

G6414405

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC



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UPC



SERIAL NO.



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

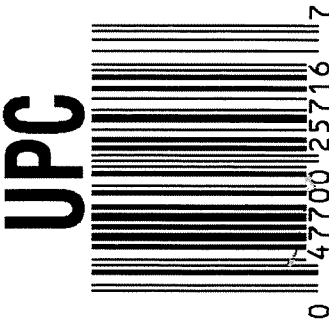
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6414405



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-9-04	RTL
600	PROOF		11-9-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	11-9-04	RTL
610	DIS-ASSEMBLE GUN	NOV 22 2004	11-10-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		11/11/04	AB
617	DRILL AND TAP SIGHT HOLES		11-10-04	TRW
620	APPLY COATINGS (BARREL ACTION)		11/13	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11/29/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/29/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/29/04	DA
	D) OIL FIRING PIN ASSEMBLY		11-30-04	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.9</u> <u>5.9</u> <u>5.9</u>	12/3/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.9</u> <u>2.9</u> <u>2.9</u>	12/3/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.025</u> <u>.022</u>	12/3/04	DA
	J) ASSEMBLE STOCK		11-30-04	RTL
	K) ASSEMBLE SWIVEL STUDS		12-3-04	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		NA	NA
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	12-1-04	NA
	MALFUNCTION	CORRECTION	NA	NA
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-1-04	NA
655	FINAL INSPECTION A) HEADSPACE		12-3-04	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.76</u> <u>2.78</u> <u>2.67</u> <u>2.66</u>	12/3/04	DA
	C) FUNCTION		12-3-04	AC
660	PACK		12/6/04	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)

SERIAL NO. _____

DATE

11-30-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.02	2.06		2.52	
PULL #2	2.70	2.03		2.53	
PULL #3	2.36	2.05		2.42	
PULL #4	2.08	2.02		2.35	
PULL #5	2.14	2.11 TRW		2.25	
TOTAL	11.30	10.27		12.07	
AVERAGE	2.26	2.05		2.41	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.12		
PULL #2	3.10	3.07		
PULL #3	3.04	3.08		
PULL #4	3.08	3.09		
PULL #5	3.06	3.10		
TOTAL	15.46	15.46		
AVERAGE	3.09	3.09		

	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	4.23		4.22
PULL #2	4.08	4.22		4.01
PULL #3	4.16	4.24		4.32
PULL #4	4.15	4.25		4.43
PULL #5	4.14	4.35		4.50
TOTAL	20.68	21.29		21.48
AVERAGE	4.13	4.25		4.29

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414405.__1
FILE DATE AND TIME: 10/08/2005 04:06

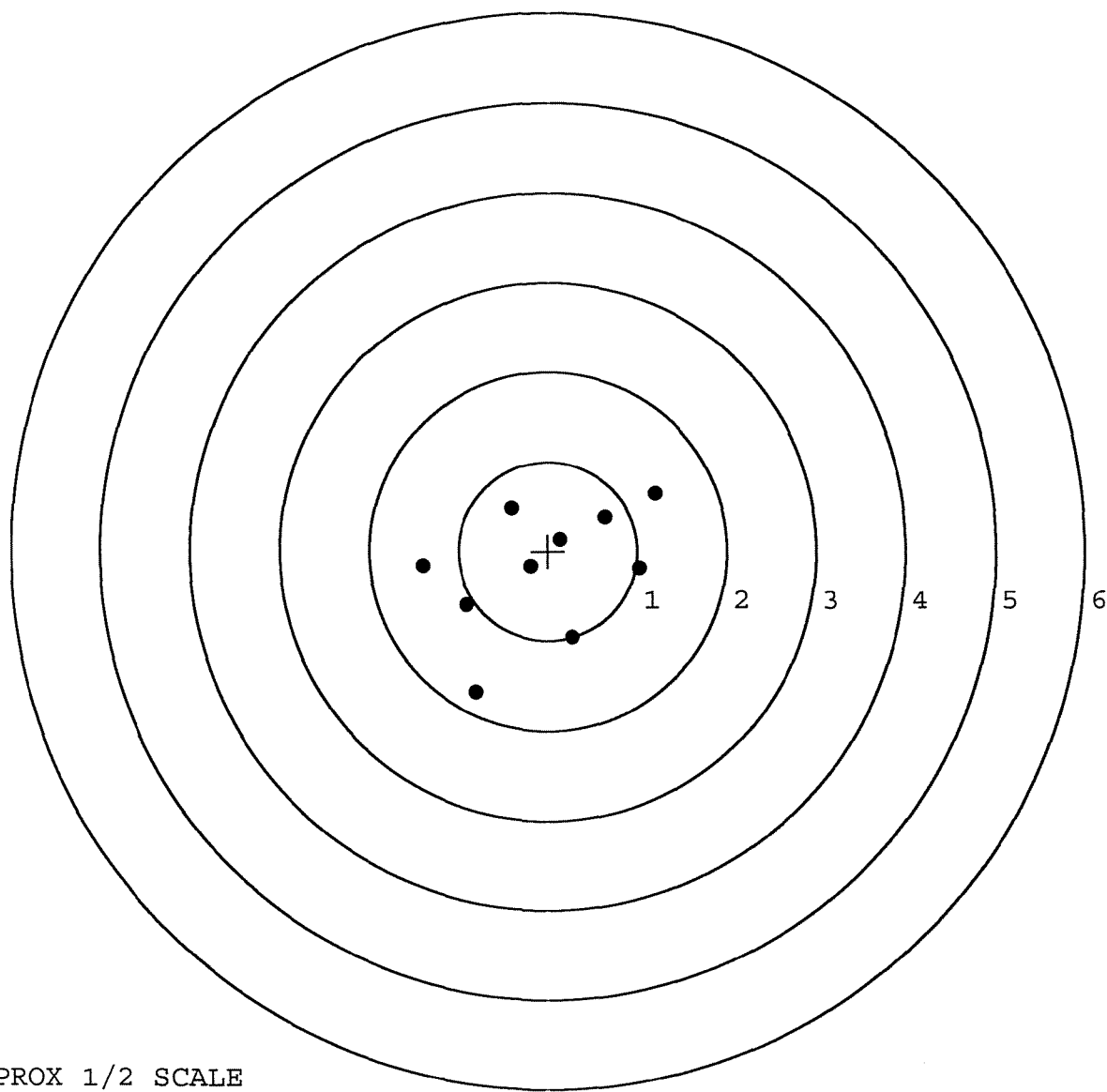
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.147
The Average Y Centroid of the Five Target Set:	-0.157
The Average Point of Impact of the Five Target Set:	0.215
The Average Mean Radius of the Five Target Set:	0.894
The Distance from POA to Centroid Target #1:	0.211
The Distance from Centroid Target #2 to Centroid Target #1:	0.372
The Distance from Centroid Target #3 to Centroid Target #1:	0.307
The Distance from Centroid Target #4 to Centroid Target #1:	0.139
The Distance from Centroid Target #5 to Centroid Target #1:	0.202

SERIAL NUMBER: G6414405. __1
 TARGET NUMBER: 1
 FILE DATE: 10/08/2005
 FILE TIME: 04:06

X CENTROID: -0.045
 Y CENTROID: -0.207
 POA TO CENTROID: 0.211
 HORZ SPREAD: 2.600
 VERT SPREAD: 2.219
 GROUP SPREAD: 2.985
 MIN RADIUS: 0.155
 MAX RADIUS: 1.564
 MEAN RADIUS: 0.949
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.021	-0.197
2:	1.194	0.644
3:	0.641	0.380
4:	0.135	0.133
5:	0.278	-0.967
6:	-0.197	-0.177
7:	-0.802	-1.575
8:	-0.913	-0.607
9:	-1.406	-0.175
10:	-0.400	0.475

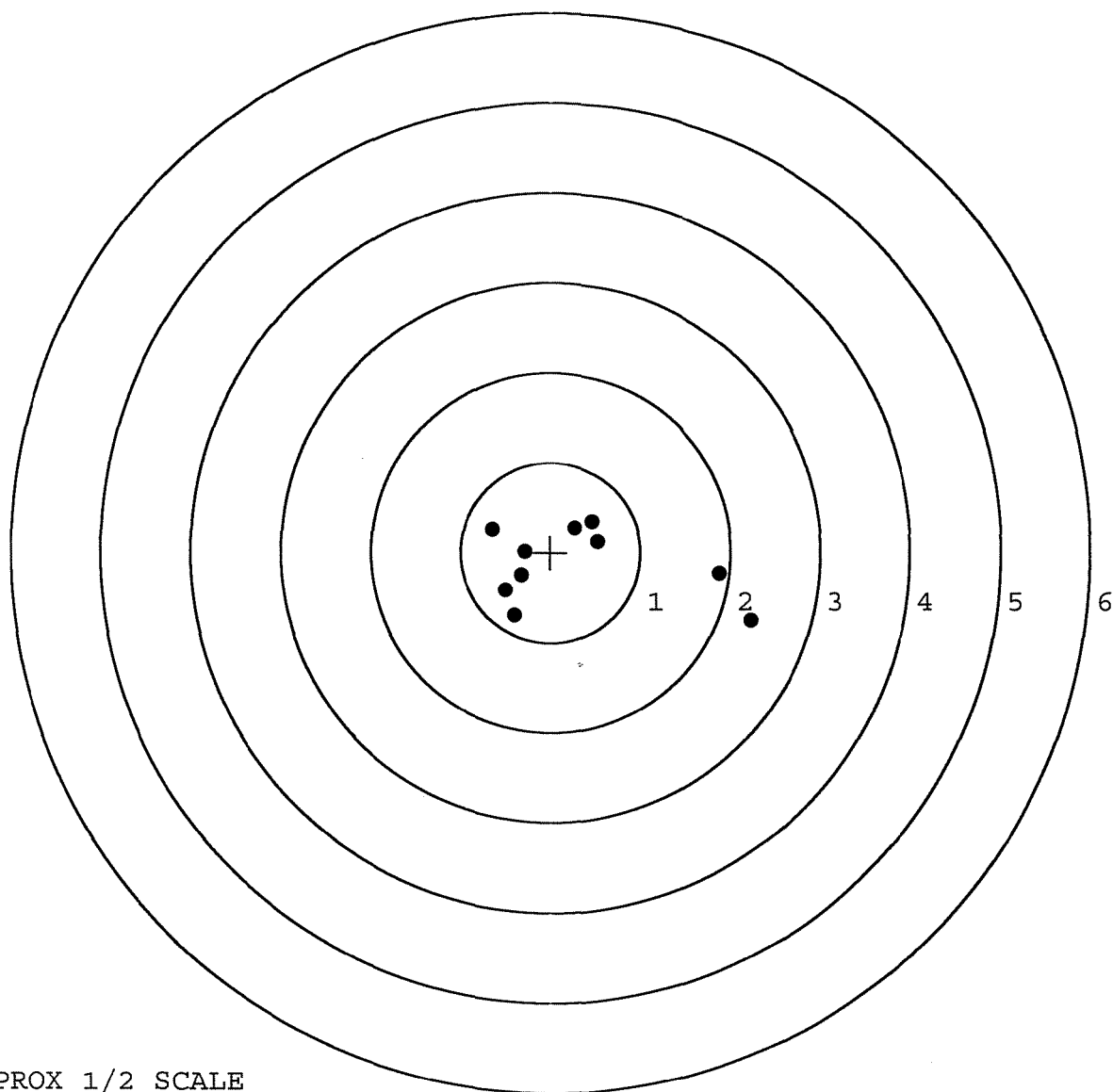


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414405. __1
TARGET NUMBER: 2
FILE DATE: 10/08/2005
FILE TIME: 04:06

X CENTROID: 0.320
Y CENTROID: -0.137
POA TO CENTROID: 0.348
HORZ SPREAD: 2.872
VERT SPREAD: 1.106
GROUP SPREAD: 3.046
MIN RADIUS: 0.334
MAX RADIUS: 2.001
MEAN RADIUS: 0.892
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	2.222	-0.760
2:	1.876	-0.238
3:	0.465	0.346
4:	0.268	0.270
5:	-0.402	-0.703
6:	-0.501	-0.420
7:	-0.320	-0.254
8:	-0.286	0.008
9:	-0.650	0.256
10:	0.529	0.123

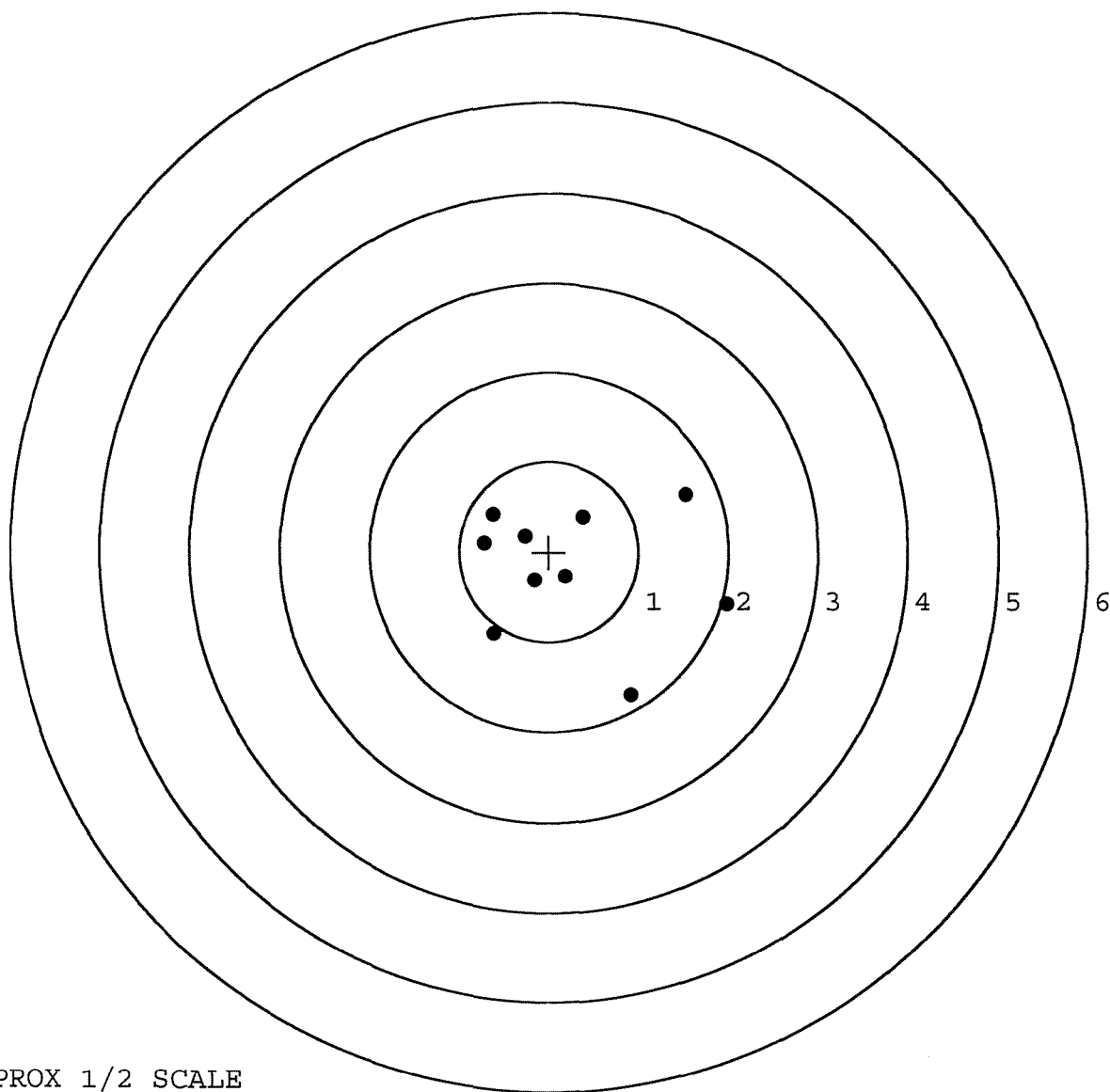


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414405. __1
 TARGET NUMBER: 3
 FILE DATE: 10/08/2005
 FILE TIME: 04:06

X CENTROID: 0.262
 Y CENTROID: -0.195
 POA TO CENTROID: 0.327
 HORZ SPREAD: 2.695
 VERT SPREAD: 2.223
 GROUP SPREAD: 2.783
 MIN RADIUS: 0.115
 MAX RADIUS: 1.759
 MEAN RADIUS: 0.983
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.977	-0.586
2:	0.918	-1.589
3:	-0.607	-0.907
4:	1.526	0.634
5:	0.381	0.392
6:	0.183	-0.279
7:	-0.161	-0.315
8:	-0.260	0.180
9:	-0.718	0.104
10:	-0.620	0.414

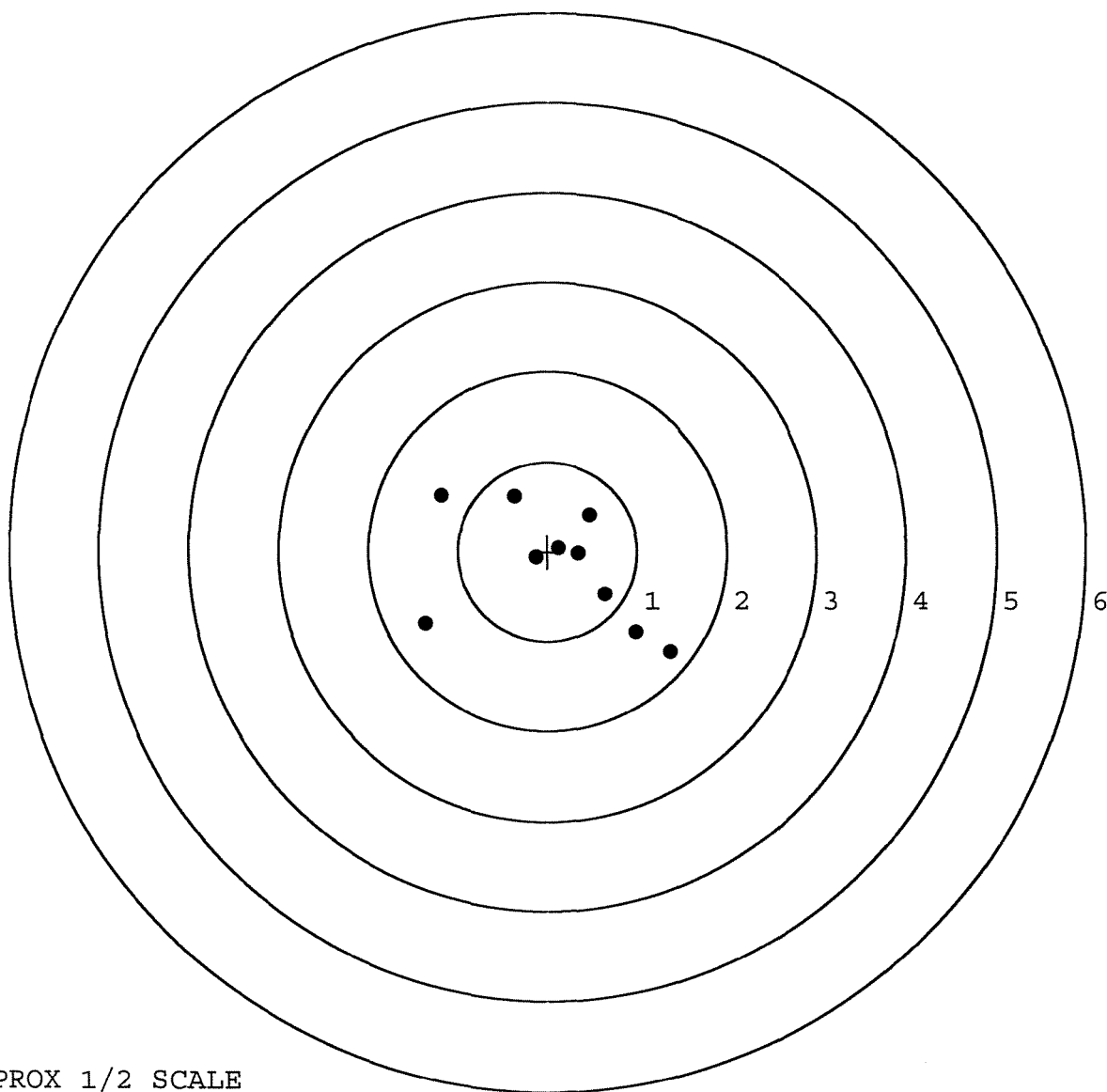


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414405. __1
 TARGET NUMBER: 4
 FILE DATE: 10/08/2005
 FILE TIME: 04:06

X CENTROID: 0.089
 Y CENTROID: -0.169
 POA TO CENTROID: 0.191
 HORZ SPREAD: 2.738
 VERT SPREAD: 1.751
 GROUP SPREAD: 3.105
 MIN RADIUS: 0.217
 MAX RADIUS: 1.599
 MEAN RADIUS: 0.886
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.371	-1.126
2:	0.986	-0.906
3:	0.646	-0.476
4:	0.351	-0.014
5:	0.469	0.407
6:	-0.367	0.618
7:	-1.193	0.625
8:	-1.367	-0.807
9:	-0.127	-0.060
10:	0.122	0.045

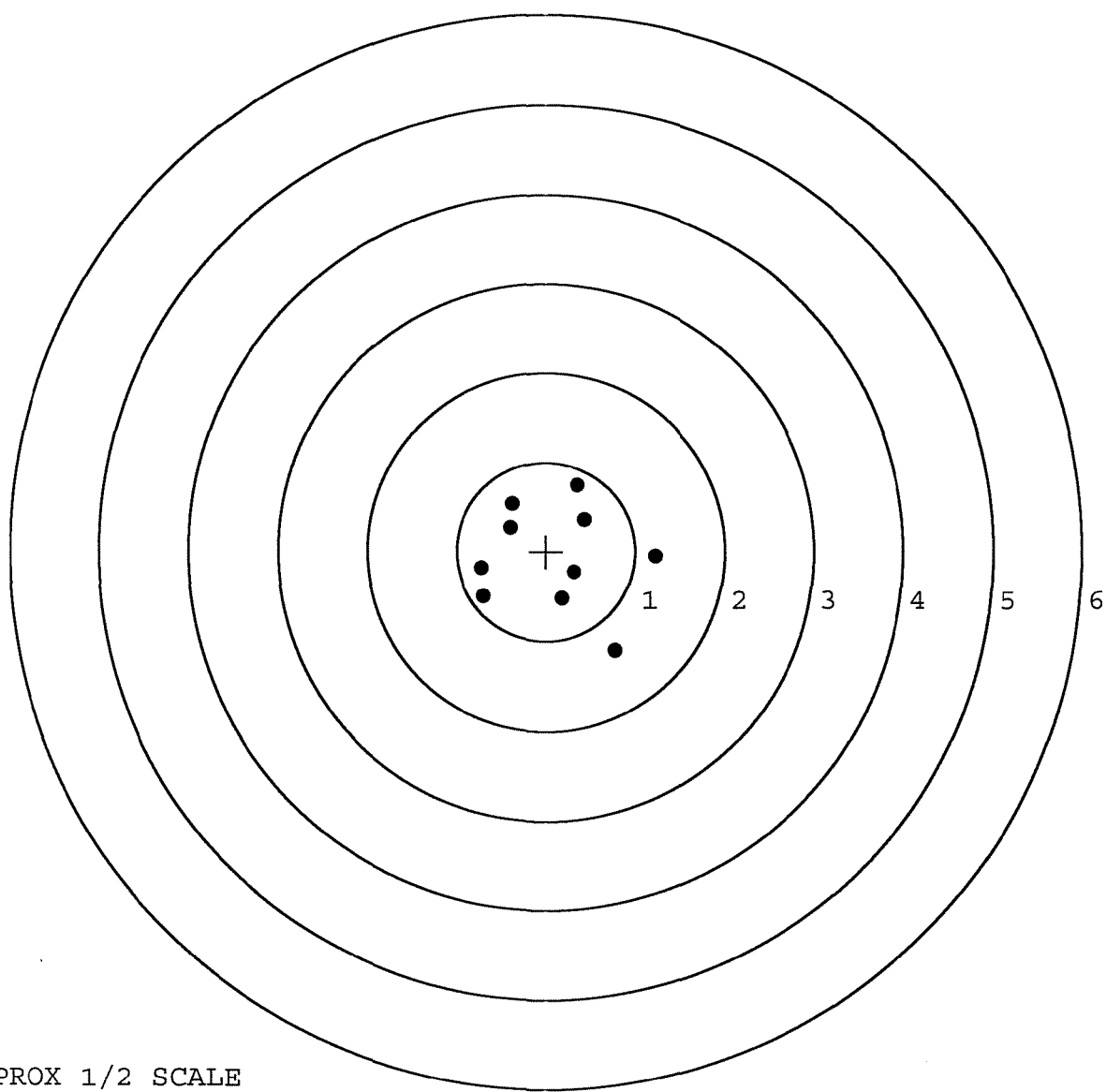


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414405. __1
TARGET NUMBER: 5
FILE DATE: 10/08/2005
FILE TIME: 04:06

X CENTROID: 0.109
Y CENTROID: -0.076
POA TO CENTROID: 0.133
HORZ SPREAD: 1.946
VERT SPREAD: 1.852
GROUP SPREAD: 2.006
MIN RADIUS: 0.265
MAX RADIUS: 1.229
MEAN RADIUS: 0.761
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.776	-1.109
2:	1.221	-0.063
3:	0.436	0.358
4:	0.354	0.743
5:	-0.377	0.533
6:	-0.397	0.263
7:	-0.725	-0.200
8:	-0.695	-0.512
9:	0.318	-0.240
10:	0.183	-0.532



TARGET APPROX 1/2 SCALE