

G-679 4772

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

- INSTRUCTION BOOK 3518

BM FORM

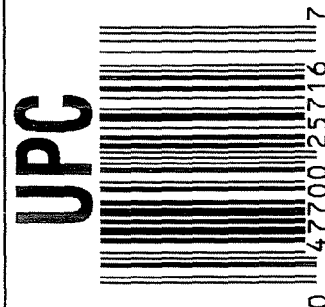


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6794772



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G 6794772

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		10-7-08	SP
430	ASSEMBLE TO STOCK		10-7-08	SP
440	PROOF		10-7-08	SP
460	CHECK HEADSPACE		10-7-08	SP
470	DIS-ASSEMBLE ACTION		10-7-08	SP
472	SERIALIZE BOLT HANDLE	MAGNA FLUX	10-8-08	ESR
475	DRILL AND TAP SIGHT HOLES	2007	10-8-08	SP
480	MAGNAFLUX BBL ACTION	OPERATOR (R)	10/11/08	(R)
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/13/08	RT
520	GOFF BLAST BBL / REC			
542	APPLY COATINGS (BARREL ACTION)		10-26	
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-21-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-08	SP
	D) OIL FIRING PIN ASSEMBLY		10-27-08	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>30</u> <u>35</u> <u>40</u>	11-5-08	X 90
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>50</u> <u>50</u> <u>50</u>	11-5-08	X 90
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.033</u> <u>.033</u> <u>.023</u>	11-5-08	X 90
	J) ASSEMBLE STOCK		10-27-08	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-5-08	X 90
	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	10-30-08	ELGw
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-30-08	TC
670	FINAL INSPECTION A) HEADSPACE		11-5-08	X 90
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.70</u> <u>2.60</u> <u>2.72</u> <u>2.78</u> <u>2.71</u>	11-3-08	TC
	C) FUNCTION		11-5-08	X 90
690	PACK		11/10/08	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

10-21-08

TESTER

10-21-08 TAE

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	215	224		265	
PULL #2	226	242		234	
PULL #3	217	247		259	
PULL #4	214	227		251	
PULL #5	211	233		251	
TOTAL	1083	1173		1260	
AVERAGE	216	234		252	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	368	315		
PULL #2	355	315		
PULL #3	327	325		
PULL #4	312	337		
PULL #5	318	340		
TOTAL	1680	1632		
AVERAGE	336	326		

	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	411	413		426
PULL #2	428	412		429
PULL #3	420	410		438
PULL #4	420	409		431
PULL #5	416	418		423
TOTAL	2095	2062		2095 2147
AVERAGE	419	412		429