

G 6591684

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

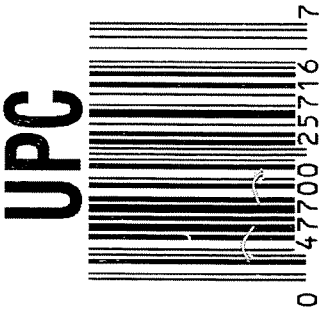
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591684



ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591684

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		8-4-06	BLG
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-4-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 17 2006	8-4-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <i>crus</i>	8/17/06	<i>crus</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-16-06	TRW
520	GOFF BLAST BBL / REC		8-17-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/21/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-21-06	RP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-21-06	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-21-06	RP
	D) OIL FIRING PIN ASSEMBLY		8-31-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/13/06	<i>crus</i>

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.0</u> <u>5.0</u>	9-1-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.5</u> <u>2.5</u>	9-1-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/13/06	mm
	I) FIRING PIN INDENT .020 MIN	<u>1.024</u> <u>1.024</u> <u>1.024</u>	9-1-06	RA
	J) ASSEMBLE STOCK		8-31-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/13/06	mm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-31-06	BLG
	M) IRON SIGHT ALIGNMENT		8-31-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-31-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-31-06	RA
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-31-06	mm
670	FINAL INSPECTION A) HEADSPACE		10/13/06	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.59</u> <u>2.68</u> <u>2.55</u> <u>2.38</u>	9-1-06	RA
	C) FUNCTION		10/13/06	mm
690	PACK		11/2/06	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 8-30-06

TESTER MTH

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.45	2.59		2.39	
PULL #2	2.45	2.40		2.56	
PULL #3	2.53	2.52		2.41	
PULL #4	2.68	2.39		2.46	
PULL #5	2.61	2.24		2.53	
TOTAL	12.72	12.14		12.35	
AVERAGE	2.54	2.43		2.47	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.04		
PULL #2	3.15	3.03		
PULL #3	3.01	3.17		
PULL #4	3.10	3.17		
PULL #5	3.07	3.17		
TOTAL	15.39	15.58		
AVERAGE	3.08	3.12		

	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	4.12	4.11		3.87
PULL #2	4.15	4.04		4.01
PULL #3	4.08	4.05		3.93
PULL #4	4.30	4.05		3.89
PULL #5	4.27	4.06		3.90
TOTAL	20.92	20.36		19.60
AVERAGE	4.18	4.07		3.92

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591684.___0
FILE DATE AND TIME: 08/31/2006 15:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.117
The Average Y Centroid of the Five Target Set:	-0.038
The Average Point of Impact of the Five Target Set:	0.123
The Average Mean Radius of the Five Target Set:	0.874
The Distance from POA to Centroid Target #1:	0.480
The Distance from Centroid Target #2 to Centroid Target #1:	0.553
The Distance from Centroid Target #3 to Centroid Target #1:	0.370
The Distance from Centroid Target #4 to Centroid Target #1:	0.536
The Distance from Centroid Target #5 to Centroid Target #1:	0.364

SERIAL NUMBER: G6591684. __0

TARGET NUMBER: 1

FILE DATE: 08/31/2006

FILE TIME: 15:23

X CENTROID: -0.464

Y CENTROID: -0.123

POA TO CENTROID: 0.480

HORZ SPREAD: 2.554

VERT SPREAD: 2.584

GROUP SPREAD: 3.230

MIN RADIUS: 0.137

MAX RADIUS: 1.846

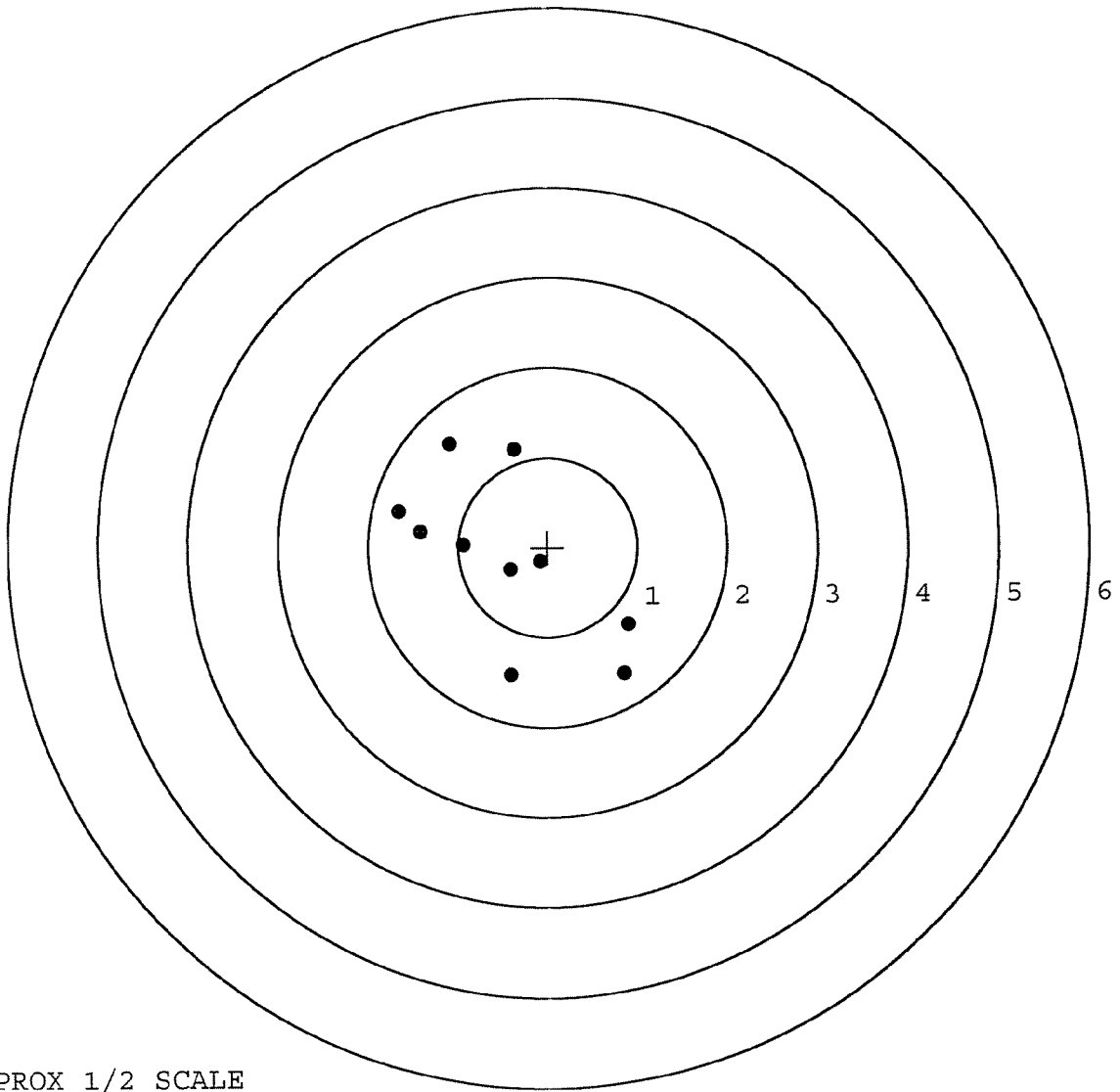
MEAN RADIUS: 1.069

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.416	-1.422
2:	0.853	-1.417
3:	0.896	-0.872
4:	-0.080	-0.164
5:	-0.414	-0.251
6:	-0.945	0.036
7:	-1.416	0.184
8:	-1.658	0.417
9:	-1.091	1.162
10:	-0.370	1.096

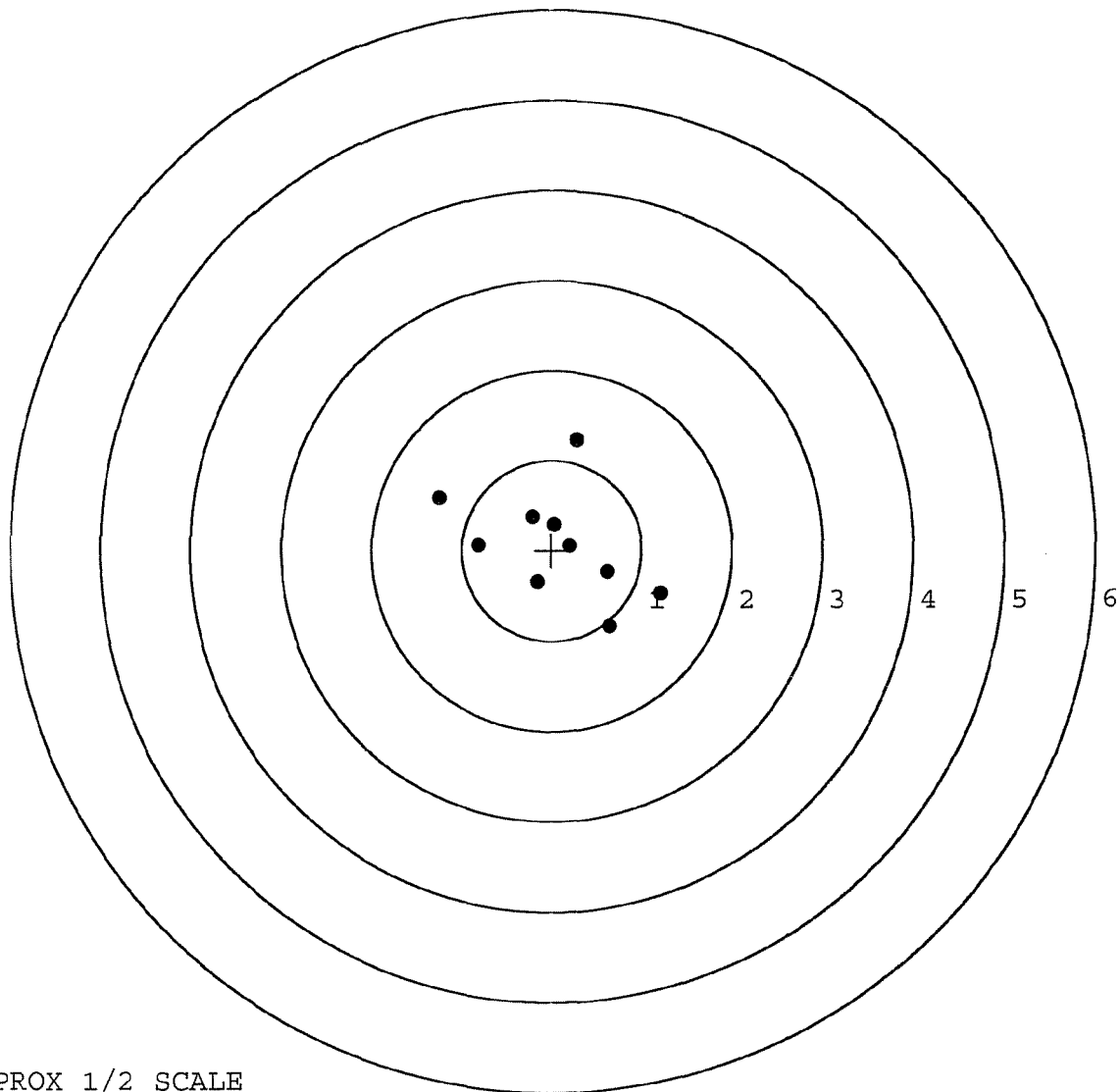


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591684. __0
 TARGET NUMBER: 2
 FILE DATE: 08/31/2006
 FILE TIME: 15:23

POINT#	X	Y
1:	0.646	-0.840
2:	1.210	-0.486
3:	0.626	-0.241
4:	0.204	0.047
5:	-0.154	-0.359
6:	-0.818	0.063
7:	-1.247	0.583
8:	0.283	1.229
9:	-0.220	0.368
10:	0.032	0.281

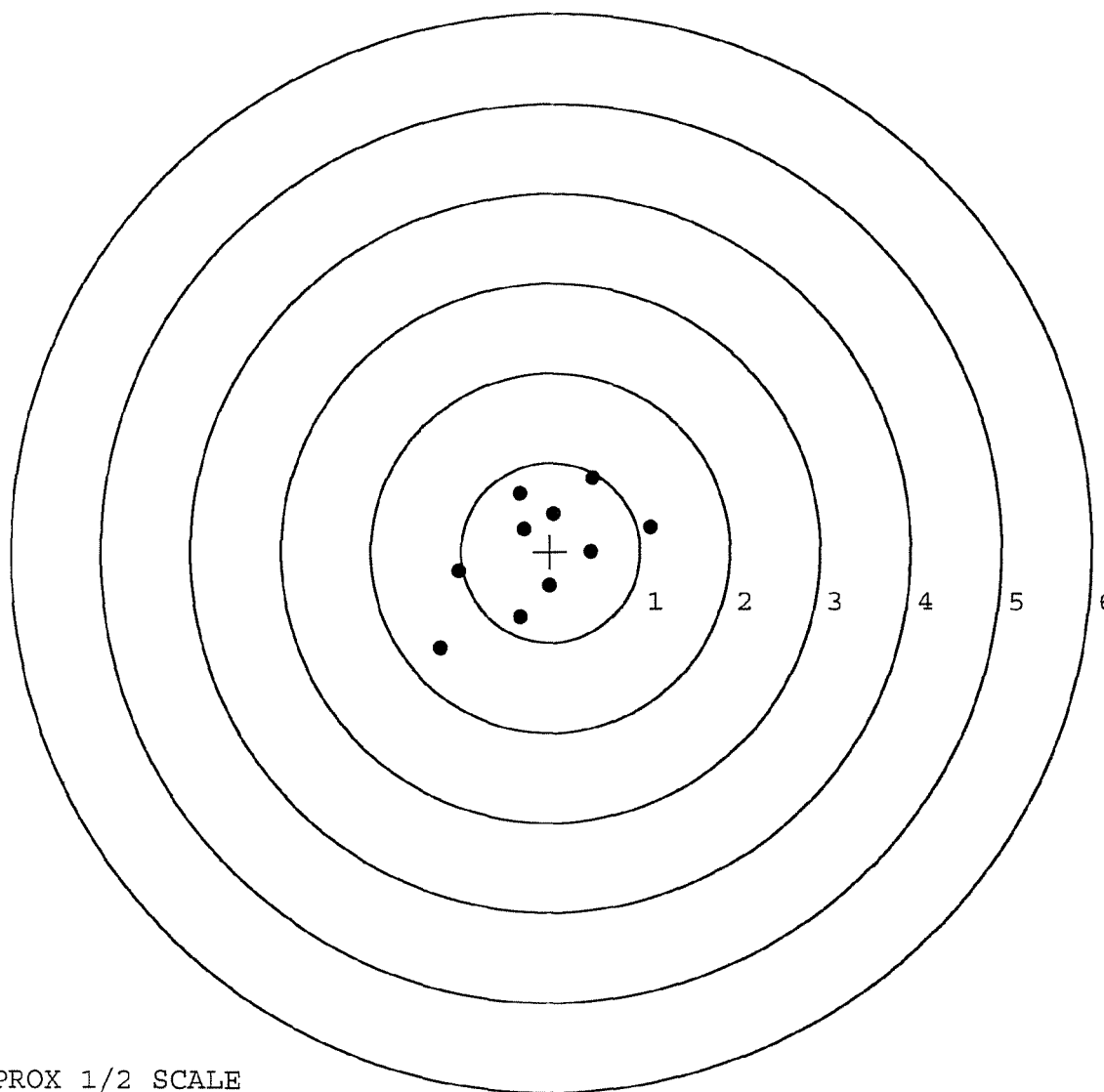
X CENTROID: 0.056
 Y CENTROID: 0.064
 POA TO CENTROID: 0.086
 HORZ SPREAD: 2.457
 VERT SPREAD: 2.069
 GROUP SPREAD: 2.679
 MIN RADIUS: 0.149
 MAX RADIUS: 1.403
 MEAN RADIUS: 0.772
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0169586

SERIAL NUMBER: G6591684. 0	POINT#	X	Y
TARGET NUMBER: 3	1:	-1.224	-1.068
FILE DATE: 08/31/2006	2:	-1.020	-0.220
FILE TIME: 15:23	3:	-0.333	-0.733
	4:	-0.009	-0.383
X CENTROID: -0.116	5:	0.459	0.002
Y CENTROID: 0.003	6:	1.107	0.274
POA TO CENTROID: 0.116	7:	0.467	0.825
HORZ SPREAD: 2.331	8:	-0.344	0.648
VERT SPREAD: 1.893	9:	-0.297	0.252
GROUP SPREAD: 2.690	10:	0.034	0.433
MIN RADIUS: 0.308			
MAX RADIUS: 1.541			
MEAN RADIUS: 0.792			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 9			



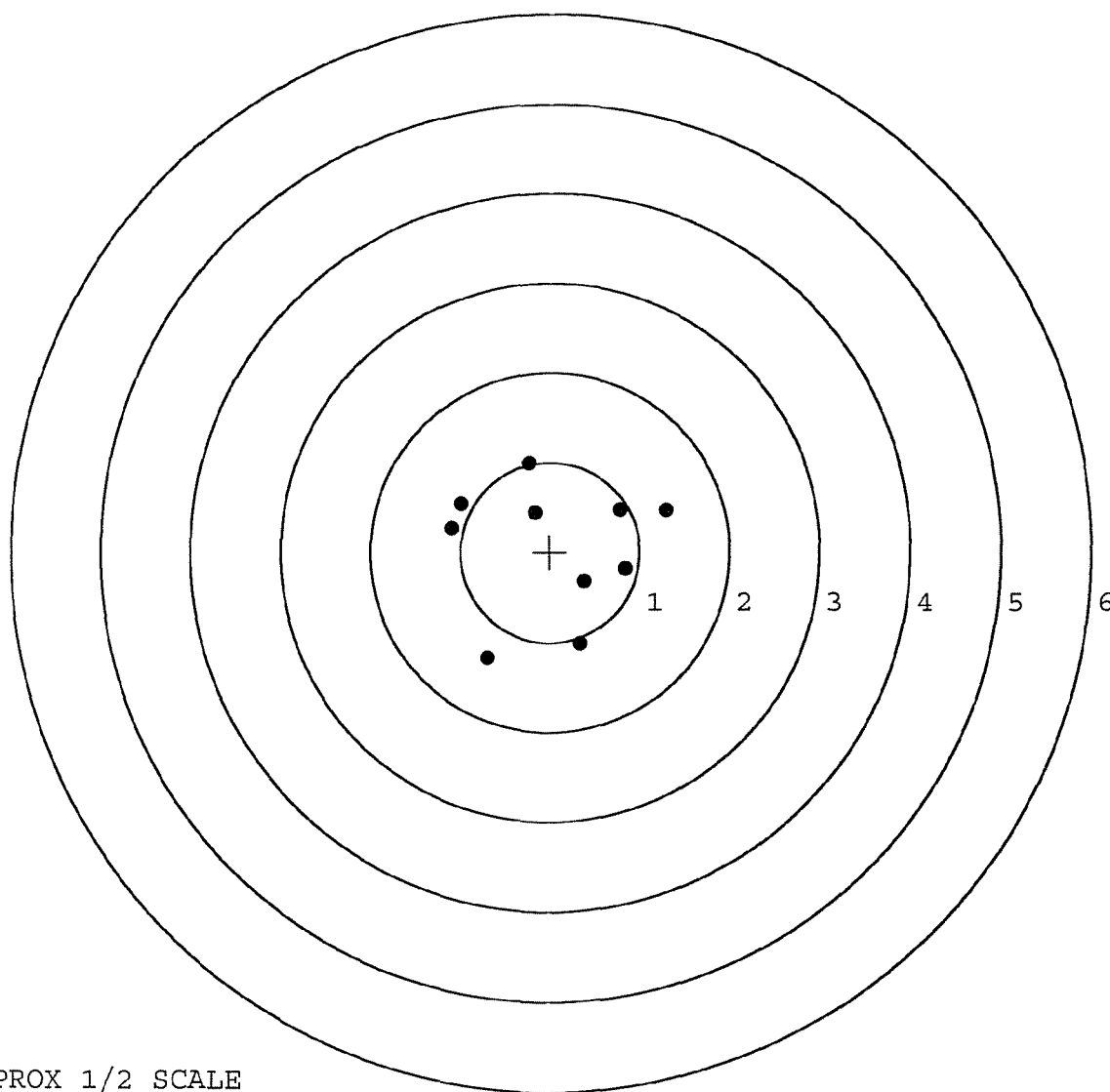
TARGET APPROX 1/2 SCALE

BARBER - M24 0169587

SERIAL NUMBER: G6591684. __0
 TARGET NUMBER: 4
 FILE DATE: 08/31/2006
 FILE TIME: 15:23

POINT#	X	Y
1:	0.783	0.473
2:	1.289	0.460
3:	0.845	-0.192
4:	0.386	-0.333
5:	-0.697	-1.176
6:	0.344	-1.016
7:	-0.167	0.437
8:	-0.995	0.539
9:	-1.104	0.265
10:	-0.236	0.989

X CENTROID: 0.045
 Y CENTROID: 0.045
 POA TO CENTROID: 0.063
 HORZ SPREAD: 2.393
 VERT SPREAD: 2.165
 GROUP SPREAD: 2.573
 MIN RADIUS: 0.446
 MAX RADIUS: 1.428
 MEAN RADIUS: 0.979
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 10

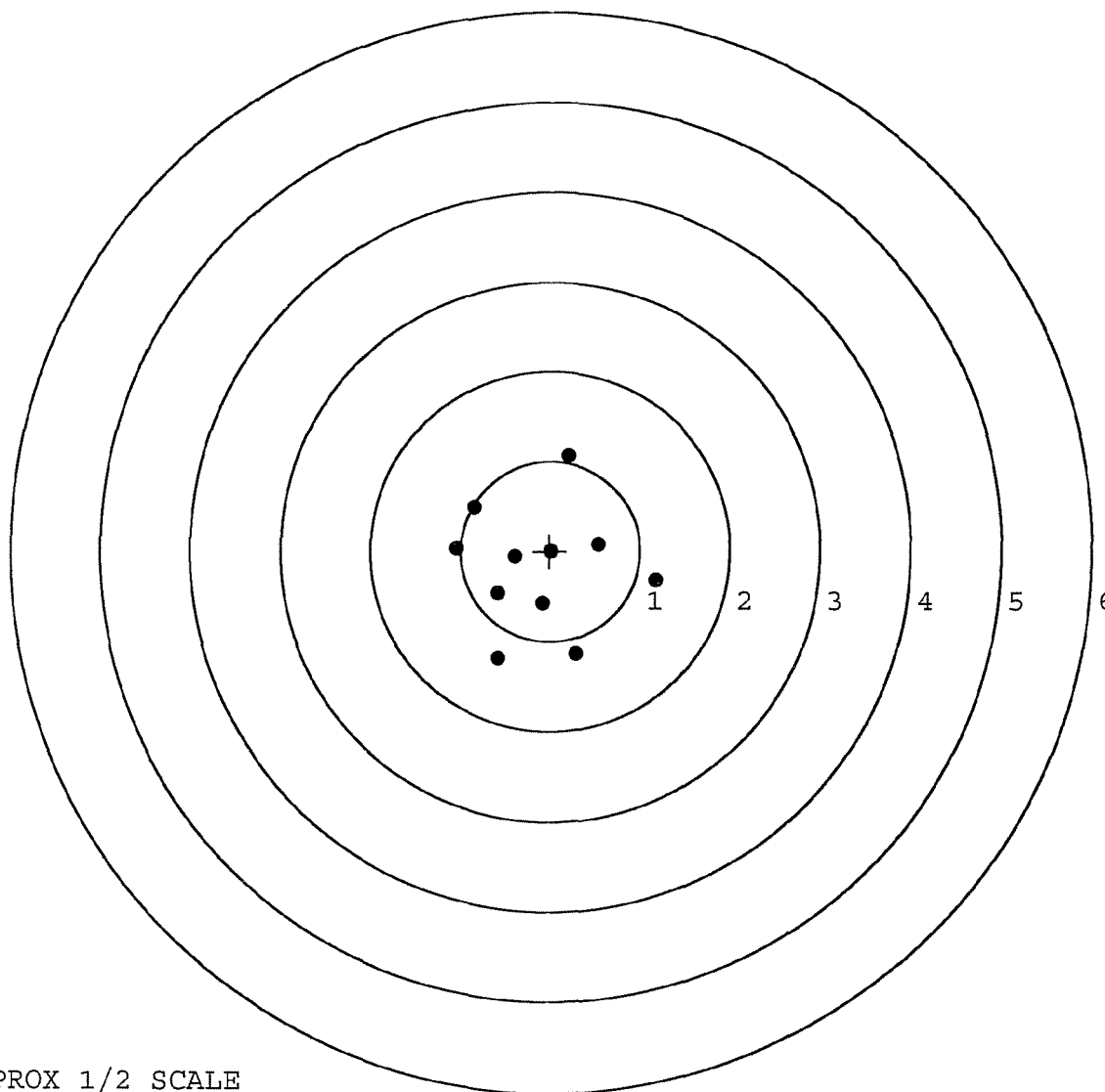


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591684. 0
 TARGET NUMBER: 5
 FILE DATE: 08/31/2006
 FILE TIME: 15:23

POINT#	X	Y
1:	0.016	-0.012
2:	0.019	-0.004
3:	-0.575	-1.188
4:	0.297	-1.140
5:	1.177	-0.327
6:	0.544	0.078
7:	-0.081	-0.582
8:	-0.580	-0.470
9:	-0.388	-0.061
10:	-1.043	0.031
11:	-0.851	0.488
12:	0.211	1.059

X CENTROID: -0.105
 Y CENTROID: -0.177
 POA TO CENTROID: 0.206
 HORZ SPREAD: 2.220
 VERT SPREAD: 2.247
 GROUP SPREAD: 2.249
 MIN RADIUS: 0.205
 MAX RADIUS: 1.290
 MEAN RADIUS: 0.756
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 12



TARGET APPROX 1/2 SCALE