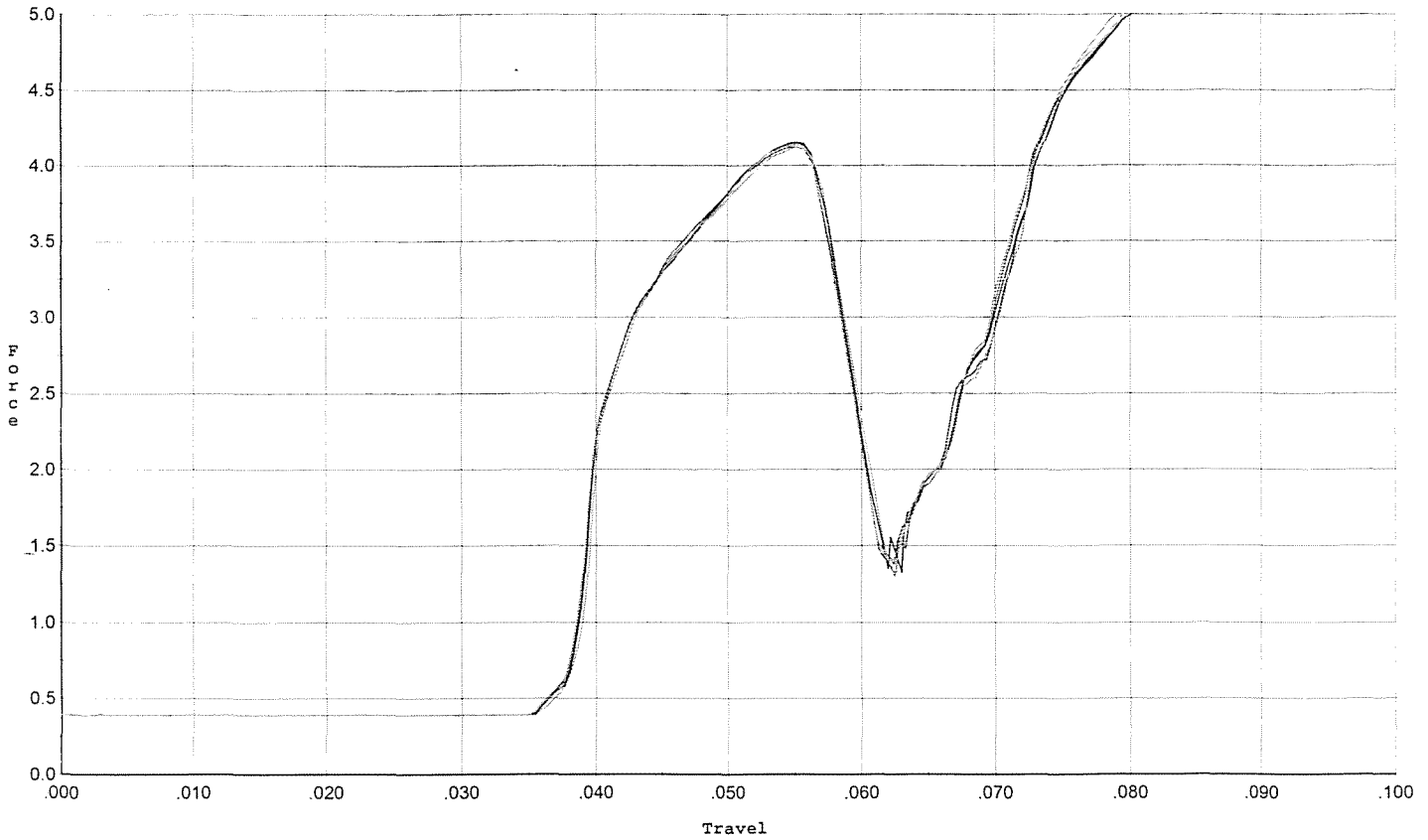
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.107	0.057	0.038	0.032	0.081		Set Trigger
2	4.111	0.057	0.038	0.032	0.081		Set Trigger
3	4.073	0.058	0.038	0.032	0.083		Set Trigger
4	4.059	0.058	0.038	0.032	0.083		Set Trigger
5	4.162	0.059	0.038	0.032	0.086		Set Trigger

A - 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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



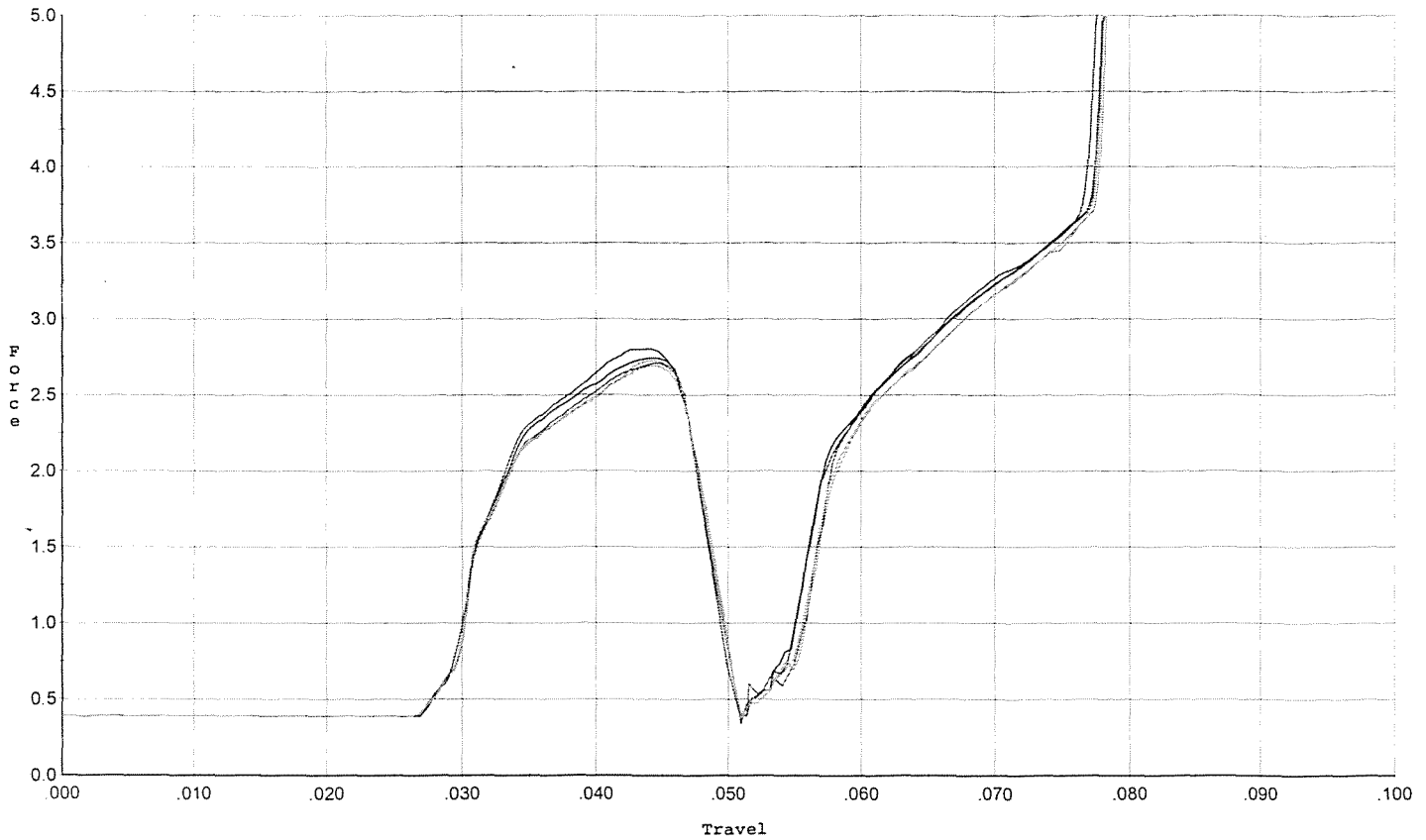
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.138	0.058	0.038	0.032	0.084		Set Trigger
2	4.150	0.057	0.038	0.032	0.083		Set Trigger
3	4.121	0.058	0.038	0.032	0.084		Set Trigger
4	4.139	0.058	0.038	0.032	0.084		Set Trigger
5	4.122	0.057	0.038	0.032	0.082		Set Trigger

A-413

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 11/07/2008

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

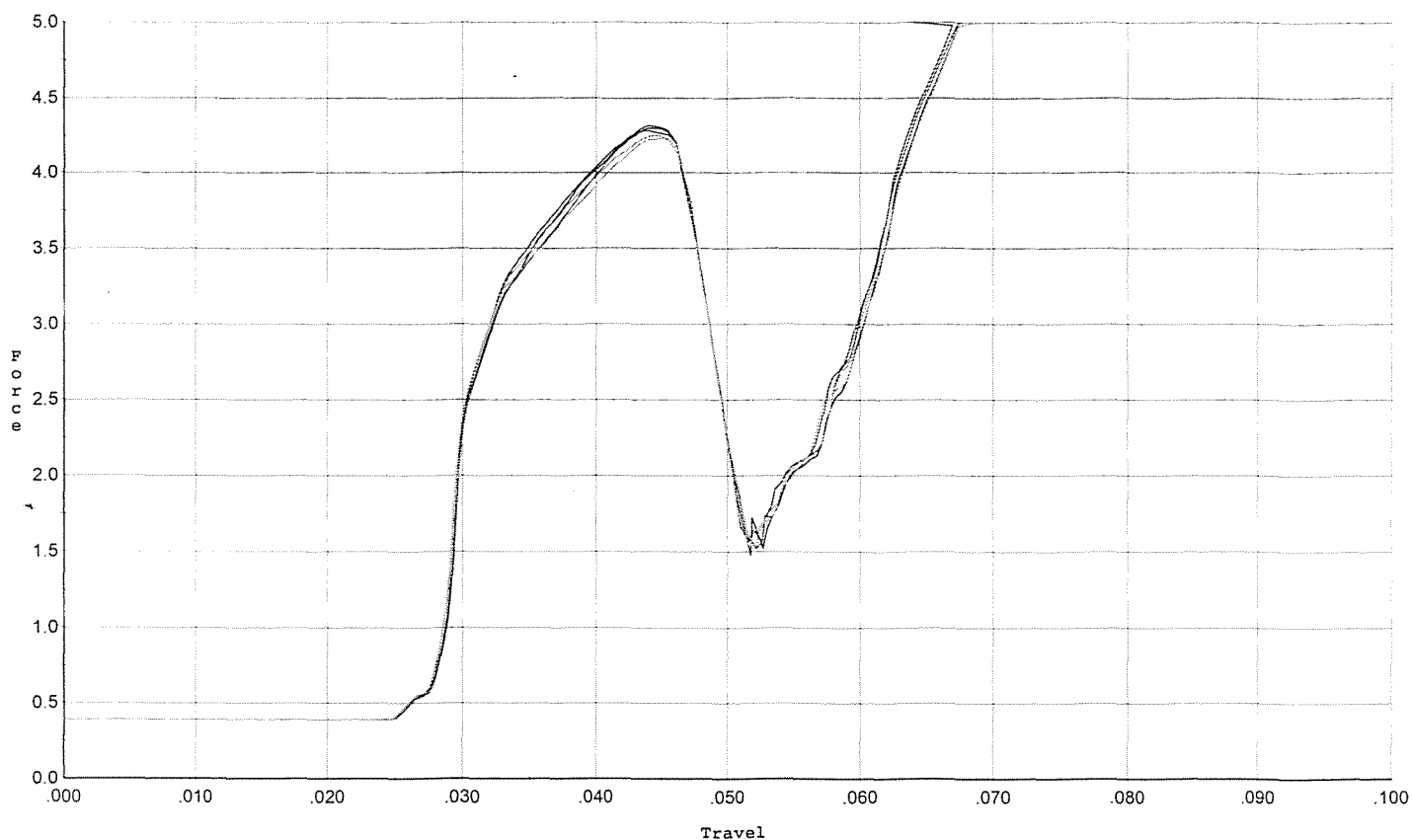


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.801	0.047	0.029	0.034	0.053		Set Trigger
2	2.745	0.047	0.028	0.034	0.052		Set Trigger
3	2.708	0.047	0.028	0.034	0.052		Set Trigger
4	2.693	0.047	0.030	0.034	0.052		Set Trigger
5	2.727	0.048	0.029	0.034	0.054		Set Trigger

A-2.73

Trigger Profile [lbs,inch]

Profile	SWS	Model:	M/24
GunType:	Rifle	Serial No:	Form #F005
Make:	Remington	Trigger:	set to 4.0 lbs +/- 1.0 for target & accuracy
Note:	C Schults 11/07/2008		



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.318	0.048	0.028	0.031	0.081		Set Trigger
2	4.302	0.047	0.028	0.031	0.080		Set Trigger
3	4.287	0.047	0.028	0.031	0.080		Set Trigger
4	4.233	0.048	0.028	0.031	0.080		Set Trigger
5	4.254	0.047	0.028	0.031	0.080		Set Trigger

A-4.27