

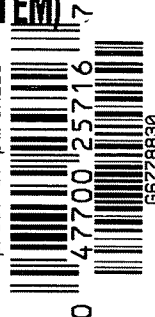
G6778830

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

— INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



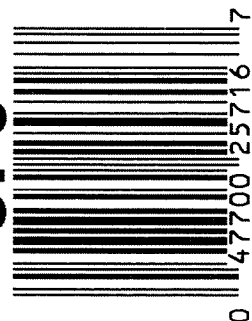
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6778830

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6778830

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-20-08	SP
430	ASSEMBLE TO STOCK		8-20-08	SP
440	PROOF		8-20-08	SP
460	CHECK HEADSPACE		8-20-08	SP
470	DIS-ASSEMBLE ACTION		8-20-08	SP
472	SERIALIZE BOLT HANDLE		8-21-08	RT
475	DRILL AND TAP SIGHT HOLES	MAGNA - FLUX AUG 22 2008 OPERATOR <u>BH</u>	8-21-08	SP
480	MAGNAFLUX BBL ACTION		8-22-08	BH
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8/22/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		8-25-	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-26-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-26-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-26-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-22-08	BH
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>4°</u>	10-27-08	L.P.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>5°</u> <u>5°</u>	10-27-08	L.P.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	10-27-08	L.P.
	J) ASSEMBLE STOCK		10-22-08	LSN
	K) ASSEMBLE SWIVEL STUDS		10-27-08	L.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	10-24-08	LSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-24-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-27-08	L.P.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>296</u> <u>297</u> <u>292</u> <u>287</u> <u>276</u>	10-24-08	L.P.
	C) FUNCTION		10-27-08	L.P.
690	PACK		10/29/08	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

10-14-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	224	230		228	
PULL #2	211	228		228	
PULL #3	227	2077		240	
PULL #4	221	207		225	
PULL #5	237	216		231	
TOTAL	1120	1088		1152	
AVERAGE	224	218		230	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	312	314		
PULL #2	330	335		
PULL #3	320	319		
PULL #4	307	342		
PULL #5	310	324		
TOTAL	1579	1634		
AVERAGE	316	327		

	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	440	435		4164
PULL #2	415	420		430
PULL #3	425	417		452
PULL #4	440	439		456
PULL #5	428	423		440
TOTAL	2148	2134		2242
AVERAGE	430	426		448