

G6784971

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



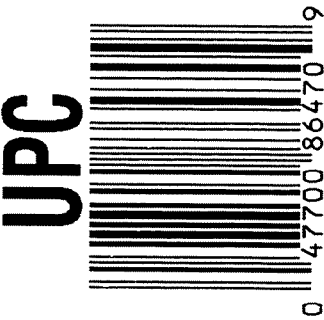
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6784971



GUN SERIAL #

G6784971

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-18-08	SP
430	ASSEMBLE TO STOCK		9-18-08	SP
440	PROOF		9-18-08	SP
460	CHECK HEADSPACE		9-18-08	SP
470	DIS-ASSEMBLE ACTION		9-18-08	SP
472	SERIALIZE BOLT HANDLE		9-19-08	BN
475	DRILL AND TAP SIGHT HOLES		9-19-08	SP
480	MAGNAFLUX BBL ACTION		9-22-08	BN
490	MAGNAFLUX BOLT		9-22-08	BN
500	ROLLMARK CALIBER		9-22-08	RT
520	GOFF BLAST BBL / REC		9-23	~
542	APPLY COATINGS (BARREL ACTION)		9-23	~
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-24-08	P
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-24-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-24-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-17-08	BN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

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OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>40</u> <u>40</u>	12-18-08	R N
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	12-18-08	RP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	12-18-08	R N
	J) ASSEMBLE STOCK		11-17-08	R N
	K) ASSEMBLE SWIVEL STUDS		12-18-08	R 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	12-16-08	R N
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-16-08	RP
670	FINAL INSPECTION A) HEADSPACE		12-18-08	R N
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.68</u> <u>2.64</u> <u>2.72</u> <u>2.74</u>	12-17-08	TC
	C) FUNCTION		12-18-08	R N
690	PACK		1/6/09	Em

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BARBER - M24 0069923
**AVERAGE 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

11-14-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	265	224		271	
PULL #2	267	234		279	
PULL #3	275	229		274	
PULL #4	266	224		281	
PULL #5	285	229		281	
TOTAL	1358	1140		289	
AVERAGE	271	234		1675	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	353	319		
PULL #2	343	325		
PULL #3	341	324		
PULL #4	355	324		
PULL #5	355	314		
TOTAL	1747	1606		
AVERAGE	349	321		

	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	463	440		421
PULL #2	464	436		446
PULL #3	451	436		436
PULL #4	458	437		418
PULL #5	445	438		432
TOTAL	3659	2281	2187	407
AVERAGE	456	437		471