

BARBER - M24 0016420

G6807690

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

BARBER - M24 0016420 M2400016459

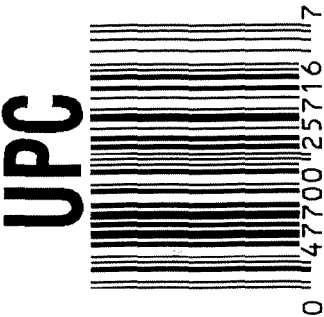
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807690



BM FORM

GUN SERIAL #

66807690

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-24-09	KT
430	ASSEMBLE TO STOCK			
440	PROOF		3-24-09	TK
460	CHECK HEADSPACE		3-24-09	TK
470	DIS-ASSEMBLE ACTION			
472	SERIALIZE BOLT HANDLE			
475	DRILL AND TAP SIGHT HOLES		3-25-09	SP
480	MAGNAFLUX BBL ACTION		3-27-09	(H)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3/27/09	RT
520	GOFF BLAST BBL / REC		3-27	BH
542	APPLY COATINGS (BARREL ACTION)		3-29	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-30-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-30-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-30-09	SP
	D) OIL FIRING PIN ASSEMBLY		4-22-09	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

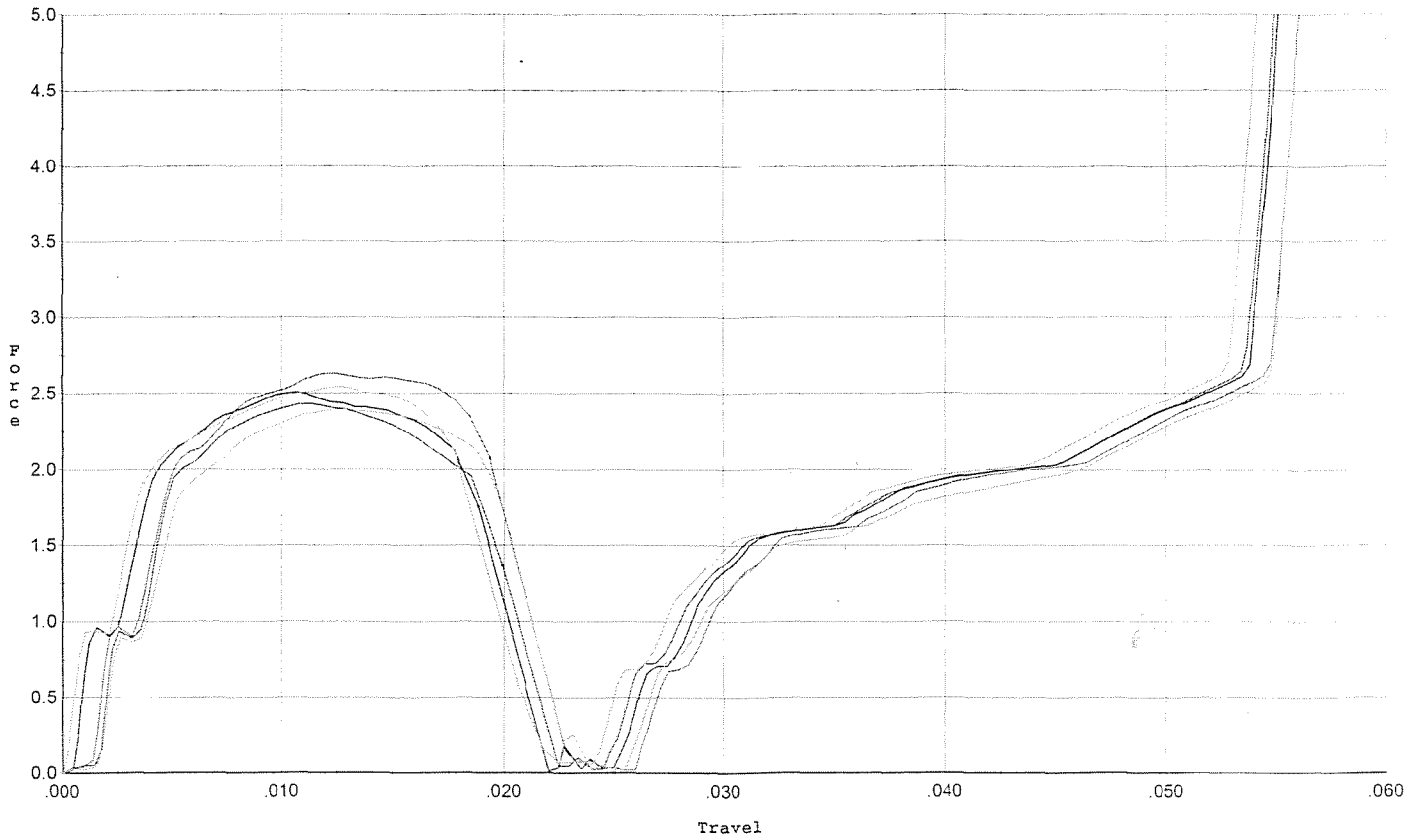
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>30</u> <u>30</u> <u>30</u>	5-6-09	L.N.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>50</u> <u>50</u>	5-6-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-6-09	L.N.
	J) ASSEMBLE STOCK		4-22-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		5-6-09	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-24-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-24-09	SP
670	FINAL INSPECTION A) HEADSPACE		5-6-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.46</u> <u>2.32</u> <u>2.42</u> <u>2.53</u>	4-28-09	WN
	C) FUNCTION		5-6-09	L.N.
690	PACK		5/29/09	Fry

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



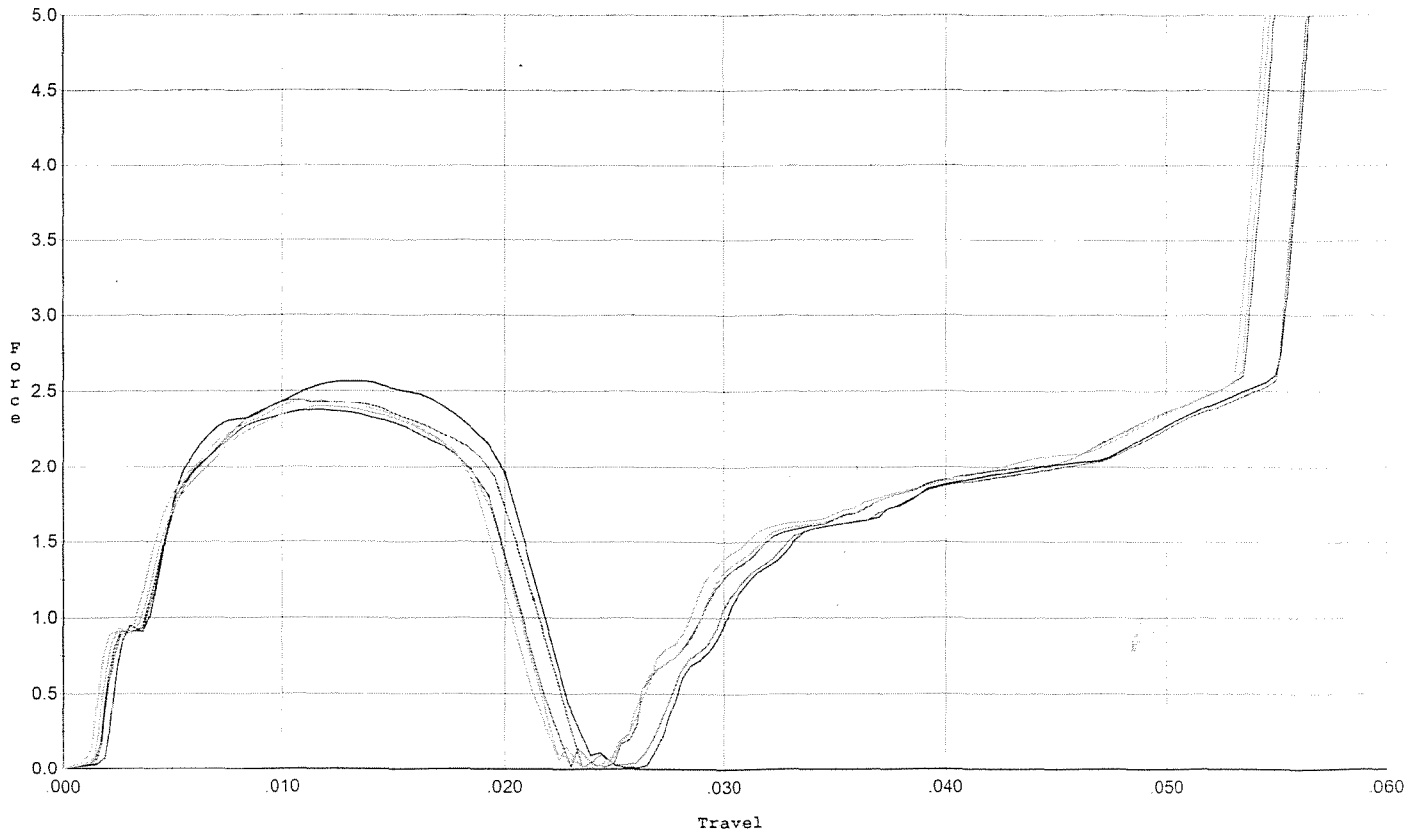
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.433	0.020	0.00	0.040	0.035		Set Trigger
2	2.506	0.019	0.00	0.041	0.036		Set Trigger
3	2.630	0.019	0.00	0.041	0.037		Set Trigger
4	2.539	0.018	0.002	0.040	0.035		Set Trigger
5	2.396	0.020	0.00	0.041	0.034		Set Trigger

A-2-50

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



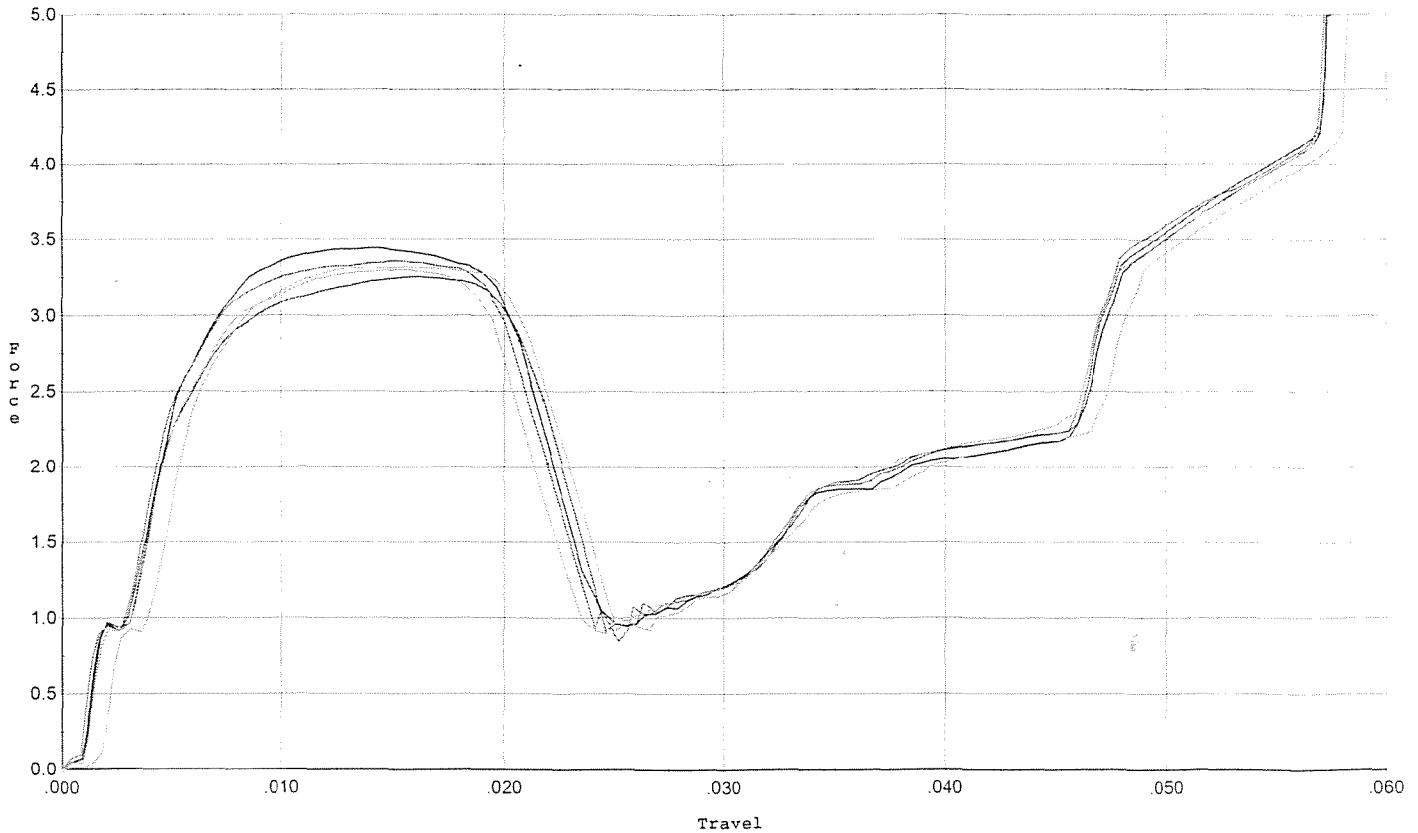
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.375	0.019	0.00	0.040	0.033		Set Trigger
2	2.563	0.020	0.00	0.041	0.037		Set Trigger
3	2.443	0.021	0.00	0.040	0.037		Set Trigger
4	2.443	0.019	0.00	0.040	0.033		Set Trigger
5	2.398	0.019	0.00	0.040	0.034		Set Trigger

A-2.44

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



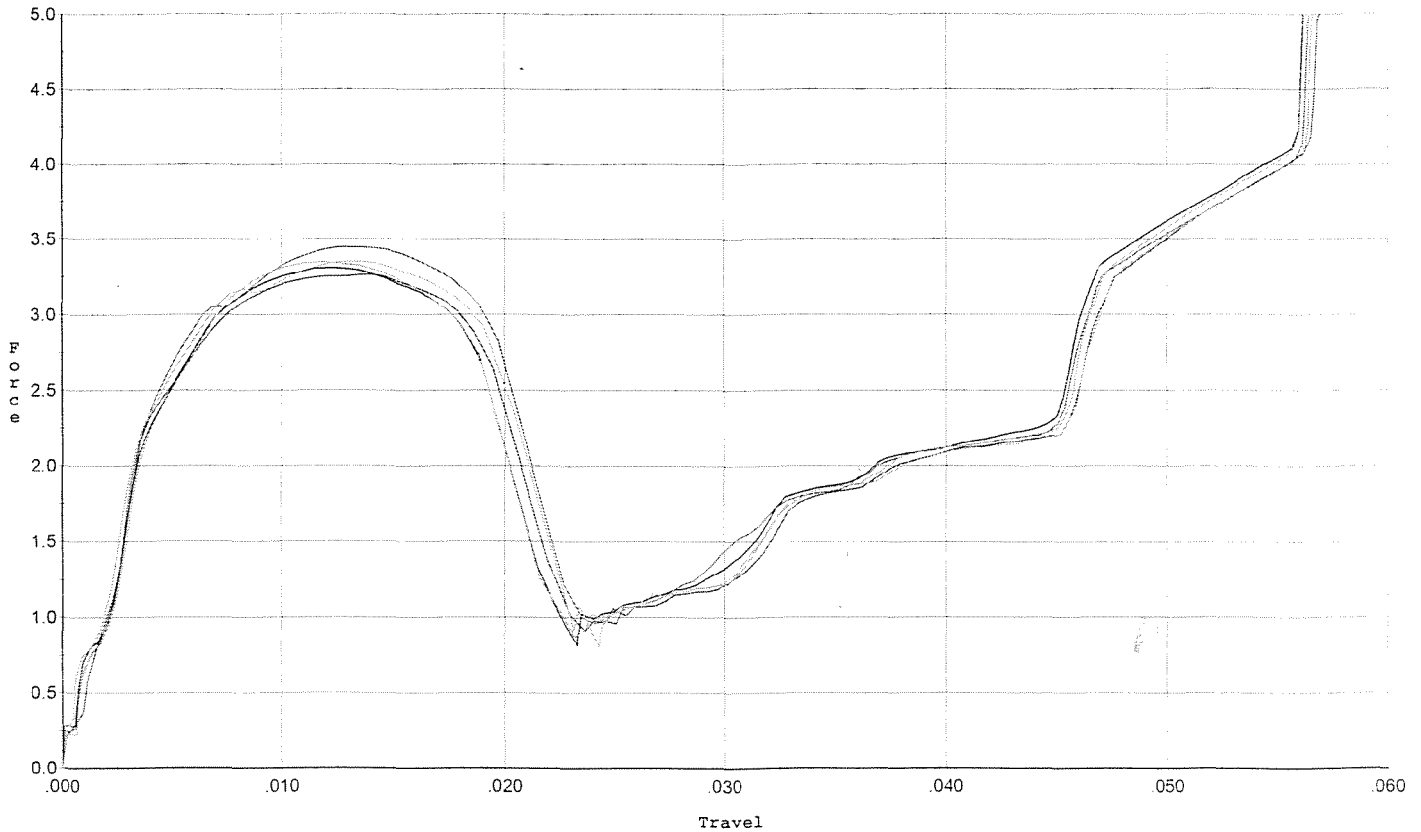
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.253	0.022	0.00	0.038	0.052		Set Trigger
2	3.445	0.021	0.00	0.039	0.052		Set Trigger
3	3.360	0.022	0.00	0.039	0.054		Set Trigger
4	3.301	0.019	0.00	0.040	0.046		Set Trigger
5	3.320	0.023	0.00	0.039	0.054		Set Trigger

A-3-33

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



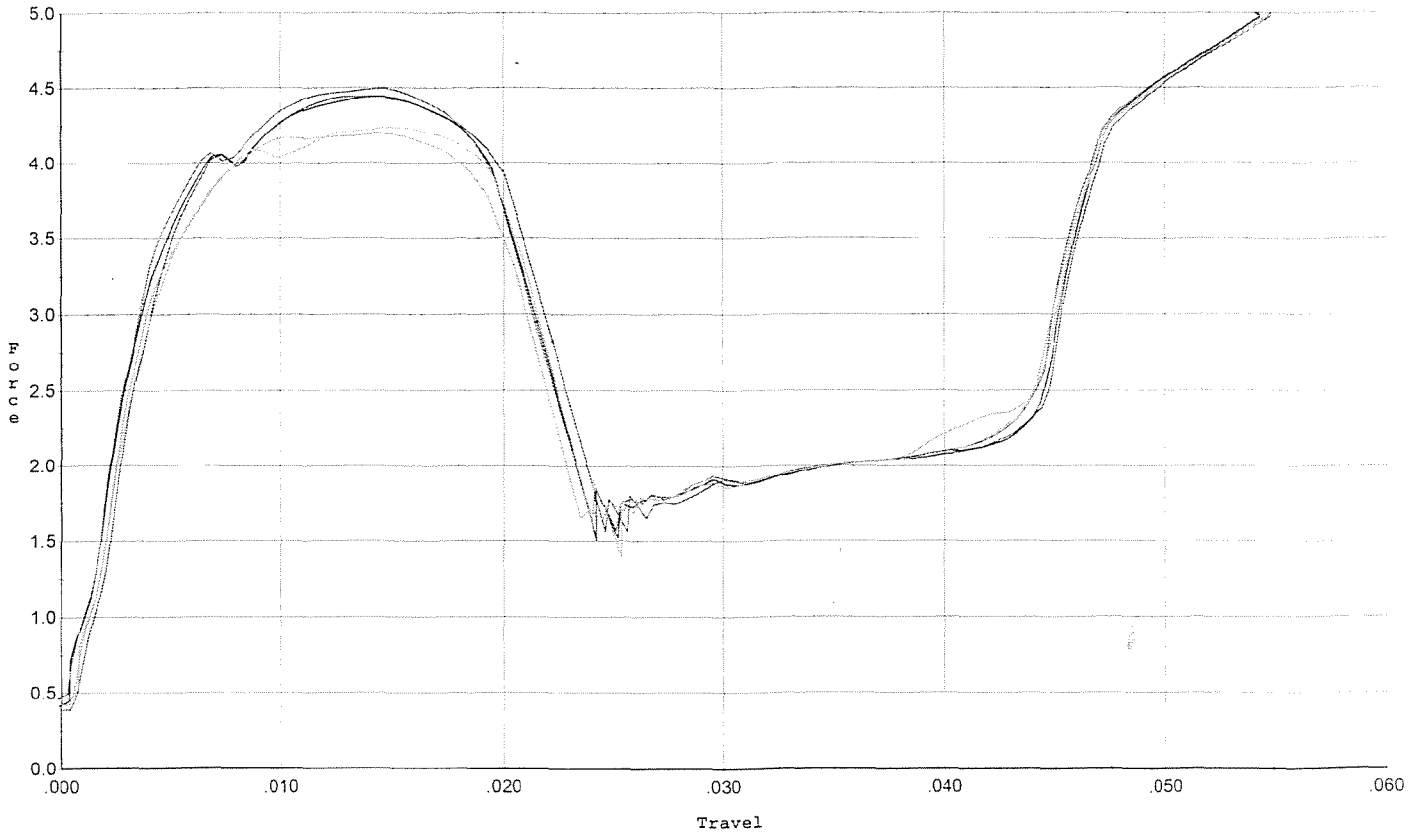
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.263	0.019	0.00	0.040	0.048		Set Trigger
2	3.304	0.019	0.00	0.040	0.046		Set Trigger
3	3.445	0.020	0.00	0.039	0.050		Set Trigger
4	3.348	0.020	0.00	0.039	0.051		Set Trigger
5	3.345	0.019	0.00	0.040	0.046		Set Trigger

A-3-34

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



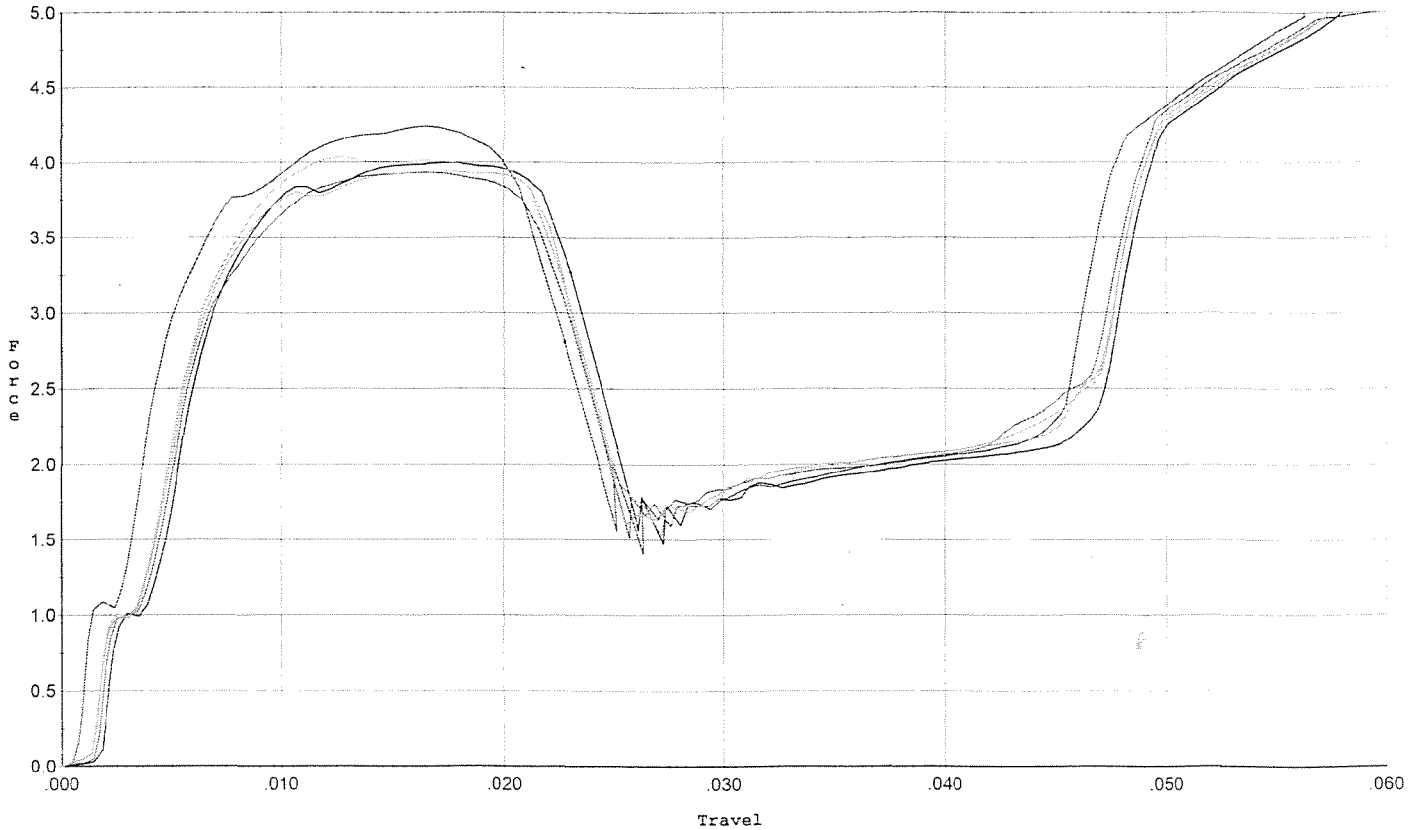
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.442	0.022	0.00	0.036	0.073		Set Trigger
2	4.440	0.022	0.00	0.036	0.071		Set Trigger
3	4.493	0.020	0.00	0.037	0.066		Set Trigger
4	4.237	0.021	0.00	0.036	0.067		Set Trigger
5	4.199	0.020	0.00	0.037	0.065		Set Trigger

A. 4.36

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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



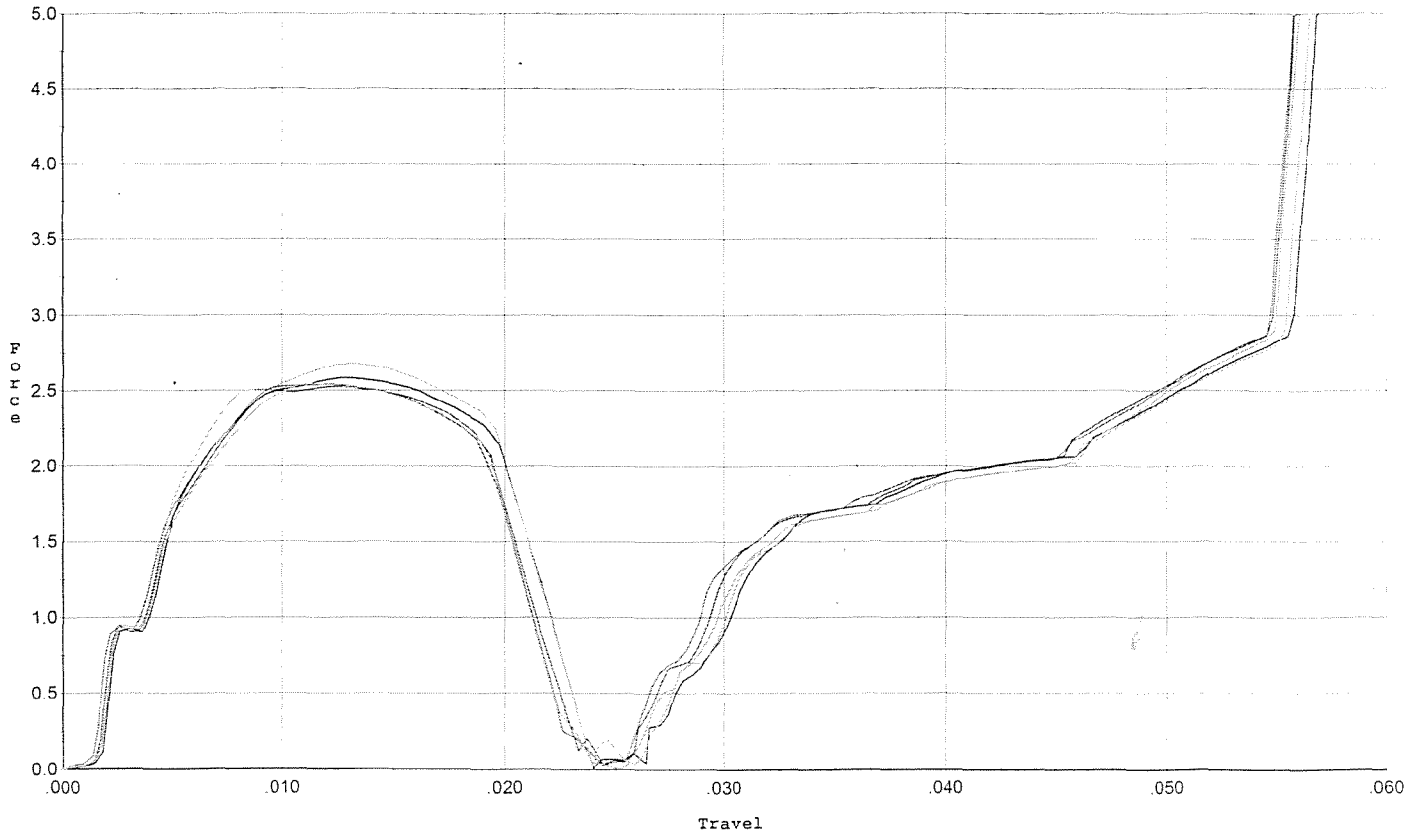
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.239	0.023	0.00	0.036	0.069		Set Trigger
2	3.999	0.023	0.00	0.038	0.064		Set Trigger
3	3.928	0.023	0.00	0.037	0.063		Set Trigger
4	4.038	0.022	0.00	0.037	0.064		Set Trigger
5	3.943	0.022	0.00	0.037	0.062		Set Trigger

A.4.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 2/25/2009

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



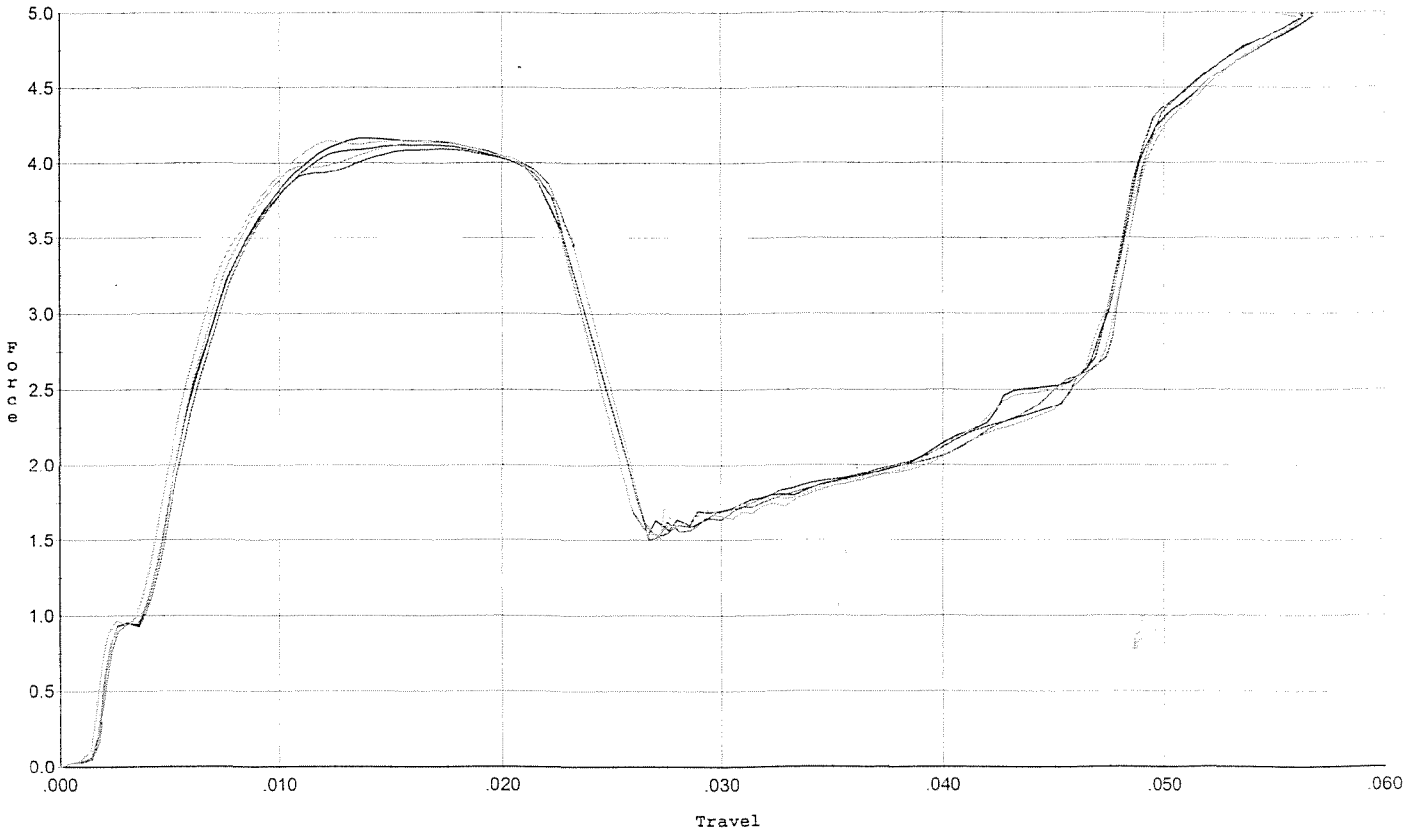
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.526	0.019	0.00	0.040	0.035		Set Trigger
2	2.583	0.022	0.00	0.040	0.039		Set Trigger
3	2.542	0.020	0.00	0.040	0.036		Set Trigger
4	2.676	0.022	0.004	0.040	0.041		Set Trigger
5	2.539	0.019	0.004	0.041	0.035		Set Trigger

A-2-57

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 2/25/2009

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	4.118	0.022	0.00	0.037	0.064		Set Trigger
2	4.161	0.023	0.00	0.037	0.065		Set Trigger
3	4.091	0.023	0.00	0.037	0.066		Set Trigger
4	4.148	0.023	0.00	0.037	0.066		Set Trigger
5	4.133	0.023	0.00	0.037	0.067		Set Trigger

A-4.13