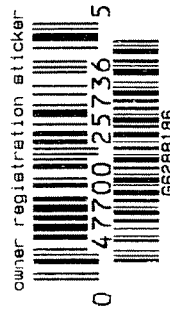


G6288186

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

- INSTRUCTION BOOK 3518

DD FORM 200348

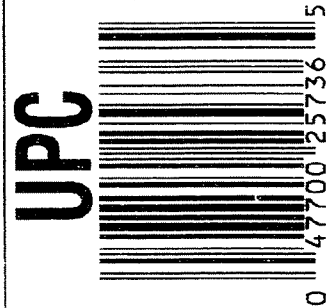


ORDER NO. 25736

BARREL LENGTH 24"

CAPACITY 5

G6288186



ORDER— 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



0 47700 25736 5

ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



0 47700 25736 5

SERIAL NO.



66288186

10/26/2004 8:17:26 AM

Crtd

Reprint

66281186

25736

M/24 300 WIN MAG (RIFLE ONLY)



.MA25736

Shop Order: SWS58802



.ABSWS58802

Start Date: 10/13/2004

Finish Date: 10/29/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003512627

0560

Reassemble Action.

89SWS1



0003512628

0690

Pack Rifle

89SWS1



0003512638

0700

Stencil SWS Container

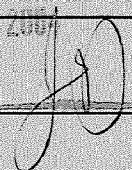
89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G628 8186

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-1-04	RTL
600	PROOF		11-1-04	TRW
607	CHECK HEADSPACE	MAGNA-FLUX	11-4-04	RTL
610	DIS-ASSEMBLE GUN	INSPECTED	11-4-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 13 2004 OPERATOR 		
615	ROLLMARK CALIBER		11-4-04	RTL
617	DRILL AND TAP SIGHT HOLES		11-4-04	TRW
620	APPLY COATINGS (BARREL ACTION)		11/9	HQ
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-10-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-10-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-10-04	RTL
	D) OIL FIRING PIN ASSEMBLY		11-10-04	RTL
	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>1-0</u> <u>6-0</u> <u>6-0</u>	12-1-04	RTL
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2-0</u> <u>2-25</u> <u>2-0</u>	12-1-04	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY		12-1-04	RTL
	I) FIRING PIN INDENT .020 MIN		12-1-04	RTL
	J) ASSEMBLE STOCK		11-10-04	RTL
	K) ASSEMBLE SWIVEL STUDS		12-1-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	11-30-04	RTL
	MALFUNCTION	CORRECTION	11-30-04	RTL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		11-30-04	RTL
655	FINAL INSPECTION A) HEADSPACE		12-1-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.54</u> <u>2.42</u> <u>2.42</u> <u>2.42</u>	12-1-04	RTL
	C) FUNCTION		12-1-04	RTL
660	PACK		12/1/04	RTA

AVERAGE PULL FORCE BETWEEN

SERIAL NO. _____

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE 11-9-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.23	2.29		2.03	
PULL #2	2.02	2.45		2.24	
PULL #3	2.19	2.67		2.11	
PULL #4	2.33	2.82		2.29	
PULL #5	2.08	2.94		2.27	
TOTAL	10.85	13.17		10.94	
AVERAGE	2.17	2.63		2.18	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.01		
PULL #2	3.37	3.01		
PULL #3	3.47	3.07		
PULL #4	3.46	2.95		
PULL #5	3.10	2.96		
TOTAL	16.74	15.00		
AVERAGE	3.34	3.00		

	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	4.46	4.37		3.95
PULL #2	4.44	4.28		4.03
PULL #3	4.42	4.36		3.99
PULL #4	4.55	4.26		4.04
PULL #5	4.55	4.14		4.05
TOTAL	22.42	21.41		20.06
AVERAGE	4.48	4.28		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6288186.___0
FILE DATE AND TIME: 11/30/2004 11:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.165
The Average Y Centroid of the Five Target Set:	-0.057
The Average Point of Impact of the Five Target Set:	0.174
The Average Mean Radius of the Five Target Set:	1.015
The Distance from POA to Centroid Target #1:	0.431
The Distance from Centroid Target #2 to Centroid Target #1:	0.479
The Distance from Centroid Target #3 to Centroid Target #1:	0.117
The Distance from Centroid Target #4 to Centroid Target #1:	0.626
The Distance from Centroid Target #5 to Centroid Target #1:	0.926

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 1

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	0.293	0.643
2:	-0.007	0.321
3:	-0.545	0.330
4:	-0.341	-0.048
5:	-1.189	-0.371
6:	0.064	-0.598
7:	-0.211	-0.845
8:	0.547	-0.383
9:	0.896	-0.983
10:	-0.038	-2.344

X CENTROID: -0.053

Y CENTROID: -0.428

POA TO CENTROID: 0.431

HORZ SPREAD: 2.085

VERT SPREAD: 2.987

GROUP SPREAD: 3.005

MIN RADIUS: 0.207

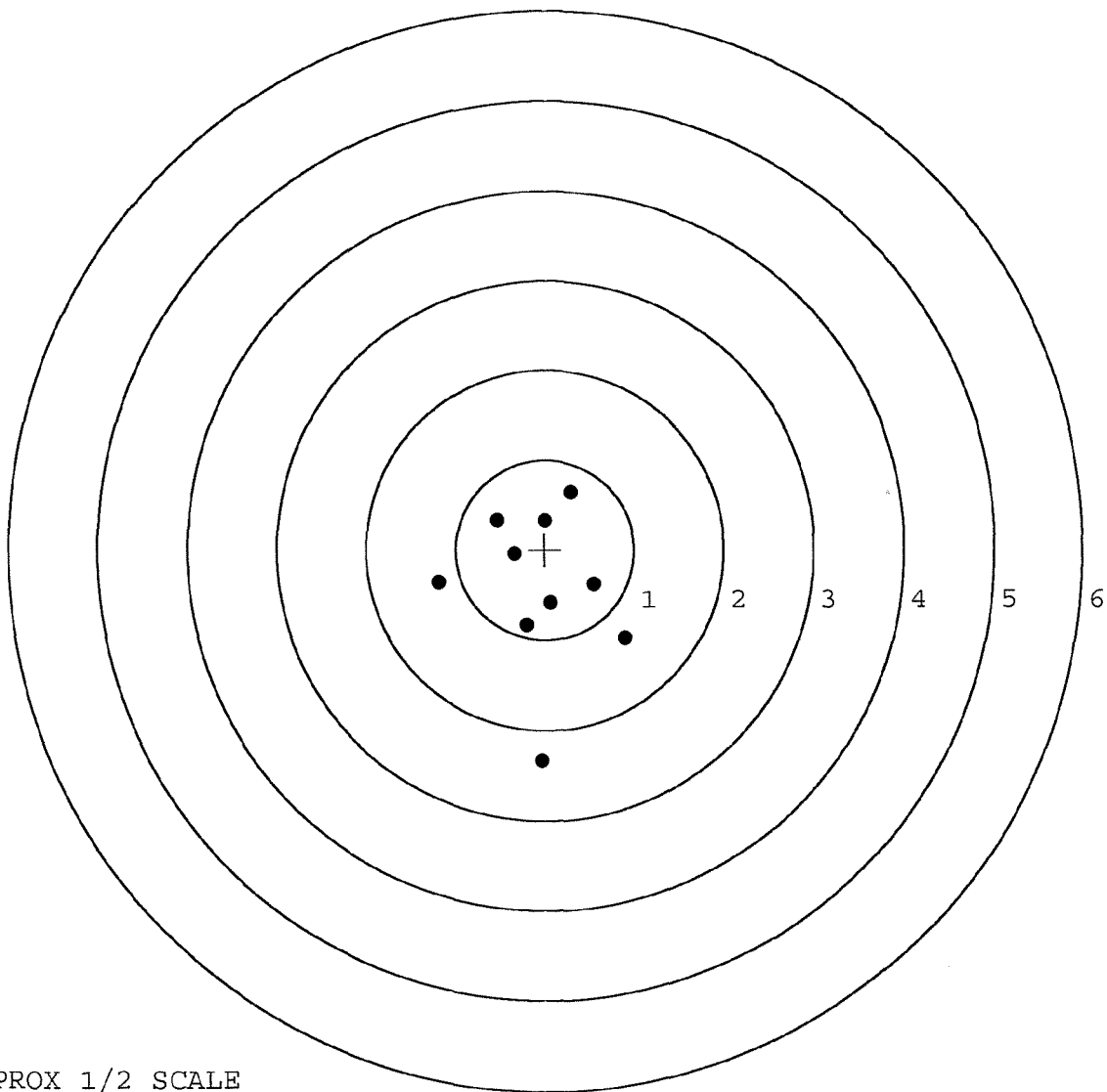
MAX RADIUS: 1.916

MEAN RADIUS: 0.866

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 2

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	0.430	1.506
2:	-0.335	1.151
3:	-0.390	0.607
4:	-1.253	-0.461
5:	-0.392	-0.289
6:	-0.807	-0.799
7:	-0.333	-1.274
8:	0.425	-0.177
9:	0.658	-0.043
10:	0.672	0.229

X CENTROID: -0.133

Y CENTROID: 0.045

POA TO CENTROID: 0.140

HORZ SPREAD: 1.925

VERT SPREAD: 2.780

GROUP SPREAD: 2.883

MIN RADIUS: 0.423

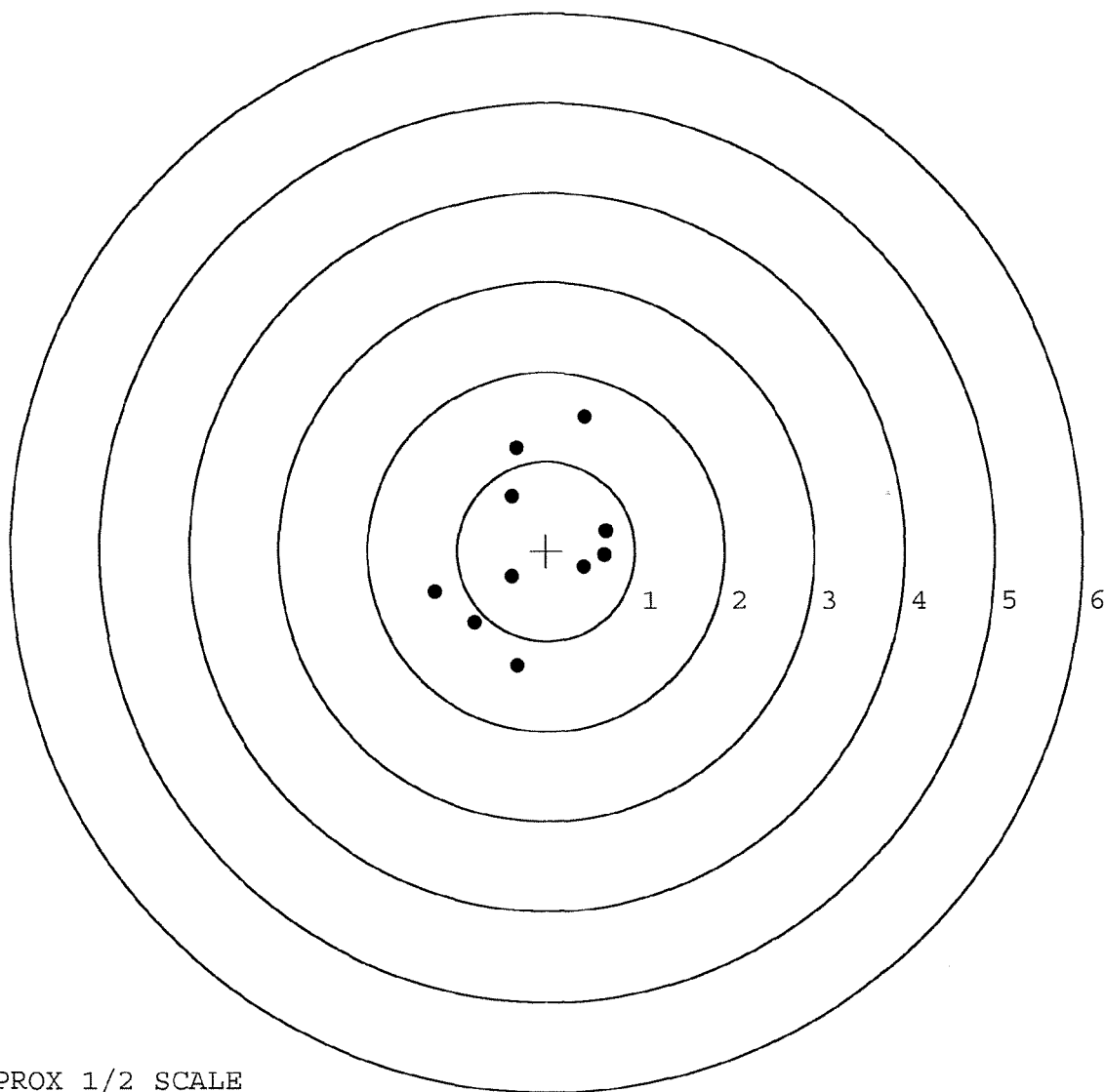
MAX RADIUS: 1.566

MEAN RADIUS: 0.960

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 3

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	0.358	0.281
2:	-0.785	-0.003
3:	-0.417	0.075
4:	-0.197	-0.148
5:	-0.054	-0.445
6:	-1.563	-0.953
7:	0.379	-1.283
8:	0.230	-1.840
9:	1.372	-0.556
10:	-0.292	-0.487

X CENTROID: -0.097

Y CENTROID: -0.536

POA TO CENTROID: 0.545

HORZ SPREAD: 2.935

VERT SPREAD: 2.121

GROUP SPREAD: 2.962

MIN RADIUS: 0.101

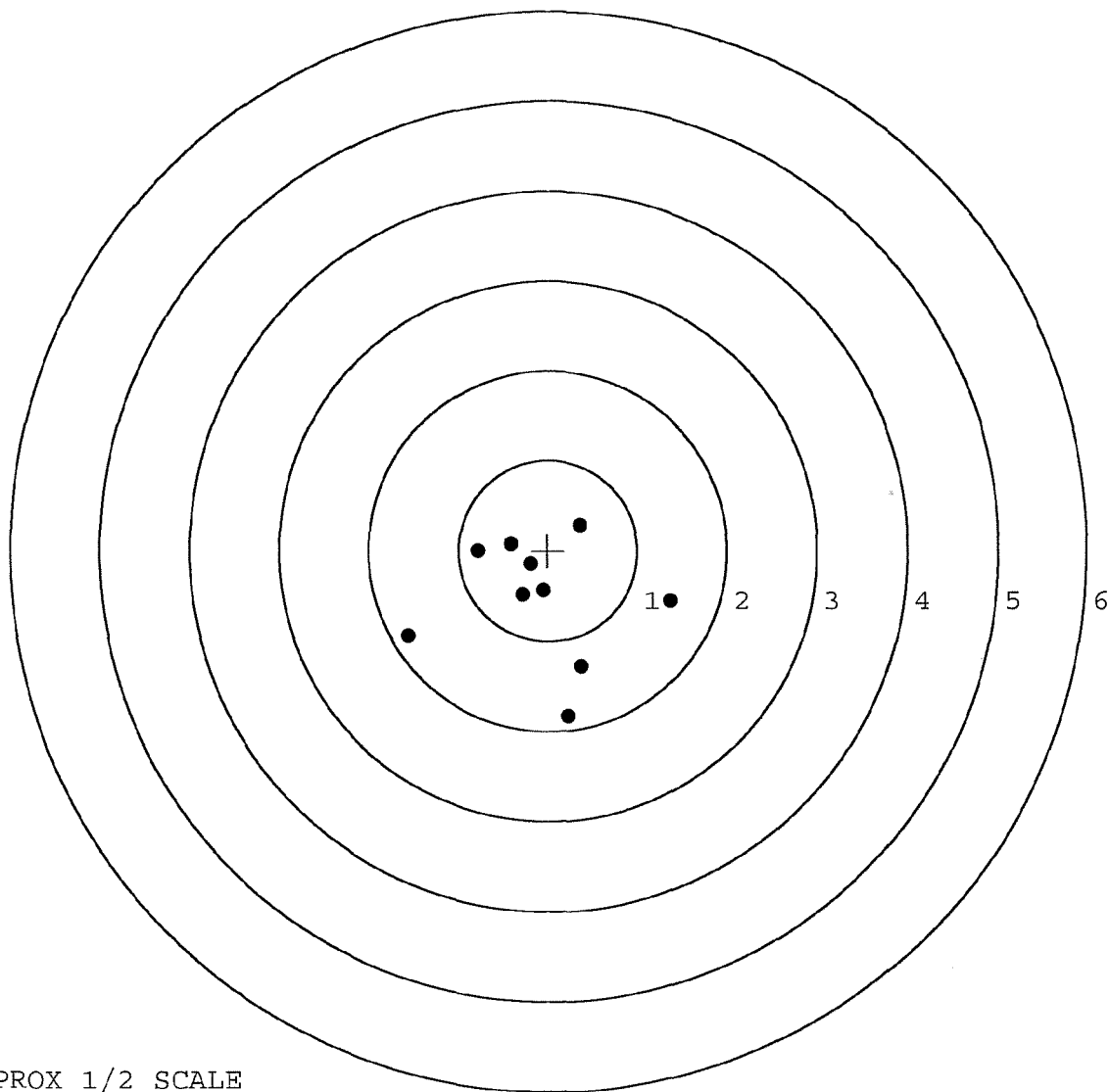
MAX RADIUS: 1.524

MEAN RADIUS: 0.842

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 4

FILE DATE: 11/30/2004

FILE TIME: 11:03

POINT#	X	Y
1:	1.340	-0.029
2:	0.153	2.419
3:	-1.534	1.793
4:	-0.859	0.725
5:	-0.307	-0.047
6:	0.278	-0.447
7:	0.044	-0.412
8:	-0.276	-0.469
9:	-1.465	-1.572
10:	-0.150	-0.392

X CENTROID: -0.278

Y CENTROID: 0.157

POA TO CENTROID: 0.319

HORZ SPREAD: 2.874

VERT SPREAD: 3.991

GROUP SPREAD: 4.307

MIN RADIUS: 0.206

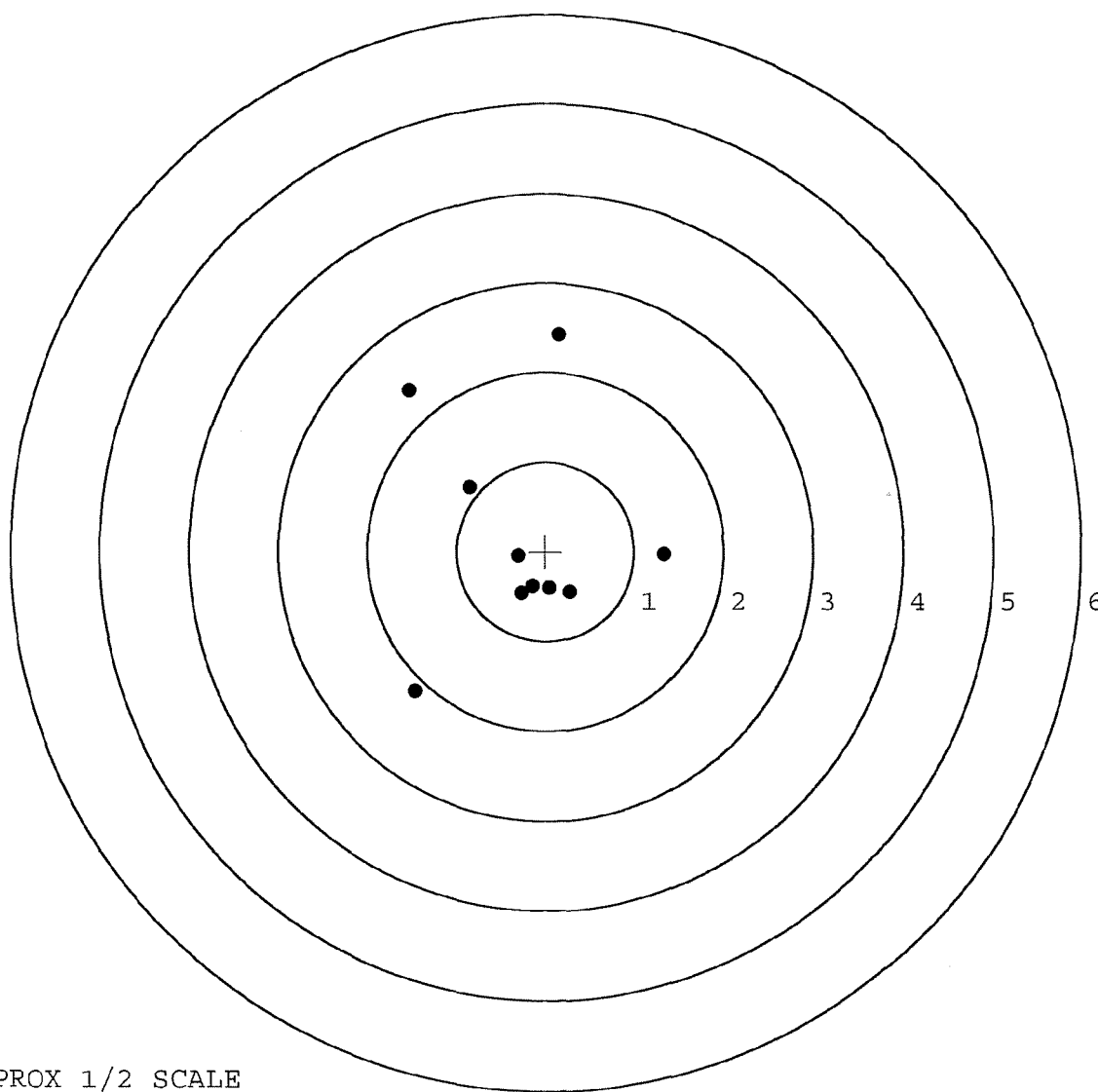
MAX RADIUS: 2.303

MEAN RADIUS: 1.177

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6288186. 0

TARGET NUMBER: 5

FILE DATE: 11/30/2004

FILE TIME: 11:03

X CENTROID: -0.262

Y CENTROID: 0.474

POA TO CENTROID: 0.542

HORZ SPREAD: 1.294

VERT SPREAD: 3.584

GROUP SPREAD: 3.635

MIN RADIUS: 0.349

MAX RADIUS: 1.908

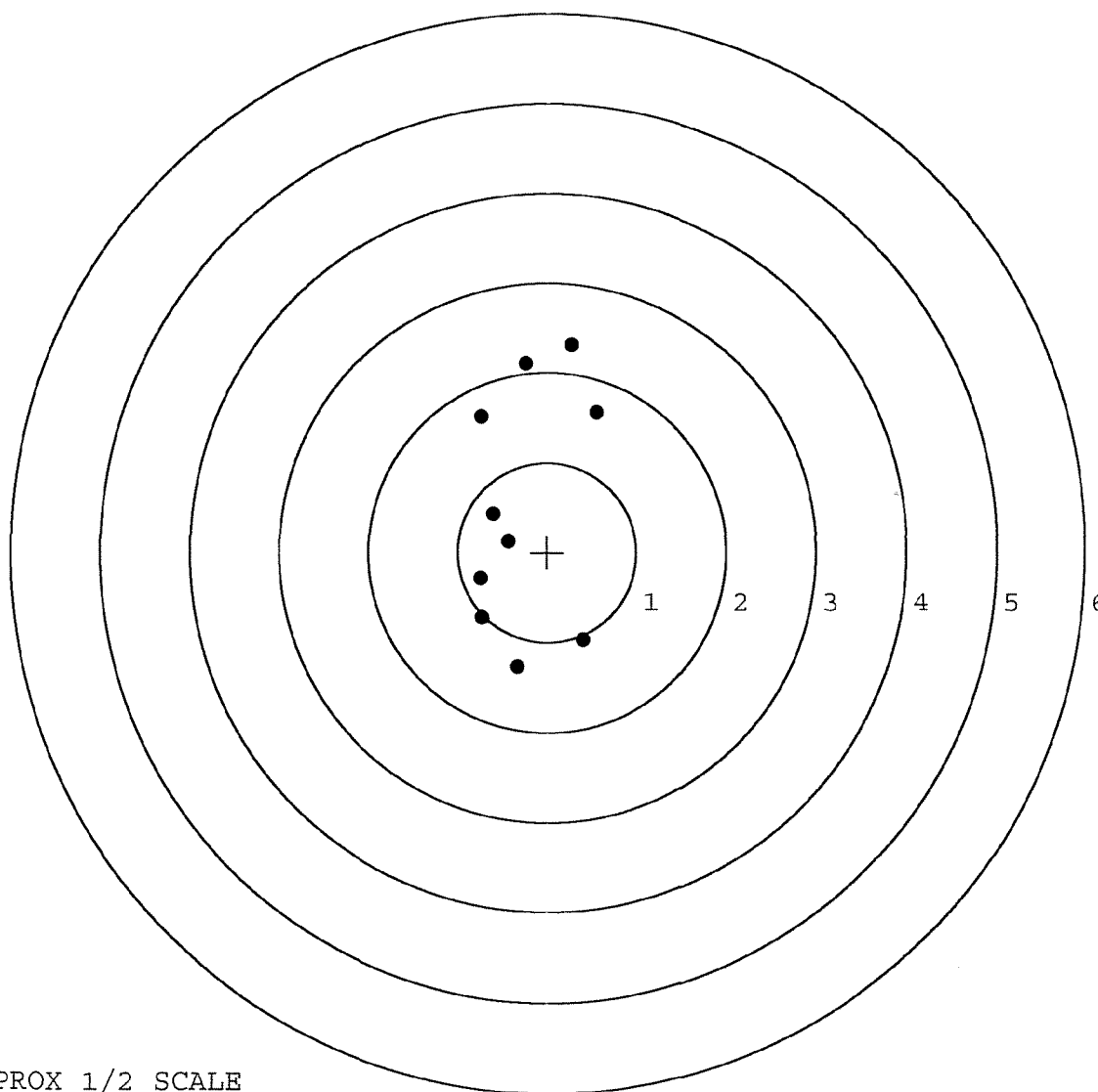
MEAN RADIUS: 1.231

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.609	0.430
2:	-0.437	0.122
3:	-0.743	-0.295
4:	-0.730	-0.727
5:	-0.334	-1.278
6:	0.405	-0.974
7:	0.273	2.306
8:	-0.253	2.094
9:	-0.745	1.512
10:	0.549	1.555



TARGET APPROX 1/2 SCALE