

66794646

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



BM FORM

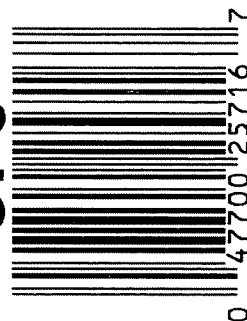
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794646

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794646

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-3-08	SP
430	ASSEMBLE TO STOCK		10-27-08	SP
440	PROOF		11-3-08	SP
460	CHECK HEADSPACE		11-3-08	SP
470	DIS-ASSEMBLE ACTION		11-3-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	11-4-08	RT
475	DRILL AND TAP SIGHT HOLES	2008	11-4-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR	11/6/08	SP
490	MAGNAFLUX BOLT		11/3/08	M12
500	ROLLMARK CALIBER		11/6/08	RT
520	GOFF BLAST BBL / REC		11/7/08	DG
542	APPLY COATINGS (BARREL ACTION)		11/5	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-17-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-17-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-17-08	SP
	D) OIL FIRING PIN ASSEMBLY		11-19-08	R8N
	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>3.5</u> <u>3.5</u> <u>3.5</u>	11-20-08	LJ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>5.0</u> <u>6.0</u>	11-20-08	LJ
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	11-20-08	LJ
	J) ASSEMBLE STOCK		11-19-08	Rgn
	K) ASSEMBLE SWIVEL STUDS		11-20-08	LJ
	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	11-19-08	TL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-19-08	LJ
670	FINAL INSPECTION A) HEADSPACE		11-20-08	LJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.37</u> <u>2.40</u> <u>2.44</u> <u>2.45</u>	11-20-08	TL
	C) FUNCTION		11-20-08	LJ
690	PACK		12-2-08	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 TGE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	266	291		229	
PULL #2	286	229		229	
PULL #3	274	254		227	
PULL #4	285	251		230	
PULL #5	291	254		229	
TOTAL	1402	1279		1144	
AVERAGE	280	255		228	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	339	301		
PULL #2	332	306		
PULL #3	324	302		
PULL #4	320	304		
PULL #5	338	310		
TOTAL	1653	1523		
AVERAGE	330	304		

	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	466	459		417
PULL #2	462	470		420
PULL #3	464	466		416
PULL #4	461	466		417
PULL #5	459	460		420
TOTAL	2322	2321		2090
AVERAGE	464	464		418