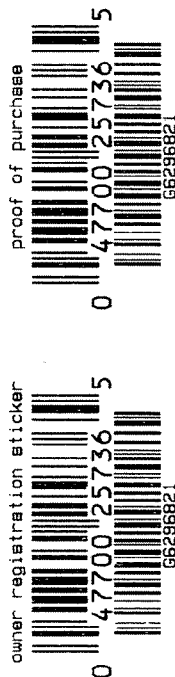


G-629 6821

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

- INSTRUCTION BOOK 3518

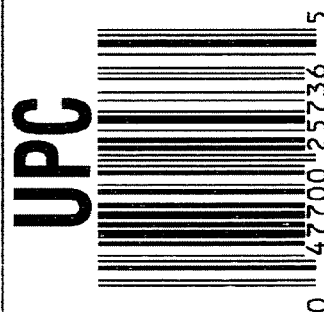
DD FORM 200348



ORDER NO. **25736**

BARREL LENGTH	24"
CAPACITY	5

G6296821



ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

300 WIN

GUN SERIAL # G6296821

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-31-05	RTZ
600	PROOF		1-31-05	RTZ
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 <i>[Signature]</i>		
615	ROLLMARK CALIBER		1-31-05	CW
617	DRILL AND TAP SIGHT HOLES		1-31-05	RTZ
620	APPLY COATINGS (BARREL ACTION)		2-1-05	<i>[Signature]</i>
	(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	5 lbs 5 lbs 5 lbs	2-23-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	3 lbs 3 lbs 3 lbs	2-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN			
	J) ASSEMBLE STOCK		2-21-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		2-24-05	AC
	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	2-22-05	AC
	MALFUNCTION JM	CORRECTION OK	2-22-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION NA		
	MALFUNCTION	CORRECTION	2-22-05	TRW
645	INSPECT FOR LIVE AMMO		2-22-05	TRW
655	FINAL INSPECTION A) HEADSPACE		2-23-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.93 2.90 2.96 2.98 2.99	2-23-05	TRW
	C) FUNCTION		2-23-05	AC
660	PACK		2-25-05	RA

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 2-14-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.36	2.02		2.34	
PULL #2	2.24	2.23		2.35	
PULL #3	2.16	2.34		2.28	
PULL #4	2.34	2.35		2.35	
PULL #5	2.24	2.39		2.44	
TOTAL	11.34	11.33		11.76	
AVERAGE	2.26	2.26		2.35	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.31		
PULL #2	3.39	3.07		
PULL #3	3.57	3.21		
PULL #4	3.35	3.32		
PULL #5	3.35	2.93		
TOTAL	17.03	15.84		
AVERAGE	3.40	3.16		

	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	4.30	4.06		4.30
PULL #2	4.37	4.09		4.29
PULL #3	4.24	4.15		4.16
PULL #4	4.23	4.14		4.23
PULL #5	3.72	4.00		4.31
TOTAL	20.86	20.44		21.29
AVERAGE	4.17	4.08		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6296821.___0
FILE DATE AND TIME: 02/22/2005 10:58

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.093
The Average Y Centroid of the Five Target Set:	-0.097
The Average Point of Impact of the Five Target Set:	0.134
The Average Mean Radius of the Five Target Set:	1.003
The Distance from POA to Centroid Target #1:	0.352
The Distance from Centroid Target #2 to Centroid Target #1:	0.250
The Distance from Centroid Target #3 to Centroid Target #1:	0.328
The Distance from Centroid Target #4 to Centroid Target #1:	0.412
The Distance from Centroid Target #5 to Centroid Target #1:	0.314

SERIAL NUMBER: G6296821. __0

TARGET NUMBER: 1

FILE DATE: 02/22/2005

FILE TIME: 10:58

X CENTROID: 0.347

Y CENTROID: -0.058

POA TO CENTROID: 0.352

HORZ SPREAD: 4.171

VERT SPREAD: 3.985

GROUP SPREAD: 4.987

MIN RADIUS: 0.264

MAX RADIUS: 2.606

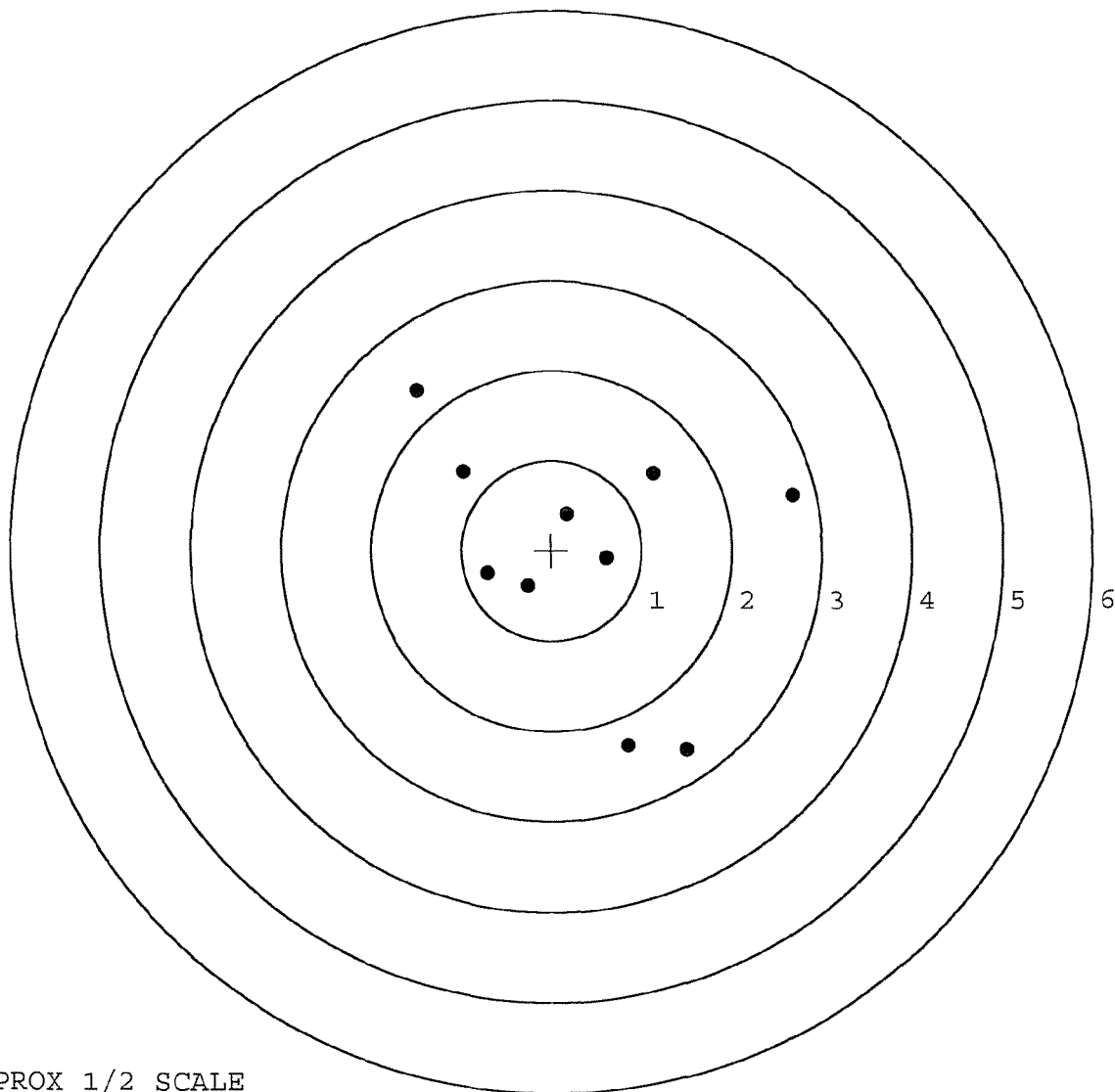
MEAN RADIUS: 1.498

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 5

POINT#	X	Y
1:	1.130	0.856
2:	0.610	-0.086
3:	0.169	0.401
4:	-0.266	-0.396
5:	-0.708	-0.252
6:	-0.975	0.876
7:	-1.499	1.781
8:	2.672	0.607
9:	1.499	-2.204
10:	0.841	-2.166

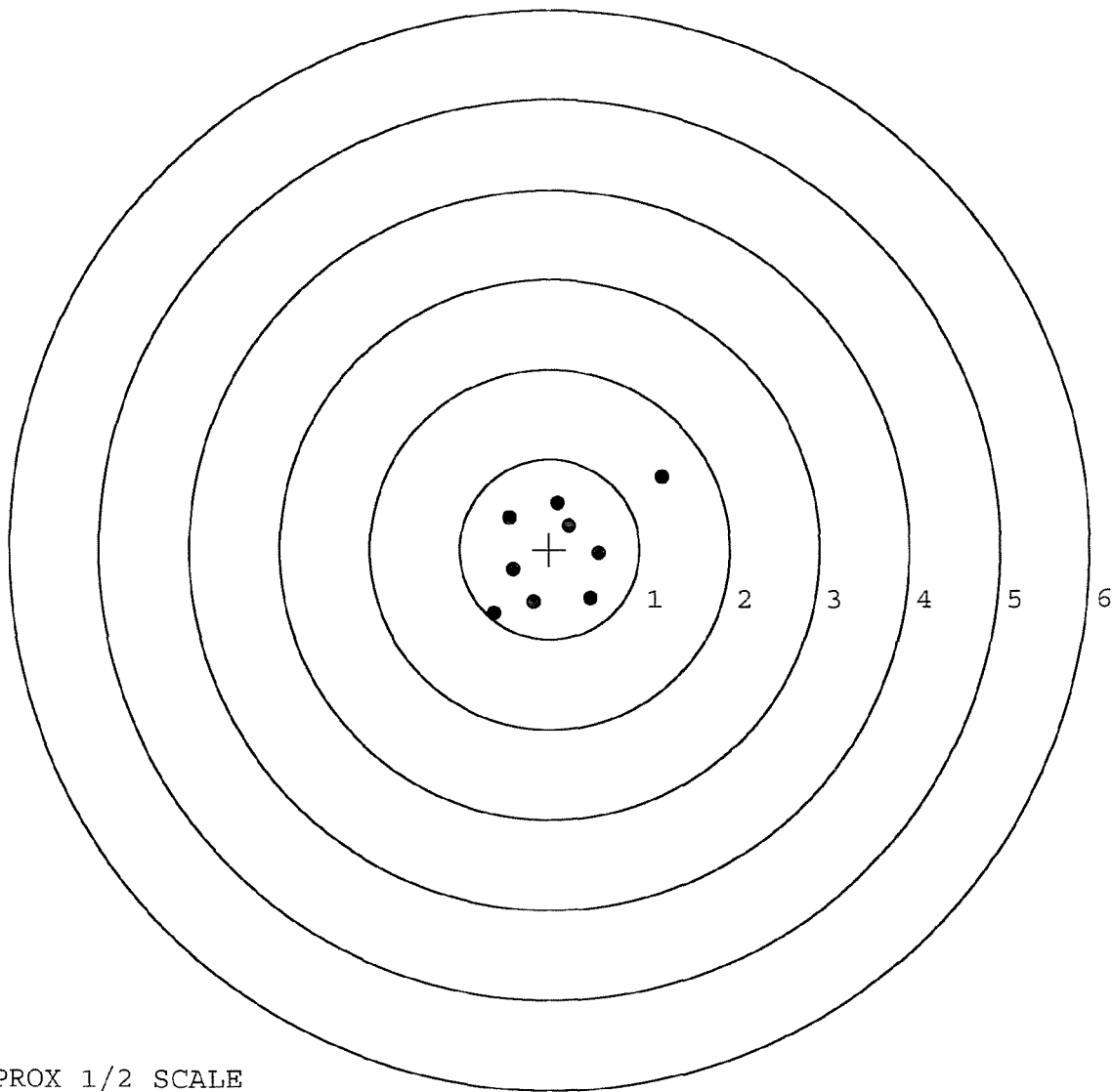


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296821. __0
TARGET NUMBER: 2
FILE DATE: 02/22/2005
FILE TIME: 10:58

POINT#	X	Y
1:	1.248	0.806
2:	0.454	-0.540
3:	0.550	-0.043
4:	0.219	0.265
5:	0.087	0.515
6:	-0.448	0.360
7:	-0.402	-0.225
8:	-0.182	-0.588
9:	-0.624	-0.710

X CENTROID: 0.100
Y CENTROID: -0.018
POA TO CENTROID: 0.102
HORZ SPREAD: 1.872
VERT SPREAD: 1.516
GROUP SPREAD: 2.409
MIN RADIUS: 0.307
MAX RADIUS: 1.413
MEAN RADIUS: 0.687
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296821. __0

TARGET NUMBER: 3

FILE DATE: 02/22/2005

FILE TIME: 10:58

POINT#	X	Y
1:	1.703	-0.705
2:	0.571	-1.087
3:	0.552	0.023
4:	0.065	0.425
5:	0.486	1.064
6:	-0.163	1.092
7:	-0.206	-0.162
8:	-0.462	-0.311
9:	-1.150	-0.507
10:	-1.181	-0.756

X CENTROID: 0.021

Y CENTROID: -0.092

POA TO CENTROID: 0.095

HORZ SPREAD: 2.884

VERT SPREAD: 2.179

GROUP SPREAD: 2.884

MIN RADIUS: 0.238

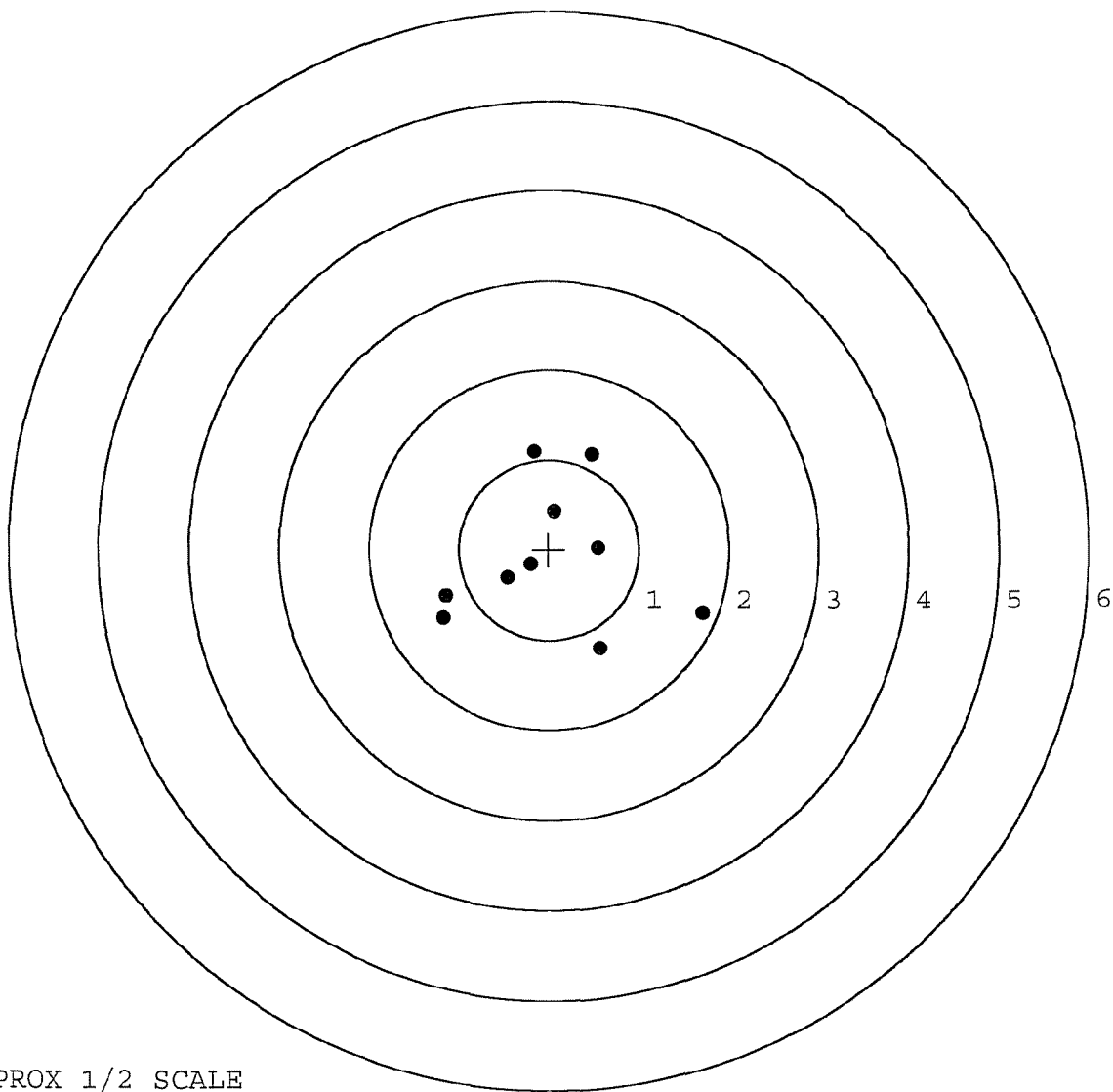
MAX RADIUS: 1.790

MEAN RADIUS: 0.982

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

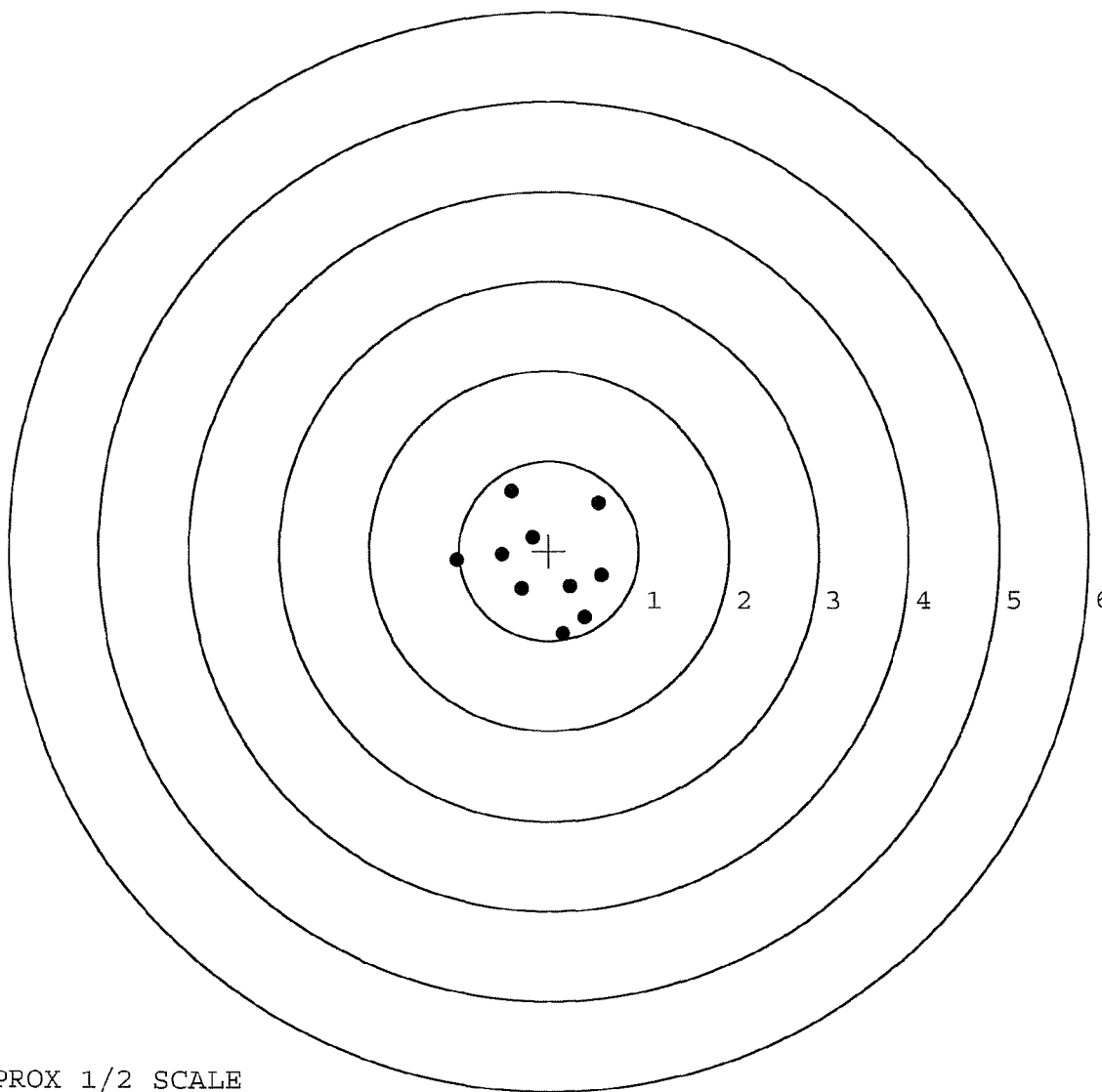


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296821. __ 0
TARGET NUMBER: 4
FILE DATE: 02/22/2005
FILE TIME: 10:58

POINT#	X	Y
1:	0.159	-0.928
2:	0.399	-0.741
3:	0.236	-0.405
4:	0.586	-0.274
5:	0.551	0.539
6:	-0.416	0.663
7:	-0.186	0.152
8:	-0.525	-0.044
9:	-0.305	-0.431
10:	-1.024	-0.112

X CENTROID: -0.052
Y CENTROID: -0.158
POA TO CENTROID: 0.167
HORZ SPREAD: 1.610
VERT SPREAD: 1.591
GROUP SPREAD: 1.704
MIN RADIUS: 0.338
MAX RADIUS: 0.973
MEAN RADIUS: 0.655
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

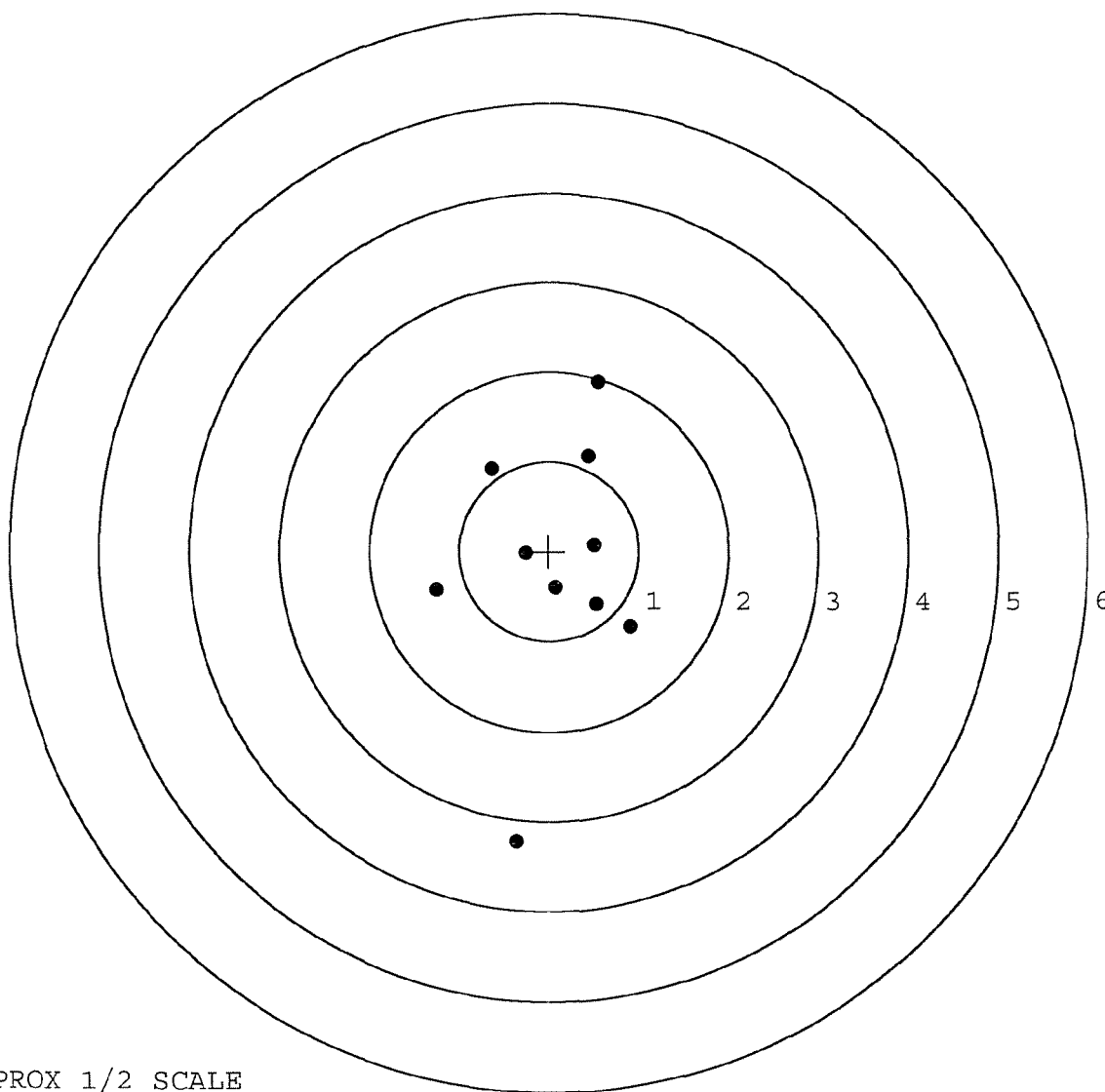


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296821. __0
TARGET NUMBER: 5
FILE DATE: 02/22/2005
FILE TIME: 10:58

X CENTROID: 0.049
Y CENTROID: -0.157
POA TO CENTROID: 0.165
HORZ SPREAD: 2.156
VERT SPREAD: 5.118
GROUP SPREAD: 5.199
MIN RADIUS: 0.253
MAX RADIUS: 3.098
MEAN RADIUS: 1.195
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.901	-0.845
2:	0.528	-0.587
3:	0.511	0.076
4:	0.075	-0.409
5:	-0.256	-0.026
6:	-1.255	-0.436
7:	-0.639	0.925
8:	0.441	1.065
9:	0.550	1.891
10:	-0.366	-3.227



TARGET APPROX 1/2 SCALE