

G-6521179

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



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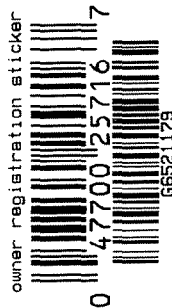
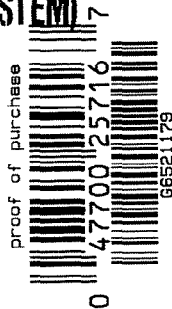
SERIAL NO.



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

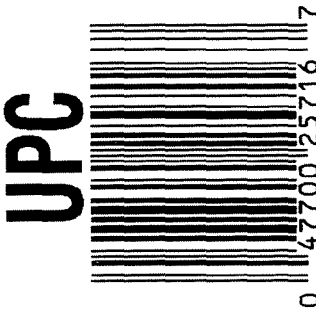
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6521179



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G652 1179

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-21-05	RTZ
440	PROOF		9-27-05	RTZ
460	CHECK HEADSPACE		9-27-05	RTZ
470	DIS-ASSEMBLE ACTION		9-28-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-3-05	CW
510	DRILL AND TAP SIGHT HOLES		9-30-05	TRW
520	GOFF BLAST BBL / REC		10-04-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/25/05	RB
	(BOLT)		10/25/05	RB
560	RE-ASSEMBLE ACTION		10/28/05	MSM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/28/05	MSM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/28/05	MSM
	D) OIL FIRING PIN ASSEMBLY		10-31-05	RTZ
	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>6 lb</u> <u>6 lb</u> <u>6 lb</u>	11-4-05	BG
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lb</u> <u>3 lb</u> <u>3 lb</u>	11-4-05	BG
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	11-4-05	BG
	J) ASSEMBLE STOCK		10-31-05	RTL
	K) ASSEMBLE SWIVEL STUDS		11-4-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-4-05	BG
	M) IRON SIGHT ALIGNMENT		11-4-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-4-05	BG
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	10/31/05	MM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/31/05	MM
670	FINAL INSPECTION A) HEADSPACE		11-4-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.82</u> <u>2.33</u> <u>2.58</u> <u>2.53</u> <u>2.60</u>	11-3-05	TRW
	C) FUNCTION		11-4-05	BG
690	PACK		12-2-05	19A

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)

SERIAL NO. _____

DATE 10-31-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.57	2.46		2.54	
PULL #2	2.65	2.46		2.48	
PULL #3	2.68	2.52		2.56	
PULL #4	2.68	2.55		2.60	
PULL #5	2.64	2.51		2.56	
TOTAL	13.22	12.50		12.74	
AVERAGE	2.64	2.50		2.54	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	3.16		
PULL #2	3.01	3.07		
PULL #3	2.98	3.16		
PULL #4	3.06	3.12		
PULL #5	3.00	3.11		
TOTAL	15.05	15.62		
AVERAGE	3.01	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	4.09	3.98		4.08
PULL #2	4.13	4.18		4.12
PULL #3	4.10	4.17		4.12
PULL #4	4.19	4.21		4.09
PULL #5	4.03	4.21		4.04
TOTAL	20.54	20.75		20.45
AVERAGE	4.10	4.15		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521179.___0
FILE DATE AND TIME: 10/31/2005 19:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.141
The Average Y Centroid of the Five Target Set:	0.087
The Average Point of Impact of the Five Target Set:	0.166
The Average Mean Radius of the Five Target Set:	0.896
The Distance from POA to Centroid Target #1:	0.132
The Distance from Centroid Target #2 to Centroid Target #1:	0.235
The Distance from Centroid Target #3 to Centroid Target #1:	0.021
The Distance from Centroid Target #4 to Centroid Target #1:	0.347
The Distance from Centroid Target #5 to Centroid Target #1:	0.213

SERIAL NUMBER: G6521179. __0

TARGET NUMBER: 1

FILE DATE: 10/31/2005

FILE TIME: 19:09

POINT#	X	Y
1:	0.537	-0.080
2:	0.682	-0.440
3:	0.362	-0.647
4:	0.413	-0.887
5:	0.203	-1.005
6:	-0.476	-0.433
7:	-0.502	0.549
8:	-1.649	1.576
9:	-0.115	1.524
10:	0.027	1.057

X CENTROID: -0.052

Y CENTROID: 0.121

POA TO CENTROID: 0.132

HORZ SPREAD: 2.331

VERT SPREAD: 2.581

GROUP SPREAD: 3.212

MIN RADIUS: 0.621

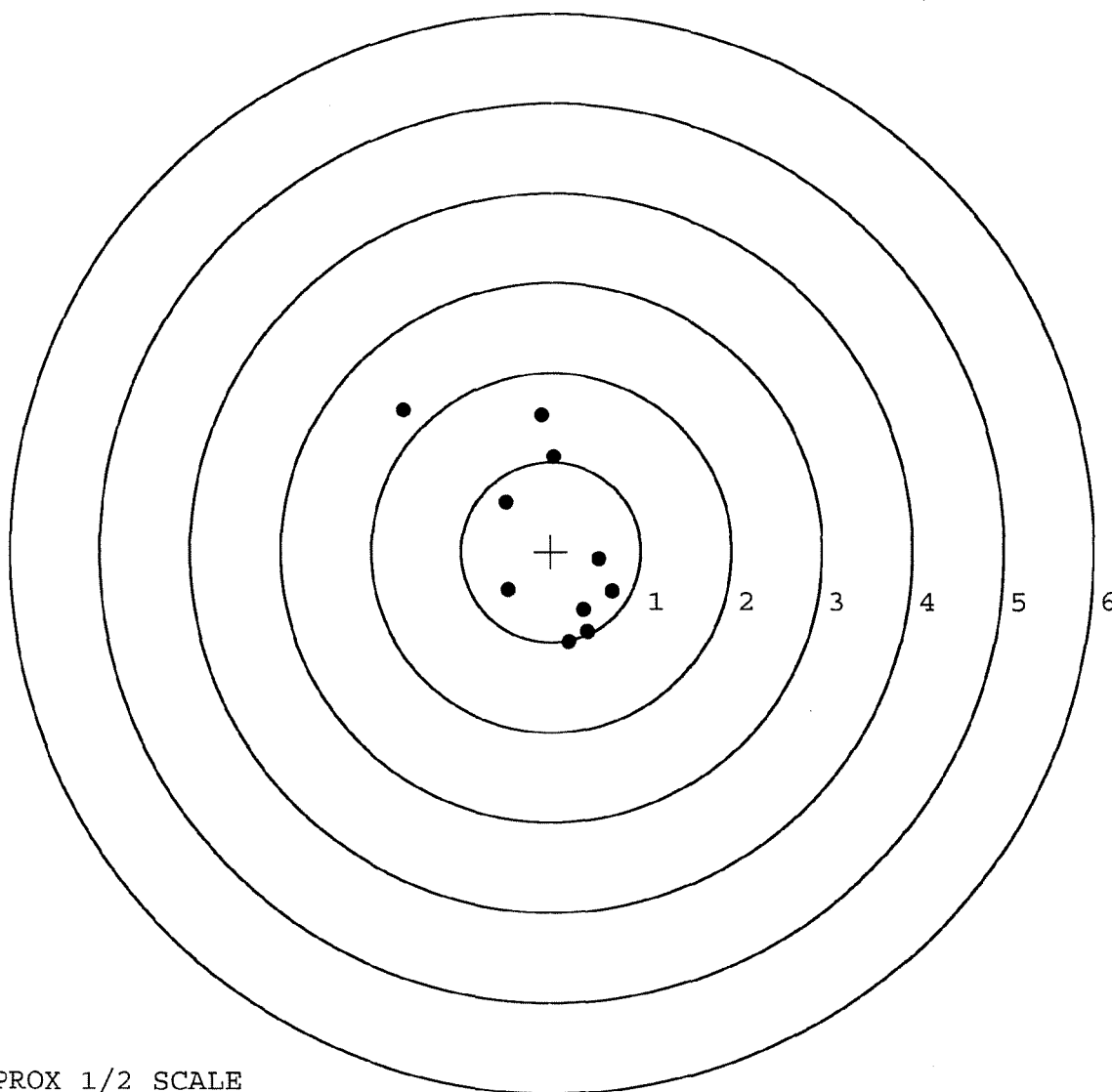
MAX RADIUS: 2.160

MEAN RADIUS: 1.051

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521179. 0

TARGET NUMBER: 2

FILE DATE: 10/31/2005

FILE TIME: 19:09

POINT#	X	Y
1:	-0.514	-0.938
2:	-0.134	-1.239
3:	0.267	-1.853
4:	-1.170	-1.222
5:	-0.463	0.370
6:	-0.554	0.726
7:	0.352	0.851
8:	0.322	1.541
9:	-0.448	2.064
10:	-0.491	0.495

X CENTROID: -0.283

Y CENTROID: 0.080

POA TO CENTROID: 0.294

HORZ SPREAD: 1.522

VERT SPREAD: 3.917

GROUP SPREAD: 3.982

MIN RADIUS: 0.342

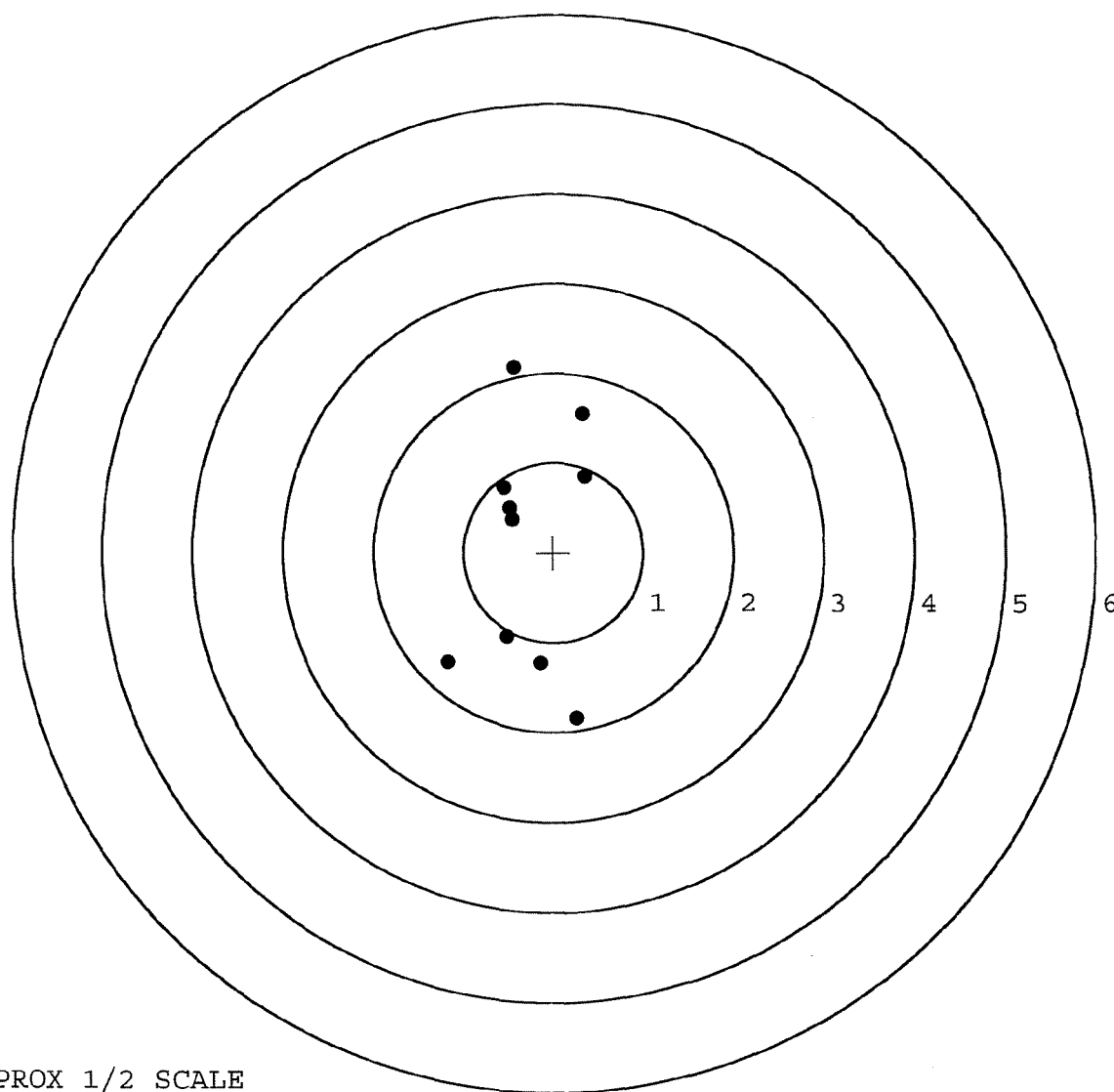
MAX RADIUS: 2.009

MEAN RADIUS: 1.203

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521179. __0

TARGET NUMBER: 3

FILE DATE: 10/31/2005

FILE TIME: 19:09

POINT#	X	Y
1:	0.150	-0.685
2:	0.488	-0.109
3:	0.496	0.245
4:	0.744	0.745
5:	0.132	0.881
6:	-0.356	1.047
7:	-0.666	0.852
8:	-0.623	0.307
9:	-0.636	-0.613
10:	-0.356	-1.276

X CENTROID: -0.063

Y CENTROID: 0.139

POA TO CENTROID: 0.153

HORZ SPREAD: 1.410

VERT SPREAD: 2.323

GROUP SPREAD: 2.323

MIN RADIUS: 0.569

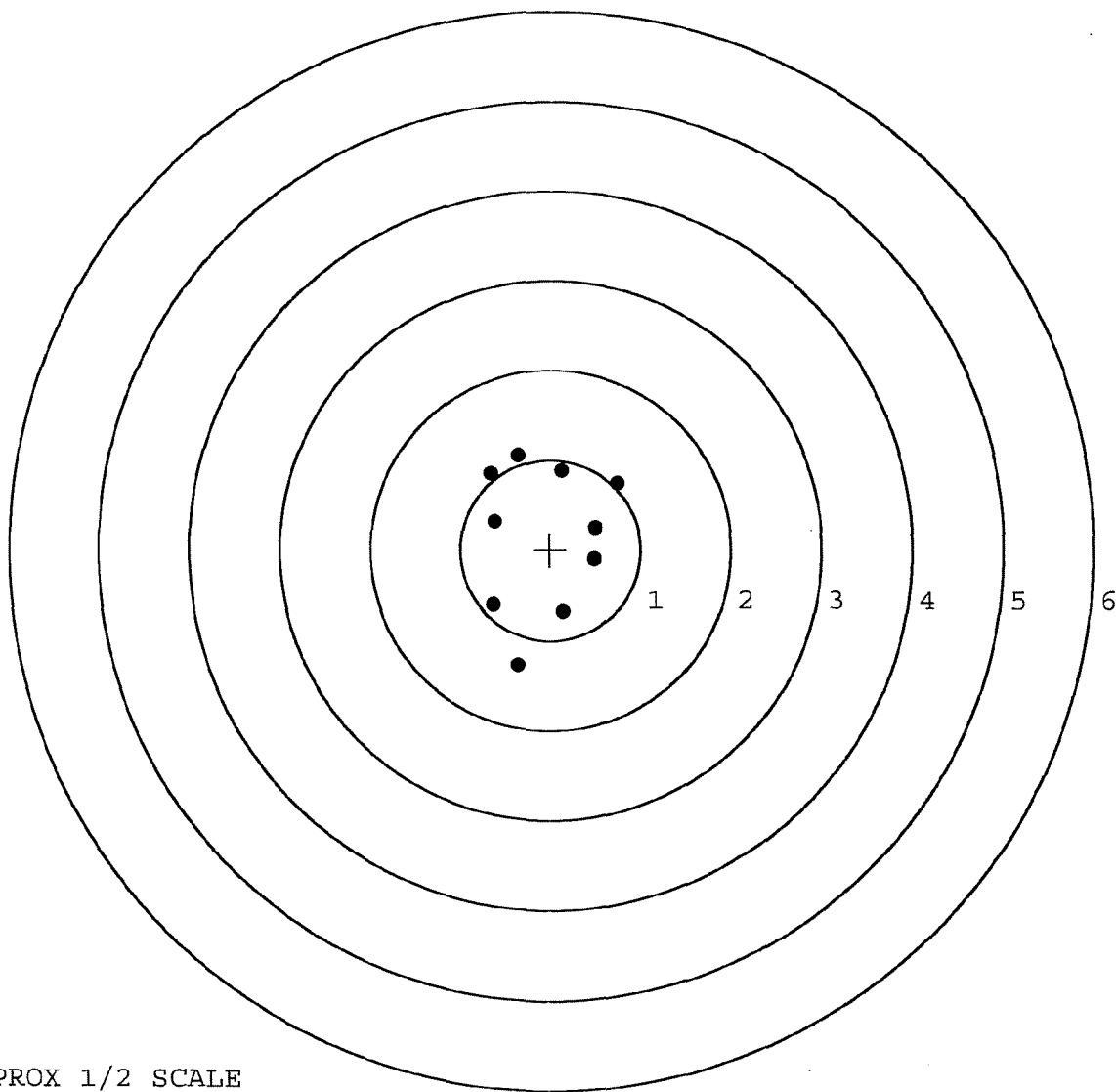
MAX RADIUS: 1.445

MEAN RADIUS: 0.866

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521179. __0

TARGET NUMBER: 4

FILE DATE: 10/31/2005

FILE TIME: 19:09

POINT#	X	Y
1:	0.442	0.325
2:	0.251	-0.839
3:	-0.366	-0.326
4:	-0.597	-0.477
5:	-0.614	-0.130
6:	-0.742	0.120
7:	-0.553	0.248
8:	-0.716	0.453
9:	-0.766	0.952
10:	-0.321	0.986

X CENTROID: -0.398

Y CENTROID: 0.131

POA TO CENTROID: 0.419

HORZ SPREAD: 1.208

VERT SPREAD: 1.825

GROUP SPREAD: 2.060

MIN RADIUS: 0.194

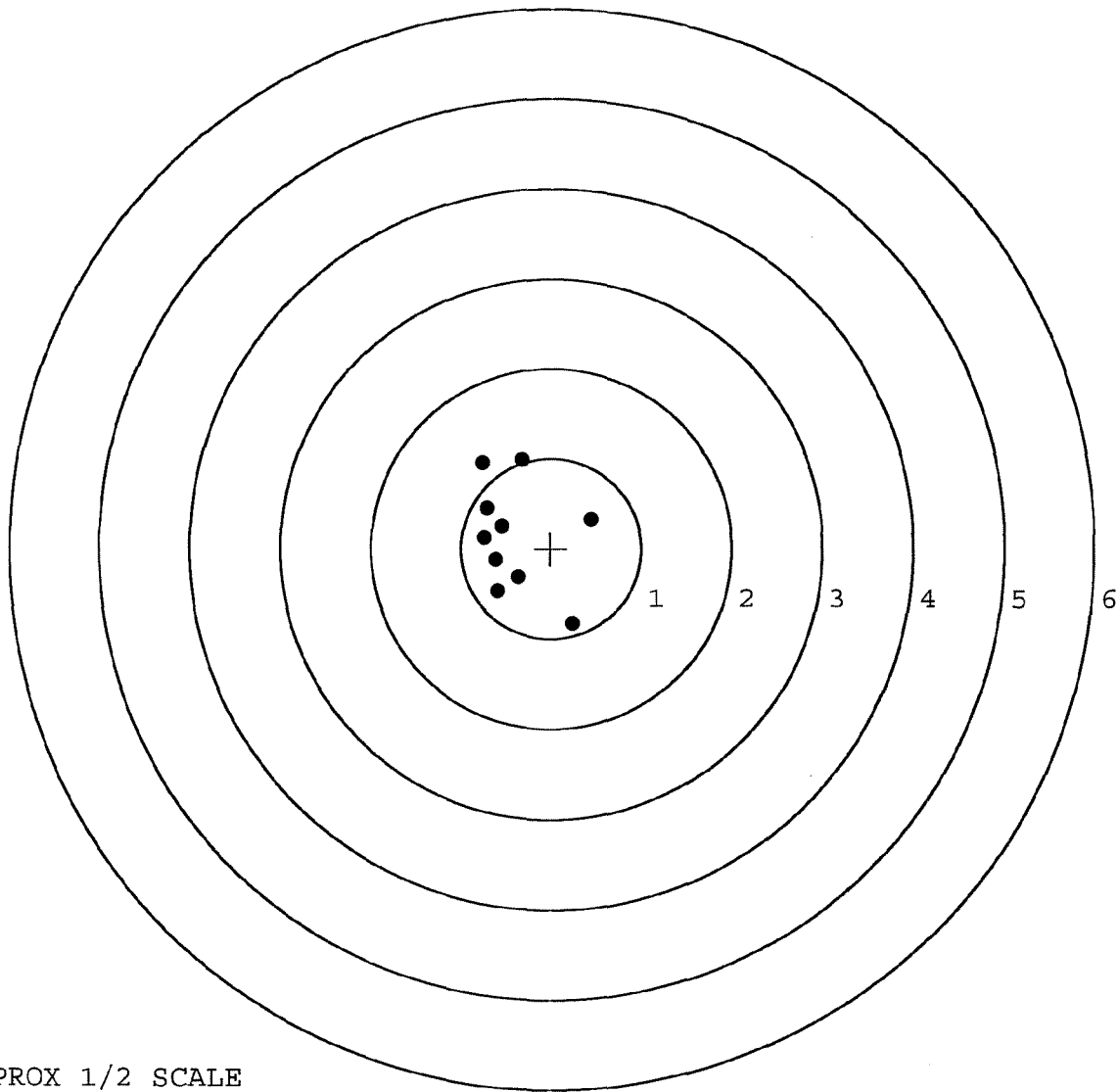
MAX RADIUS: 1.167

MEAN RADIUS: 0.621

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521179. __0

TARGET NUMBER: 5

FILE DATE: 10/31/2005

FILE TIME: 19:09

POINT#	X	Y
1:	-0.262	-0.365
2:	-0.057	-0.287
3:	0.182	-0.235
4:	0.815	-0.271
5:	0.643	-0.131
6:	1.050	0.344
7:	0.590	0.745
8:	-0.677	0.664
9:	-0.637	0.172
10:	-0.752	-1.021

X CENTROID: 0.089

Y CENTROID: -0.039

POA TO CENTROID: 0.097

HORZ SPREAD: 1.802

VERT SPREAD: 1.766

GROUP SPREAD: 2.261

MIN RADIUS: 0.217

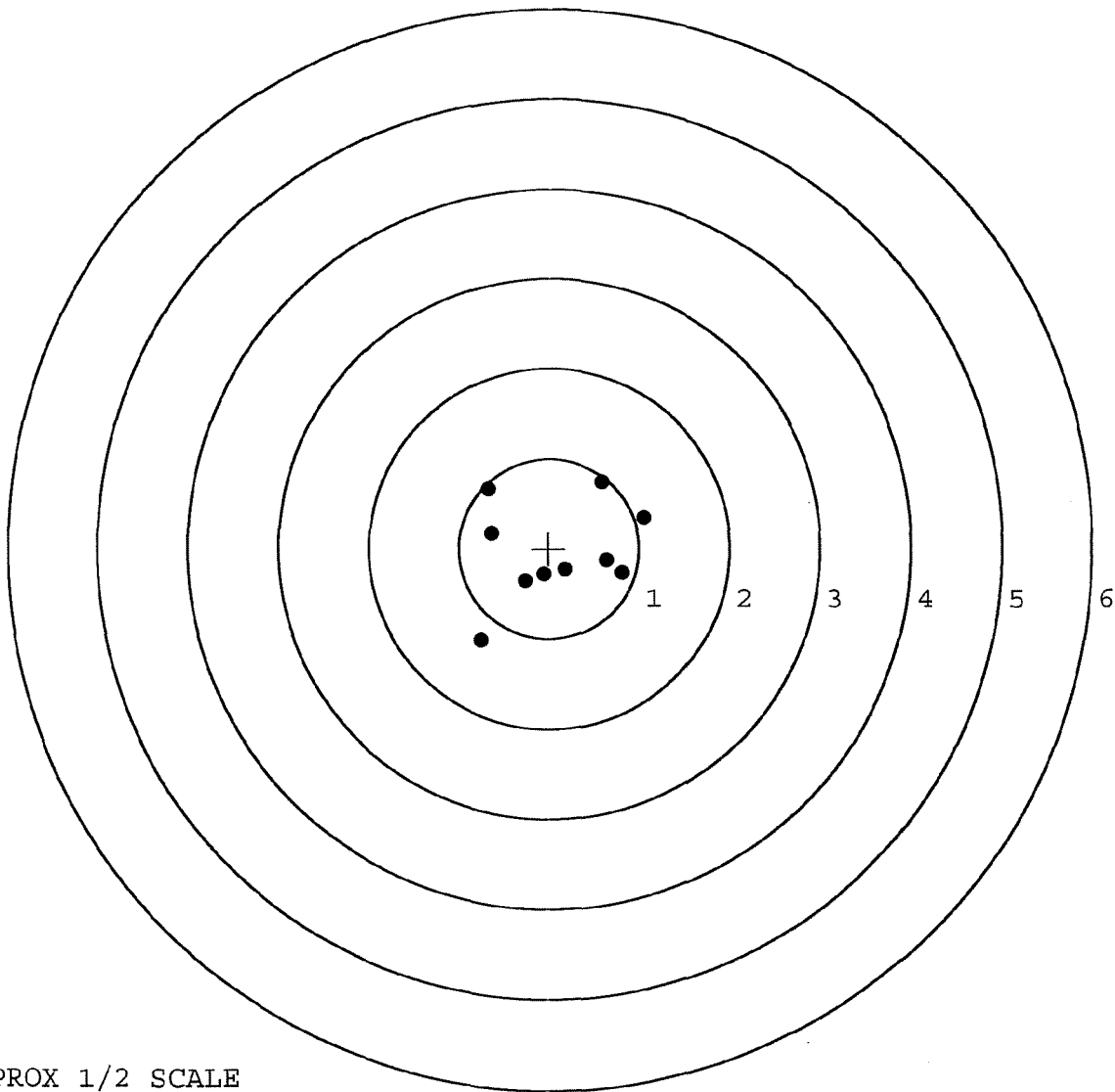
MAX RADIUS: 1.294

MEAN RADIUS: 0.736

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE