

GC794694

BARBER - M24 0074442

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

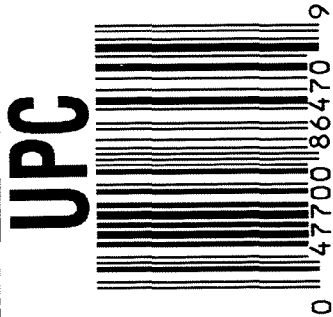


ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6794694



BM FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794694

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-11-08	SPD
430	ASSEMBLE TO STOCK		11-11-08	SP
440	PROOF		11-11-08	SPD
460	CHECK HEADSPACE		11-11-08	SPD
470	DIS-ASSEMBLE ACTION		11-11-08	SPD
472	SERIALIZE BOLT HANDLE		11-12-08	Rsw
475	DRILL AND TAP SIGHT HOLES		11-12-08	SP
480	MAGNAFLUX BBL ACTION		11/17/08	SP
490	MAGNAFLUX BOLT		11/17/08	MR
500	ROLLMARK CALIBER		11/17/08	RT
520	GOFF BLAST BBL / REC		11/17/08	DG
542	APPLY COATINGS (BARREL ACTION)		11-20	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-20-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-20-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-20-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-13-09	Rsw
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

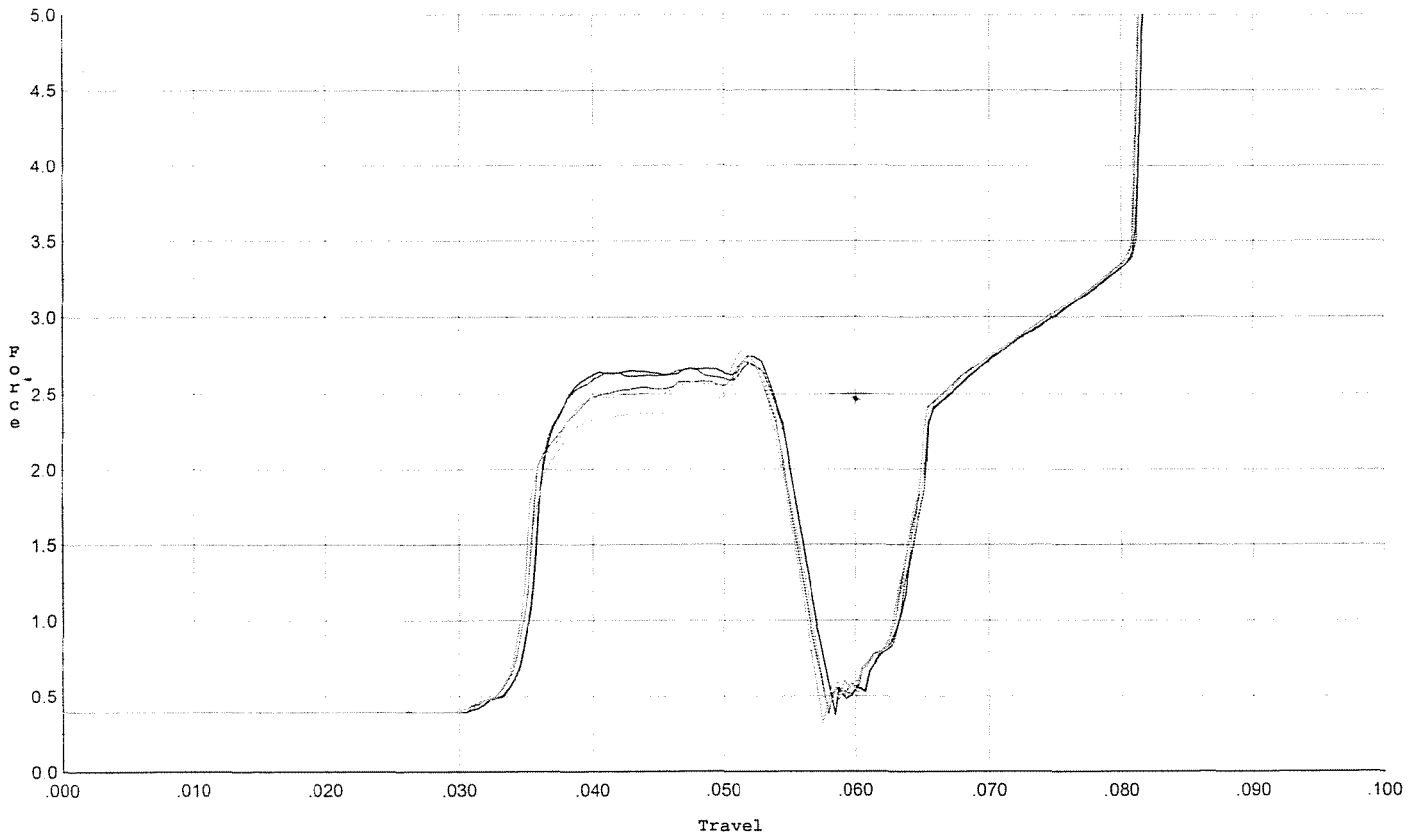
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> <u>6</u> <u>5.5</u>	1-31-09	TL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	1-31-09	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-31-09	TL
	J) ASSEMBLE STOCK		1-13-09	LSH
	K) ASSEMBLE SWIVEL STUDS		1-31-09	TL
	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	1-27-09	SPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-27-09	SP
670	FINAL INSPECTION A) HEADSPACE		1-31-09	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.20</u> <u>2.23</u> <u>2.23</u> <u>2.24</u>	1-30-09	WW
	C) FUNCTION		1-31-09	TL
690	PACK		2/2/09	FM

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



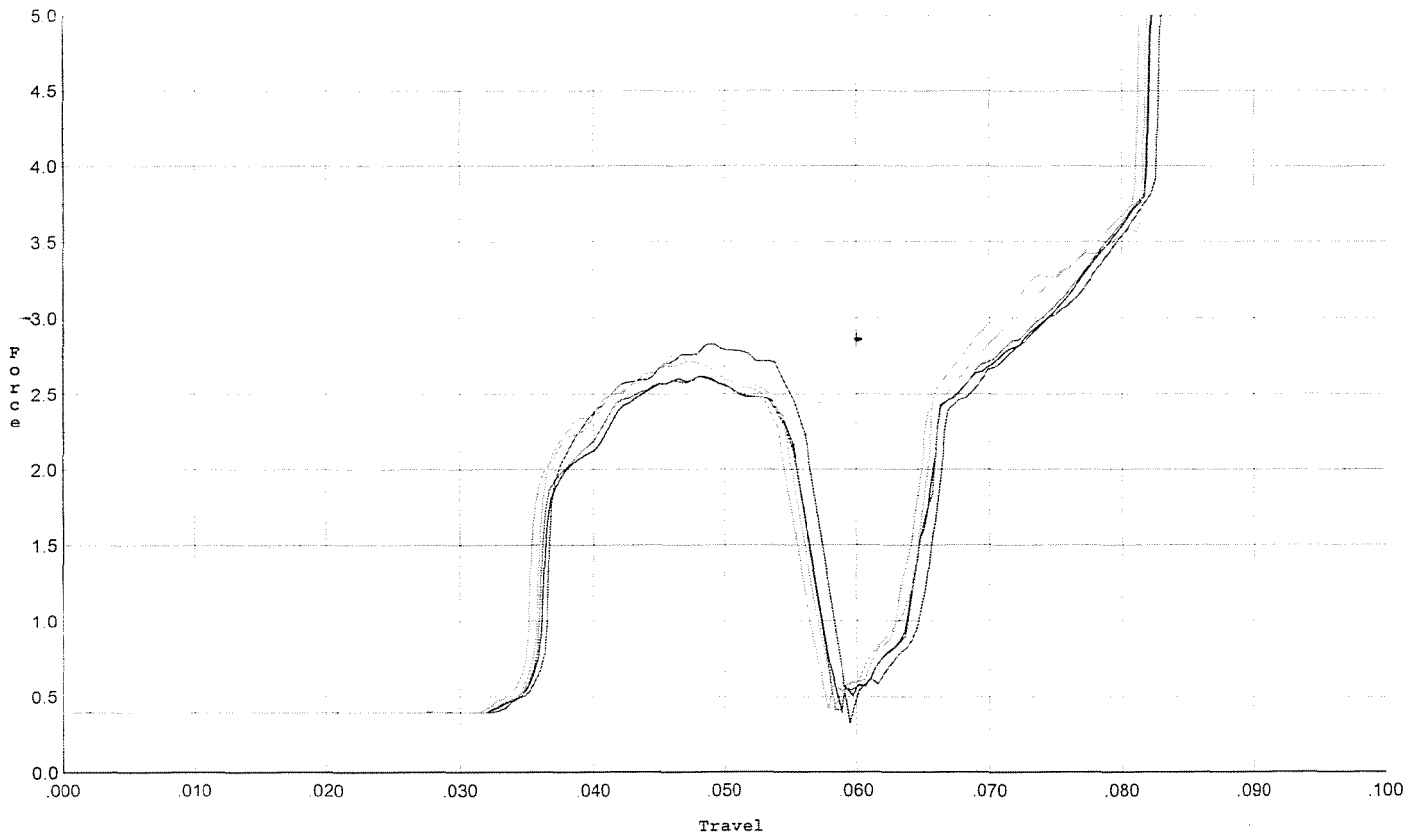
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.701	0.055	0.034	0.033	0.064		Set Trigger
2	2.745	0.054	0.034	0.033	0.064		Set Trigger
3	2.713	0.054	0.034	0.033	0.062		Set Trigger
4	2.739	0.056	0.034	0.032	0.062		Set Trigger
5	2.781	0.054	0.034	0.033	0.062		Set Trigger

A-2.73

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



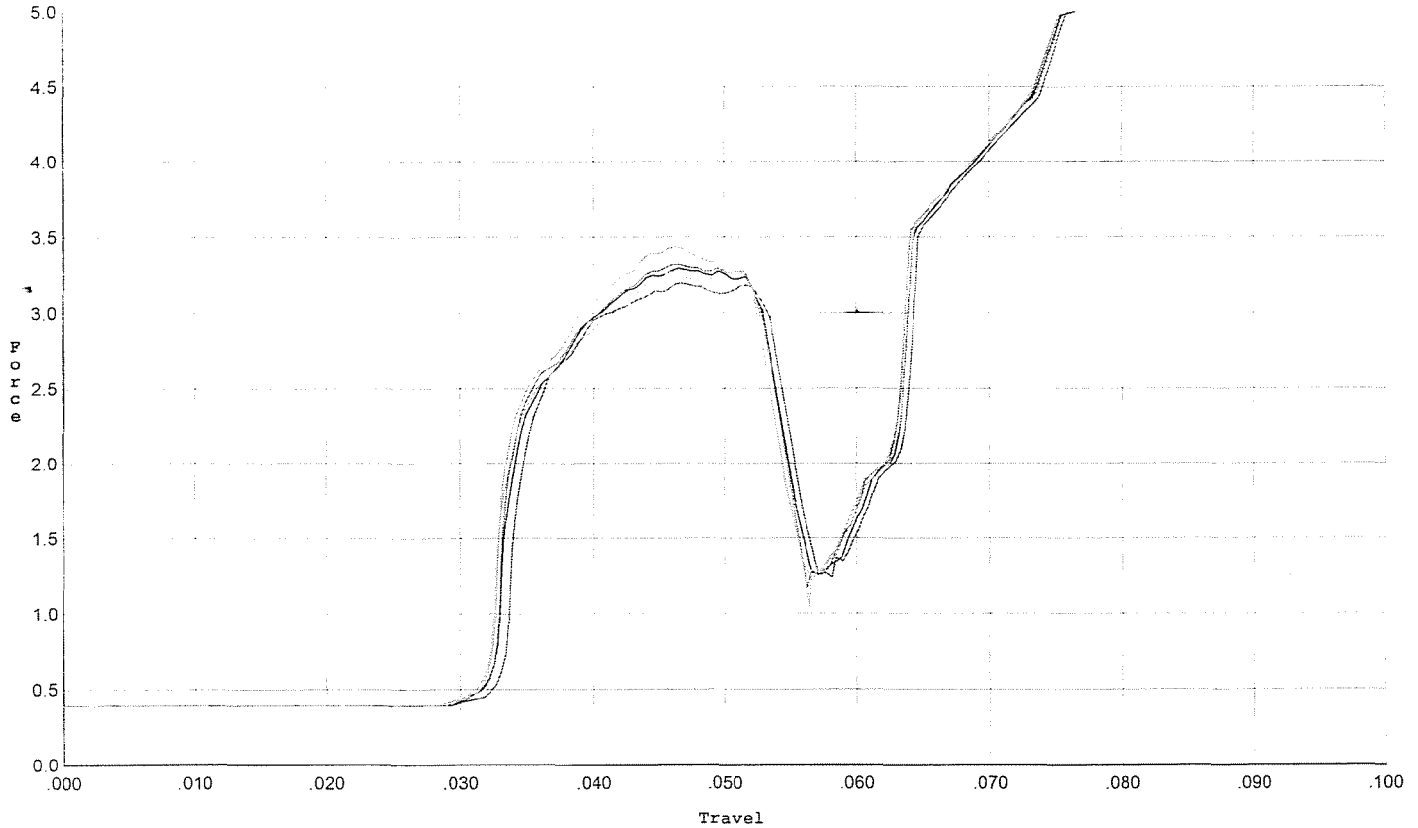
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.826	0.056	0.036	0.032	0.065		Set Trigger
2	2.615	0.055	0.035	0.033	0.060		Set Trigger
3	2.612	0.055	0.035	0.033	0.061		Set Trigger
4	2.767	0.054	0.035	0.033	0.062		Set Trigger
5	2.717	0.054	0.035	0.033	0.061		Set Trigger

A-2-70

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



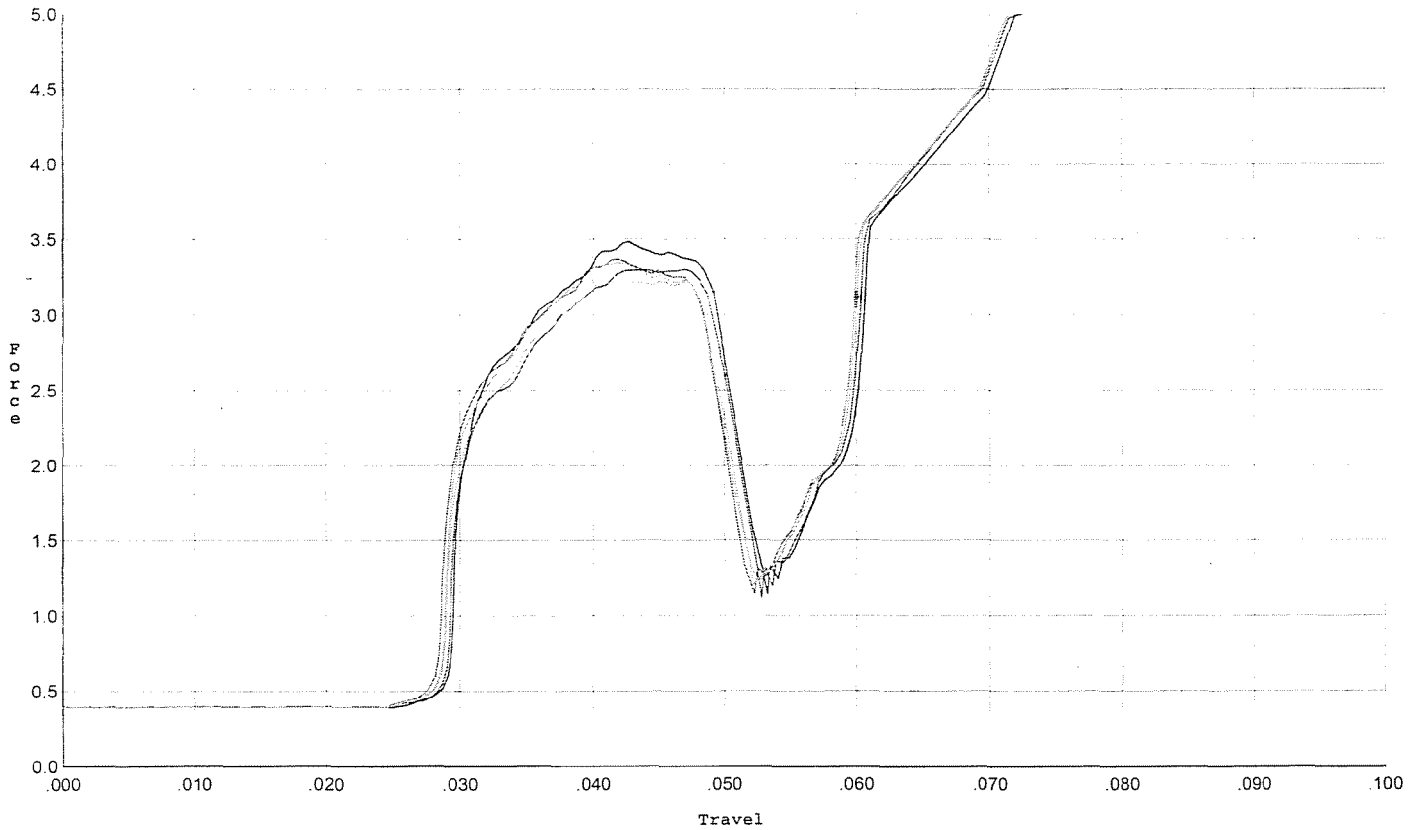
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.198	0.053	0.033	0.030	0.073		Set Trigger
2	3.291	0.053	0.032	0.030	0.073		Set Trigger
3	3.321	0.053	0.032	0.030	0.074		Set Trigger
4	3.270	0.052	0.032	0.031	0.072		Set Trigger
5	3.436	0.053	0.032	0.031	0.076		Set Trigger

A-3-30

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



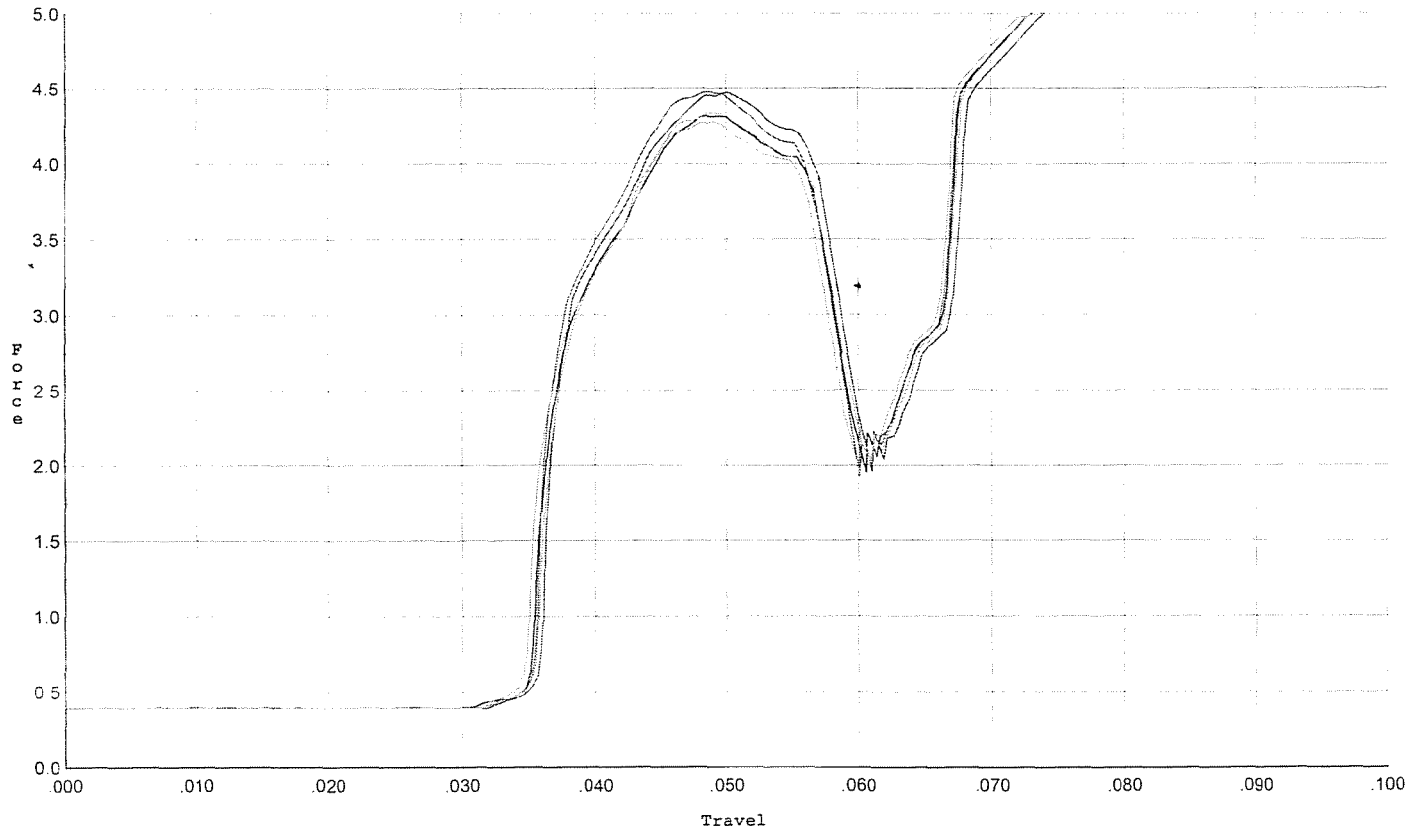
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.297	0.050	0.029	0.029	0.072		Set Trigger
2	3.482	0.049	0.029	0.030	0.074		Set Trigger
3	3.370	0.048	0.028	0.029	0.071		Set Trigger
4	3.250	0.050	0.029	0.029	0.071		Set Trigger
5	3.344	0.048	0.029	0.029	0.070		Set Trigger

A-3.34

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



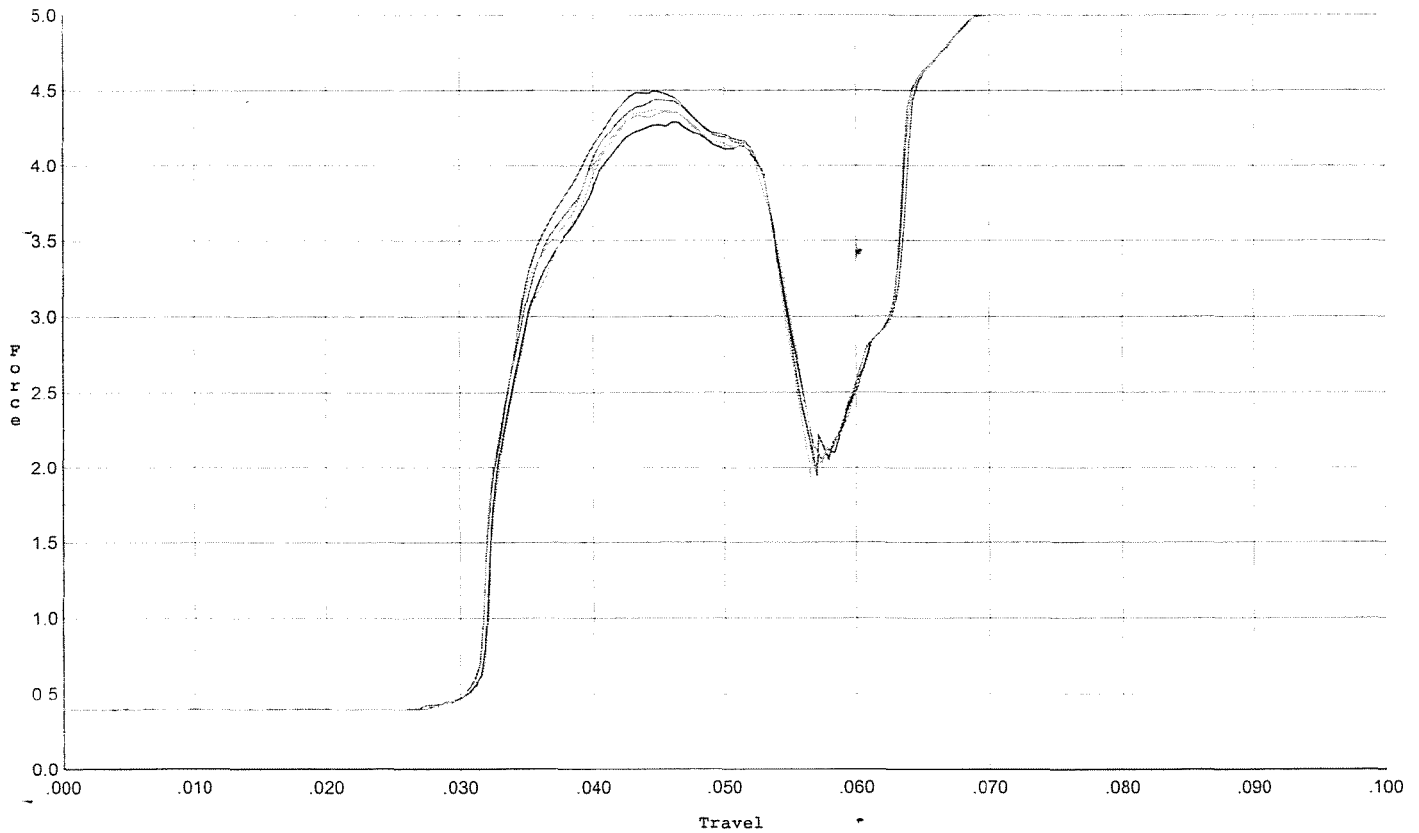
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.472	0.057	0.036	0.029	0.099		Set Trigger
2	4.316	0.057	0.035	0.029	0.096		Set Trigger
3	4.476	0.057	0.035	0.029	0.099		Set Trigger
4	4.337	0.057	0.035	0.029	0.095		Set Trigger
5	4.277	0.056	0.035	0.029	0.095		Set Trigger

A-4-37

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



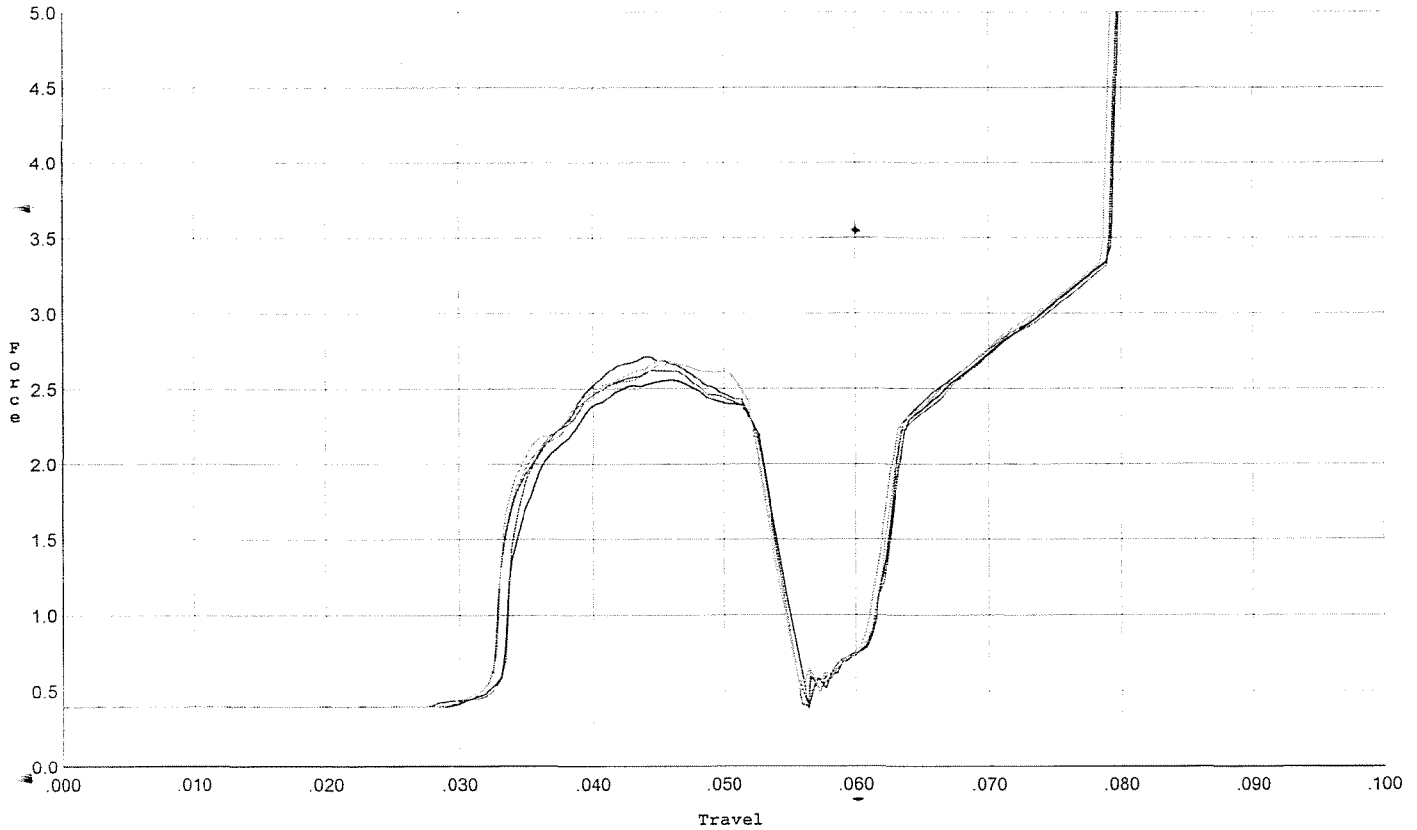
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.496	0.053	0.031	0.029	0.097		Set Trigger
2	4.286	0.053	0.032	0.029	0.094		Set Trigger
3	4.440	0.053	0.031	0.029	0.096		Set Trigger
4	4.354	0.055	0.032	0.028	0.097		Set Trigger
5	4.373	0.053	0.031	0.029	0.096		Set Trigger

A-4.39

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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



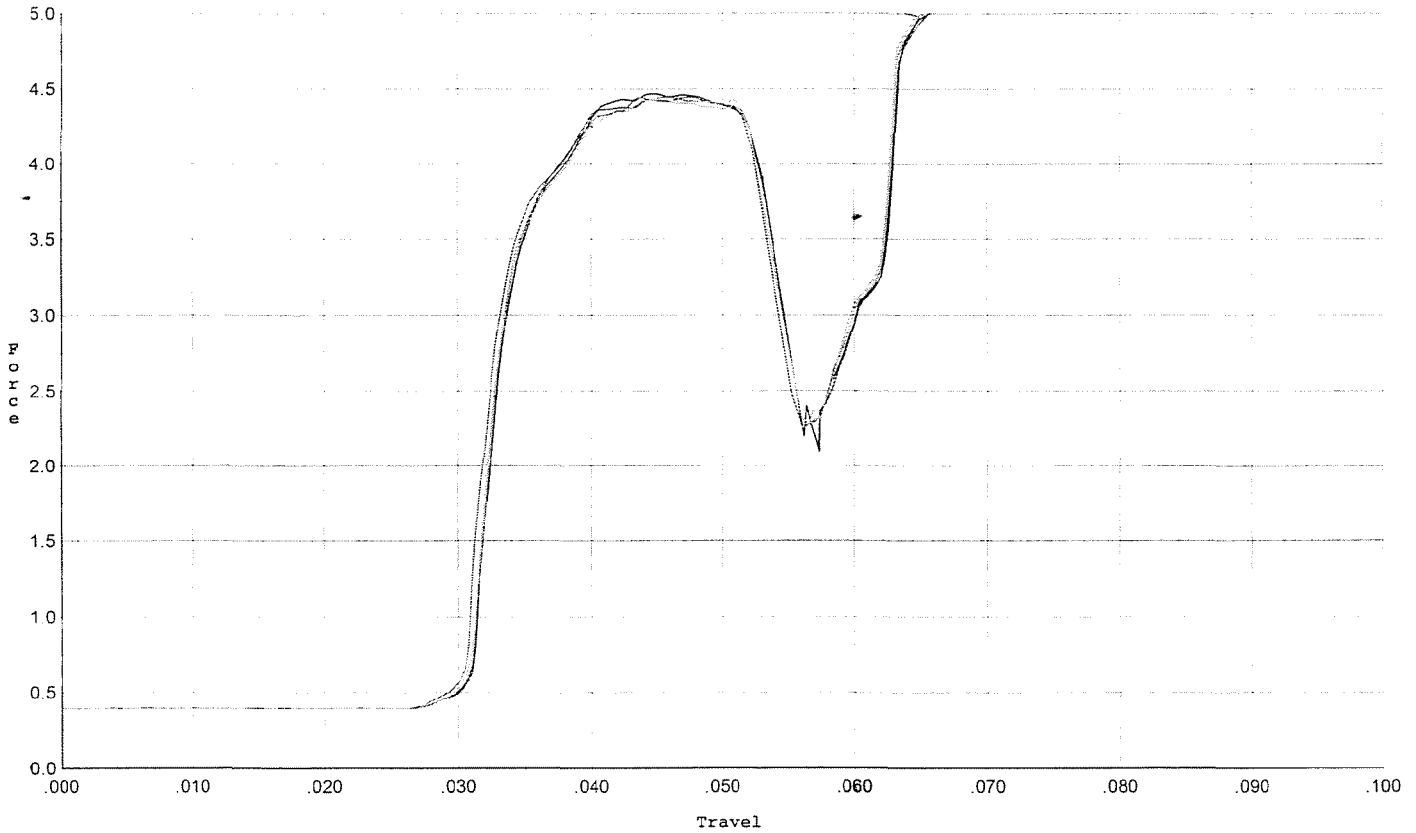
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.713	0.053	0.033	0.033	0.061		Set Trigger
2	2.557	0.053	0.033	0.033	0.058		Set Trigger
3	2.620	0.053	0.033	0.033	0.059		Set Trigger
4	2.688	0.052	0.033	0.033	0.060		Set Trigger
5	2.670	0.053	0.033	0.032	0.062		Set Trigger

A-2-65

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 12/16/2008

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	4.446	0.053	0.031	0.023	0.101		Set Trigger
2	4.466	0.053	0.031	0.023	0.100		Set Trigger
3	4.445	0.052	0.031	0.024	0.099		Set Trigger
4	4.420	0.054	0.031	0.023	0.102		Set Trigger
5	4.426	0.052	0.031	0.024	0.098		Set Trigger

4.44