

66794595

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

— INSTRUCTION BOOK 3518

BM FORM

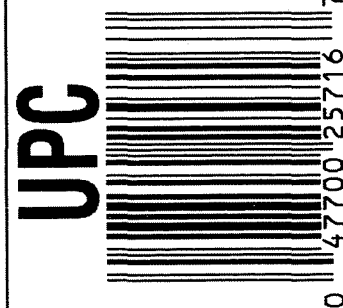


ORDER NO. **25716**

BARREL LENGTH **24"**

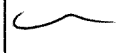
CAPACITY **6**

G6794595

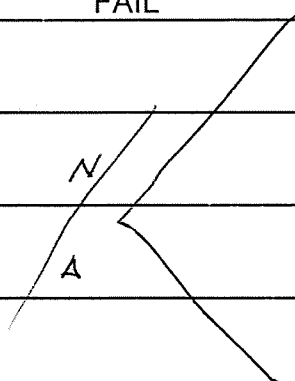


INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794595

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SPH
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SPH
460	CHECK HEADSPACE		10-7-08	SPH
470	DIS-ASSEMBLE ACTION		10-7-08	SPH
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-8-08	Rsn
475	DRILL AND TAP SIGHT HOLES	UCI 1 : 2008	10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/11/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		1021	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/21/08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/21/08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/21/08	SP
	D) OIL FIRING PIN ASSEMBLY		11-4-08	Rsn
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

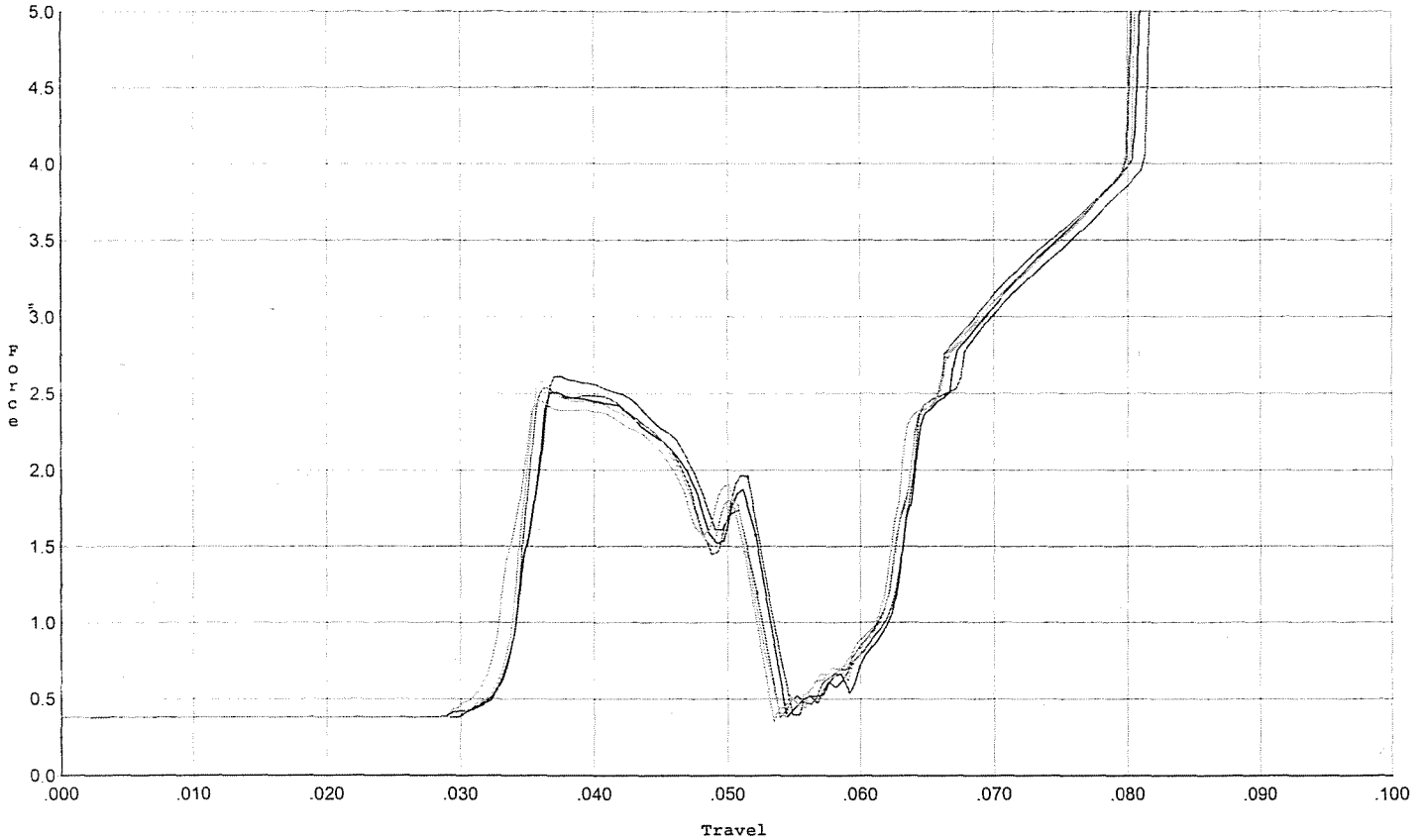
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	11-12-08	RJA		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.0</u>	<u>4.0</u>	<u>4.0</u>	11-12-08	RJA		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	11-12-08	RJA		
	J) ASSEMBLE STOCK					11-4-08	RSN		
	K) ASSEMBLE SWIVEL STUDS					11-12-08	RJA		
	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		11-5-08	RSW		
			<u>PASS</u>	FAIL					
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					11-5-08	TL		
670	FINAL INSPECTION A) HEADSPACE					11-12-08	RJA		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u>	<u>2.55</u>	<u>2.61</u>	<u>2.62</u>	<u>2.50</u>	11-6-08	TL
	C) FUNCTION							11-12-08	RJA
690	PACK							11/13/08	F-m

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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



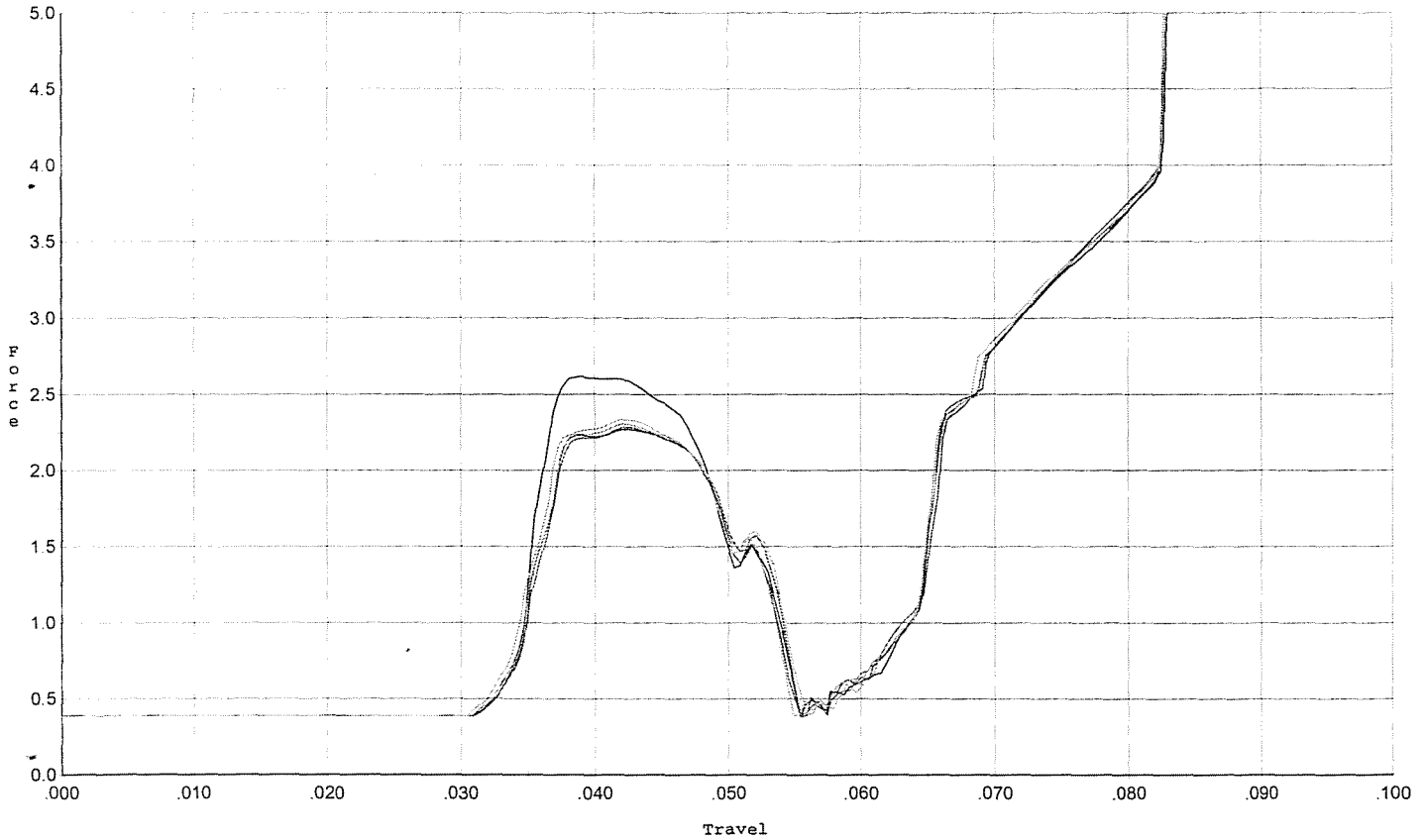
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.612	0.052	0.033	0.035	0.052		Set Trigger
2	2.511	0.052	0.033	0.034	0.051		Set Trigger
3	2.531	0.052	0.033	0.034	0.051		Set Trigger
4	2.580	0.051	0.033	0.035	0.050		Set Trigger
5	2.452	0.051	0.032	0.034	0.051		Set Trigger

A-2.53

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



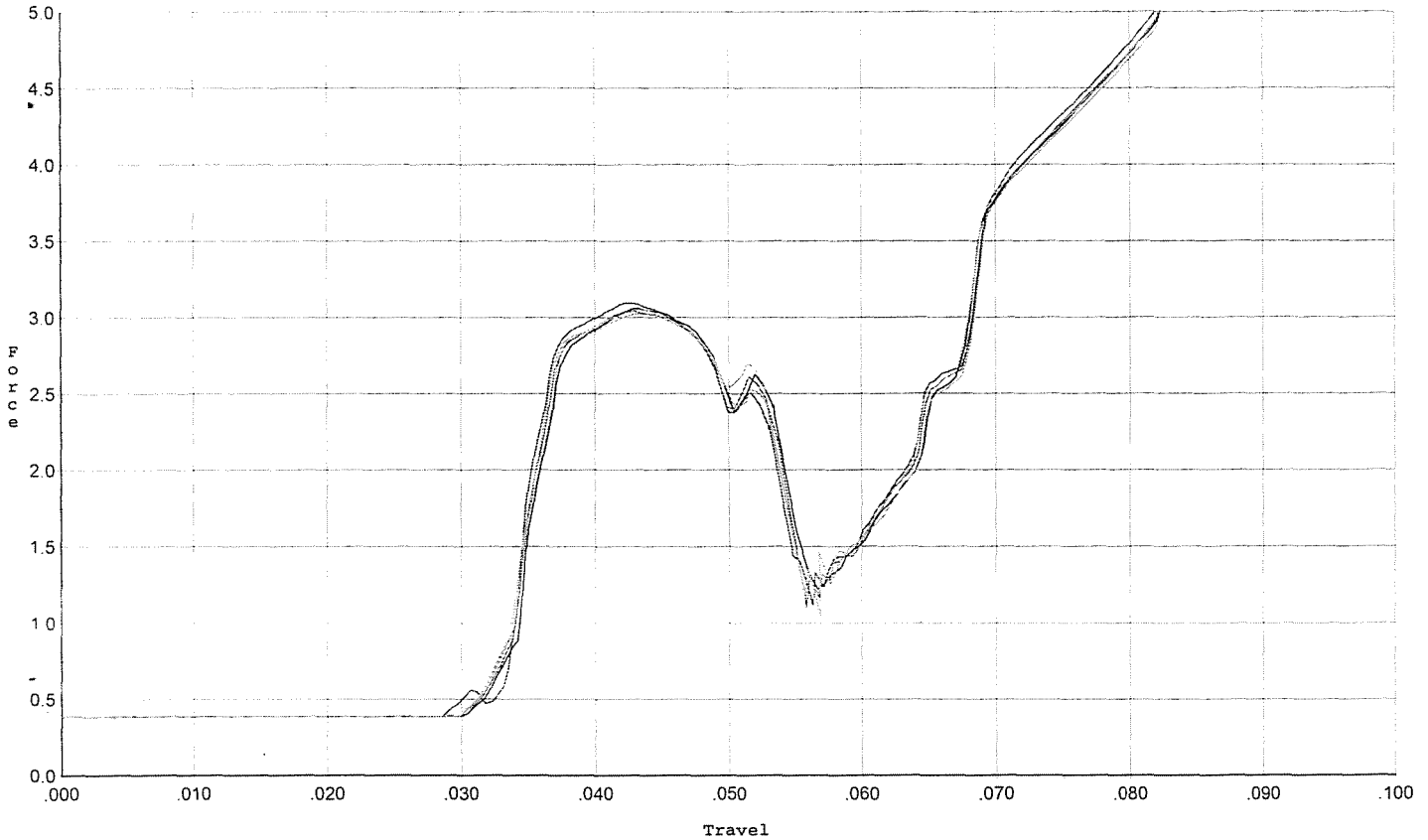
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.274	0.053	0.033	0.035	0.049		Set Trigger
2	2.619	0.054	0.033	0.035	0.054		Set Trigger
3	2.285	0.054	0.033	0.035	0.050		Set Trigger
4	2.336	0.053	0.033	0.035	0.051		Set Trigger
5	2.307	0.053	0.032	0.035	0.051		Set Trigger

A 236

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs ini +/- .758 lbs



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.093	0.053	0.033	0.034	0.066		Set Trigger
2	3.058	0.053	0.032	0.034	0.066		Set Trigger
3	3.041	0.054	0.032	0.034	0.066		Set Trigger
4	3.052	0.053	0.032	0.034	0.066		Set Trigger
5	3.023	0.053	0.032	0.034	0.065		Set Trigger

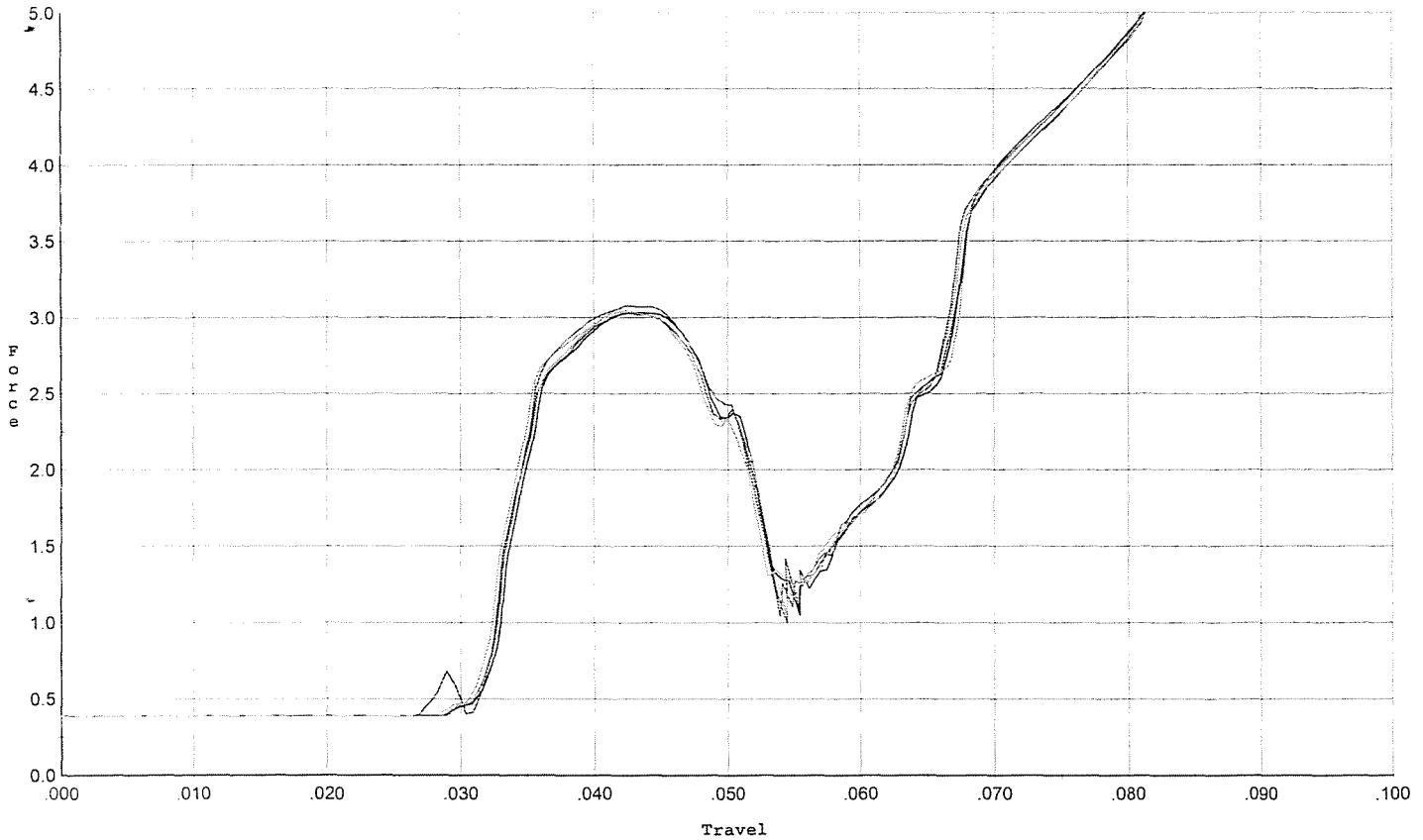
A-3.05

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs after 20 cycles+/- ~~7.5~~ lbs

75 lbs



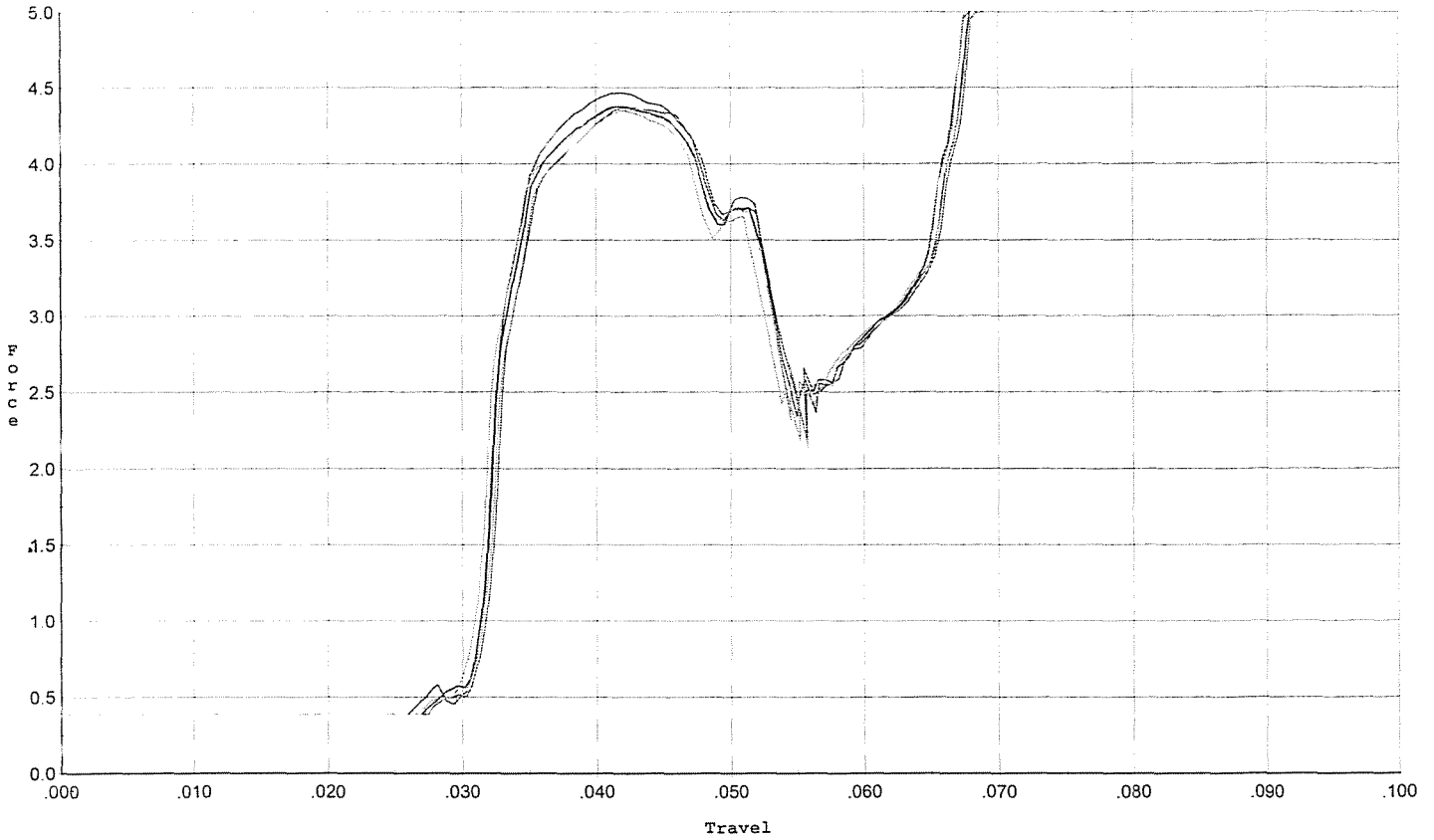
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.028	0.052	0.029	0.034	0.064		Set Trigger
2	3.038	0.052	0.032	0.034	0.063		Set Trigger
3	3.077	0.052	0.031	0.034	0.065		Set Trigger
4	3.037	0.052	0.031	0.034	0.063		Set Trigger
5	3.047	0.051	0.031	0.033	0.063		Set Trigger

A-304

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



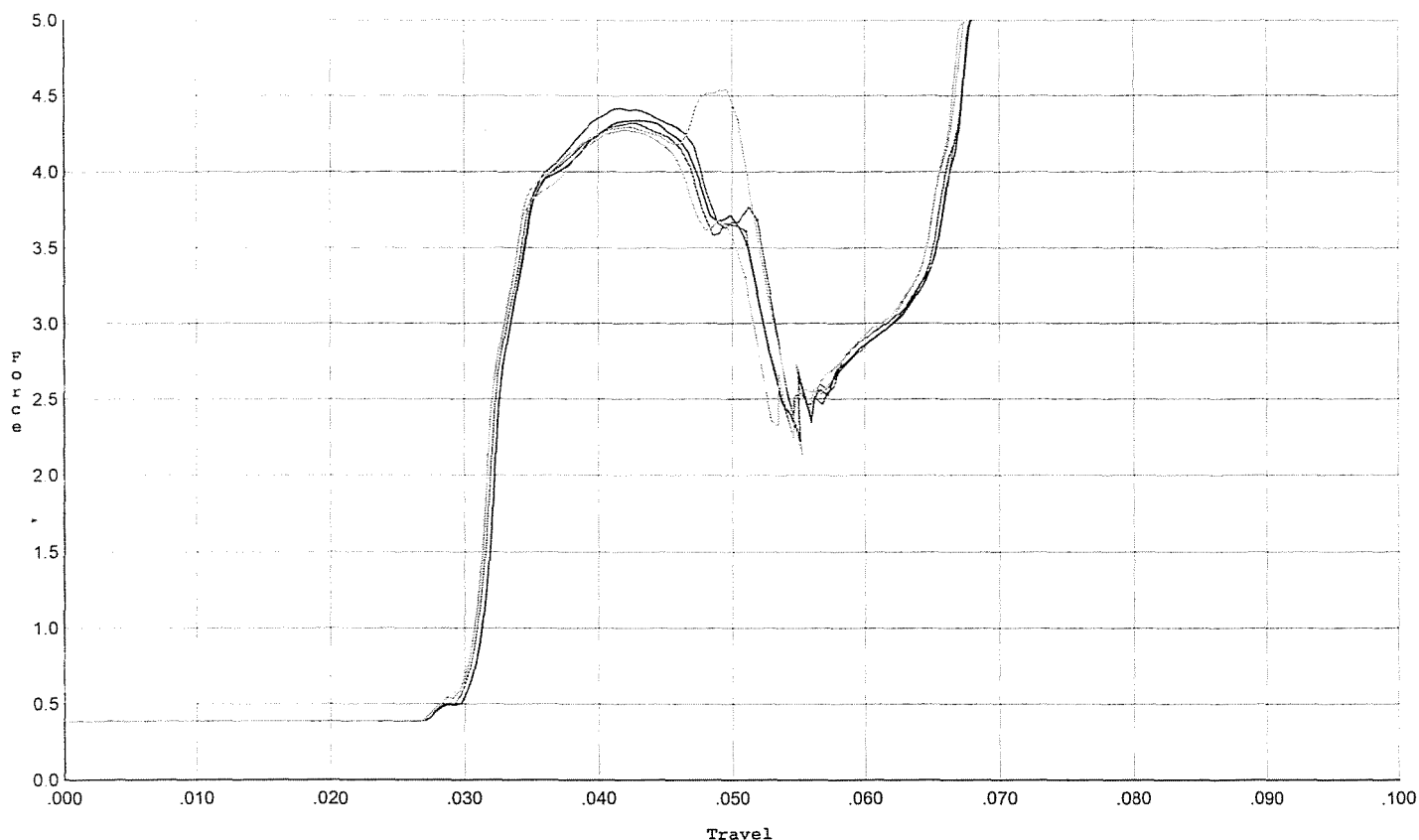
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.466	0.052	0.031	0.029	0.095		Set Trigger
2	4.377	0.052	0.031	0.029	0.093		Set Trigger
3	4.370	0.052	0.031	0.030	0.092		Set Trigger
4	4.359	0.052	0.031	0.029	0.092		Set Trigger
5	4.361	0.052	0.030	0.030	0.093		Set Trigger

A-438

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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



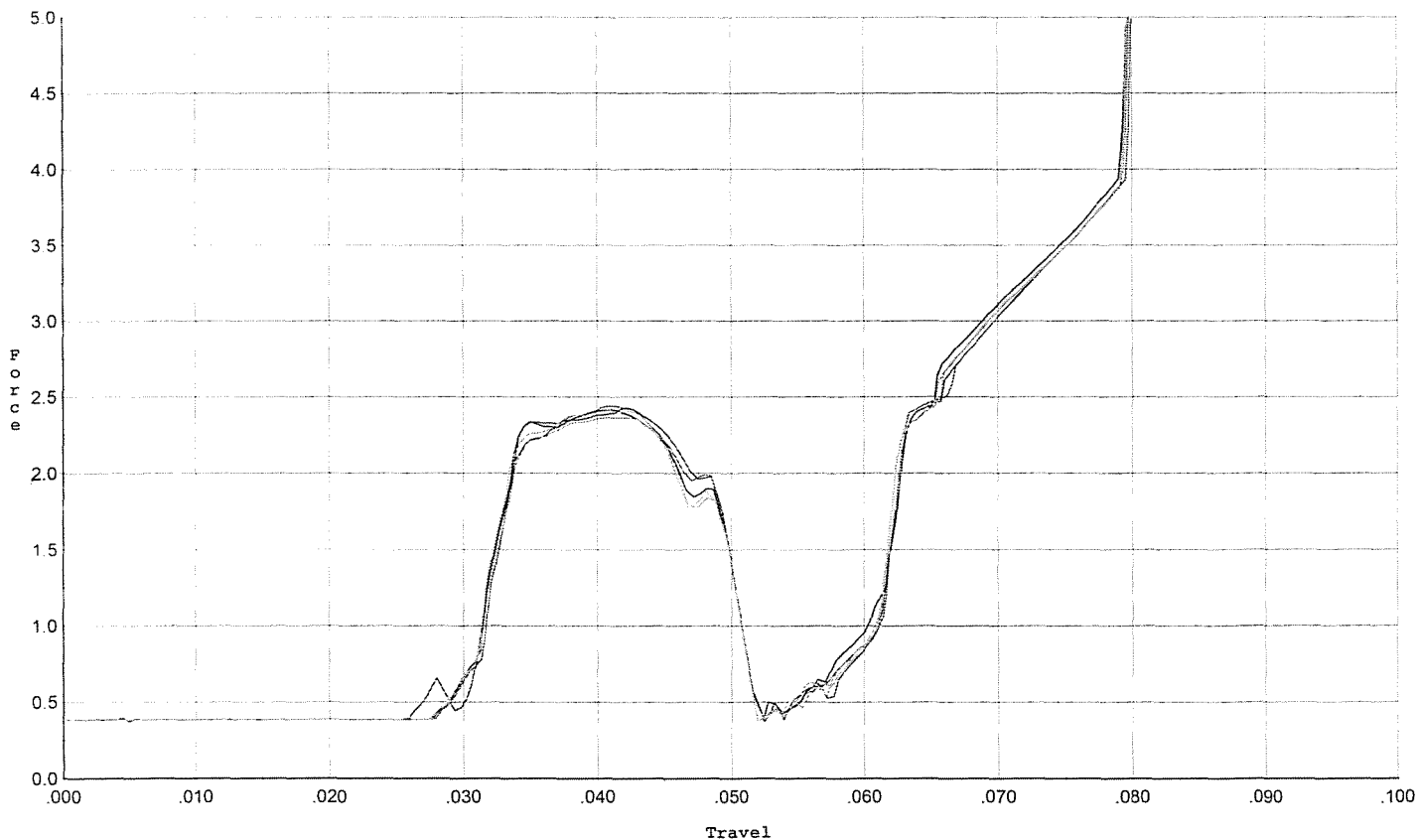
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.414	0.052	0.030	0.029	0.093		Set Trigger
2	4.339	0.051	0.030	0.030	0.089		Set Trigger
3	4.321	0.051	0.030	0.030	0.090		Set Trigger
4	4.276	0.051	0.030	0.030	0.088		Set Trigger
5	4.540	0.050	0.030	0.029	0.093		Set Trigger

A-4-37

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C schults 10/31/2008

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



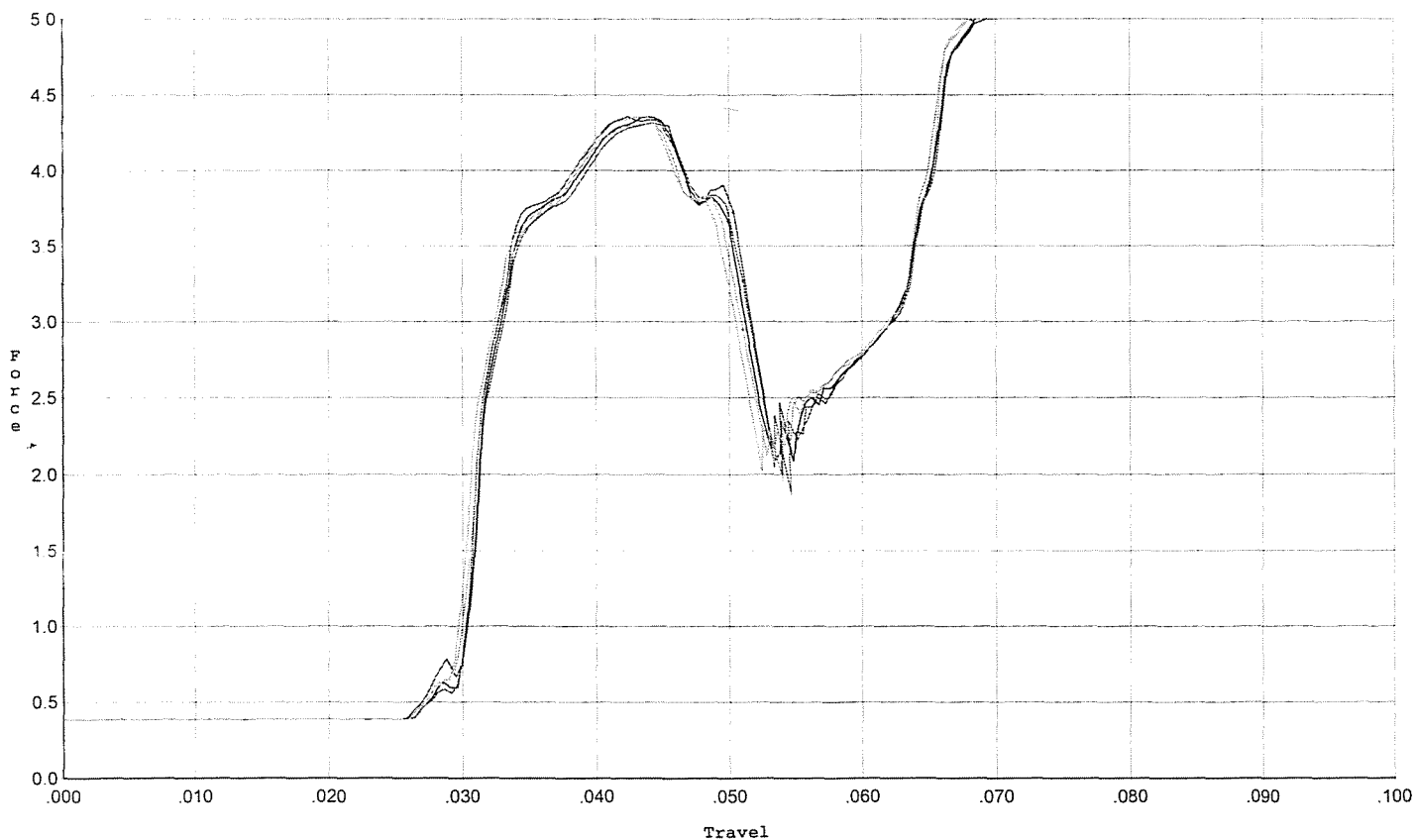
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.421	0.049	0.028	0.034	0.052		Set Trigger
2	2.415	0.050	0.030	0.034	0.052		Set Trigger
3	2.439	0.050	0.030	0.034	0.051		Set Trigger
4	2.410	0.050	0.030	0.034	0.051		Set Trigger
5	2.366	0.050	0.030	0.034	0.051		Set Trigger

A-2.41

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C schults 10/31/2008

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	4.358	0.050	0.028	0.030	0.090		Set Trigger
2	4.359	0.050	0.028	0.030	0.087		Set Trigger
3	4.312	0.051	0.030	0.030	0.089		Set Trigger
4	4.359	0.050	0.028	0.030	0.088		Set Trigger
5	4.315	0.051	0.028	0.030	0.089		Set Trigger

A-434