

G6814688

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

- INSTRUCTION BOOK 3518

BM FORM

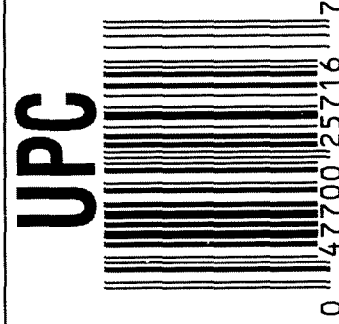


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6814688



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6814688

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SP
430	ASSEMBLE TO STOCK		3-4-09	SP
440	PROOF		3-4-09	SP
460	CHECK HEADSPACE		3-4-09	RP
470	DIS-ASSEMBLE ACTION		3-4-09	RP
472	SERIALIZE BOLT HANDLE		3-5-09	R/R
480	MAGNAFLUX BBL ACTION	(N)	3/9/09	(N)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/9/09	RT
510	DRILL AND TAP SIGHT HOLES		3-5-09	SP
520	GOFF BLAST BBL / REC		3-11	TR
540	APPLY COATINGS (BARREL ACTION)		3-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-28-09	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

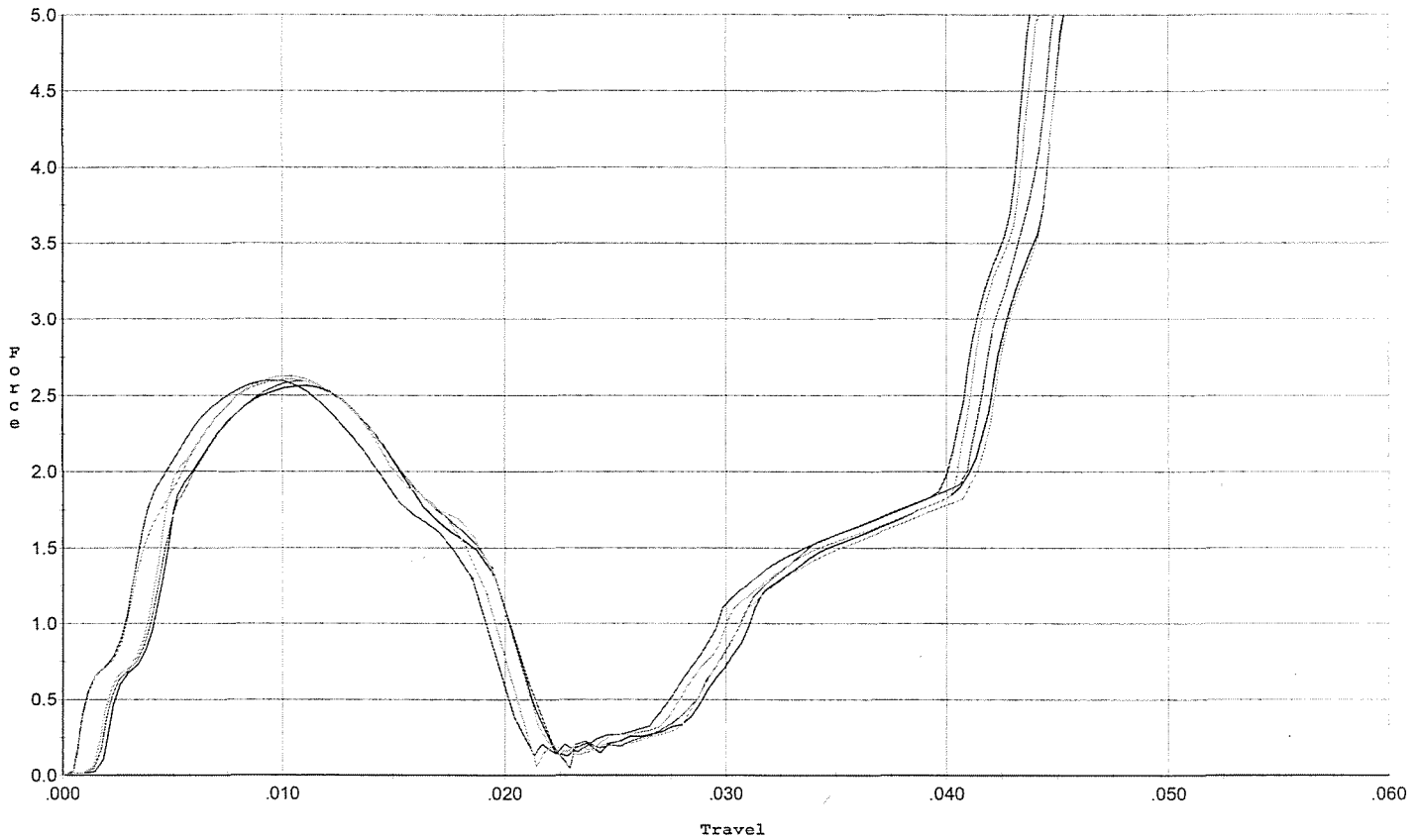
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>6</u>	4-1-09	NW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3</u> <u>3.5</u>	4-1-09	NW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	4-1-09	NW
	J) ASSEMBLE STOCK		3-28-09	RPD
	K) ASSEMBLE SWIVEL STUDS		4-1-09	NW
	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 PASS FAIL	3-31-09	RPD
	MALFUNCTION.	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-31-09	RP
670	FINAL INSPECTION A) HEADSPACE		4-1-09	NW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.17</u> <u>2.37</u> <u>2.49</u> <u>2.29</u>	4-1-09	NW
	C) FUNCTION		4-1-09	NW
690	PACK		5/22/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



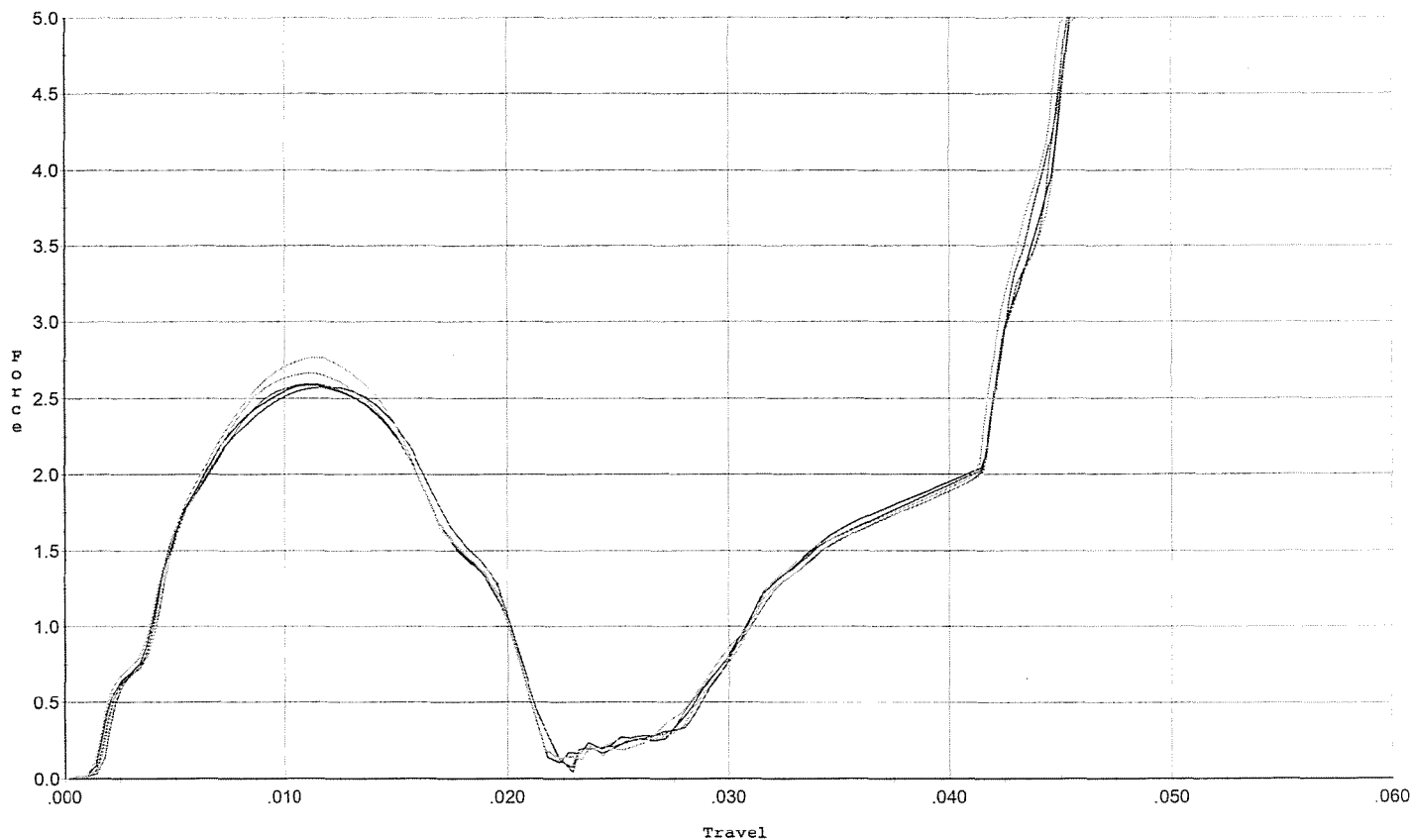
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.602	0.019	0.00	0.031	0.033		Set Trigger
2	2.564	0.019	0.00	0.032	0.032		Set Trigger
3	2.592	0.019	0.00	0.032	0.032		Set Trigger
4	2.604	0.019	0.00	0.032	0.033		Set Trigger
5	2.625	0.019	0.00	0.031	0.034		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



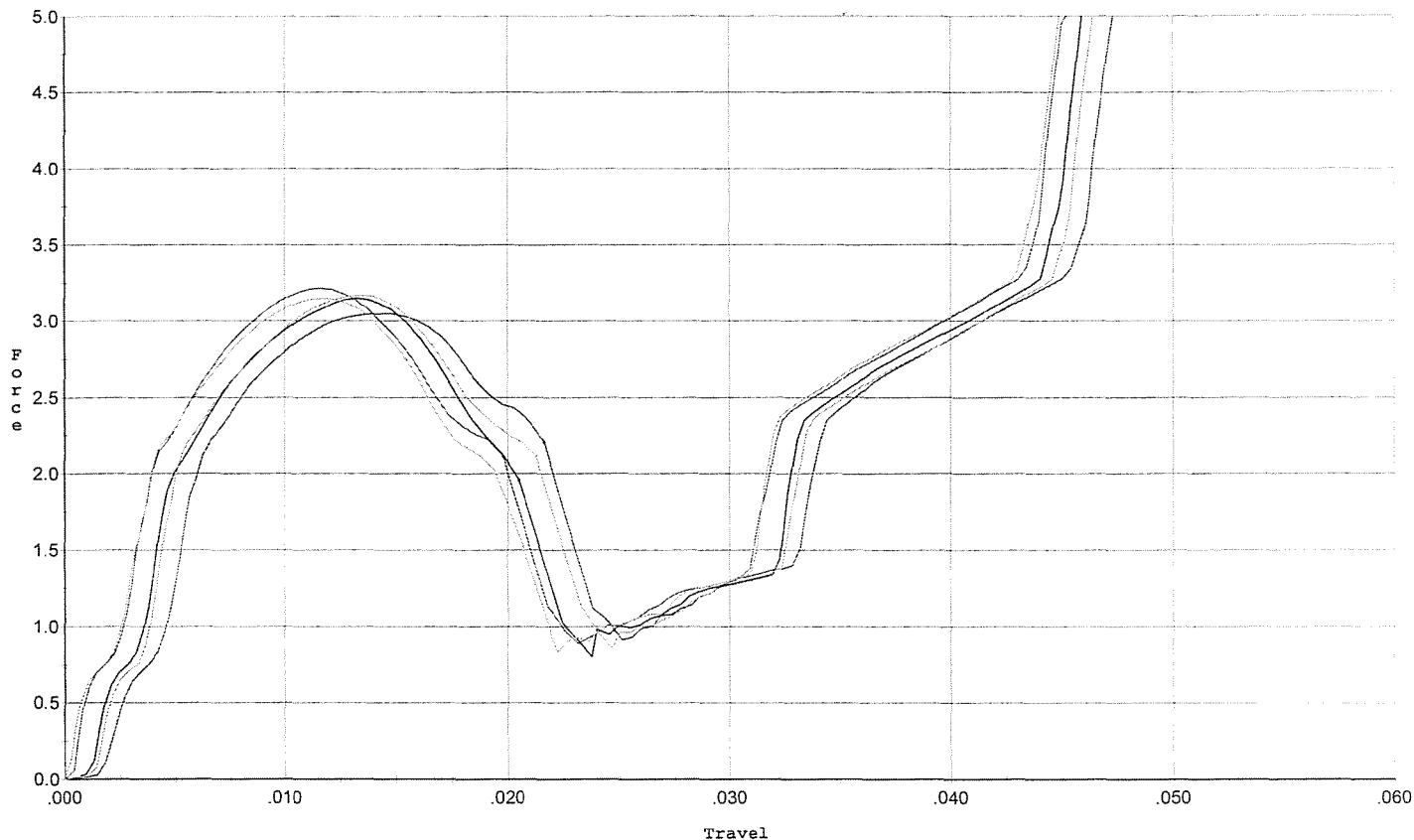
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.574	0.020	0.00	0.032	0.033		Set Trigger
2	2.588	0.020	0.00	0.032	0.033		Set Trigger
3	2.594	0.020	0.00	0.032	0.032		Set Trigger
4	2.767	0.020	0.00	0.032	0.034		Set Trigger
5	2.663	0.020	0.00	0.032	0.033		Set Trigger

1A-263

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



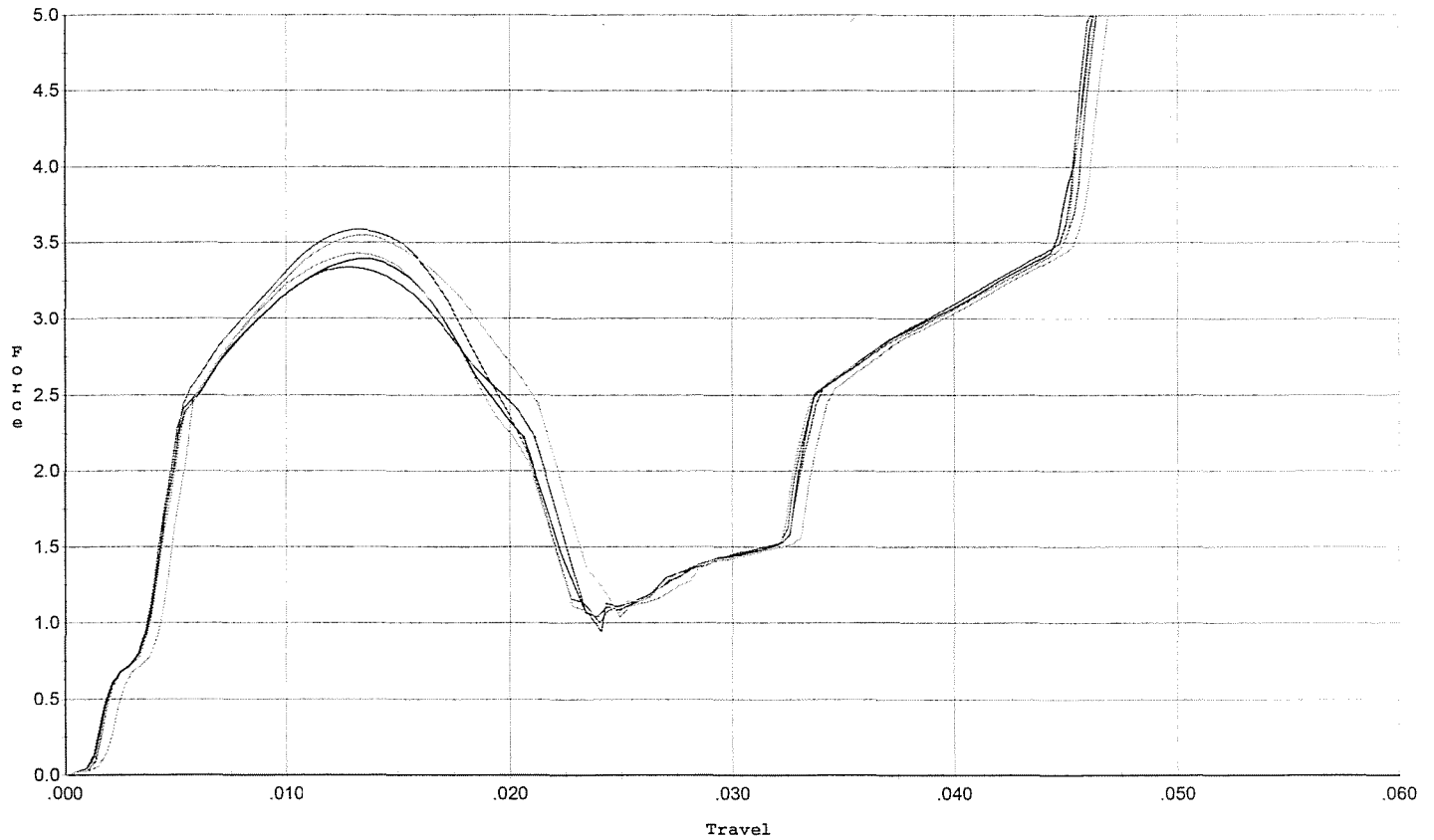
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.045	0.022	0.00	0.031	0.044		Set Trigger
2	3.149	0.021	0.00	0.031	0.043		Set Trigger
3	3.216	0.020	0.00	0.030	0.044		Set Trigger
4	3.150	0.021	0.00	0.030	0.045		Set Trigger
5	3.169	0.021	0.00	0.030	0.045		Set Trigger

A-3-14

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



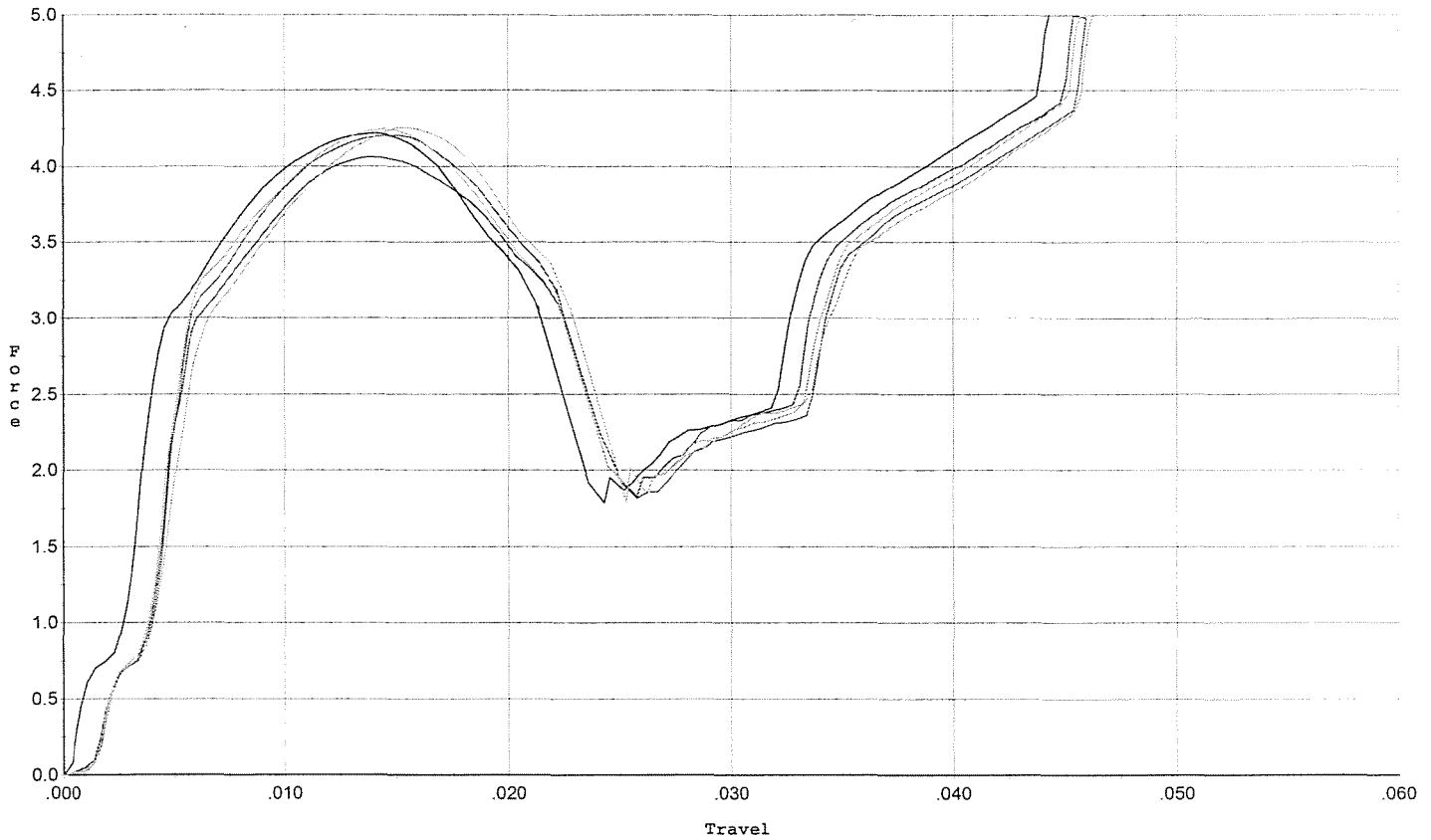
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.341	0.021	0.00	0.029	0.048		Set Trigger
2	3.394	0.021	0.00	0.030	0.046		Set Trigger
3	3.585	0.021	0.00	0.030	0.049		Set Trigger
4	3.429	0.021	0.00	0.030	0.047		Set Trigger
5	3.550	0.021	0.00	0.030	0.049		Set Trigger

A-3.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



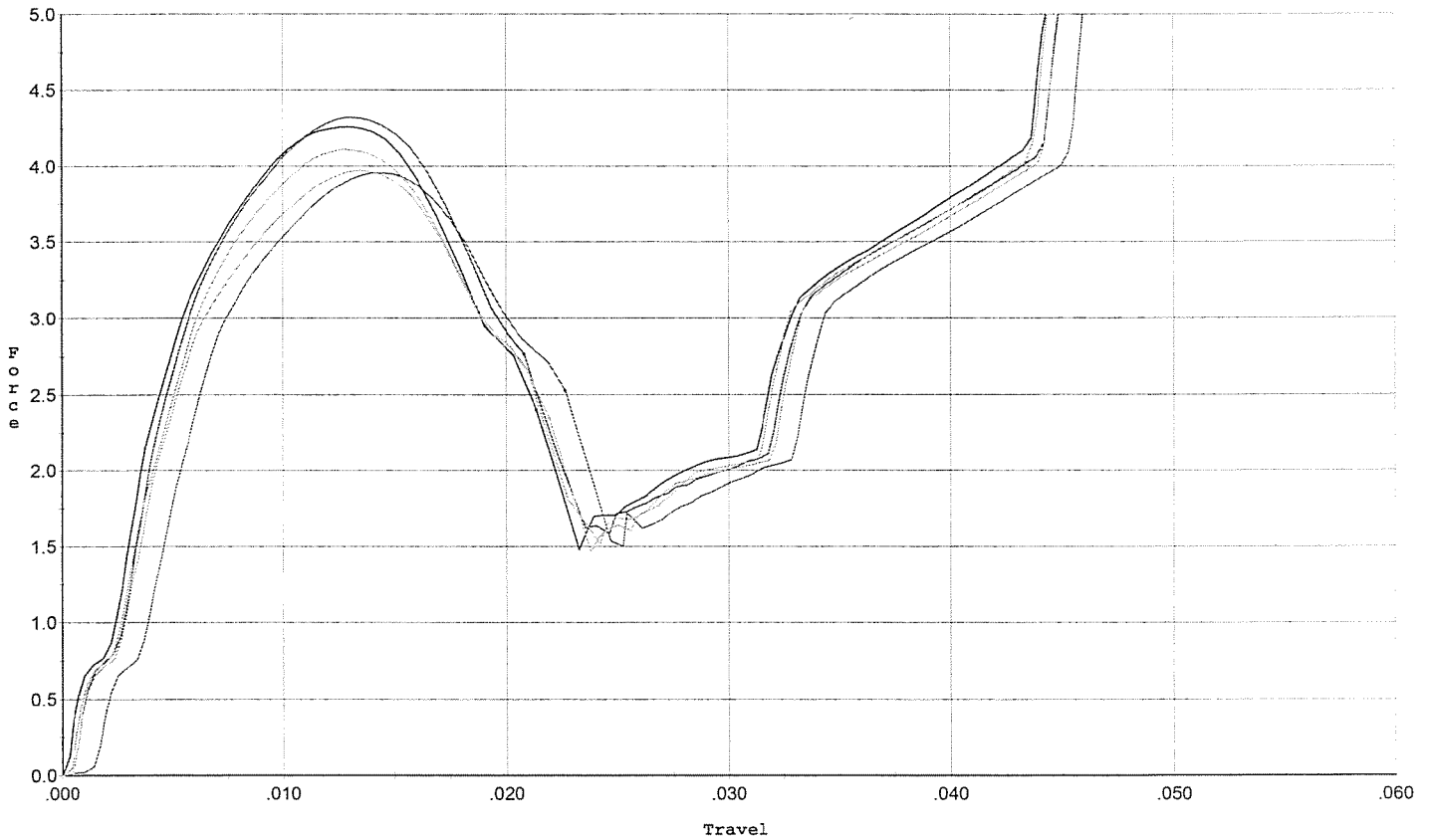
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.063	0.022	0.00	0.026	0.061		Set Trigger
2	4.219	0.021	0.00	0.026	0.063		Set Trigger
3	4.204	0.022	0.00	0.026	0.062		Set Trigger
4	4.247	0.022	0.00	0.026	0.063		Set Trigger
5	4.257	0.023	0.00	0.026	0.064		Set Trigger

A-4-19

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



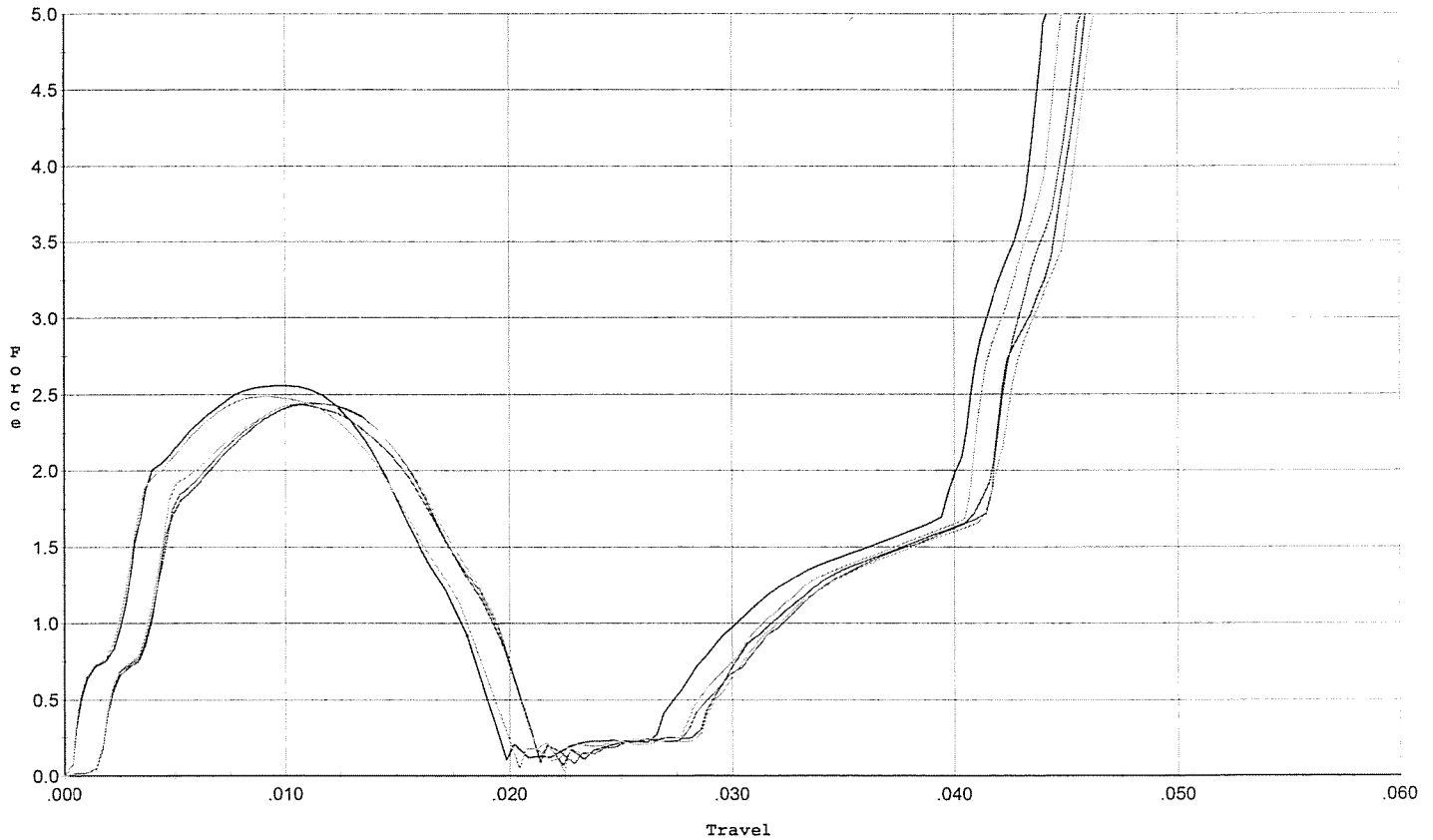
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.324	0.021	0.00	0.027	0.059		Set Trigger
2	4.260	0.021	0.00	0.027	0.061		Set Trigger
3	3.956	0.023	0.00	0.027	0.058		Set Trigger
4	3.972	0.022	0.00	0.027	0.058		Set Trigger
5	4.112	0.021	0.00	0.027	0.057		Set Trigger

A.4.12

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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



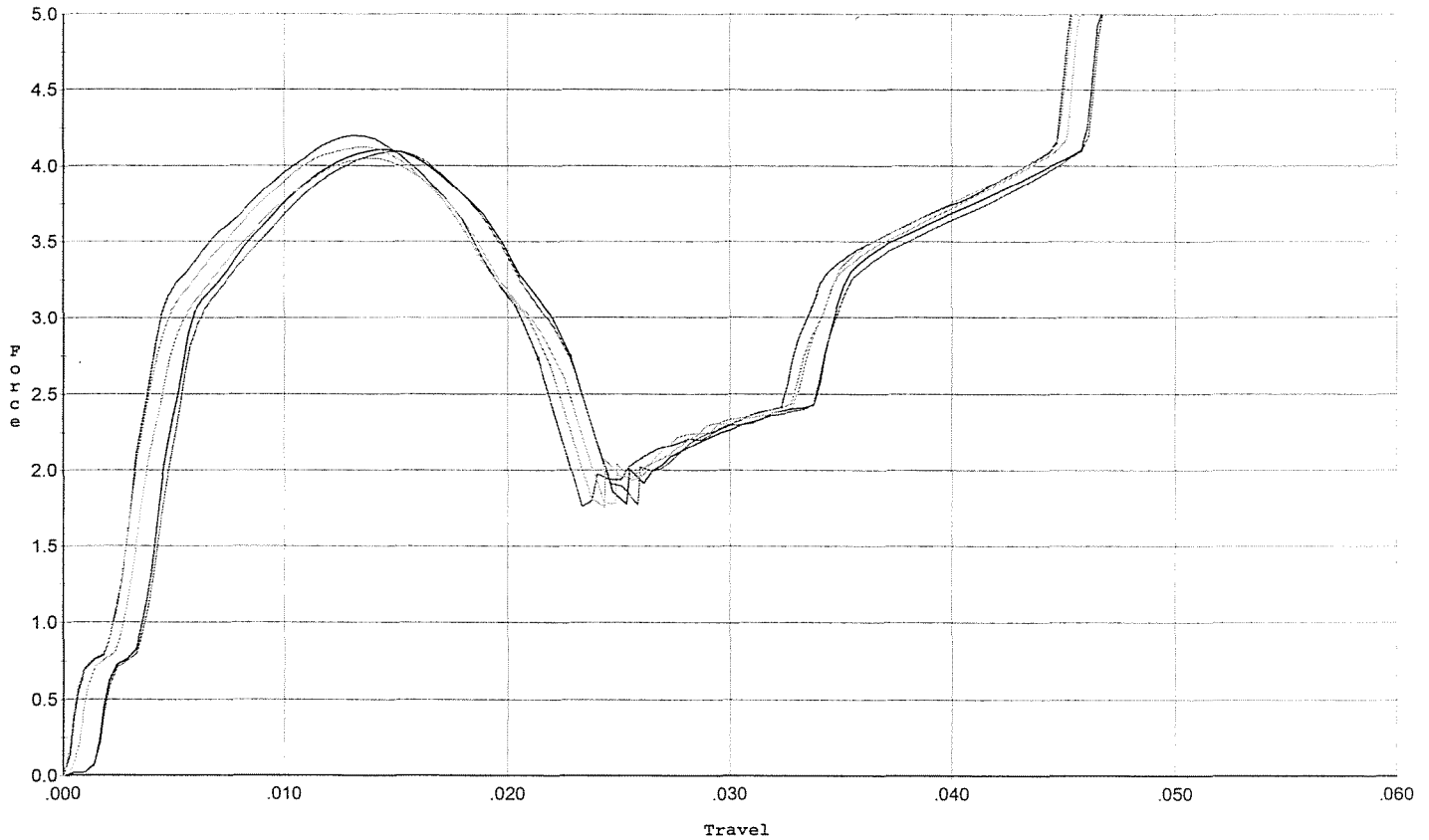
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.440	0.020	0.00	0.033	0.031		Set Trigger
2	2.558	0.018	0.00	0.033	0.032		Set Trigger
3	2.436	0.020	0.00	0.033	0.031		Set Trigger
4	2.447	0.019	0.00	0.033	0.032		Set Trigger
5	2.488	0.019	0.00	0.033	0.033		Set Trigger

A-2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/28/2009

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	4.198	0.021	0.00	0.027	0.063		Set Trigger
2	4.107	0.023	0.00	0.026	0.063		Set Trigger
3	4.093	0.023	0.00	0.026	0.062		Set Trigger
4	4.047	0.023	0.00	0.026	0.063		Set Trigger
5	4.123	0.022	0.00	0.026	0.064		Set Trigger

A.4.11