

56784678

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

G6784678



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 678 4678

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		8-28-08	SP
430	ASSEMBLE TO STOCK		8-28-08	SP
440	PROOF		8-28-08	SP
460	CHECK HEADSPACE		8-28-08	SP
470	DIS-ASSEMBLE ACTION		8-28-08	SP
472	SERIALIZE BOLT HANDLE		8-29-08	RSN
475	DRILL AND TAP SIGHT HOLES		8-29-08	SP
480	MAGNAFLUX BBL ACTION		9-2-08	BN
490	MAGNAFLUX BOLT		8/28/08	MR
500	ROLLMARK CALIBER		9/3/08	RT
520	GOFF BLAST BBL / REC		9/5/08	DS
542	APPLY COATINGS (BARREL ACTION)		9-9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-18-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-18-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-18-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-2-08	RSN
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

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OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>3.5</u> <u>3.5</u> <u>4.0</u>	10-20-08	L.P.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>5.0</u> <u>5.0</u>	10-20-08	L.P.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-20-08	L.P.
	J) ASSEMBLE STOCK		10-20-08	RSN
	K) ASSEMBLE SWIVEL STUDS		10-20-08	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	10-20-08	RSN
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-20-08	TC
670	FINAL INSPECTION A) HEADSPACE		10-20-08	L.P.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.33</u> <u>2.36</u> <u>2.56</u> <u>2.54</u>	10/3/08	Fm
	C) FUNCTION		10-20-08	L.P.
690	PACK		12-4-08	TC

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AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50 LBS 2.50 LBS AFTER 50 CYCLES
3.00 LBS 3.00 LBS AFTER 20 CYCLES
4.00 LBS 4.00 LBS AFTER 20 CYCLES

DATE

9-24-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	251	264		250	
PULL #2	293	272		211	
PULL #3	254	278		234	
PULL #4	274	267		226	
PULL #5	290	259		230	
TOTAL	1362	1340		1151	
AVERAGE	272	268		230	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	310	320		
PULL #2	322	346		
PULL #3	311	362		
PULL #4	304	349		
PULL #5	358	349		
TOTAL	1605	1724		
AVERAGE	321	344		

	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	436	451		436
PULL #2	454	441		441
PULL #3	457	434		448
PULL #4	411	434		414
PULL #5	451	406		437
TOTAL	2209	2166		2176
AVERAGE	441	433		435