

G 652,1410

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

- INSTRUCTION BOOK 3518



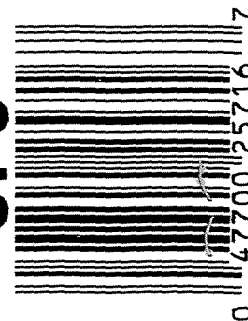
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6521410

UPC



DD FORM

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

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL0521410

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-12-06	RTZ
440	PROOF		1-12-06	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX	1-12-06	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	1-13-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 13 2006 4/80 OPERATOR <i>unns</i>	1/18/06	<i>unns</i>
500	ROLLMARK CALIBER		1-18-06	CW
510	DRILL AND TAP SIGHT HOLES		1-16-06	TRW
520	GOFF BLAST BBL / REC		1-18-06	DG
530 & 540	APPLY COATINGS (BARREL ACTION)		1/19	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1/25/06	mgg
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1/25/06	mgg
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1/25/06	mgg
	D) OIL FIRING PIN ASSEMBLY		1-27-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		2-27-06	mjm
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.0</u> <u>5.0</u>	1-29-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.0</u> <u>2.0</u>	1-29-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		2-21-06	MJM
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	2-21-06	MJM
	J) ASSEMBLE STOCK		1-27-06	RTL
	K) ASSEMBLE SWIVEL STUDS		3/27/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-27-06	RTL
	M) IRON SIGHT ALIGNMENT		1-27-06	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-27-06	RTL
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	1/27/06	MJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-27-06	MJM
670	FINAL INSPECTION A) HEADSPACE		2-21-06	MJM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.81</u> <u>2.75</u> <u>2.60</u> <u>2.71</u> <u>2.76</u>	1-27-06	DA
	C) FUNCTION		2-21-06	MJM
690	PACK		3-28-06	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 1-27-06

TESTER R.P

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.60	2.67		2.57	
PULL #2	2.58	2.61		2.55	
PULL #3	2.50	2.53		2.57	
PULL #4	2.49	2.52		2.48	
PULL #5	2.56	2.51		2.49	
TOTAL	12.73	12.84		12.66	
AVERAGE	2.54	2.56		2.53	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.18		
PULL #2	2.98	3.17		
PULL #3	3.05	3.27		
PULL #4	3.15	3.26		
PULL #5	3.16	3.24		
TOTAL	15.44	16.12		
AVERAGE	3.08	3.22		

	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	4.00	4.00		4.09
PULL #2	3.99	3.95		4.03
PULL #3	3.98	4.18		3.96
PULL #4	4.07	4.16		4.17
PULL #5	4.12	4.15		4.06
TOTAL	20.16	20.44		20.31
AVERAGE	4.03	4.08		4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521410.___0
FILE DATE AND TIME: 01/27/2006 22:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

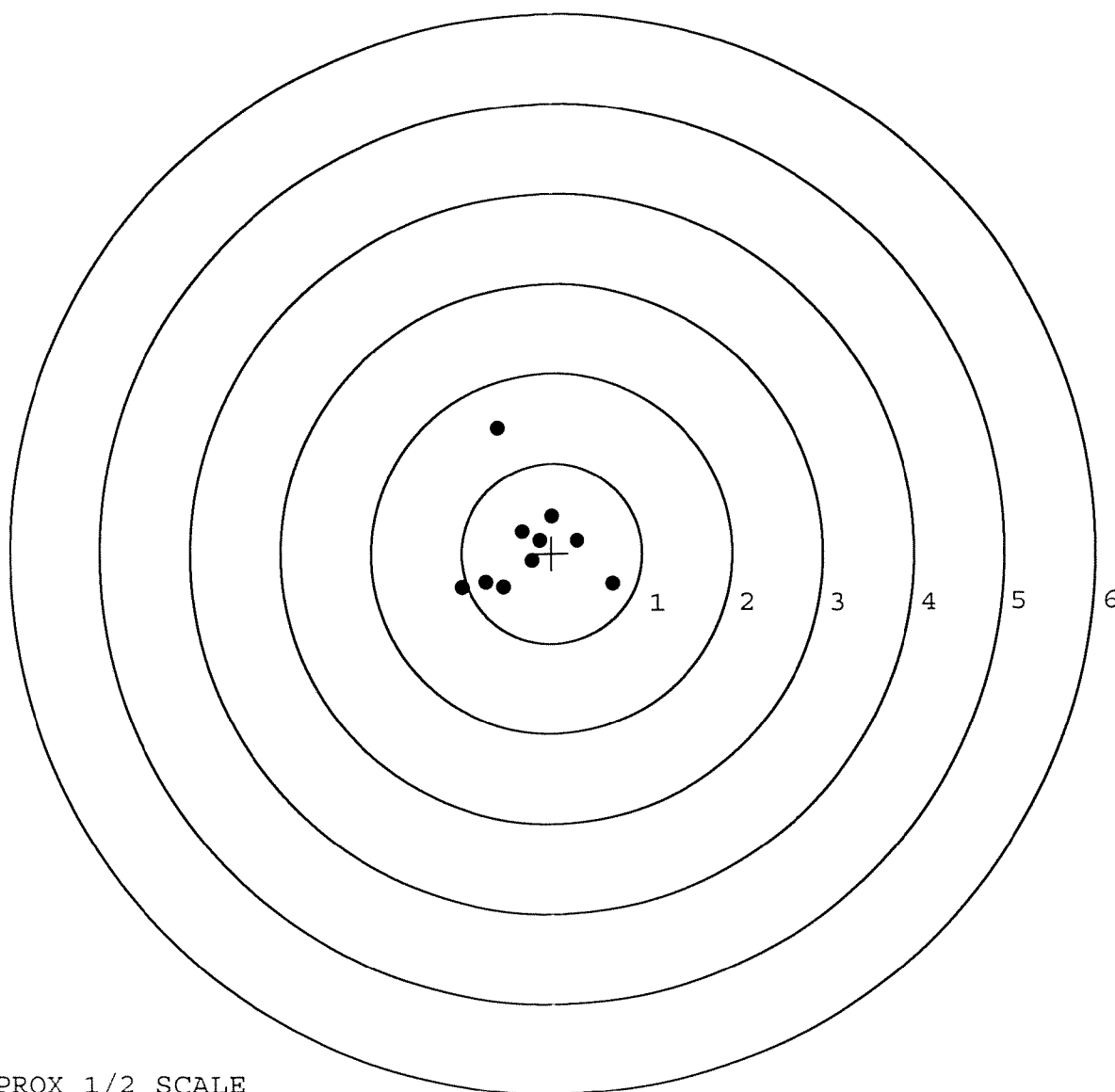
The Average X Centroid of the Five Target Set:	-0.135
The Average Y Centroid of the Five Target Set:	-0.051
The Average Point of Impact of the Five Target Set:	0.145
The Average Mean Radius of the Five Target Set:	0.565
The Distance from POA to Centroid Target #1:	0.271
The Distance from Centroid Target #2 to Centroid Target #1:	0.426
The Distance from Centroid Target #3 to Centroid Target #1:	0.226
The Distance from Centroid Target #4 to Centroid Target #1:	0.244
The Distance from Centroid Target #5 to Centroid Target #1:	0.079

SERIAL NUMBER: G6521410.___0
TARGET NUMBER: 1
FILE DATE: 01/27/2006
FILE TIME: 22:22

X CENTROID: -0.258
Y CENTROID: 0.084
POA TO CENTROID: 0.271
HORZ SPREAD: 1.673
VERT SPREAD: 1.773
GROUP SPREAD: 2.159
MIN RADIUS: 0.137
MAX RADIUS: 1.355
MEAN RADIUS: 0.585

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.285	0.137
2:	0.000	0.409
3:	-0.333	0.244
4:	-0.223	-0.083
5:	-0.135	0.145
6:	-0.534	-0.373
7:	-0.994	-0.377
8:	-0.596	1.396
9:	0.679	-0.346
10:	-0.728	-0.316



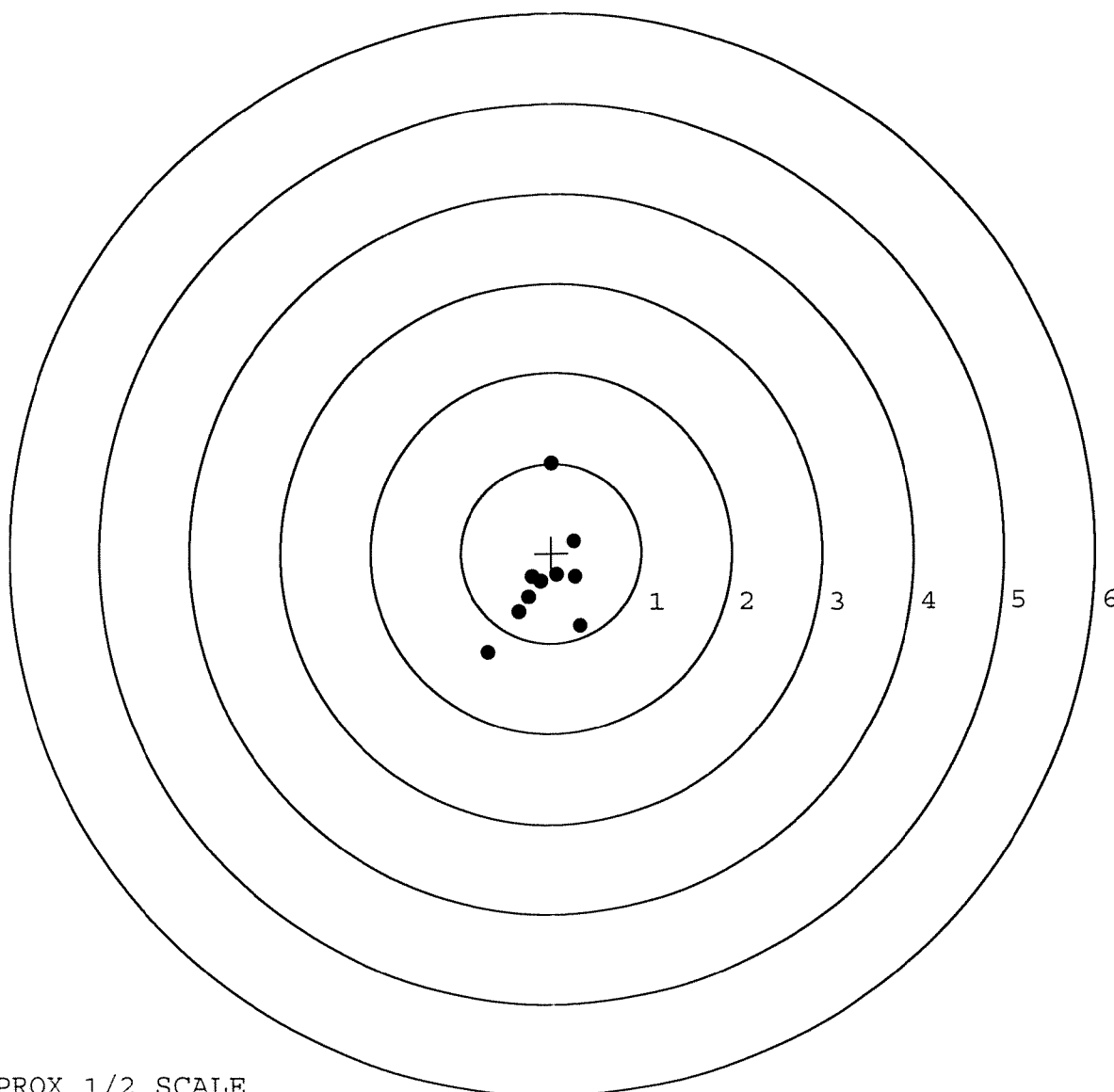
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521410. __0
TARGET NUMBER: 2
FILE DATE: 01/27/2006
FILE TIME: 22:22

X CENTROID: -0.078
Y CENTROID: -0.303
POA TO CENTROID: 0.313
HORZ SPREAD: 1.020
VERT SPREAD: 2.108
GROUP SPREAD: 2.224
MIN RADIUS: 0.046
MAX RADIUS: 1.310
MEAN RADIUS: 0.491

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.247	0.129
2:	0.261	-0.268
3:	0.058	-0.246
4:	-0.121	-0.317
5:	-0.255	-0.493
6:	-0.364	-0.659
7:	-0.705	-1.103
8:	0.315	-0.815
9:	0.003	1.005
10:	-0.215	-0.261

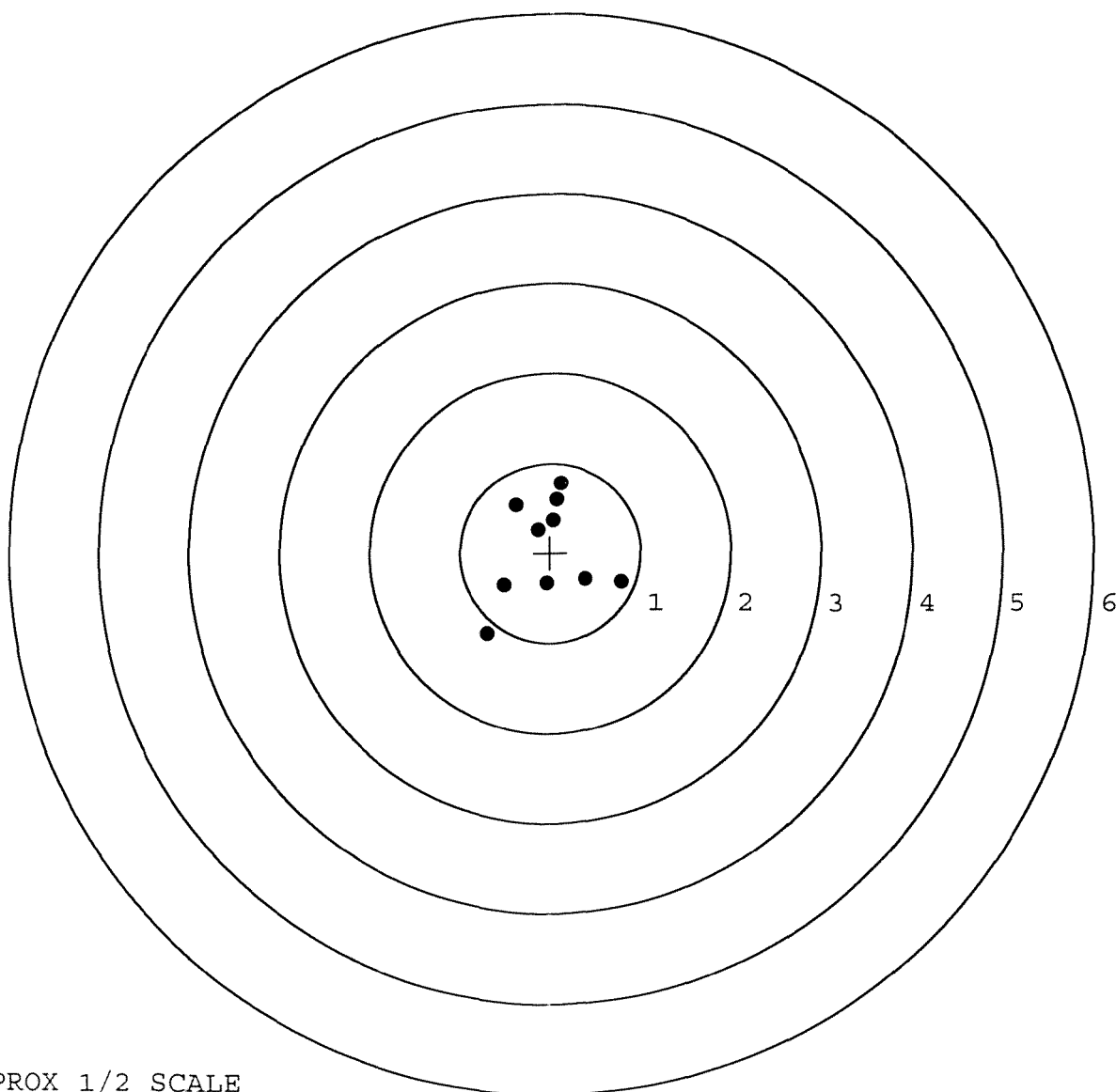


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521410. __0
TARGET NUMBER: 3
FILE DATE: 01/27/2006
FILE TIME: 22:22

X CENTROID: -0.039
Y CENTROID: 0.029
POA TO CENTROID: 0.048
HORZ SPREAD: 1.483
VERT SPREAD: 1.677
GROUP SPREAD: 1.863
MIN RADIUS: 0.248
MAX RADIUS: 1.140
MEAN RADIUS: 0.610
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

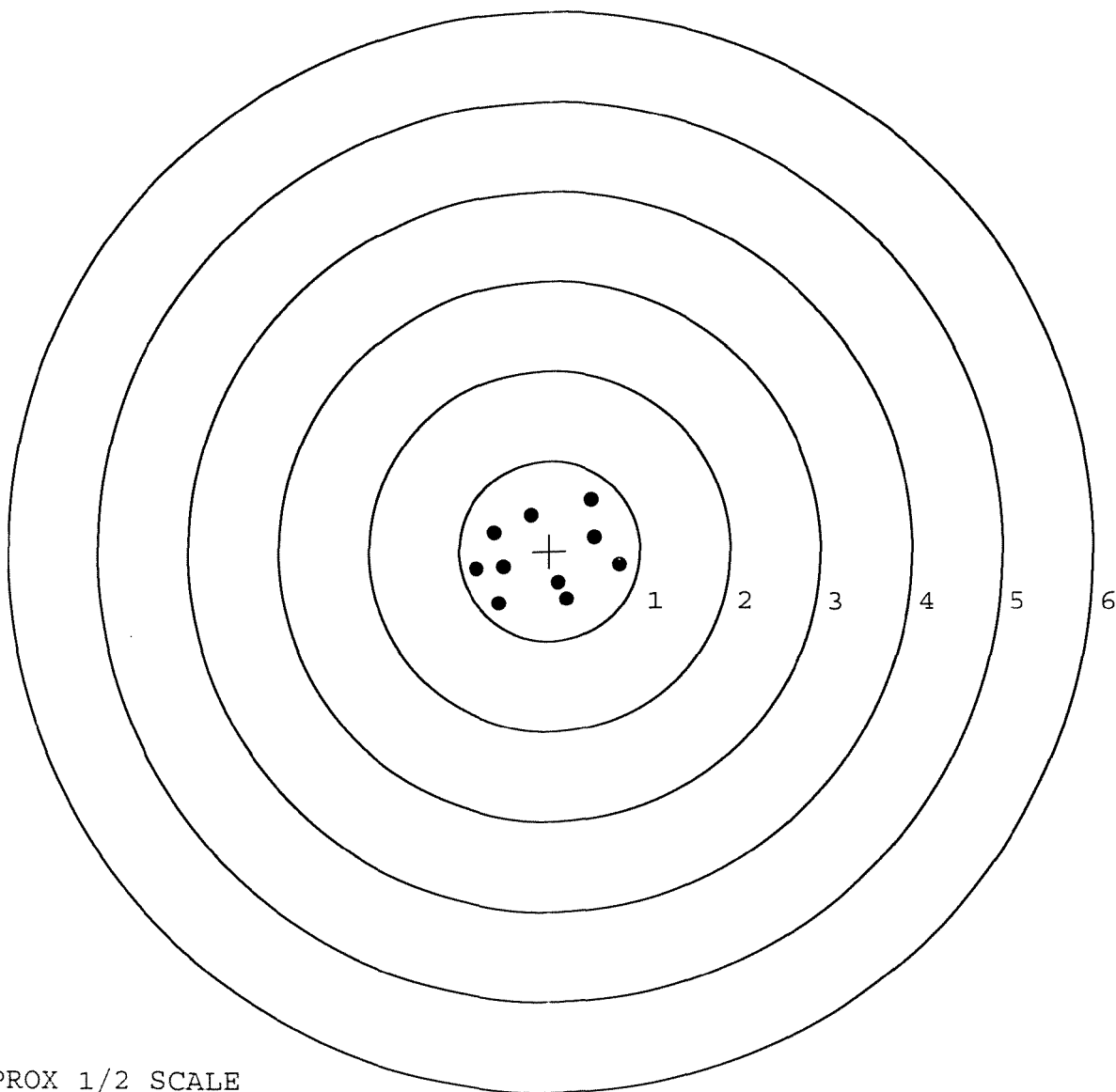
POINT#	X	Y
1:	-0.141	0.255
2:	0.027	0.362
3:	0.067	0.595
4:	0.115	0.774
5:	-0.385	0.536
6:	-0.507	-0.365
7:	-0.696	-0.903
8:	-0.043	-0.342
9:	0.390	-0.294
10:	0.787	-0.330



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521410.____0
TARGET NUMBER: 4
FILE DATE: 01/27/2006
FILE TIME: 22:22

	POINT#	X	Y
	1:	0.494	0.149
	2:	0.462	0.563
	3:	-0.208	0.398
	4:	-0.614	0.203
X CENTROID:	5:	-0.811	-0.208
Y CENTROID:	6:	-0.513	-0.179
POA TO CENTROID:	7:	-0.566	-0.583
HORZ SPREAD:	8:	0.096	-0.357
VERT SPREAD:	9:	0.190	-0.544
GROUP SPREAD:	10:	0.779	-0.157
MIN RADIUS:		0.330	
MAX RADIUS:		0.852	
MEAN RADIUS:		0.618	
# IN 1 IN DIAMETER:		3	
# IN 2 IN DIAMETER:		10	
# in 3 IN DIAMETER:		10	

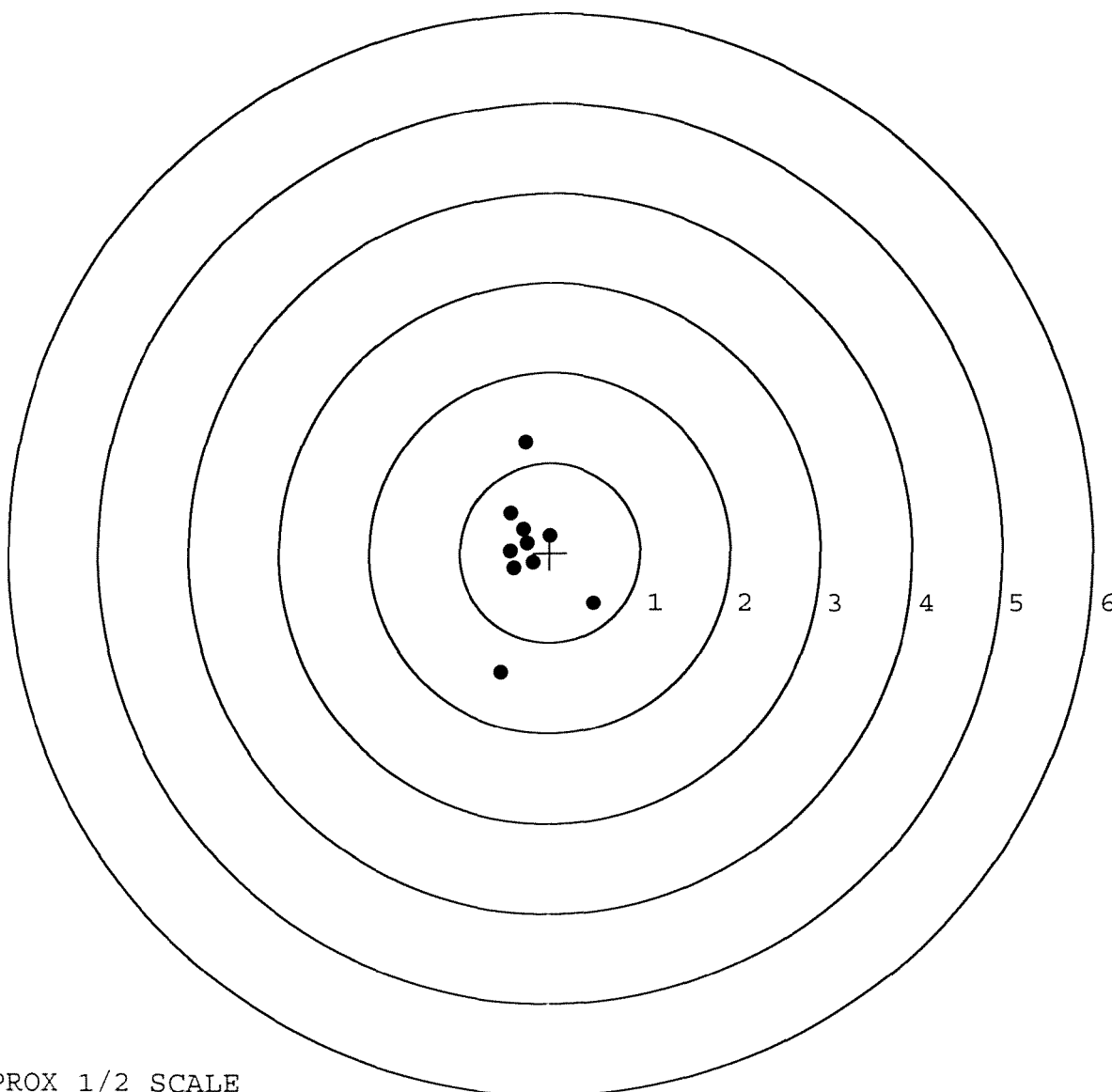


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521410. __0
TARGET NUMBER: 5
FILE DATE: 01/27/2006
FILE TIME: 22:22

POINT#	X	Y
1:	0.490	-0.566
2:	-0.189	-0.108
3:	-0.396	-0.172
4:	-0.435	0.023
5:	-0.254	0.107
6:	-0.004	0.187
7:	-0.294	0.263
8:	-0.438	0.443
9:	-0.278	1.233
10:	-0.537	-1.327

X CENTROID: -0.233
Y CENTROID: 0.008
POA TO CENTROID: 0.234
HORZ SPREAD: 1.027
VERT SPREAD: 2.560
GROUP SPREAD: 2.573
MIN RADIUS: 0.101
MAX RADIUS: 1.369
MEAN RADIUS: 0.522
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE