

BARBER - M24 0095638

G6869845

BARBER - M24 0095639

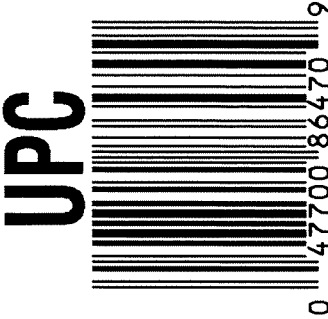
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6869845



BARBER - M24 0095640 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6869845

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-24-09	SP
430	ASSEMBLE TO STOCK		6-24-09	SP
440	PROOF		6-24-09	SP
460	CHECK HEADSPACE	MAGNA - FLUX	6-24-09	SP
470	DIS-ASSEMBLE ACTION		6-24-09	SP
472	SERIALIZE BOLT HANDLE		6-30-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	7-1-09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-10-09	DWD
510	DRILL AND TAP SIGHT HOLES		7-1-09	SP
520	GOFF BLAST BBL / REC		7/10	REM
540	APPLY COATINGS (BARREL ACTION)		7/16	✓
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-23-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-23-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER	INSPECT FOR LIVE AMMO	7-23-09	SP
	D) OIL FIRING PIN ASSEMBLY		8-10-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

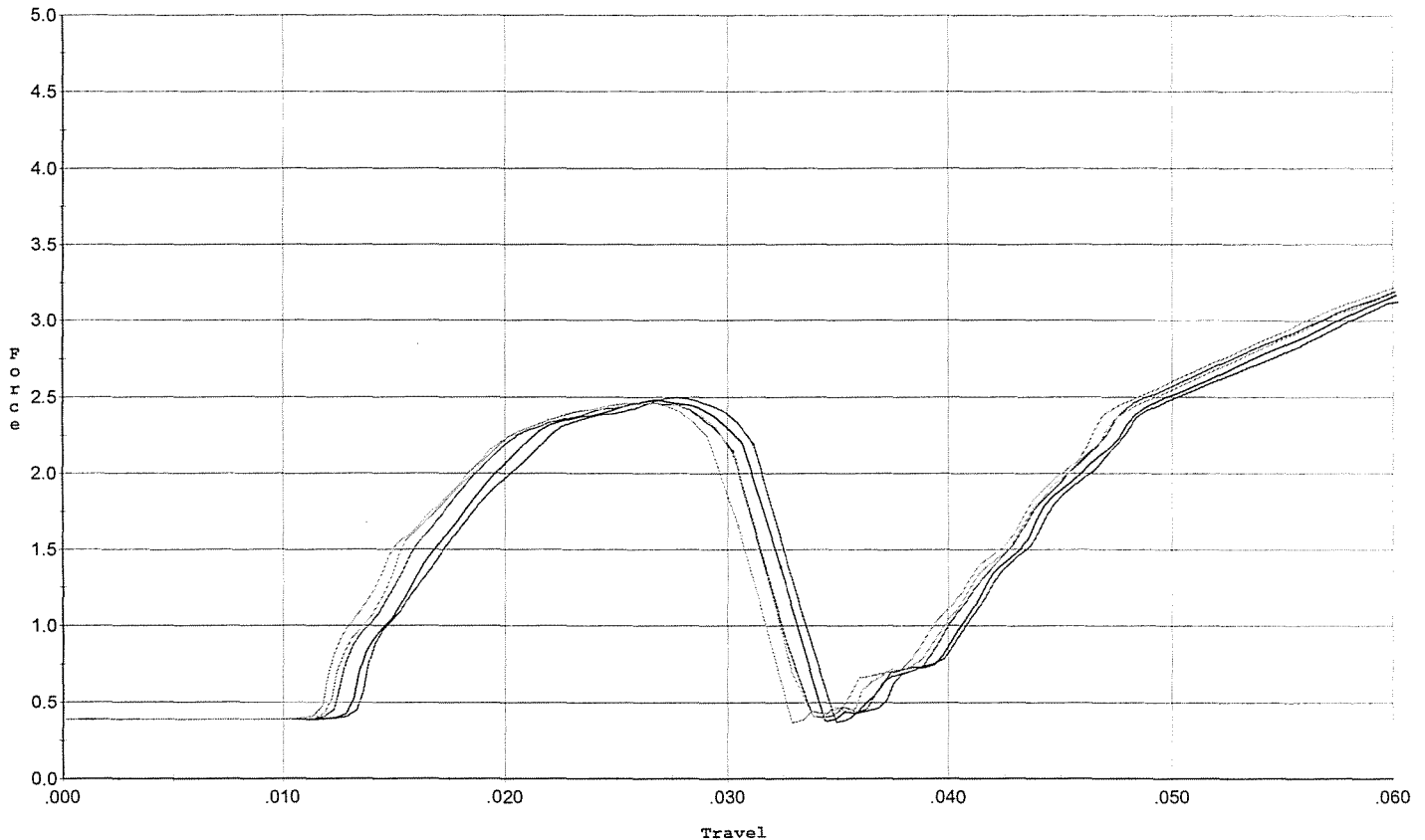
560	F) SAFETY ON FORCE	BARBER - M24 00956412 LBS MIN 10 LBS MAX	<u>3°</u>	<u>3°</u>	<u>3°</u>	8/24/09	RB		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5°</u>	<u>5°</u>	<u>5°</u>	8/24/09	RB		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.024</u>	<u>.024</u>	8/24/09	RB		
	J) ASSEMBLE STOCK					8-10-09	RZ		
	K) ASSEMBLE SWIVEL STUDS					8/24/09	RB		
	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		8-22-09	RP		
			<u>PASS</u>	FAIL					
	MALFUNCTION		N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					8-22-09	S.P.D.		
670	FINAL INSPECTION A) HEADSPACE					8/24/09	RB		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u>	<u>2.51</u>	<u>2.65</u>	<u>2.59</u>	<u>2.33</u>	8/24/09	RB
	C) FUNCTION					8/24/09	RB		
690	PACK					8/24/09	Fm		

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



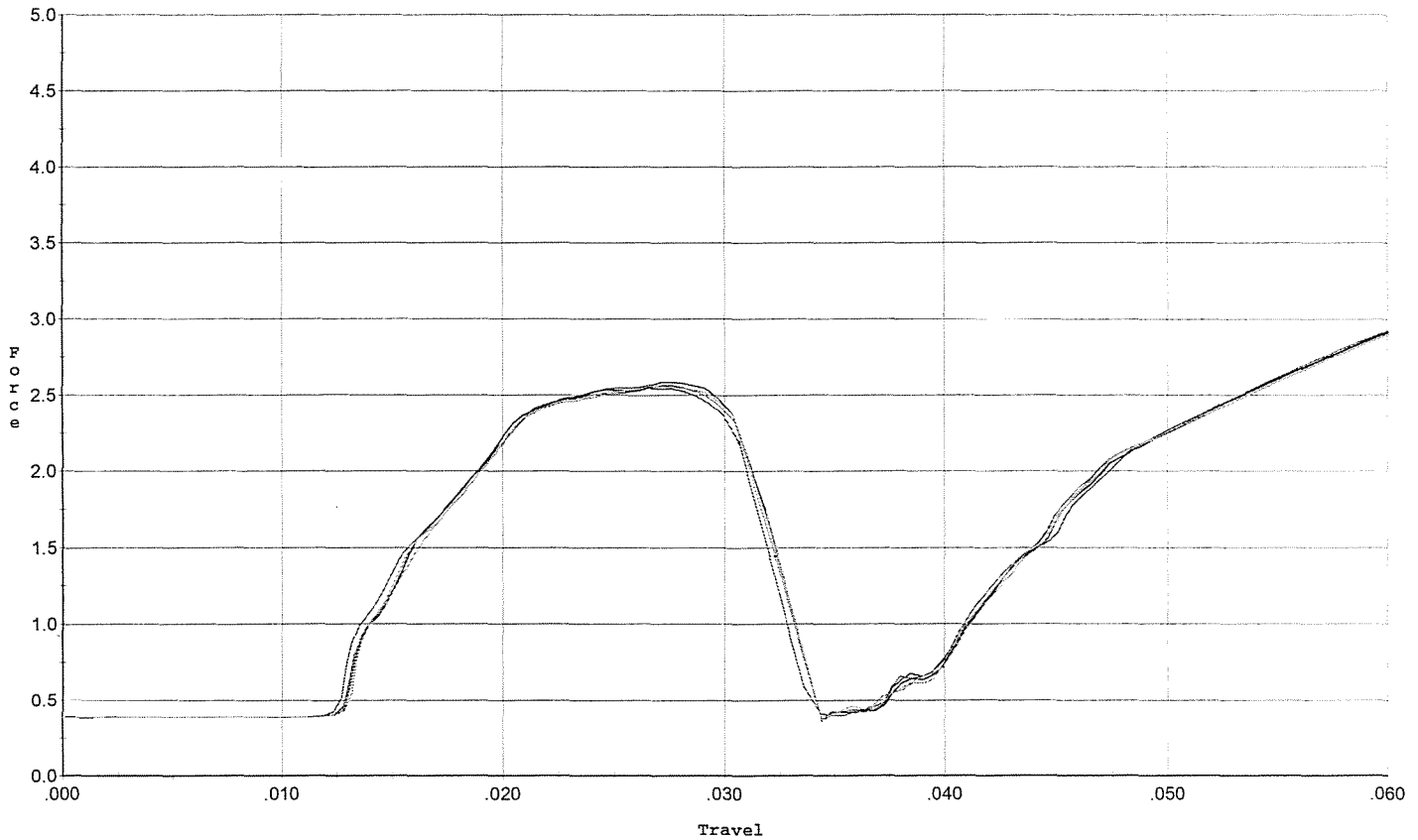
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.499	0.031	0.014	0.038	0.040		Set Trigger
2	2.483	0.032	0.013	0.038	0.042		Set Trigger
3	2.457	0.030	0.013	0.038	0.040		Set Trigger
4	2.462	0.030	0.012	0.038	0.041		Set Trigger
5	2.464	0.030	0.012	0.038	0.041		Set Trigger

Aug 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



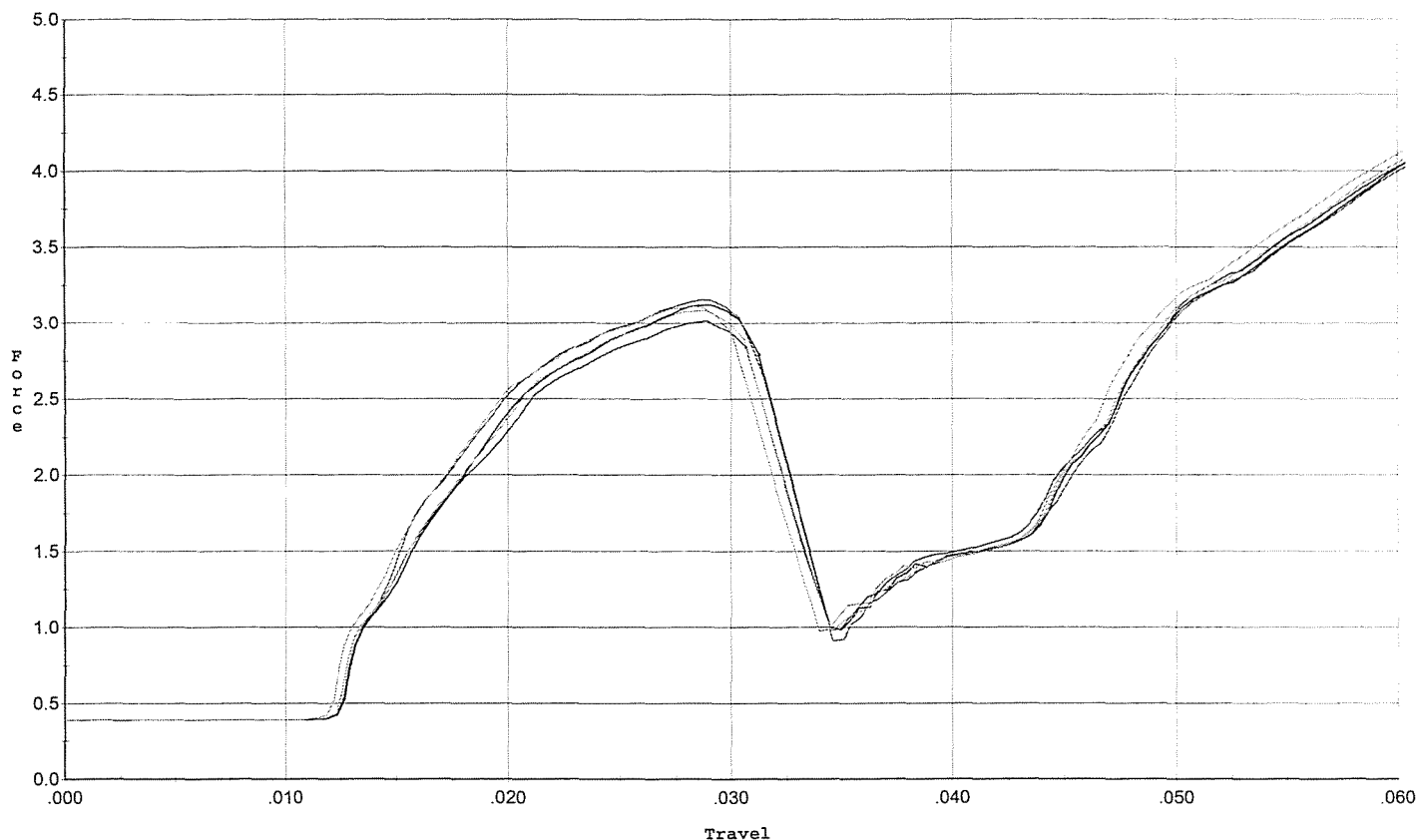
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.584	0.032	0.013	0.038	0.044		Set Trigger
2	2.563	0.032	0.013	0.039	0.044		Set Trigger
3	2.544	0.031	0.013	0.039	0.042		Set Trigger
4	2.560	0.032	0.013	0.039	0.044		Set Trigger
5	2.556	0.032	0.013	0.039	0.043		Set Trigger

Avg 2.56

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



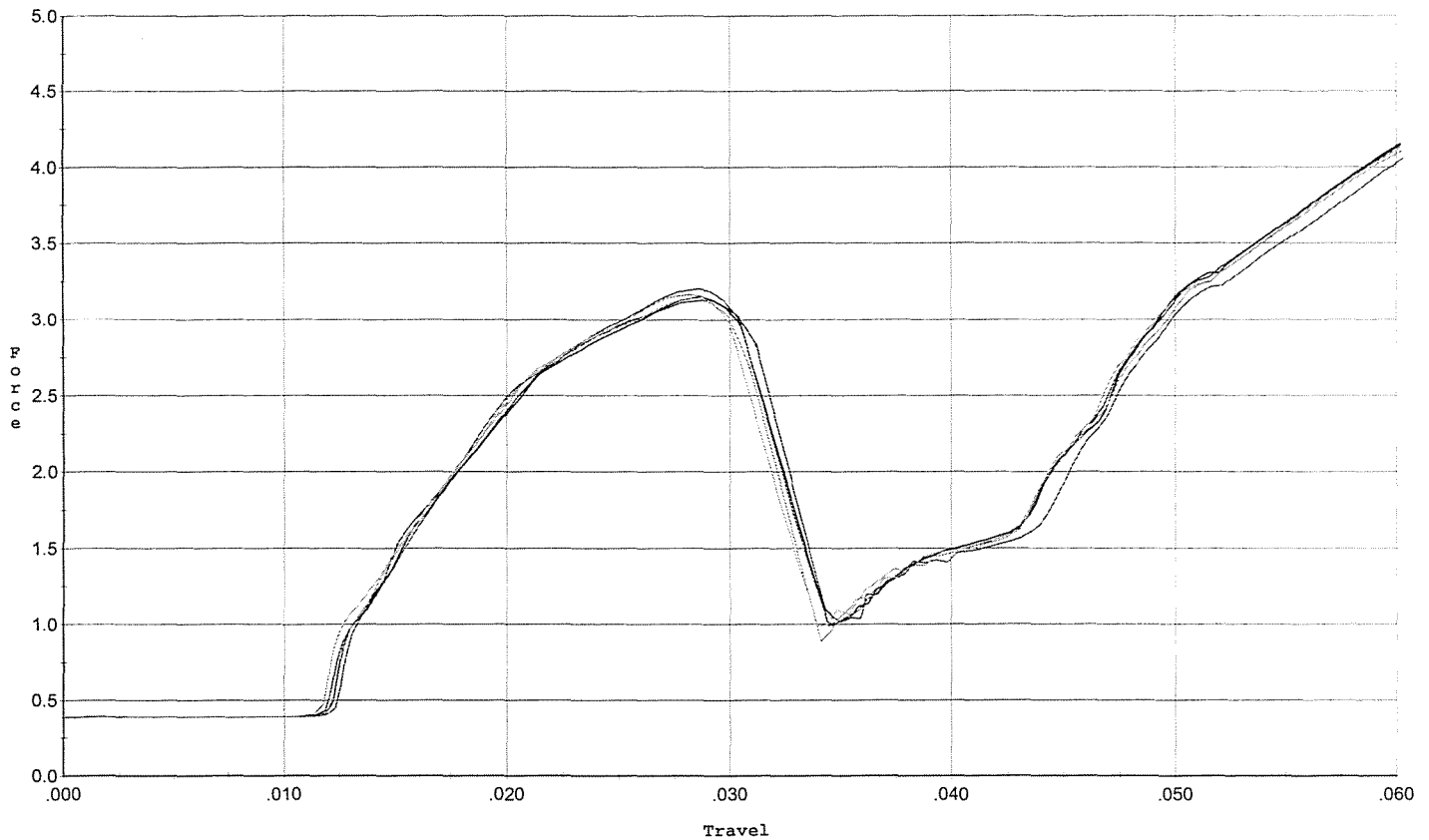
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.015	0.031	0.013	0.037	0.047		Set Trigger
2	3.117	0.031	0.013	0.036	0.049		Set Trigger
3	3.155	0.031	0.013	0.036	0.051		Set Trigger
4	3.082	0.031	0.013	0.036	0.048		Set Trigger
5	3.115	0.030	0.012	0.037	0.048		Set Trigger

Aug 3.09

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



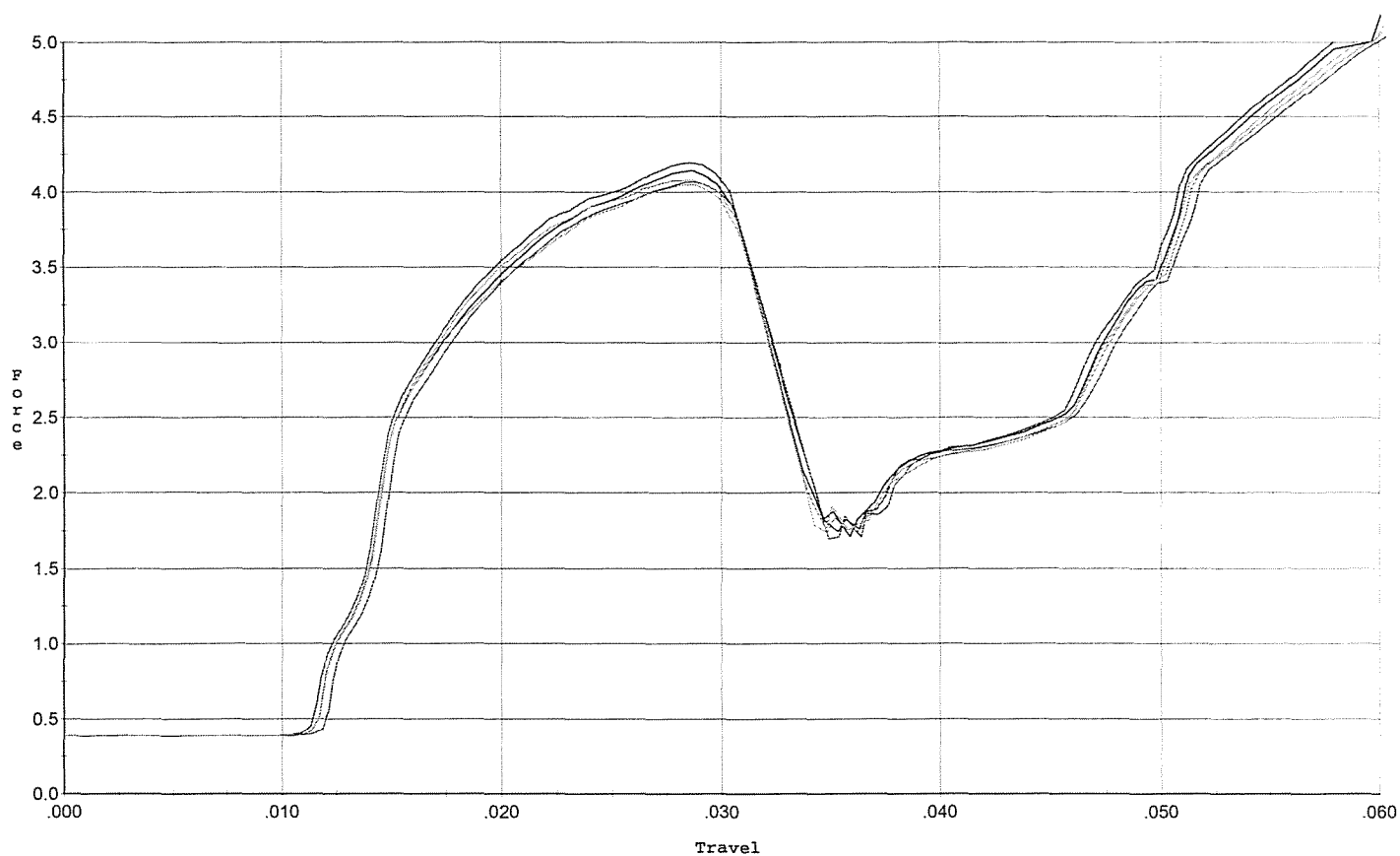
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.126	0.031	0.012	0.036	0.050		Set Trigger
2	3.153	0.030	0.012	0.036	0.048		Set Trigger
3	3.203	0.030	0.013	0.037	0.048		Set Trigger
4	3.164	0.030	0.012	0.036	0.047		Set Trigger
5	3.139	0.031	0.012	0.036	0.049		Set Trigger

Aug 3.15

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



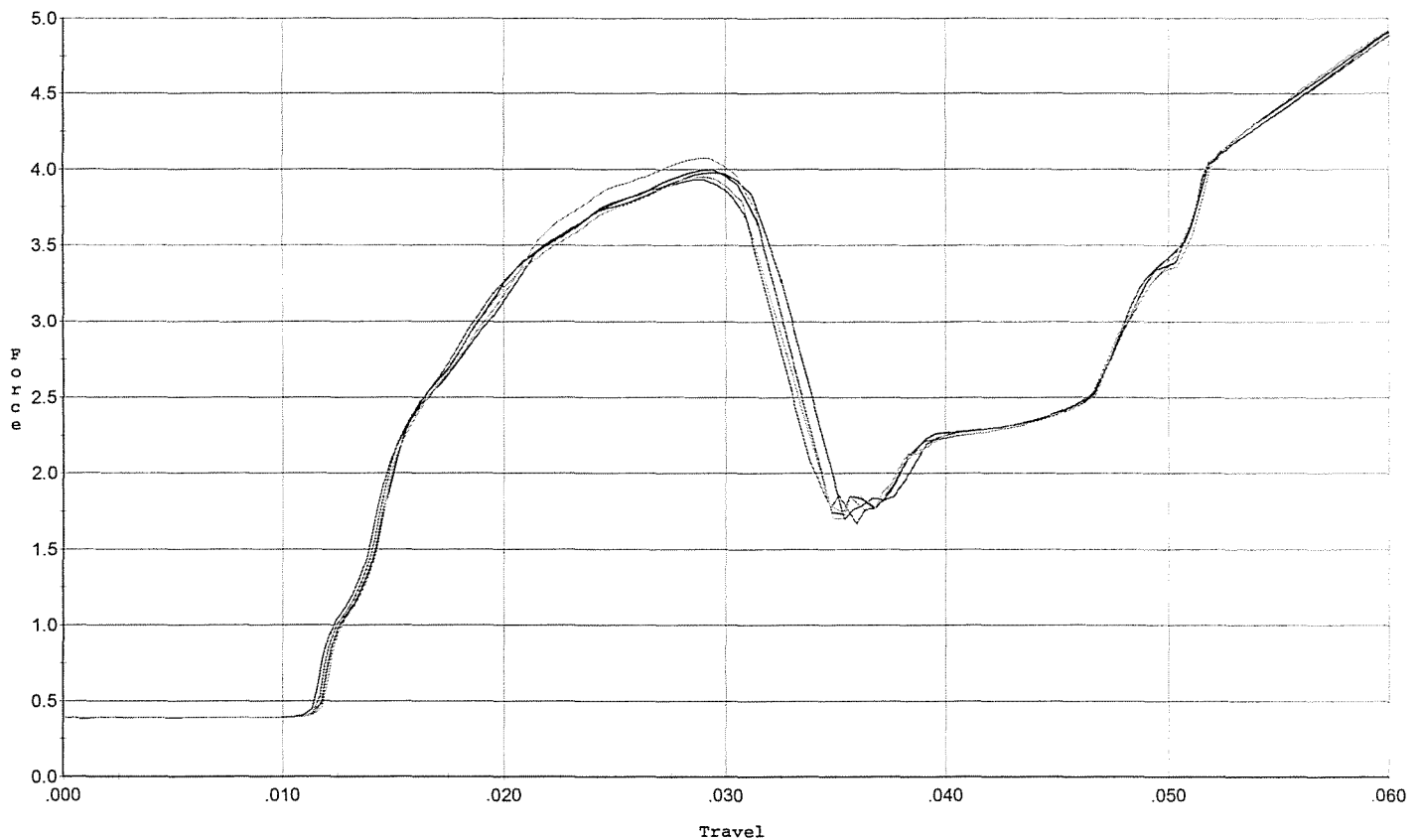
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.196	0.030	0.012	0.029	0.066		Set Trigger
2	4.145	0.031	0.012	0.030	0.065		Set Trigger
3	4.069	0.033	0.012	0.030	0.068		Set Trigger
4	4.050	0.031	0.012	0.030	0.065		Set Trigger
5	4.078	0.031	0.012	0.030	0.065		Set Trigger

Avg 4.10

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



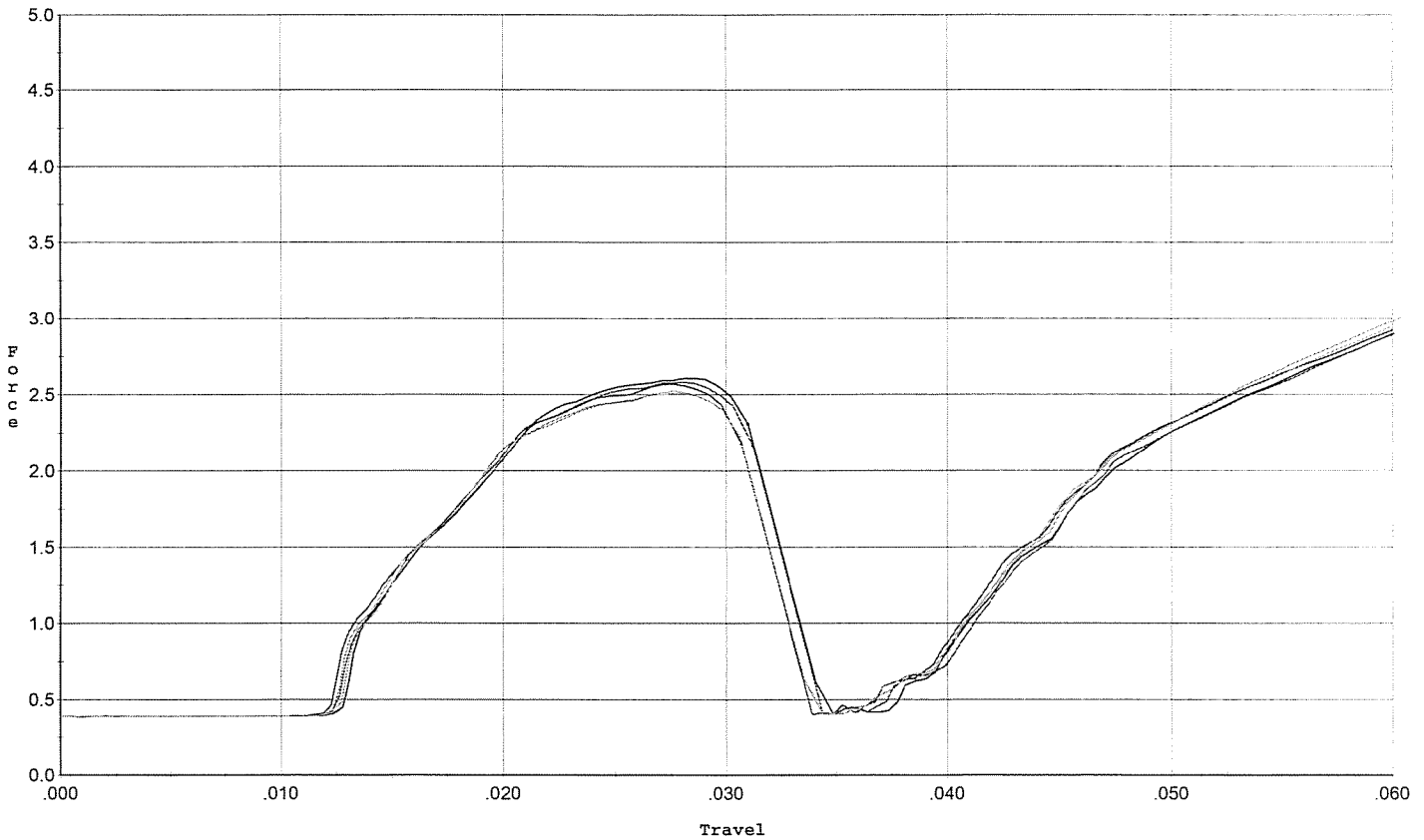
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.979	0.033	0.012	0.029	0.068		Set Trigger
2	3.997	0.031	0.012	0.030	0.065		Set Trigger
3	3.932	0.031	0.012	0.031	0.063		Set Trigger
4	3.953	0.033	0.012	0.030	0.066		Set Trigger
5	4.072	0.031	0.012	0.030	0.065		Set Trigger

Avg 3.98

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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



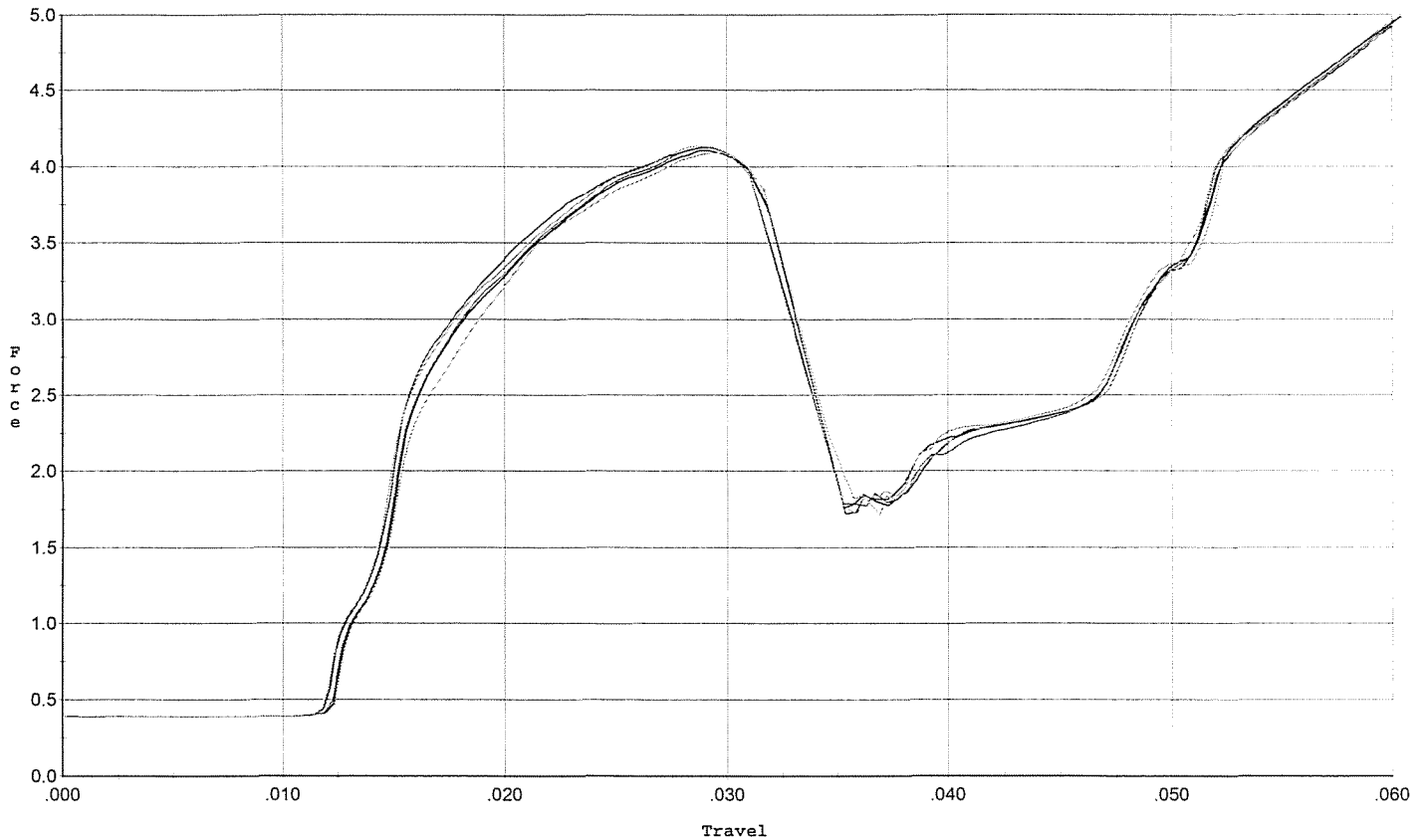
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.569	0.031	0.012	0.039	0.042		Set Trigger
2	2.606	0.031	0.013	0.038	0.042		Set Trigger
3	2.581	0.031	0.013	0.038	0.043		Set Trigger
4	2.526	0.031	0.013	0.039	0.041		Set Trigger
5	2.509	0.031	0.013	0.038	0.041		Set Trigger

Aug 2.55

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R.P. 8/7/09

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	4.128	0.033	0.012	0.030	0.070		Set Trigger
2	4.106	0.032	0.012	0.030	0.067		Set Trigger
3	4.121	0.032	0.012	0.029	0.067		Set Trigger
4	4.091	0.032	0.012	0.030	0.066		Set Trigger
5	4.137	0.031	0.012	0.030	0.066		Set Trigger

Avg 4.11