

BARBER - M24 0073419

56794598

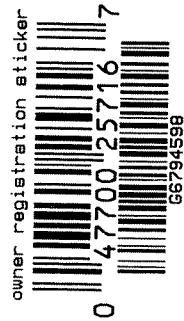
CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0073419 M2400073458

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

- INSTRUCTION BOOK 3518

BM FORM



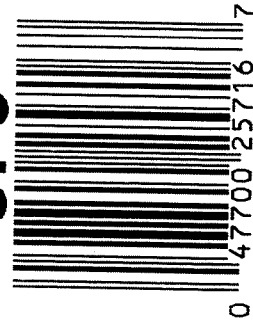
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6794598

UPC



M-24
BARBER - M24 0073421 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6794598

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-14-08	SP
430	ASSEMBLE TO STOCK		10-14-08	SP
440	PROOF		10-14-08	SP
460	CHECK HEADSPACE		10-14-08	SP
470	DIS-ASSEMBLE ACTION		10-14-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA - FLUX	10-15-08	RTZ
475	DRILL AND TAP SIGHT HOLES	17 2008	10-15-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	10/17/08	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/17/08	RT
520	GOFF BLAST BBL / REC		10/20/08	DB
542	APPLY COATINGS (BARREL ACTION)		10-22	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-23-08	SP
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

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BARBER - M24 0073421 M2400073460

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>4.0</u>	10-30-08	L. D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>6.0</u>	10-30-08	L. D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-30-08	L. D.
	J) ASSEMBLE STOCK		10-23-08	L. D.
	K) ASSEMBLE SWIVEL STUDS		10-30-08	L. D.
	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	10-24-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	Rsn
670	FINAL INSPECTION A) HEADSPACE		10-30-08	L. D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.30</u> <u>2.34</u> <u>2.24</u> <u>2.25</u>	10-28-08	TC
	C) FUNCTION		10-30-08	L. D.
690	PACK		11/3/08	F. M.

F004 REV 5/2006

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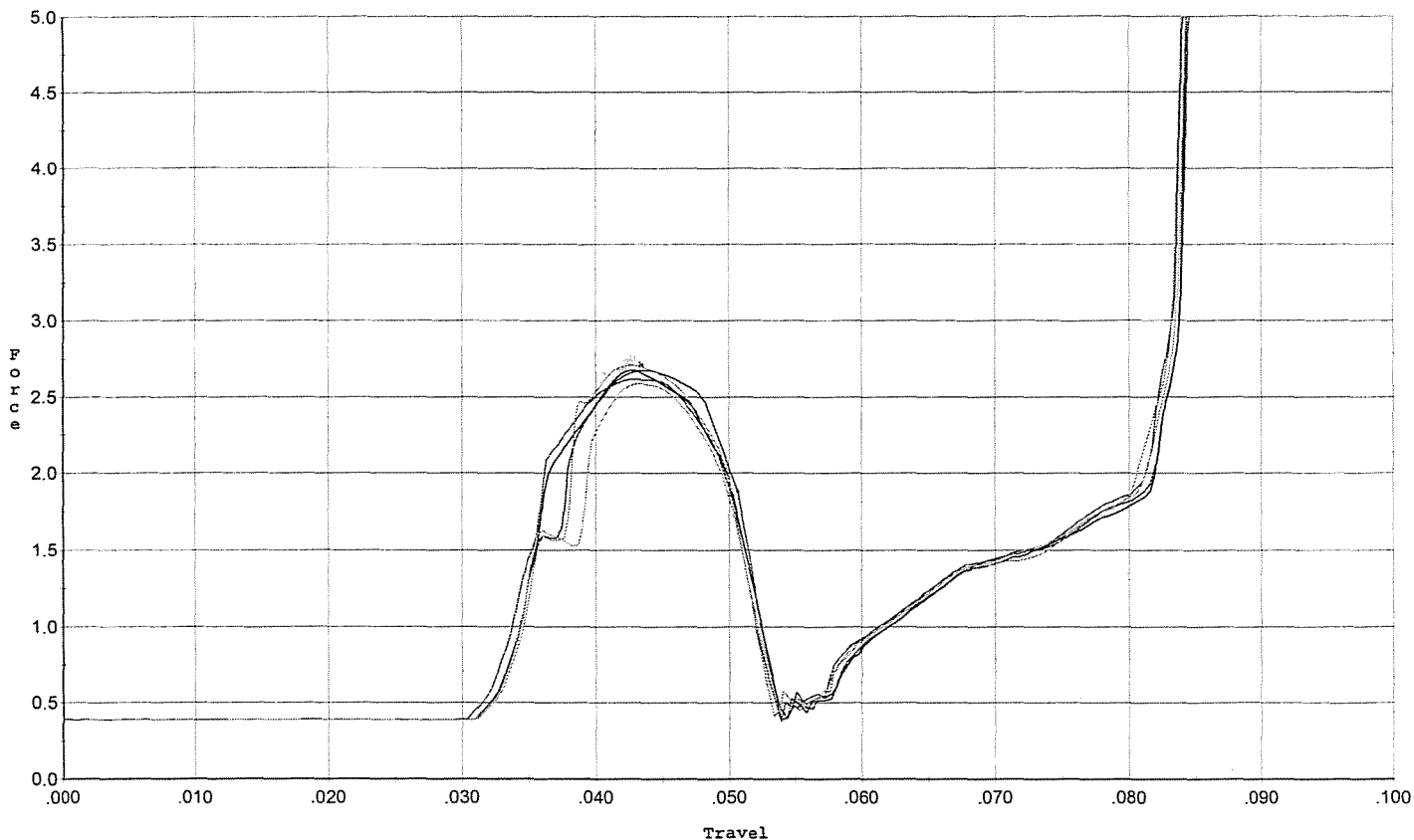
BARBER - M24 0073422

M2400973461

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



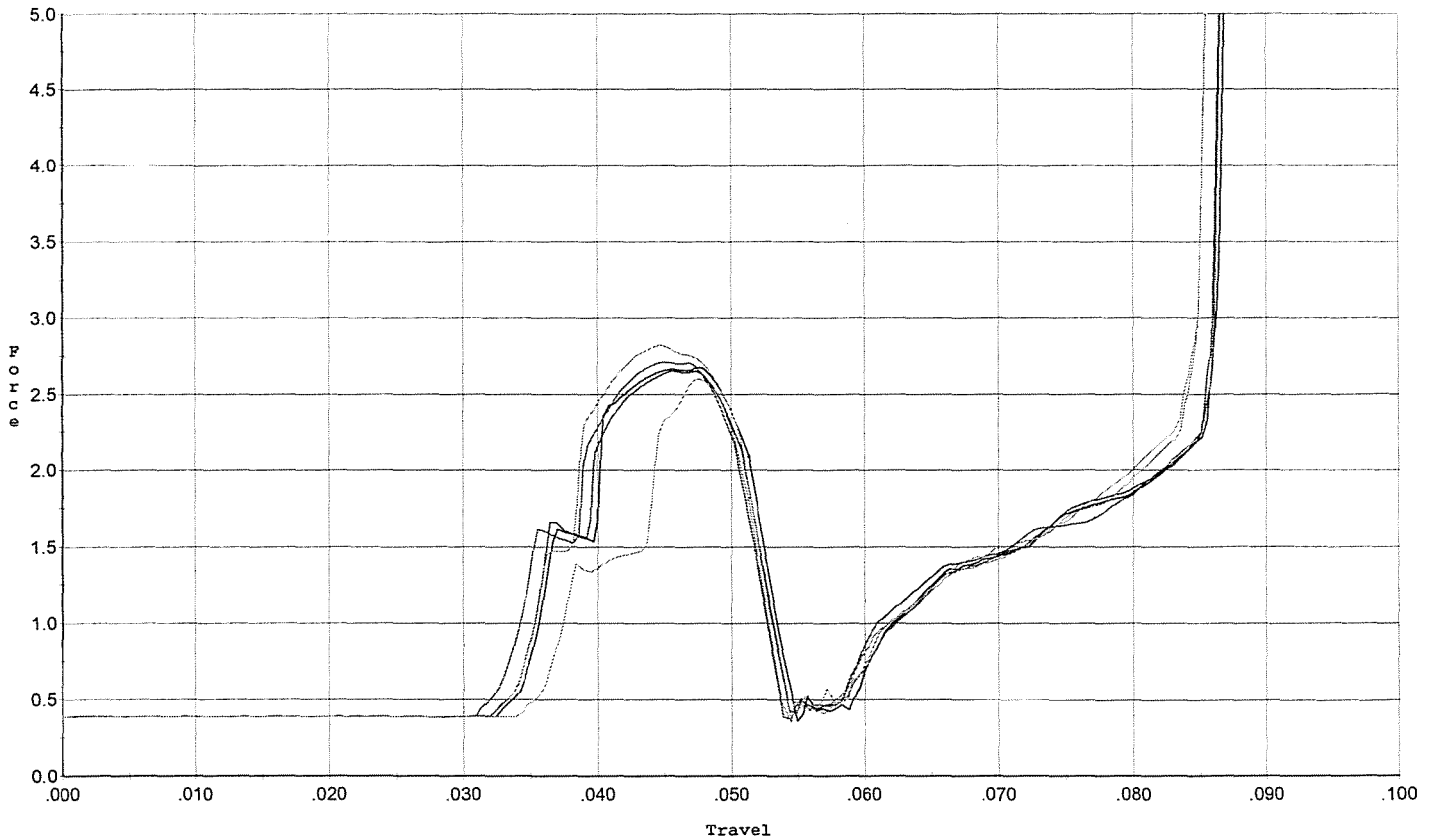
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.676	0.051	0.033	0.038	0.051		Set Trigger
2	2.674	0.052	0.033	0.037	0.053		Set Trigger
3	2.618	0.050	0.032	0.038	0.051		Set Trigger
4	2.589	0.050	0.033	0.039	0.048		Set Trigger
5	2.709	0.050	0.033	0.038	0.050		Set Trigger

A-2.65

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



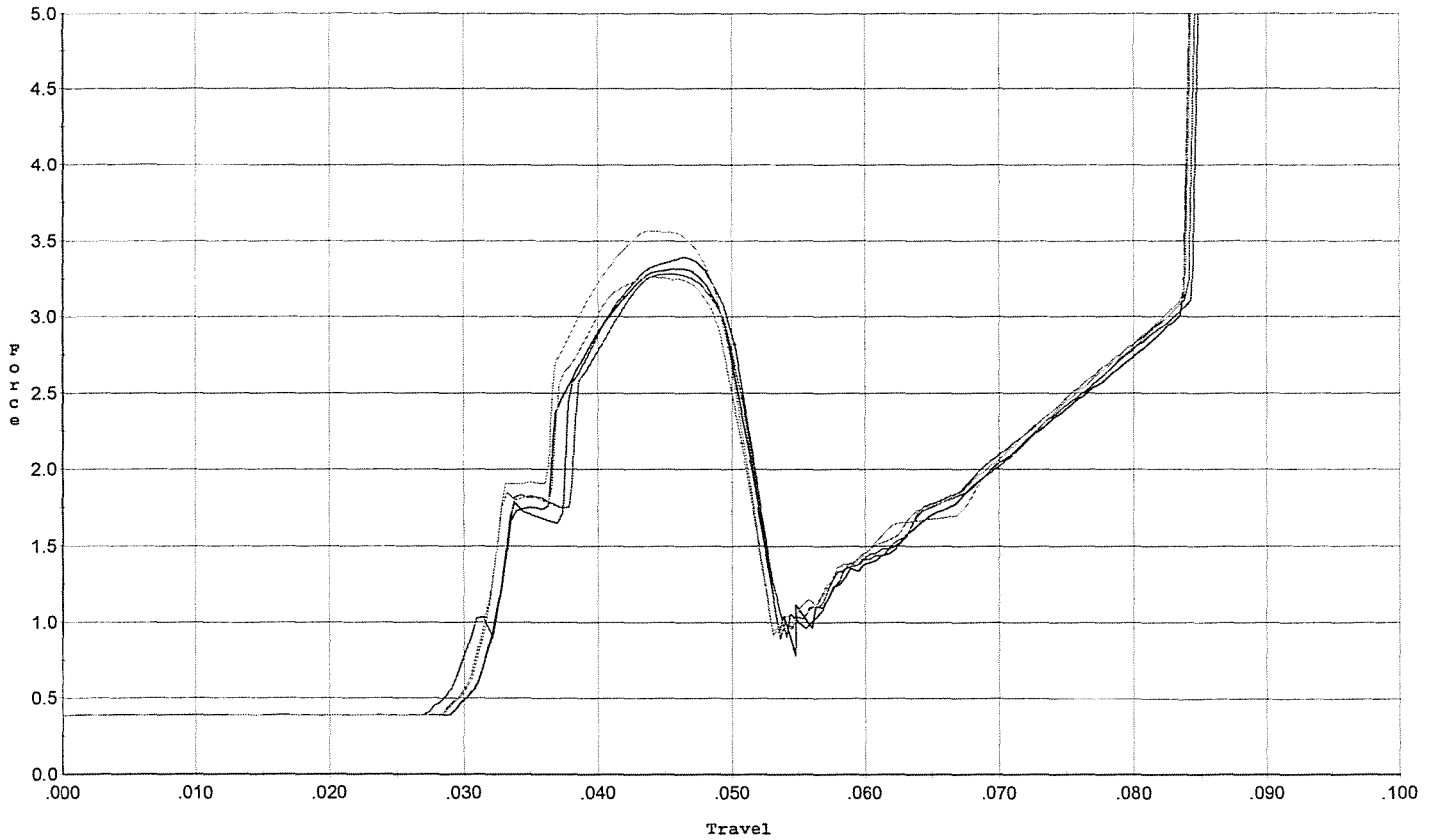
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.655	0.053	0.034	0.039	0.051		Set Trigger
2	2.678	0.051	0.035	0.040	0.050		Set Trigger
3	2.713	0.052	0.033	0.039	0.052		Set Trigger
4	2.602	0.051	0.036	0.039	0.042		Set Trigger
5	2.823	0.051	0.034	0.038	0.052		Set Trigger

A-2.69

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



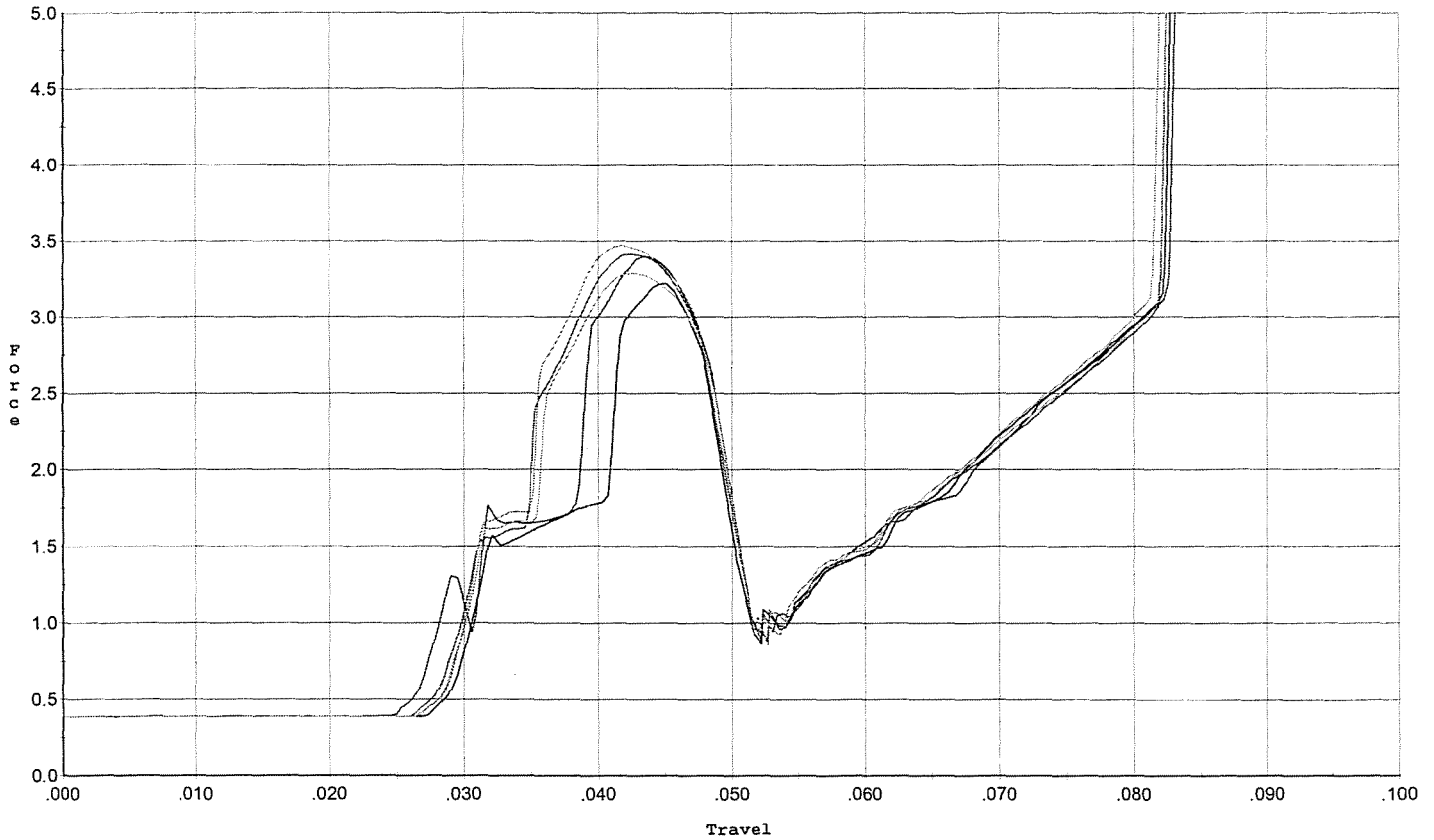
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.395	0.050	0.029	0.037	0.063		Set Trigger
2	3.319	0.051	0.031	0.037	0.064		Set Trigger
3	3.284	0.051	0.031	0.037	0.062		Set Trigger
4	3.565	0.050	0.030	0.037	0.066		Set Trigger
5	3.264	0.051	0.030	0.037	0.064		Set Trigger

A-3.36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



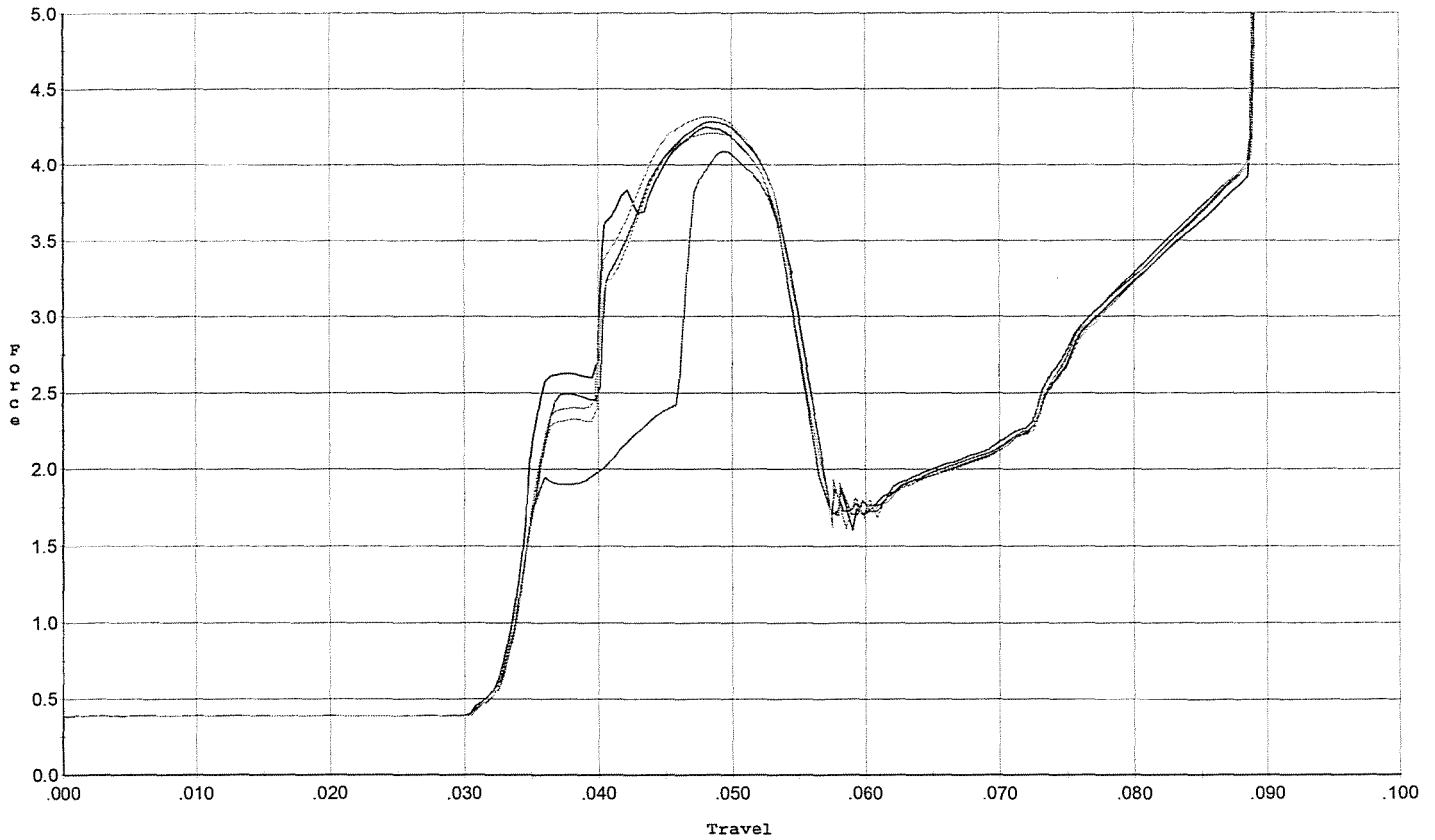
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.400	0.049	0.027	0.038	0.059		Set Trigger
2	3.223	0.048	0.029	0.038	0.052		Set Trigger
3	3.419	0.048	0.028	0.036	0.061		Set Trigger
4	3.293	0.049	0.029	0.036	0.061		Set Trigger
5	3.471	0.049	0.029	0.035	0.064		Set Trigger

A-3-36

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



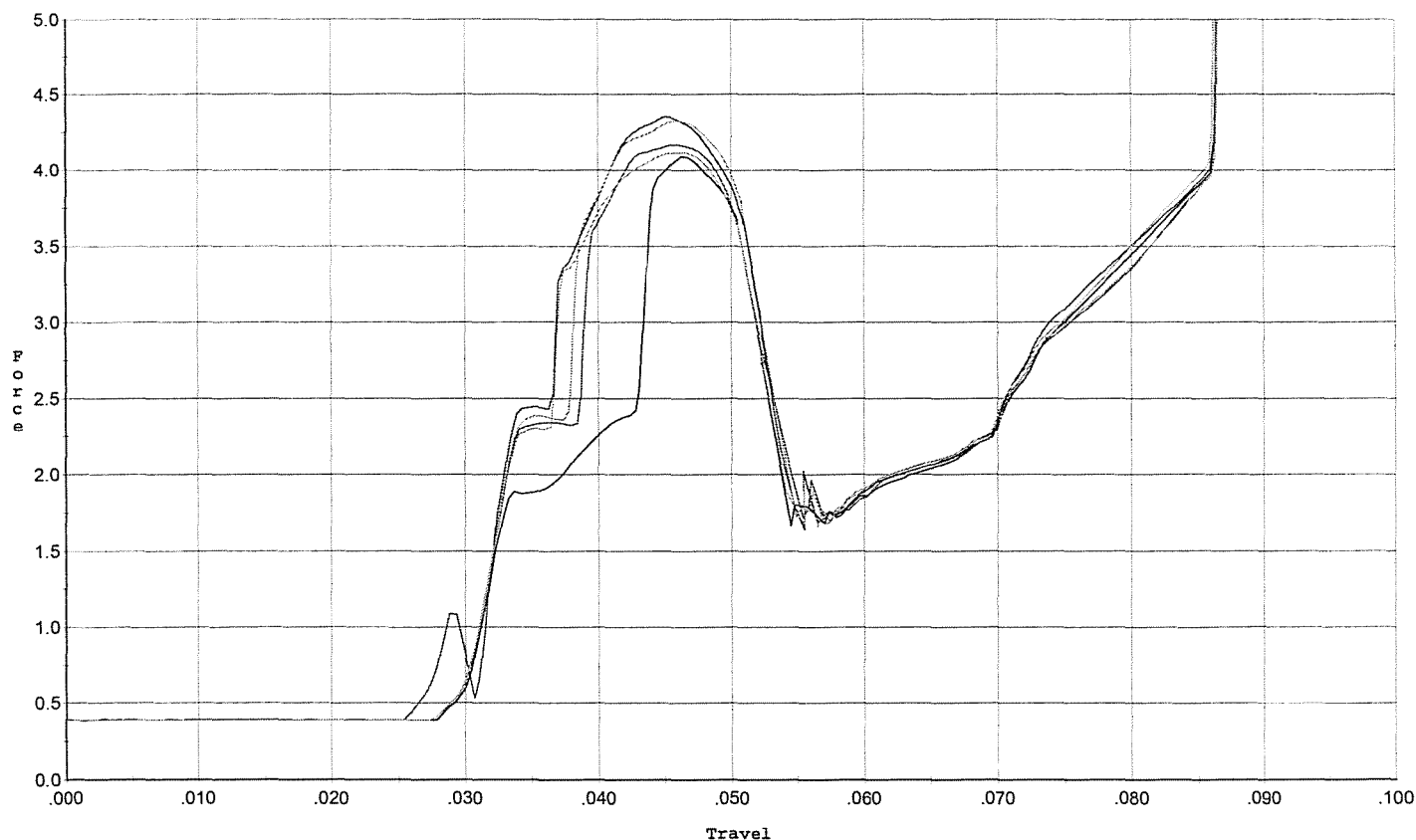
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.282	0.054	0.033	0.036	0.085		Set Trigger
2	4.247	0.054	0.033	0.036	0.084		Set Trigger
3	4.090	0.054	0.033	0.037	0.071		Set Trigger
4	4.207	0.053	0.033	0.036	0.082		Set Trigger
5	4.315	0.055	0.033	0.036	0.086		Set Trigger

A-4.22

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/14/2008

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



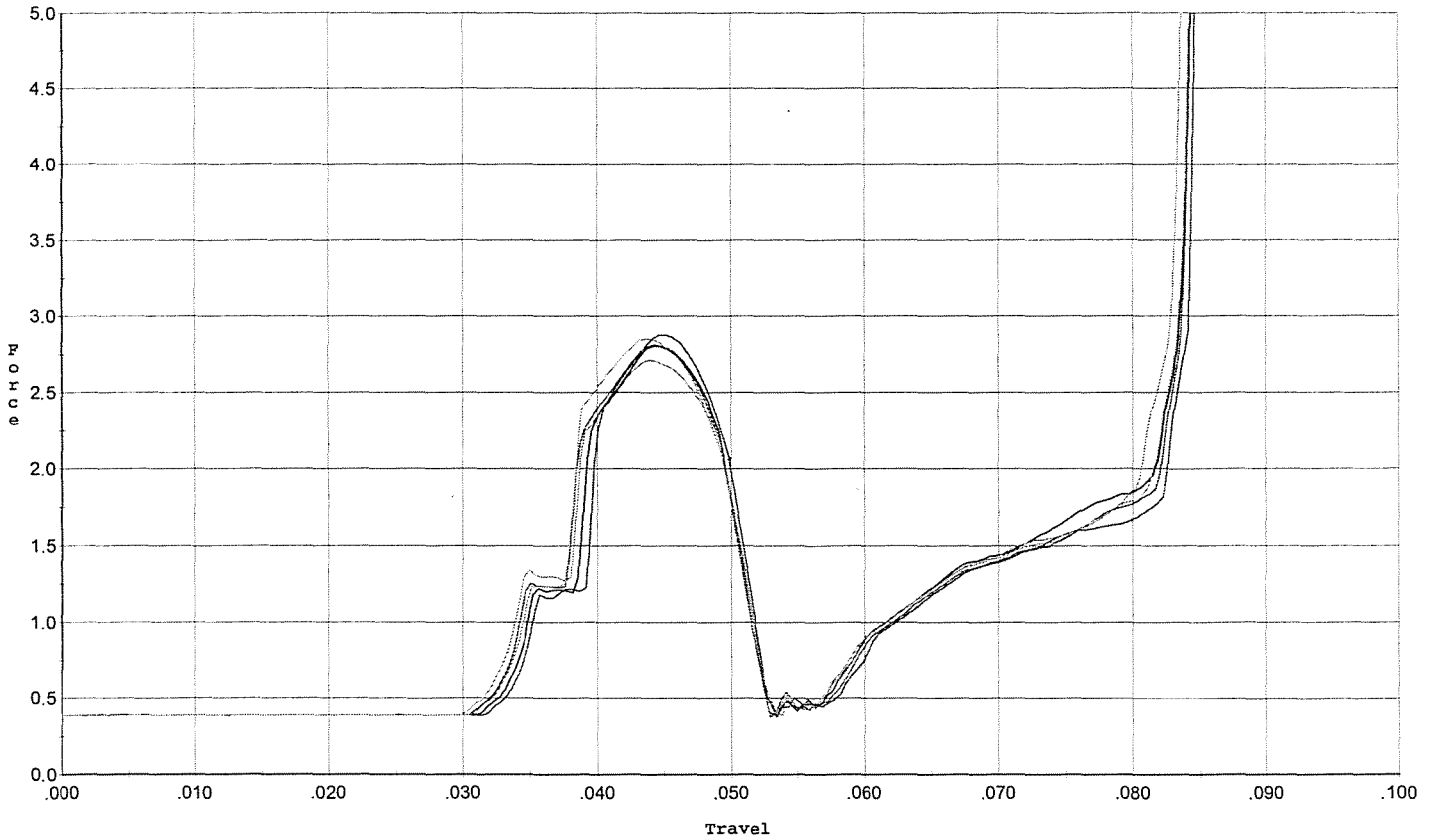
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.351	0.051	0.028	0.036	0.084		Set Trigger
2	4.089	0.052	0.030	0.037	0.072		Set Trigger
3	4.168	0.050	0.030	0.036	0.078		Set Trigger
4	4.115	0.050	0.030	0.036	0.079		Set Trigger
5	4.325	0.051	0.030	0.036	0.082		Set Trigger

A-4.21

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



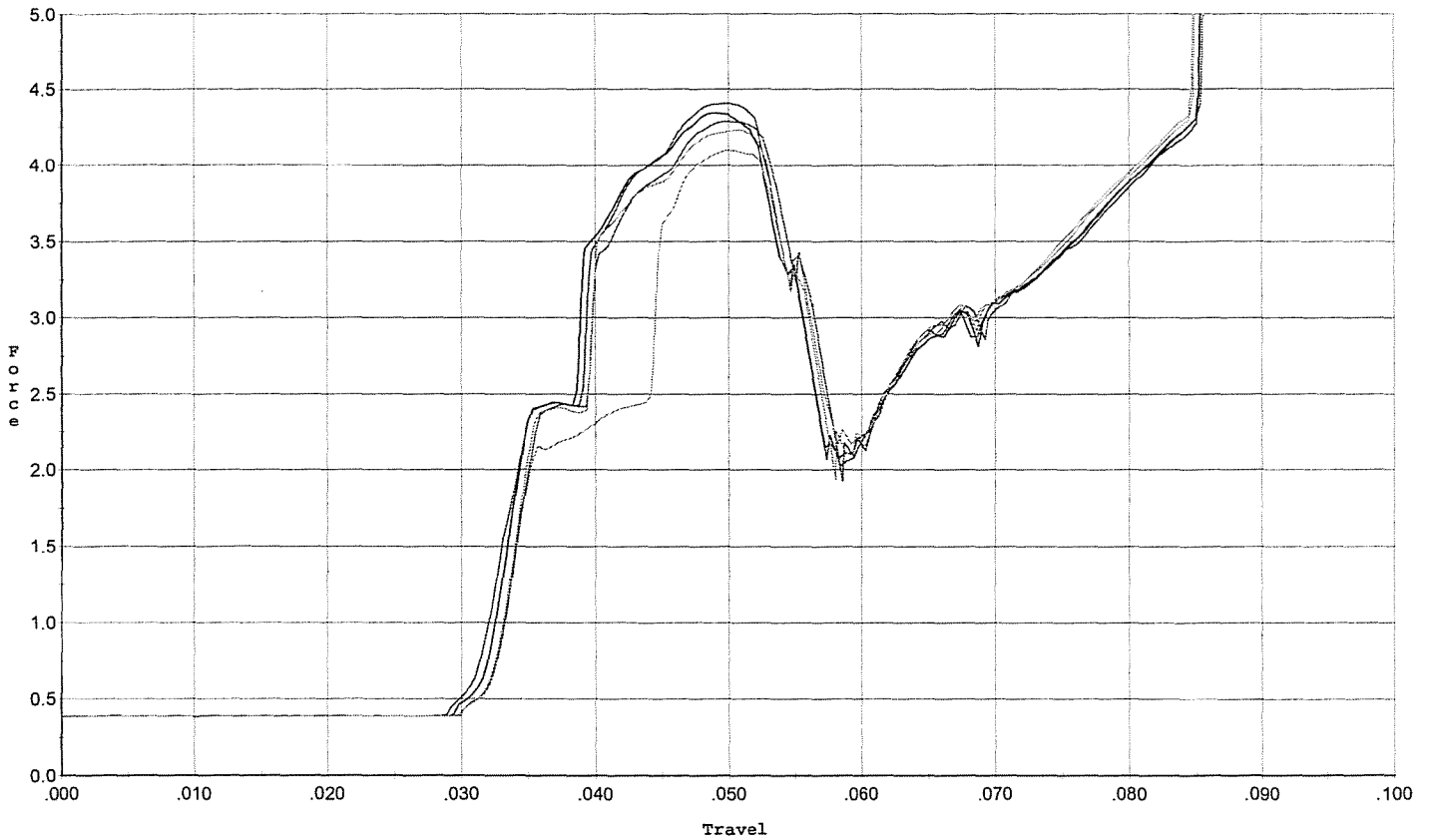
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.877	0.050	0.034	0.039	0.047		Set Trigger
2	2.807	0.051	0.034	0.039	0.048		Set Trigger
3	2.812	0.049	0.033	0.038	0.048		Set Trigger
4	2.852	0.049	0.033	0.038	0.048		Set Trigger
5	2.712	0.051	0.032	0.038	0.049		Set Trigger

A - 2.81

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/14/2008

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



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.406	0.055	0.031	0.033	0.092		Set Trigger
2	4.345	0.055	0.030	0.033	0.091		Set Trigger
3	4.287	0.056	0.030	0.033	0.092		Set Trigger
4	4.233	0.056	0.032	0.033	0.090		Set Trigger
5	4.100	0.055	0.032	0.033	0.082		Set Trigger

A-4.27