

66785095

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



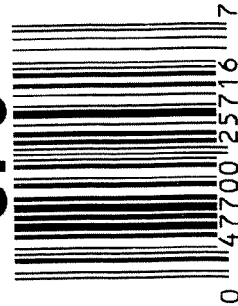
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6785095

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6785095

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-29-08	SPD
430	ASSEMBLE TO STOCK		9-29-08	SP
440	PROOF		9-29-08	SPD
460	CHECK HEADSPACE		9-29-08	SPD
470	DIS-ASSEMBLE ACTION		9-29-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA FLUX	9-30-08	RTZ
475	DRILL AND TAP SIGHT HOLES	10/1/08	10/1/08	Fm
480	MAGNAFLUX BBL ACTION	OPERATOR (KB)	10/2/08	(KB)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/2/08	RT
520	GOFF BLAST BBL / REC		10/03/08	DG
542	APPLY COATINGS (BARREL ACTION)		10-9	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-9-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-9-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-9-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-3-08	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>4°</u> <u>4°</u> <u>4°</u>	11-11-08	L. J.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-11-08	L. J.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	11-11-08	L. J.
	J) ASSEMBLE STOCK		11-03-08	ESN
	K) ASSEMBLE SWIVEL STUDS		11-11-08	L. J.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL	11-5-08	ESN
650	TARGET	<u>PASS</u> FAIL		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-5-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-11-08	L. J.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u> <u>2.32</u> <u>2.30</u> <u>2.32</u> <u>2.28</u>	11-6-08	TC
	C) FUNCTION		11-11-08	L. J.
690	PACK		11/12/08	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 10-28-08

TESTER TAC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	221	242		274	
PULL #2	235	249		273	
PULL #3	255	236		248	
PULL #4	265	253		268	
PULL #5	243	224		269	
TOTAL	1225	1204		258	
AVERAGE	245	240		1591	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	367	358		
PULL #2	350	359		
PULL #3	344	354		
PULL #4	339	353		
PULL #5	343	353		
TOTAL	1743	1743 1707		
AVERAGE	348	4.3554		

	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	438	457		430
PULL #2	454	426		414
PULL #3	452	441		437
PULL #4	459	417		435
PULL #5	428	423		425
TOTAL	2232	2164		2232 2141
AVERAGE	446	432		428