

G6296860

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

— INSTRUCTION BOOK 3518

DD FORM 200348

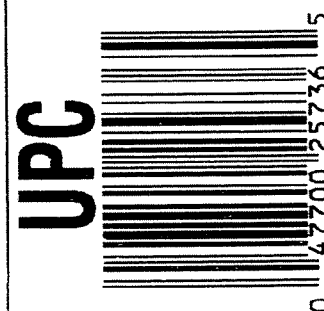


ORDER NO. 25736

BARREL LENGTH 24"

CAPACITY 5

G6296860



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 # G6296860

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 		
615	ROLLMARK CALIBER		1-31-05	CW
617	DRILL AND TAP SIGHT HOLES		1-31-05	TRW
620	APPLY COATINGS (BARREL ACTION)		2/1/05	4/10
	(BOLT)		2/1/05	
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>7 lbs</u> <u>7 lbs</u> <u>7 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> FAIL	2-27-05	Ac
	MALFUNCTION <i>JM</i>	CORRECTION <i>OK</i>	2-27-05	Ac
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>NA</i>		
	MALFUNCTION	CORRECTION		
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	<u>2.50</u> <u>2.48</u> <u>2.45</u> <u>2.41</u> <u>2.46</u>	2-23-05	TRW
	C) FUNCTION		2-23-05	Ac
660	PACK		2-25-05	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	2.70	2.62		2.49	
PULL #2	2.71	2.60		2.41	
PULL #3	2.60	2.58		2.45	
PULL #4	2.61	2.53		2.42	
PULL #5	2.67	2.59		2.44	
TOTAL	13.29	12.92		12.21	
AVERAGE	2.65	2.58		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.35		
PULL #2	3.41	3.40		
PULL #3	3.44	3.37		
PULL #4	3.42	3.37		
PULL #5	3.43	3.33		
TOTAL	17.15	16.82		
AVERAGE	3.43	3.36		

	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	4.25	4.30		4.36
PULL #2	4.41	4.32		4.16
PULL #3	4.38	4.20		3.98
PULL #4	4.32	4.33		4.31
PULL #5	4.40	4.33		4.30
TOTAL	21.76	21.48		21.11
AVERAGE	4.35	4.29		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6296860.___0

FILE DATE AND TIME: 02/22/2005 10:40

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	-0.063
The Average Point of Impact of the Five Target Set:	0.067
The Average Mean Radius of the Five Target Set:	0.951
The Distance from POA to Centroid Target #1:	0.275
The Distance from Centroid Target #2 to Centroid Target #1:	0.184
The Distance from Centroid Target #3 to Centroid Target #1:	0.334
The Distance from Centroid Target #4 to Centroid Target #1:	0.436
The Distance from Centroid Target #5 to Centroid Target #1:	0.344

SERIAL NUMBER: G6296860. __0

TARGET NUMBER: 1

FILE DATE: 02/22/2005

FILE TIME: 10:40

POINT#	X	Y
1:	1.401	-1.900
2:	0.368	-1.490
3:	-0.544	-0.783
4:	-0.540	-0.390
5:	-0.197	-0.062
6:	-0.727	0.560
7:	0.899	0.729
8:	0.393	0.804
9:	0.778	0.398
10:	0.619	0.882

X CENTROID: 0.245

Y CENTROID: -0.125

POA TO CENTROID: 0.275

HORZ SPREAD: 2.128

VERT SPREAD: 2.782

GROUP SPREAD: 3.253

MIN RADIUS: 0.446

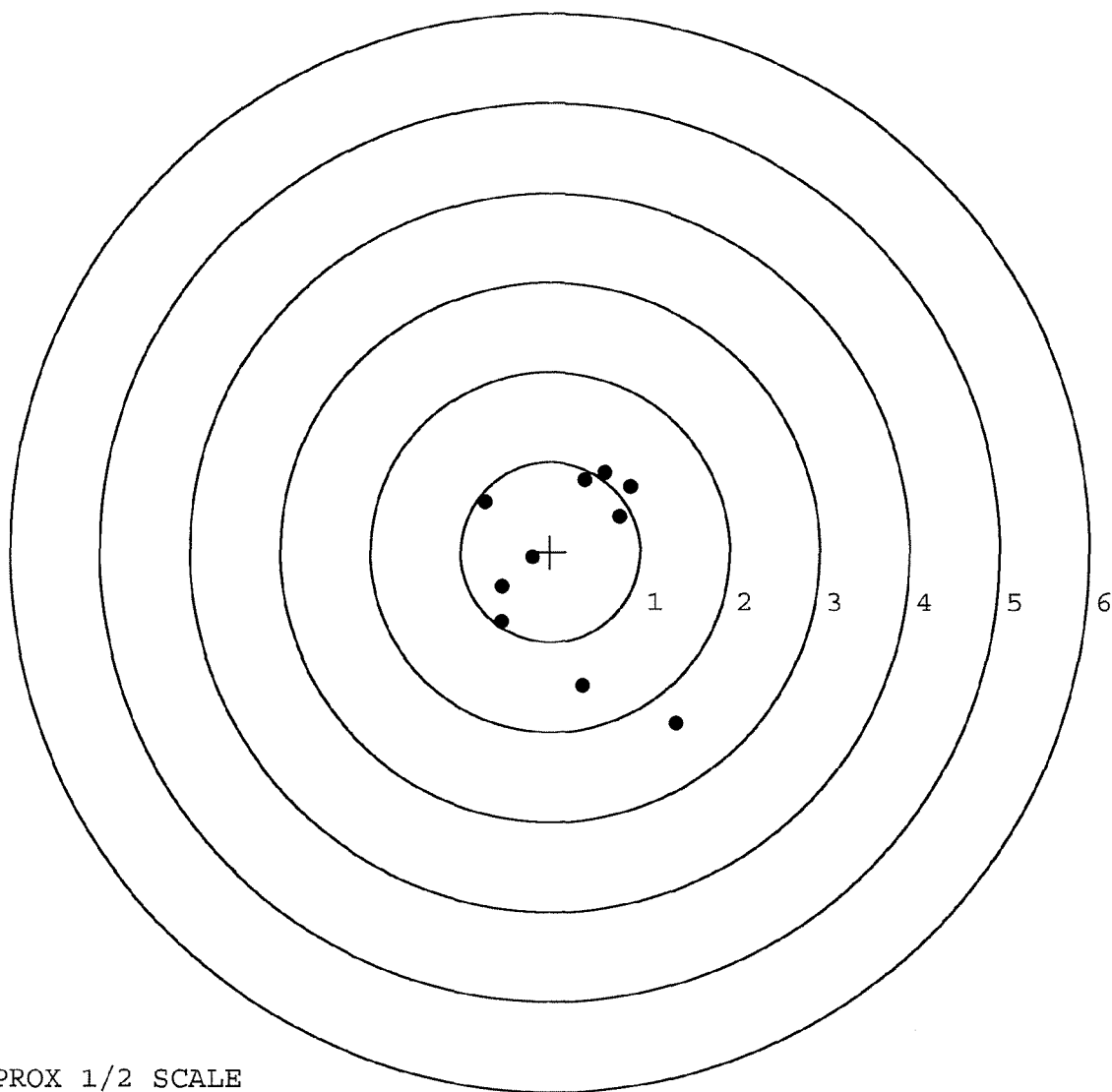
MAX RADIUS: 2.118

MEAN RADIUS: 1.082

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296860.____0

TARGET NUMBER: 2

FILE DATE: 02/22/2005

FILE TIME: 10:40

X CENTROID: 0.133

Y CENTROID: -0.271

POA TO CENTROID: 0.302

HORZ SPREAD: 1.712

VERT SPREAD: 2.748

GROUP SPREAD: 3.049

MIN RADIUS: 0.172

MAX RADIUS: 1.744

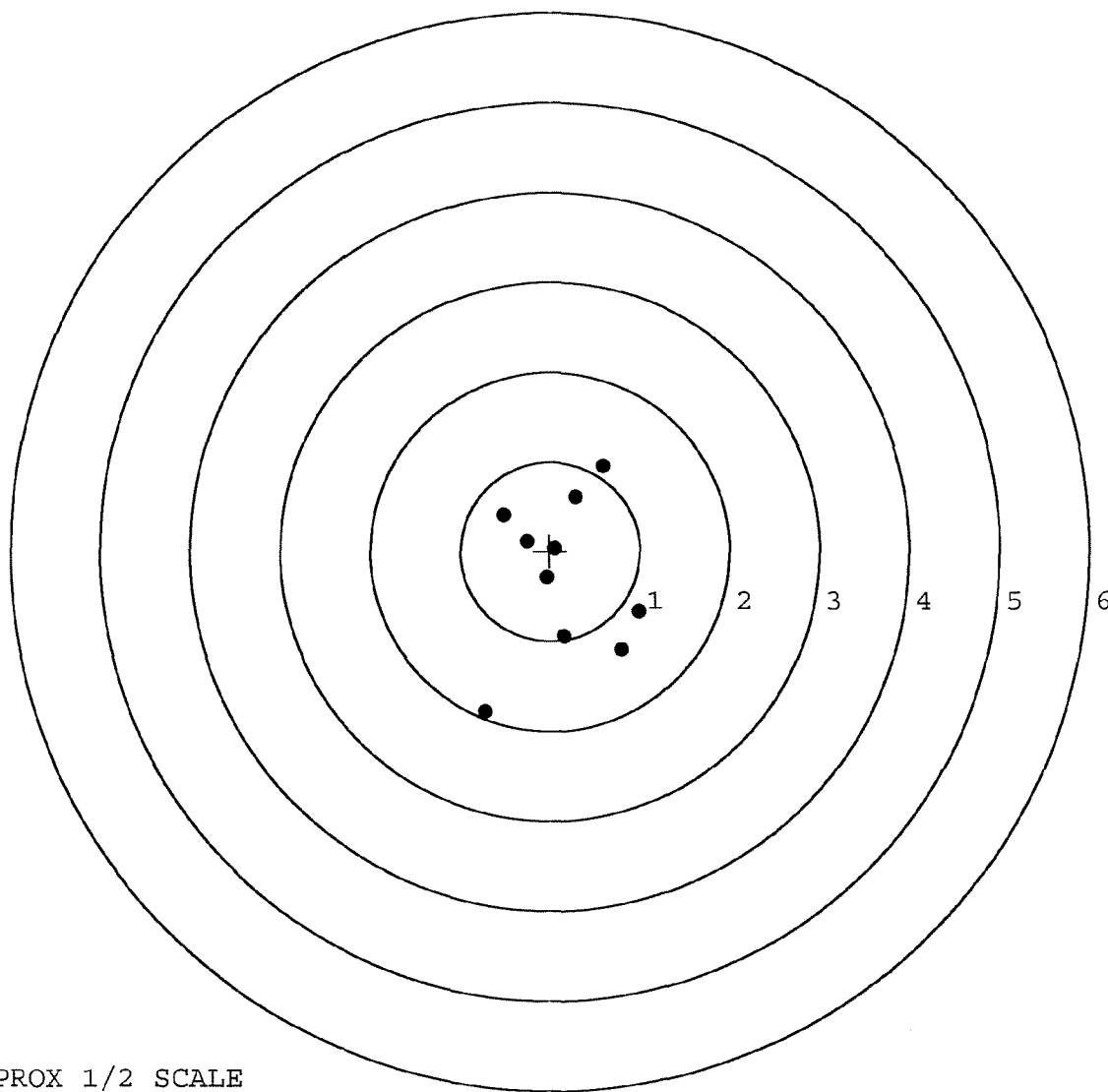
MEAN RADIUS: 0.863

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.988	-0.680
2:	0.797	-1.106
3:	0.155	-0.958
4:	-0.724	-1.791
5:	-0.038	-0.295
6:	0.055	0.031
7:	-0.265	0.113
8:	-0.521	0.404
9:	0.284	0.610
10:	0.597	0.957



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296860. __0

TARGET NUMBER: 3

FILE DATE: 02/22/2005

FILE TIME: 10:40

POINT#	X	Y
1:	0.885	-1.104
2:	0.530	-0.969
3:	0.358	-0.382
4:	-0.345	-0.106
5:	-0.845	-0.701
6:	0.484	0.315
7:	0.390	0.852
8:	-0.238	0.724
9:	-0.977	1.505
10:	-0.402	0.693

X CENTROID: -0.016

Y CENTROID: 0.083

POA TO CENTROID: 0.084

HORZ SPREAD: 1.862

VERT SPREAD: 2.609

GROUP SPREAD: 3.205

MIN RADIUS: 0.379

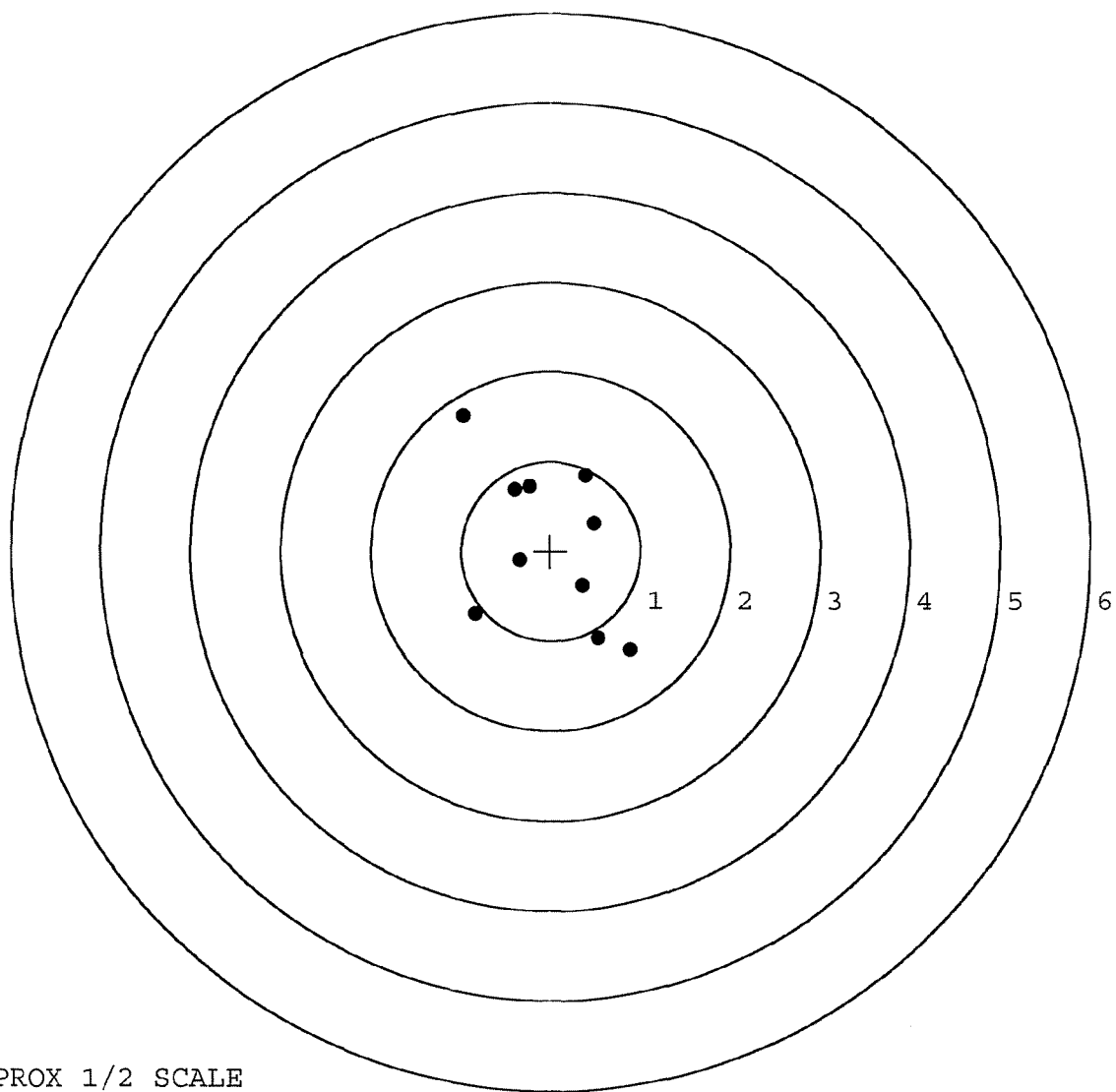
MAX RADIUS: 1.717

MEAN RADIUS: 0.933

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296860. 0

TARGET NUMBER: 4

FILE DATE: 02/22/2005

FILE TIME: 10:40

X CENTROID: -0.178

Y CENTROID: -0.019

POA TO CENTROID: 0.179

HORZ SPREAD: 2.424

VERT SPREAD: 2.411

GROUP SPREAD: 2.824

MIN RADIUS: 0.472

MAX RADIUS: 1.576

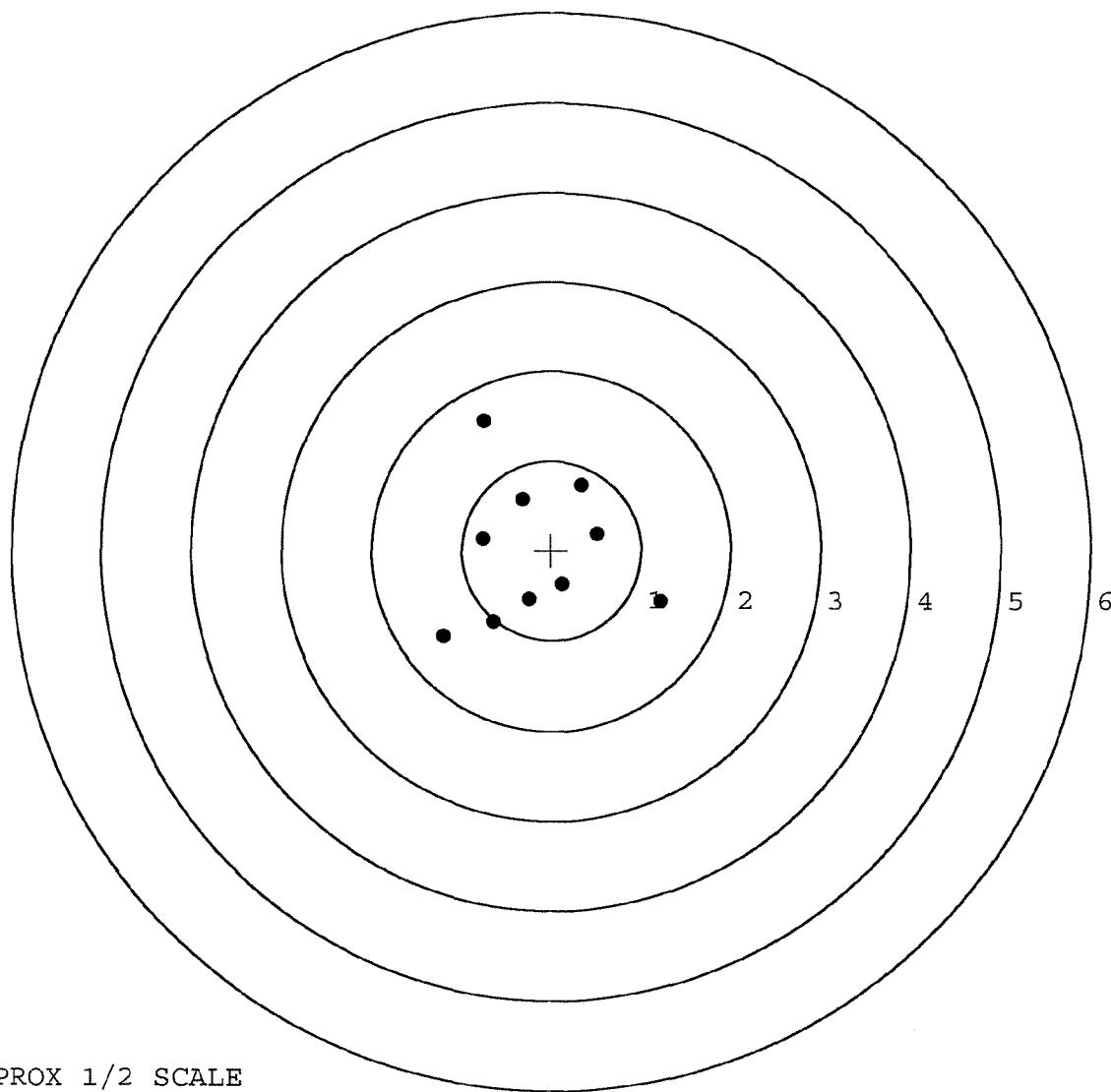
MEAN RADIUS: 0.925

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.218	-0.568
2:	0.510	0.192
3:	0.335	0.736
4:	-0.323	0.573
5:	-0.770	0.131
6:	0.122	-0.383
7:	-0.252	-0.547
8:	-0.651	-0.801
9:	-1.206	-0.967
10:	-0.764	1.444



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6296860. __0

TARGET NUMBER: 5

FILE DATE: 02/22/2005

FILE TIME: 10:40

POINT#	X	Y
1:	0.374	-1.201
2:	-0.225	-0.830
3:	-0.409	-0.308
4:	0.058	0.015
5:	0.297	0.229
6:	1.159	0.229
7:	1.294	0.968
8:	-0.458	0.372
9:	-0.758	0.705
10:	-2.012	-0.007

X CENTROID: -0.068

Y CENTROID: 0.017

POA TO CENTROID: 0.070

HORZ SPREAD: 3.306

VERT SPREAD: 2.169

GROUP SPREAD: 3.447

MIN RADIUS: 0.126

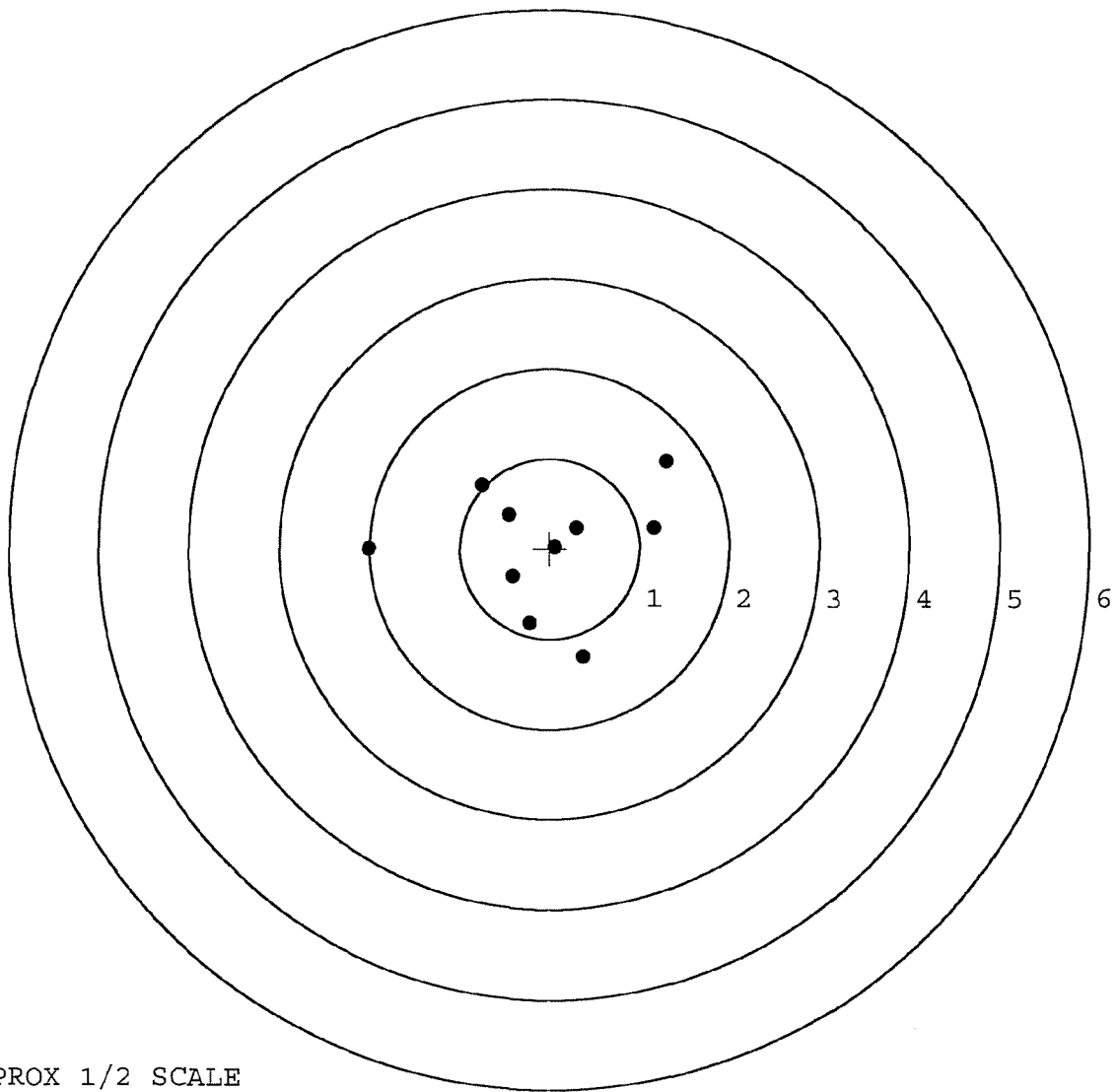
MAX RADIUS: 1.944

MEAN RADIUS: 0.953

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE