

BARBER - M24 0073354

66794592

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

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase

owner registration sticker



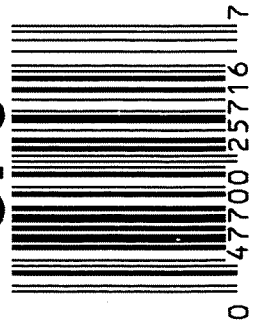
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794592

UPC



GUN SERIAL #

G6794592

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-27-08	SPD
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		10-27-08	SPD
460	CHECK HEADSPACE		10-27-08	SPD
470	DIS-ASSEMBLE ACTION		10-27-08	SPD
472	SERIALIZE BOLT HANDLE		10-28-08	PSN
475	DRILL AND TAP SIGHT HOLES		10-28-08	SP
480	MAGNAFLUX BBL ACTION		10/24/08	KB
490	MAGNAFLUX BOLT		10/27/08	TTZ
500	ROLLMARK CALIBER		10/29/08	KT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		11-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-4-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-4-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-4-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-10-08	SPD
	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 0073357 F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5</u> <u>4</u> <u>4.5</u>	11-17-08	TL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3</u> <u>3</u> <u>3.5</u>	11-17-08	TL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	11-17-08	TL
	J) ASSEMBLE STOCK		11-10-08	R.P.D.
	K) ASSEMBLE SWIVEL STUDS		11-17-08	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	PASS PASS FAIL FAIL	11-11-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-11-08	JS
670	FINAL INSPECTION A) HEADSPACE		11-17-08	TL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.37</u> <u>2.33</u> <u>2.33</u> <u>2.32</u>	11-12-08	TL
	C) FUNCTION		11-17-08	TL
690	PACK		12-1-08	TL

F004 REV 5/2006

BARBER - M24 0073358AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

3.00 LBS (plus or minus 0.75 LBS)

4.00 LBS (plus or minus 1.00 LBS)

DATE 10-31-08TESTER TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	267	250		257	
PULL #2	258	270		266	
PULL #3	255	260		273	
PULL #4	253	262		260	
PULL #5	251	271		262	
TOTAL	1284	1313		1318	
AVERAGE	256	262		263	-

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	347	340		
PULL #2	333	349		
PULL #3	337	340		
PULL #4	334	344		
PULL #5	337	344		
TOTAL	1688	1717		
AVERAGE	337	343		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	444	458		439
PULL #2	444	439		422
PULL #3	442	440		427
PULL #4	451	430		428
PULL #5	459	437		436
TOTAL	2240	2204		2141
AVERAGE	448	437		428