

G6577091

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



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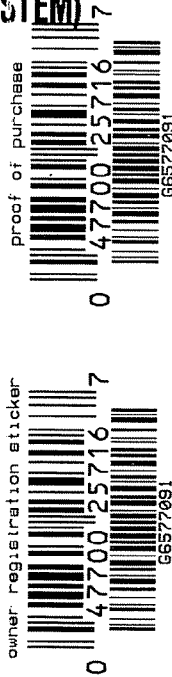
SERIAL NO.



M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6577091



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577091

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-3-06	BLG
420	ASSEMBLE ACTION		8-3-06	BLG
430	ASSEMBLE TO STOCK		8-4-06	DK
440	PROOF	MAGNA-FLUX INSPECTED	8-4-06	BLG
460	CHECK HEADSPACE	AUG 14 2006	8-4-06	BLG
470	DIS-ASSEMBLE ACTION	OPERATOR <u>APD</u>	8-4-06	APD
480	MAGNAFLUX BBL ACTION			
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-14-06	CU
510	DRILL AND TAP SIGHT HOLES		8-11-06	TRW
520	GOFF BLAST BBL / REC		8-14-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/17/06	TB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		8-18-06	MDH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-18-06	MDH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-18-06	MDH
	D) OIL FIRING PIN ASSEMBLY		8-21-06	RTZ
	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>55</u> <u>60</u> <u>5.5</u>	8-22-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	8-22-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1026</u> <u>025</u> <u>1027</u>	8-22-06	RA
	J) ASSEMBLE STOCK		8-21-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-30-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-21-06	RTZ
	M) IRON SIGHT ALIGNMENT		8-21-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-21-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	8-21-06	L.P.S.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/21/06	MGD
670	FINAL INSPECTION A) HEADSPACE		8-30-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>261</u> <u>277</u> <u>279</u> <u>271</u> <u>271</u>	8/22/06	RP
	C) FUNCTION		8-30-06	RTZ
690	PACK		10-26-06	RA

F004 REV 5/2006

**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 8-14-06

 TESTER MJH

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.49	2.52		2.51	
PULL #2	2.45	2.64		2.55	
PULL #3	2.47	2.62		2.56	
PULL #4	2.60	2.63		2.58	
PULL #5	2.65	2.70		2.59	
TOTAL	12.66	13.11		12.76	
AVERAGE	2.53	2.62		2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.98	3.13		
PULL #2	3.01	3.03		
PULL #3	2.99	3.04		
PULL #4	2.98	3.23		
PULL #5	3.13	3.08		
TOTAL	15.09	15.51		
AVERAGE	3.02	3.10		

	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	3.96	3.94		4.00
PULL #2	3.93	3.91		4.09
PULL #3	4.01	3.93		4.07
PULL #4	3.97	3.96		4.04
PULL #5	3.93	3.91		4.01
TOTAL	19.80	19.65		20.21
AVERAGE	3.96	3.93		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577091.___0
FILE DATE AND TIME: 08/21/2006 19:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.045
The Average Y Centroid of the Five Target Set:	-0.016
The Average Point of Impact of the Five Target Set:	0.048
The Average Mean Radius of the Five Target Set:	0.994
The Distance from POA to Centroid Target #1:	0.105
The Distance from Centroid Target #2 to Centroid Target #1:	0.183
The Distance from Centroid Target #3 to Centroid Target #1:	0.156
The Distance from Centroid Target #4 to Centroid Target #1:	0.128
The Distance from Centroid Target #5 to Centroid Target #1:	0.111

SERIAL NUMBER: G6577091. __0

TARGET NUMBER: 1

FILE DATE: 08/21/2006

FILE TIME: 19:50

POINT#	X	Y
1:	0.577	1.336
2:	0.021	1.551
3:	-0.666	1.447
4:	-0.769	0.954
5:	-0.856	0.678
6:	0.463	-0.092
7:	-0.456	-0.552
8:	0.173	-0.902
9:	-0.393	-1.637
10:	1.281	-1.941

X CENTROID: -0.062

Y CENTROID: 0.084

POA TO CENTROID: 0.105

HORZ SPREAD: 2.137

VERT SPREAD: 3.492

GROUP SPREAD: 3.908

MIN RADIUS: 0.554

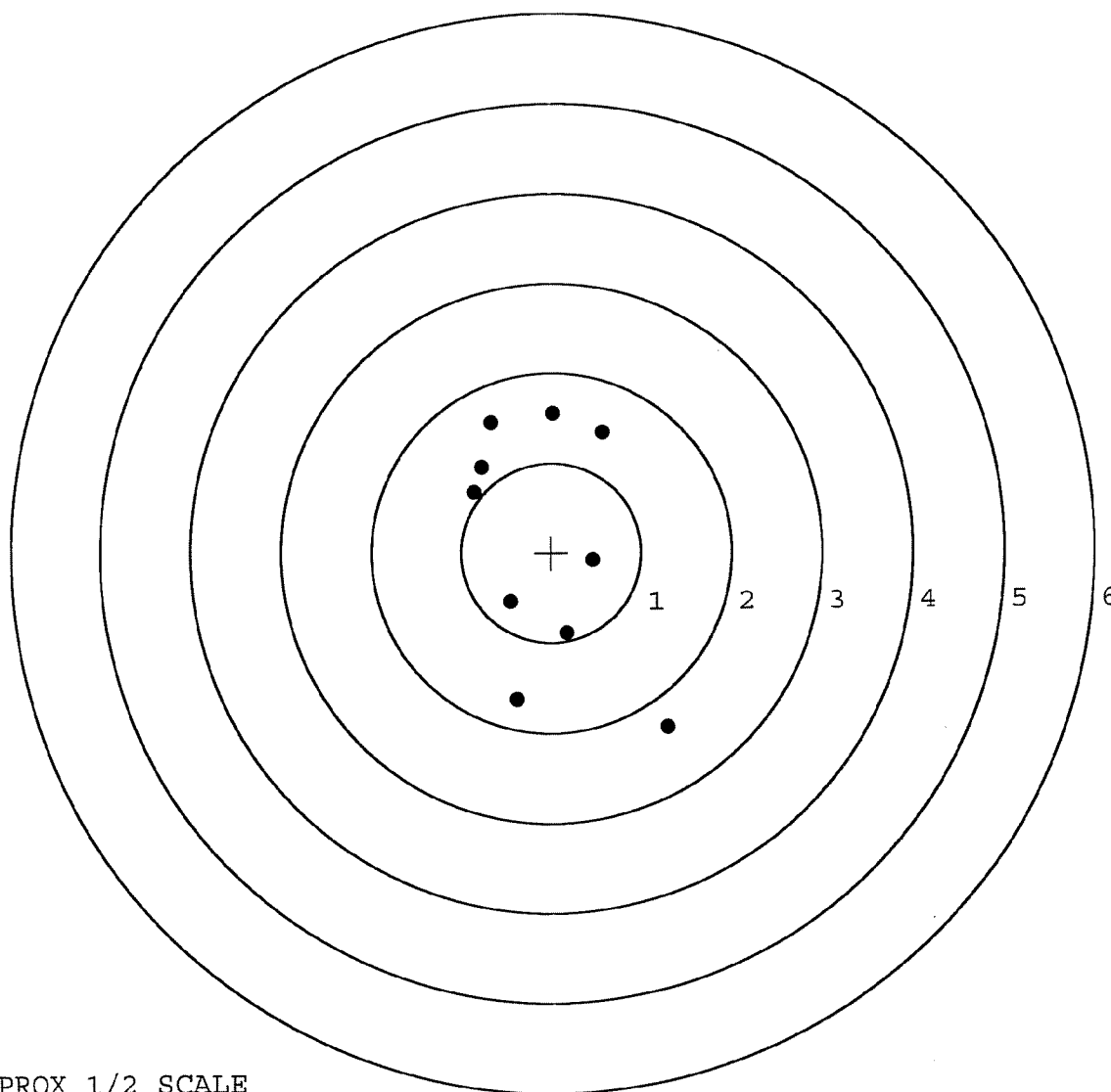
MAX RADIUS: 2.430

MEAN RADIUS: 1.298

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577091. __0

TARGET NUMBER: 2

FILE DATE: 08/21/2006

FILE TIME: 19:50

POINT#	X	Y
1:	0.406	-1.823
2:	1.350	-1.262
3:	1.174	-0.123
4:	0.429	-0.500
5:	-0.978	0.976
6:	-0.529	0.853
7:	-1.359	0.314
8:	-0.607	-0.012
9:	0.007	0.331
10:	-0.152	0.292

X CENTROID: -0.026

Y CENTROID: -0.095

POA TO CENTROID: 0.099

HORZ SPREAD: 2.709

VERT SPREAD: 2.799

GROUP SPREAD: 3.229

MIN RADIUS: 0.407

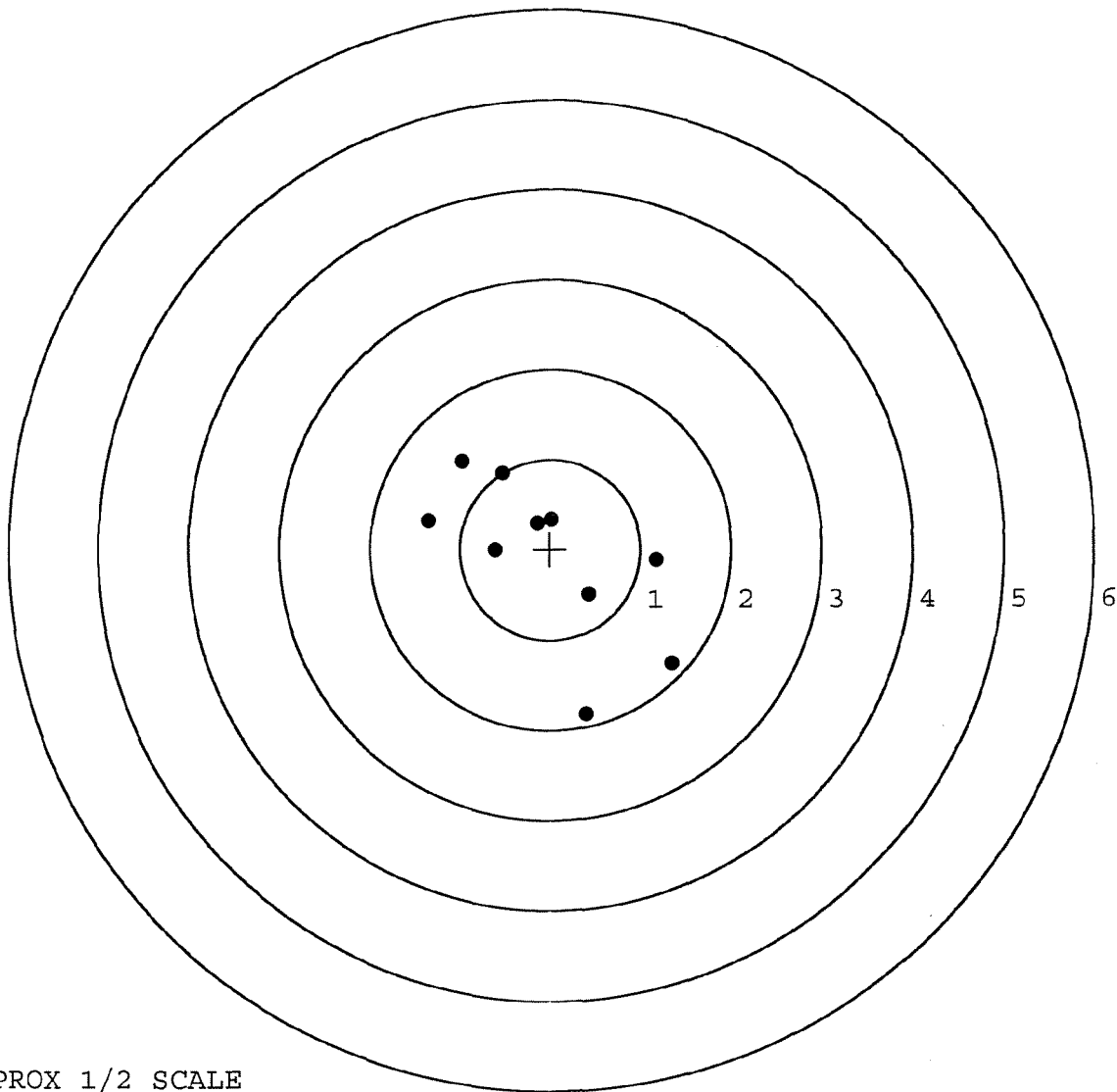
MAX RADIUS: 1.804

MEAN RADIUS: 1.072

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577091. __0

TARGET NUMBER: 3

FILE DATE: 08/21/2006

FILE TIME: 19:50

X CENTROID: 0.058

Y CENTROID: -0.015

POA TO CENTROID: 0.060

HORZ SPREAD: 1.914

VERT SPREAD: 2.418

GROUP SPREAD: 2.943

MIN RADIUS: 0.266

MAX RADIUS: 1.682

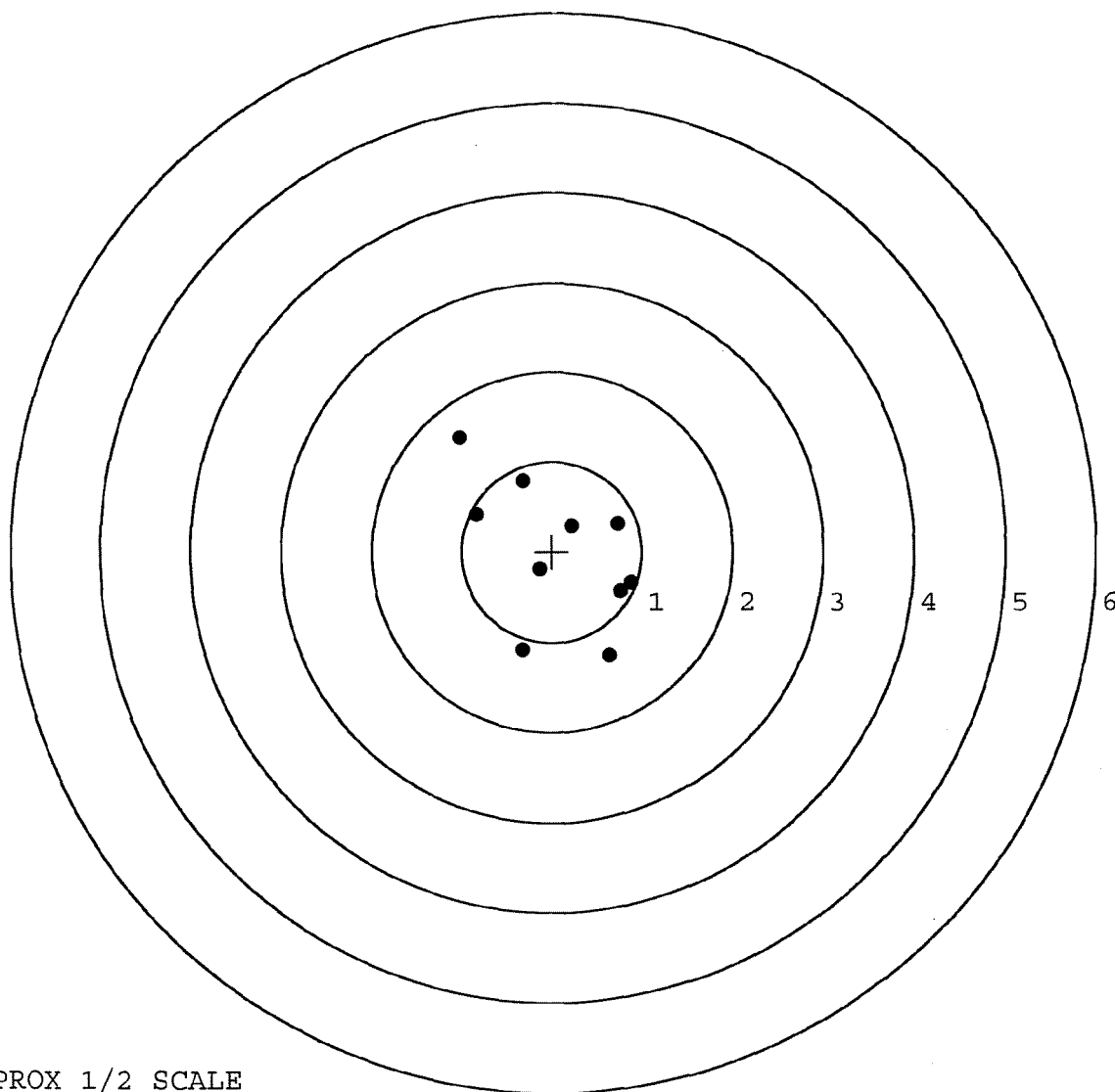
MEAN RADIUS: 0.904

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.324	-1.088
2:	0.645	-1.153
3:	0.763	-0.435
4:	0.881	-0.339
5:	0.728	0.309
6:	0.219	0.290
7:	-0.136	-0.197
8:	-0.840	0.413
9:	-0.321	0.782
10:	-1.033	1.265

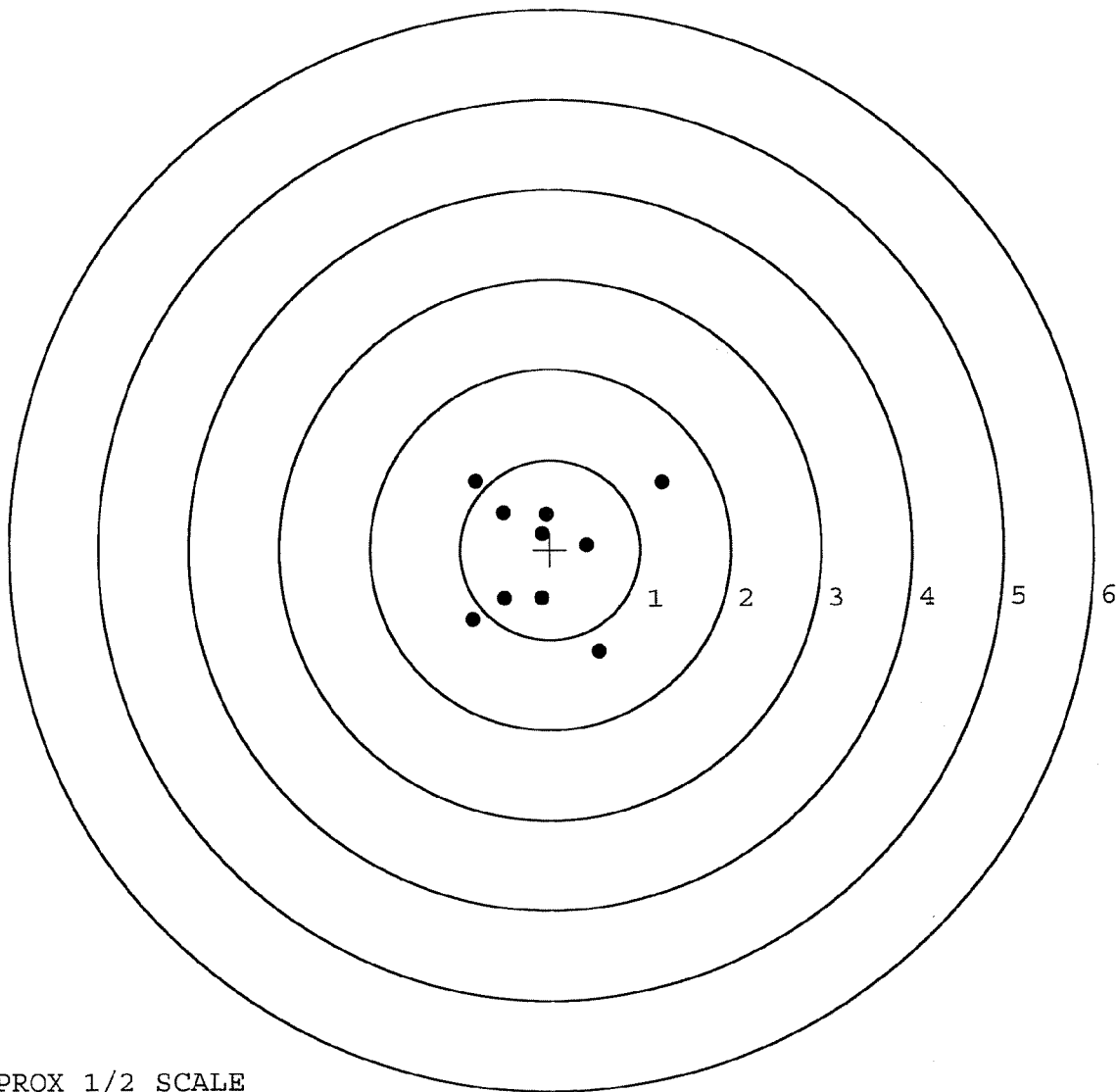


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577091. __0
 TARGET NUMBER: 4
 FILE DATE: 08/21/2006
 FILE TIME: 19:50

POINT#	X	Y
1:	1.244	0.746
2:	0.409	0.052
3:	0.546	-1.137
4:	-0.096	-0.540
5:	-0.507	-0.540
6:	-0.866	-0.774
7:	-0.822	0.768
8:	-0.519	0.419
9:	-0.046	0.399
10:	-0.090	0.174

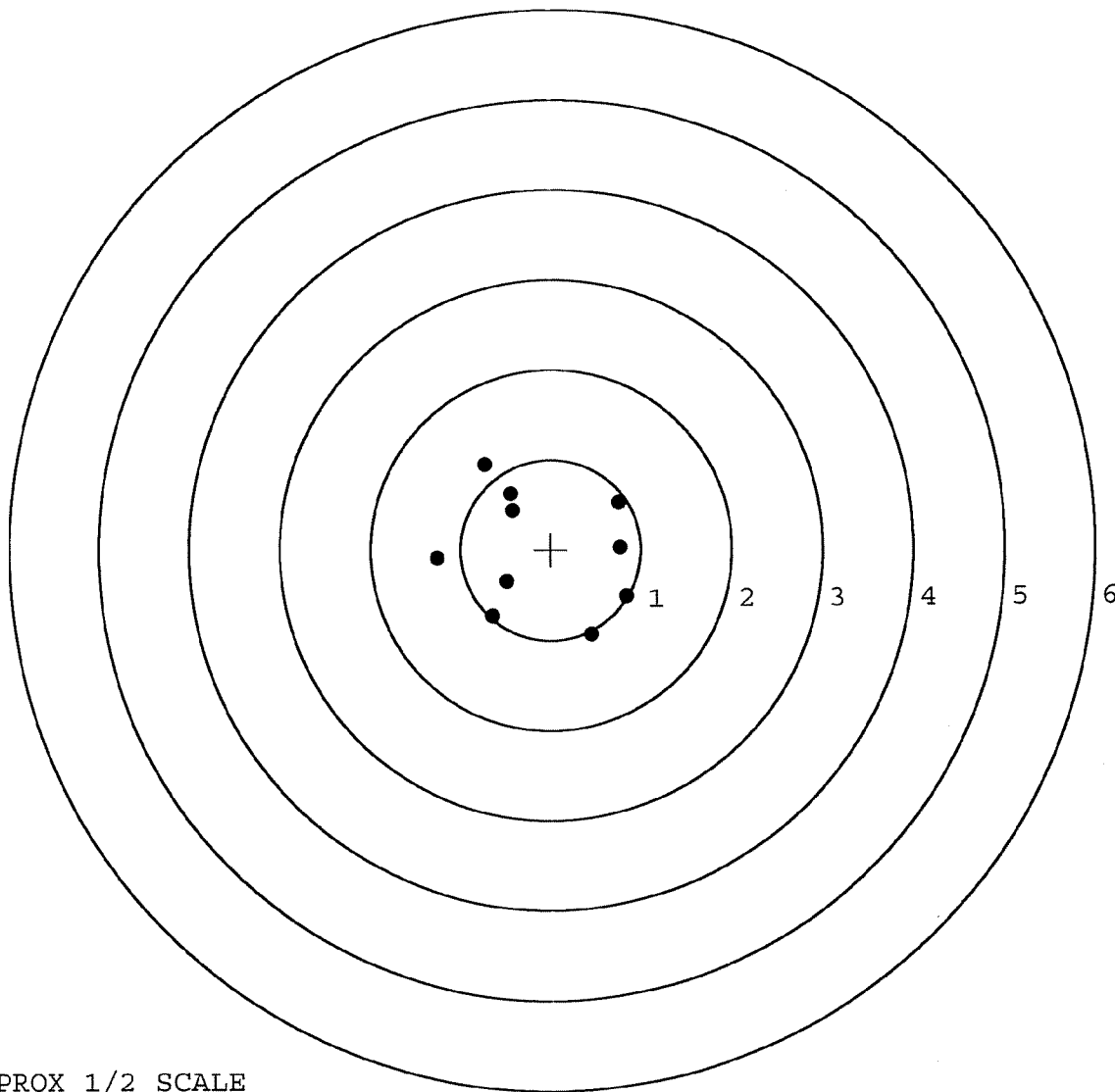
X CENTROID: -0.075
 Y CENTROID: -0.043
 POA TO CENTROID: 0.086
 HORZ SPREAD: 2.110
 VERT SPREAD: 1.905
 GROUP SPREAD: 2.600
 MIN RADIUS: 0.218
 MAX RADIUS: 1.537
 MEAN RADIUS: 0.793
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577091. __0
 TARGET NUMBER: 5
 FILE DATE: 08/21/2006
 FILE TIME: 19:50

	POINT#	X	Y
	1:	0.839	-0.532
	2:	0.447	-0.941
	3:	0.770	0.014
	4:	0.759	0.517
	5:	-0.649	-0.734
	6:	-0.488	-0.356
	7:	-1.262	-0.100
	8:	-0.423	0.439
	9:	-0.446	0.623
	10:	-0.730	0.948
X CENTROID:		-0.118	
Y CENTROID:		-0.012	
POA TO CENTROID:		0.119	
HORZ SPREAD:		2.101	
VERT SPREAD:		1.889	
GROUP SPREAD:		2.145	
MIN RADIUS:		0.505	
MAX RADIUS:		1.147	
MEAN RADIUS:		0.904	
# IN 1 IN DIAMETER:		0	
# IN 2 IN DIAMETER:		5	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE