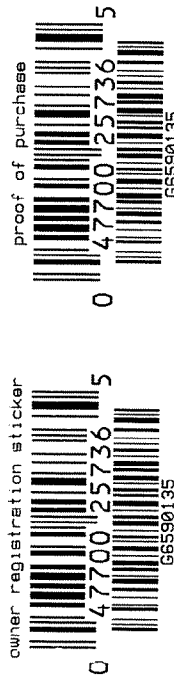


G 659 0135 W: N

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

- INSTRUCTION BOOK 3518

DD FORM 200348

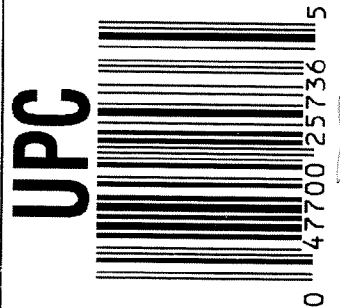


ORDER NO. **25736**

BARREL LENGTH **24"**

CAPACITY **5**

G6590135



ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



SERIAL NO.



300 WIN.

GUN SERIAL #

G6590135

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		4-19-07	RT
420	ASSEMBLE ACTION		4-19-07	RT
430	ASSEMBLE TO STOCK		4-19-07	TRW
440	PROOF	MAGNA-FLUX	4-19-07	TRW
460	CHECK HEADSPACE	APR 24 2007	4-20-07	RT
470	DIS-ASSEMBLE ACTION		4-28-07	RT
480	MAGNAFLUX BBL ACTION	OPERATOR <i>W mg</i>	4/24/07	<i>W mg</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER			
510	DRILL AND TAP SIGHT HOLES		4-24-07	TRW
520	GOFF BLAST BBL / REC		5-10-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5-12-07	WJ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-07	<i>SPD</i>
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-07	<i>SPD</i>
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-07	<i>SPD</i>
	D) OIL FIRING PIN ASSEMBLY		5-21-07	<i>SPD</i>
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	5/22/07	<i>W mg</i>

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.5</u> <u>7.75</u> <u>7.5</u>	5-22-07	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.25</u> <u>2.25</u>	5-22-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		5/22/07	TRW
	I) FIRING PIN INDENT .020 MIN	<u>.020</u> <u>.020</u> <u>.0205</u>	5-22-07	TRW
	J) ASSEMBLE STOCK		5-21-07	RA
	K) ASSEMBLE SWIVEL STUDS		5-23-07	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	N/A		
	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	5-22-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-22-07	Fm
670	FINAL INSPECTION A) HEADSPACE		5-23-07	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.58</u> <u>2.85</u> <u>2.62</u> <u>2.56</u>	5-22-07	TRW
	C) FUNCTION		5-23-07	RTZ
690	PACK		5-23-07	RA

F004 REV 5/2006

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 5-18-07TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.68		2.81	
PULL #2	2.64	2.57		2.66	
PULL #3	2.48	2.63		2.65	
PULL #4	2.43	2.67		2.64	
PULL #5	2.47	2.51		2.62	
TOTAL	12.50	13.06		13.38	
AVERAGE	2.50	2.61		2.67	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.32		
PULL #2	3.36	3.45		
PULL #3	3.42	3.29		
PULL #4	3.48	3.21		
PULL #5	3.44	3.28		
TOTAL	16.97	16.55		
AVERAGE	3.39	3.31		

	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	4.33	4.43		4.22
PULL #2	4.35	4.16		4.30
PULL #3	4.28	4.41		4.38
PULL #4	4.28	4.32		4.38
PULL #5	4.41	4.36		4.29
TOTAL	21.65	21.68		21.57
AVERAGE	4.33	4.33		4.31

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590135.__0
FILE DATE AND TIME: 05/22/2007 10:26

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.207
The Average Y Centroid of the Five Target Set:	-0.083
The Average Point of Impact of the Five Target Set:	0.224
The Average Mean Radius of the Five Target Set:	0.989
The Distance from POA to Centroid Target #1:	0.355
The Distance from Centroid Target #2 to Centroid Target #1:	0.271
The Distance from Centroid Target #3 to Centroid Target #1:	0.242
The Distance from Centroid Target #4 to Centroid Target #1:	0.142
The Distance from Centroid Target #5 to Centroid Target #1:	0.333

SERIAL NUMBER: G6590135. 0

TARGET NUMBER: 1

FILE DATE: 05/22/2007

FILE TIME: 10:26

X CENTROID: -0.293

Y CENTROID: -0.201

POA TO CENTROID: 0.355

HORZ SPREAD: 2.790

VERT SPREAD: 4.112

GROUP SPREAD: 4.470

MIN RADIUS: 0.312

MAX RADIUS: 2.695

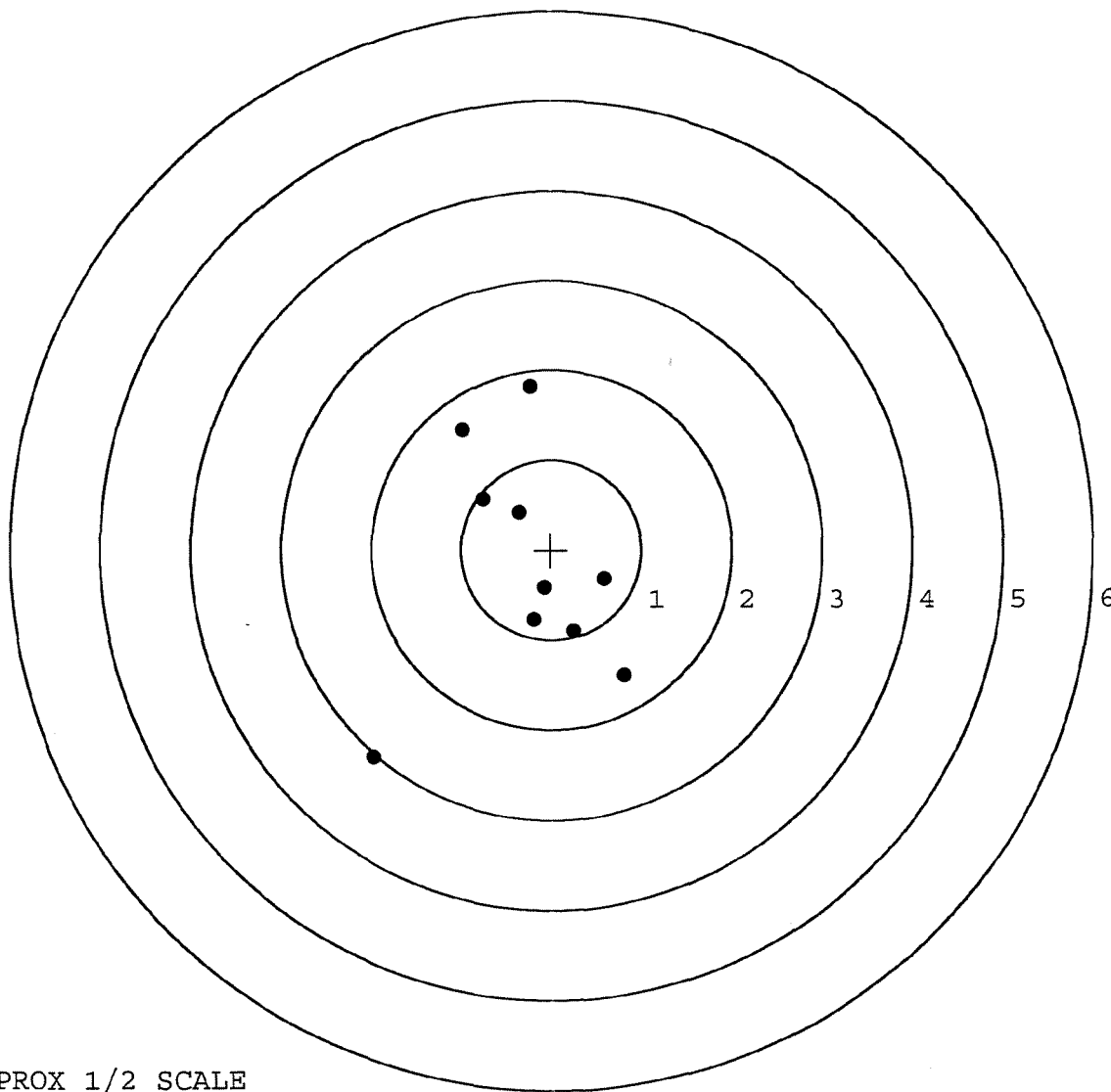
MEAN RADIUS: 1.221

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.807	-1.402
2:	0.250	-0.907
3:	-0.195	-0.780
4:	-0.074	-0.423
5:	0.588	-0.326
6:	-0.354	0.414
7:	-0.759	0.570
8:	-0.978	1.332
9:	-0.231	1.811
10:	-1.983	-2.301



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590135. __0

TARGET NUMBER: 2

FILE DATE: 05/22/2007

FILE TIME: 10:26

POINT#	X	Y
1:	0.156	-1.312
2:	0.639	-0.808
3:	0.284	-0.569
4:	-0.156	-1.034
5:	-1.276	-0.959
6:	0.292	0.280
7:	0.096	1.119
8:	-0.584	0.680
9:	-1.366	0.944
10:	-0.134	2.205

X CENTROID: -0.205

Y CENTROID: 0.055

POA TO CENTROID: 0.212

HORZ SPREAD: 2.005

VERT SPREAD: 3.517

GROUP SPREAD: 3.529

MIN RADIUS: 0.546

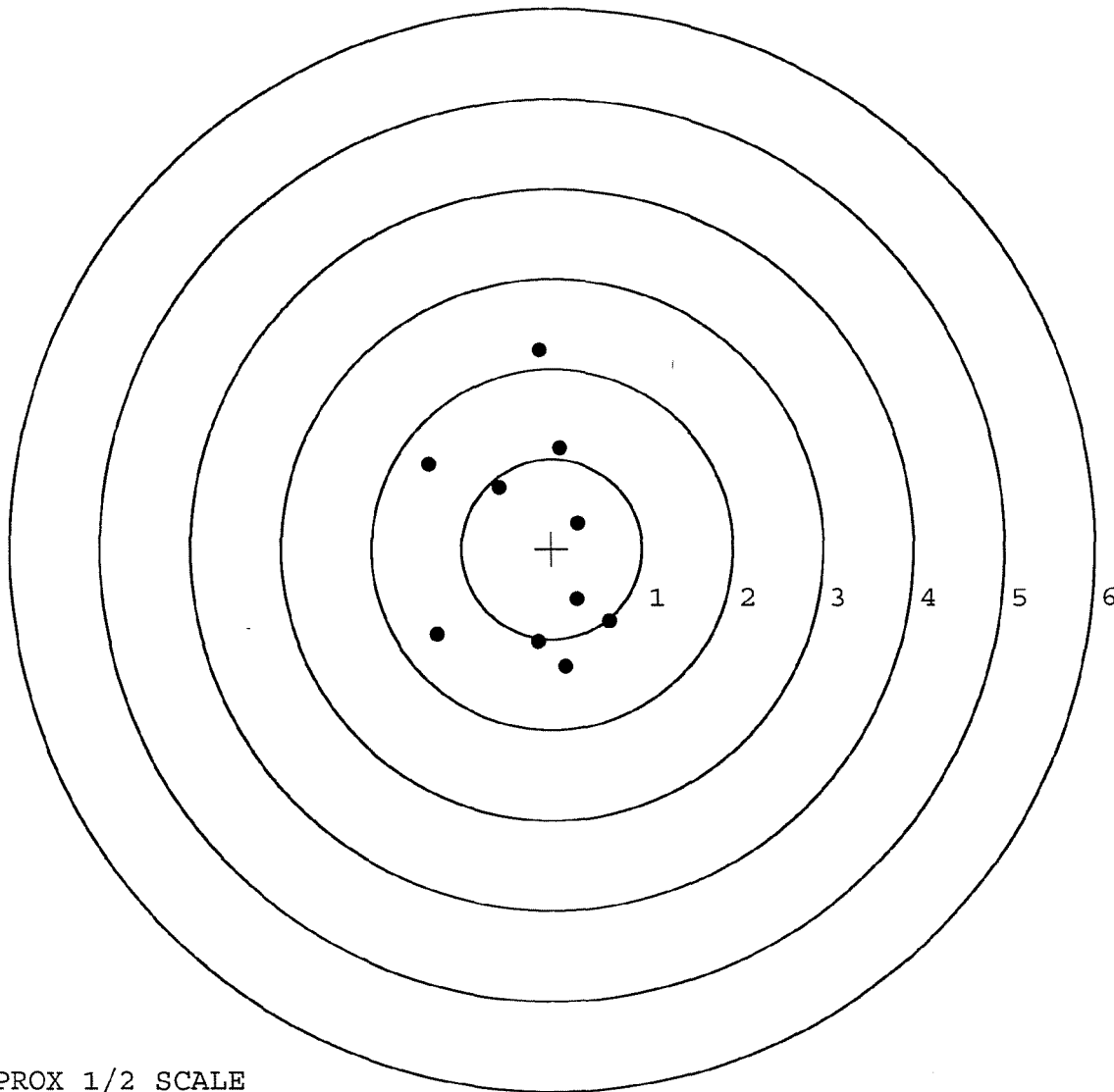
MAX RADIUS: 2.152

MEAN RADIUS: 1.197

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590135. __0

TARGET NUMBER: 3

FILE DATE: 05/22/2007

FILE TIME: 10:26

POINT#	X	Y
1:	1.095	0.375
2:	0.680	0.028
3:	-1.214	0.543
4:	-0.730	0.002
5:	0.027	0.119
6:	-0.331	-0.656
7:	-0.088	-0.314
8:	-0.205	-0.026
9:	-0.338	-0.215
10:	-0.095	-0.176

X CENTROID: -0.120

Y CENTROID: -0.032

POA TO CENTROID: 0.124

HORZ SPREAD: 2.309

VERT SPREAD: 1.199

GROUP SPREAD: 2.315

MIN RADIUS: 0.085

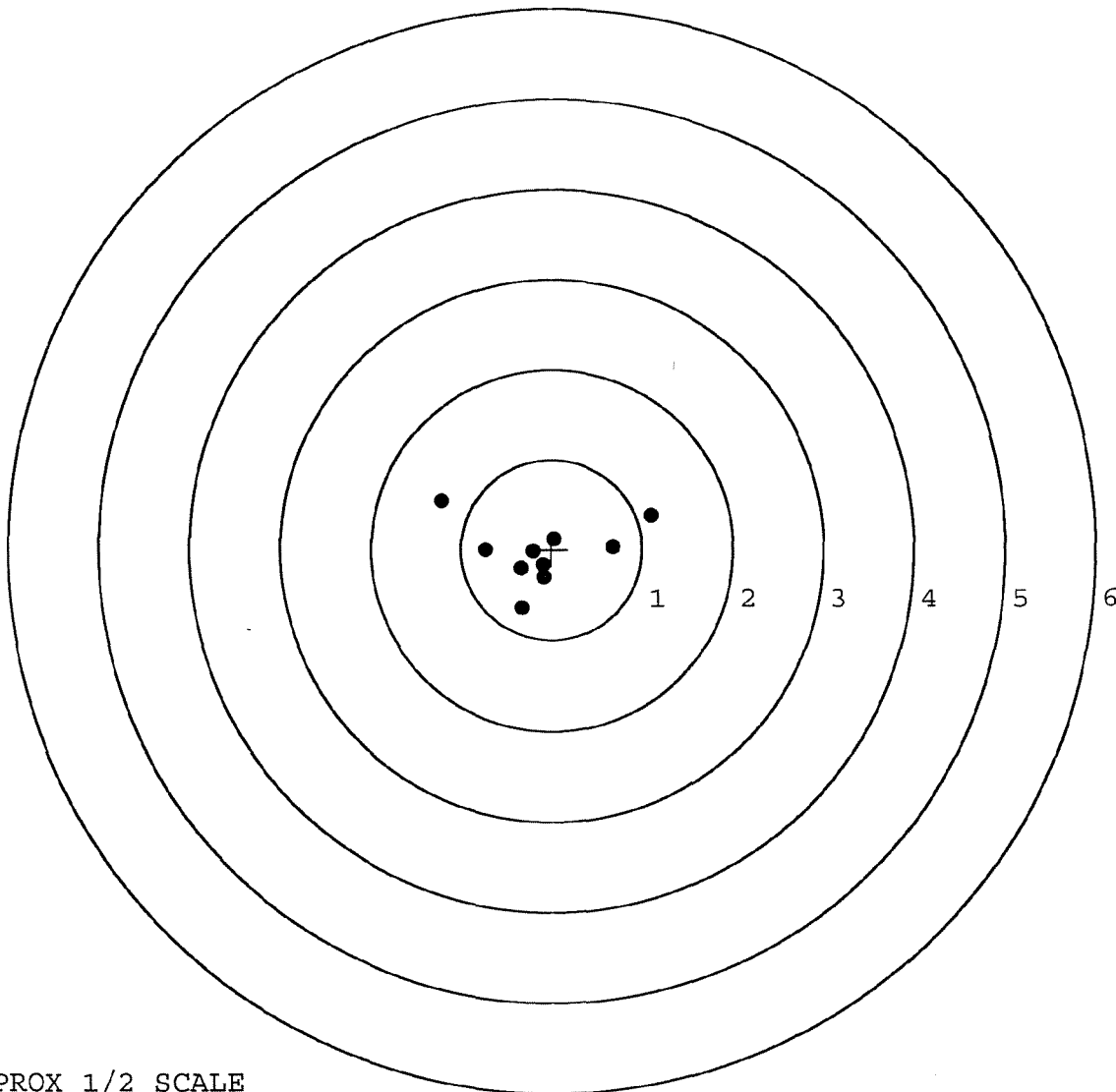
MAX RADIUS: 1.281

MEAN RADIUS: 0.560

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590135. __0

TARGET NUMBER: 4

FILE DATE: 05/22/2007

FILE TIME: 10:26

POINT#	X	Y
1:	0.230	-0.867
2:	-0.005	-0.628
3:	-0.495	0.112
4:	-0.103	0.255
5:	0.440	0.733
6:	0.564	1.086
7:	-1.110	1.010
8:	-1.511	-0.430
9:	-0.422	-1.246
10:	-1.908	-1.729

X CENTROID: -0.432

Y CENTROID: -0.170

POA TO CENTROID: 0.464

HORZ SPREAD: 2.472

VERT SPREAD: 2.815

GROUP SPREAD: 3.746

MIN RADIUS: 0.289

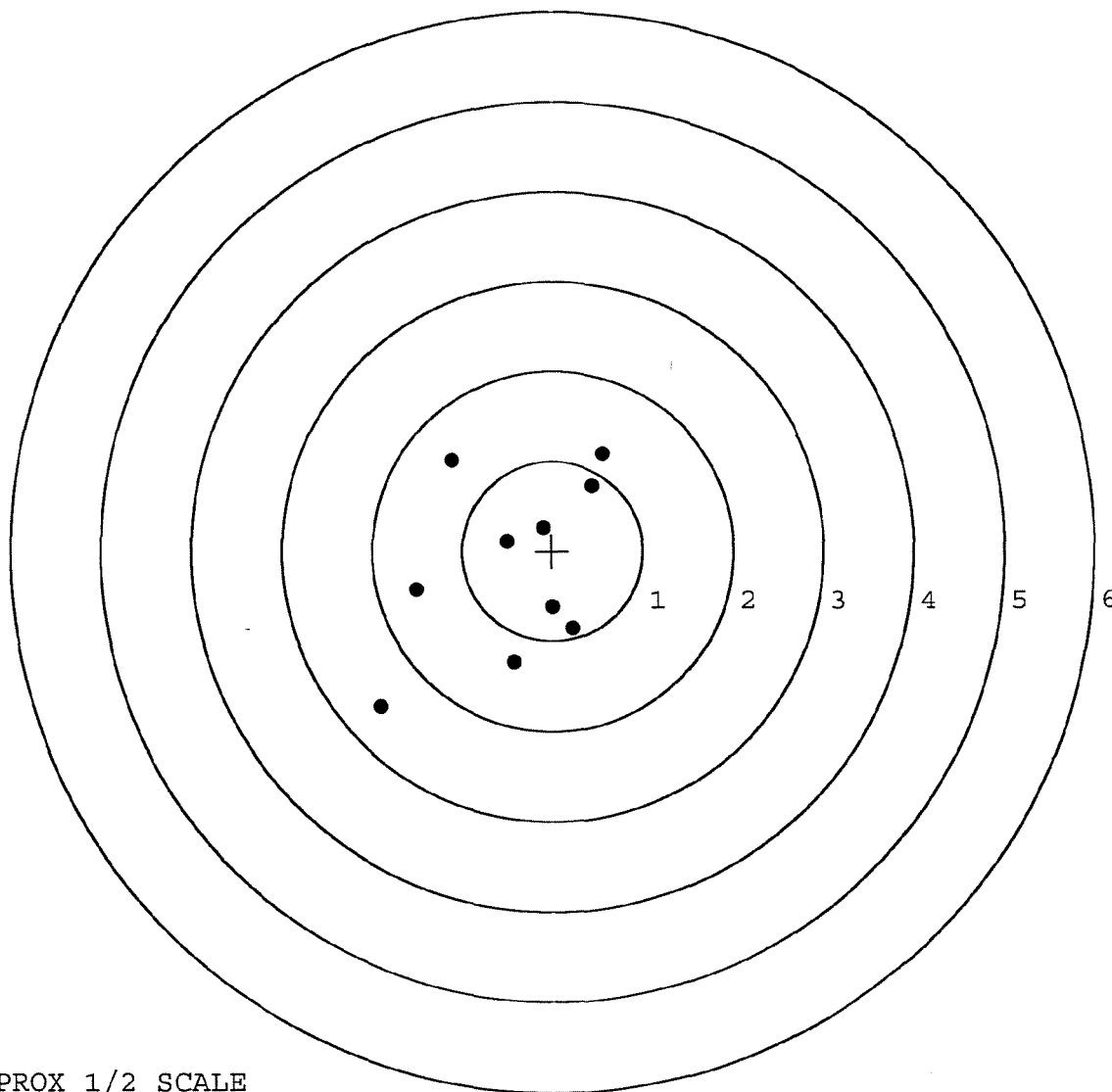
MAX RADIUS: 2.147

MEAN RADIUS: 1.097

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

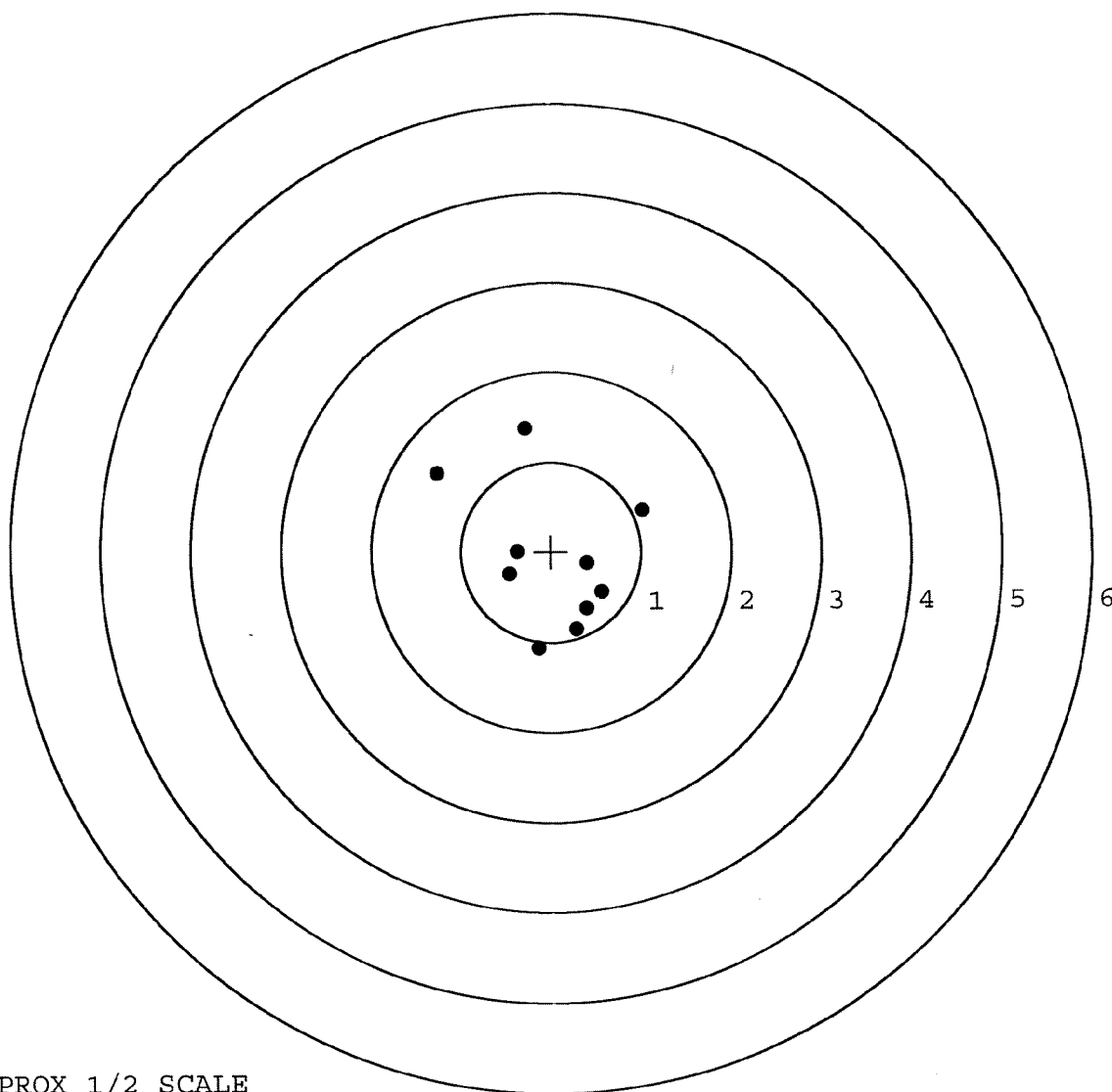


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590135. __0
 TARGET NUMBER: 5
 FILE DATE: 05/22/2007
 FILE TIME: 10:26

POINT#	X	Y
1:	1.016	0.463
2:	-0.286	1.380
3:	-1.265	0.882
4:	0.402	-0.132
5:	-0.377	0.001
6:	-0.461	-0.252
7:	0.561	-0.450
8:	0.394	-0.633
9:	0.280	-0.863
10:	-0.141	-1.071

X CENTROID: 0.012
 Y CENTROID: -0.068
 POA TO CENTROID: 0.069
 HORZ SPREAD: 2.281
 VERT SPREAD: 2.451
 GROUP SPREAD: 2.331
 MIN RADIUS: 0.395
 MAX RADIUS: 1.592
 MEAN RADIUS: 0.871
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE