

G6794632

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



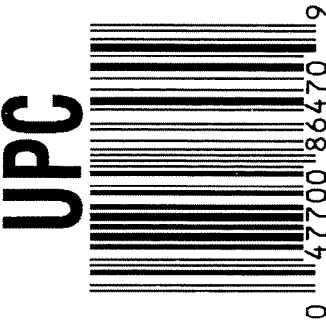
BM FORM

ORDER NO. 86470

BARREL LENGTH 24"

CAPACITY 6

G6794632



BARBER - M24 0073768 M-24 INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 679 4632

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPJ
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPJ
460	CHECK HEADSPACE		9-29-08	SPJ
470	DIS-ASSEMBLE ACTION		9-29-08	SPJ
472	SERIALIZE BOLT HANDLE		9-30-08	RN
475	DRILL AND TAP SIGHT HOLES		10/1/08	FM
480	MAGNAFLUX BBL ACTION		10/7/08	(R)
490	MAGNAFLUX BOLT		10/29/08	SPJ
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/2/08	DS
542	APPLY COATINGS (BARREL ACTION)		10-3	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-3-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-3-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-3-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-13-08	SPJ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

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OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	12-15-08	LJN
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>5.0</u>	12-15-08	LJN
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.025</u>	12-15-08	LJN
	J) ASSEMBLE STOCK		10-13-08	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		12-15-08	L.P.D.
	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	12-11-08	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-11-08	RP
670	FINAL INSPECTION A) HEADSPACE		12-15-08	LJN
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.26</u> <u>2.27</u> <u>2.29</u> <u>2.36</u> <u>2.29</u>	12-15-08	LJN
	C) FUNCTION		12-15-08	LJN
690	PACK		12/19/08	FM

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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

10-10-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	219	268		269	
PULL #2	202	268		253	
PULL #3	251	251		239	
PULL #4	265	238		257	
PULL #5	262	245		253	
TOTAL	1199	1270		1271	
AVERAGE	239	254		254	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	343	348		
PULL #2	338	370		
PULL #3	317	357		
PULL #4	340	368		
PULL #5	356	353		
TOTAL	1694	1796		
AVERAGE	338	359		

	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	404	415		435
PULL #2	425	424		442
PULL #3	409	410		442
PULL #4	443	430		428
PULL #5	447	409		423
TOTAL	2128	2497		2170
AVERAGE	425	499		434

EVALUATION RECORD - M24 TRIGGER ASSEMBLY

F005 REV 5/2006

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