

679 4698

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

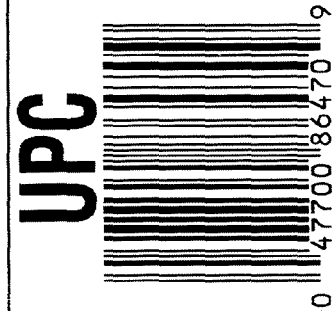


ORDER NO. **86470**

BARREL LENGTH 24"

CAPACITY 6

G6794698



BM FORM

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6794698

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		11-11-08	SPD
430	ASSEMBLE TO STOCK		11-11-08	SP
440	PROOF		11-11-08	SPD
460	CHECK HEADSPACE		11-11-08	SPD
470	DIS-ASSEMBLE ACTION		11-11-08	SPD
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	11-12-08	RTZ
475	DRILL AND TAP SIGHT HOLES		11-12-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	11/17/08	RT
490	MAGNAFLUX BOLT		11/17/08	RTZ
500	ROLLMARK CALIBER		11/17/08	RT
520	GOFF BLAST BBL / REC		11/17/08	DE
542	APPLY COATINGS (BARREL ACTION)		11/21	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-25-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-25-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-25-08	SP
	D) OIL FIRING PIN ASSEMBLY		1-6-09	RTZ
	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>40</u> <u>40</u> <u>40</u>	1-12-09	LH
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>60</u>	1-12-09	LH
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.025</u> <u>.025</u>	1-12-09	LH
	J) ASSEMBLE STOCK		1-05-09	RP
	K) ASSEMBLE SWIVEL STUDS		1-12-09	LH
	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	1-7-09	RP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-7-09	RP
670	FINAL INSPECTION A) HEADSPACE		1-12-09	LH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.18</u> <u>2.19</u> <u>2.17</u> <u>2.08</u> <u>2.13</u>	1-8-09	RP
	C) FUNCTION		1-12-09	LH
690	PACK		1/22/09	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

11-19-08

TESTER

TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	259	267		276	
PULL #2	250	247		259	
PULL #3	251	238		263	
PULL #4	267	243		262	
PULL #5	252	262		269	
TOTAL	1279	1257		1329	
AVERAGE	256	251		266	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	355	335		
PULL #2	340	327		
PULL #3	344	335		
PULL #4	357	331		
PULL #5	331	349		
TOTAL	1727	1677		
AVERAGE	345	335		

	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	423	409		460
PULL #2	417	430		454
PULL #3	419	408		455
PULL #4	408	416		460
PULL #5	411	412		445
TOTAL	2078	2075		2274
AVERAGE	415	415		455