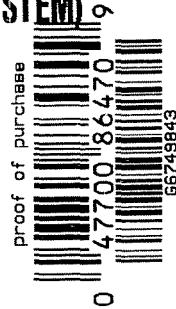


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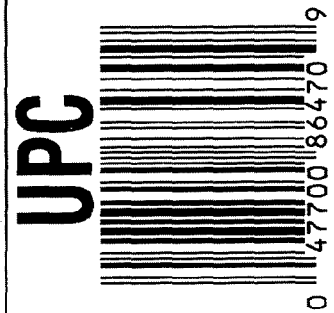
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
WITH BIPOD



BM FORM

ORDER NO.	86470
BARREL LENGTH	24"
CAPACITY	6

G6749843



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6749843

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		6-25-08	RP
430	ASSEMBLE TO STOCK		6-25-08	SP
440	PROOF		6-25-08	SD
460	CHECK HEADSPACE		6-25-08	SD
470	DIS-ASSEMBLE ACTION		6-25-08	RP
472	SERIALIZE BOLT HANDLE		7-8-08	RP
475	DRILL AND TAP SIGHT HOLES		JUL 15 2008 7-15-08	SP
480	MAGNAFLUX BBL ACTION		7-15-08	SP
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7/11/08	RT
520	GOFF BLAST BBL / REC		7/18	cur
542	APPLY COATINGS (BARREL ACTION)			
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-22-08	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-22-08	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-22-08	SP
	D) OIL FIRING PIN ASSEMBLY		7-23-08	RP
	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>6</u> <u>6</u> <u>6</u>	7-30	TK
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6.5</u> <u>6</u> <u>6</u>	7-30	TK
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	7-30	TK
	J) ASSEMBLE STOCK		7-23-08	APD
	K) ASSEMBLE SWIVEL STUDS		7-30-08	TK
	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	7-24-08	TKW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/24/08	MED
670	FINAL INSPECTION A) HEADSPACE		7-30-08	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.94</u> <u>2.94</u> <u>3.14</u> <u>2.84</u> <u>2.68</u>	7-30-08	ESN
	C) FUNCTION		7-30-08	RTZ
690	PACK		7/30/08	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 7-21-08
TESTER S. Day

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.58	2.21		2.53	
PULL #2	2.50	2.31		2.54	
PULL #3	2.33	2.25		2.50	
PULL #4	2.38	2.25		2.50	
PULL #5	2.38	2.26		2.51	
TOTAL	12.17	11.28		12.57	
AVERAGE	2.43	2.25		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.20		
PULL #2	3.08	3.18		
PULL #3	3.17	3.11		
PULL #4	3.16	3.12		
PULL #5	3.13	3.14		
TOTAL	15.61	15.75		
AVERAGE	3.12	3.15		

	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	4.00	4.25		4.13
PULL #2	4.16	4.22		4.17
PULL #3	4.08	4.14		4.20
PULL #4	4.08	4.16		4.13
PULL #5	4.07	4.16		4.15
TOTAL	20.39	20.93		20.78
AVERAGE	4.07	4.18		4.15