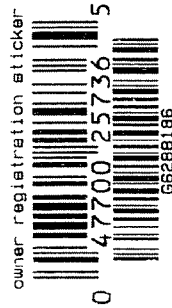


G 6288186

M/24 .300 WIN MAG (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL .300 WIN MAG

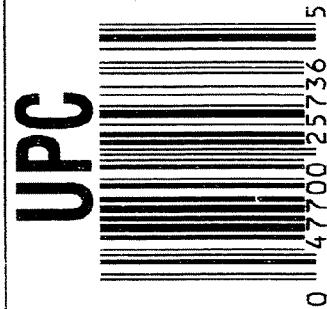
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25736
BARREL LENGTH	24"
CAPACITY	5

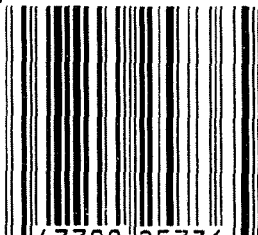
G6288186



ORDER— 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC

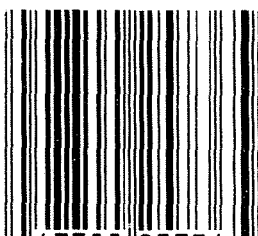


0 47700 25736 5

ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



0 47700 25736 5

SERIAL NO.



66288186

10/26/2004 8:17:26 AM
Reprint
Crib
1
G-28-18C

25736
M/24 300 WIN MAG (RIFLE ONLY)
MA25736
Shop Order: SWS58802
ABSWS58802
Start Date: 10/13/2004
Finish Date: 10/29/2004

0540 01PC001
Flat Black Powder Coat, Barrel and
0003512627
0560 89SWS1
Reassemble Action.
0003512628
0690 89SWS1
Pack Rifle
0003512638
0700 89SWS1
Stencil SWS Container
OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G628 8186

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-1-04	RTL
600	PROOF		11-1-04	TRW
607	CHECK HEADSPACE	MAGNA-FLUX	11-4-04	RTL
610	DIS-ASSEMBLE GUN	INSPECTED	11-4-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 13 2004 OPERATOR <i>[Signature]</i>		
615	ROLLMARK CALIBER		11-4-04	RTL
617	DRILL AND TAP SIGHT HOLES		11-4-04	TRW
620	APPLY COATINGS (BARREL ACTION)		11/9	HQ
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-10-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-10-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-10-04	RTL
	D) OIL FIRING PIN ASSEMBLY		11-10-04	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	BARBER M24 M157839	READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	1-0	6-0	6-0	12-1-04	RL
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	2-0	2-25	2-0	12-1-04	RL
	H) TRIGGER PULL TEST AND RETAINABILITY					12-1-04	RL
	I) FIRING PIN INDENT	.020 MIN				12-1-04	RL
	J) ASSEMBLE STOCK					11-10-04	RTL
	K) ASSEMBLE SWIVEL STUDS					12-1-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S						
	M) IRON SIGHT ALIGNMENT						
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER						
640	GALLERY TEST AND TARGET		PASS	FAIL		11-30-04	AK
	MALFUNCTION		CORRECTION			11-30-04	AK
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION				
645	INSPECT FOR LIVE AMMO					11-30-04	AK
655	FINAL INSPECTION A) HEADSPACE					12-1-04	RTL
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	257	254	242 2.42 2.42	12-1-04	RL
	C) FUNCTION					12-1-04	RTL
660	PACK					12/1/04	RA

AVERAGE PULL FORCE BETWEEN
 INITIAL RESET
BARBER - M24 0157840
 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)

SERIAL NO.

DATE

11-9-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.23	2.29		2.03	
PULL #2	2.02	2.45		2.24	
PULL #3	2.19	2.67		2.11	
PULL #4	2.33	2.82		2.29	
PULL #5	2.08	2.94		2.27	
TOTAL	10.85	13.17		10.94	
AVERAGE	2.17	2.63		2.18	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.01		
PULL #2	3.37	3.01		
PULL #3	3.47	3.07		
PULL #4	3.46	2.95		
PULL #5	3.10	2.96		
TOTAL	16.74	15.00		
AVERAGE	3.34	3.00		

	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	4.46	4.37		3.95
PULL #2	4.44	4.28		4.03
PULL #3	4.42	4.36		3.99
PULL #4	4.55	4.26		4.04
PULL #5	4.55	4.14		4.05
TOTAL	22.42	21.41		20.06
AVERAGE	4.48	4.28		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6288186.___0
FILE DATE AND TIME: 11/30/2004 11:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.165
The Average Y Centroid of the Five Target Set:	-0.057
The Average Point of Impact of the Five Target Set:	0.174
The Average Mean Radius of the Five Target Set:	1.015
The Distance from POA to Centroid Target #1:	0.431
The Distance from Centroid Target #2 to Centroid Target #1:	0.479
The Distance from Centroid Target #3 to Centroid Target #1:	0.117
The Distance from Centroid Target #4 to Centroid Target #1:	0.626
The Distance from Centroid Target #5 to Centroid Target #1:	0.926

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 1

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	0.293	0.643
2:	-0.007	0.321
3:	-0.545	0.330
4:	-0.341	-0.048
5:	-1.189	-0.371
6:	0.064	-0.598
7:	-0.211	-0.845
8:	0.547	-0.383
9:	0.896	-0.983
10:	-0.038	-2.344

X CENTROID: -0.053

Y CENTROID: -0.428

POA TO CENTROID: 0.431

HORZ SPREAD: 2.085

VERT SPREAD: 2.987

GROUP SPREAD: 3.005

MIN RADIUS: 0.207

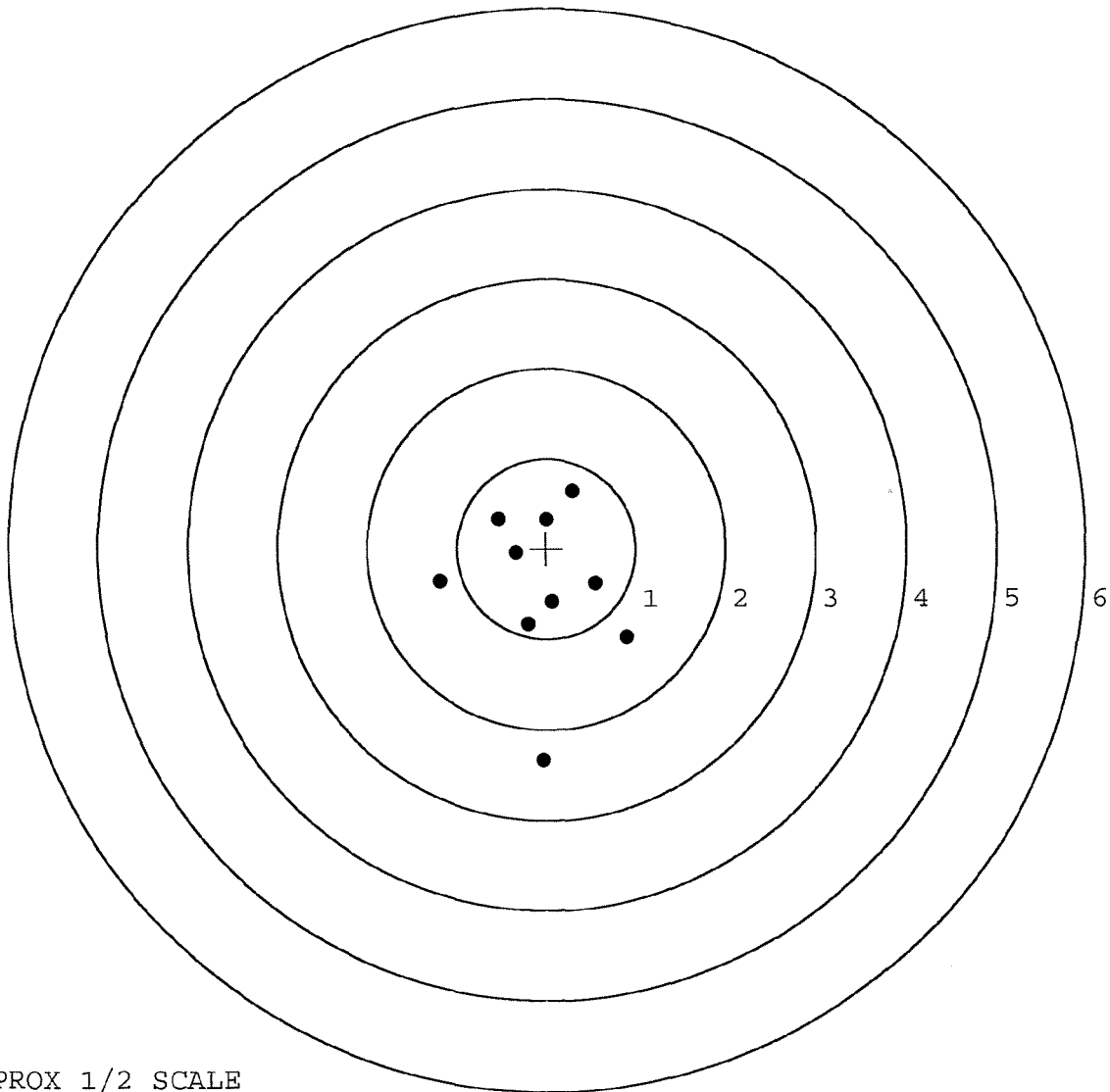
MAX RADIUS: 1.916

MEAN RADIUS: 0.866

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 2

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	0.430	1.506
2:	-0.335	1.151
3:	-0.390	0.607
4:	-1.253	-0.461
5:	-0.392	-0.289
6:	-0.807	-0.799
7:	-0.333	-1.274
8:	0.425	-0.177
9:	0.658	-0.043
10:	0.672	0.229

X CENTROID: -0.133

Y CENTROID: 0.045

POA TO CENTROID: 0.140

HORZ SPREAD: 1.925

VERT SPREAD: 2.780

GROUP SPREAD: 2.883

MIN RADIUS: 0.423

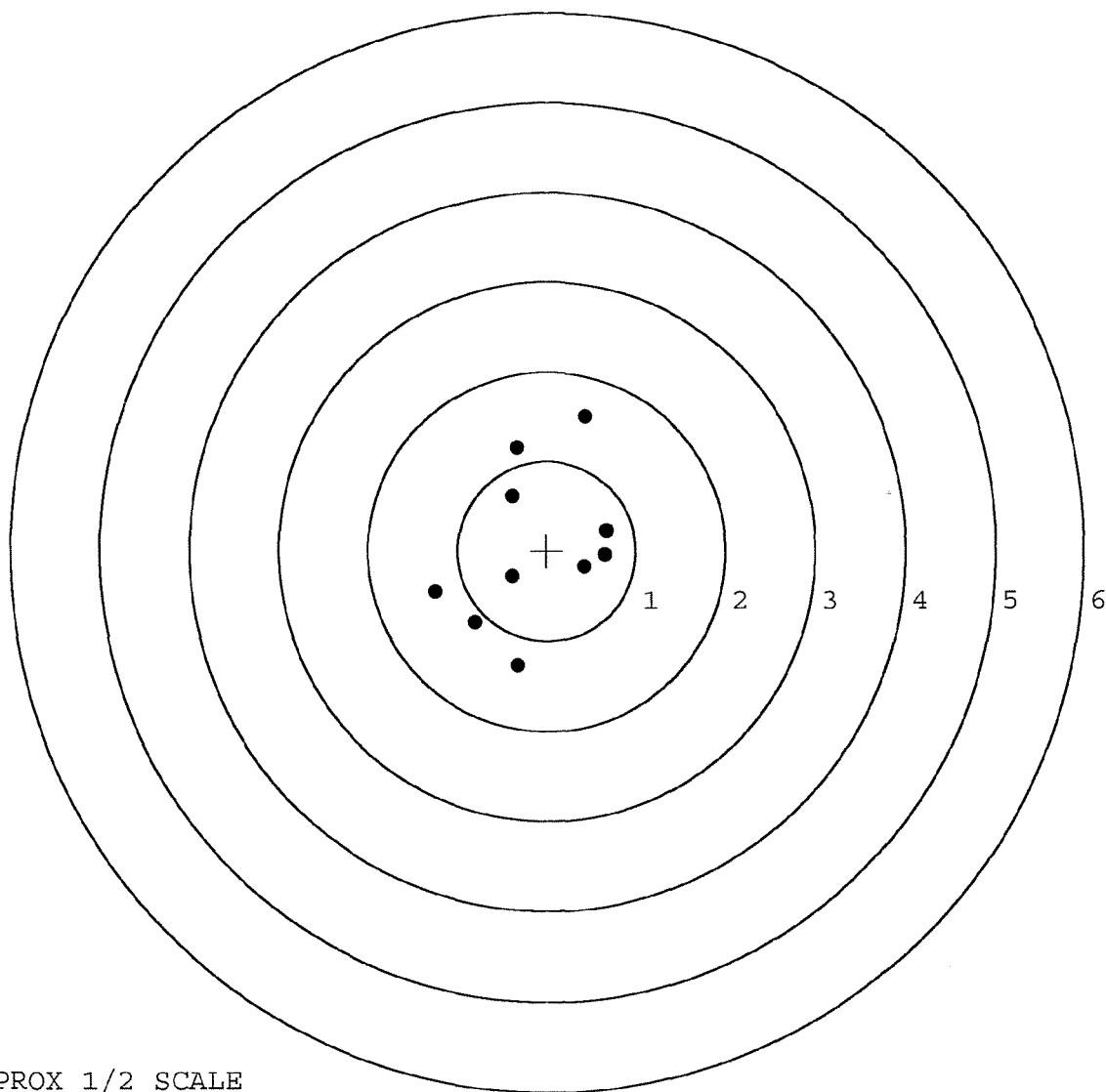
MAX RADIUS: 1.566

MEAN RADIUS: 0.960

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 3

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	0.358	0.281
2:	-0.785	-0.003
3:	-0.417	0.075
4:	-0.197	-0.148
5:	-0.054	-0.445
6:	-1.563	-0.953
7:	0.379	-1.283
8:	0.230	-1.840
9:	1.372	-0.556
10:	-0.292	-0.487

X CENTROID: -0.097

Y CENTROID: -0.536

POA TO CENTROID: 0.545

HORZ SPREAD: 2.935

VERT SPREAD: 2.121

GROUP SPREAD: 2.962

MIN RADIUS: 0.101

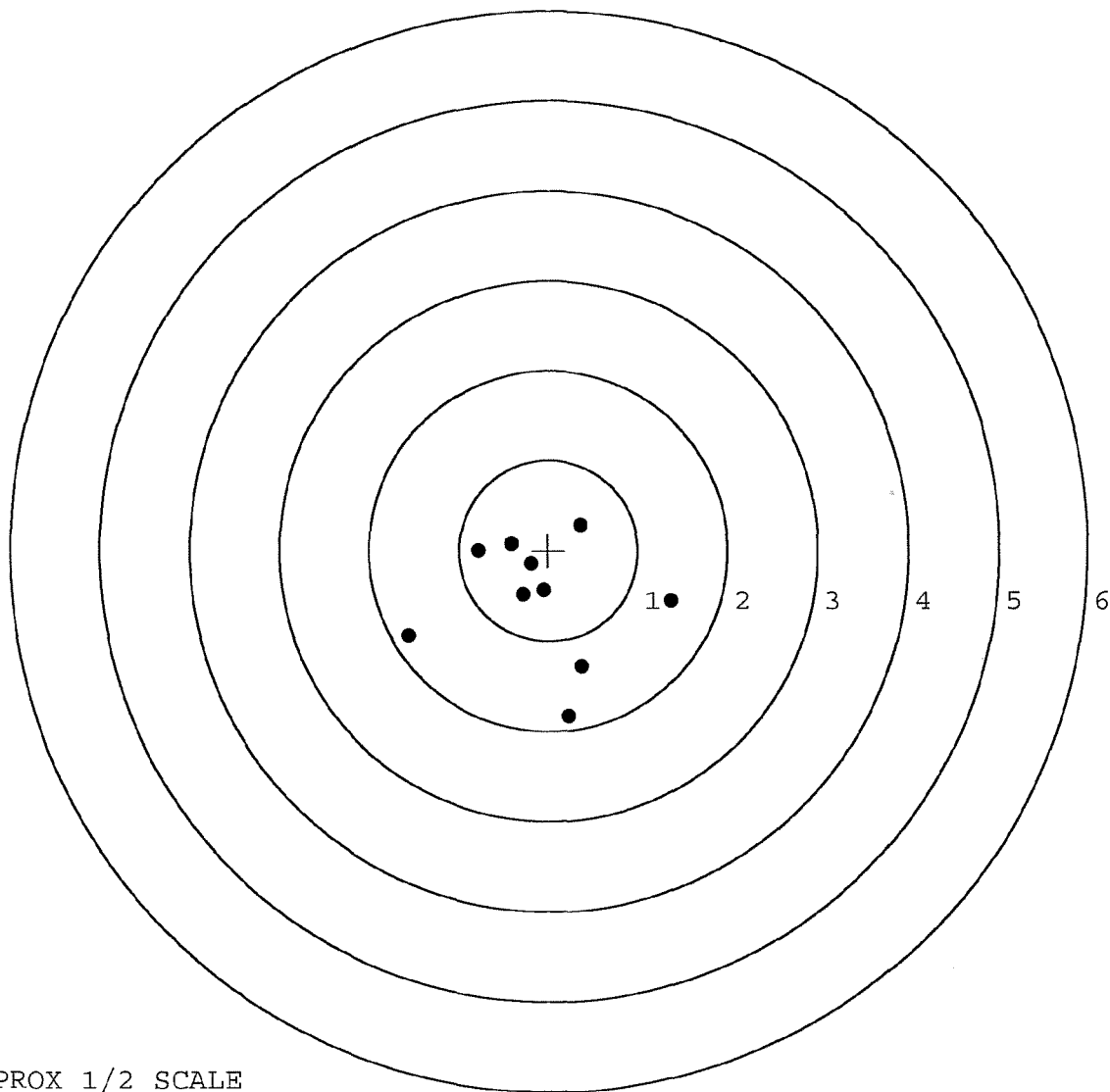
MAX RADIUS: 1.524

MEAN RADIUS: 0.842

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 4

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	1.340	-0.029
2:	0.153	2.419
3:	-1.534	1.793
4:	-0.859	0.725
5:	-0.307	-0.047
6:	0.278	-0.447
7:	0.044	-0.412
8:	-0.276	-0.469
9:	-1.465	-1.572
10:	-0.150	-0.392

X CENTROID: -0.278

Y CENTROID: 0.157

POA TO CENTROID: 0.319

HORZ SPREAD: 2.874

VERT SPREAD: 3.991

GROUP SPREAD: 4.307

MIN RADIUS: 0.206

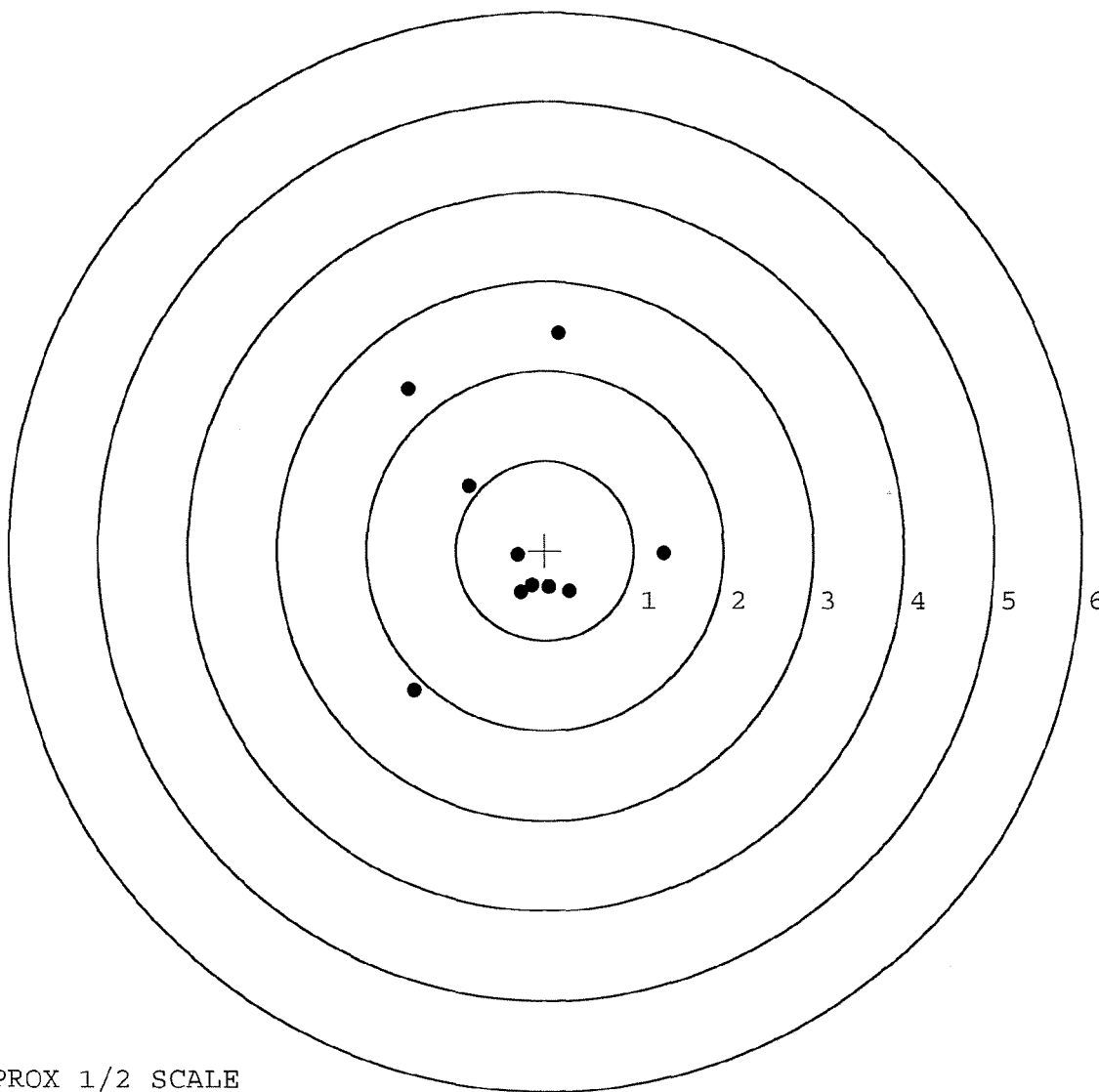
MAX RADIUS: 2.303

MEAN RADIUS: 1.177

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

BARBER - M24 0157846

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 5

FILE DATE: 11/30/2004

FILE TIME: 11:03

X CENTROID: -0.262

Y CENTROID: 0.474

POA TO CENTROID: 0.542

HORZ SPREAD: 1.294

VERT SPREAD: 3.584

GROUP SPREAD: 3.635

MIN RADIUS: 0.349

MAX RADIUS: 1.908

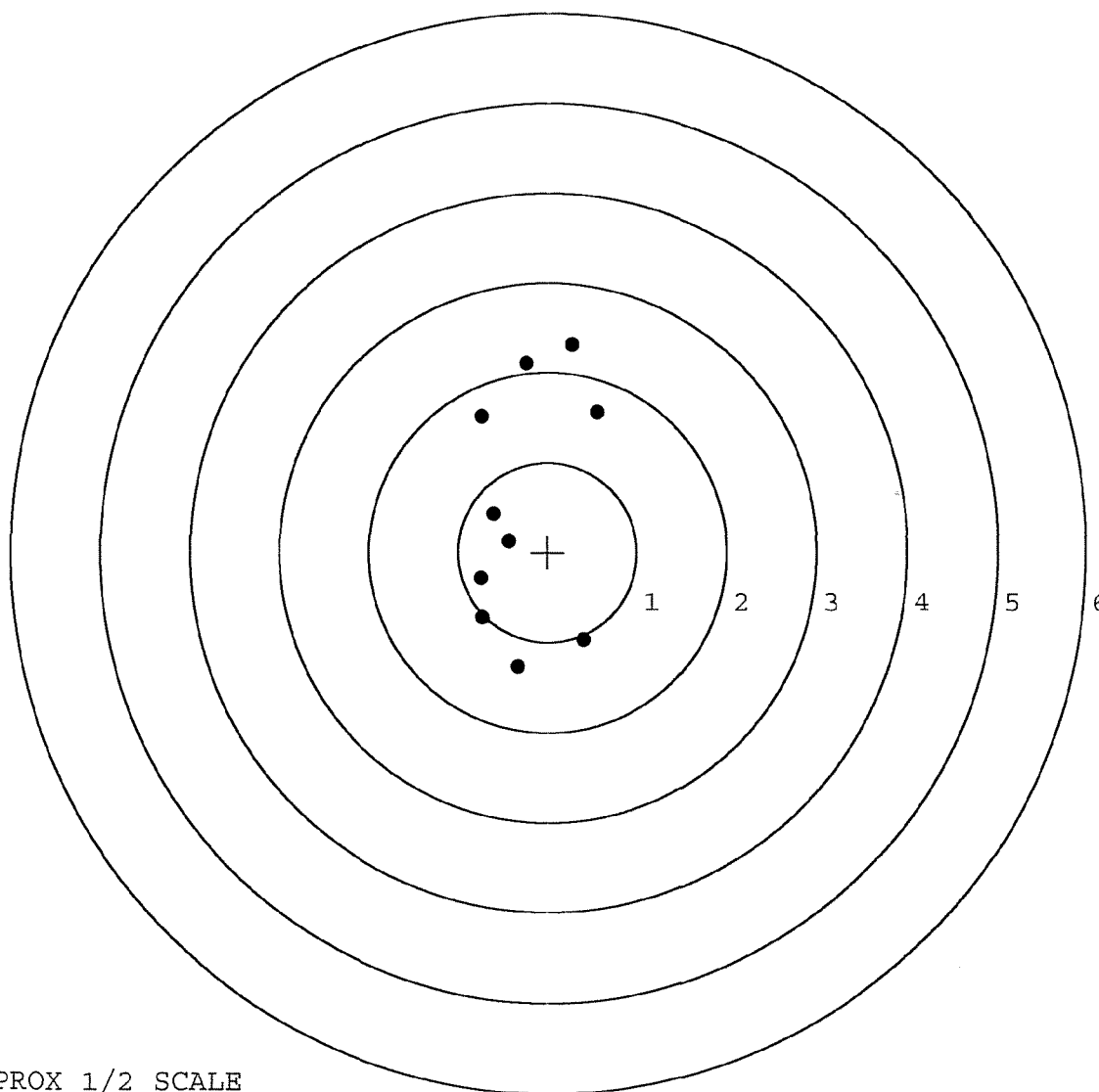
MEAN RADIUS: 1.231

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.609	0.430
2:	-0.437	0.122
3:	-0.743	-0.295
4:	-0.730	-0.727
5:	-0.334	-1.278
6:	0.405	-0.974
7:	0.273	2.306
8:	-0.253	2.094
9:	-0.745	1.512
10:	0.549	1.555



TARGET APPROX 1/2 SCALE