

G-653 5348

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

G6535348



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5348

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-10-06	RTZ
440	PROOF		2-10-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	2-10-06	AC
470	DIS-ASSEMBLE ACTION	FEB 14 2006	2-10-06	AC
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 OPERATOR <u>CPD</u>	2-11-06	APD
500	ROLLMARK CALIBER		2-14-06	CW
510	DRILL AND TAP SIGHT HOLES		2-13-06	TRW
520	GOFF BLAST BBL / REC		2-14-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/20/06	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		2/21/06	mgd
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/21/06	mgd
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/21/06	mgd
	D) OIL FIRING PIN ASSEMBLY		3-7-06	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>5.0</u> <u>5.0</u> <u>5.0</u>	3-14-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	3-14-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.022</u> <u>.021</u>	3-14-06	RA
	J) ASSEMBLE STOCK		3-8-06	RJL
	K) ASSEMBLE SWIVEL STUDS		3-27-06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-7-06	AC
	M) IRON SIGHT ALIGNMENT		3-7-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-7-06	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-8-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-8-06	MAL
670	FINAL INSPECTION A) HEADSPACE		3-27-06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.25</u> <u>2.24</u> <u>2.20</u> <u>2.23</u>	3-14-06	TRL
	C) FUNCTION		3-27-06	MJD
690	PACK		3-28-06	RA

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 2-24-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.53	2.51		2.48	
PULL #2	2.50	2.58		2.46	
PULL #3	2.51	2.55		2.49	
PULL #4	2.41	2.49		2.47	
PULL #5	2.51	2.47		2.53	
TOTAL	12.46	12.60		12.43	
AVERAGE	2.49	2.52		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.01		
PULL #2	3.10	3.02		
PULL #3	3.00	2.98		
PULL #4	3.04	3.04		
PULL #5	3.03	3.13		
TOTAL	15.23	15.18		
AVERAGE	3.04	3.03		

	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	4.15	3.99		4.17
PULL #2	4.20	4.09		4.18
PULL #3	4.16	4.06		4.24
PULL #4	4.15	4.12		4.11
PULL #5	4.24	4.01		4.11
TOTAL	20.90	20.27		20.81
AVERAGE	4.18	4.05		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535348.__0
FILE DATE AND TIME: 03/08/2006 15:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.003
The Average Y Centroid of the Five Target Set:	-0.111
The Average Point of Impact of the Five Target Set:	0.111
The Average Mean Radius of the Five Target Set:	0.687
The Distance from POA to Centroid Target #1:	0.204
The Distance from Centroid Target #2 to Centroid Target #1:	0.326
The Distance from Centroid Target #3 to Centroid Target #1:	0.482
The Distance from Centroid Target #4 to Centroid Target #1:	0.304
The Distance from Centroid Target #5 to Centroid Target #1:	0.282

SERIAL NUMBER: G6535348. 0

TARGET NUMBER: 1

FILE DATE: 03/08/2006

FILE TIME: 15:59

X CENTROID: -0.196

Y CENTROID: 0.057

POA TO CENTROID: 0.204

HORZ SPREAD: 1.420

VERT SPREAD: 2.116

GROUP SPREAD: 2.157

MIN RADIUS: 0.178

MAX RADIUS: 1.107

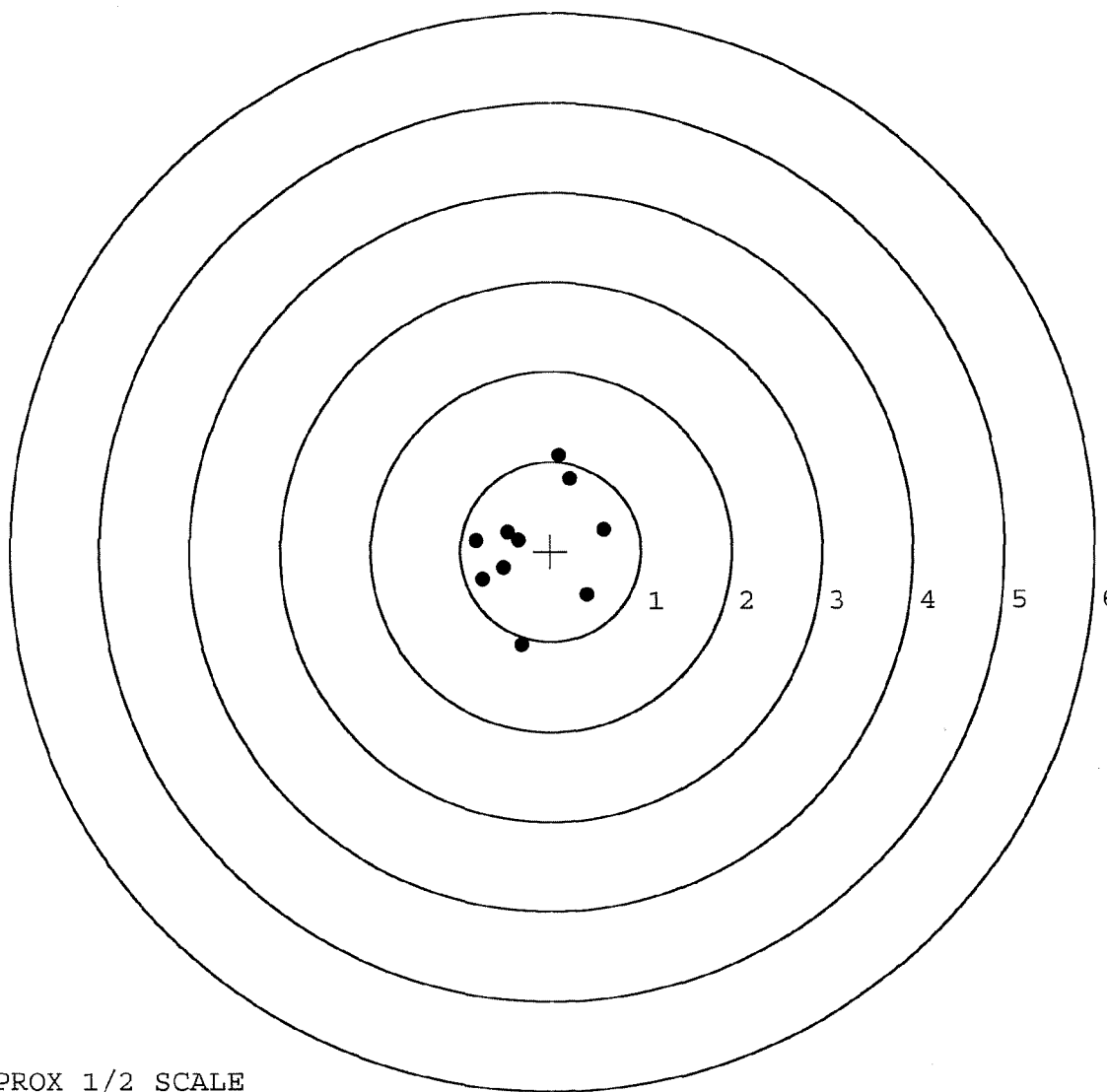
MEAN RADIUS: 0.686

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.098	1.073
2:	0.219	0.812
3:	0.591	0.242
4:	0.404	-0.482
5:	-0.322	-1.043
6:	-0.757	-0.309
7:	-0.520	-0.183
8:	-0.829	0.121
9:	-0.484	0.217
10:	-0.361	0.123



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535348. 0

TARGET NUMBER: 2

FILE DATE: 03/08/2006

FILE TIME: 15:59

X CENTROID: -0.002

Y CENTROID: -0.205

POA TO CENTROID: 0.205

HORZ SPREAD: 1.922

VERT SPREAD: 2.063

GROUP SPREAD: 2.405

MIN RADIUS: 0.166

MAX RADIUS: 1.448

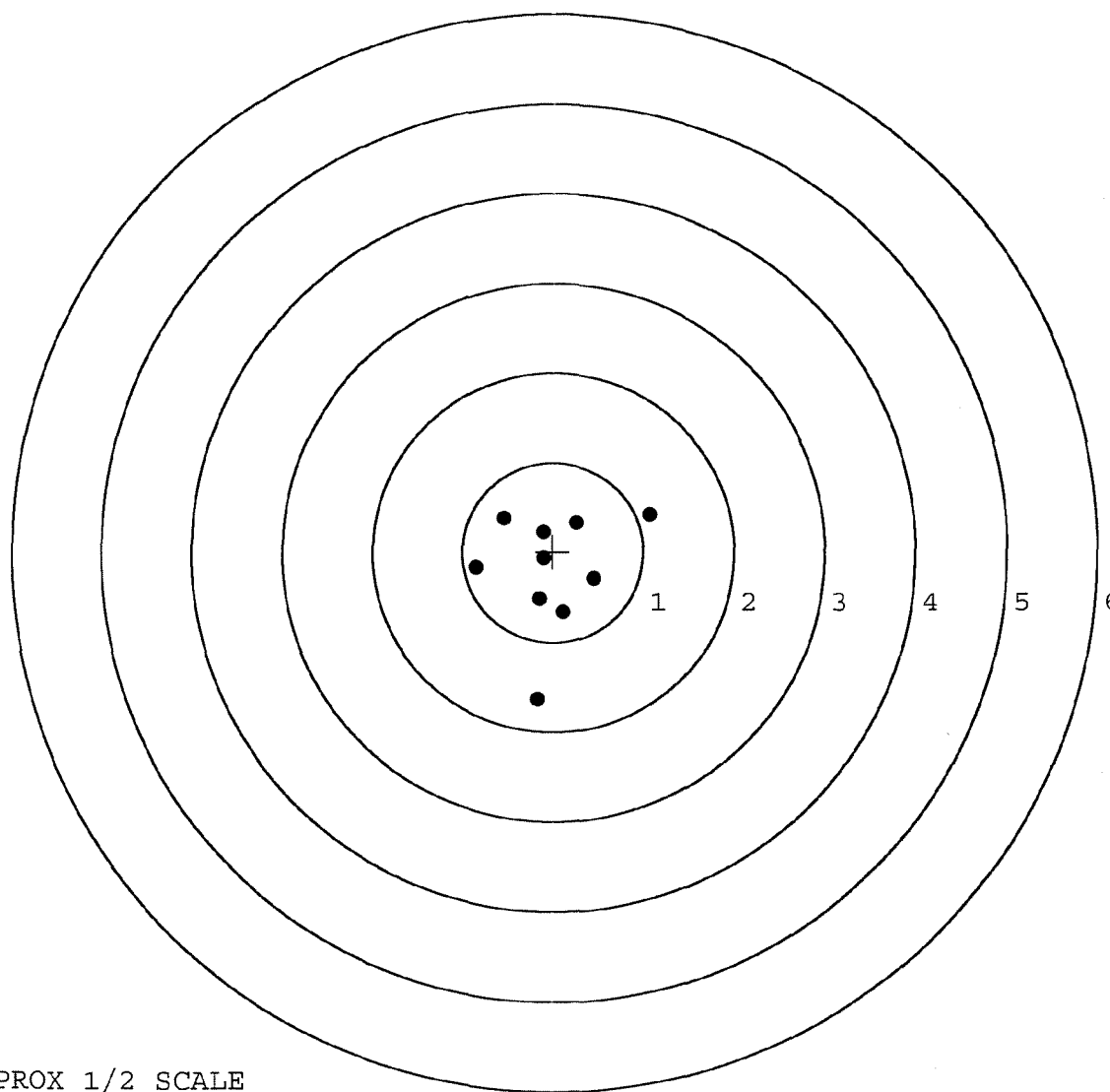
MEAN RADIUS: 0.682

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.069	0.420
2:	-0.167	-1.643
3:	-0.853	-0.175
4:	-0.545	0.374
5:	-0.147	-0.521
6:	0.120	-0.670
7:	0.457	-0.298
8:	-0.104	-0.074
9:	-0.109	0.215
10:	0.262	0.326



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535348. 0

TARGET NUMBER: 3

FILE DATE: 03/08/2006

FILE TIME: 15:59

X CENTROID: 0.202

Y CENTROID: -0.215

POA TO CENTROID: 0.295

HORZ SPREAD: 1.806

VERT SPREAD: 1.834

GROUP SPREAD: 2.177

MIN RADIUS: 0.112

MAX RADIUS: 1.428

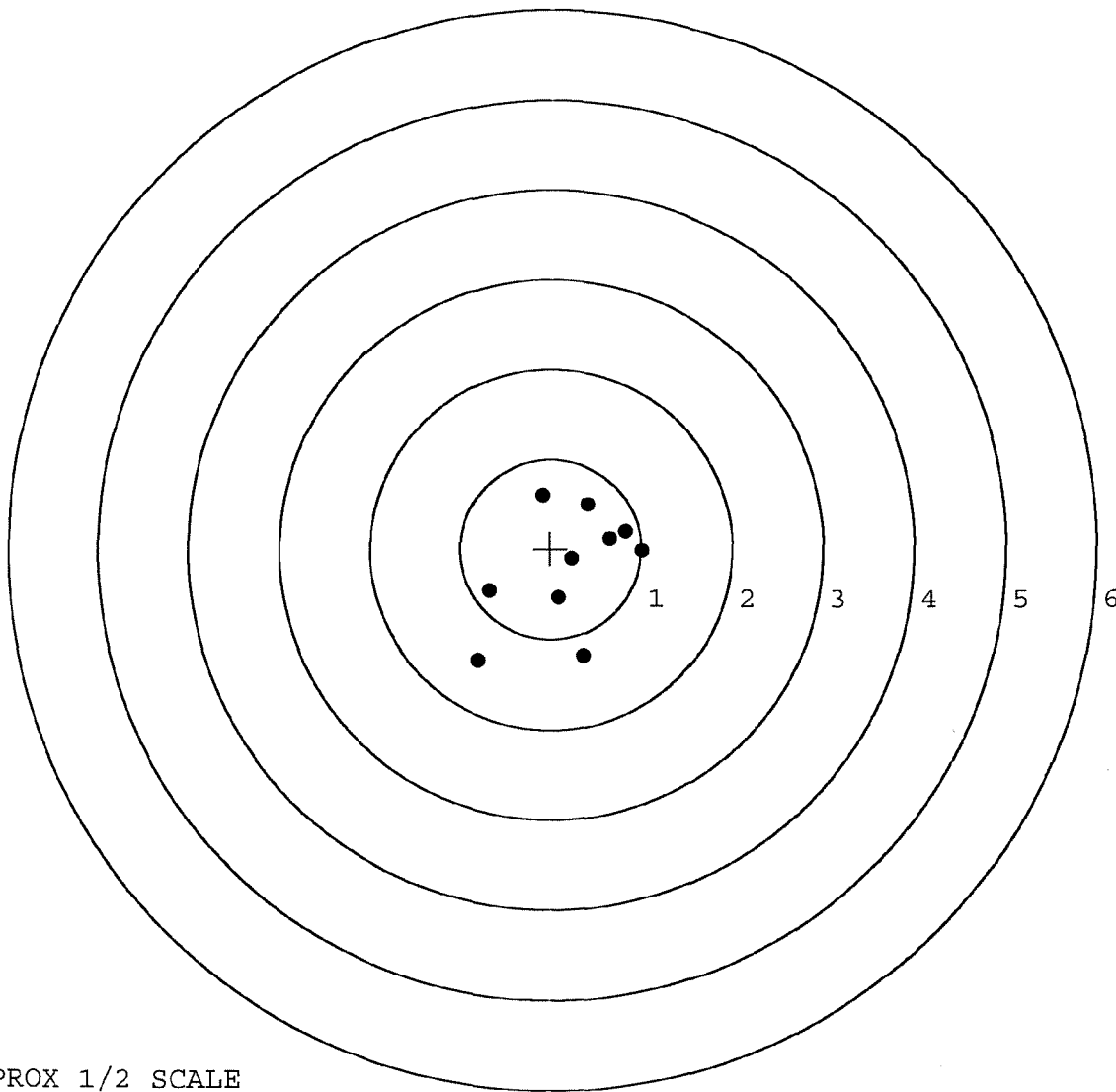
MEAN RADIUS: 0.754

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.674	-0.468
2:	-0.795	-1.236
3:	0.368	-1.186
4:	0.088	-0.551
5:	0.238	-0.109
6:	1.011	-0.020
7:	0.820	0.200
8:	0.651	0.119
9:	0.409	0.506
10:	-0.092	0.598

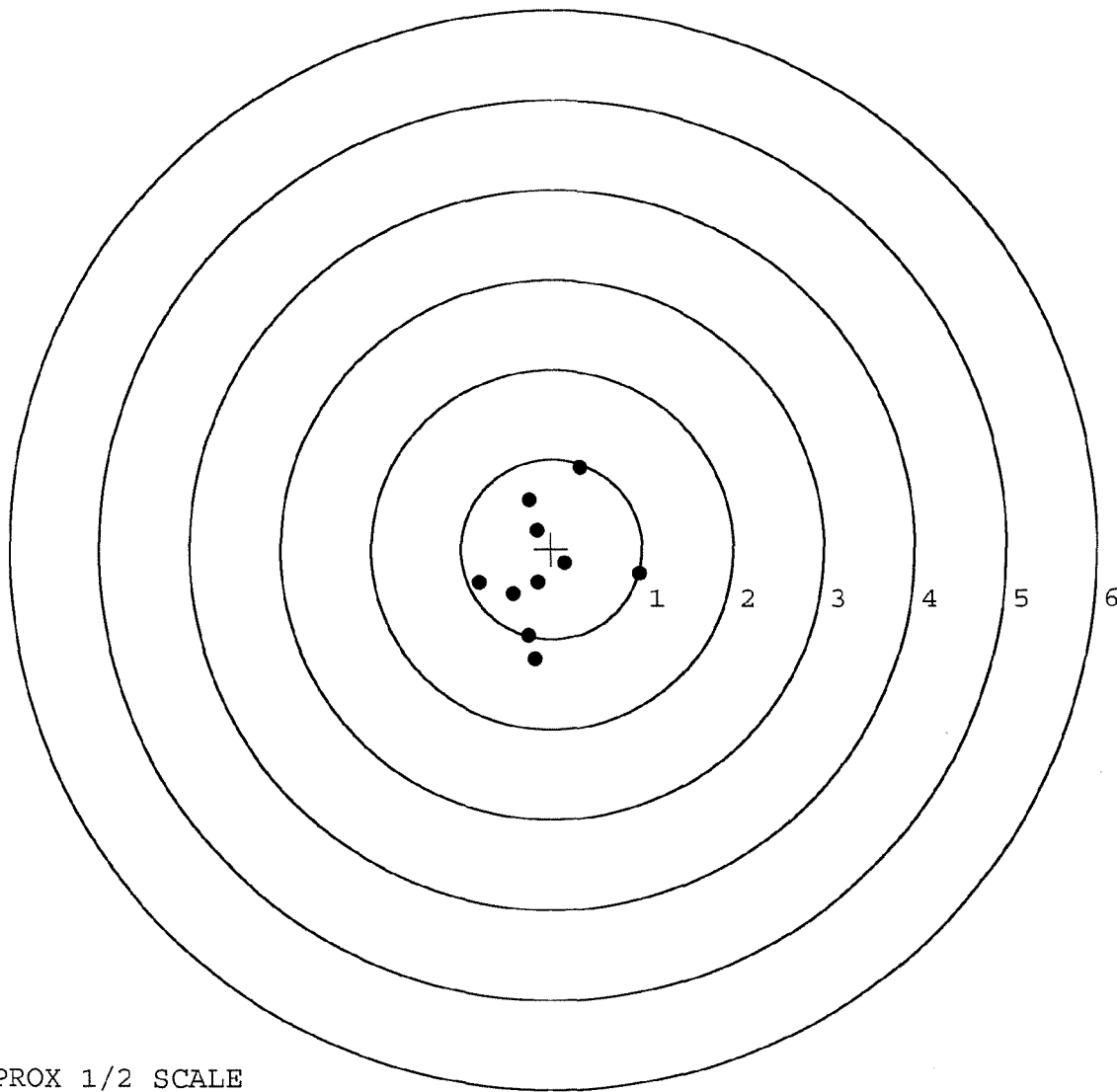


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535348. 0
TARGET NUMBER: 4
FILE DATE: 03/08/2006
FILE TIME: 15:59

X CENTROID: -0.077
Y CENTROID: -0.223
POA TO CENTROID: 0.236
HORZ SPREAD: 1.773
VERT SPREAD: 2.143
GROUP SPREAD: 2.200
MIN RADIUS: 0.169
MAX RADIUS: 1.203
MEAN RADIUS: 0.684
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.318	0.913
2:	0.974	-0.279
3:	-0.178	-1.230
4:	-0.254	-0.968
5:	-0.420	-0.500
6:	-0.150	-0.376
7:	0.150	-0.164
8:	-0.799	-0.374
9:	-0.165	0.203
10:	-0.247	0.545



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535348. 0

TARGET NUMBER: 5

FILE DATE: 03/08/2006

FILE TIME: 15:59

POINT#	X	Y
1:	0.062	0.736
2:	0.363	0.512
3:	0.617	0.270
4:	1.116	0.070
5:	0.332	-0.113
6:	0.193	-0.191
7:	-0.224	0.228
8:	-0.690	0.009
9:	-0.634	-0.446
10:	-0.283	-0.763

X CENTROID: 0.085

Y CENTROID: 0.031

POA TO CENTROID: 0.091

HORZ SPREAD: 1.806

VERT SPREAD: 1.499

GROUP SPREAD: 1.824

MIN RADIUS: 0.247

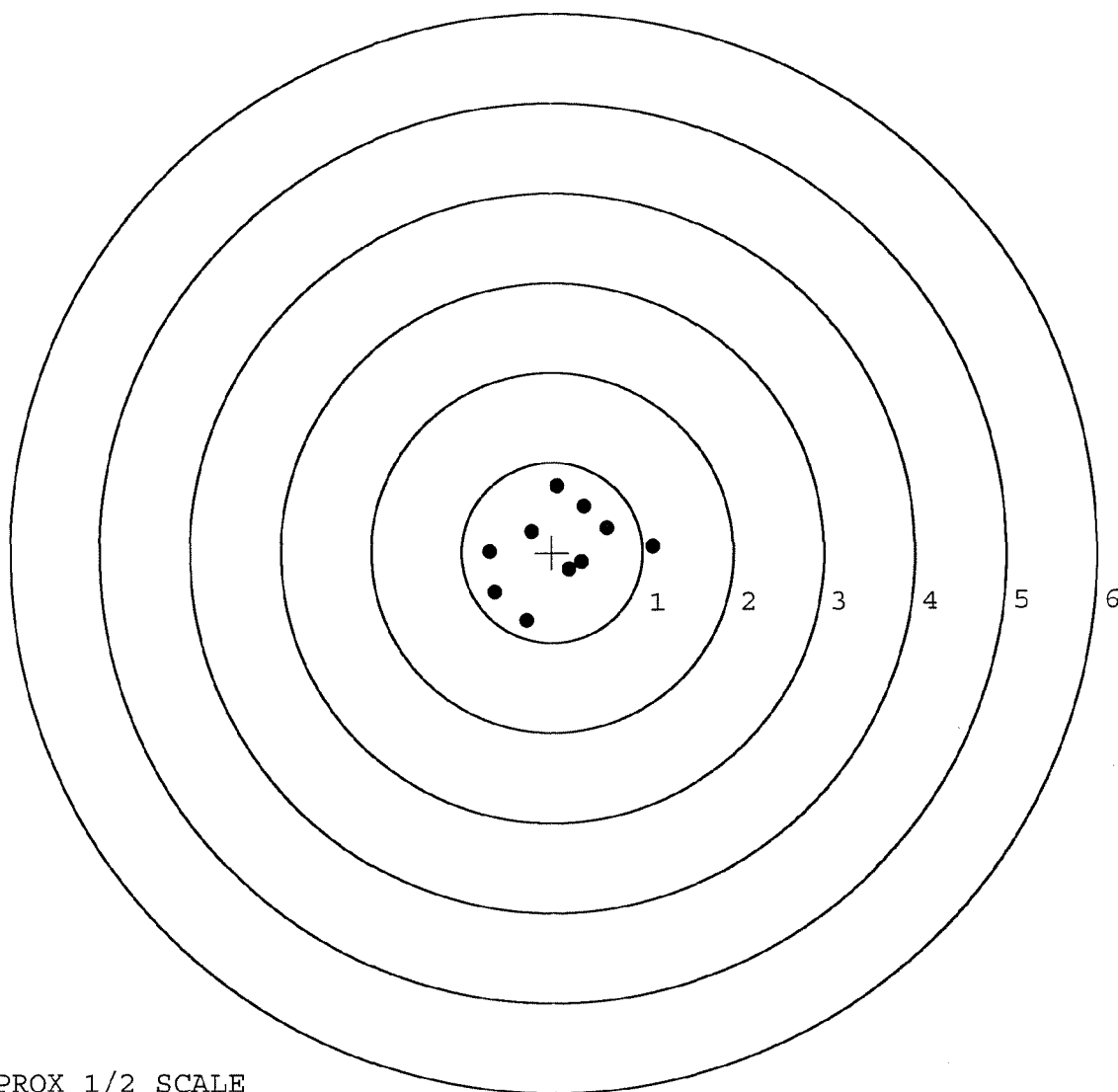
MAX RADIUS: 1.032

MEAN RADIUS: 0.629

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE