

BARBER - M24 0017182

7680 7753

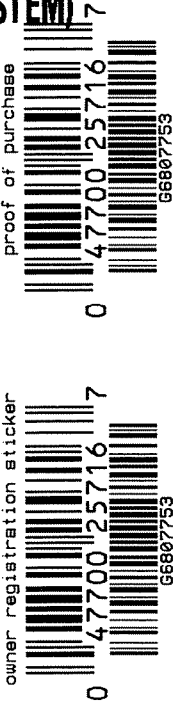
**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

BARBER - M24 0017182 M2400017221

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

- INSTRUCTION BOOK 3518

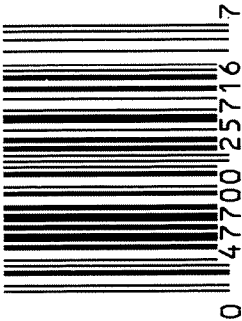
BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6807753

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6807753

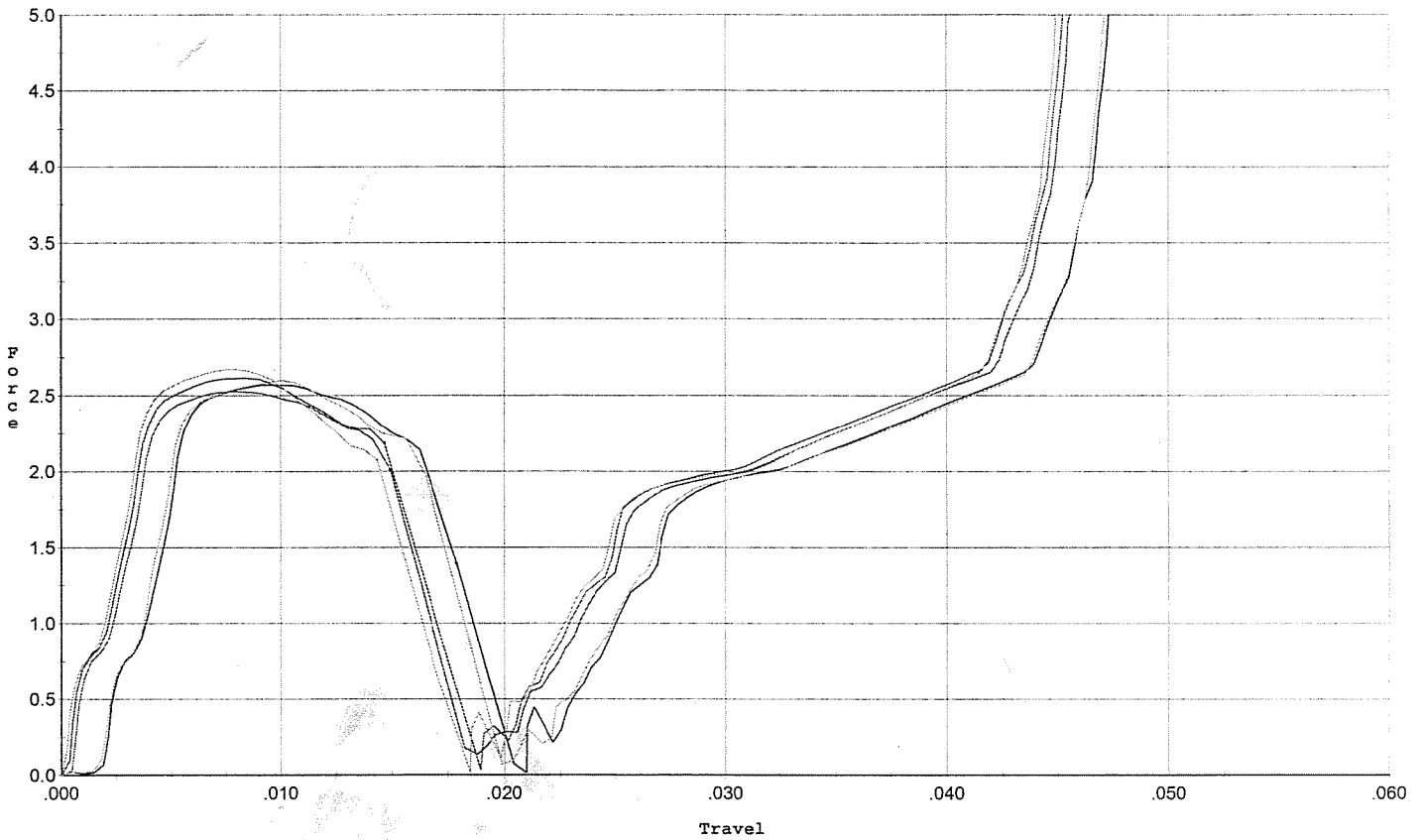
OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		3-6-09	RTZ
430	ASSEMBLE TO STOCK		3-6-09	RTZ
440	PROOF		3-6-09	TC
460	CHECK HEADSPACE		3-6-09	TC
470	DIS-ASSEMBLE ACTION		3-6-09	SPD
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX MARK 13 2009	3-9-09	RTZ
475	DRILL AND TAP SIGHT HOLES	OPERATOR 	3-9-09	SP
480	MAGNAFLUX BBL ACTION		3/13/09	
490	MAGNAFLUX BOLT		3/13/09	NR
500	ROLLMARK CALIBER		3/13/09	RT
520	GOFF BLAST BBL / REC		3-16	Bt
542	APPLY COATINGS (BARREL ACTION)		8/24	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-25-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-25-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-25-09	SP
	D) OIL FIRING PIN ASSEMBLY		3-25-09	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>3.0</u>	3-30-09	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>4.0</u>	3-30-09	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-30-09	L.N.
	J) ASSEMBLE STOCK		3-25-09	L.N.
	K) ASSEMBLE SWIVEL STUDS		3-31-09	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	3-27-09	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-27-09	W.W.
670	FINAL INSPECTION A) HEADSPACE		3-31-09	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.77</u> <u>2.79</u> <u>2.72</u> <u>2.75</u>	3-30-09	TL
	C) FUNCTION		3-31-09	L.N.
690	PACK		4/13/09	Fm

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



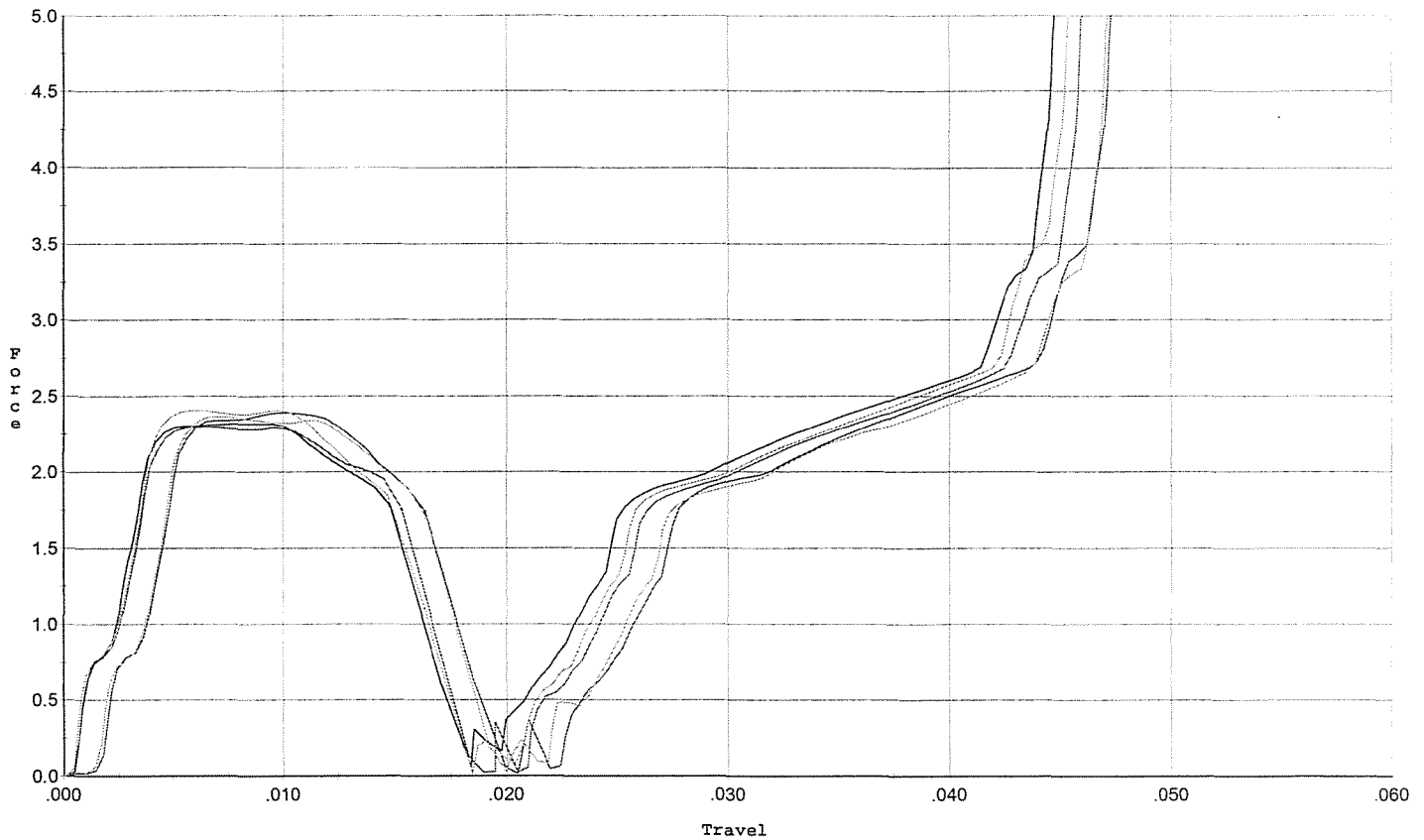
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.613	0.015	0.00	0.034	0.029		Set Trigger
2	2.569	0.018	0.00	0.034	0.031		Set Trigger
3	2.526	0.015	0.00	0.034	0.028		Set Trigger
4	2.597	0.017	0.00	0.034	0.029		Set Trigger
5	2.671	0.014	0.00	0.034	0.028		Set Trigger

A-2-59

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009

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



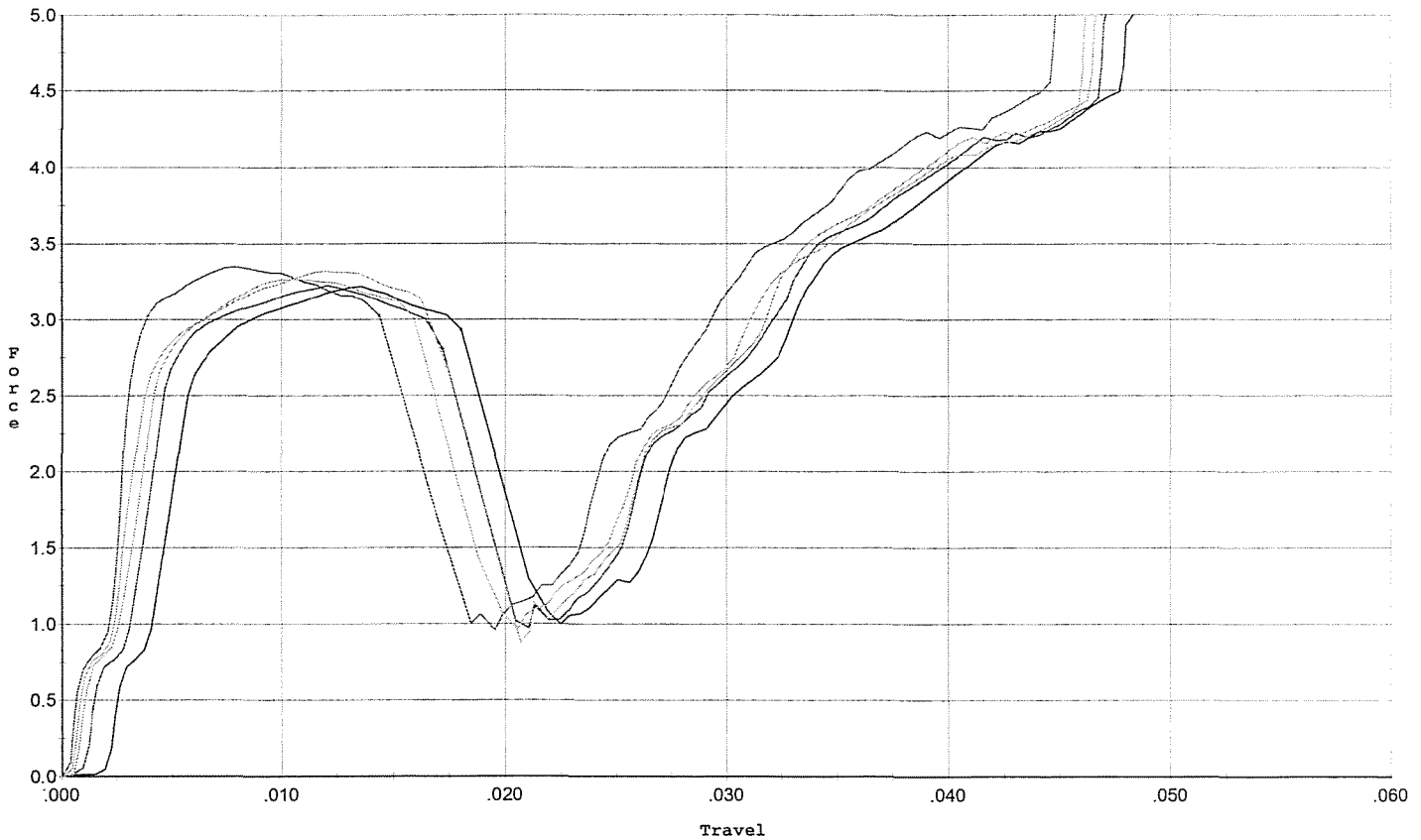
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.393	0.016	0.00	0.035	0.027		Set Trigger
2	2.316	0.015	0.00	0.034	0.026		Set Trigger
3	2.297	0.015	0.00	0.034	0.026		Set Trigger
4	2.367	0.016	0.00	0.035	0.027		Set Trigger
5	2.409	0.016	0.00	0.034	0.029		Set Trigger

A-2.35

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



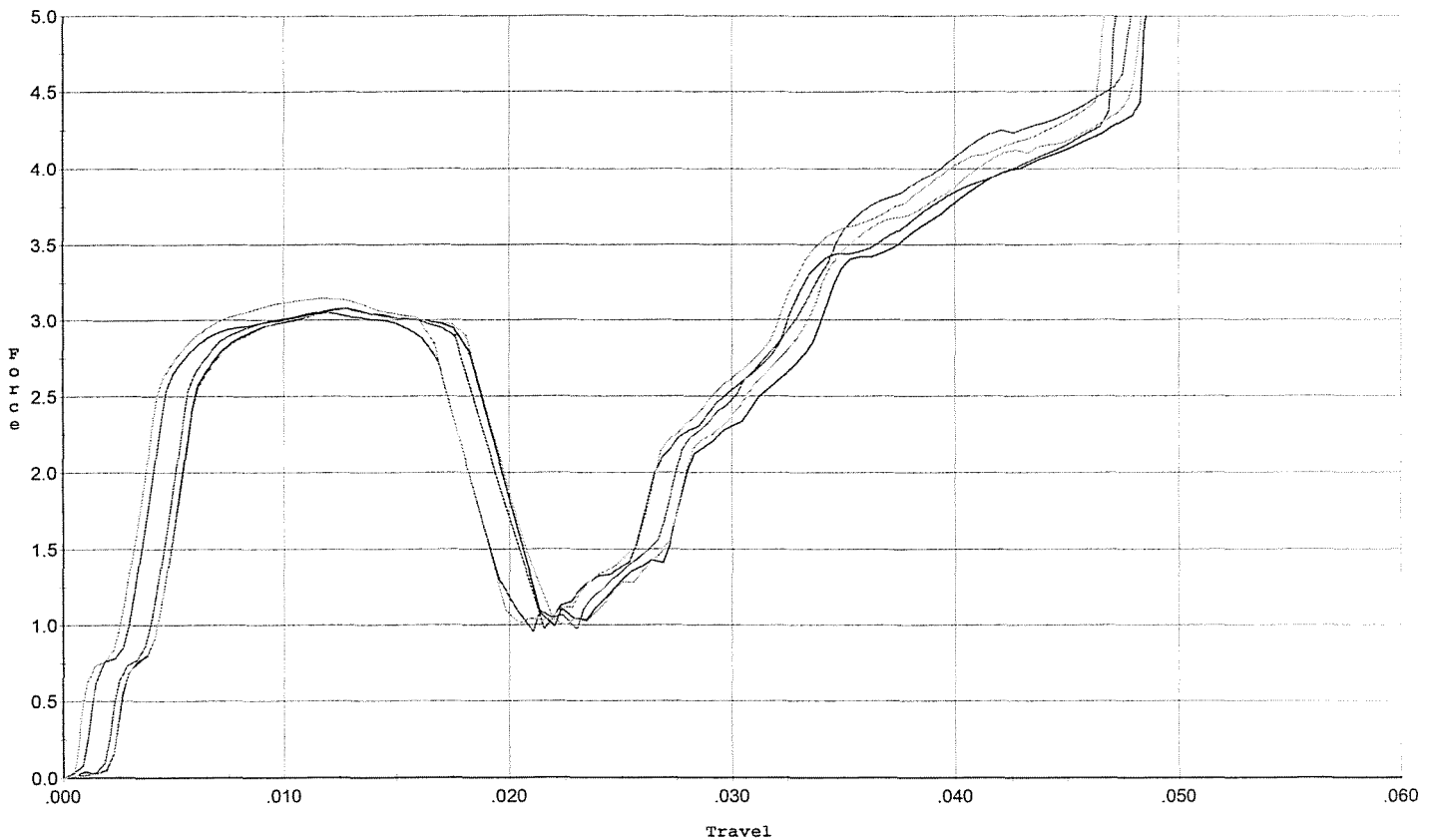
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.226	0.017	0.00	0.031	0.040		Set Trigger
2	3.218	0.018	0.002	0.031	0.039		Set Trigger
3	3.350	0.014	0.00	0.031	0.036		Set Trigger
4	3.269	0.016	0.00	0.031	0.038		Set Trigger
5	3.320	0.017	0.00	0.031	0.042		Set Trigger

A-3.27

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



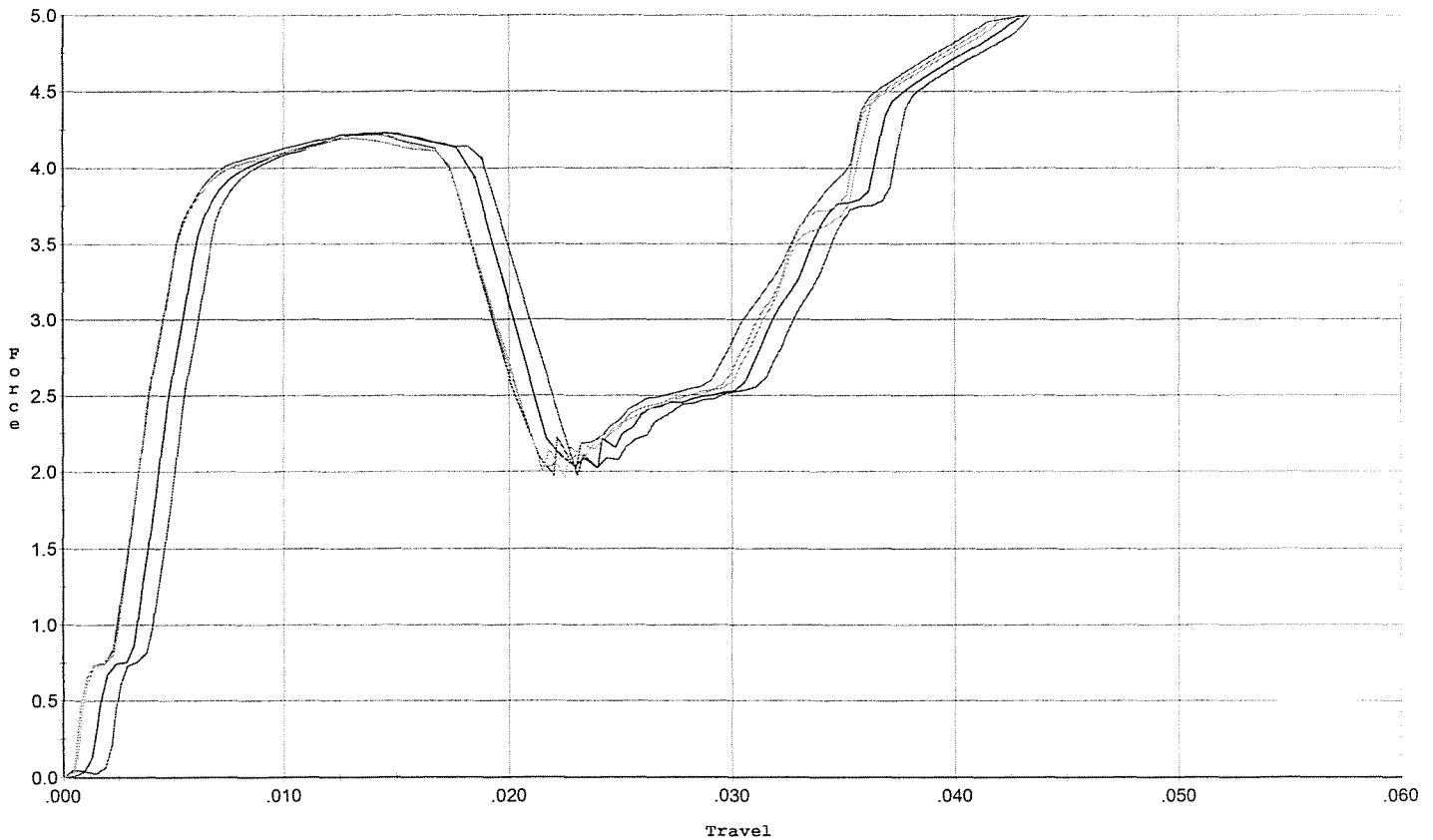
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.051	0.017	0.00	0.032	0.037		Set Trigger
2	3.077	0.018	0.00	0.032	0.038		Set Trigger
3	3.074	0.018	0.00	0.031	0.038		Set Trigger
4	3.076	0.018	0.00	0.031	0.038		Set Trigger
5	3.148	0.017	0.00	0.031	0.039		Set Trigger

A. 3.08
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Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



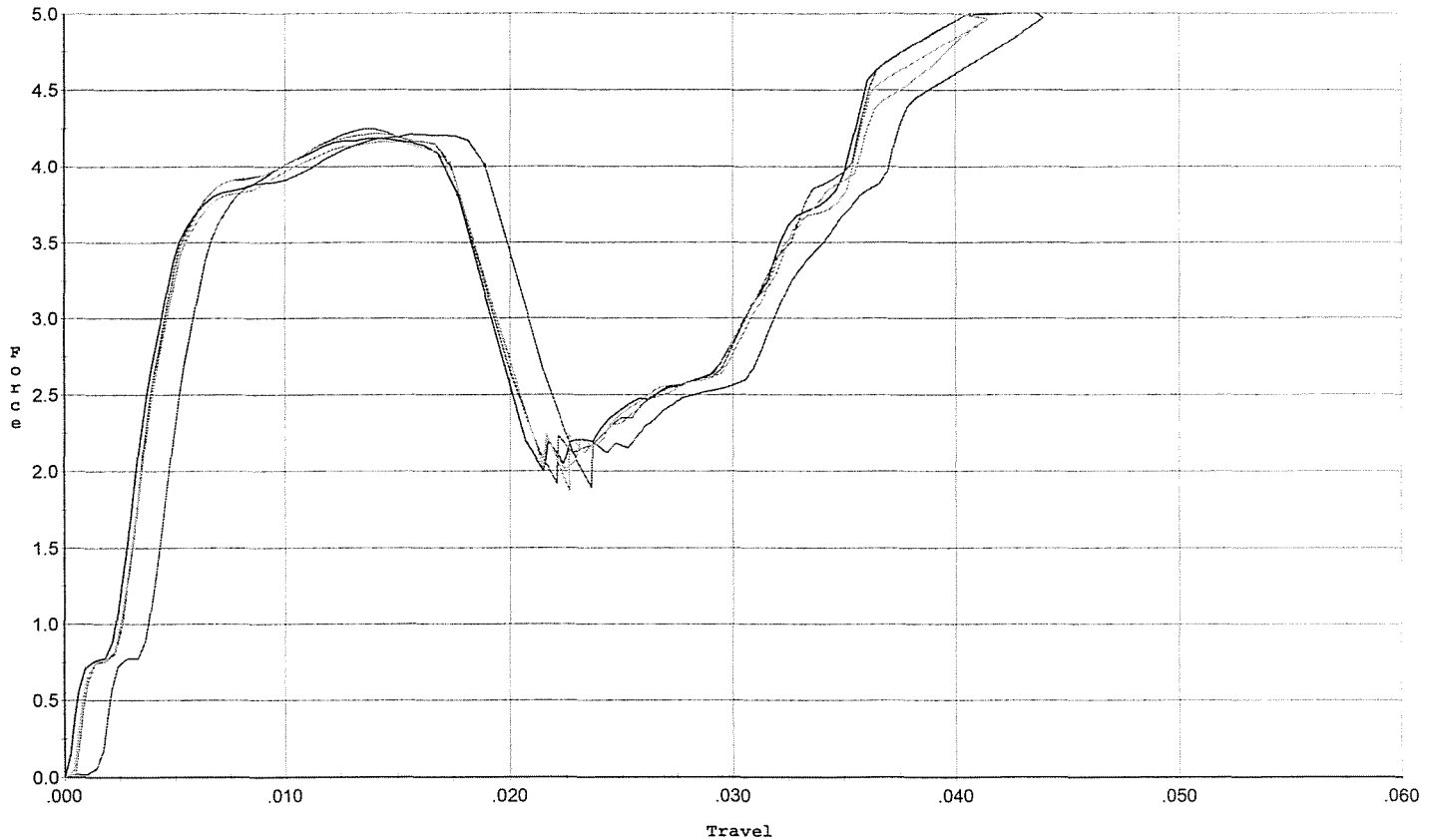
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.231	0.019	0.00	0.029	0.053		Set Trigger
2	4.228	0.019	0.00	0.029	0.054		Set Trigger
3	4.223	0.017	0.00	0.029	0.053		Set Trigger
4	4.215	0.017	0.00	0.029	0.052		Set Trigger
5	4.195	0.017	0.00	0.029	0.052		Set Trigger

A 4.21

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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



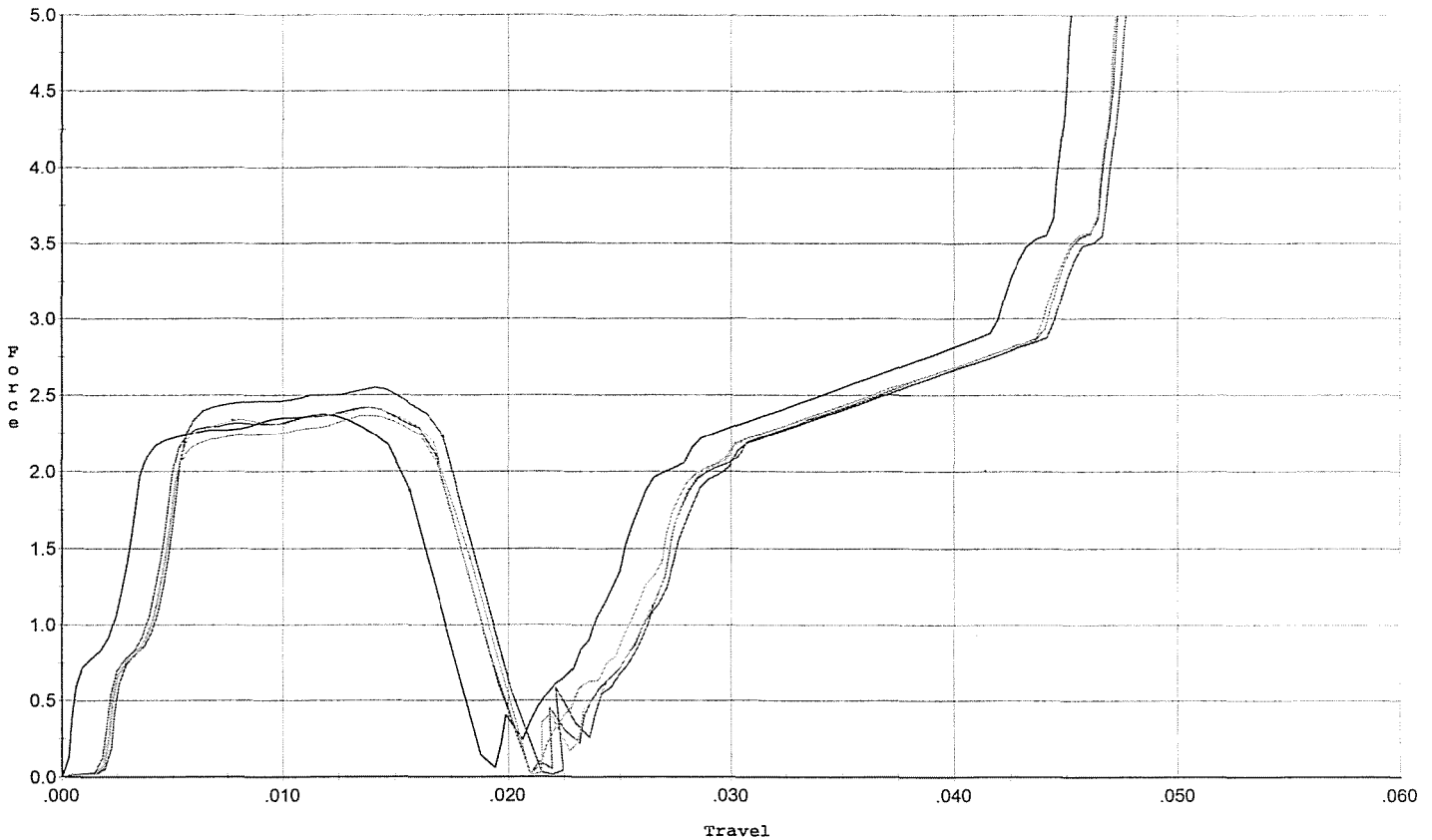
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.209	0.019	0.00	0.029	0.054		Set Trigger
2	4.185	0.018	0.00	0.029	0.053		Set Trigger
3	4.247	0.017	0.00	0.029	0.052		Set Trigger
4	4.161	0.017	0.00	0.029	0.051		Set Trigger
5	4.218	0.017	0.00	0.029	0.052		Set Trigger

A-4.20

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 3/16/2009

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

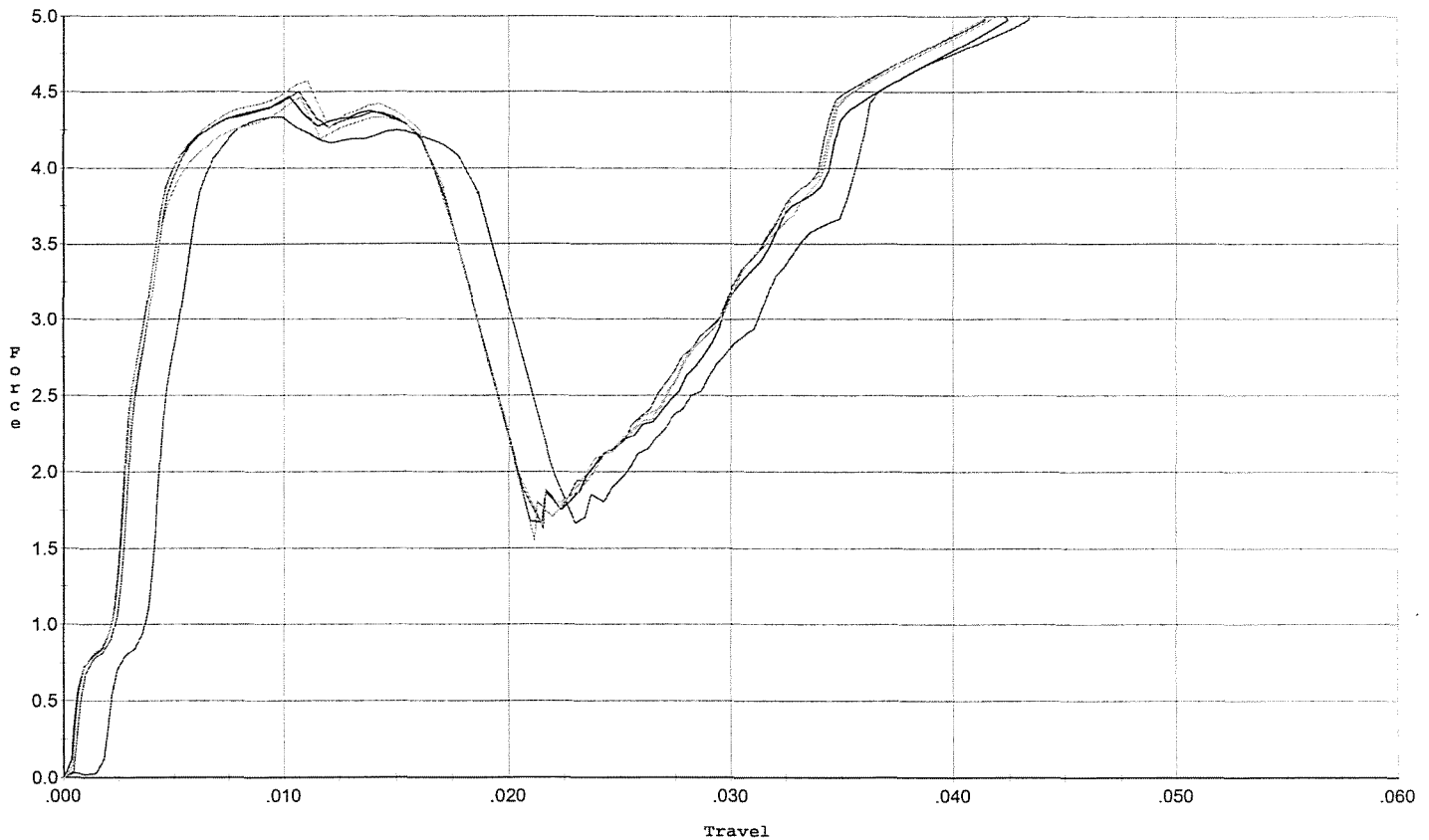


#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.550	0.017	0.002	0.033	0.030		Set Trigger
2	2.376	0.016	0.00	0.033	0.029		Set Trigger
3	2.420	0.017	0.002	0.033	0.029		Set Trigger
4	2.418	0.018	0.00	0.033	0.031		Set Trigger
5	2.366	0.017	0.002	0.033	0.028		Set Trigger

A-247

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 3/16/2009
 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	4.334	0.019	0.00	0.029	0.055		Set Trigger
2	4.468	0.017	0.00	0.028	0.055		Set Trigger
3	4.502	0.017	0.00	0.028	0.054		Set Trigger
4	4.464	0.017	0.00	0.028	0.054		Set Trigger
5	4.571	0.017	0.00	0.028	0.056		Set Trigger

A-4.46