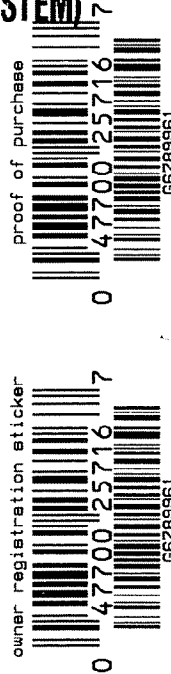


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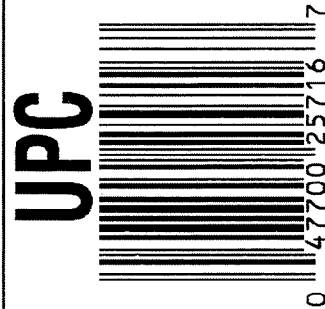
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6789961	



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 678 9961

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	ESN
475	DRILL AND TAP SIGHT HOLES		10-8-08	SP
480	MAGNAFLUX BBL ACTION		10/11/08	HS
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		11-3-08	ESN
	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>	11-12-08	R. P.
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>50</u>	11-12-08	R. P.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11-12-08	R. P.
	J) ASSEMBLE STOCK		11-3-08	RSW
	K) ASSEMBLE SWIVEL STUDS		11-12-08	R. P.
	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	RSW
670	FINAL INSPECTION A) HEADSPACE		11-12-08	R. P.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.14</u> <u>2.10</u> <u>2.14</u> <u>2.10</u> <u>2.09</u>	11-5-08	TC
	C) FUNCTION		11-12-08	R. P.
690	PACK		11/13/08	Em

F004 REV 5/2006

BARBER - M24 0071570

 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

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	268	268		273	
PULL #2	275	275		263	
PULL #3	236	268		255	
PULL #4	253	273		240	
PULL #5	275	266		254	
TOTAL	1307	1350	TAE	2076	1285
AVERAGE	261	270	TAE	415	257

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	341	337		
PULL #2	333	339		
PULL #3	330	308		
PULL #4	331	317		
PULL #5	340	340		
TOTAL	1681	1641		
AVERAGE	336	328		

	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	468	461		415
PULL #2	447	461		418
PULL #3	464	457		418
PULL #4	454	469		420
PULL #5	458	458		412
TOTAL	2288	2306		2083
AVERAGE	457	461		416