

G67945-80

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

- INSTRUCTION BOOK 3518

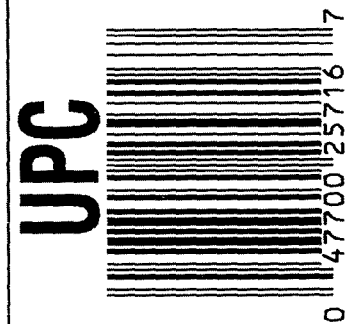


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794580



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794580

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE		10-28-08	PSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/29/08	RS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		1030	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-6-08	PSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

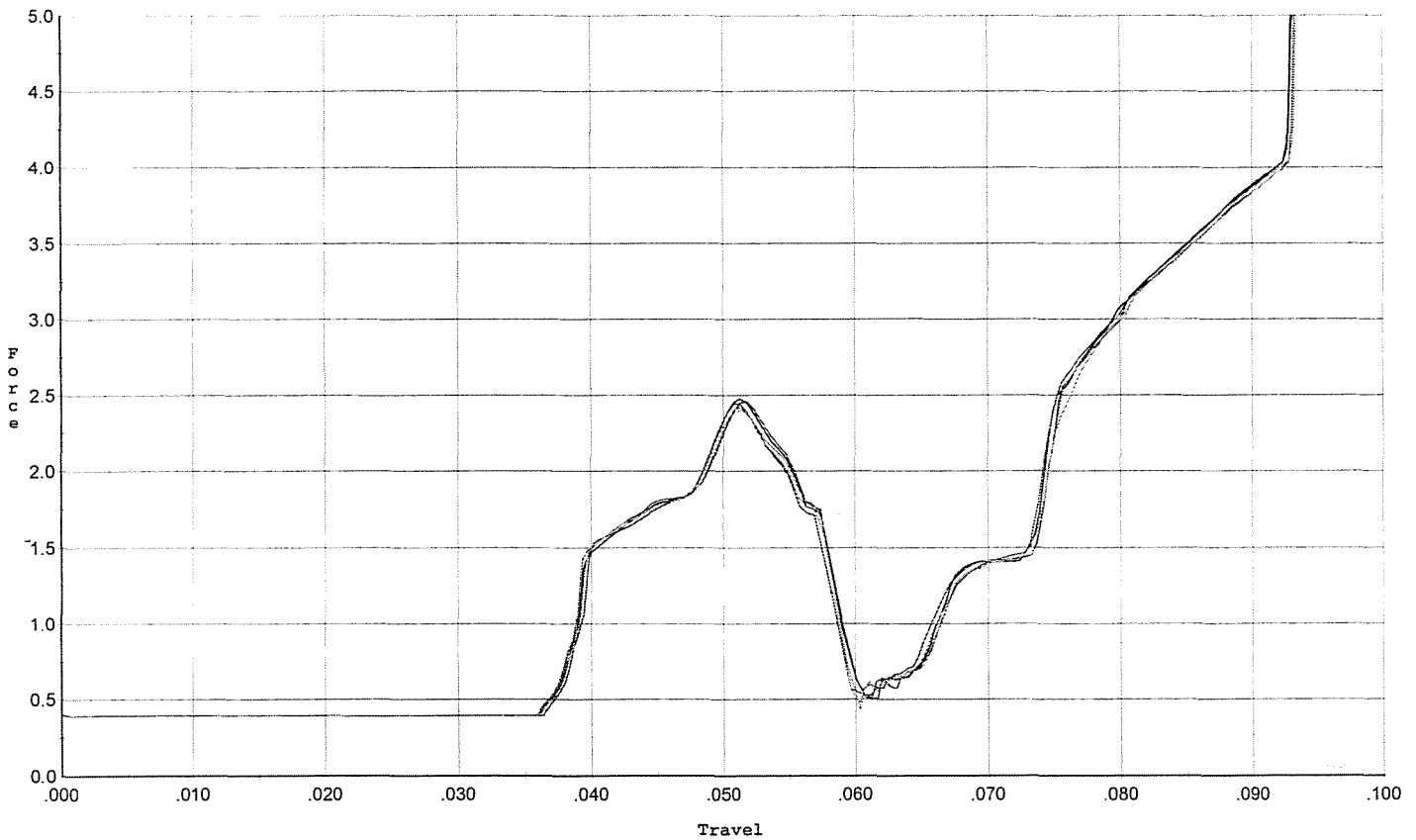
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4⁰</u> <u>4⁰</u> <u>4⁰</u>	11-13-08	LJD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4⁰</u> <u>4⁰</u> <u>5⁰</u>	11-13-08	LJD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	11-13-08	LJD
	J) ASSEMBLE STOCK		11-6-08	BSW
	K) ASSEMBLE SWIVEL STUDS		11-13-08	LJD
	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	11-7-08	LJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION NA		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-7-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-13-08	LJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.73</u> <u>2.72</u> <u>2.71</u> <u>2.74</u> <u>2.71</u>	11-7-08	TC
	C) FUNCTION		11-13-08	LJD
690	PACK		11/14/08	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



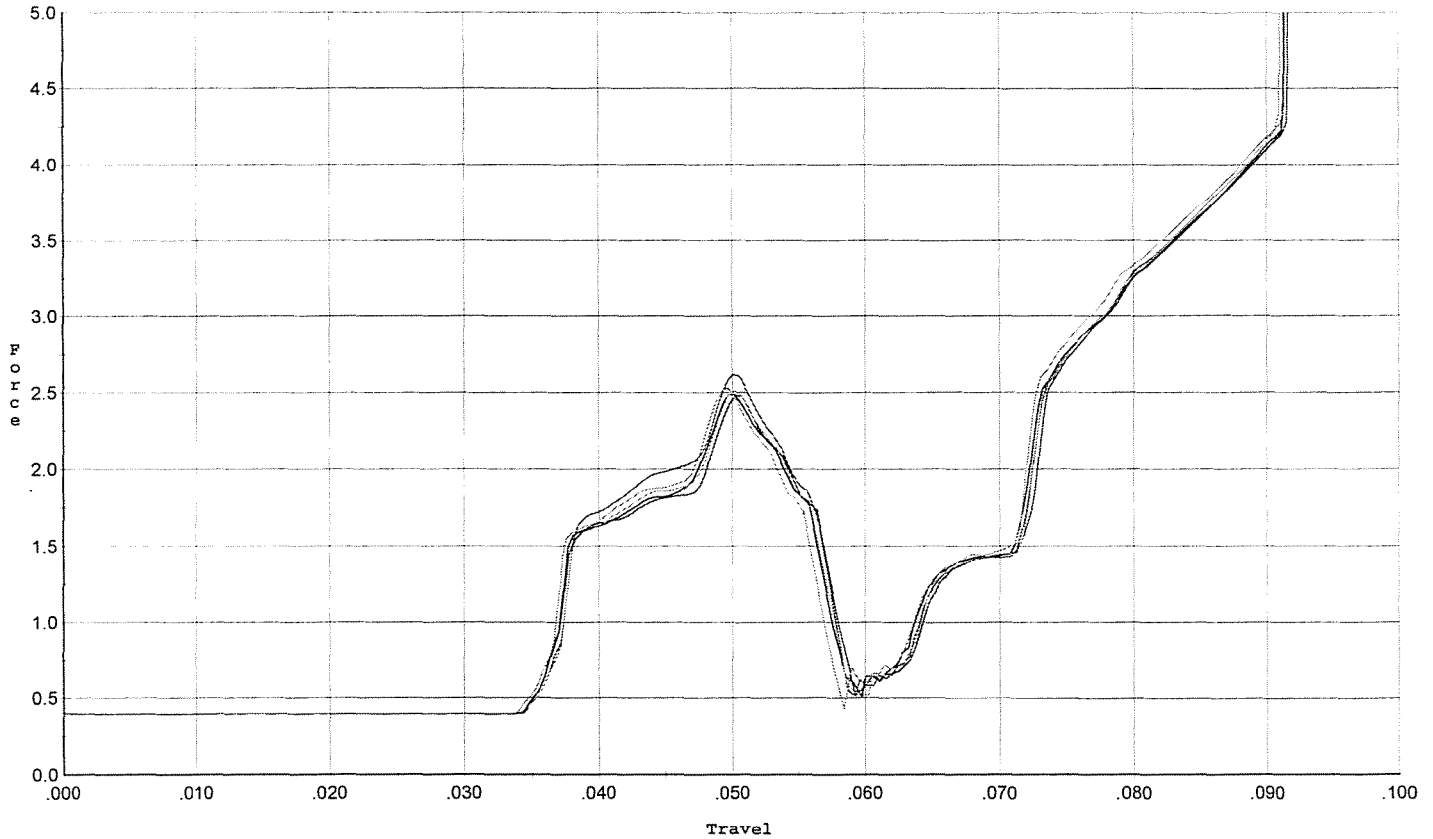
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.057	0.038	0.041	0.051		Set Trigger
2	2.477	0.057	0.038	0.040	0.052		Set Trigger
3	2.442	0.058	0.036	0.041	0.052		Set Trigger
4	2.404	0.058	0.038	0.041	0.051		Set Trigger
5	2.420	0.057	0.037	0.041	0.051		Set Trigger

Avg 2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



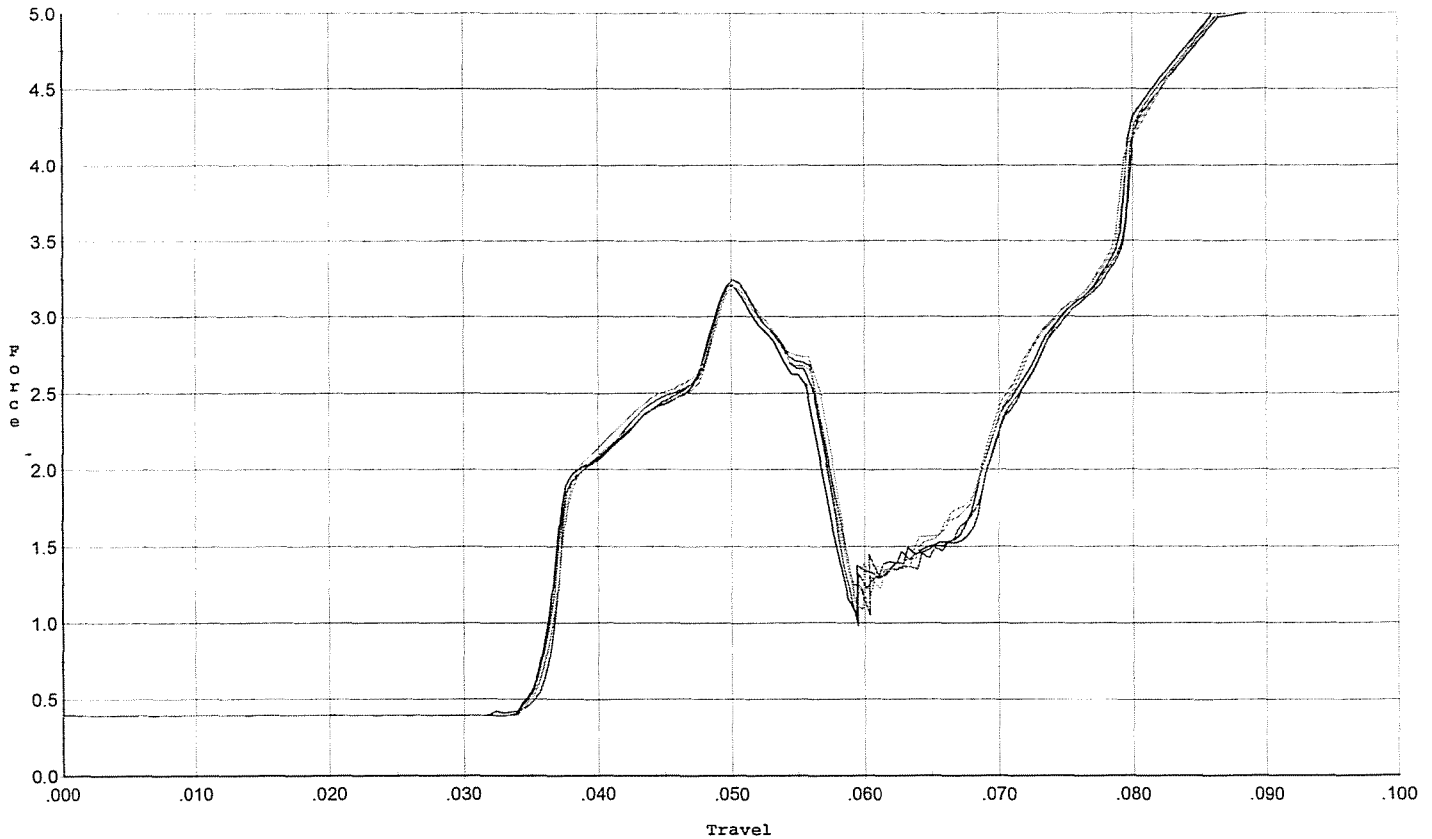
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.479	0.056	0.035	0.040	0.052		Set Trigger
2	2.485	0.056	0.035	0.040	0.051		Set Trigger
3	2.620	0.056	0.036	0.039	0.054		Set Trigger
4	2.509	0.057	0.035	0.040	0.053		Set Trigger
5	2.530	0.055	0.036	0.040	0.051		Set Trigger

Avg 2.52

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



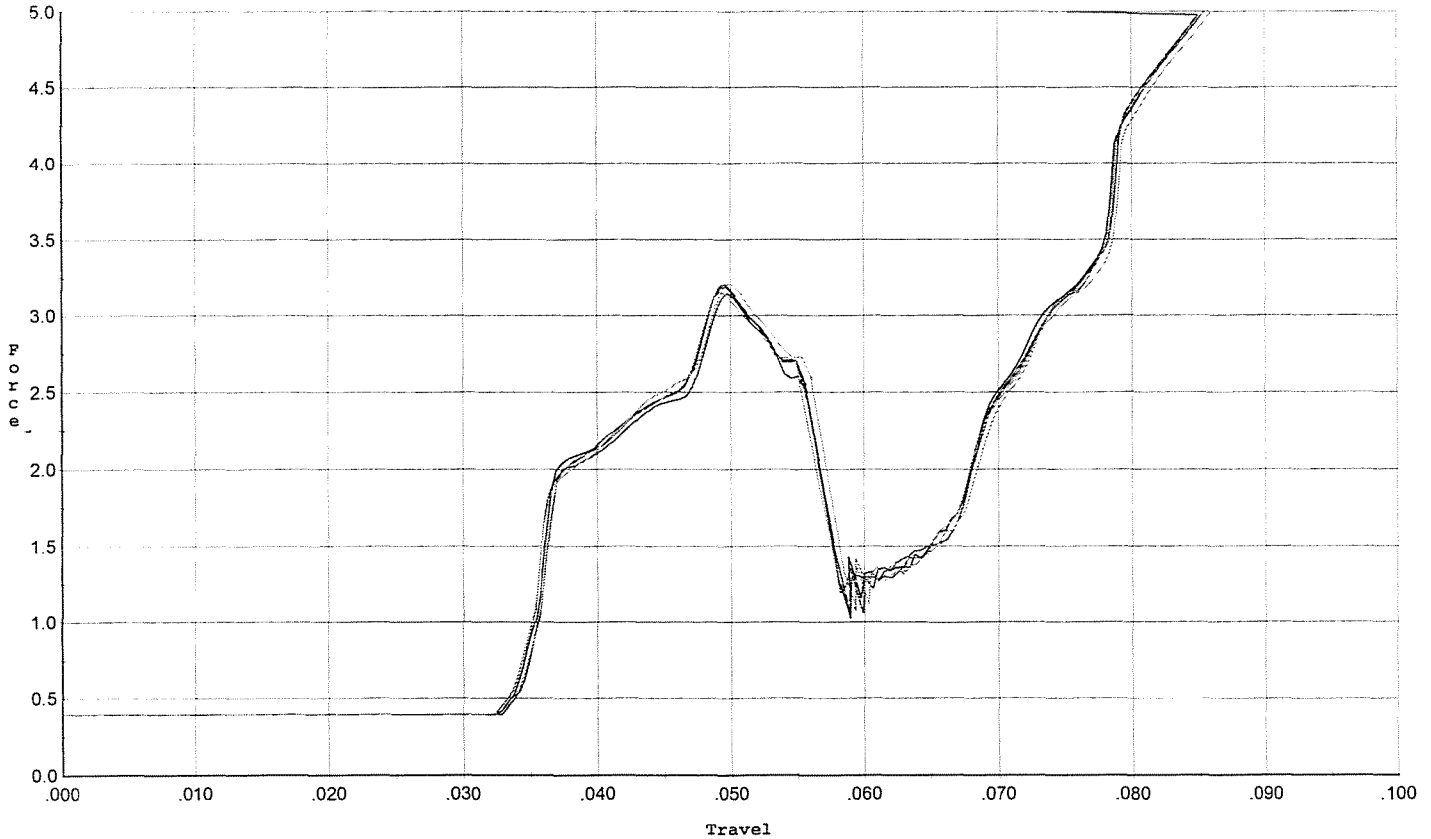
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.245	0.056	0.036	0.038	0.065		Set Trigger
2	3.208	0.056	0.034	0.038	0.064		Set Trigger
3	3.247	0.056	0.034	0.038	0.065		Set Trigger
4	3.242	0.057	0.036	0.038	0.067		Set Trigger
5	3.201	0.056	0.036	0.038	0.065		Set Trigger

Aug 3.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



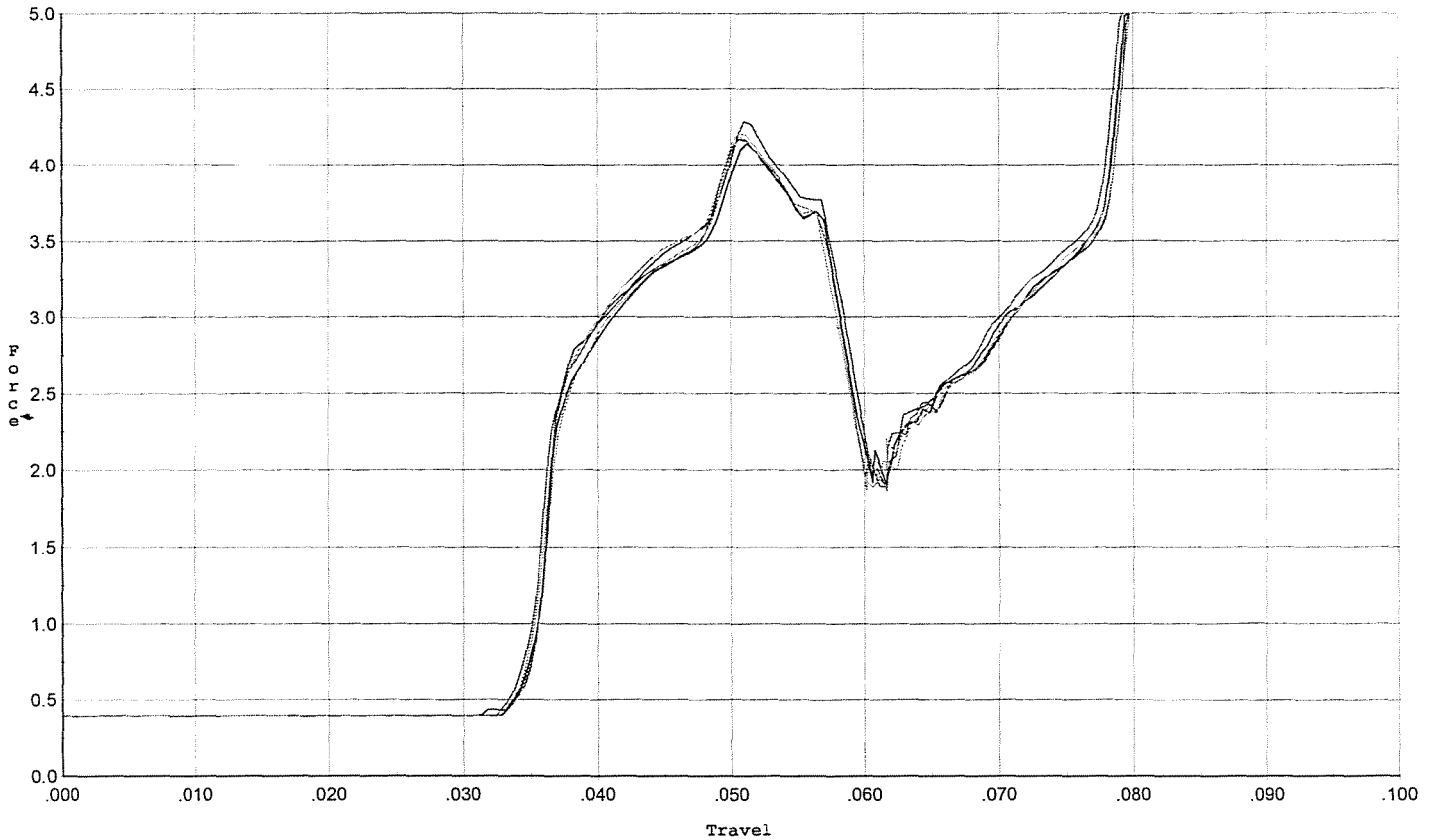
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.150	0.056	0.035	0.037	0.065		Set Trigger
2	3.193	0.056	0.033	0.037	0.066		Set Trigger
3	3.207	0.056	0.034	0.037	0.066		Set Trigger
4	3.211	0.056	0.034	0.037	0.067		Set Trigger
5	3.158	0.055	0.033	0.038	0.064		Set Trigger

Avg 3.18

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



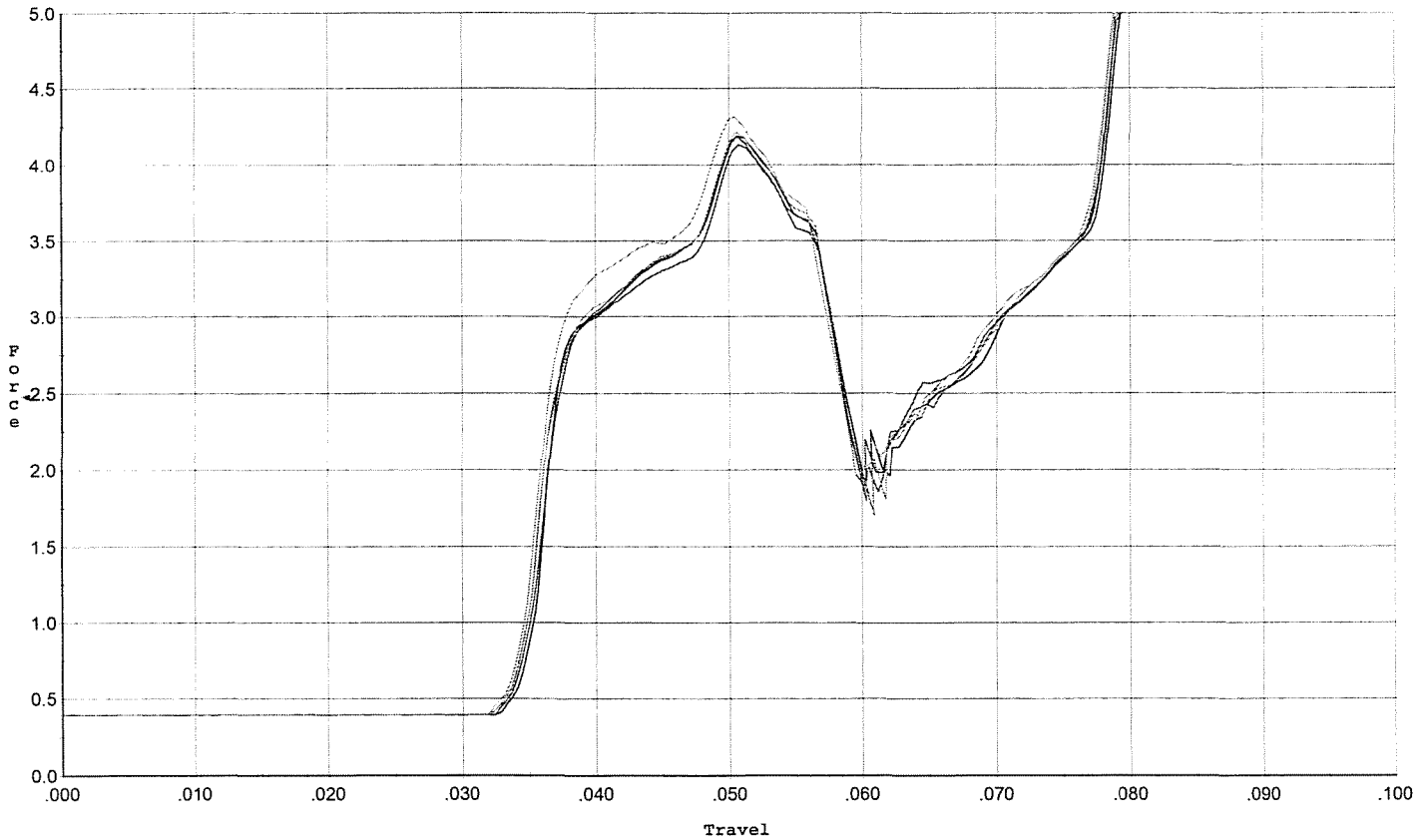
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.285	0.058	0.034	0.032	0.092		Set Trigger
2	4.139	0.057	0.034	0.033	0.088		Set Trigger
3	4.169	0.057	0.034	0.032	0.090		Set Trigger
4	4.209	0.058	0.034	0.032	0.091		Set Trigger
5	4.184	0.057	0.035	0.032	0.088		Set Trigger

Aug 4.19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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



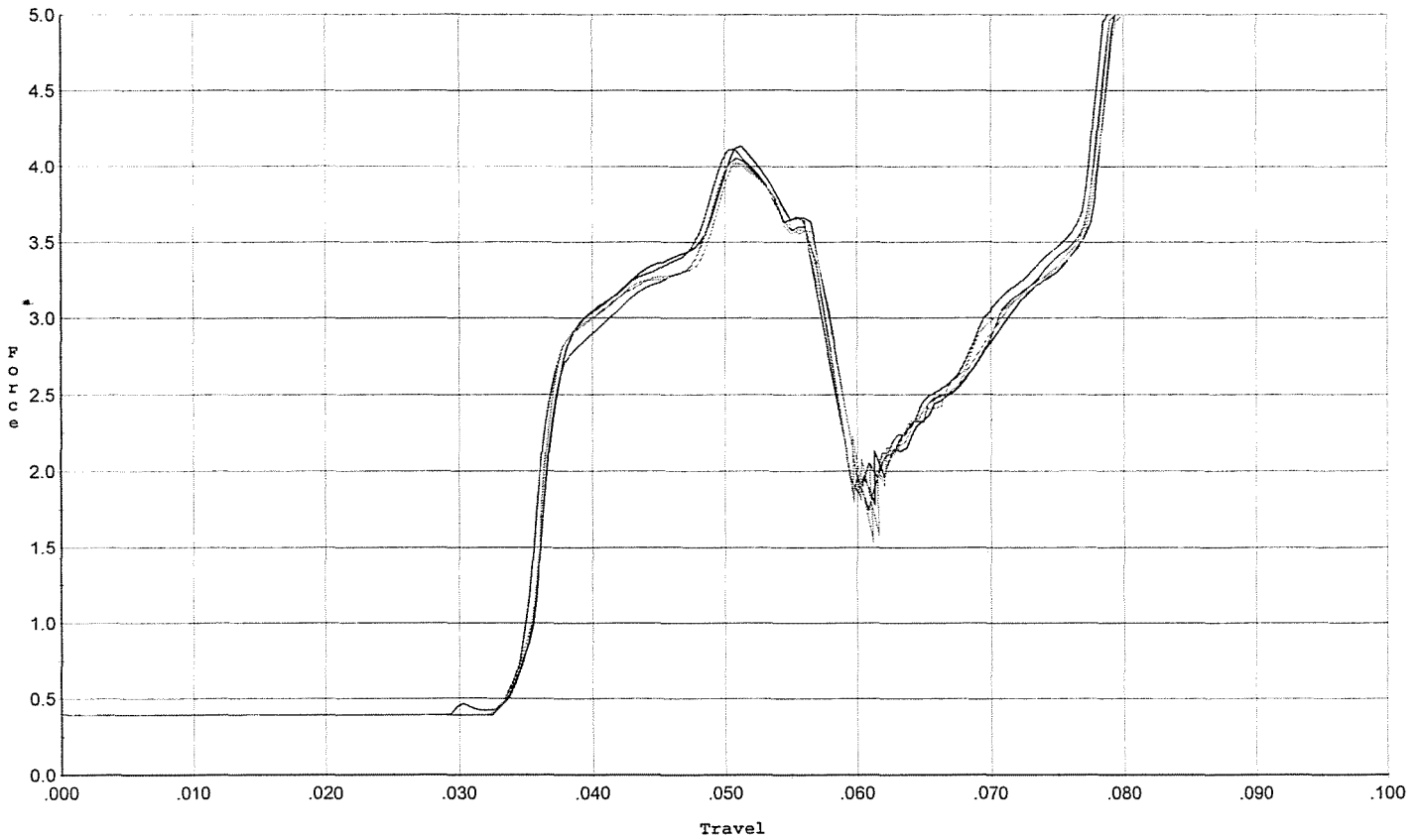
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.131	0.057	0.034	0.033	0.087		Set Trigger
2	4.188	0.057	0.034	0.033	0.088		Set Trigger
3	4.182	0.057	0.034	0.033	0.089		Set Trigger
4	4.315	0.058	0.034	0.032	0.093		Set Trigger
5	4.212	0.057	0.034	0.033	0.089		Set Trigger

Avg 4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/6/08

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	4.114	0.056	0.034	0.033	0.086		Set Trigger
2	4.134	0.058	0.034	0.033	0.090		Set Trigger
3	4.057	0.057	0.034	0.033	0.086		Set Trigger
4	4.024	0.057	0.034	0.033	0.087		Set Trigger
5	4.021	0.058	0.034	0.033	0.089		Set Trigger

Avg 4.07