

66801437

BARBER - M24 0015271
M24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

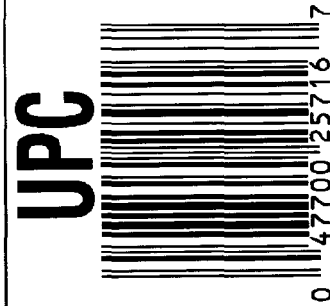
BM FORM



ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6801437



INSPECTION CHECKLIST NEW GUNS

GUN SERIAL #

66801437

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-4-09	SPD
430	ASSEMBLE STOCK		3-4-09	SP
440	PROOF		3-4-09	SPD
460	CHECK HEADSPACE		3-4-09	SPD
470	DIS-ASSEMBLE ACTION		3-4-09	SPD
472	SERIALIZE BOLT HANDLE		3-5-09	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR 	3/9/09	
490	MAGNAFLUX BOLT		3/9/09	MR
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)		3/18	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-19-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-19-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	0015273	REMARKS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>5.0</u>	3-28-09	DN
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	3-28-09	DN
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.022</u> <u>.028</u>	3-28-09	DN
	J) ASSEMBLE STOCK			3-28-09	DN
	K) ASSEMBLE SWIVEL STUDS			3-28-09	DN
	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 PASS FAIL FAIL	3-26-09	WY
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION N/A		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			3-26-09	TL
670	FINAL INSPECTION A) HEADSPACE			3-28-09	DN
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.45</u> <u>2.54</u> <u>2.43</u> <u>2.57</u>	3-27-09	TL
	C) FUNCTION			3-28-09	DN
690	PACK			3/28/09	FM

F004 REV 5/2006

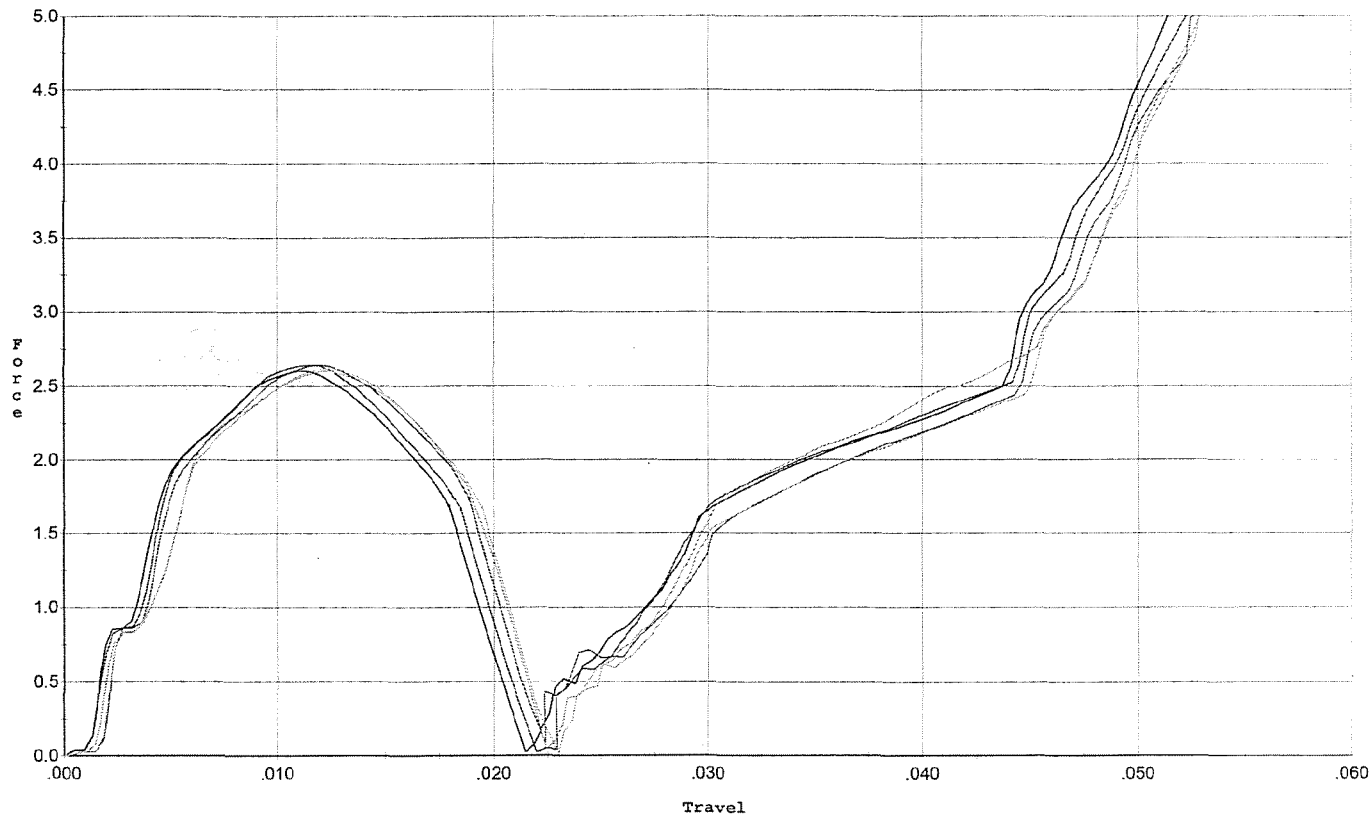
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0015273 15312

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



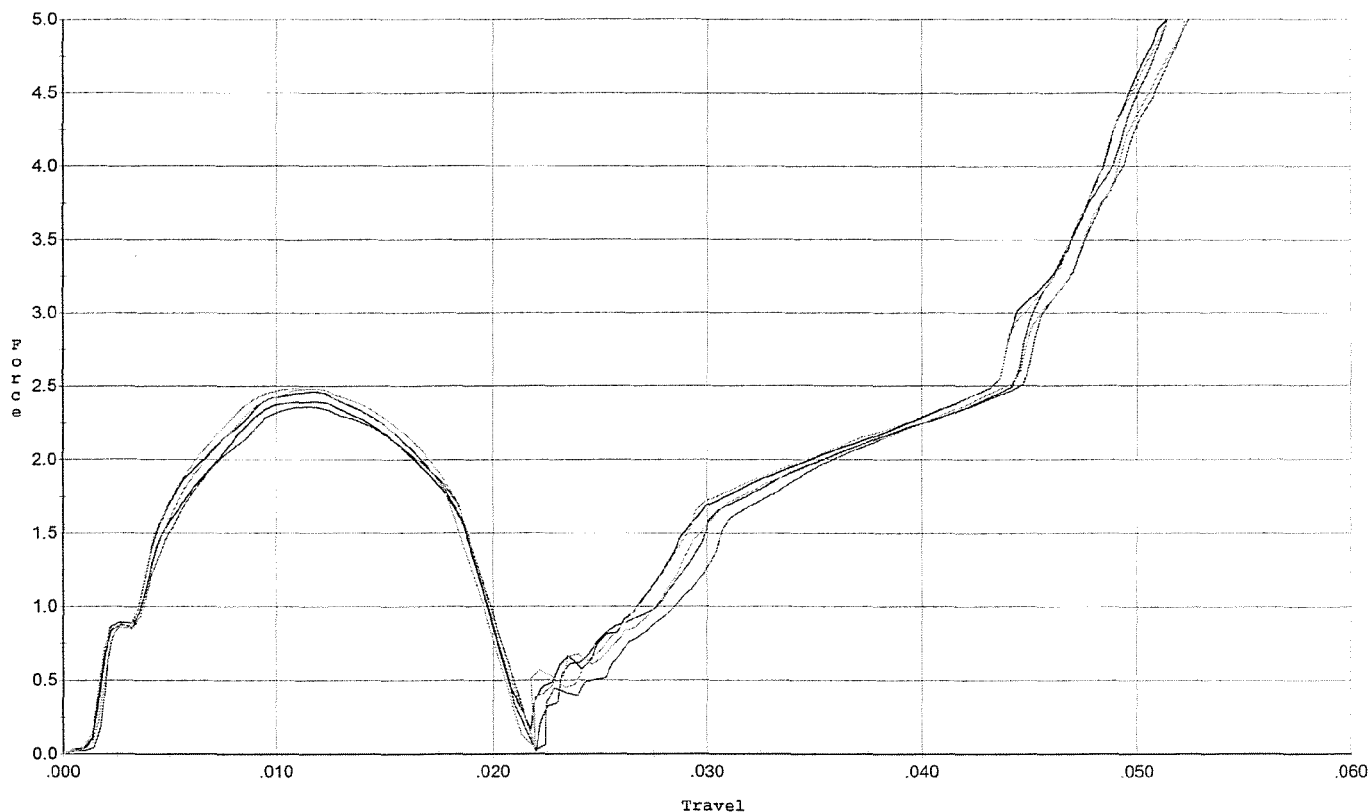
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.642	0.018	0.00	0.038	0.033		Set Trigger
2	2.603	0.018	0.00	0.038	0.032		Set Trigger
3	2.644	0.019	0.00	0.037	0.033		Set Trigger
4	2.622	0.019	0.00	0.037	0.034		Set Trigger
5	2.601	0.020	0.00	0.037	0.035		Set Trigger

A-2.62

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



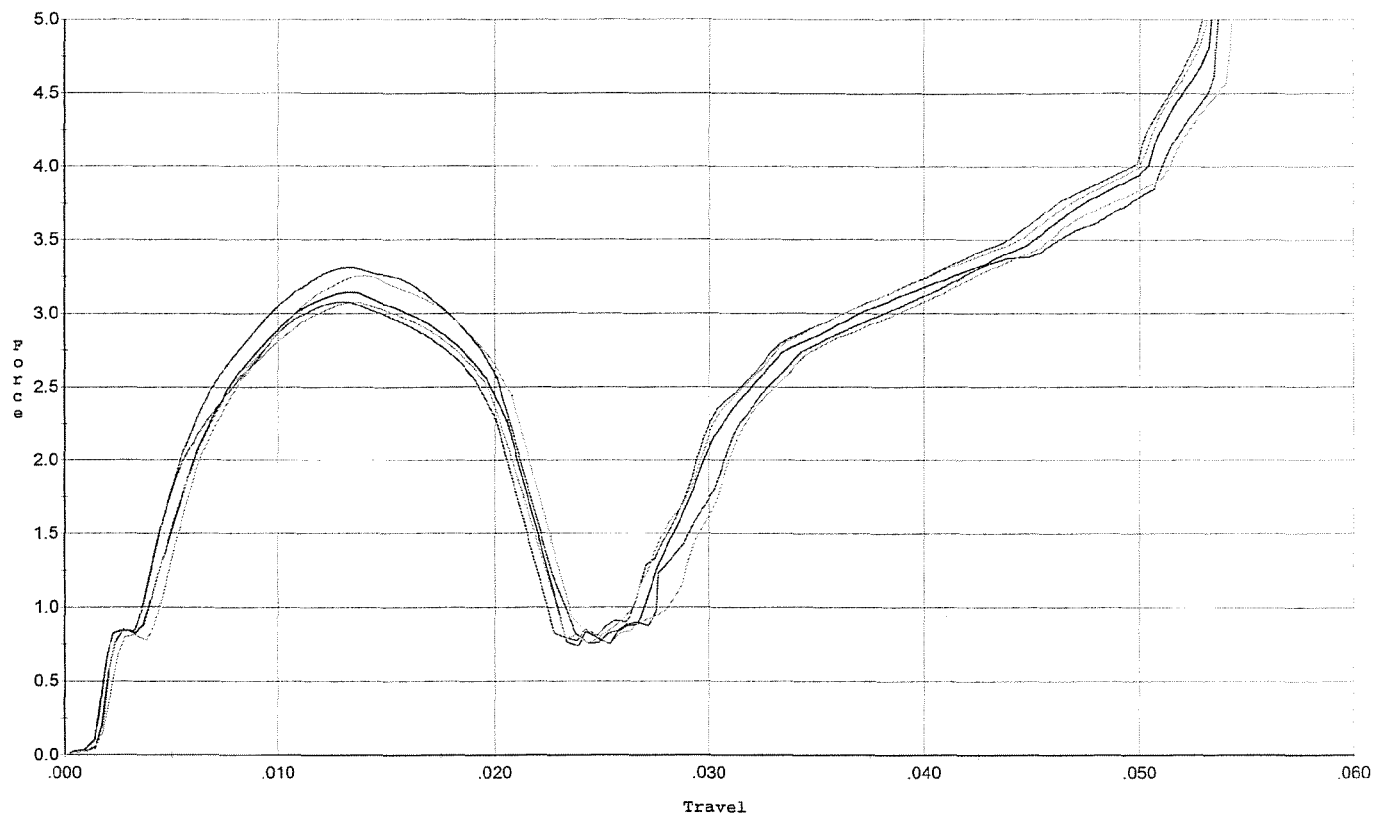
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.458	0.019	0.00	0.038	0.032		Set Trigger
2	2.396	0.019	0.00	0.037	0.031		Set Trigger
3	2.358	0.018	0.00	0.038	0.030		Set Trigger
4	2.484	0.019	0.00	0.037	0.033		Set Trigger
5	2.482	0.018	0.00	0.038	0.031		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



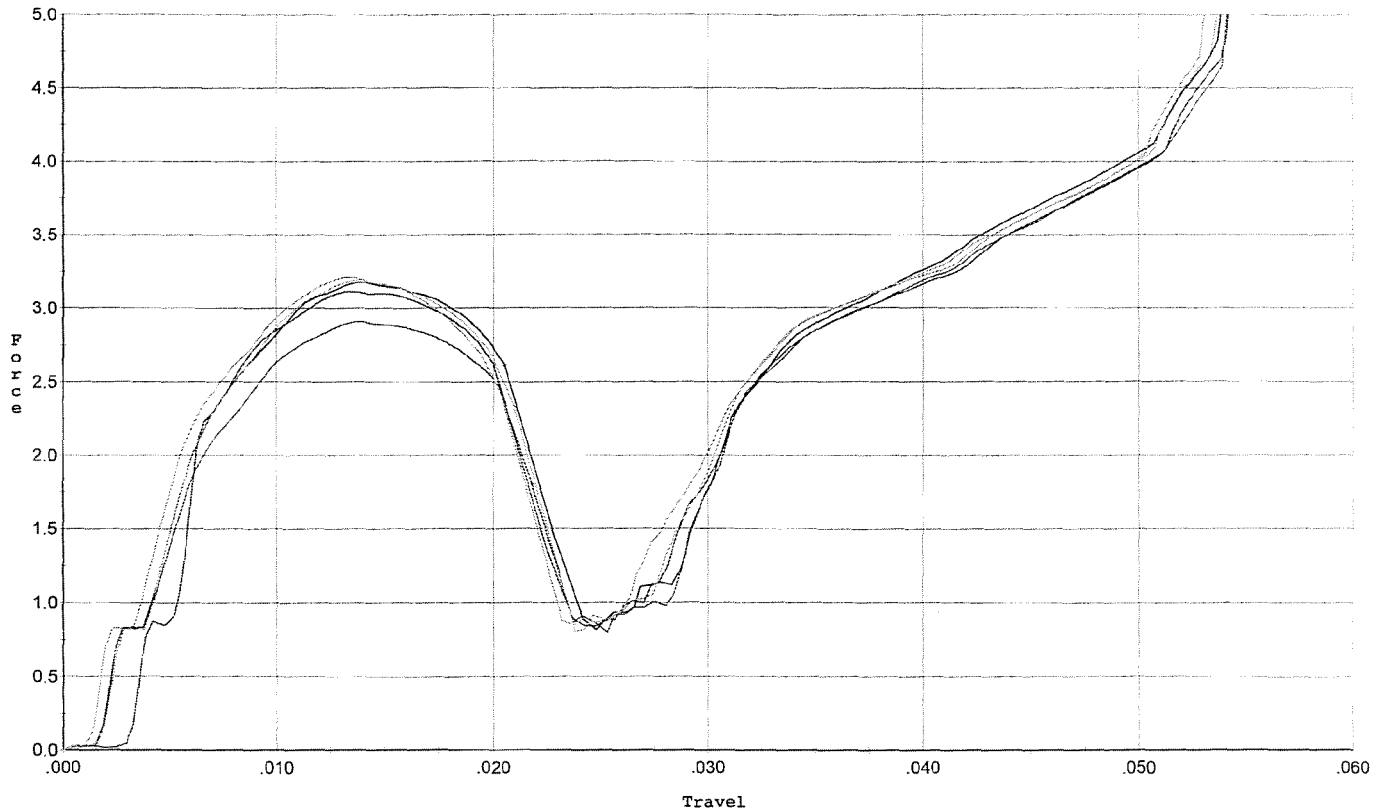
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.312	0.020	0.00	0.035	0.045		Set Trigger
2	3.143	0.021	0.00	0.035	0.043		Set Trigger
3	3.080	0.020	0.00	0.035	0.042		Set Trigger
4	3.260	0.021	0.00	0.035	0.045		Set Trigger
5	3.074	0.021	0.00	0.035	0.043		Set Trigger

A-3-17

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



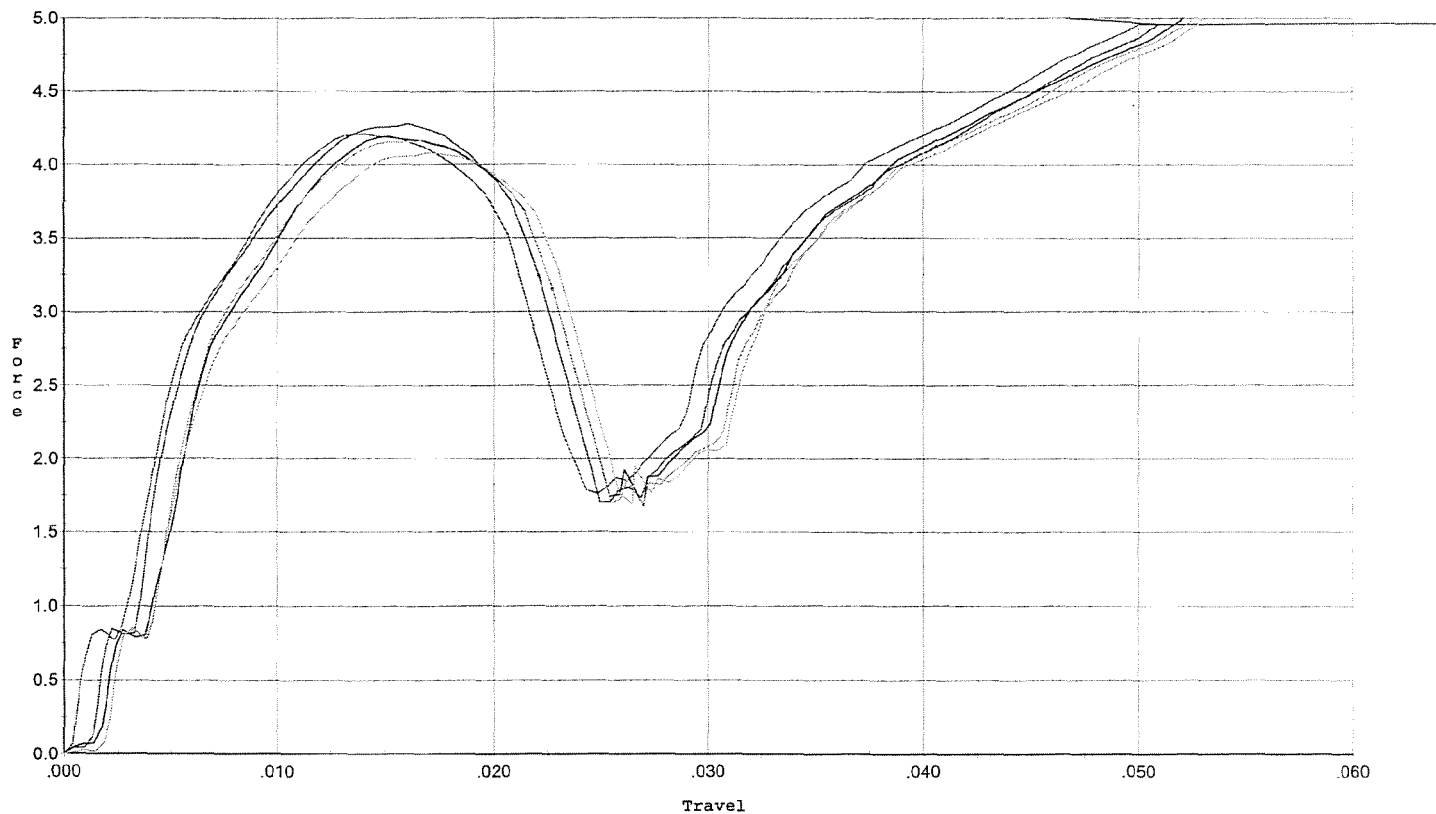
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.112	0.020	0.003	0.036	0.040		Set Trigger
2	3.174	0.021	0.004	0.035	0.044		Set Trigger
3	2.907	0.022	0.00	0.035	0.043		Set Trigger
4	3.190	0.021	0.00	0.035	0.044		Set Trigger
5	3.210	0.020	0.004	0.035	0.044		Set Trigger

A-3.11

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/13/2009

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



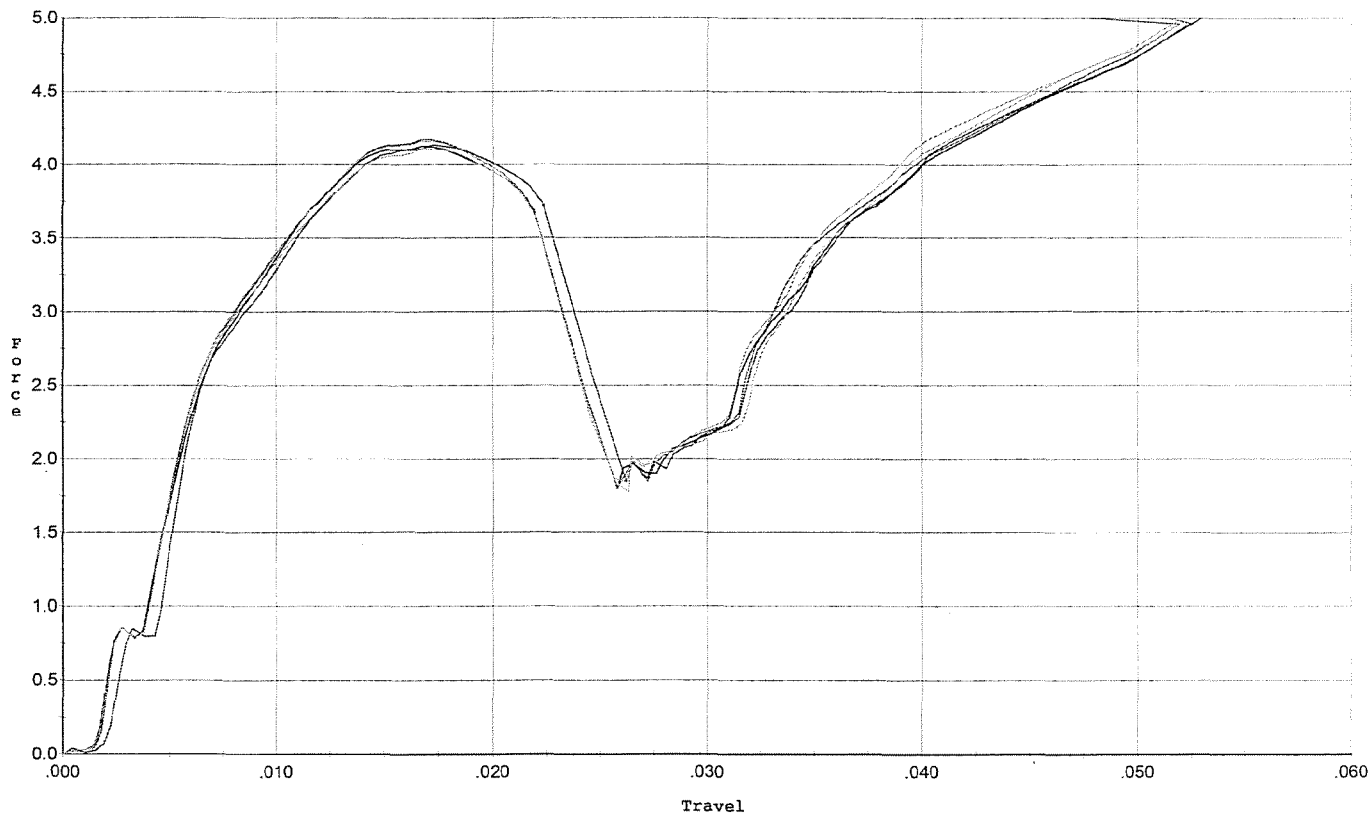
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.277	0.022	0.00	0.032	0.063		Set Trigger
2	4.193	0.023	0.00	0.032	0.062		Set Trigger
3	4.207	0.021	0.00	0.032	0.059		Set Trigger
4	4.079	0.023	0.002	0.032	0.062		Set Trigger
5	4.169	0.023	0.00	0.032	0.062		Set Trigger

A-4-18

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



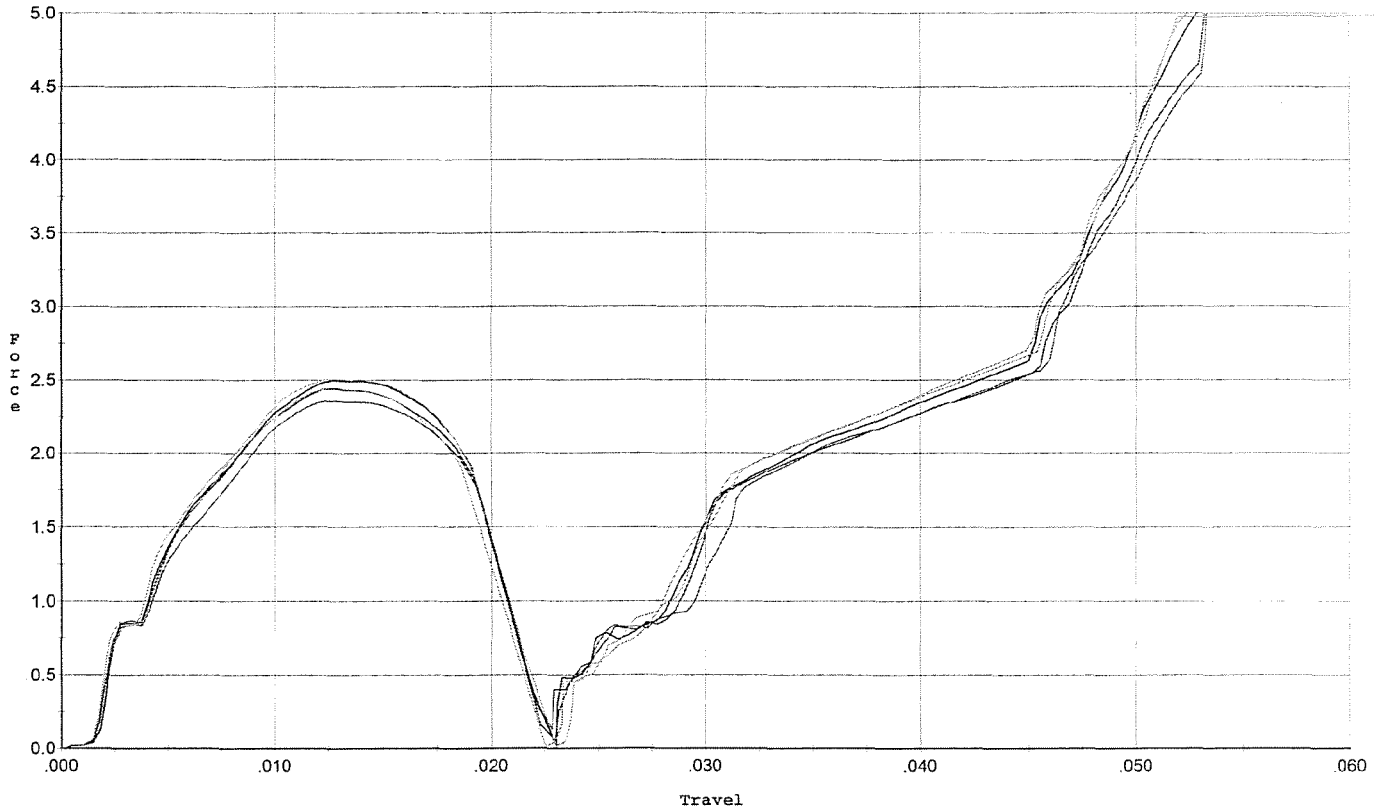
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.134	0.022	0.005	0.033	0.060		Set Trigger
2	4.127	0.022	0.00	0.033	0.060		Set Trigger
3	4.170	0.022	0.00	0.033	0.060		Set Trigger
4	4.110	0.022	0.00	0.033	0.059		Set Trigger
5	4.161	0.022	0.00	0.033	0.060		Set Trigger

A-4.14

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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



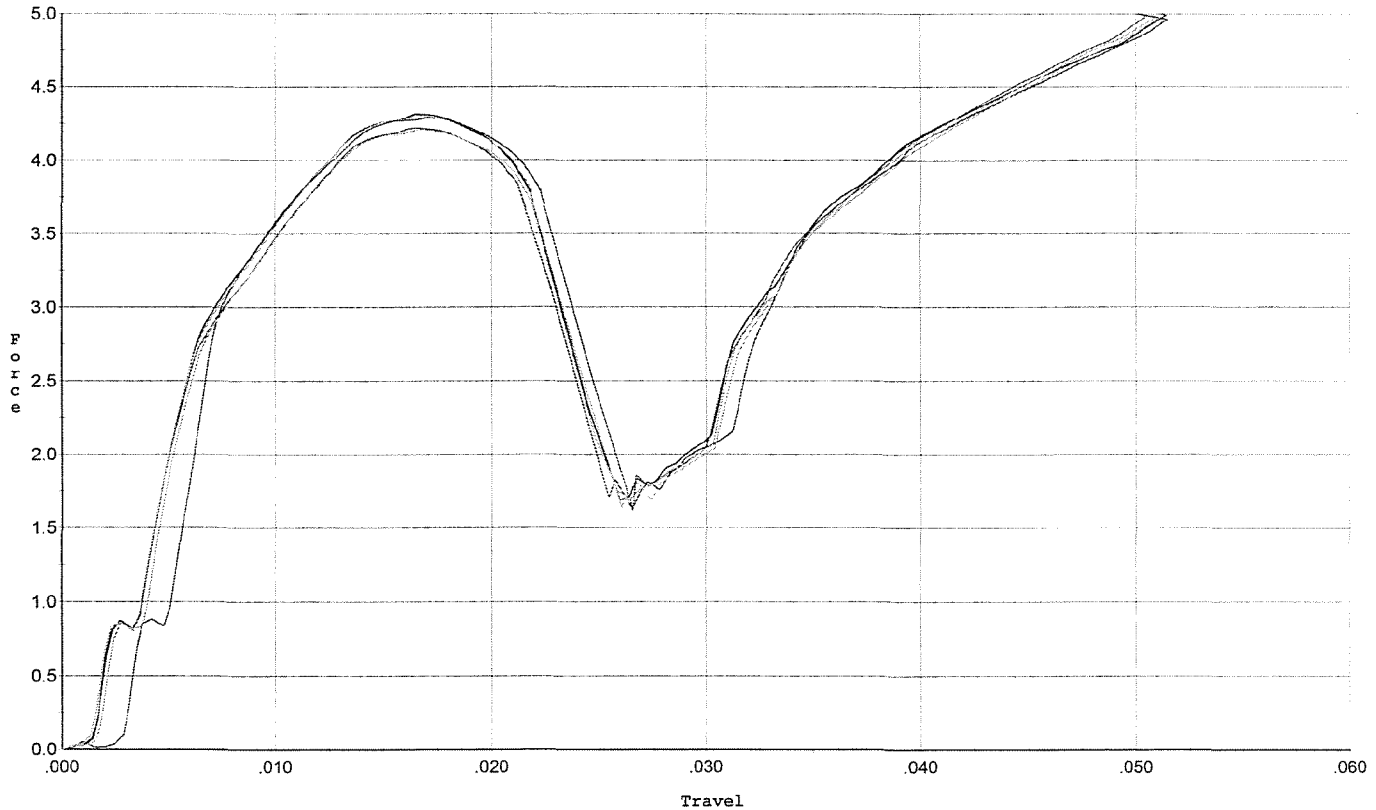
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.446	0.019	0.00	0.038	0.032		Set Trigger
2	2.501	0.019	0.004	0.037	0.032		Set Trigger
3	2.359	0.019	0.00	0.038	0.031		Set Trigger
4	2.510	0.019	0.00	0.038	0.033		Set Trigger
5	2.439	0.020	0.00	0.037	0.033		Set Trigger

A-2.45

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/13/2009

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	4.289	0.022	0.003	0.033	0.061		Set Trigger
2	4.314	0.022	0.00	0.032	0.062		Set Trigger
3	4.221	0.023	0.00	0.032	0.063		Set Trigger
4	4.305	0.022	0.00	0.033	0.062		Set Trigger
5	4.210	0.022	0.00	0.032	0.061		Set Trigger

A-4.26