

G 653 5345

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

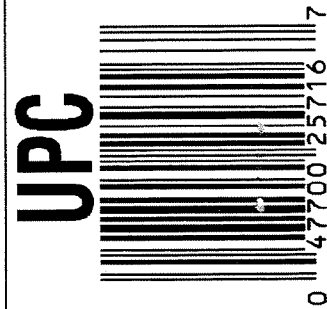


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6535345



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66535345

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-10-06	PTZ
440	PROOF		2-10-06	TRL
460	CHECK HEADSPACE	MAGNA-FLUX	2-10-06	AC
470	DIS-ASSEMBLE ACTION	INSPECTED	2-10-06	AC
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 FEB 14 2006 OPERATOR <u>APD</u>	2-14-06	APD
500	ROLLMARK CALIBER		2-14-06	CW
510	DRILL AND TAP SIGHT HOLES		2-13-06	TRL
520	GOFF BLAST BBL / REC		2-14-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/20/06	TEB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2/22/06	mgd
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/22/06	mgd
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/22/06	mgd
	D) OIL FIRING PIN ASSEMBLY		3-8-06	AC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>55</u> <u>50</u> <u>50</u>	3-14-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>25</u> <u>25</u>	3-14-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3-14-06	DA
	J) ASSEMBLE STOCK		3-8-06	A
	K) ASSEMBLE SWIVEL STUDS		3/27/06	MGD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-8-06	A
	M) IRON SIGHT ALIGNMENT		3-8-06	A
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-8-06	A
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-9-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3/9/06	R.P.
670	FINAL INSPECTION A) HEADSPACE		3/27/06	MGD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.37</u> <u>2.54</u> <u>2.14</u> <u>2.35</u>	3-14-06	TRW
	C) FUNCTION		3/27/06	MGD
690	PACK		3-8-06	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)

DATE 2-27-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	238	247	232	
PULL #2	254	236	235	
PULL #3	242	237	240	
PULL #4	248	246	237	
PULL #5	239	258	254	
TOTAL	12.21	12.24	11.98	
AVERAGE	2.44	2.44	2.39	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	311	309	
PULL #2	308	311	
PULL #3	309	318	
PULL #4	314	293	
PULL #5	312	323	
TOTAL	1554	1554	
AVERAGE	3.10	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	403	402		4.12
PULL #2	426	403		4.29
PULL #3	413	411		4.18
PULL #4	429	3.88		4.36
PULL #5	407	403		4.18
TOTAL	20.78	20.07		21.13
AVERAGE	4.15	4.01		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535345.___0
FILE DATE AND TIME: 03/09/2006 07:17

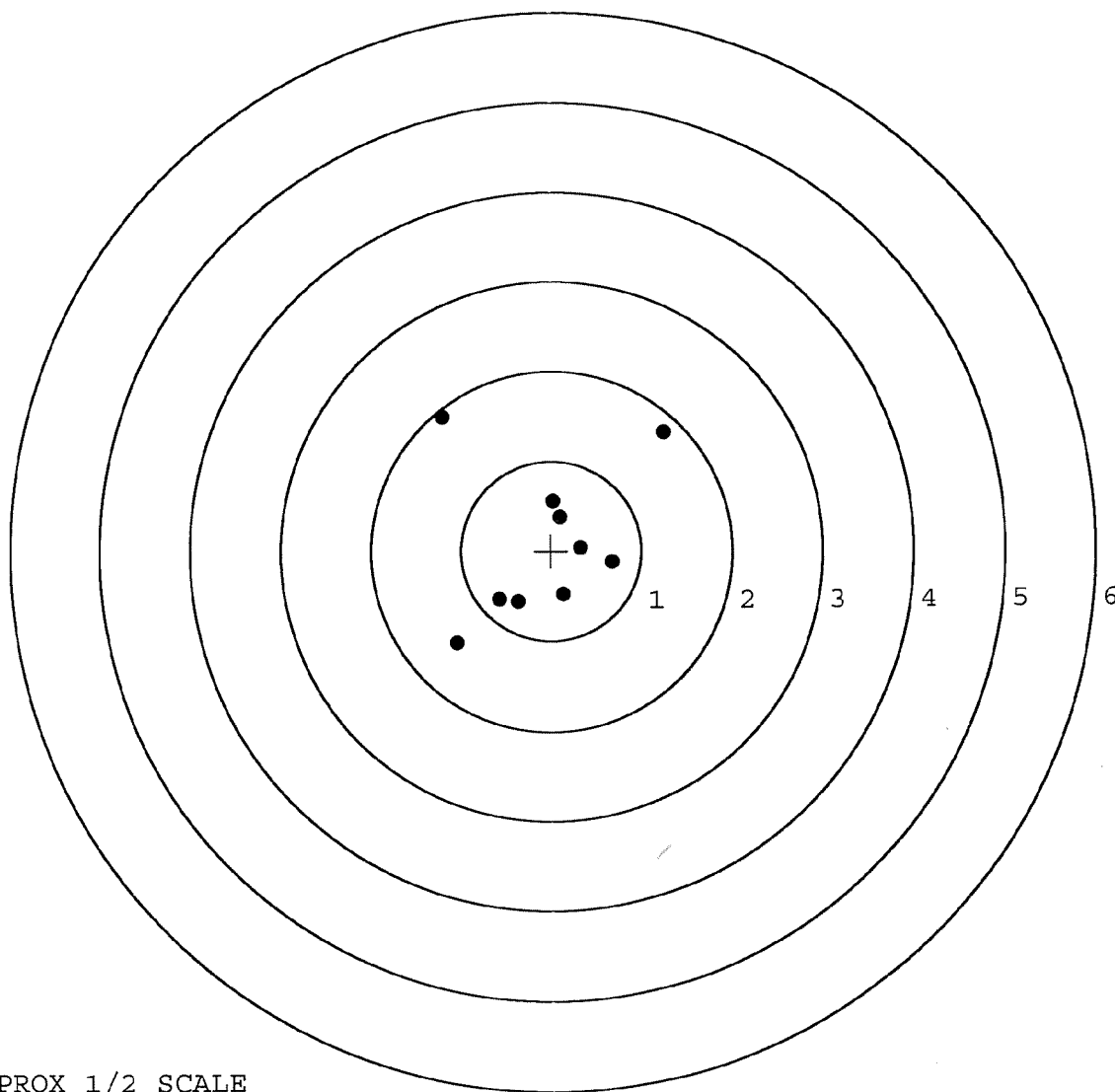
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.017
The Average Y Centroid of the Five Target Set:	0.000
The Average Point of Impact of the Five Target Set:	0.017
The Average Mean Radius of the Five Target Set:	0.631
The Distance from POA to Centroid Target #1:	0.123
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.187
The Distance from Centroid Target #4 to Centroid Target #1:	0.124
The Distance from Centroid Target #5 to Centroid Target #1:	0.165

SERIAL NUMBER: G6535345. __0
TARGET NUMBER: 1
FILE DATE: 03/09/2006
FILE TIME: 07:17

X CENTROID: -0.068
Y CENTROID: 0.103
POA TO CENTROID: 0.123
HORZ SPREAD: 2.451
VERT SPREAD: 2.521
GROUP SPREAD: 2.525
MIN RADIUS: 0.324
MAX RADIUS: 1.795
MEAN RADIUS: 0.925
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.249	1.319
2:	-1.202	1.495
3:	0.023	0.560
4:	0.101	0.380
5:	0.330	0.039
6:	0.677	-0.130
7:	0.139	-0.490
8:	-0.368	-0.573
9:	-0.576	-0.543
10:	-1.052	-1.026

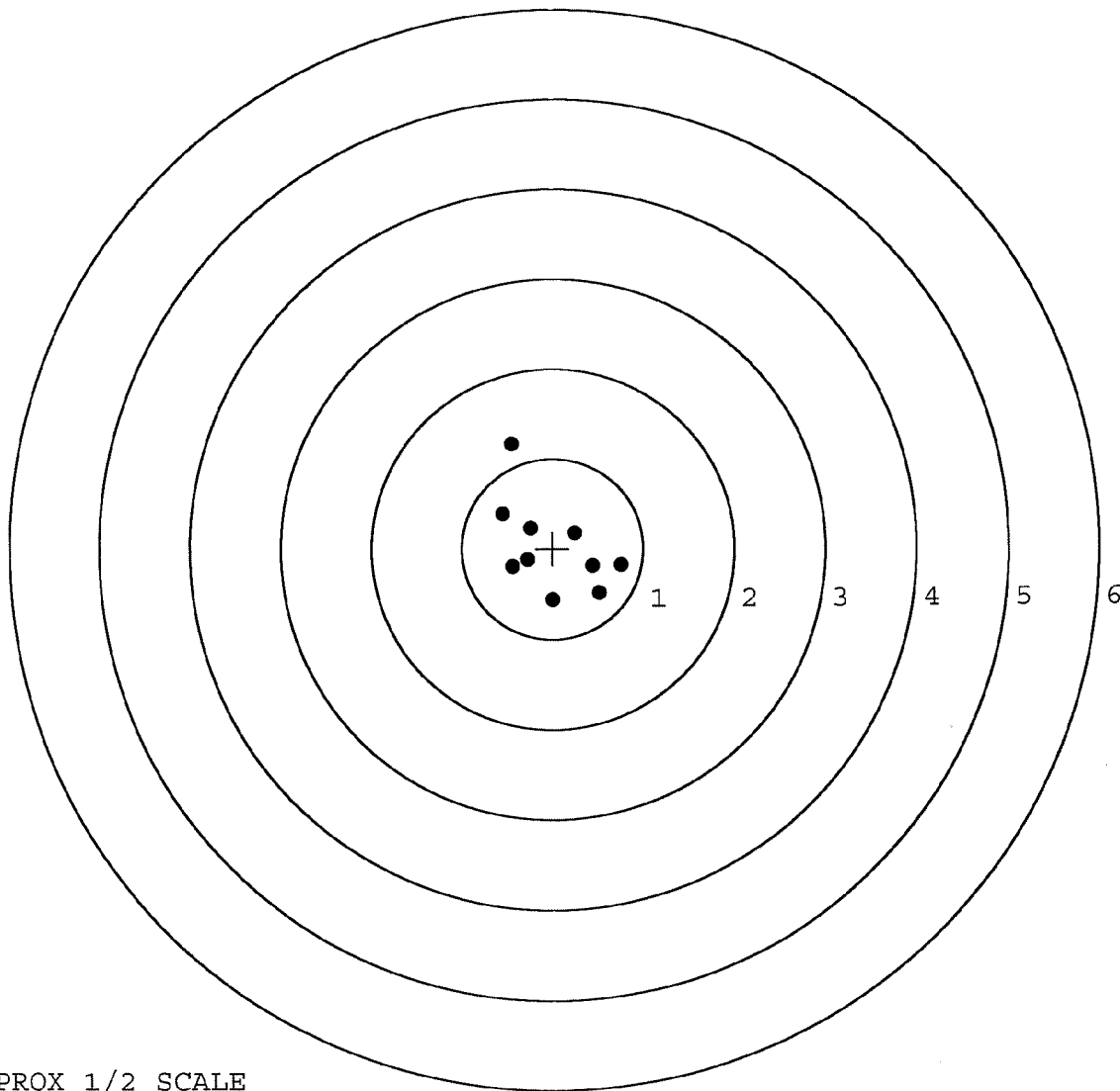


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535345. __0
TARGET NUMBER: 2
FILE DATE: 03/09/2006
FILE TIME: 07:17

X CENTROID: 0.000
Y CENTROID: 0.015
POA TO CENTROID: 0.016
HORZ SPREAD: 1.305
VERT SPREAD: 1.731
GROUP SPREAD: 1.920
MIN RADIUS: 0.296
MAX RADIUS: 1.233
MEAN RADIUS: 0.590
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.453	1.162
2:	-0.551	0.382
3:	-0.244	0.222
4:	-0.442	-0.200
5:	-0.277	-0.131
6:	0.252	0.170
7:	-0.002	-0.569
8:	0.445	-0.199
9:	0.754	-0.187
10:	0.517	-0.495



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535345.___0

TARGET NUMBER: 3

FILE DATE: 03/09/2006

FILE TIME: 07:17

X CENTROID: -0.032

Y CENTROID: -0.080

POA TO CENTROID: 0.086

HORZ SPREAD: 0.770

VERT SPREAD: 2.165

GROUP SPREAD: 2.169

MIN RADIUS: 0.108

MAX RADIUS: 1.165

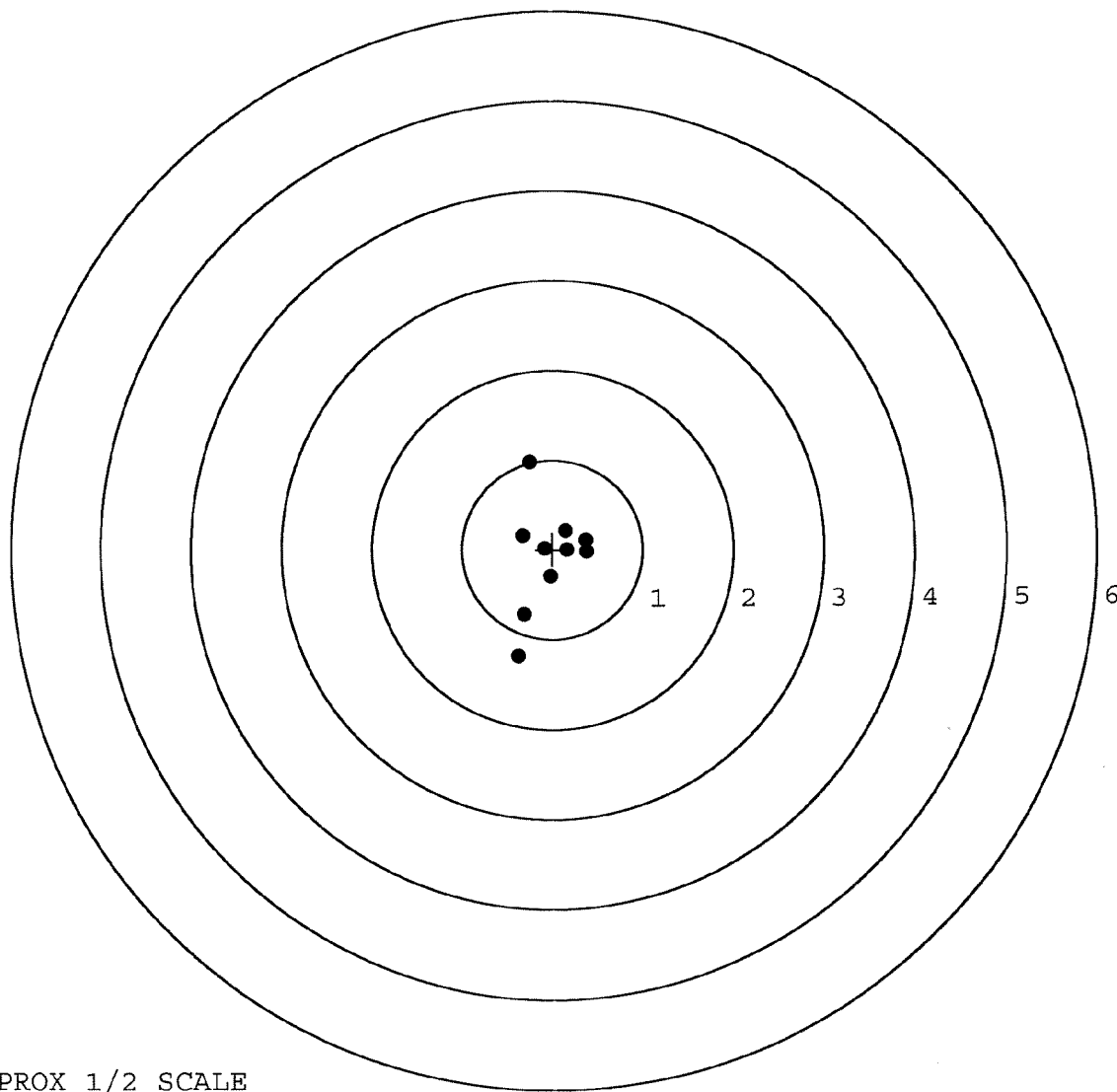
MEAN RADIUS: 0.510

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.251	0.975
2:	-0.386	-1.190
3:	-0.314	-0.731
4:	-0.021	-0.308
5:	-0.091	0.010
6:	-0.333	0.160
7:	0.163	-0.009
8:	0.384	-0.027
9:	0.378	0.106
10:	0.153	0.213



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535345. __0

TARGET NUMBER: 4

FILE DATE: 03/09/2006

FILE TIME: 07:17

POINT#	X	Y
1:	-0.132	-0.775
2:	0.643	-0.027
3:	-0.429	1.039
4:	-0.378	-0.083
5:	-0.503	-0.343
6:	0.201	-0.190
7:	-0.032	-0.185
8:	0.390	0.255
9:	0.038	0.238
10:	0.183	0.055

X CENTROID: -0.002

Y CENTROID: -0.002

POA TO CENTROID: 0.002

HORZ SPREAD: 1.146

VERT SPREAD: 1.814

GROUP SPREAD: 1.838

MIN RADIUS: 0.186

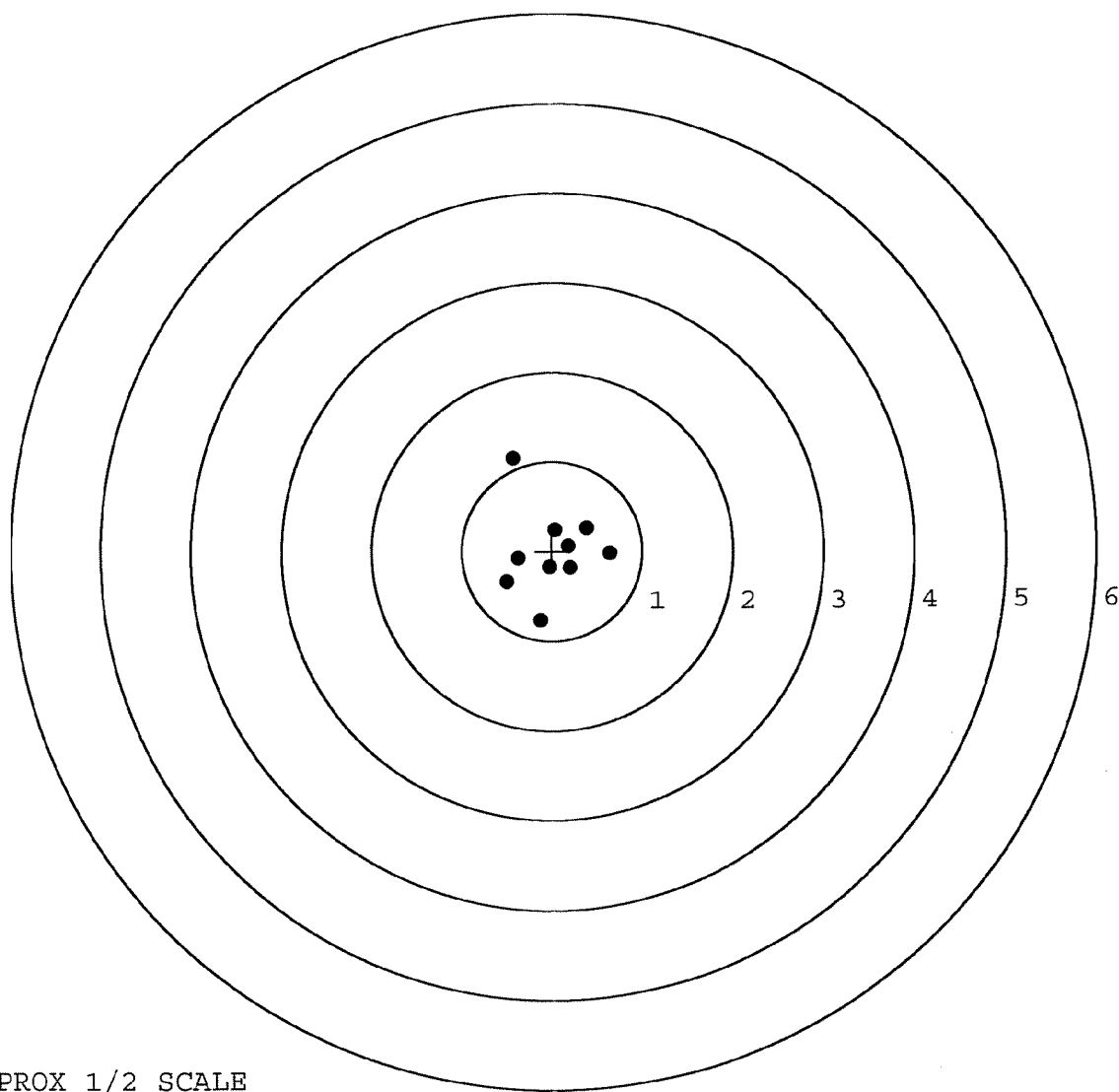
MAX RADIUS: 1.125

MEAN RADIUS: 0.491

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



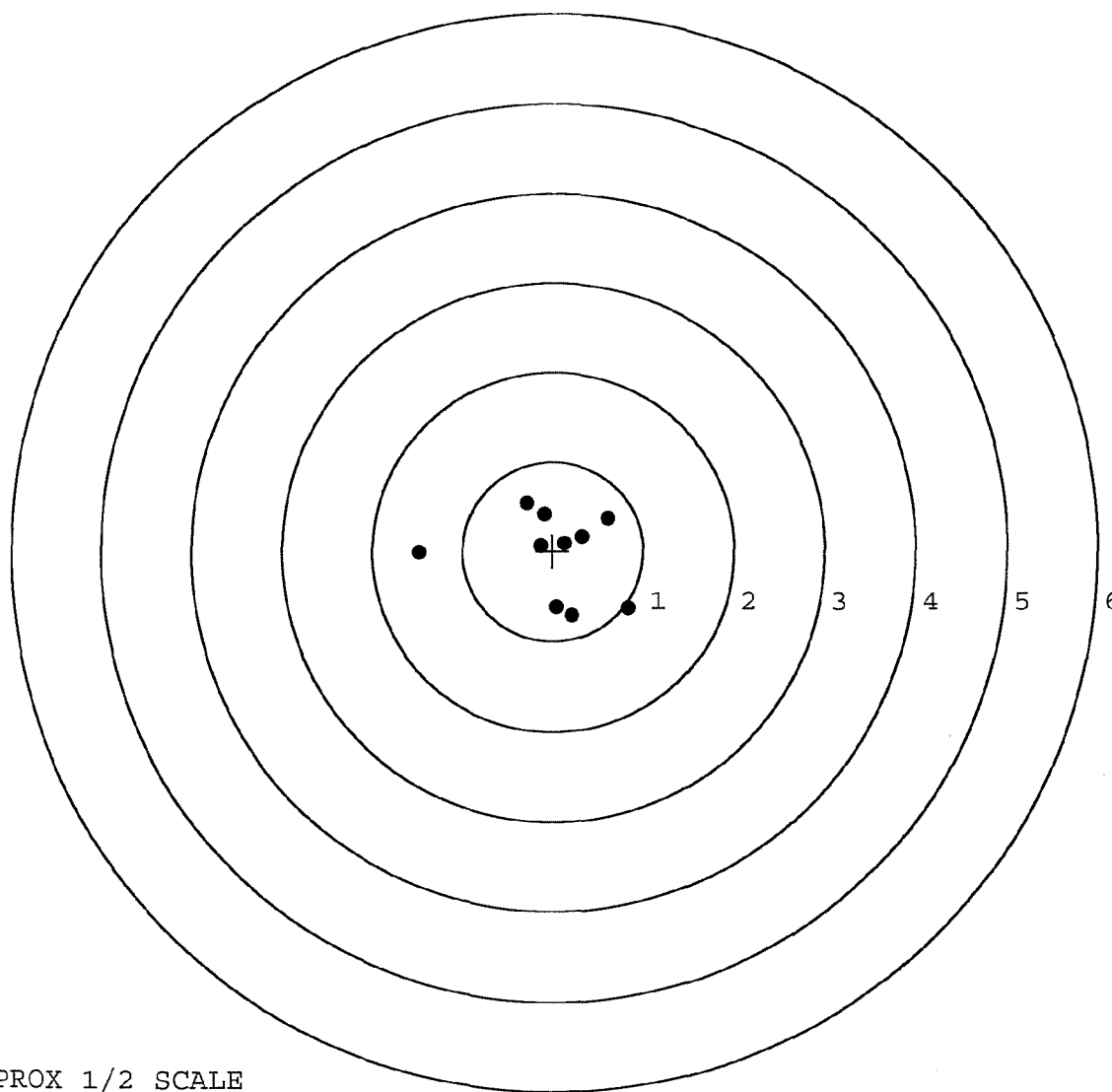
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535345. __0
TARGET NUMBER: 5
FILE DATE: 03/09/2006
FILE TIME: 07:17

X CENTROID: 0.017
Y CENTROID: -0.039
POA TO CENTROID: 0.042
HORZ SPREAD: 2.321
VERT SPREAD: 1.261
GROUP SPREAD: 2.401
MIN RADIUS: 0.172
MAX RADIUS: 1.503
MEAN RADIUS: 0.637

POINT#	X	Y
1:	0.835	-0.639
2:	0.216	-0.721
3:	0.044	-0.627
4:	0.613	0.370
5:	0.320	0.163
6:	0.138	0.083
7:	-0.128	0.056
8:	-0.097	0.412
9:	-0.287	0.540
10:	-1.486	-0.026

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE