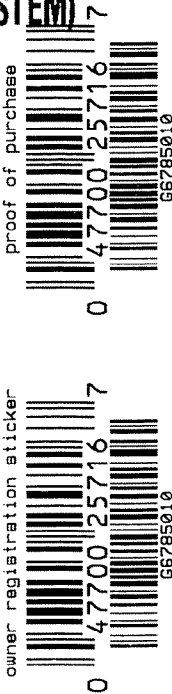


G6785010

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

- INSTRUCTION BOOK 3518

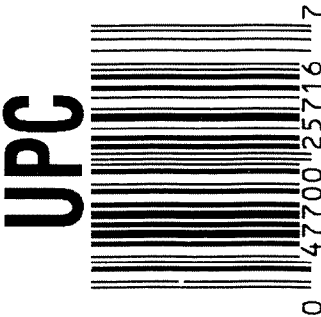
BM FORM



ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6785010



GUN SERIAL # G 6785010

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SP
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SP
460	CHECK HEADSPACE		9-29-08	SP
470	DIS-ASSEMBLE ACTION		9-29-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES	2008	9-30-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (KA)	10/2/08	(KA)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/3/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-3-08	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	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>4.0</u> <u>4.0</u>	11-12-08	L. GP
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>5.0</u>	11-12-08	L. GP
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-12-08	L. GP
	J) ASSEMBLE STOCK		11-3-08	LSW
	K) ASSEMBLE SWIVEL STUDS		11-12-08	L. GP
	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	LSW
670	FINAL INSPECTION A) HEADSPACE		11-12-08	L. GP
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.27</u> <u>2.26</u> <u>2.28</u> <u>2.23</u> <u>2.16</u>	11-5-08	TC
	C) FUNCTION		11-12-08	L. GP
690	PACK		11/13/06	Fm

F004 REV 5/2006

BARBER - M24 0070363AVERAGE 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

10-28-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	276	257		267	
PULL #2	276	278		278	
PULL #3	274	260		279	
PULL #4	266	267		274	
PULL #5	264	256		272	
TOTAL	1356	1319		1370	
AVERAGE	271	263		274	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	361	326		
PULL #2	354	319		
PULL #3	363	319		
PULL #4	372	313		
PULL #5	364	339		
TOTAL	1814	1614		
AVERAGE	362	322		

	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	430	430		429
PULL #2	423	436		424
PULL #3	436	420		422
PULL #4	435	426		432
PULL #5	436	432		415
TOTAL	216	2144		2122
AVERAGE	432	428		424