

678 4968

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6784968

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-18-08	SPD
430	ASSEMBLE TO STOCK		9-18-08	SP
440	PROOF		9-18-08	SPD
460	CHECK HEADSPACE		9-18-08	SPD
470	DIS-ASSEMBLE ACTION		9-18-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNAFLUX	10-7-08	RIZ
475	DRILL AND TAP SIGHT HOLES		10-7-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (H)	10/8/08	(H)
490	MAGNAFLUX BOLT		9/18/08	DR
500	ROLLMARK CALIBER		10/8/08	Rt
520	GOFF BLAST BBL / REC		10/9/08	DG
542	APPLY COATINGS (BARREL ACTION)		10/3	c
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-13-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-13-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-13-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-19-08	BSW
	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>5.0</u> <u>4.0</u> <u>5.0</u>	12-17-08	L.N.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.0</u> <u>6.0</u> <u>6.0</u>	12-17-08	L.N.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.024</u>	12-17-08	L.N.
	J) ASSEMBLE STOCK		11-19-08	Rgn
	K) ASSEMBLE SWIVEL STUDS		12-17-08	L.N.
	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	12-12-08	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
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660	INSPECT FOR LIVE AMMO		12-12-08	RP
670	FINAL INSPECTION A) HEADSPACE		12-17-08	L.N.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.39</u> <u>2.30</u> <u>2.31</u> <u>2.31</u>	12-16-08	TL
	C) FUNCTION		12-17-08	L.N.
690	PACK		1-18-09	TL

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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

11-13-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	252	271		273	
PULL #2	262	272		273	
PULL #3	262	271		273	
PULL #4	264	266		266	
PULL #5	264	269		260	
TOTAL	1304	1349		1345	
AVERAGE	260	269		269	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	328	353		
PULL #2	389 353	349		
PULL #3	348	345		
PULL #4	360	353		
PULL #5	349	347		
TOTAL	1738	1747 1742		
AVERAGE	347	349		

	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	462	461		422
PULL #2	457	454		423
PULL #3	465	470		413
PULL #4	451	474		441
PULL #5	472	463		422
TOTAL	2307	2322		2121
AVERAGE	461	464		424

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