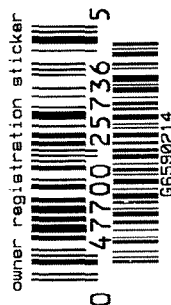


G 6590214

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

- INSTRUCTION BOOK 3518

BM FORM 200348



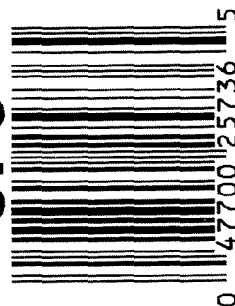
ORDER NO. 25736

BARREL LENGTH 24"

CAPACITY 5

G6590214

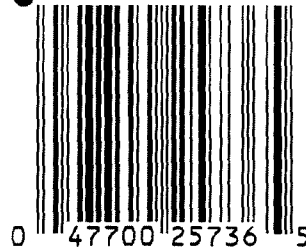
UPC



ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC

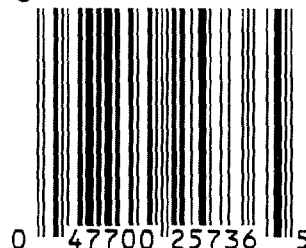


0 47700 25736 5

ORDER 25736

M/24 .300 WIN MAG (RIFLE ONLY)

UPC



0 47700 25736 5

SERIAL NO.



66590214

M-24
INSPECTION CHECKLIST-NEW GUNS

300 Win

GUN SERIAL # E6590214

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		11-30-07	RZ
420	ASSEMBLE ACTION		11-30-07	RZ
430	ASSEMBLE TO STOCK		11-30-07	TRW
440	PROOF		11-30-07	TRW
460	CHECK HEADSPACE		11-30-07	TRW
470	DIS-ASSEMBLE ACTION		11-30-07	LPD
480	MAGNAFLUX BBL ACTION			
490	MAGNAFLUX BOLT		12-04-07	JB
500	ROLLMARK CALIBER		12-30-07	CW
510	DRILL AND TAP SIGHT HOLES		12-3-07	TRW
520	GOFF BLAST BBL / REC		12-5-07	YH
530 & 540	APPLY COATINGS (BARREL ACTION)		12-8-07	CM
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-10-07	RZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-10-07	RZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-10-07	RZ
	D) OIL FIRING PIN ASSEMBLY		12-10-07	RZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>625</u> <u>65</u> <u>65</u>	12/20/07	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	12/20/07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	12-12-07	DA
	J) ASSEMBLE STOCK		12-10-07	FL
	K) ASSEMBLE SWIVEL STUDS			
	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	PASS FAIL <u>PASS</u> FAIL	12-10-07	TRW
	MALFUNCTION <i>shell jumps mag.</i>	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-10-07	Fm
670	FINAL INSPECTION A) HEADSPACE		12/20/07	DA
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.54</u> <u>2.41</u> <u>2.54</u> <u>2.58</u>	12/20/07	DA
	C) FUNCTION			
690	PACK		12/12/07	DA

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590214.__0

FILE DATE AND TIME: 12/10/2007 13:57

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.016
The Average Y Centroid of the Five Target Set:	0.067
The Average Point of Impact of the Five Target Set:	0.069
The Average Mean Radius of the Five Target Set:	0.871
The Distance from POA to Centroid Target #1:	0.109
The Distance from Centroid Target #2 to Centroid Target #1:	0.162
The Distance from Centroid Target #3 to Centroid Target #1:	0.209
The Distance from Centroid Target #4 to Centroid Target #1:	0.450
The Distance from Centroid Target #5 to Centroid Target #1:	0.282

SERIAL NUMBER: G6590214. 0

TARGET NUMBER: 1

FILE DATE: 12/10/2007

FILE TIME: 13:57

POINT#	X	Y
--------	---	---

1:	0.721	-1.207
----	-------	--------

2:	0.872	-0.899
----	-------	--------

3:	-0.704	-0.742
----	--------	--------

4:	0.420	-0.131
----	-------	--------

5:	-0.086	-0.003
----	--------	--------

6:	0.015	0.232
----	-------	-------

7:	-0.119	0.907
----	--------	-------

8:	-0.369	0.610
----	--------	-------

9:	-0.806	0.393
----	--------	-------

10:	-0.791	0.161
-----	--------	-------

X CENTROID: -0.085

Y CENTROID: -0.068

POA TO CENTROID: 0.109

HORZ SPREAD: 1.678

VERT SPREAD: 2.114

GROUP SPREAD: 2.275

MIN RADIUS: 0.065

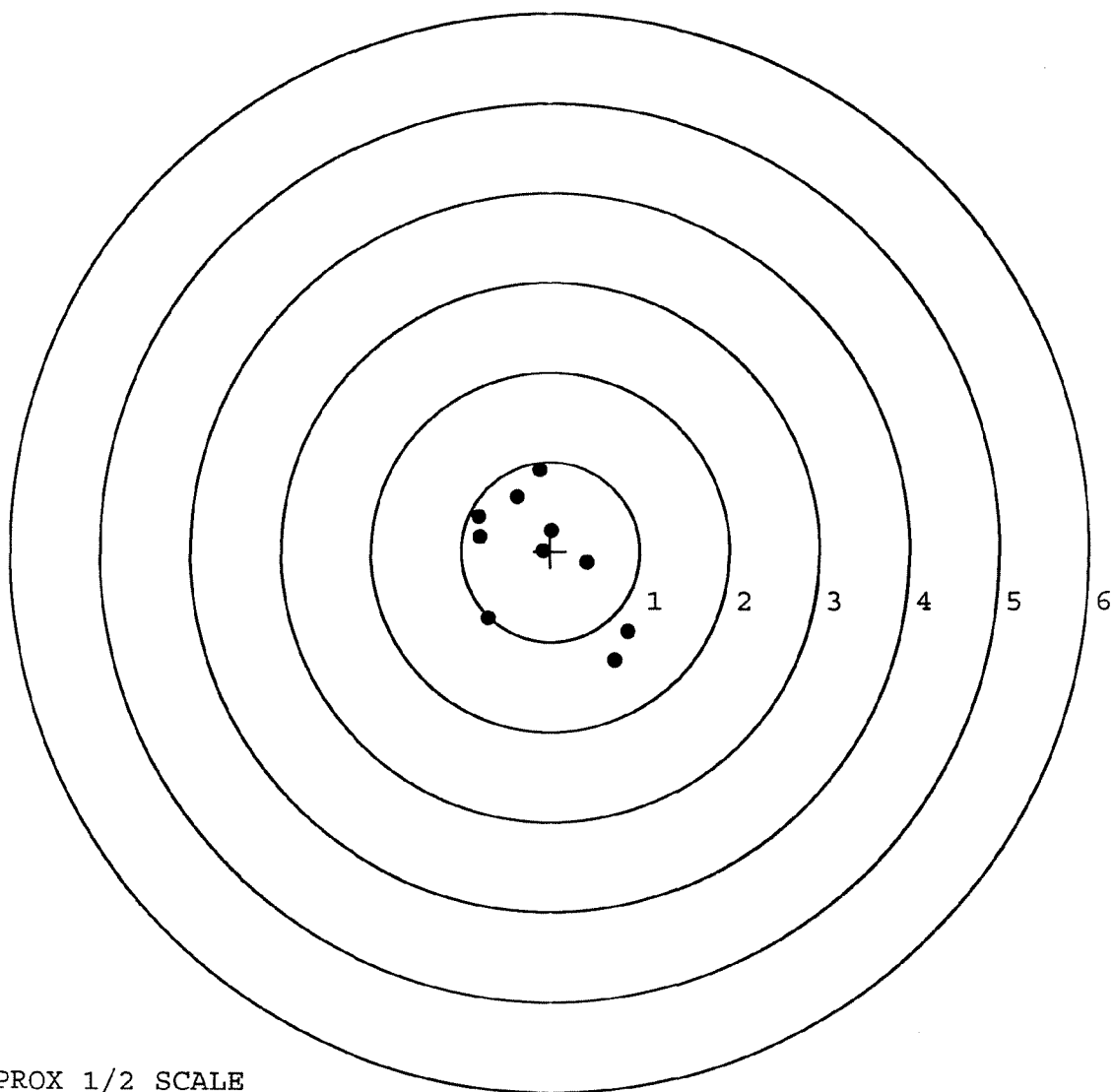
MAX RADIUS: 1.395

MEAN RADIUS: 0.778

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

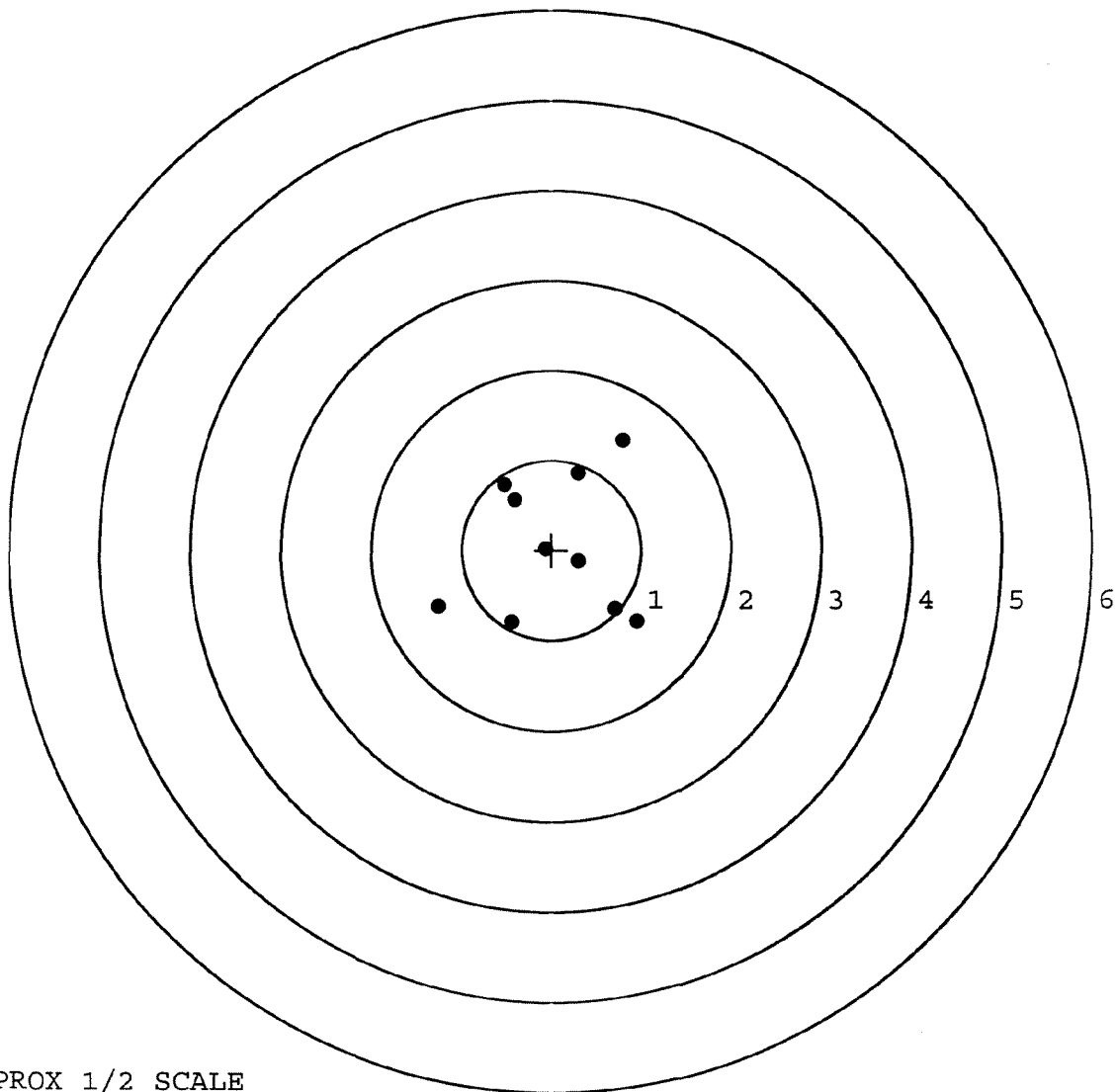


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590214.___0
TARGET NUMBER: 2
FILE DATE: 12/10/2007
FILE TIME: 13:57

POINT#	X	Y
1:	0.803	1.225
2:	0.305	0.858
3:	-0.525	0.729
4:	-0.409	0.565
5:	-0.069	0.008
6:	0.311	-0.128
7:	-1.254	-0.632
8:	-0.447	-0.801
9:	0.959	-0.796
10:	0.712	-0.657

X CENTROID: 0.039
Y CENTROID: 0.037
POA TO CENTROID: 0.054
HORZ SPREAD: 2.213
VERT SPREAD: 2.026
GROUP SPREAD: 2.771
MIN RADIUS: 0.111
MAX RADIUS: 1.456
MEAN RADIUS: 0.892
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590214. 0

TARGET NUMBER: 3

FILE DATE: 12/10/2007

FILE TIME: 13:57

POINT#	X	Y
1:	0.873	-0.857
2:	0.776	-0.444
3:	0.733	-0.186
4:	1.209	-0.058
5:	-0.939	1.386
6:	-0.511	1.427
7:	0.032	0.809
8:	-0.408	0.446
9:	-1.046	-0.395
10:	-0.894	-0.825

X CENTROID: -0.018

Y CENTROID: 0.130

POA TO CENTROID: 0.131

HORZ SPREAD: 2.255

VERT SPREAD: 2.284

GROUP SPREAD: 2.883

MIN RADIUS: 0.502

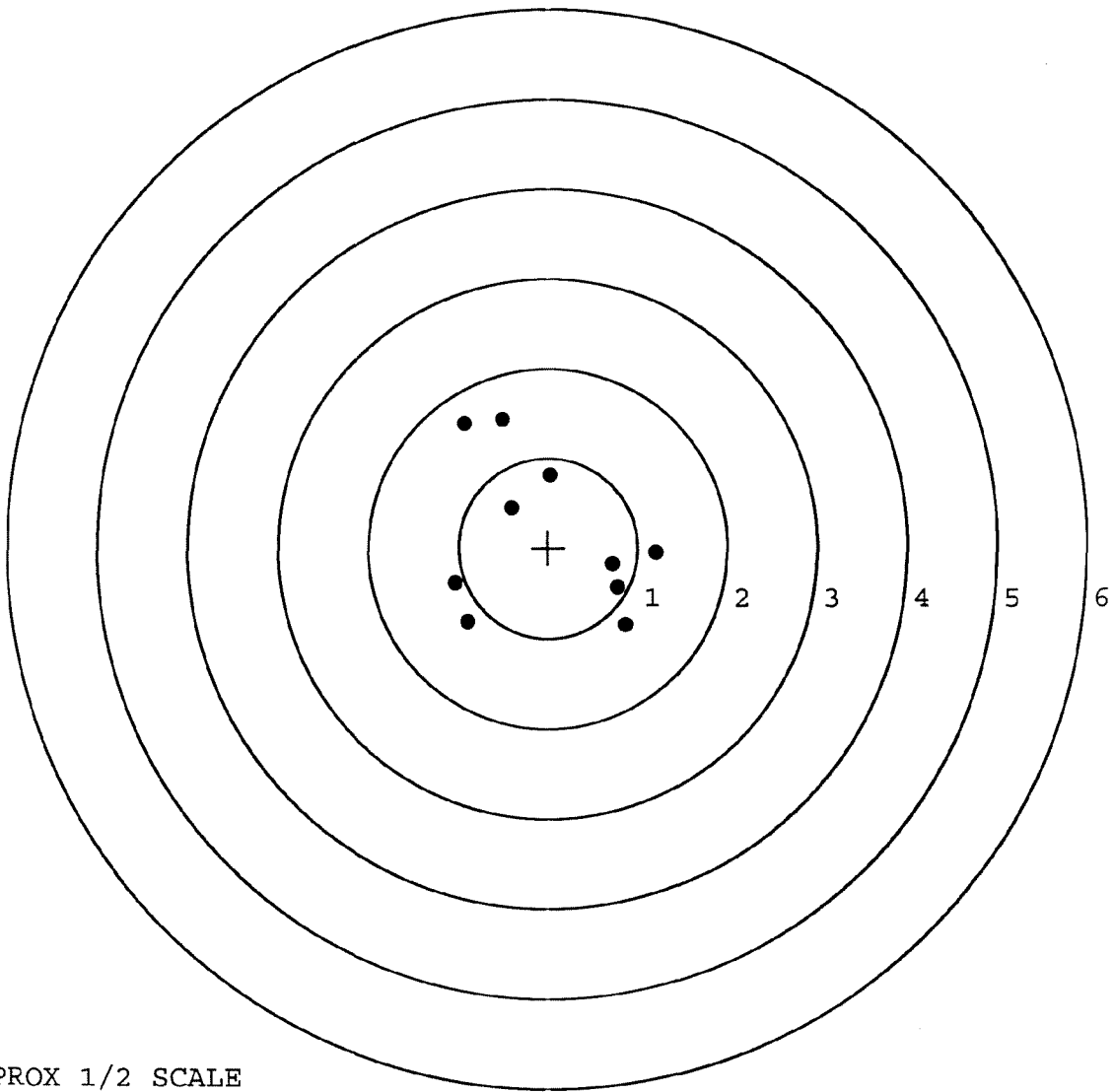
MAX RADIUS: 1.558

MEAN RADIUS: 1.094

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

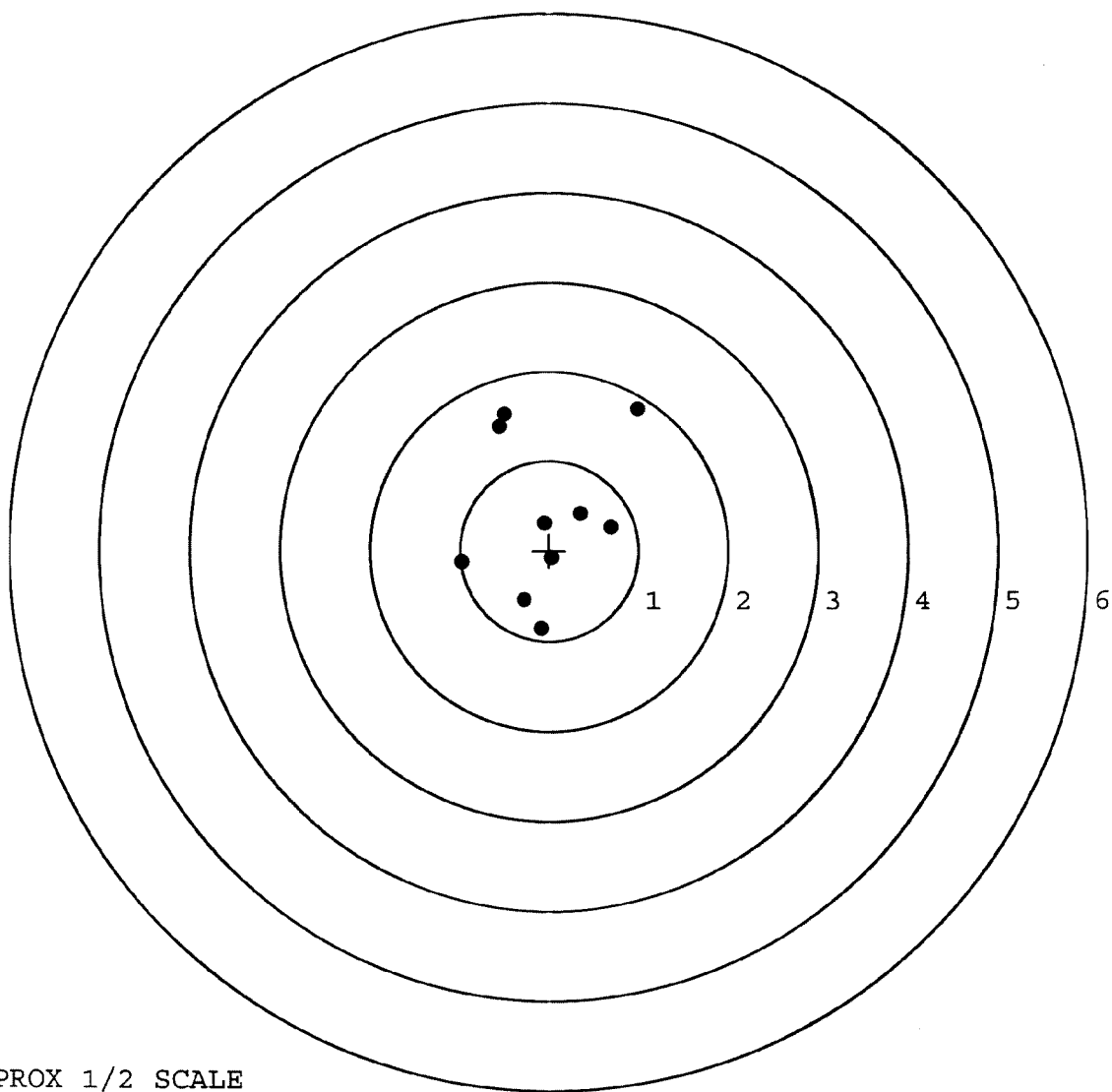


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590214. __0
TARGET NUMBER: 4
FILE DATE: 12/10/2007
FILE TIME: 13:57

POINT#	X	Y
1:	-0.985	-0.130
2:	-0.091	-0.872
3:	-0.283	-0.548
4:	0.032	-0.085
5:	0.698	0.255
6:	0.350	0.411
7:	-0.060	0.301
8:	0.987	1.577
9:	-0.503	1.518
10:	-0.565	1.374

X CENTROID: -0.042
Y CENTROID: 0.380
POA TO CENTROID: 0.382
HORZ SPREAD: 1.972
VERT SPREAD: 2.449
GROUP SPREAD: 2.676
MIN RADIUS: 0.081
MAX RADIUS: 1.578
MEAN RADIUS: 0.891
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590214. 0

TARGET NUMBER: 5

FILE DATE: 12/10/2007

FILE TIME: 13:57

POINT#	X	Y
--------	---	---

1:	-0.492	0.630
----	--------	-------

2:	0.041	0.951
----	-------	-------

3:	0.791	0.598
----	-------	-------

4:	0.756	-0.470
----	-------	--------

5:	0.357	-1.280
----	-------	--------

6:	0.052	-1.011
----	-------	--------

7:	0.011	-0.503
----	-------	--------

8:	0.339	-0.350
----	-------	--------

9:	0.046	-0.214
----	-------	--------

10:	-0.033	0.205
-----	--------	-------

X CENTROID: 0.187

Y CENTROID: -0.144

POA TO CENTROID: 0.236

HORZ SPREAD: 1.283

VERT SPREAD: 2.231

GROUP SPREAD: 2.253

MIN RADIUS: 0.157

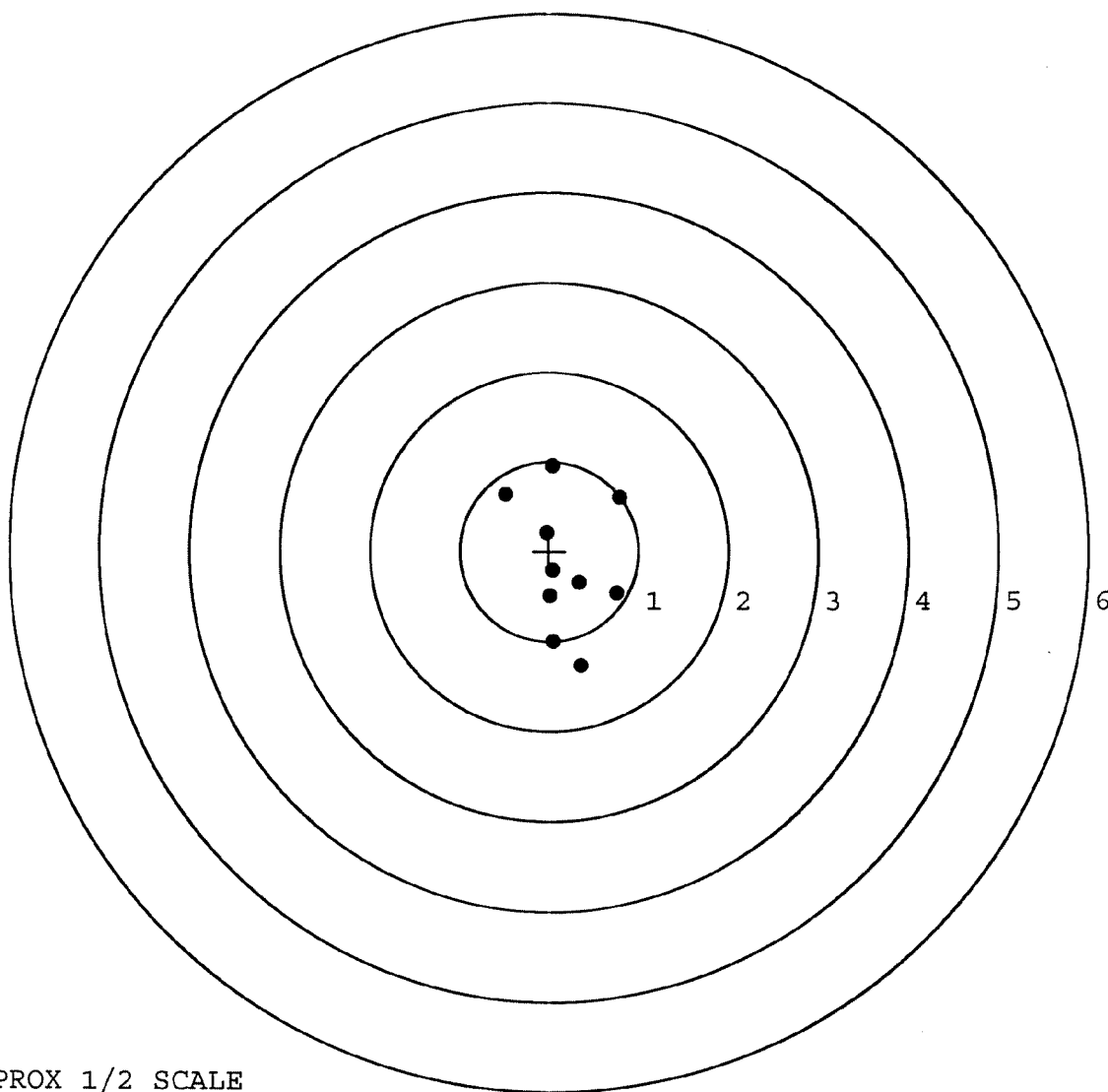
MAX RADIUS: 1.148

MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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 11-27-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.47		2.74	
PULL #2	2.44	2.67		2.75	
PULL #3	2.56	2.85		2.83	
PULL #4	2.48	2.60		2.91	
PULL #5	2.54	2.89		2.84	
TOTAL	12.56	13.48		14.07	
AVERAGE	2.51	2.69		2.81	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.45	3.45		
PULL #2	3.40	3.36		
PULL #3	3.18	3.36		
PULL #4	3.33	3.40		
PULL #5	3.50	3.37		
TOTAL	16.86	16.94		
AVERAGE	3.37	3.38		

	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	4.26		4.08
PULL #2	4.22	3.74		4.23
PULL #3	4.19	4.18		4.14
PULL #4	4.08	4.12		3.98
PULL #5	4.24	4.17		4.15
TOTAL	21.03	20.47		20.58
AVERAGE	4.20	4.09		4.11