

BARBER - M24 0014761

G680 1394

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

proof of purchase



owner registration sticker



BM FORM

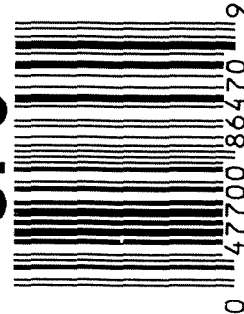
ORDER NO. **86470**

BARREL LENGTH **24"**

CAPACITY **6**

G6801394

UPC



GUN SERIAL #

G 680 1394

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-21-08	SP
430	ASSEMBLE TO STOCK		10-21-08	SP
440	PROOF		10-21-08	SP
460	CHECK HEADSPACE		10-21-08	SP
470	DIS-ASSEMBLE ACTION		10-21-08	SP
472	SERIALIZE BOLT HANDLE		10-22-08	BSN
475	DRILL AND TAP SIGHT HOLES		10-22-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (15)	10/24/08	(15)
490	MAGNAFLUX BOLT		10/24/08	MR
500	ROLLMARK CALIBER		10/24/08	RT
520	GOFF BLAST BBL / REC		10/25/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-28	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-30-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-30-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-30-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-9-09	BSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

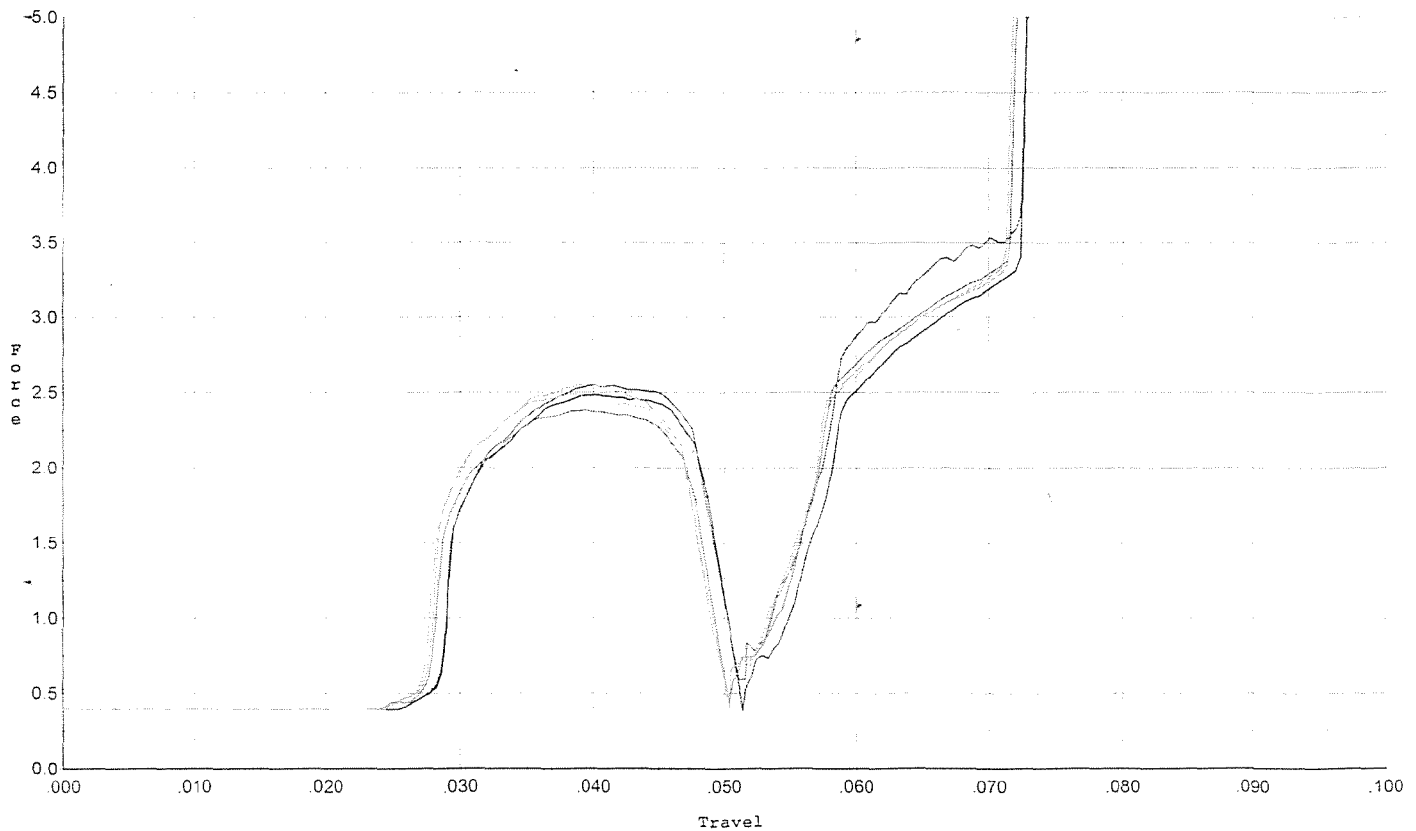
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	1-13-09	L N
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	1-13-09	L N
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-13-09	R N
	J) ASSEMBLE STOCK		1-9-09	RBN
	K) ASSEMBLE SWIVEL STUDS		1-13-09	L N
	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	1-12-09	L N
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-12-09	R P
670	FINAL INSPECTION A) HEADSPACE		1-13-09	L N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.44</u> <u>2.47</u> <u>2.41</u> <u>2.42</u>	1-13-09	L N
	C) FUNCTION		1-13-09	L N
690	PACK		1/16/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



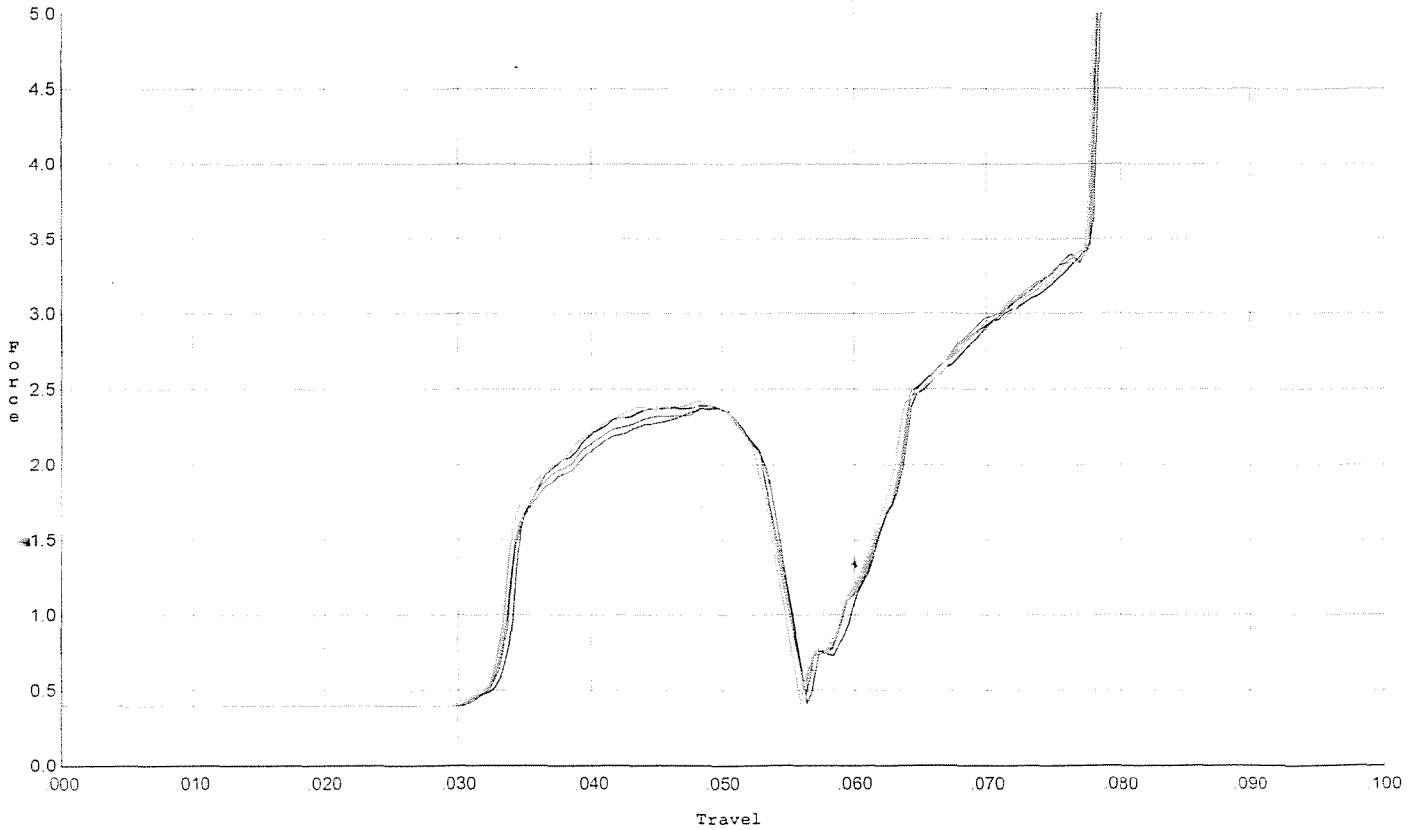
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.548	0.049	0.029	0.029	0.058		Set Trigger
2	2.487	0.049	0.029	0.029	0.056		Set Trigger
3	2.381	0.048	0.028	0.029	0.054		Set Trigger
4	2.488	0.047	0.027	0.029	0.055		Set Trigger
5	2.553	0.047	0.028	0.029	0.055		Set Trigger

A-2-49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



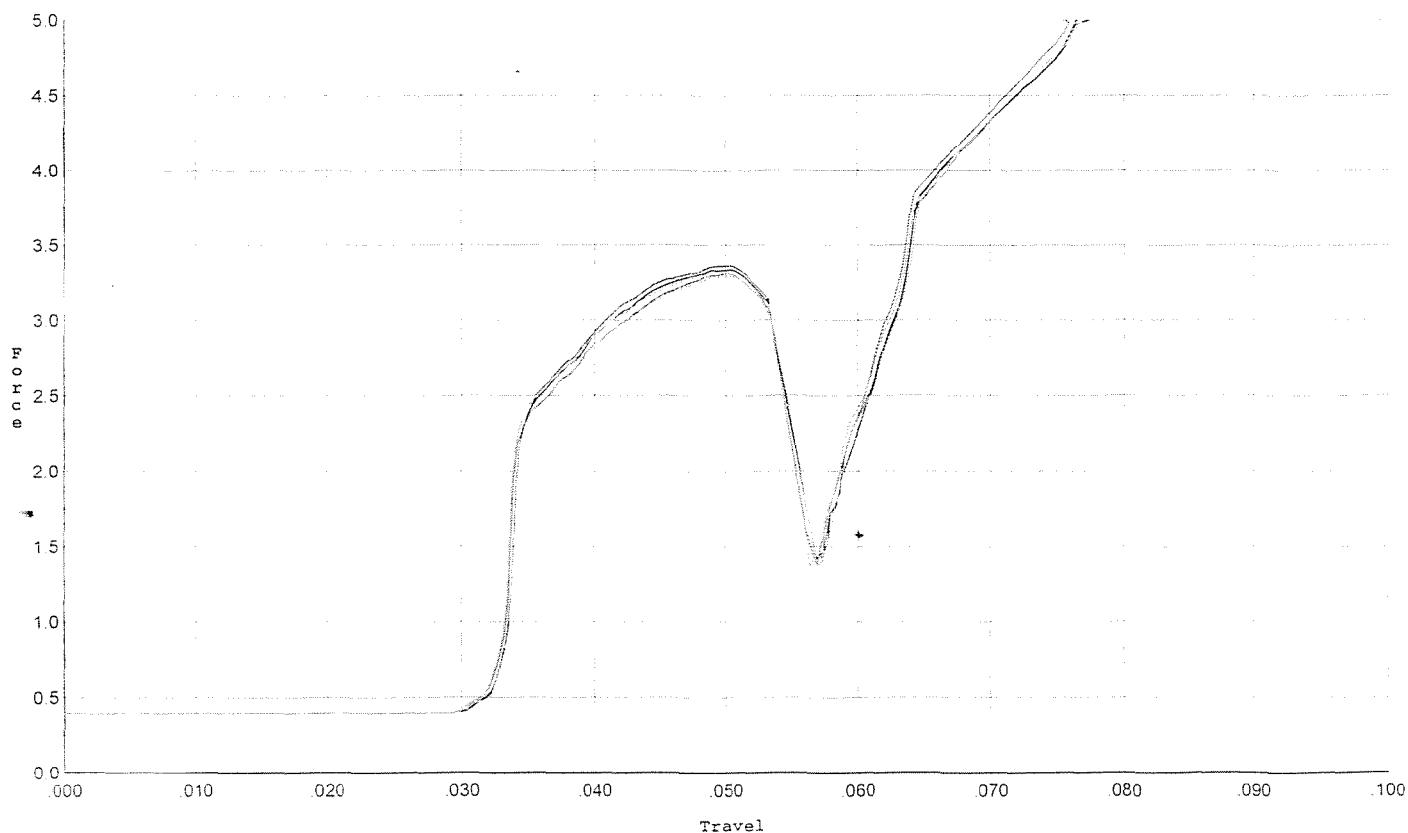
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.374	0.054	0.033	0.031	0.056		Set Trigger
2	2.395	0.054	0.033	0.031	0.057		Set Trigger
3	2.373	0.053	0.033	0.031	0.055		Set Trigger
4	2.390	0.053	0.033	0.031	0.057		Set Trigger
5	2.426	0.053	0.033	0.031	0.057		Set Trigger

A-239

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



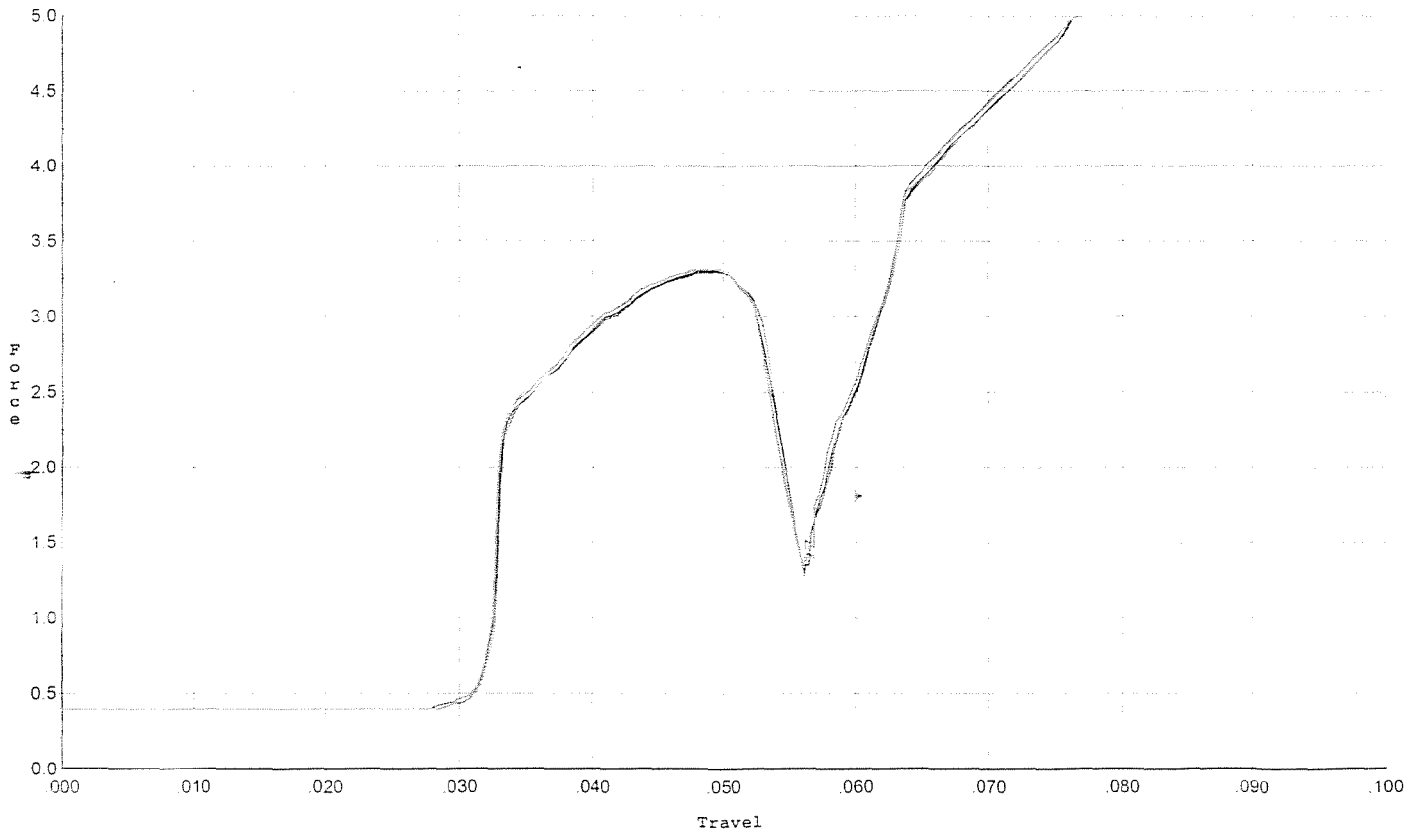
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.364	0.053	0.033	0.029	0.074		Set Trigger
2	3.337	0.053	0.033	0.029	0.074		Set Trigger
3	3.315	0.053	0.032	0.029	0.074		Set Trigger
4	3.316	0.053	0.032	0.029	0.075		Set Trigger
5	3.296	0.055	0.033	0.029	0.076		Set Trigger

A 3-32

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/15/2008

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



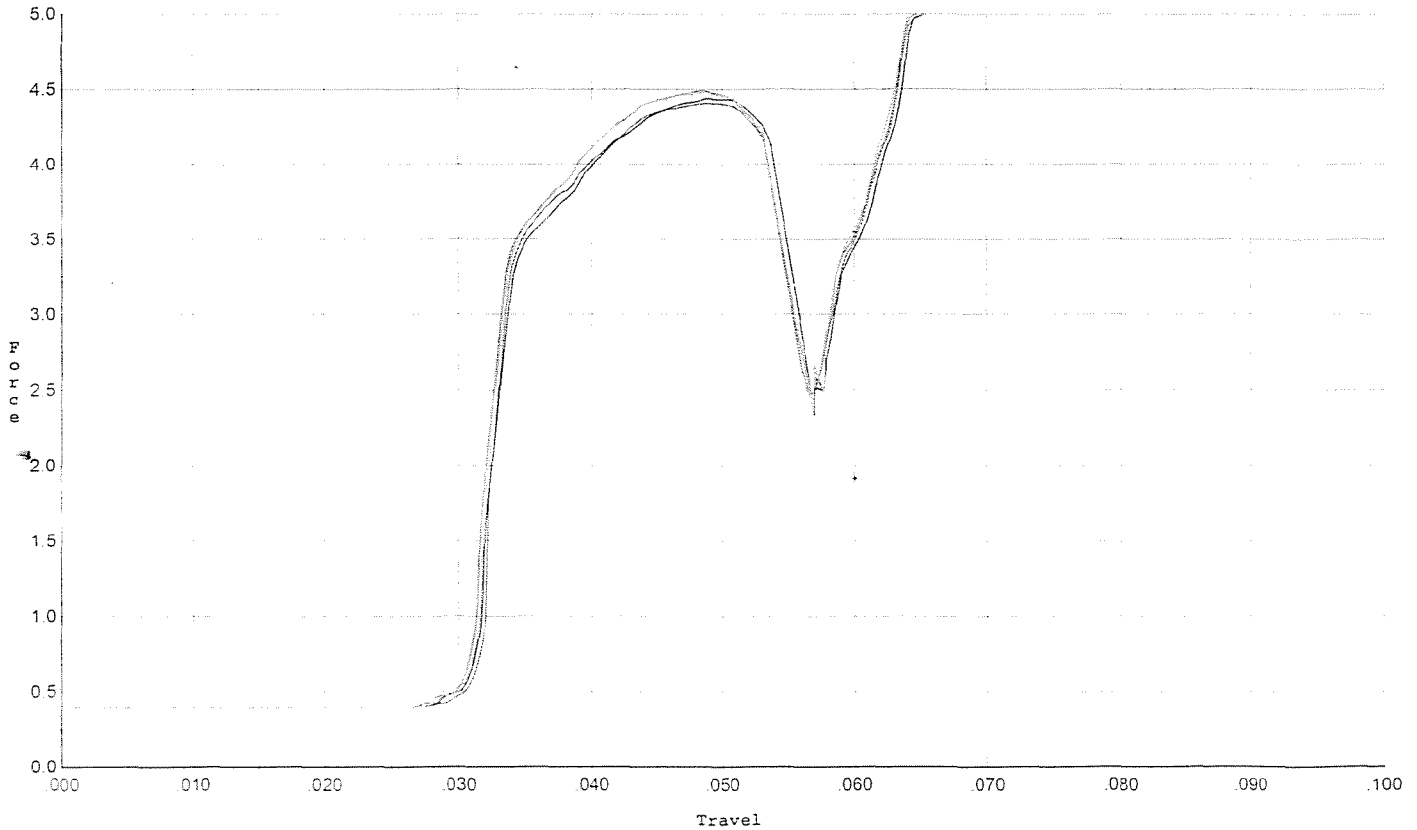
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.295	0.053	0.032	0.029	0.074		Set Trigger
2	3.303	0.054	0.032	0.029	0.075		Set Trigger
3	3.311	0.052	0.032	0.029	0.073		Set Trigger
4	3.320	0.053	0.032	0.029	0.074		Set Trigger
5	3.313	0.052	0.032	0.029	0.073		Set Trigger

A3.30

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



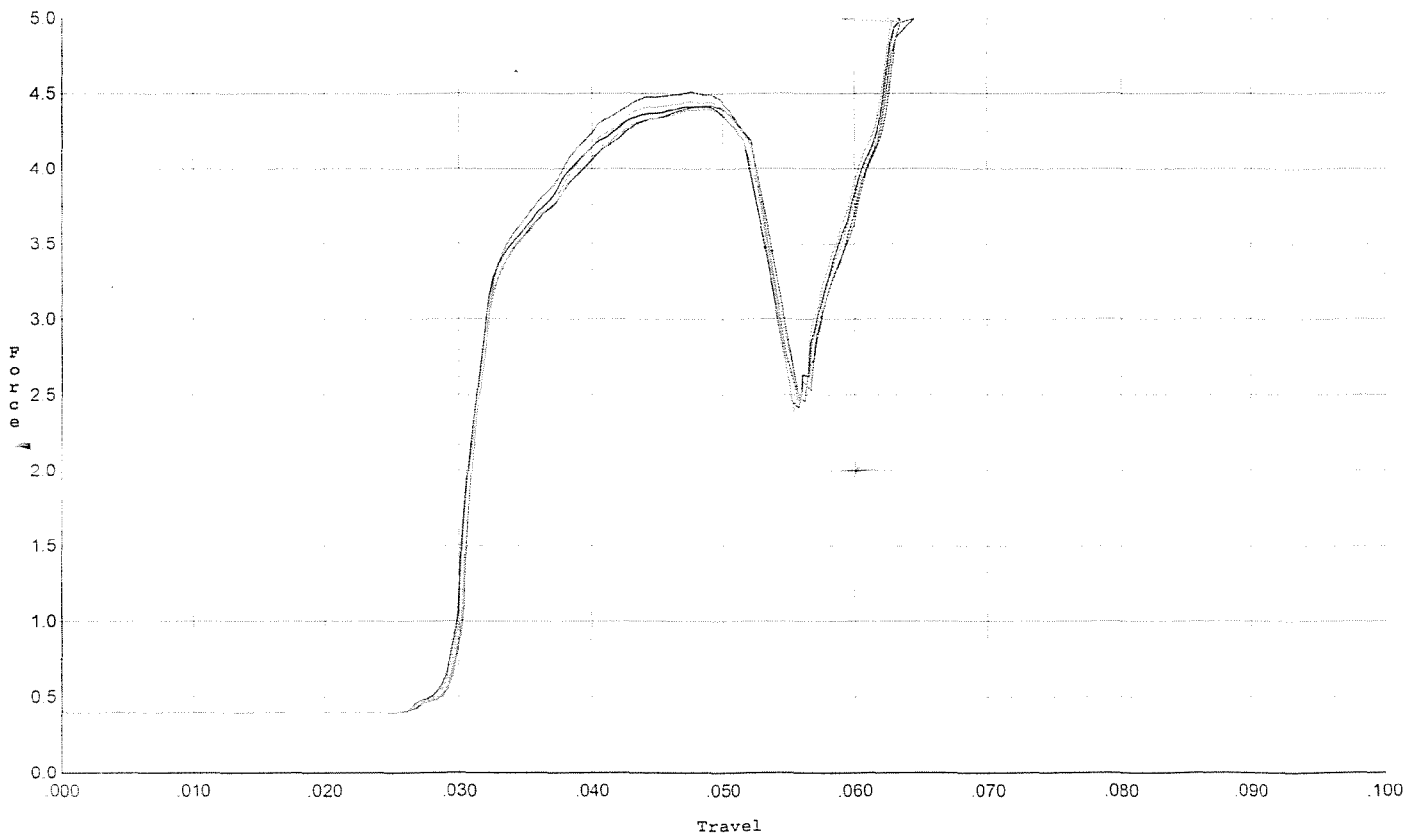
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.412	0.053	0.031	0.018	0.099		Set Trigger
2	4.440	0.054	0.031	0.018	0.102		Set Trigger
3	4.492	0.053	0.031	0.018	0.102		Set Trigger
4	4.481	0.053	0.031	0.018	0.101		Set Trigger
5	4.480	0.053	0.031	0.018	0.102		Set Trigger

A-4.46

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



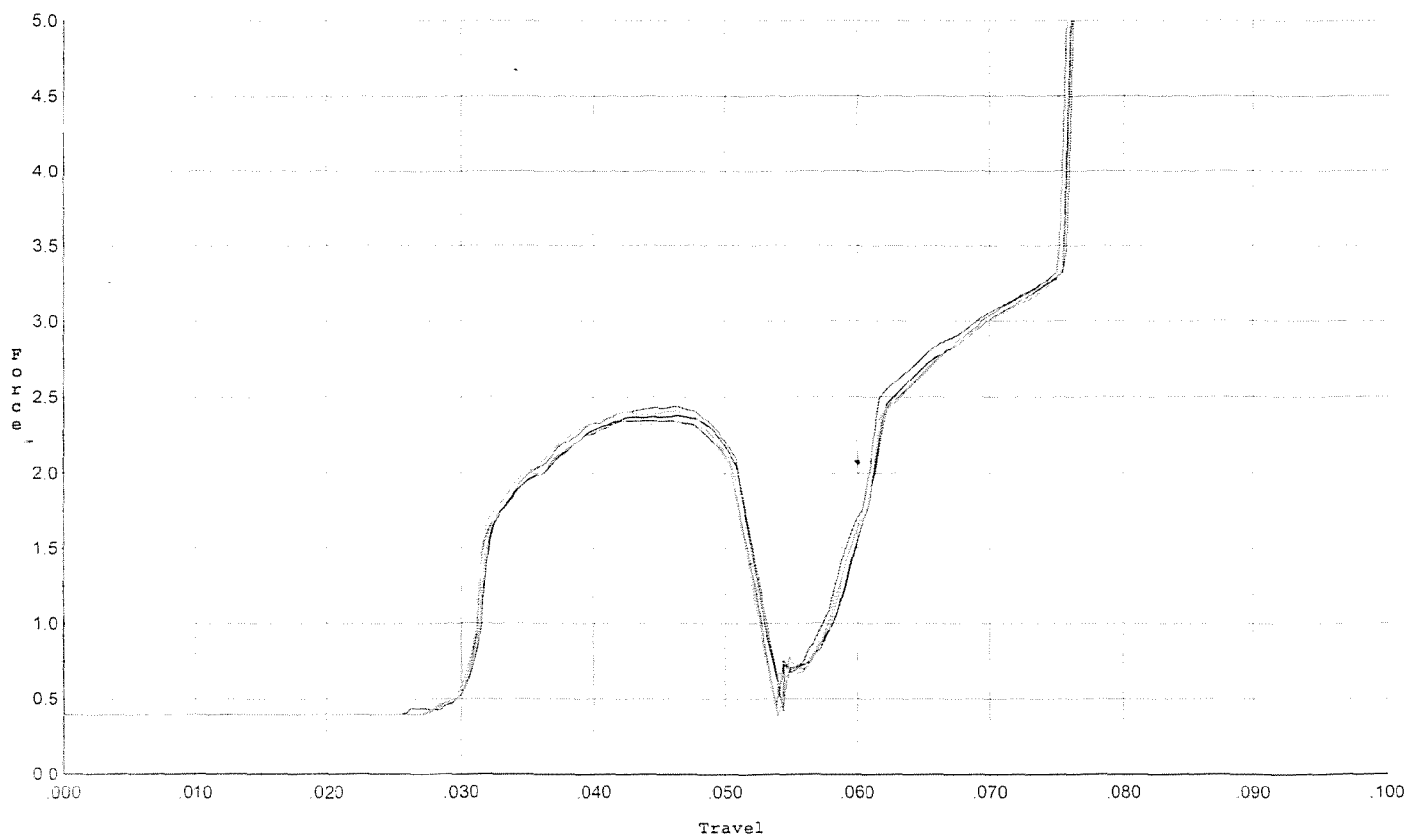
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.419	0.054	0.029	0.018	0.104		Set Trigger
2	4.415	0.053	0.029	0.018	0.103		Set Trigger
3	4.509	0.052	0.030	0.018	0.102		Set Trigger
4	4.447	0.052	0.029	0.018	0.101		Set Trigger
5	4.395	0.053	0.029	0.018	0.101		Set Trigger

A - 4.43

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

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



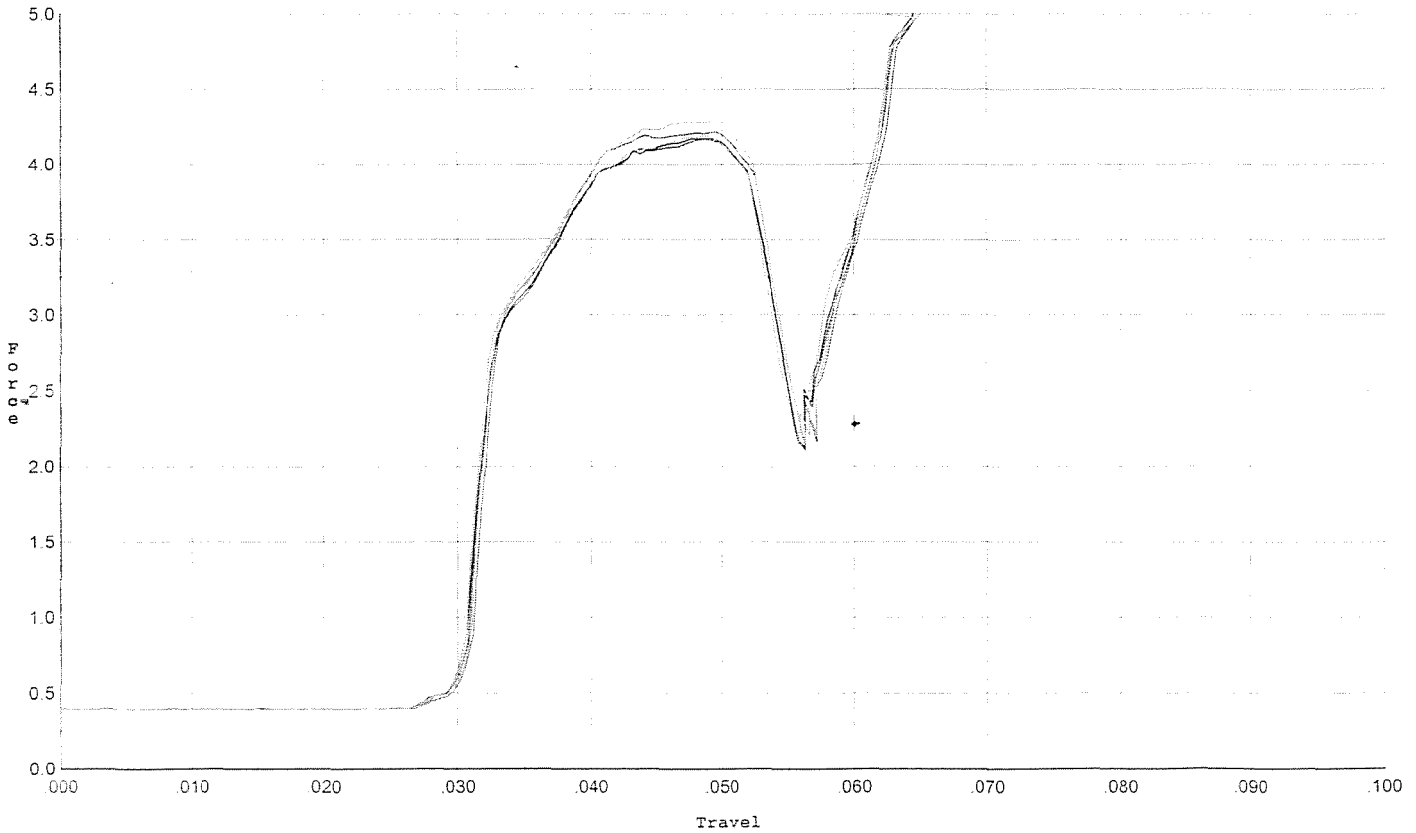
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.344	0.052	0.030	0.031	0.056		Set Trigger
2	2.377	0.051	0.030	0.031	0.055		Set Trigger
3	2.442	0.053	0.030	0.031	0.058		Set Trigger
4	2.409	0.050	0.030	0.031	0.055		Set Trigger
5	2.339	0.051	0.030	0.031	0.055		Set Trigger

A-2-38

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 12/15/2008

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lb +/- 1.0 lb for target&accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.165	0.054	0.030	0.026	0.095		Set Trigger
2	4.172	0.053	0.030	0.026	0.095		Set Trigger
3	4.217	0.053	0.030	0.027	0.094		Set Trigger
4	4.193	0.052	0.030	0.027	0.093		Set Trigger
5	4.289	0.052	0.030	0.026	0.095		Set Trigger

A-4.20