

G6410215

ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



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M/24 .300 WIN MAG (RIFLE ONLY)

UPC



SERIAL NO.



M/24 .300 WIN MAG (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL .300 WIN MAG

— INSTRUCTION BOOK 3518

DD FORM 200348



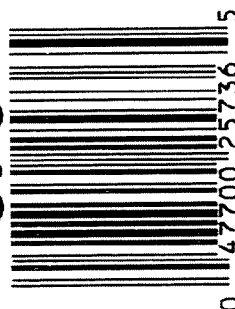
ORDER NO. 25736

BARREL LENGTH 24"

CAPACITY 5

G6410215

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

300 win

GUN SERIAL # G6410215

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-31-05	RTZ
600	PROOF		1-31-05	RR
607	CHECK HEADSPACE	MAGNA-FLUX	1-31-05	RTZ
610	DIS-ASSEMBLE GUN	INSPECTED	1-31-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 31 2005 OPERATOR 		
615	ROLLMARK CALIBER		1-31-05	CW
617	DRILL AND TAP SIGHT HOLES		1-31-05	TRW
620	APPLY COATINGS (BARREL ACTION)		2-11-05	TRW
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-15-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-15-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-15-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-15-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5 lbs</u> <u>5 lbs</u> <u>5 lbs</u>	2-23-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	2-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	_____	X	X
	J) ASSEMBLE STOCK		2-21-05	RTL
	K) ASSEMBLE SWIVEL STUDS		2-24-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		X	X
	M) IRON SIGHT ALIGNMENT		X	X
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		X	X
640	GALLERY TEST AND TARGET	<u>PASS</u> <u>FAIL</u>	2-22-05	TRL
	MALFUNCTION <u>JM</u>	CORRECTION <u>OK</u>	2-23-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>NA</u>		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-22-05	AC
655	FINAL INSPECTION A) HEADSPACE		2-23-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.70</u> <u>2.69</u> <u>2.85</u> <u>2.77</u>	2-24-05	TRL
	C) FUNCTION		2-23-05	AC
660	PACK		2-26-05	DA

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)

SERIAL NO. _____

DATE 2-11-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.27		2.21	
PULL #2	2.50	2.32		2.16	
PULL #3	2.56	2.34		2.15	
PULL #4	2.66	2.29		2.20	
PULL #5	2.90	2.37		2.17	
TOTAL	12.96	11.59		10.89	
AVERAGE	2.59	2.31		2.17	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.02		
PULL #2	3.10	2.95		
PULL #3	3.12	3.06		
PULL #4	3.09	3.07		
PULL #5	3.19	3.08		
TOTAL	15.54	15.18		
AVERAGE	3.10	3.03		

	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	4.15	4.08		4.01
PULL #2	4.15	4.04		3.92
PULL #3	4.10	4.02		4.05
PULL #4	4.11	4.00		4.00
PULL #5	4.10	4.01		3.97
TOTAL	20.61	20.15		19.95
AVERAGE	4.12	4.03		3.99

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410215.___0
FILE DATE AND TIME: 02/22/2005 11:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.119
The Average Y Centroid of the Five Target Set:	-0.028
The Average Point of Impact of the Five Target Set:	0.122
The Average Mean Radius of the Five Target Set:	0.985
The Distance from POA to Centroid Target #1:	0.516
The Distance from Centroid Target #2 to Centroid Target #1:	0.545
The Distance from Centroid Target #3 to Centroid Target #1:	0.549
The Distance from Centroid Target #4 to Centroid Target #1:	0.471
The Distance from Centroid Target #5 to Centroid Target #1:	0.477

SERIAL NUMBER: G6410215. __0

TARGET NUMBER: 1

FILE DATE: 02/22/2005

FILE TIME: 11:04

POINT#	X	Y
1:	1.733	-1.445
2:	2.209	-1.077
3:	1.329	-0.478
4:	0.754	-1.670
5:	0.657	1.065
6:	0.227	0.108
7:	-0.370	0.301
8:	-0.373	-0.184
9:	-0.449	-0.546
10:	-1.336	1.192

X CENTROID: 0.438

Y CENTROID: -0.273

POA TO CENTROID: 0.516

HORZ SPREAD: 3.545

VERT SPREAD: 2.862

GROUP SPREAD: 4.209

MIN RADIUS: 0.436

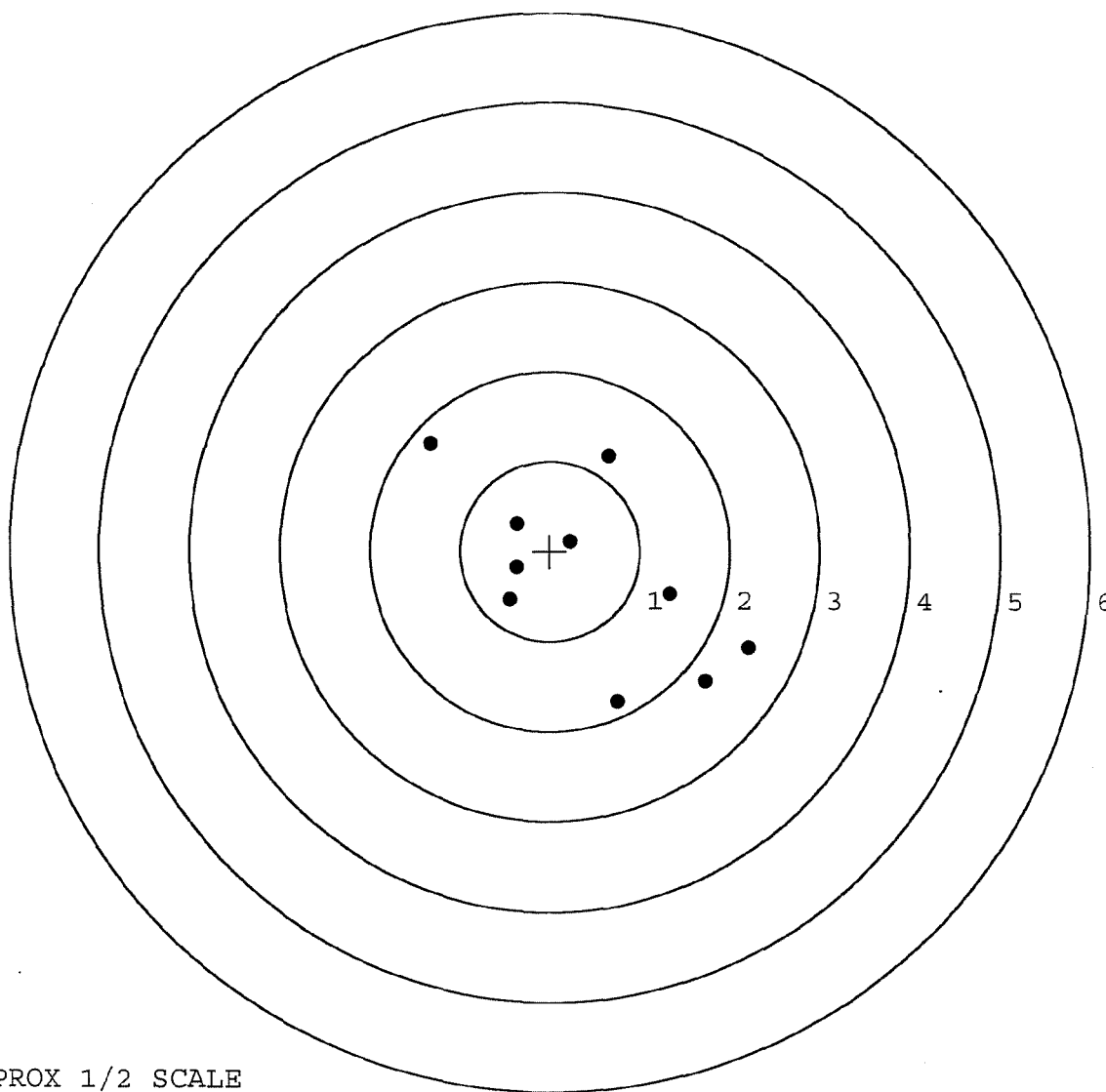
MAX RADIUS: 2.301

MEAN RADIUS: 1.287

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

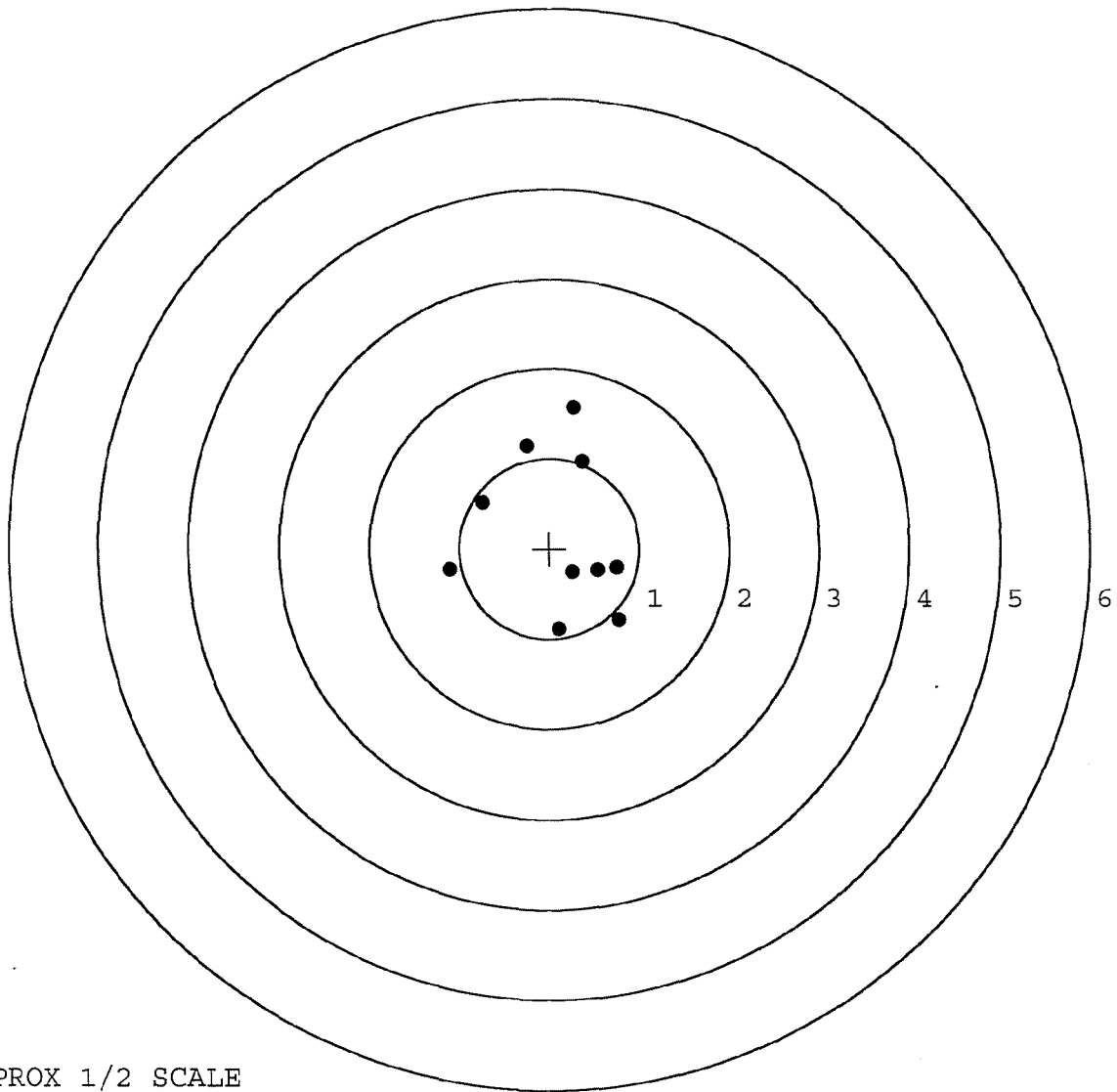


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410215.___0
TARGET NUMBER: 2
FILE DATE: 02/22/2005
FILE TIME: 11:04

X CENTROID: 0.097
Y CENTROID: 0.153
POA TO CENTROID: 0.181
HORZ SPREAD: 1.891
VERT SPREAD: 2.463
GROUP SPREAD: 2.468
MIN RADIUS: 0.445
MAX RADIUS: 1.423
MEAN RADIUS: 0.950
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.779	-0.789
2:	0.752	-0.207
3:	0.259	-0.262
4:	0.112	-0.898
5:	-0.743	0.509
6:	-1.112	-0.240
7:	-0.253	1.134
8:	0.373	0.960
9:	0.271	1.565
10:	0.537	-0.246



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410215. 0

TARGET NUMBER: 3

FILE DATE: 02/22/2005

FILE TIME: 11:04

POINT#	X	Y
1:	0.484	-1.191
2:	-0.070	-0.745
3:	0.996	0.100
4:	0.590	0.331
5:	0.452	-0.026
6:	-0.264	0.283
7:	-0.464	0.111
8:	-0.506	-0.145
9:	-1.068	0.029
10:	-0.734	0.867

X CENTROID: -0.058

Y CENTROID: -0.039

POA TO CENTROID: 0.070

HORZ SPREAD: 2.064

VERT SPREAD: 2.058

GROUP SPREAD: 2.391

MIN RADIUS: 0.382

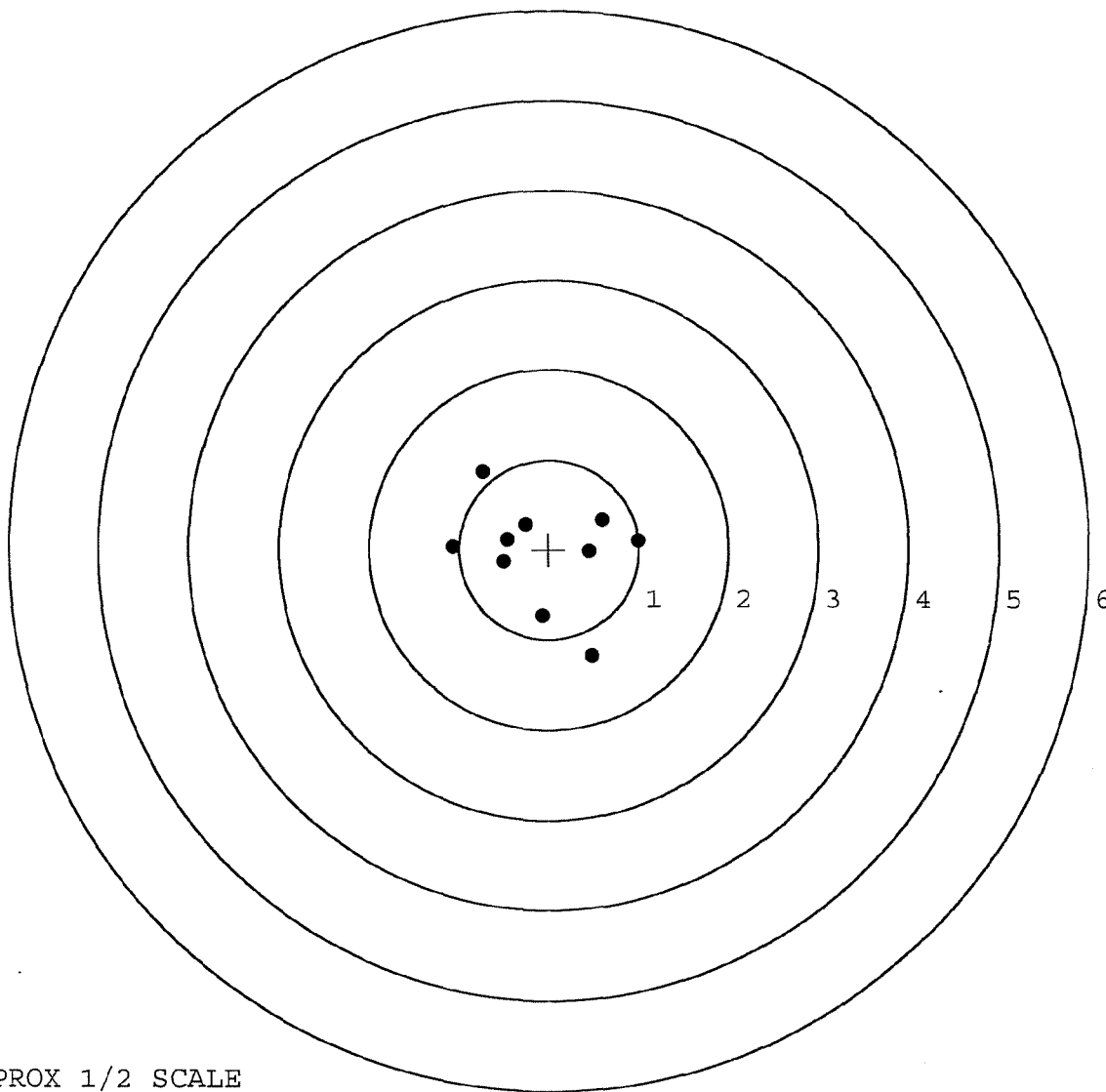
MAX RADIUS: 1.274

MEAN RADIUS: 0.772

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

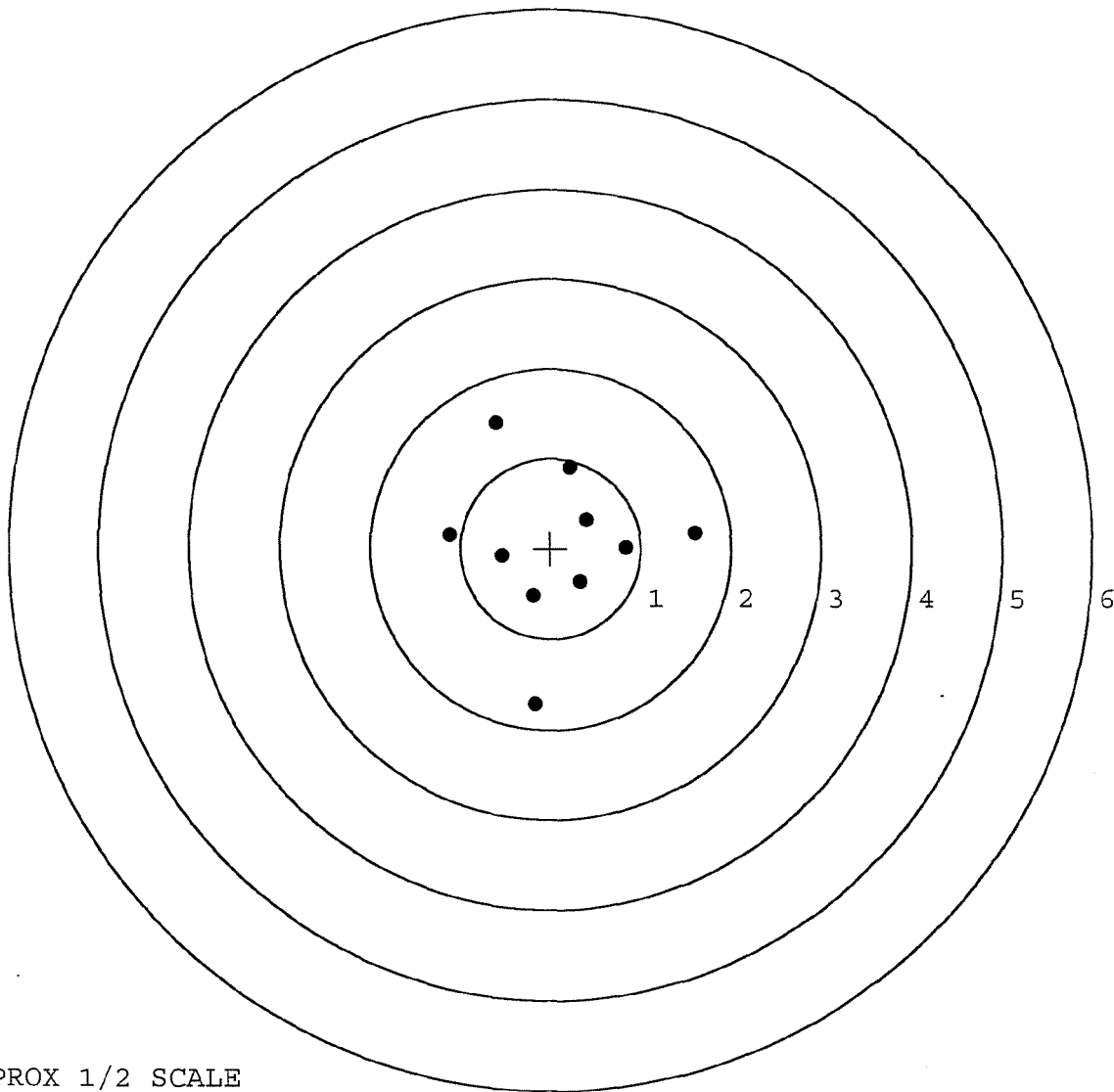


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410215. __0
TARGET NUMBER: 4
FILE DATE: 02/22/2005
FILE TIME: 11:04

POINT#	X	Y
1:	-0.168	-1.725
2:	1.599	0.184
3:	0.840	0.020
4:	0.396	0.322
5:	0.332	-0.368
6:	0.216	0.903
7:	-0.611	1.395
8:	-0.195	-0.531
9:	-0.539	-0.085
10:	-1.119	0.149

X CENTROID: 0.075
Y CENTROID: 0.026
POA TO CENTROID: 0.080
HORZ SPREAD: 2.718
VERT SPREAD: 3.120
GROUP SPREAD: 3.151
MIN RADIUS: 0.436
MAX RADIUS: 1.768
MEAN RADIUS: 0.983
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410215. __0

TARGET NUMBER: 5

FILE DATE: 02/22/2005

FILE TIME: 11:04

POINT#	X	Y
1:	0.142	-0.871
2:	0.461	-0.492
3:	-0.045	-0.337
4:	-0.709	-0.924
5:	-1.430	-0.715
6:	1.038	0.357
7:	0.654	0.531
8:	0.436	0.676
9:	0.413	1.066
10:	-0.534	0.644

X CENTROID: 0.043

Y CENTROID: -0.006

POA TO CENTROID: 0.043

HORZ SPREAD: 2.468

VERT SPREAD: 1.990

GROUP SPREAD: 2.691

MIN RADIUS: 0.342

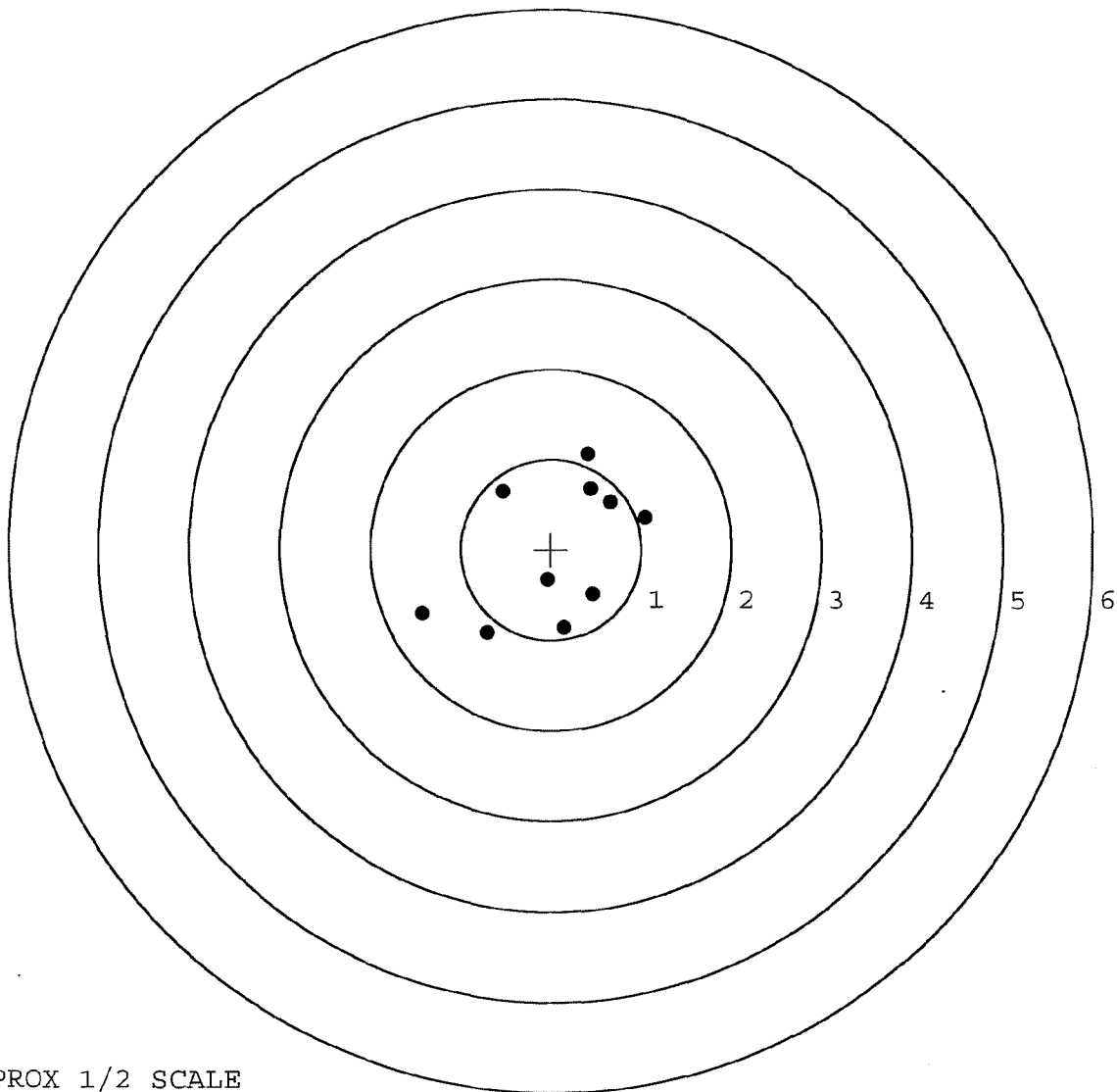
MAX RADIUS: 1.634

MEAN RADIUS: 0.934

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE