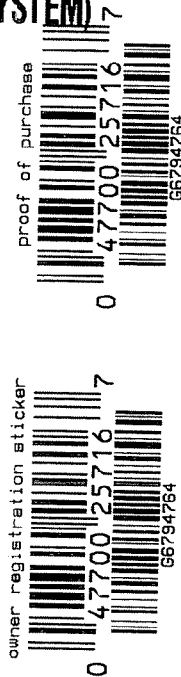


56794764

**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.       | <b>25716</b> |
| BARREL LENGTH   | <b>24"</b>   |
| CAPACITY        | <b>6</b>     |
| <b>G6794764</b> |              |



GUN SERIAL #

G 6794764

| OP # | OPERATION NAME                                                 | READINGS            | DATE     | INITIAL |
|------|----------------------------------------------------------------|---------------------|----------|---------|
| 420  | ASSEMBLE ACTION                                                |                     | 10-7-08  | SP      |
| 430  | ASSEMBLE TO STOCK                                              |                     | 10-7-08  | SP      |
| 440  | PROOF                                                          |                     | 10-7-08  | SP      |
| 460  | CHECK HEADSPACE                                                |                     | 10-7-08  | SP      |
| 470  | DIS-ASSEMBLE ACTION                                            |                     | 10-7-08  | SP      |
| 472  | SERIALIZE BOLT HANDLE                                          |                     | 10-8-08  | Rgn     |
| 475  | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 10-8-08  | SP      |
| 480  | MAGNAFLUX BBL ACTION                                           | OPERATOR (P)        | 10/11/08 | (P)     |
| 490  | MAGNAFLUX BOLT                                                 |                     |          |         |
| 500  | ROLLMARK CALIBER                                               |                     | 10/13/08 | RT      |
| 520  | GOFF BLAST BBL / REC                                           |                     |          |         |
| 542  | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 10-21    |         |
| 545  | (BOLT)                                                         |                     |          |         |
| 560  | RE-ASSEMBLE ACTION                                             |                     |          |         |
|      | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 11-21-08 | SP      |
|      | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 10-21-08 | SP      |
|      | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 10-21-08 | SP      |
|      | D) OIL FIRING PIN ASSEMBLY                                     |                     | 10-27-08 | RT      |
|      | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |          |         |

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| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>4.0</u> <u>4.0</u> <u>4.0</u>                            | 11-5-08  | RJ      |
| CONT.        |                                                                          |                                                             |          |         |
|              | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>4.0</u> <u>4.0</u> <u>5.0</u>                            | 11-5-08  | RJ      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.002</u> <u>.002</u> <u>.002</u>                         | 11-5-08  | RJ      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 10-27-08 | RTZ     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 11-5-08  | RJ      |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             |          |         |
|              | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             |          |         |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             |          |         |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                              | PASS PASS<br>FAIL FAIL                                      | 10-30-08 | REN     |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 10-30-08 | TL      |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 10-5-08  | RJ      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.43</u> <u>2.49</u> <u>2.45</u> <u>2.49</u> <u>2.53</u> | 11-3-08  | TL      |
|              | C) FUNCTION                                                              |                                                             | 11-5-08  | RJ      |
| 690          | PACK                                                                     |                                                             | 11/7/08  | FM      |

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**BARBER - M24 0075195**

 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

10-21-08

TESTER

TAE

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER 50<br>CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |                      | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|----------------------|----------|
| PULL #1 | 233                 | 219                         |                                   | 265                  |          |
| PULL #2 | 245                 | 235                         |                                   | 226                  |          |
| PULL #3 | 221                 | 286                         |                                   | 240                  |          |
| PULL #4 | 224                 | 231                         |                                   | 264                  |          |
| PULL #5 | 214                 | 232                         |                                   | 226                  |          |
| TOTAL   | 1137                | 1203                        |                                   | 1982                 |          |
| AVERAGE | 227                 | 240                         |                                   | <del>396</del> 396.4 |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER 20<br>CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 320                 | 318                         |  |          |
| PULL #2 | 351                 | 314                         |  |          |
| PULL #3 | 361                 | 306                         |  |          |
| PULL #4 | 360                 | 308                         |  |          |
| PULL #5 | 353                 | 333                         |  |          |
| TOTAL   | 1745                | 1579                        |  |          |
| AVERAGE | 349                 | 315                         |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER 20<br>CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 440                 | 462                         |                                   | 425                                     |
| PULL #2 | 425                 | 451                         |                                   | 423                                     |
| PULL #3 | 418                 | 431                         |                                   | 432                                     |
| PULL #4 | 425                 | 454                         |                                   | 426                                     |
| PULL #5 | 430                 | 460                         |                                   | 435                                     |
| TOTAL   | 2138                | 2264                        |                                   | 2141                                    |
| AVERAGE | <del>428</del>      | 452                         |                                   | 428                                     |