

G6794652

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

— INSTRUCTION BOOK 3518

BM FORM

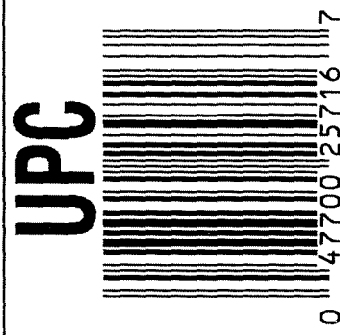


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794652



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794652

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SP
460	CHECK HEADSPACE		10-27-08	SP
470	DIS-ASSEMBLE ACTION		10-27-08	SP
472	SERIALIZE BOLT HANDLE		10-28-08	RSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/29/08	SP
490	MAGNAFLUX BOLT		10/27/08	MR
500	ROLLMARK CALIBER		10/29/08	RT
520	GOFF BLAST BBL / REC		10/30/08	TC
542	APPLY COATINGS (BARREL ACTION)		11-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-5-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
F004 REV 5/2006				

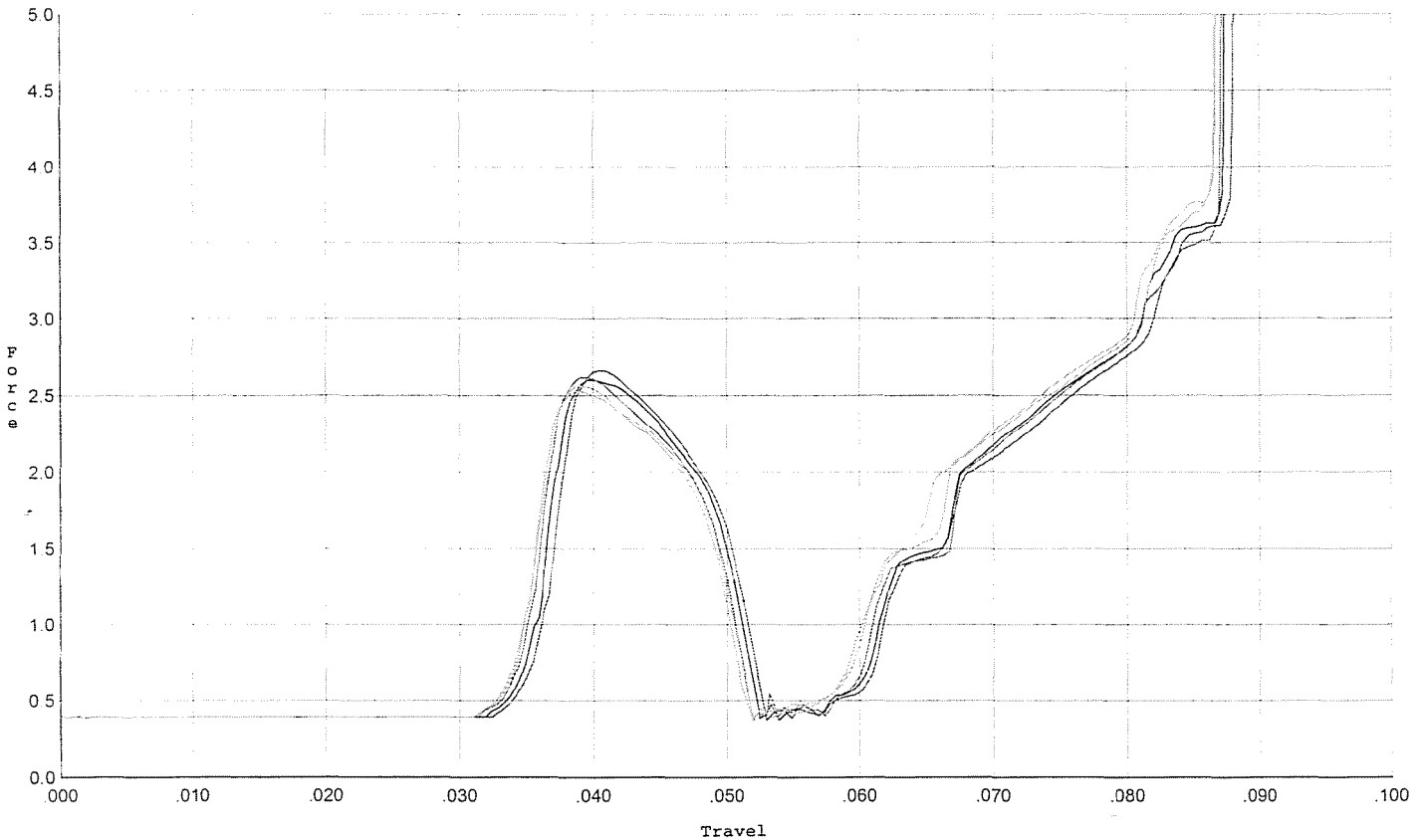
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>35</u> <u>40</u> <u>40</u>	12-2-08	R. D
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>45</u> <u>50</u>	12-2-08	R. D
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	12-2-08	R. D
	J) ASSEMBLE STOCK		11-10-08	FSW
	K) ASSEMBLE SWIVEL STUDS		12-2-08	R. 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> FAIL <u>PASS</u> FAIL	11-12-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-12-08	JS
670	FINAL INSPECTION A) HEADSPACE		12-2-08	R. D
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u> <u>2.24</u> <u>2.29</u> <u>2.26</u> <u>2.24</u>	11-20-08	TC
	C) FUNCTION		12-2-08	R. D
690	PACK		12-3-08	TC

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



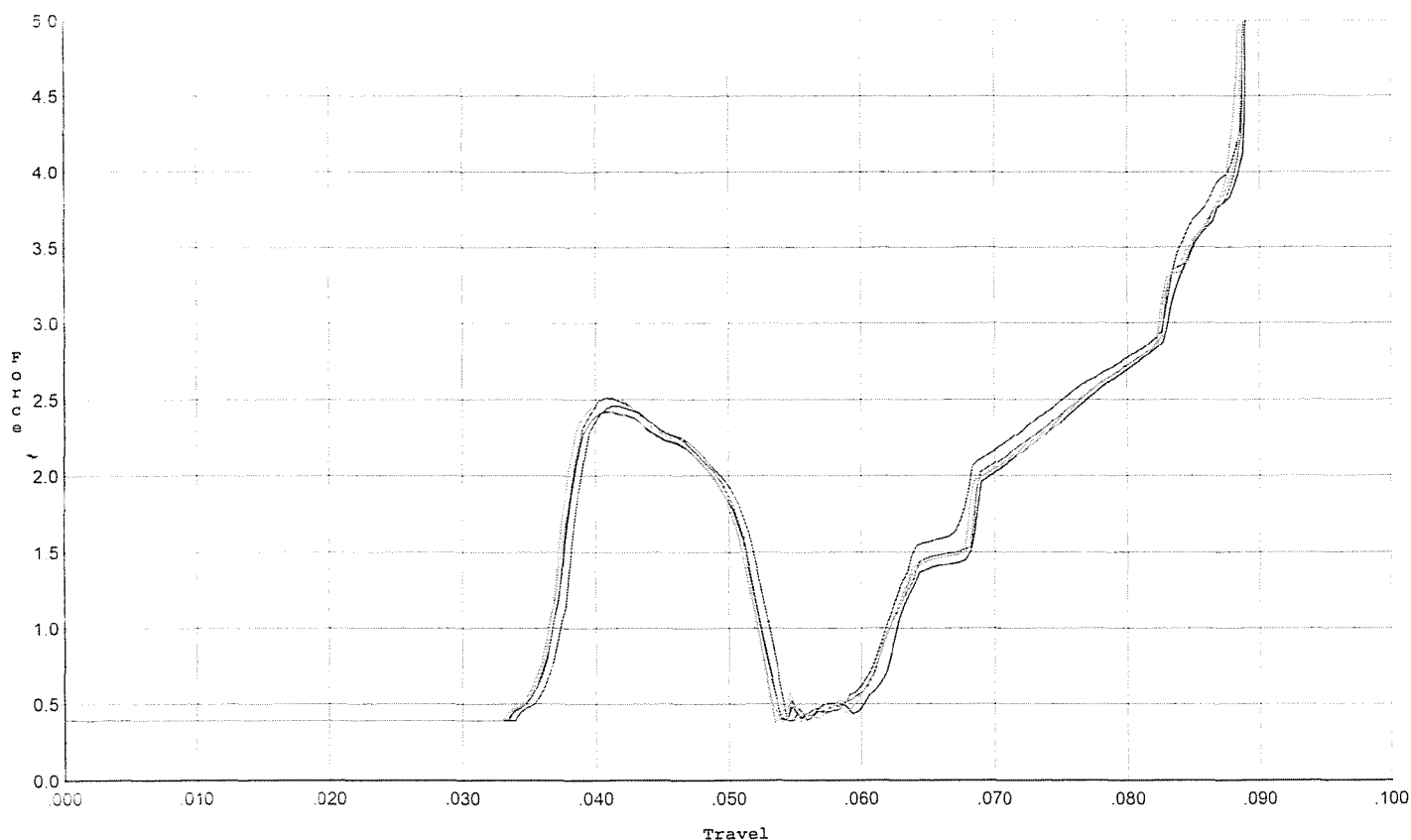
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.664	0.051	0.035	0.040	0.047		Set Trigger
2	2.600	0.051	0.034	0.041	0.047		Set Trigger
3	2.616	0.050	0.034	0.041	0.046		Set Trigger
4	2.526	0.049	0.034	0.041	0.045		Set Trigger
5	2.564	0.050	0.034	0.041	0.047		Set Trigger

Aug 2.59

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



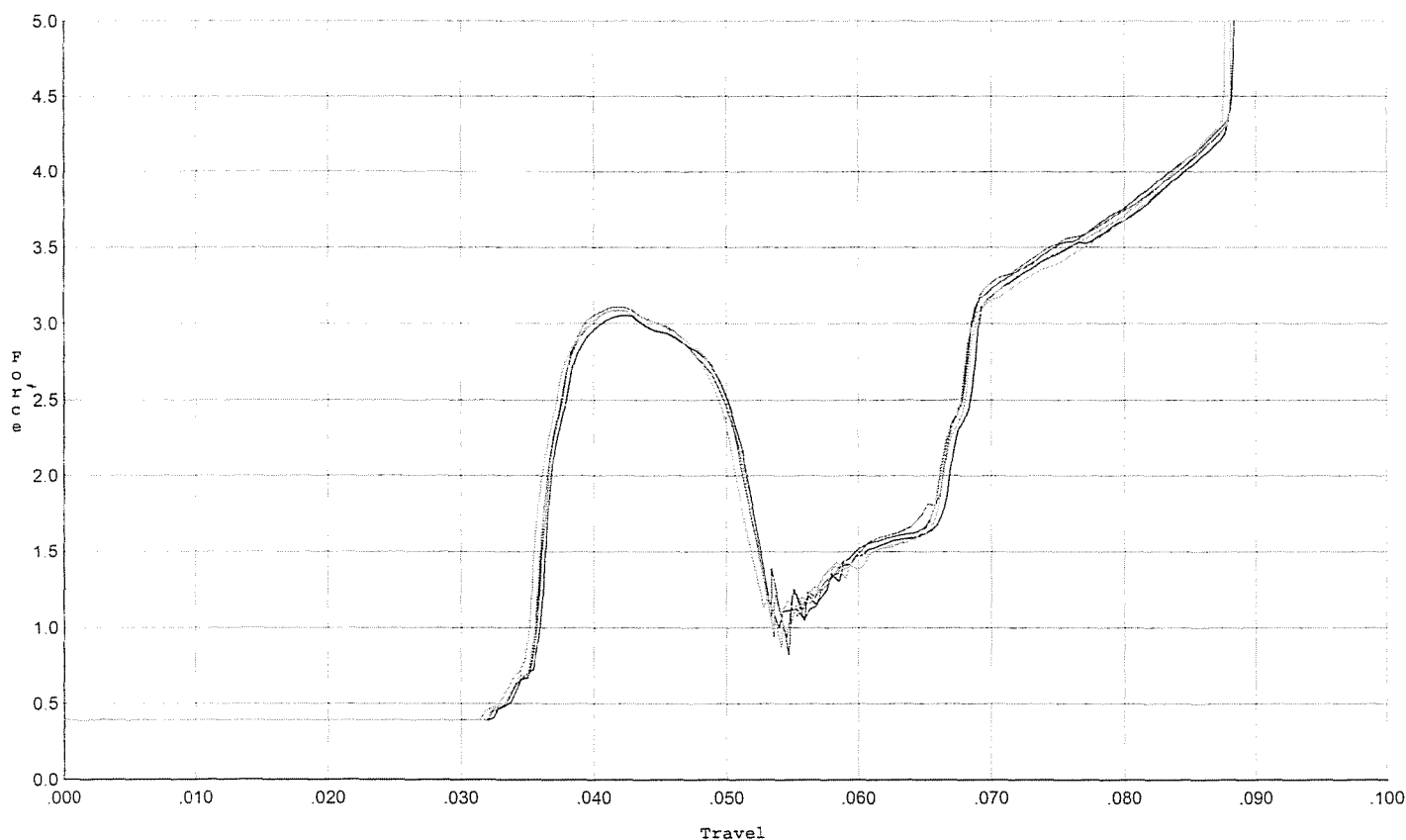
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.461	0.053	0.034	0.040	0.047		Set Trigger
2	2.423	0.051	0.034	0.041	0.045		Set Trigger
3	2.512	0.051	0.034	0.041	0.046		Set Trigger
4	2.420	0.051	0.035	0.041	0.046		Set Trigger
5	2.515	0.052	0.035	0.041	0.047		Set Trigger

Aug 2.46

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 10/30/08

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



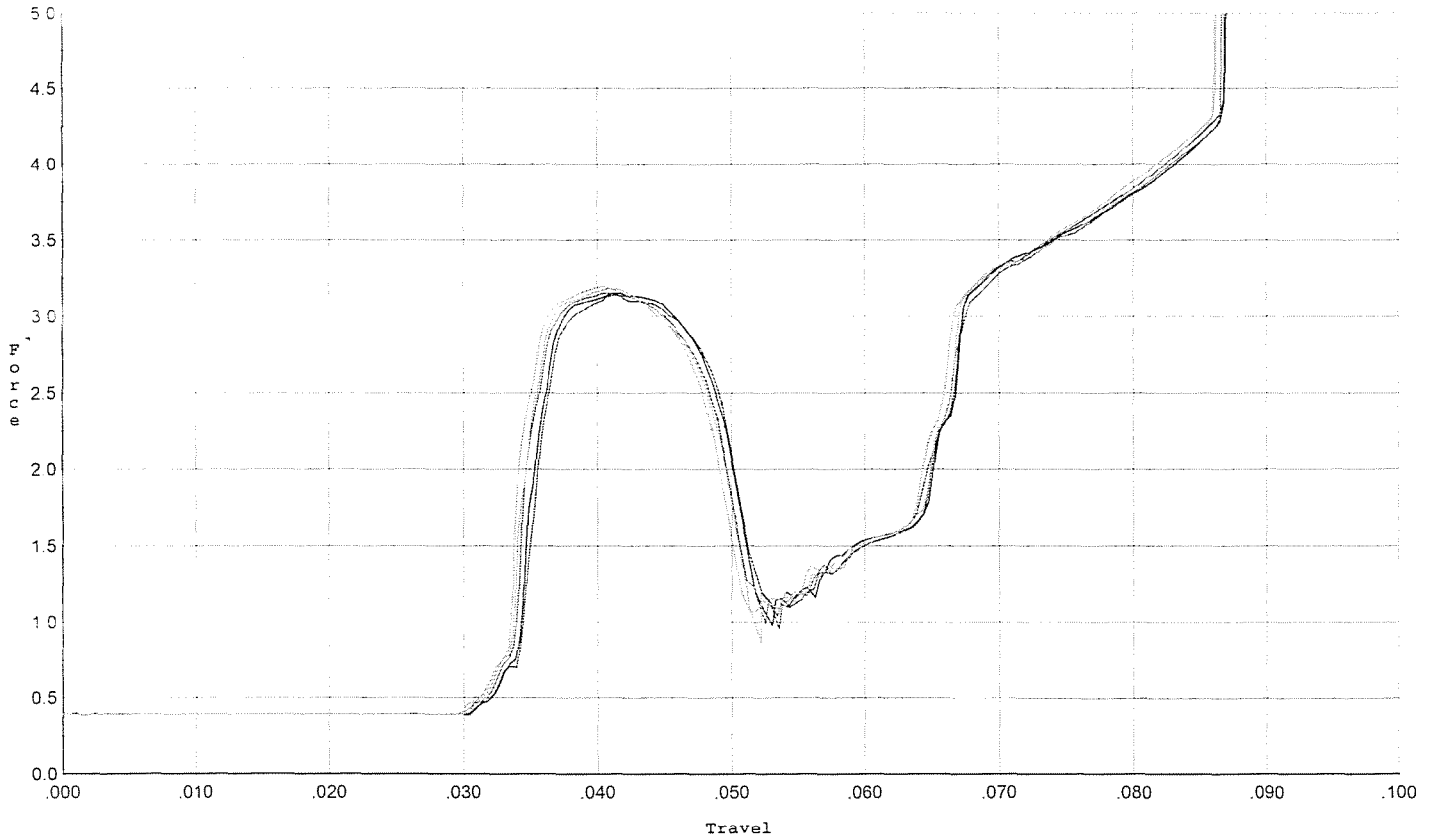
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.082	0.050	0.032	0.039	0.056		Set Trigger
2	3.052	0.051	0.033	0.039	0.057		Set Trigger
3	3.104	0.052	0.034	0.039	0.058		Set Trigger
4	3.085	0.051	0.032	0.039	0.058		Set Trigger
5	3.085	0.050	0.032	0.039	0.056		Set Trigger

Avg 3.08

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



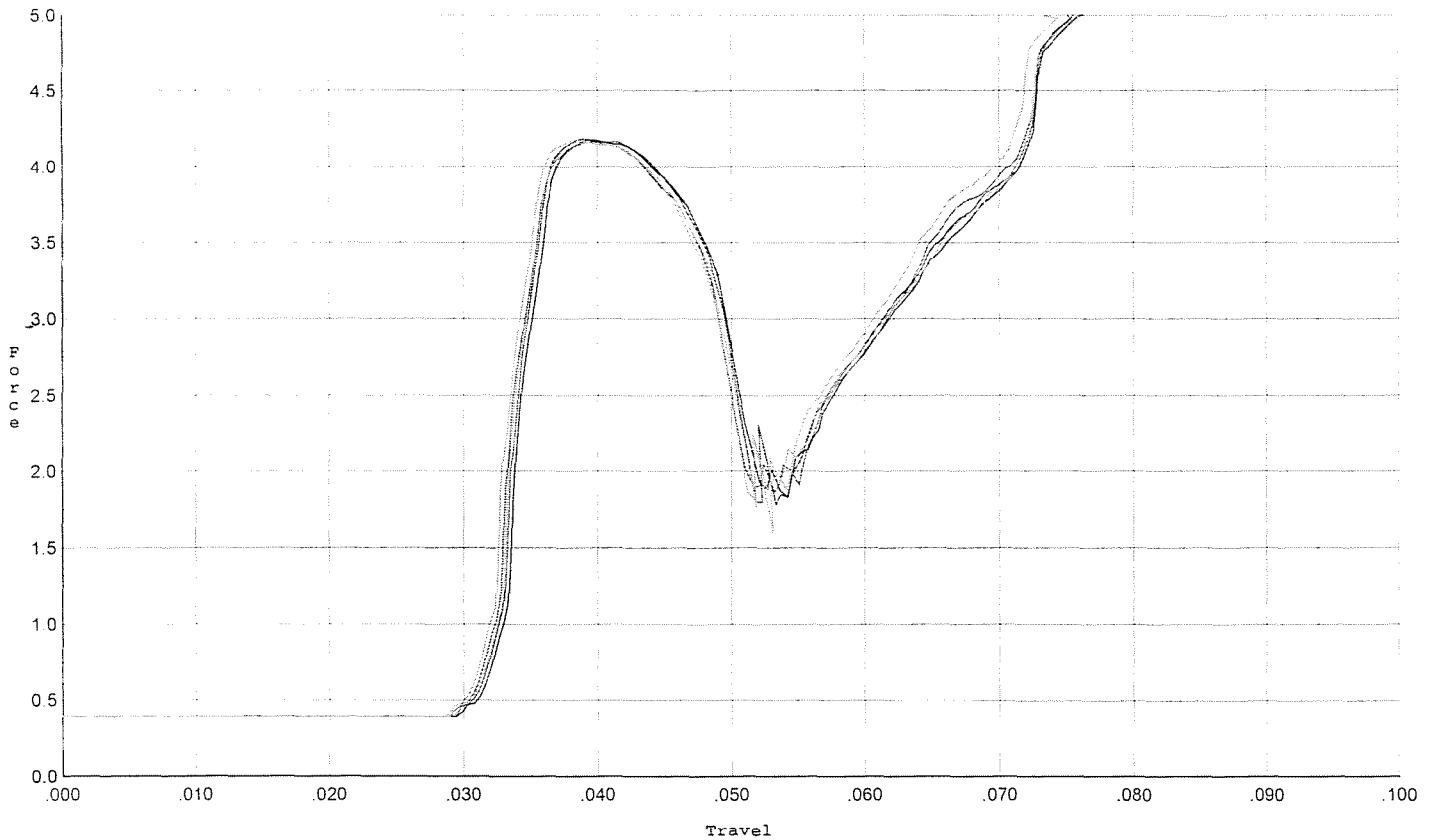
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.142	0.049	0.033	0.039	0.057		Set Trigger
2	3.154	0.050	0.033	0.039	0.058		Set Trigger
3	3.155	0.049	0.031	0.039	0.058		Set Trigger
4	3.194	0.049	0.030	0.039	0.058		Set Trigger
5	3.184	0.049	0.032	0.039	0.058		Set Trigger

Avg 3.16

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



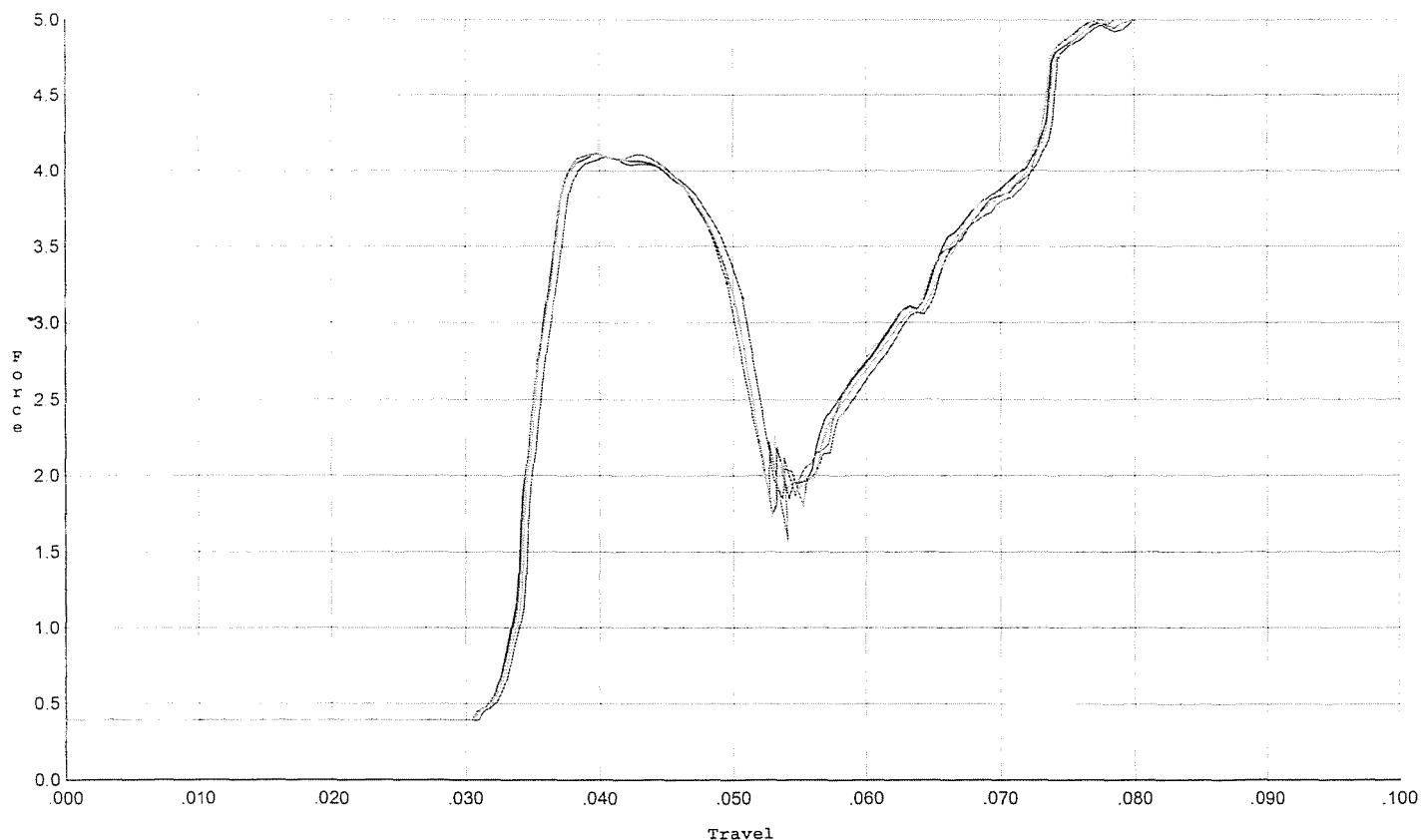
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.180	0.049	0.030	0.036	0.075		Set Trigger
2	4.174	0.049	0.032	0.036	0.074		Set Trigger
3	4.165	0.049	0.031	0.036	0.074		Set Trigger
4	4.156	0.050	0.031	0.036	0.076		Set Trigger
5	4.173	0.049	0.029	0.035	0.075		Set Trigger

Aug 4.17

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



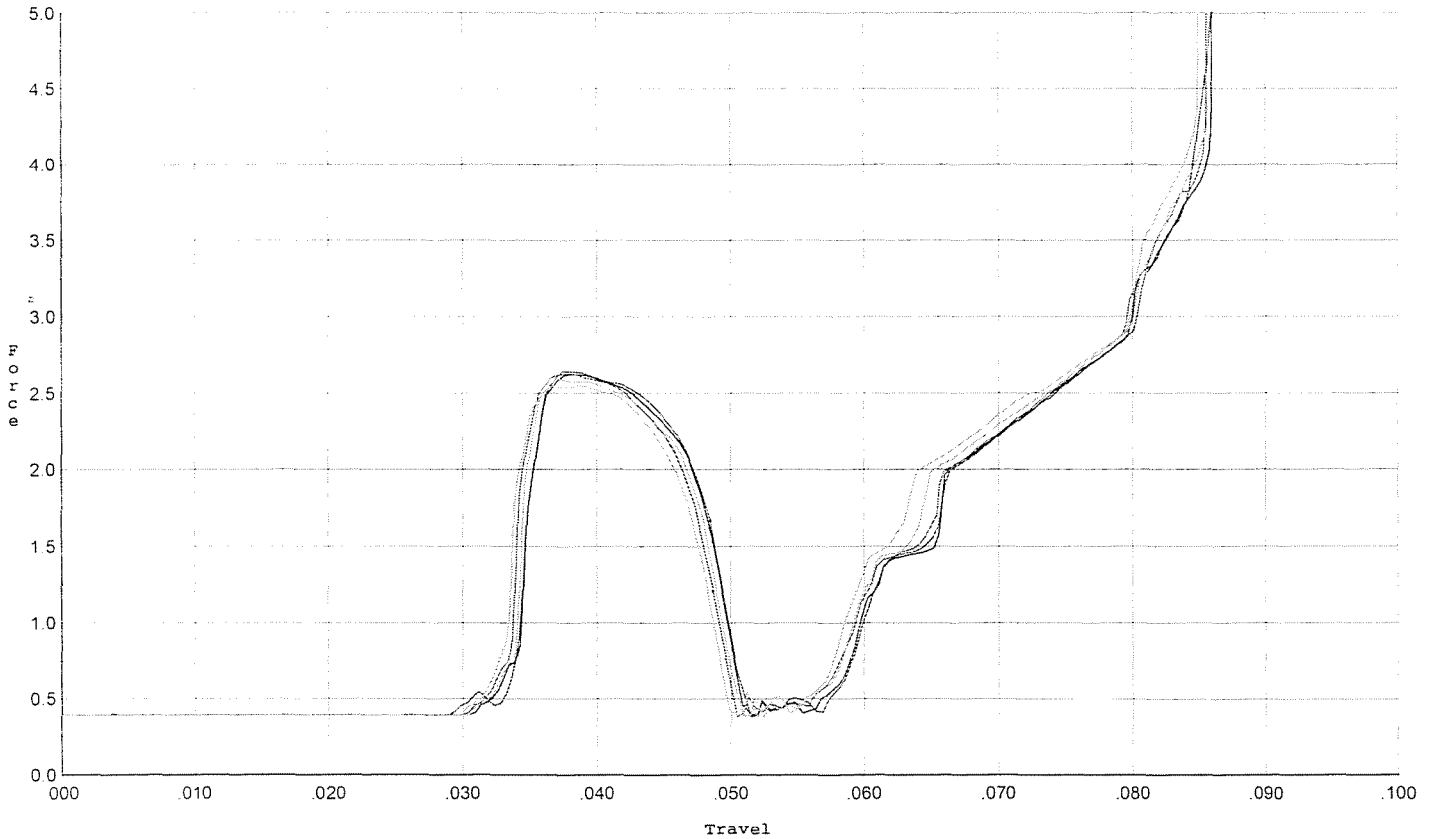
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.088	0.051	0.031	0.036	0.075		Set Trigger
2	4.115	0.050	0.031	0.036	0.076		Set Trigger
3	4.113	0.050	0.031	0.036	0.074		Set Trigger
4	4.109	0.050	0.032	0.036	0.076		Set Trigger
5	4.109	0.050	0.033	0.036	0.075		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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



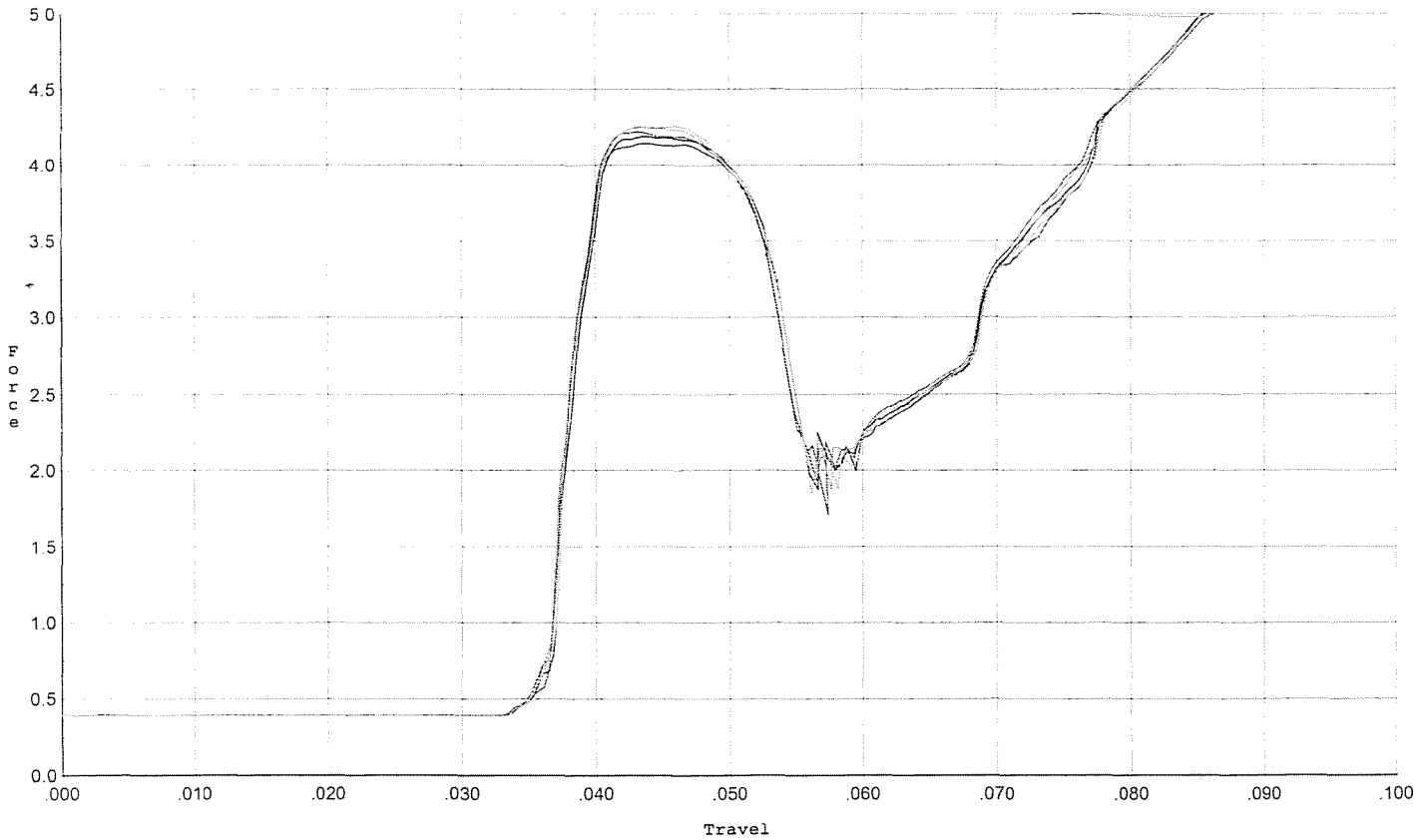
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.645	0.048	0.033	0.041	0.048		Set Trigger
2	2.623	0.049	0.033	0.041	0.047		Set Trigger
3	2.626	0.049	0.032	0.041	0.048		Set Trigger
4	2.595	0.048	0.033	0.041	0.047		Set Trigger
5	2.549	0.048	0.032	0.041	0.046		Set Trigger

Aug 2.60

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 10/30/08

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	4.142	0.053	0.036	0.038	0.077		Set Trigger
2	4.191	0.054	0.036	0.038	0.079		Set Trigger
3	4.219	0.053	0.035	0.038	0.078		Set Trigger
4	4.251	0.054	0.036	0.038	0.079		Set Trigger
5	4.256	0.054	0.036	0.038	0.080		Set Trigger

Aug 4.21