

BARBER - M24 0075030

56794749

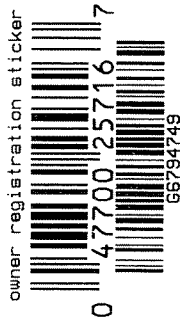
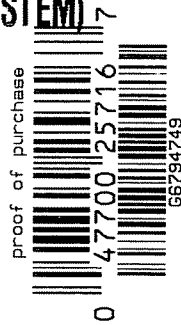
**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

BARBER - M24 ~~0075030~~ M2400075069

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

- INSTRUCTION BOOK 3518

BM FORM

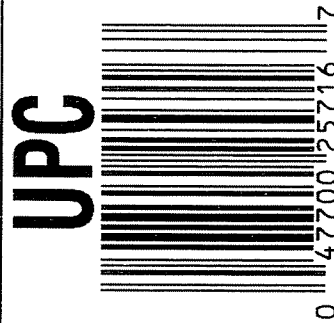


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6794749



GUN SERIAL #

G 6794749

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SPD
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SPD
460	CHECK HEADSPACE		10-7-08	SPD
470	DIS-ASSEMBLE ACTION		10-7-08	SPD
472	SERIALIZE BOLT HANDLE		10-8-08	RSW
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (A)	10/11/08	(A)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-4-08	RSW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

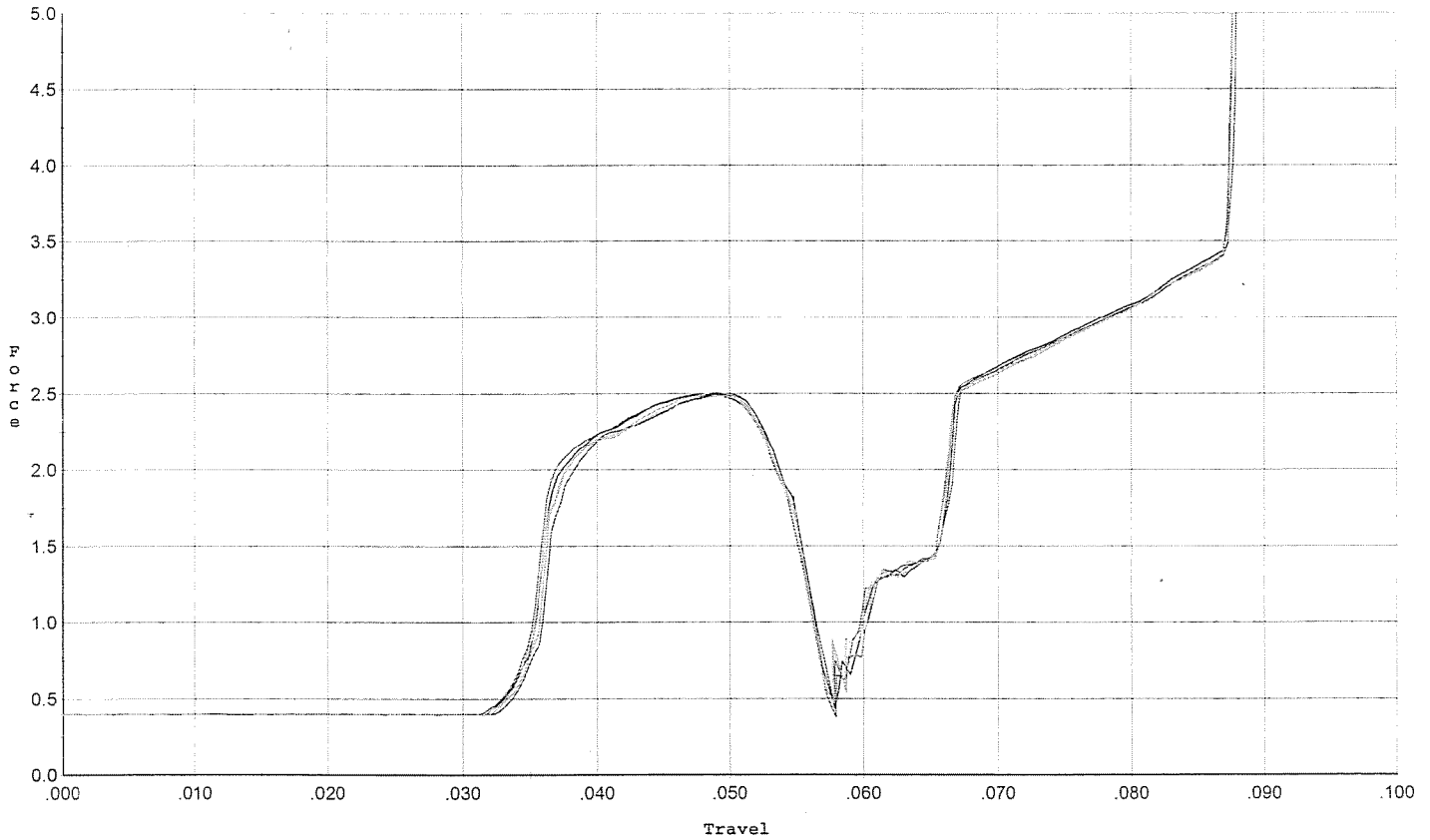
OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	BARBER - M24 0075033 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	11-11-08	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-11-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-11-08	L. J.
	J) ASSEMBLE STOCK		11-11-08	R. J.
	K) ASSEMBLE SWIVEL STUDS		11-11-08	L. J.
	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	11-5-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	R. J.
670	FINAL INSPECTION A) HEADSPACE		11-11-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.38</u> <u>2.39</u> <u>2.40</u> <u>2.42</u>	11-6-08	TC
	C) FUNCTION		11-11-08	L. J.
690	PACK		11/13/08	F. J.

F004 REV 5/2006

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/5/08

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



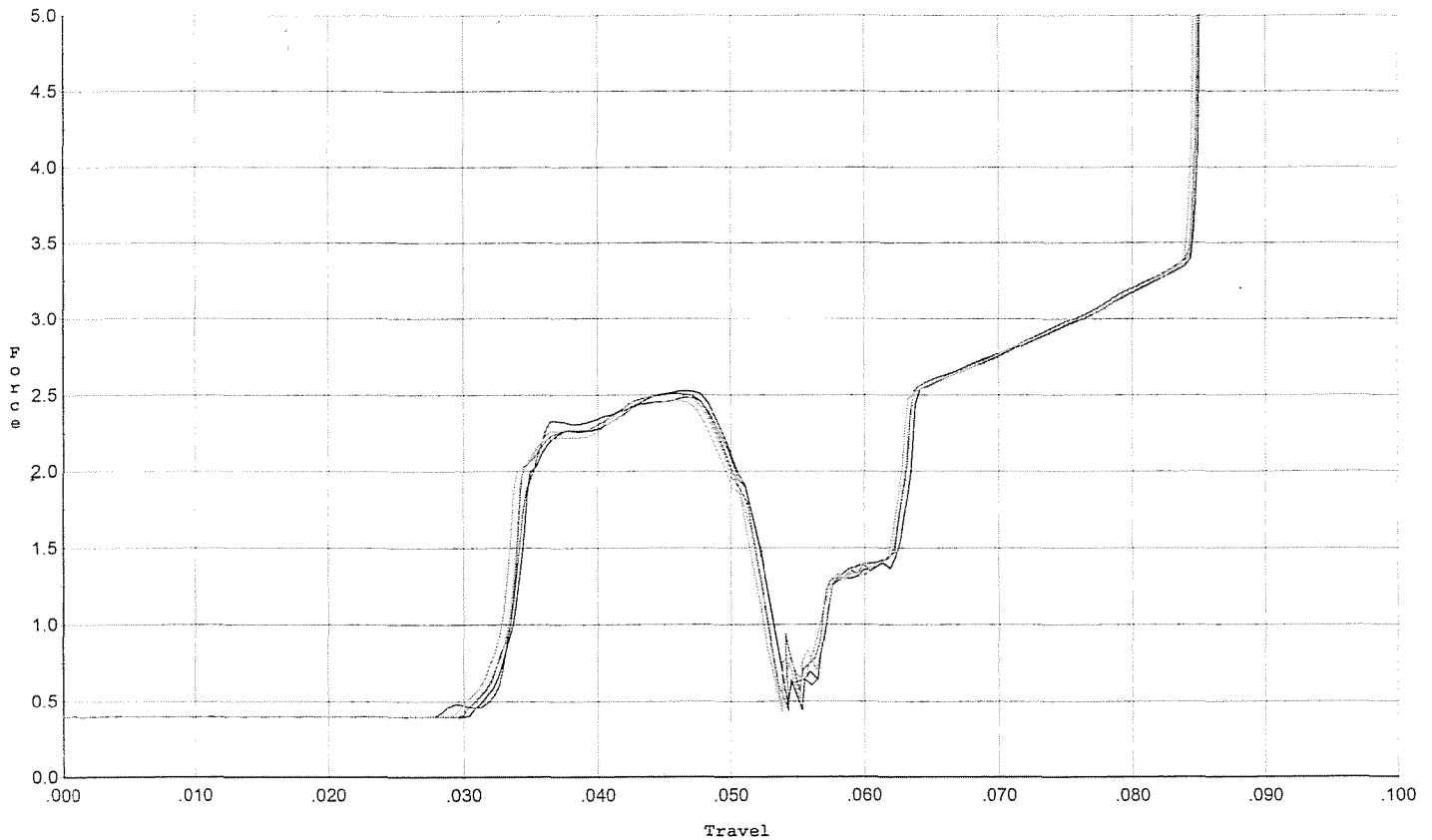
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.493	0.055	0.034	0.037	0.057		Set Trigger
2	2.502	0.055	0.034	0.037	0.058		Set Trigger
3	2.494	0.055	0.034	0.037	0.059		Set Trigger
4	2.507	0.055	0.034	0.037	0.058		Set Trigger
5	2.485	0.055	0.034	0.037	0.057		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/5/08

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



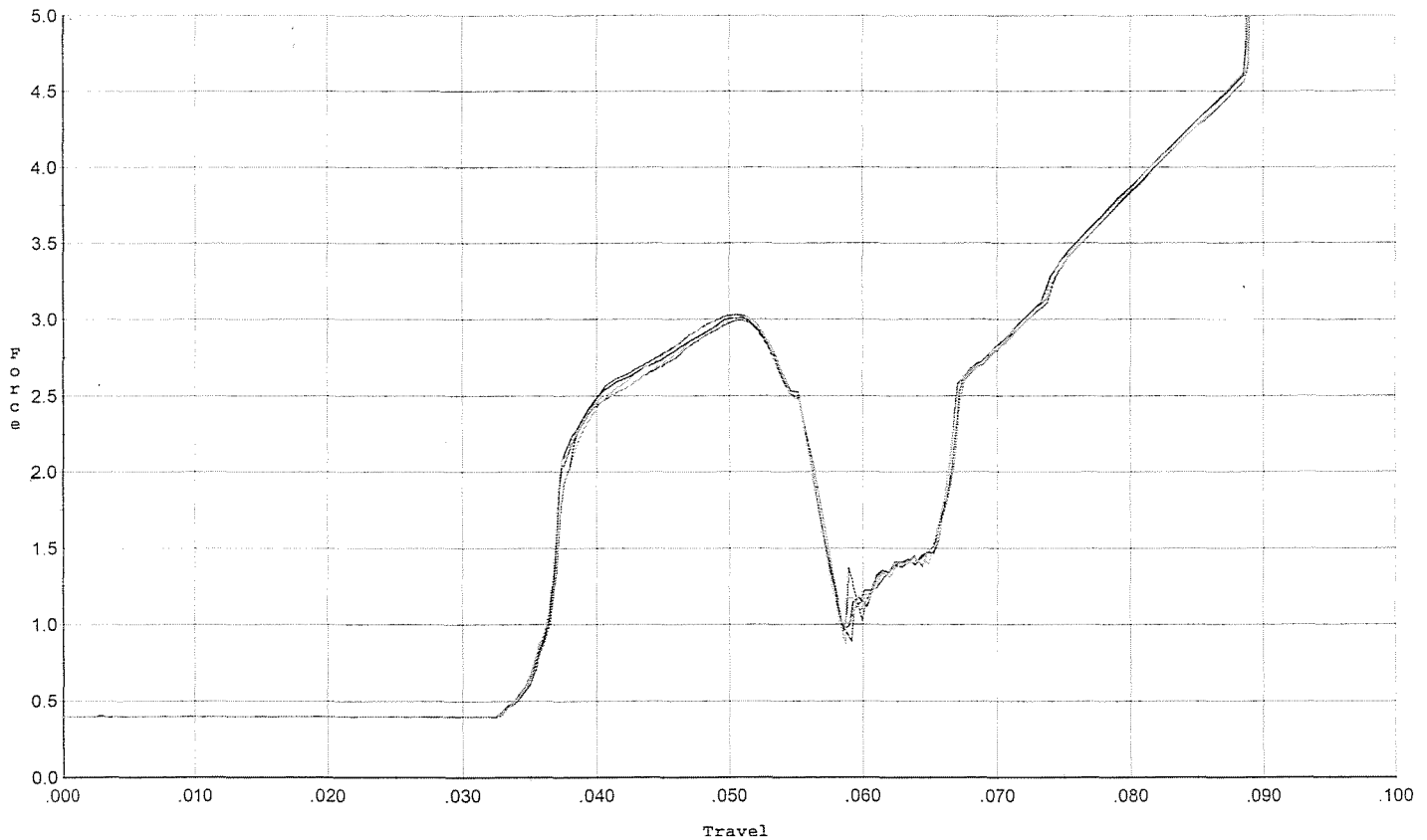
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.484	0.052	0.033	0.036	0.056		Set Trigger
2	2.527	0.052	0.033	0.037	0.055		Set Trigger
3	2.508	0.051	0.032	0.037	0.054		Set Trigger
4	2.466	0.051	0.032	0.037	0.054		Set Trigger
5	2.504	0.052	0.032	0.037	0.055		Set Trigger

Avg 2.49

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 11/5/08

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



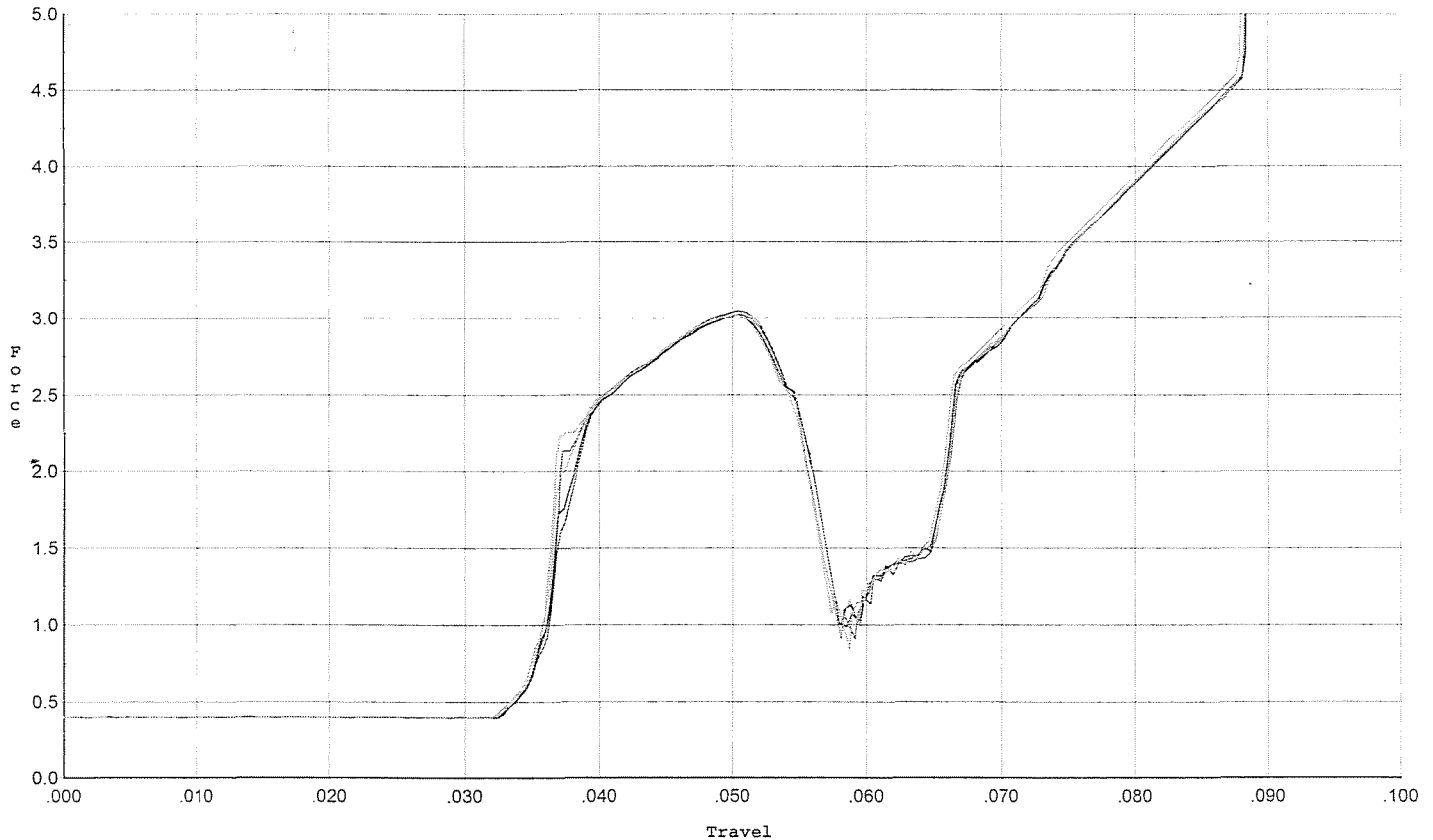
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.031	0.057	0.035	0.037	0.068		Set Trigger
2	3.012	0.055	0.035	0.037	0.066		Set Trigger
3	2.993	0.055	0.035	0.037	0.065		Set Trigger
4	3.019	0.056	0.035	0.037	0.067		Set Trigger
5	3.039	0.055	0.035	0.037	0.066		Set Trigger

Aug 3.01

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/5/08

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



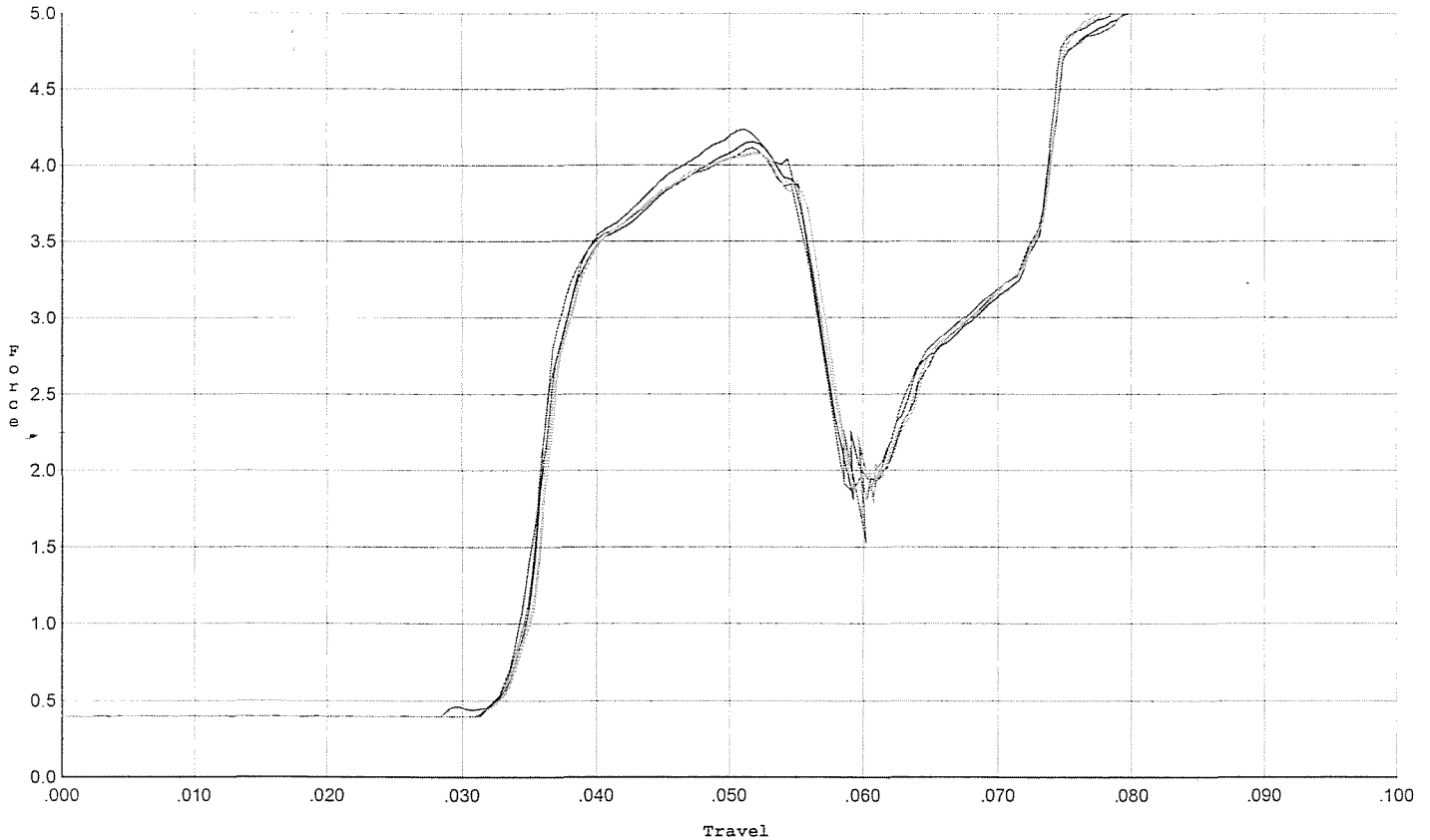
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.026	0.056	0.035	0.037	0.066		Set Trigger
2	3.019	0.055	0.035	0.037	0.064		Set Trigger
3	3.045	0.056	0.035	0.037	0.067		Set Trigger
4	3.026	0.055	0.035	0.036	0.066		Set Trigger
5	3.015	0.055	0.035	0.037	0.065		Set Trigger

Avg 3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/5/08

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



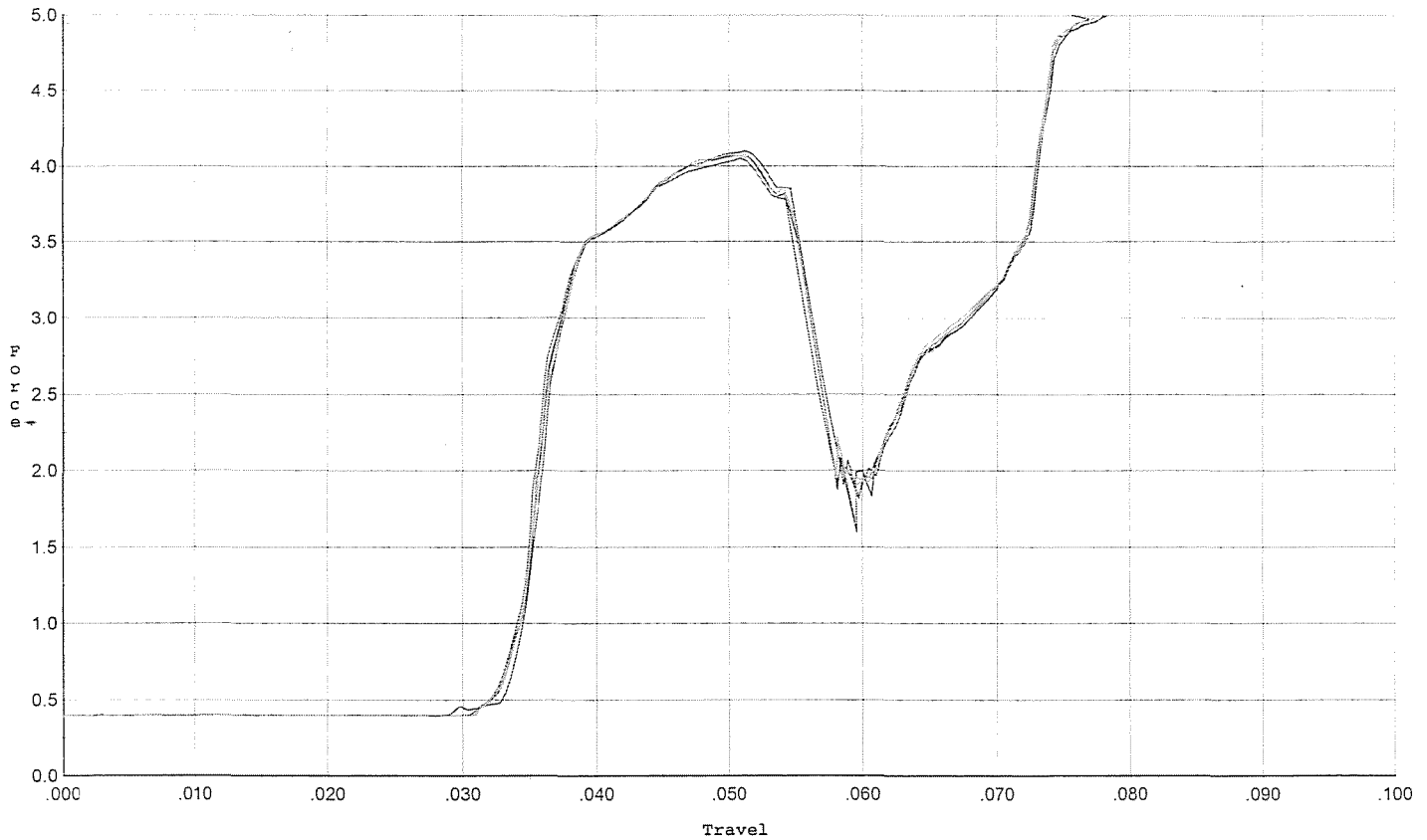
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.235	0.055	0.033	0.035	0.092		Set Trigger
2	4.155	0.055	0.034	0.035	0.090		Set Trigger
3	4.115	0.056	0.033	0.035	0.091		Set Trigger
4	4.076	0.056	0.034	0.035	0.091		Set Trigger
5	4.088	0.055	0.034	0.035	0.089		Set Trigger

Avg 4.13

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/5/08

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



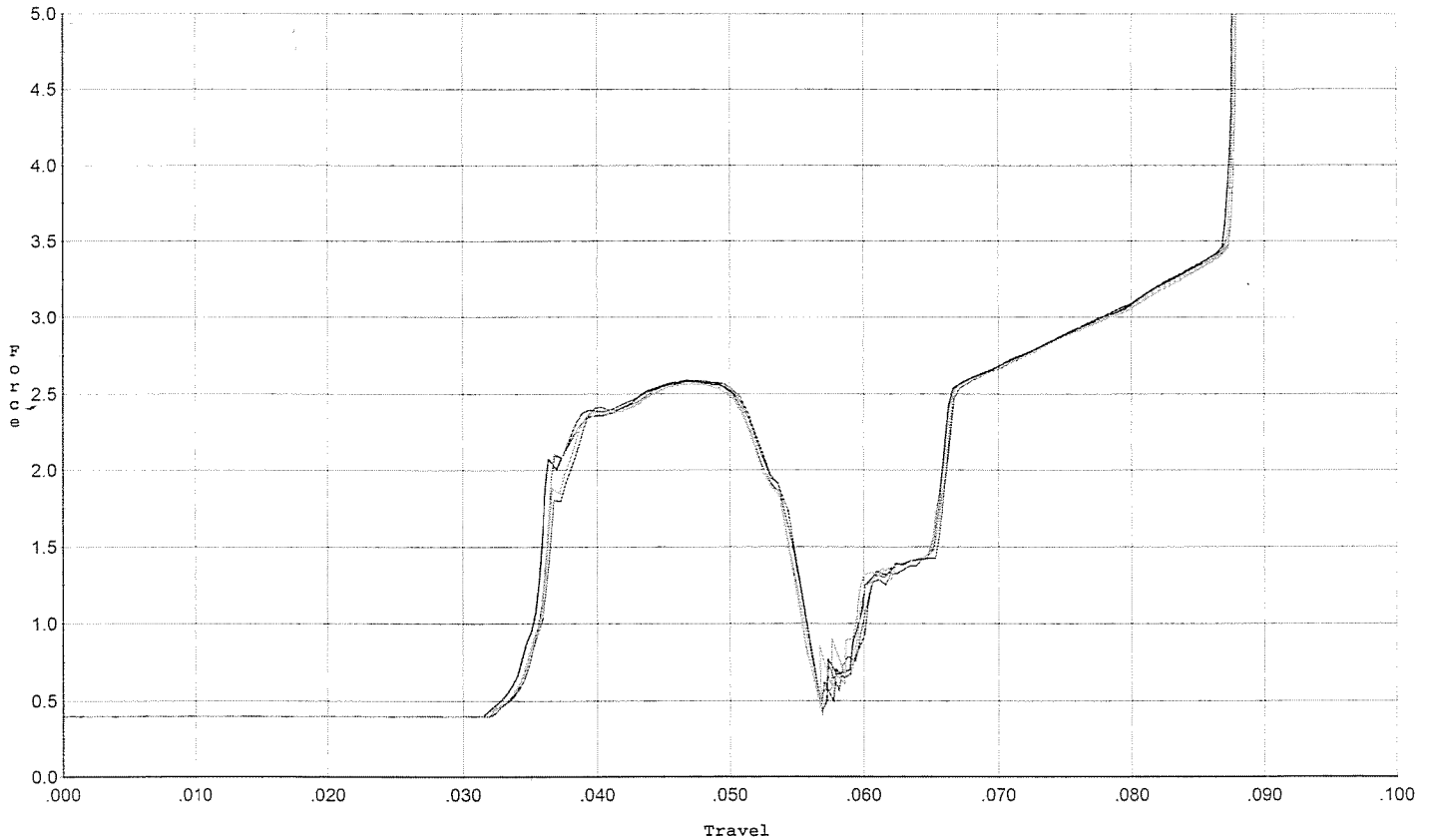
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.101	0.055	0.033	0.035	0.089		Set Trigger
2	4.075	0.055	0.033	0.034	0.090		Set Trigger
3	4.053	0.054	0.033	0.035	0.088		Set Trigger
4	4.076	0.055	0.033	0.034	0.090		Set Trigger
5	4.078	0.055	0.033	0.034	0.089		Set Trigger

Avg 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/5/08

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



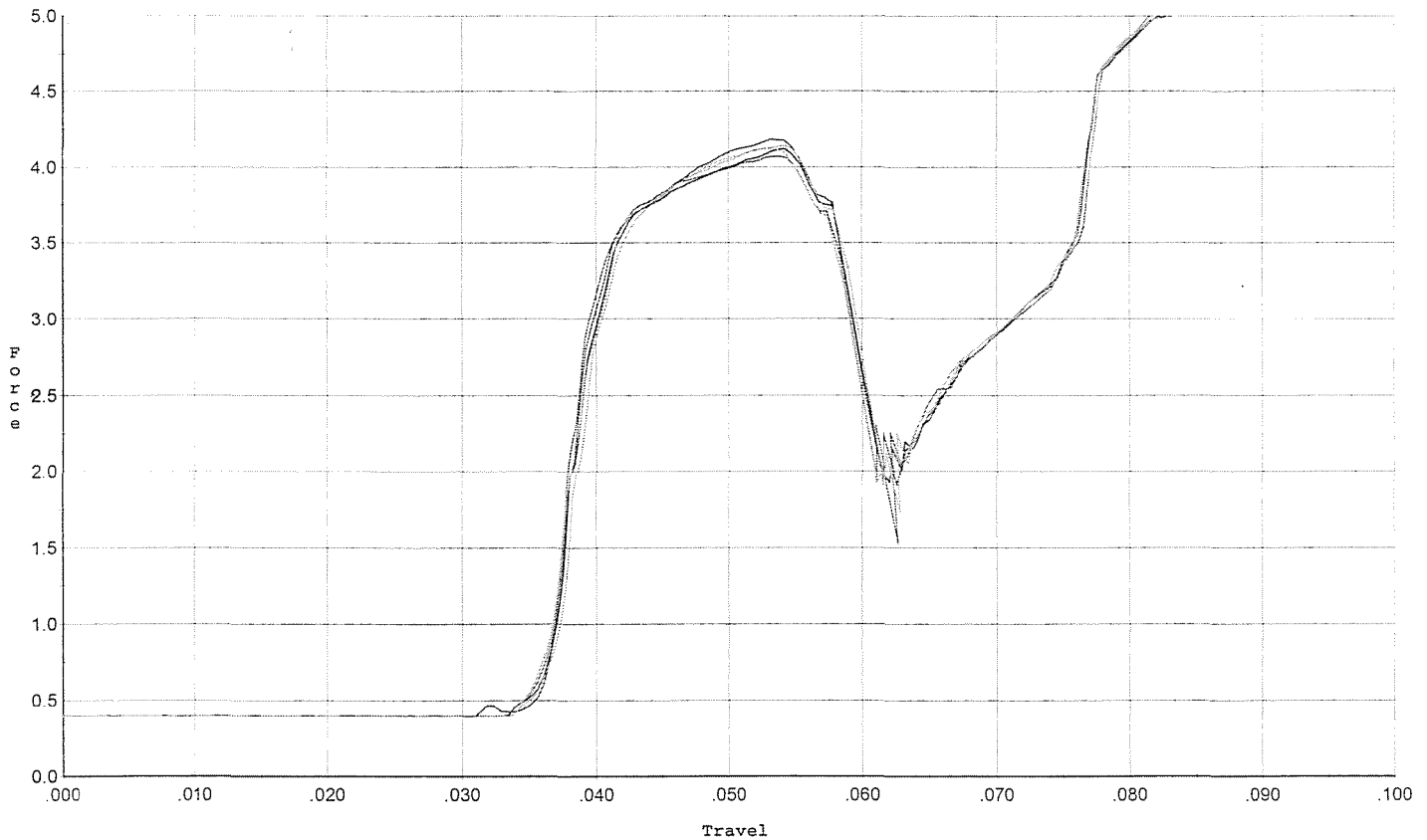
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.577	0.055	0.034	0.037	0.059		Set Trigger
2	2.588	0.054	0.034	0.037	0.058		Set Trigger
3	2.588	0.054	0.035	0.038	0.058		Set Trigger
4	2.565	0.054	0.034	0.038	0.056		Set Trigger
5	2.565	0.054	0.034	0.038	0.057		Set Trigger

Aug 2.57

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 11/5/08

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	4.184	0.058	0.036	0.036	0.094		Set Trigger
2	4.120	0.058	0.036	0.036	0.093		Set Trigger
3	4.072	0.058	0.036	0.036	0.094		Set Trigger
4	4.142	0.059	0.036	0.036	0.095		Set Trigger
5	4.123	0.059	0.035	0.036	0.094		Set Trigger

Avg 4.12