

G6801483

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

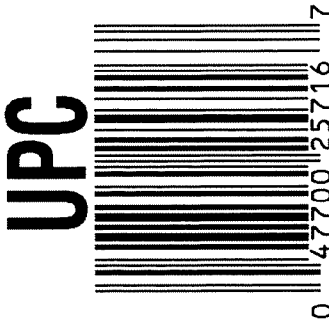
- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6801483



M-24
BARBER - M24 0015822 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # B 6801483

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-20-09	SPD
430	ASSEMBLE TO STOCK		3-20-09	RP
440	PROOF		3-20-09	SPD
460	CHECK HEADSPACE		3-20-09	RP
470	DIS-ASSEMBLE ACTION		3-20-09	RP
472	SERIALIZE BOLT HANDLE		3-23-09	RP
475	DRILL AND TAP SIGHT HOLES		3-23-09	JP
480	MAGNAFLUX BBL ACTION	(D)	3/25/09	(D)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/25/09	RT
520	GOFF BLAST BBL / REC		3-25	Bt
542	APPLY COATINGS (BARREL ACTION)		3-29	—
545	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	TL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	TL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	TL
	D) OIL FIRING PIN ASSEMBLY		4-2-09	X JD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

BARBER - M24 0015822 15861

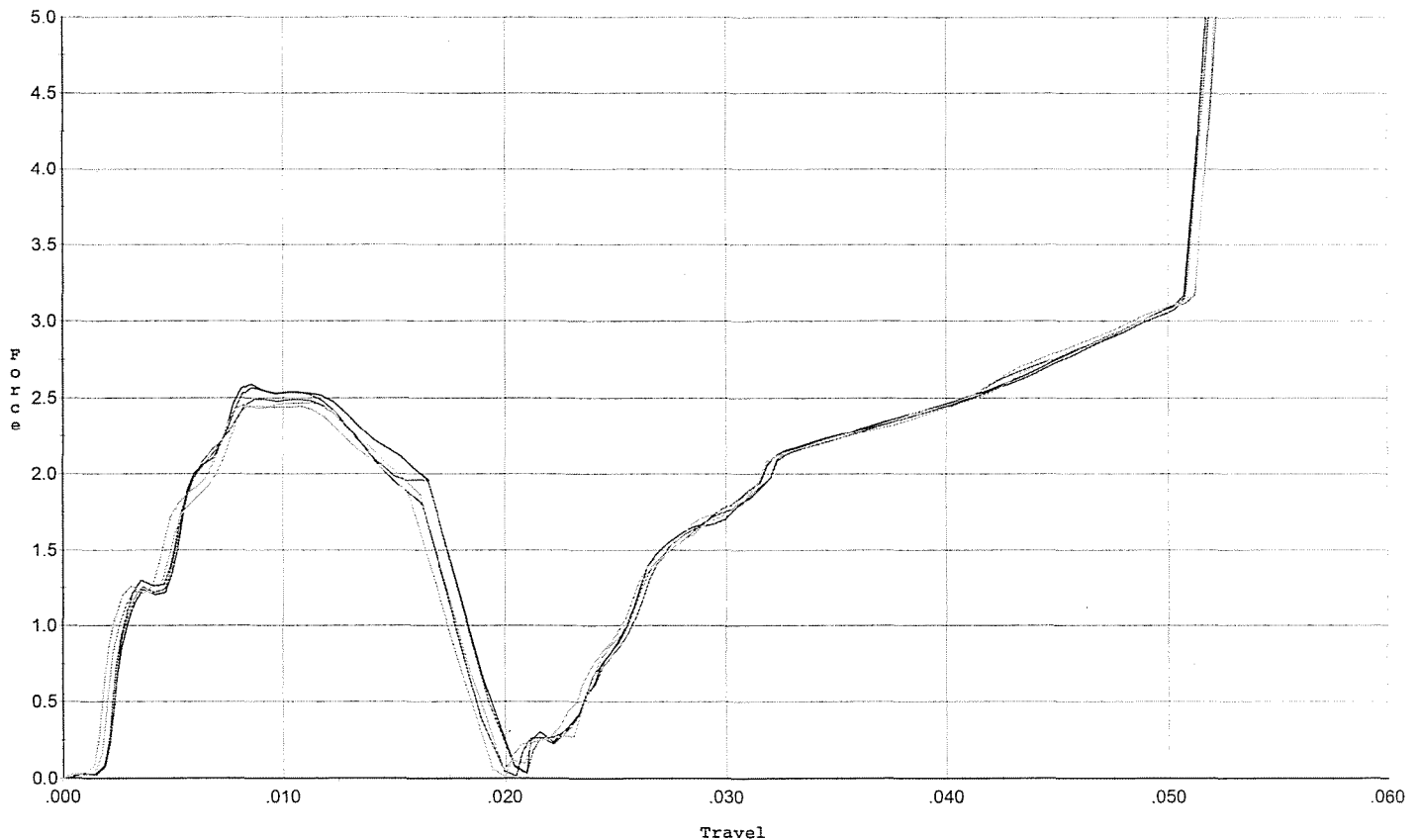
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2.9</u> <u>2.9</u> <u>2.9</u>	4-17-09	RP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.8</u> <u>4.9</u> <u>4.8</u>	4-17-09	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	4-17-09	RP
	J) ASSEMBLE STOCK		4-2-09	L. J.
	K) ASSEMBLE SWIVEL STUDS		4-17-09	RP
	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	4-9-09	NW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	4-9-09	TAR
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.54</u> <u>2.60</u> <u>2.50</u> <u>2.55</u>	4-14-09	NW
	C) FUNCTION		4-17-09	RP
690	PACK		5/29/09	Fm

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



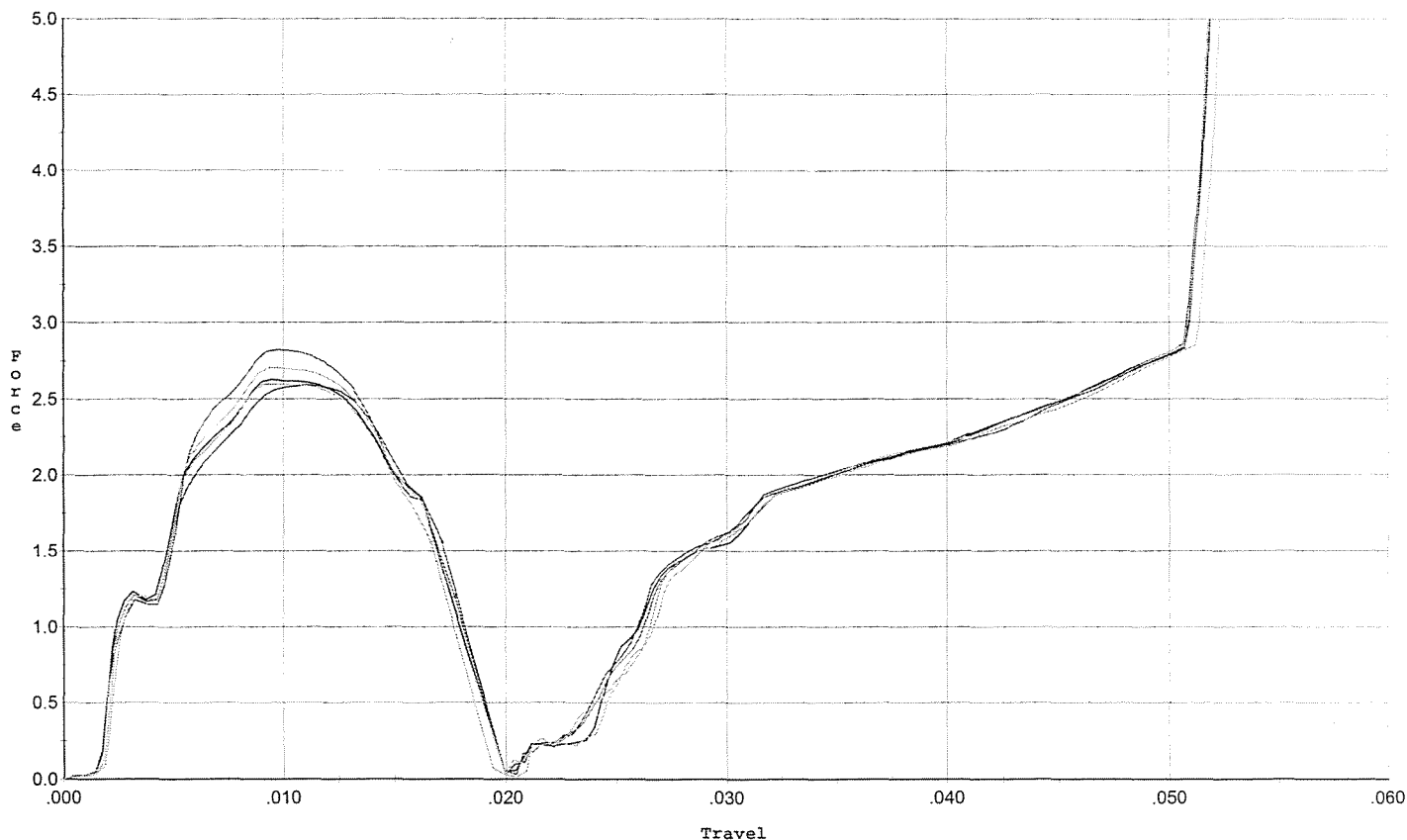
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.567	0.016	0.005	0.039	0.027		Set Trigger
2	2.589	0.017	0.002	0.038	0.028		Set Trigger
3	2.491	0.017	0.00	0.039	0.027		Set Trigger
4	2.469	0.016	0.00	0.039	0.027		Set Trigger
5	2.456	0.016	0.00	0.039	0.026		Set Trigger

A-2-51

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



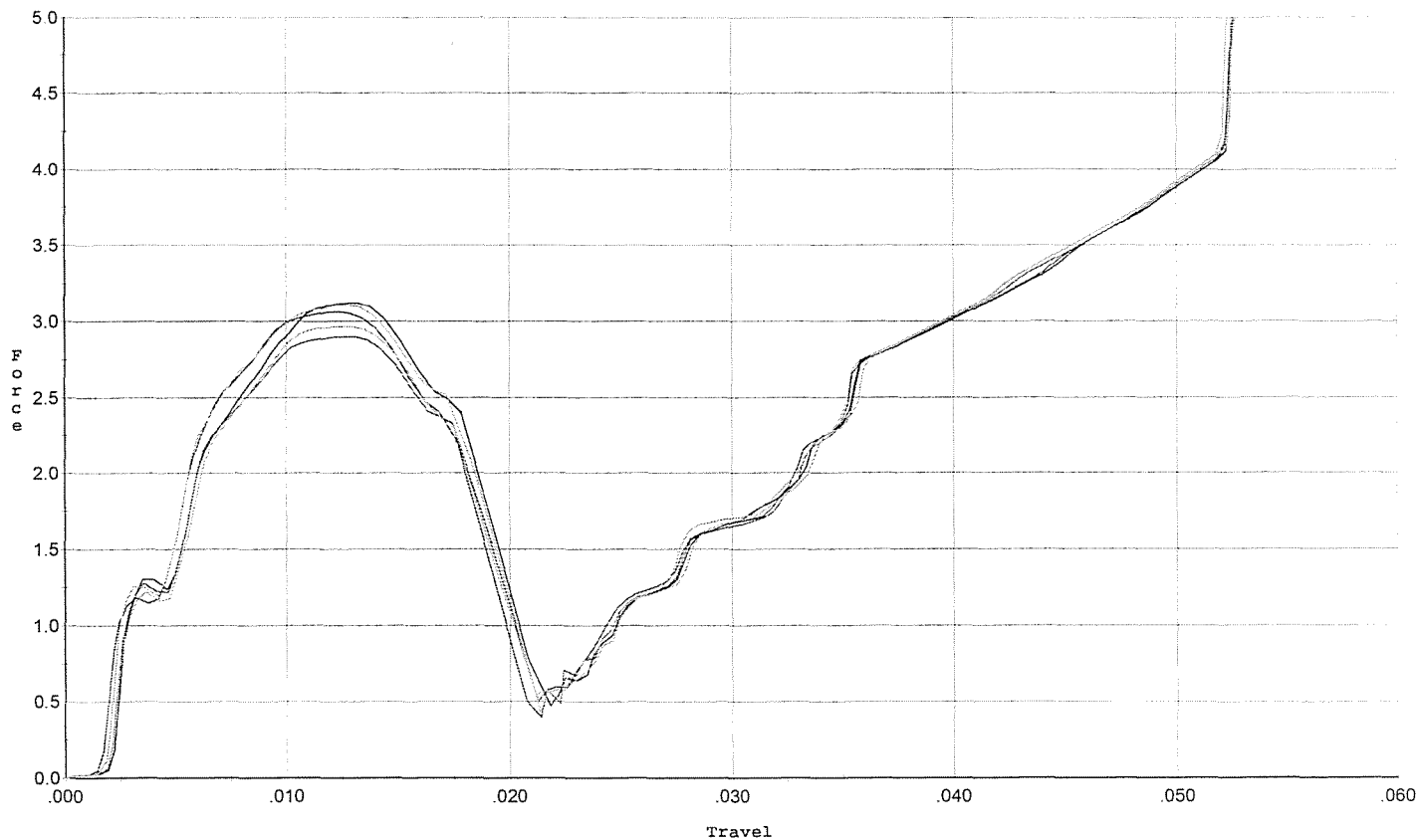
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.593	0.017	0.00	0.039	0.029		Set Trigger
2	2.630	0.016	0.00	0.039	0.028		Set Trigger
3	2.823	0.018	0.005	0.039	0.031		Set Trigger
4	2.709	0.016	0.00	0.040	0.029		Set Trigger
5	2.601	0.017	0.002	0.039	0.028		Set Trigger

A-2.67

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



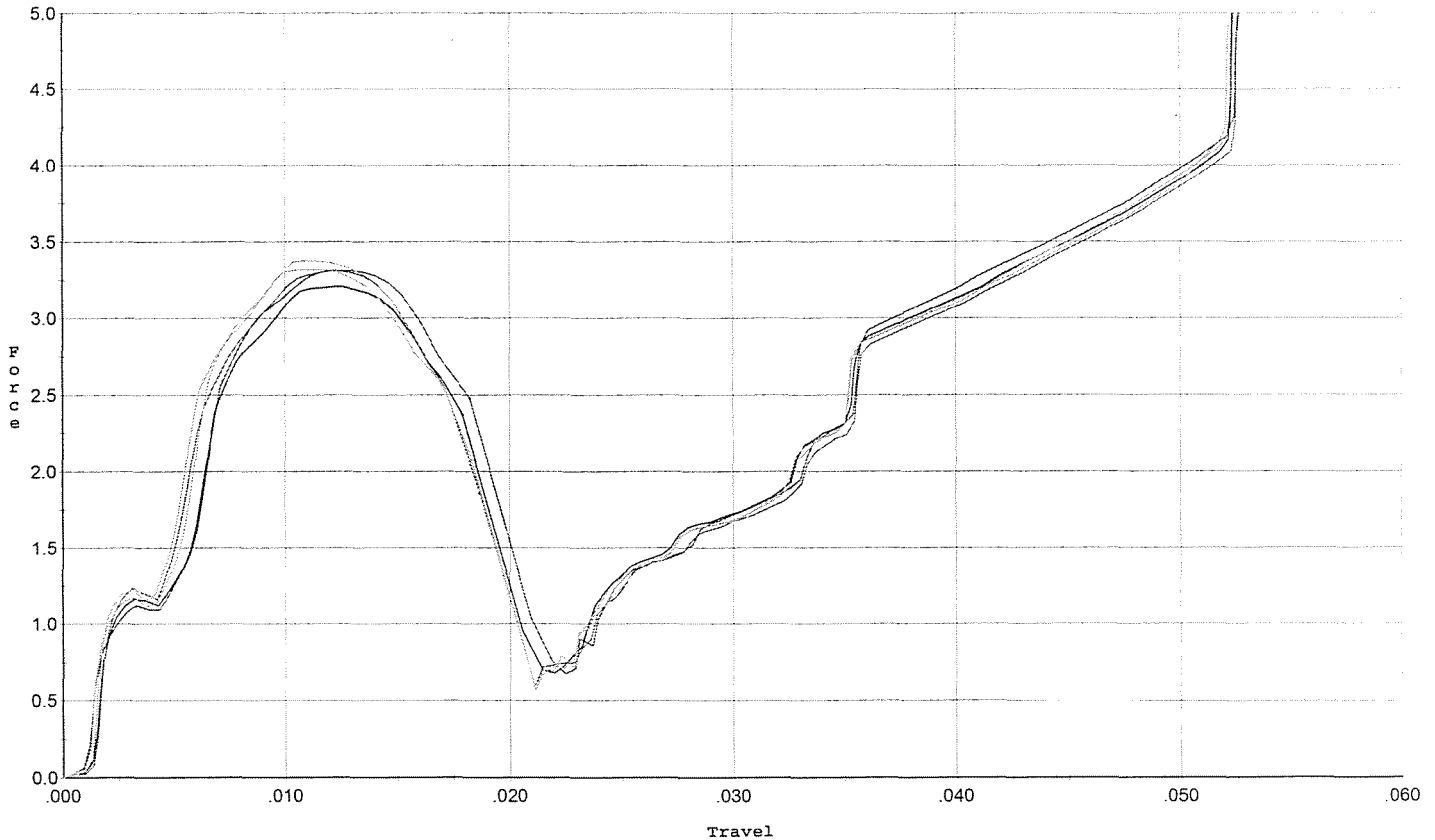
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.061	0.018	0.00	0.037	0.035		Set Trigger
2	3.119	0.018	0.005	0.037	0.035		Set Trigger
3	2.899	0.019	0.002	0.037	0.036		Set Trigger
4	2.966	0.017	0.002	0.037	0.033		Set Trigger
5	3.107	0.018	0.005	0.036	0.037		Set Trigger

A-3-03

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



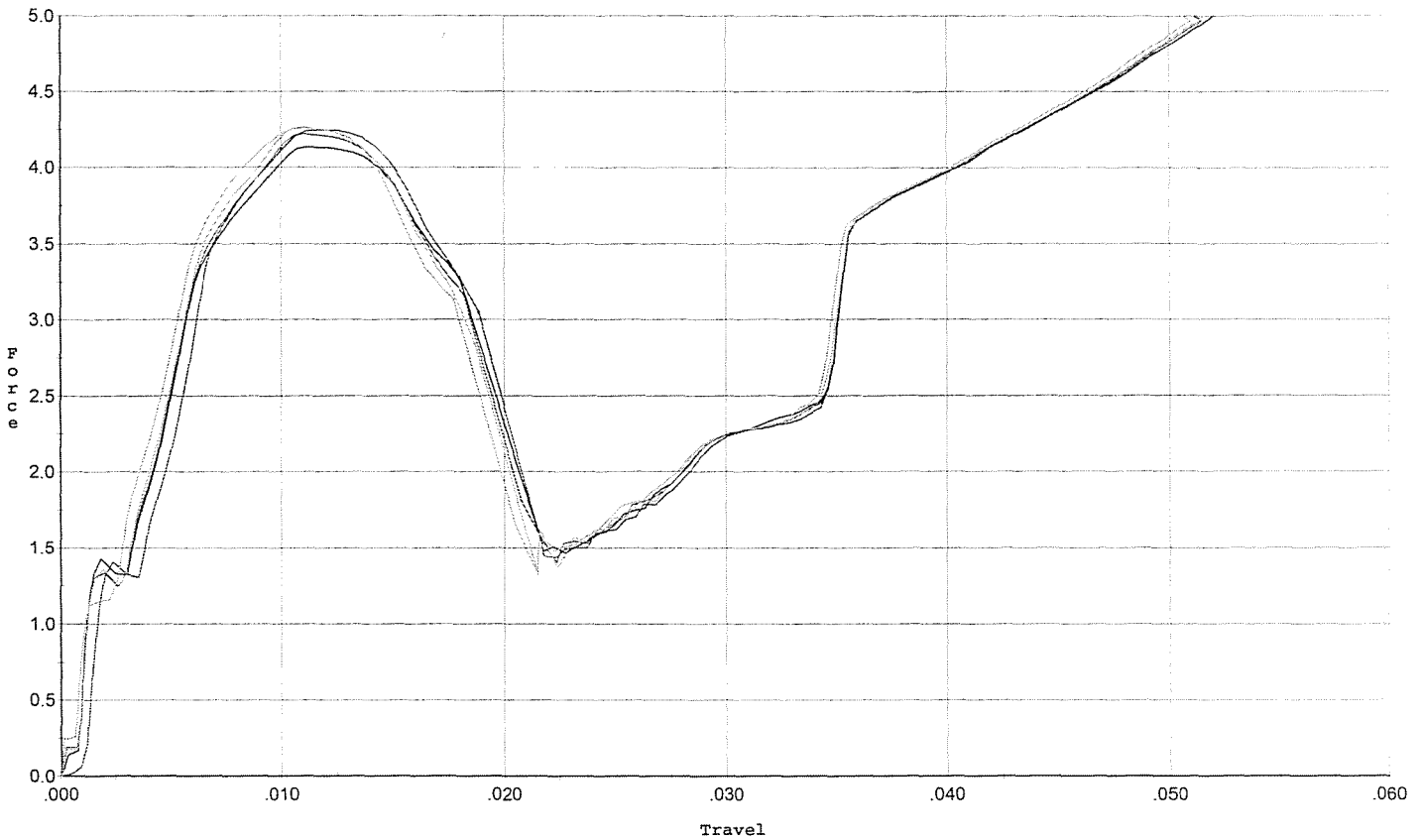
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.315	0.018	0.005	0.036	0.039		Set Trigger
2	3.207	0.018	0.005	0.036	0.037		Set Trigger
3	3.314	0.019	0.005	0.037	0.040		Set Trigger
4	3.377	0.018	0.00	0.036	0.040		Set Trigger
5	3.319	0.019	0.00	0.036	0.040		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



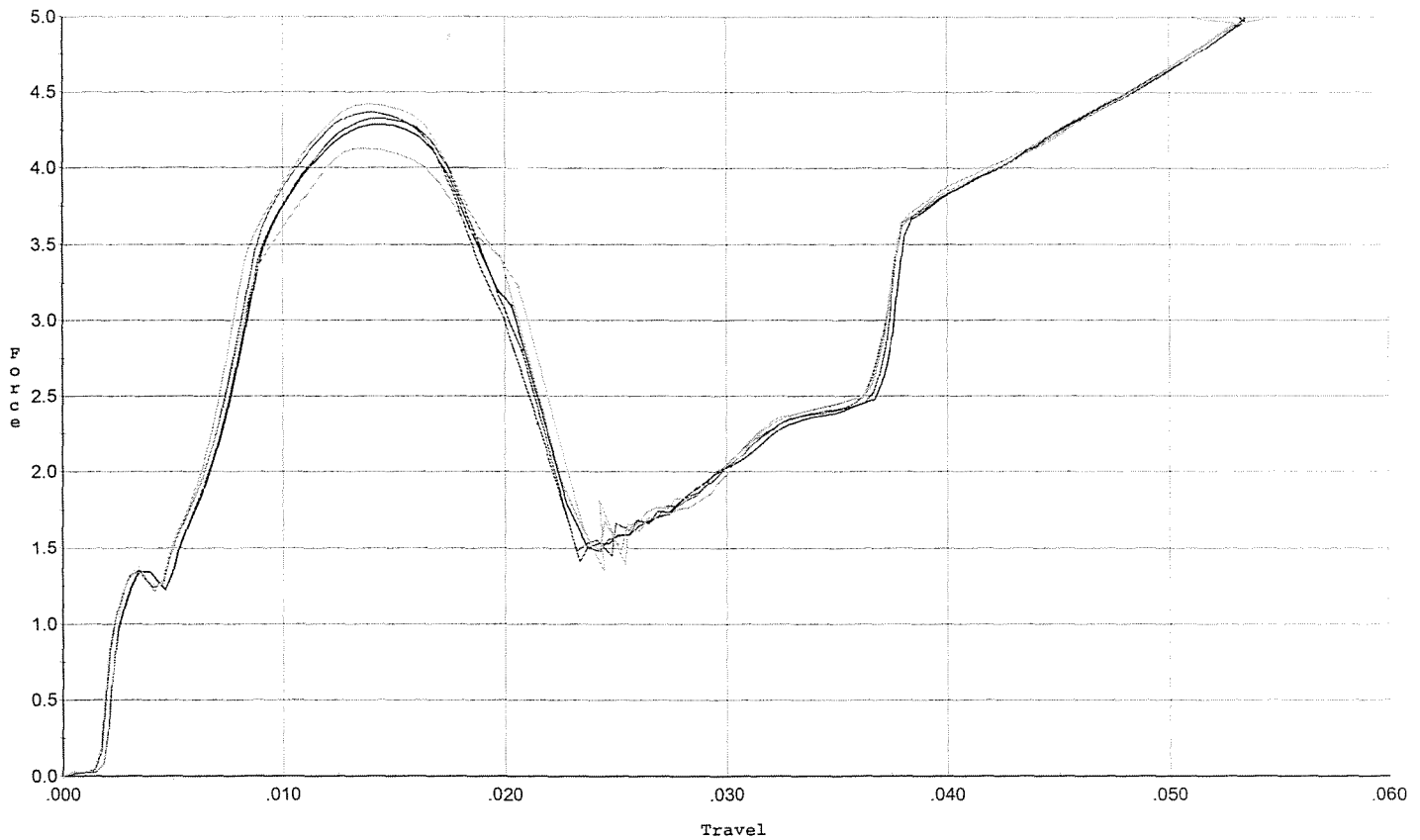
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.246	0.019	0.004	0.035	0.052		Set Trigger
2	4.136	0.018	0.003	0.035	0.050		Set Trigger
3	4.224	0.018	0.00	0.035	0.051		Set Trigger
4	4.264	0.019	0.00	0.035	0.053		Set Trigger
5	4.262	0.018	0.00	0.035	0.051		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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



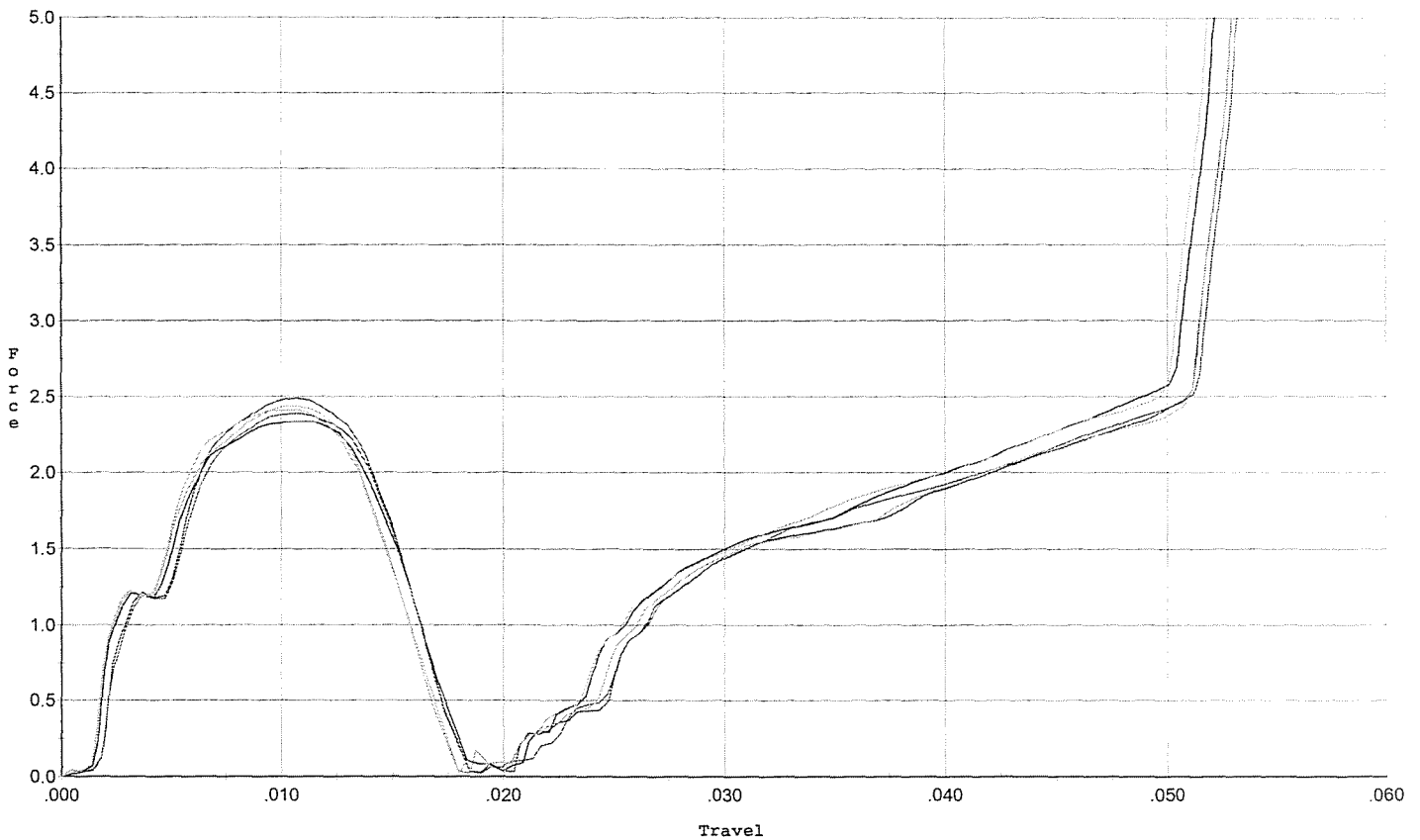
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.326	0.021	0.005	0.035	0.054		Set Trigger
2	4.288	0.020	0.002	0.035	0.053		Set Trigger
3	4.369	0.021	0.00	0.035	0.057		Set Trigger
4	4.130	0.021	0.002	0.035	0.053		Set Trigger
5	4.421	0.020	0.00	0.035	0.054		Set Trigger

A-4.30

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/2/2009

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



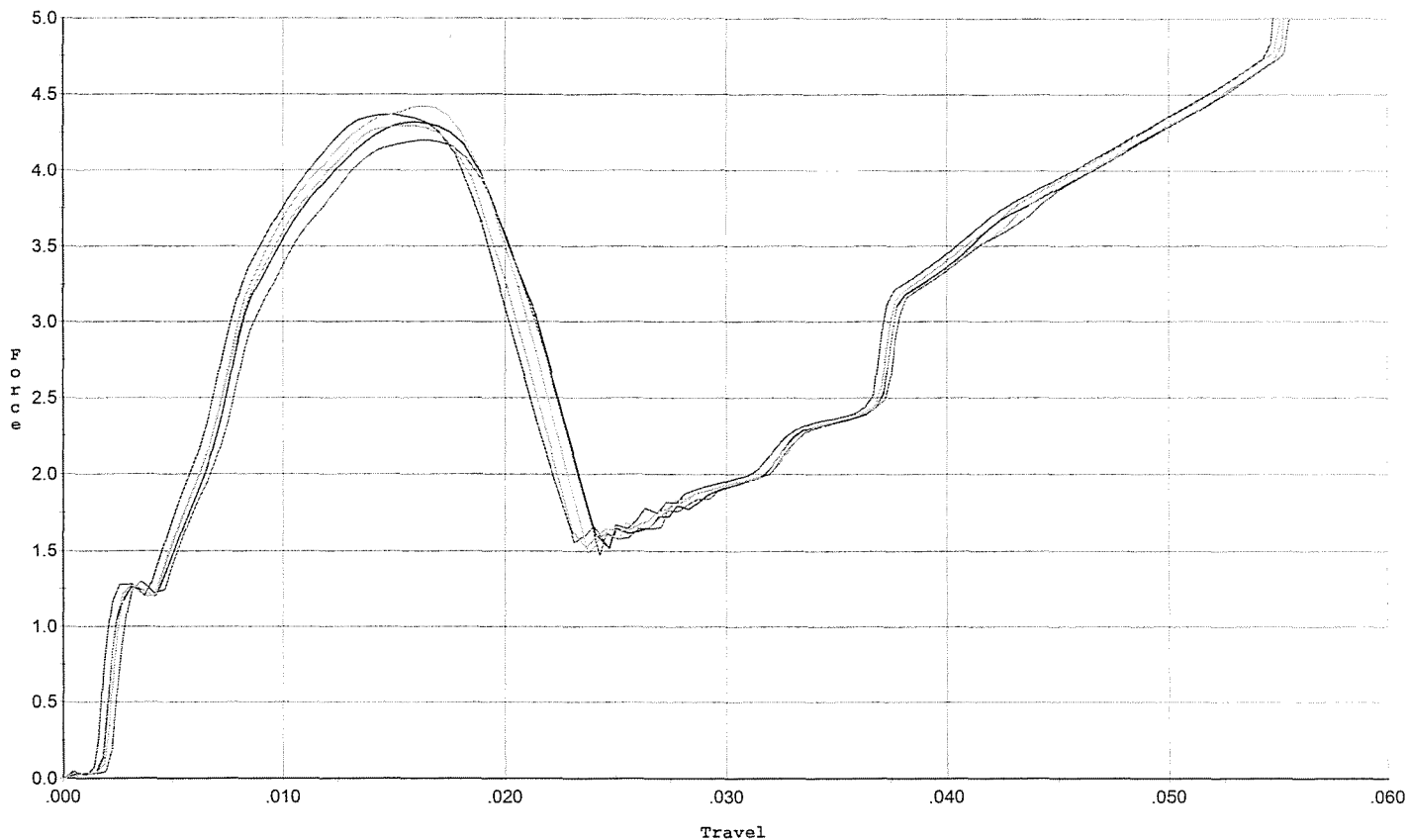
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.489	0.015	0.00	0.042	0.024		Set Trigger
2	2.335	0.015	0.005	0.041	0.024		Set Trigger
3	2.390	0.015	0.005	0.042	0.023		Set Trigger
4	2.410	0.015	0.00	0.041	0.024		Set Trigger
5	2.437	0.015	0.005	0.042	0.023		Set Trigger

A-2-41

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/2/2009

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	4.369	0.019	0.004	0.036	0.052		Set Trigger
2	4.321	0.021	0.002	0.035	0.057		Set Trigger
3	4.199	0.022	0.00	0.035	0.056		Set Trigger
4	4.423	0.021	0.004	0.036	0.056		Set Trigger
5	4.296	0.020	0.004	0.036	0.053		Set Trigger

A. 4.32