

G6785102

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



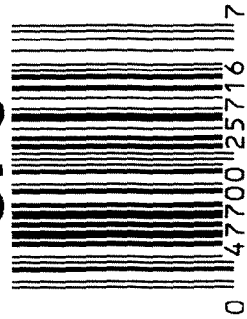
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6785102

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6785102

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		9-5-08	SPD
430	ASSEMBLE TO STOCK		9-6-08	TC
440	PROOF		9-6-08	TC
460	CHECK HEADSPACE		9-6-08	TC
470	DIS-ASSEMBLE ACTION		9-6-08	SPD
472	SERIALIZE BOLT HANDLE		9-8-08	RT
475	DRILL AND TAP SIGHT HOLES		9-8-08	SP
480	MAGNAFLUX BBL ACTION		9-10-08	RT
490	MAGNAFLUX BOLT		9/10/08	MR
500	ROLLMARK CALIBER		9/10/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		9/15	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		9-24-08	RT
	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>4.0</u> <u>4.0</u> <u>4.0</u>	10-23-08	LJD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	10-23-08	LJD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-23-08	LJD
	J) ASSEMBLE STOCK		9-24-08	RT
	K) ASSEMBLE SWIVEL STUDS		10-23-08	LJD
	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	10-4-08	TC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-4-08	JD
670	FINAL INSPECTION A) HEADSPACE		10-23-08	LJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.71</u> <u>2.72</u> <u>2.60</u> <u>2.65</u>	10/9/08	Fm
	C) FUNCTION		10-23-08	LJD
690	PACK		12-1-08	TC

F004 REV 5/2006

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

1.50 LBS. 1.50 LBS. 1.50 LBS.
1.50 LBS. 1.50 LBS. 1.50 LBS.
1.50 LBS. 1.50 LBS. 1.50 LBS.

DATE 9-23-08

TESTER T98

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	284	281	244	
PULL #2	285	276	244	
PULL #3	285	297	231	
PULL #4	272	283	257	
PULL #5	264	263	255	
TOTAL	1390	1400	1231	
AVERAGE	278	280	246	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	367	305	
PULL #2	329	301	
PULL #3	315	309	
PULL #4	341	356	
PULL #5	305	345	
TOTAL	1619	1616	
AVERAGE	323	323	

	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	491	463		418
PULL #2	454	453		407
PULL #3	480	435		4103
PULL #4	480	467		484
PULL #5	466	483		487
TOTAL	2371	2291		2199
AVERAGE	474	460		439