

G-646 1571

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

- INSTRUCTION BOOK 3518

DD FORM



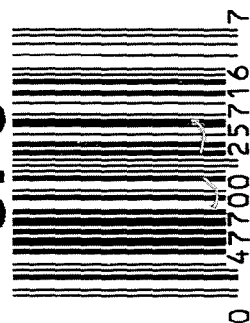
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461571

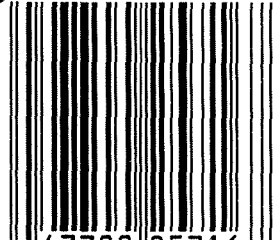
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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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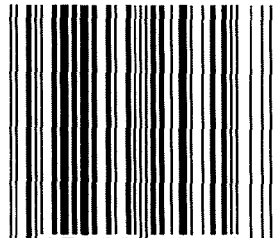


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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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SERIAL NO.



66461571

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461571

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/2/05	CD
440	PROOF		11/2/05	CD
460	CHECK HEADSPACE		11/2/05	CD
470	DIS-ASSEMBLE ACTION		11/2/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/80 MAGNETIC UNIT	12/8/05	unab
500	ROLLMARK CALIBER		12-8-05	CW
510	DRILL AND TAP SIGHT HOLES		12-8-05	BR
520	GOFF BLAST BBL / REC		12-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		12/12/05	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-16-05	Q
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-16-05	Q
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-16-05	Q
	D) OIL FIRING PIN ASSEMBLY		12-28-05	TC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/7/06	MJP

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.2</u> <u>5.5</u> <u>5.5</u>	2/2/06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.0</u> <u>2.0</u>	2/2/06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/7/06	MJD
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3/7/06	MJD
	J) ASSEMBLE STOCK		12-28-05	AC
	K) ASSEMBLE SWIVEL STUDS		3/7/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-28-05	AC
	M) IRON SIGHT ALIGNMENT		12-28-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-28-05	AC
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	12-29-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12/29/05	R.P.
670	FINAL INSPECTION A) HEADSPACE		3/7/06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u> <u>2.79</u> <u>2.84</u> <u>2.79</u> <u>2.90</u>	2/2/06	DA
	C) FUNCTION		3/7/06	MJD
690	PACK		3-29-06	DA

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 10-20-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.73	2.41		2.88	
PULL #2	2.72	2.41		2.73	
PULL #3	2.74	2.43		2.87	
PULL #4	2.67	2.48		2.72	
PULL #5	2.70	2.62		2.43	
TOTAL	13.56	12.35		13.63	
AVERAGE	2.71	2.47		2.72	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.19		
PULL #2	3.18	3.38		
PULL #3	3.34	3.38		
PULL #4	3.32	3.43		
PULL #5	3.43	3.27		
TOTAL	16.35	16.65		
AVERAGE	3.27	3.33		

	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	3.94	3.90		4.15
PULL #2	4.00	4.10		4.19
PULL #3	4.23	3.93		4.27
PULL #4	4.24	4.01		4.24
PULL #5	4.10	4.19		4.29
TOTAL	20.51	20.13		21.09
AVERAGE	4.10	4.02		4.21

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461571.___0
FILE DATE AND TIME: 12/29/2005 15:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.039
The Average Y Centroid of the Five Target Set:	0.011
The Average Point of Impact of the Five Target Set:	0.040
The Average Mean Radius of the Five Target Set:	0.726
The Distance from POA to Centroid Target #1:	0.158
The Distance from Centroid Target #2 to Centroid Target #1:	0.310
The Distance from Centroid Target #3 to Centroid Target #1:	0.039
The Distance from Centroid Target #4 to Centroid Target #1:	0.183
The Distance from Centroid Target #5 to Centroid Target #1:	0.426

SERIAL NUMBER: G6461571. 0

TARGET NUMBER: 1

FILE DATE: 12/29/2005

FILE TIME: 15:47

X CENTROID: 0.047

Y CENTROID: -0.151

POA TO CENTROID: 0.158

HORZ SPREAD: 1.806

VERT SPREAD: 1.972

GROUP SPREAD: 2.304

MIN RADIUS: 0.078

MAX RADIUS: 1.290

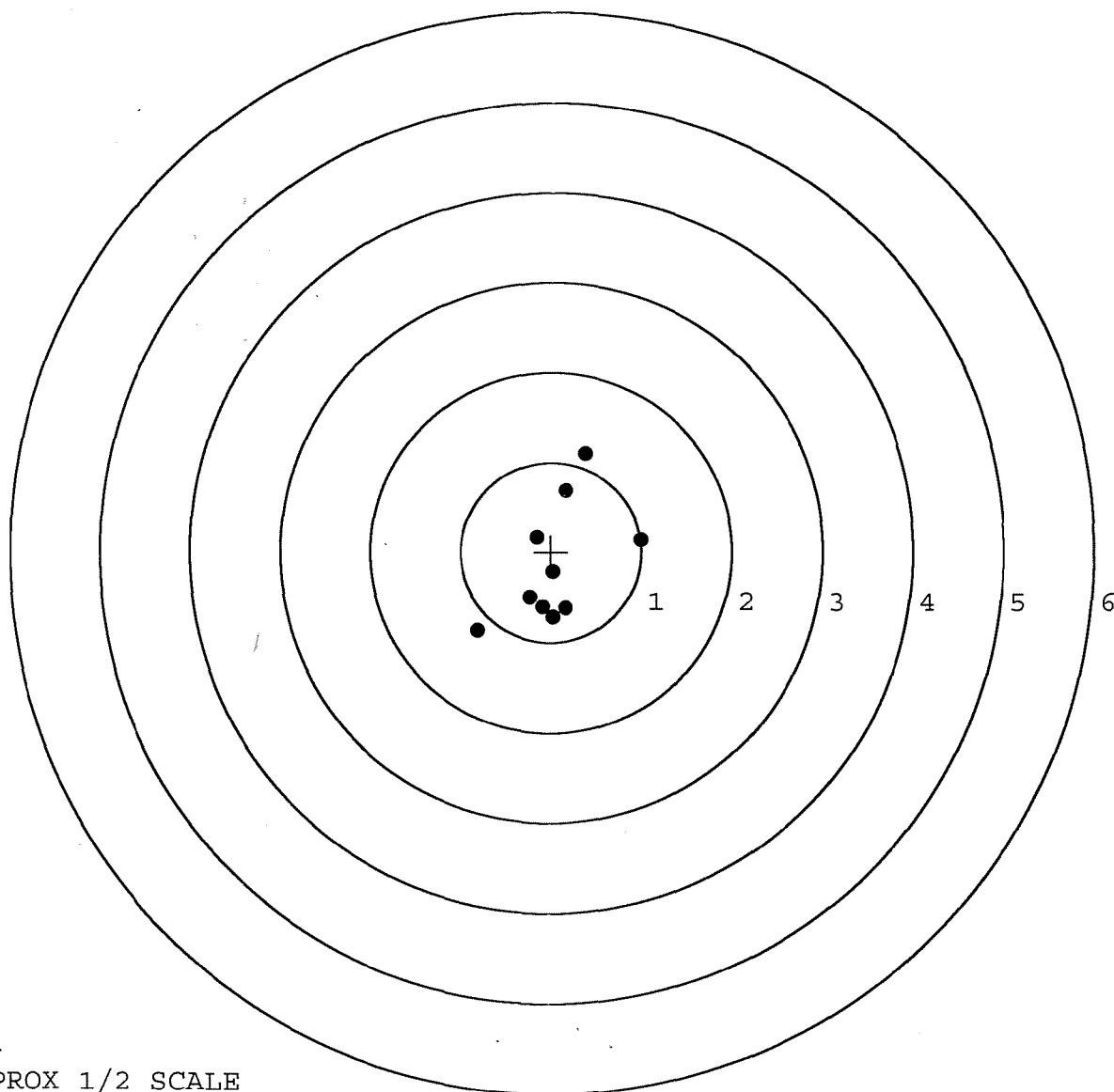
MEAN RADIUS: 0.672

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.994	0.136
2:	0.380	1.096
3:	0.166	0.684
4:	-0.160	0.165
5:	-0.026	-0.226
6:	-0.812	-0.876
7:	0.169	-0.633
8:	0.029	-0.731
9:	-0.089	-0.616
10:	-0.232	-0.507

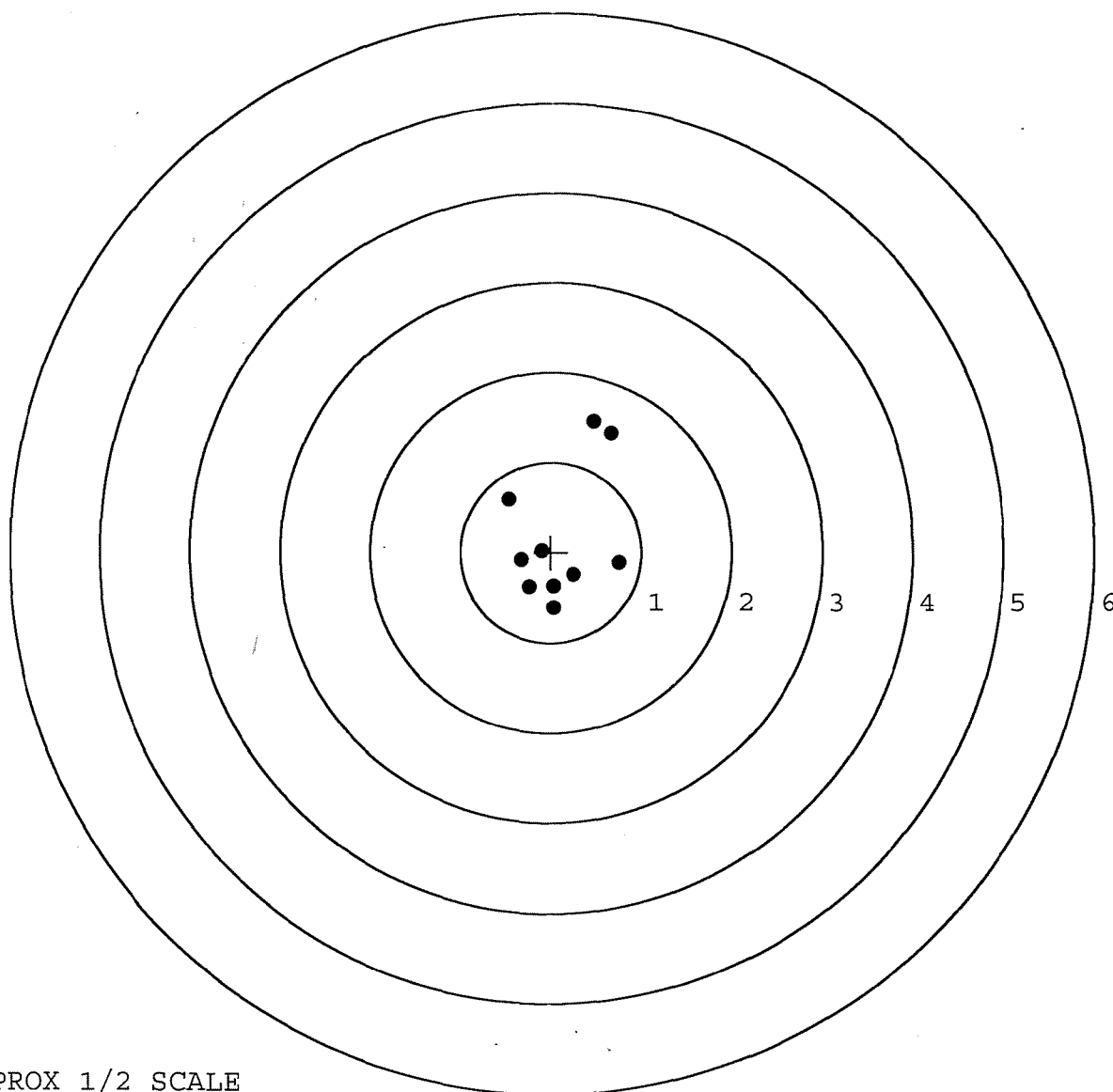


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461571. 0
TARGET NUMBER: 2
FILE DATE: 12/29/2005
FILE TIME: 15:47

X CENTROID: 0.106
Y CENTROID: 0.154
POA TO CENTROID: 0.187
HORZ SPREAD: 1.230
VERT SPREAD: 2.064
GROUP SPREAD: 2.110
MIN RADIUS: 0.249
MAX RADIUS: 1.344
MEAN RADIUS: 0.719
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.661	1.322
2:	0.473	1.447
3:	0.757	-0.114
4:	-0.473	0.583
5:	-0.101	0.016
6:	-0.329	-0.085
7:	0.251	-0.251
8:	0.036	-0.617
9:	-0.243	-0.384
10:	0.032	-0.379

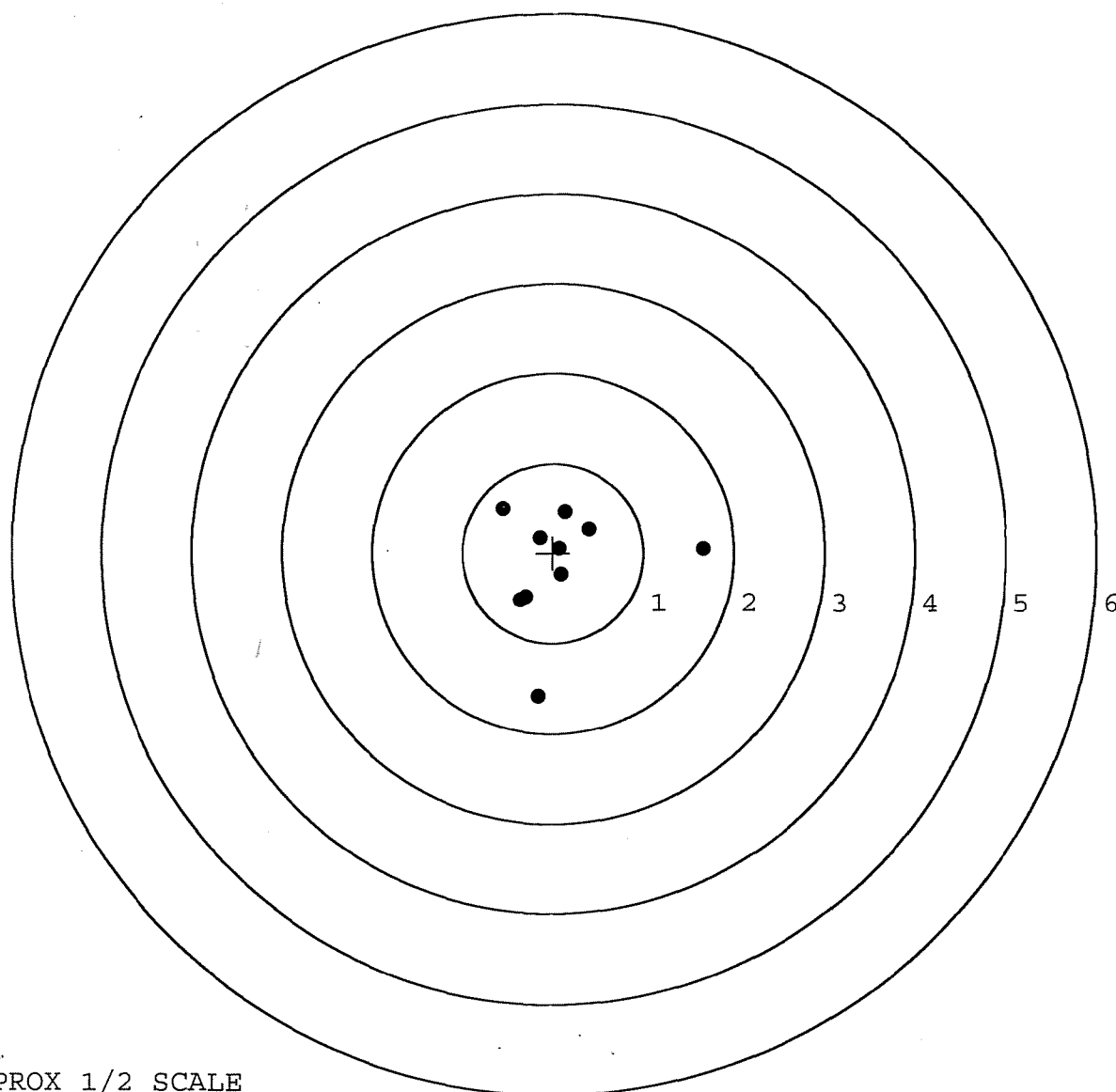


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461571. 0
TARGET NUMBER: 3
FILE DATE: 12/29/2005
FILE TIME: 15:47

X CENTROID: 0.084
Y CENTROID: -0.137
POA TO CENTROID: 0.161
HORZ SPREAD: 2.220
VERT SPREAD: 2.076
GROUP SPREAD: 2.453
MIN RADIUS: 0.104
MAX RADIUS: 1.592
MEAN RADIUS: 0.686
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.665	0.051
2:	-0.159	-1.589
3:	-0.362	-0.529
4:	0.402	0.266
5:	-0.133	0.459
6:	-0.555	0.487
7:	-0.141	0.170
8:	0.067	0.050
9:	0.087	-0.241
10:	-0.300	-0.494

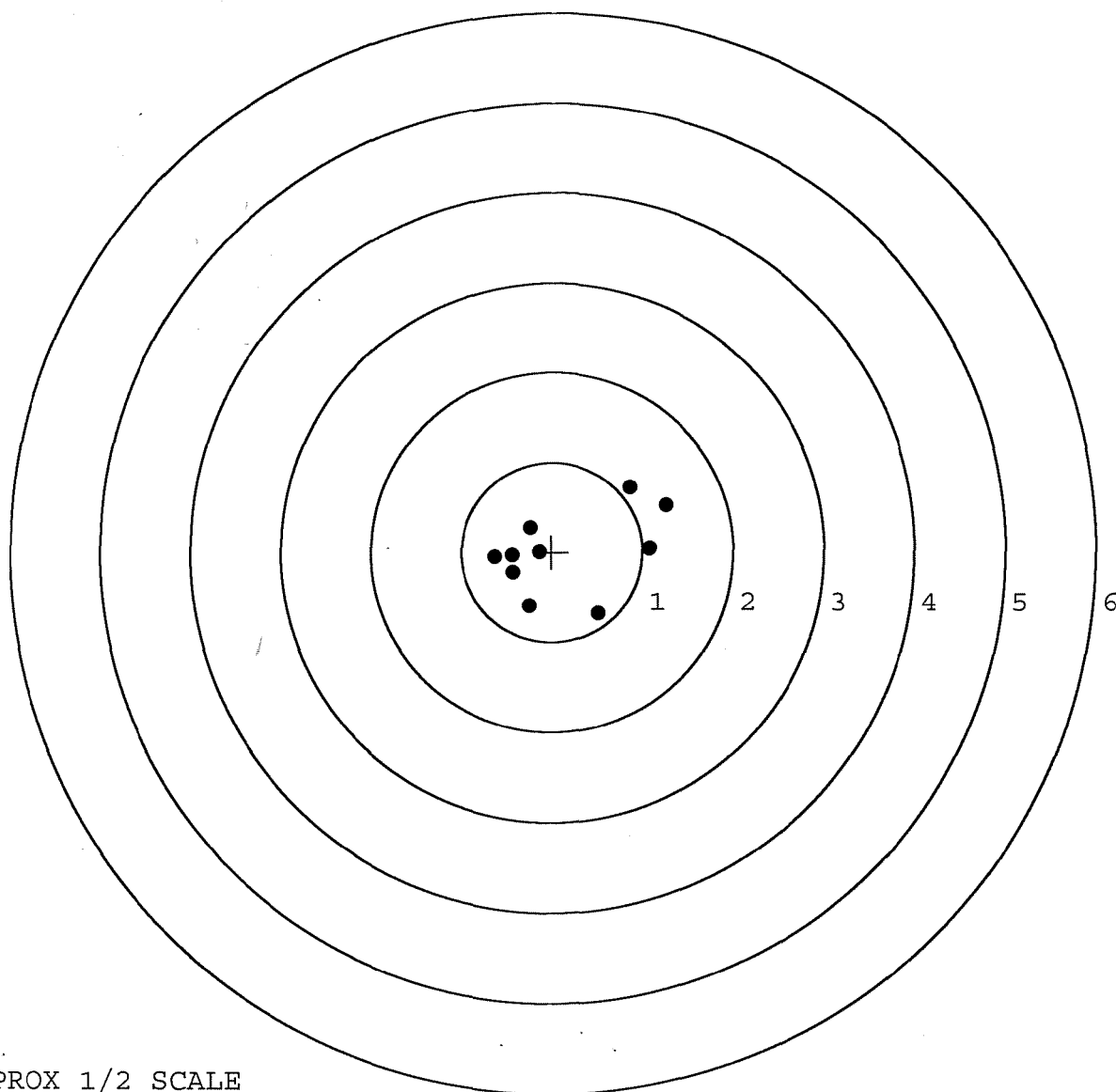


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461571. __0
TARGET NUMBER: 4
FILE DATE: 12/29/2005
FILE TIME: 15:47

X CENTROID: 0.158
Y CENTROID: -0.005
POA TO CENTROID: 0.158
HORZ SPREAD: 1.889
VERT SPREAD: 1.404
GROUP SPREAD: 1.977
MIN RADIUS: 0.298
MAX RADIUS: 1.221
MEAN RADIUS: 0.745
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.518	-0.681
2:	1.078	0.041
3:	1.259	0.523
4:	0.864	0.723
5:	-0.251	-0.606
6:	-0.630	-0.059
7:	-0.431	-0.233
8:	-0.139	0.005
9:	-0.246	0.267
10:	-0.438	-0.034

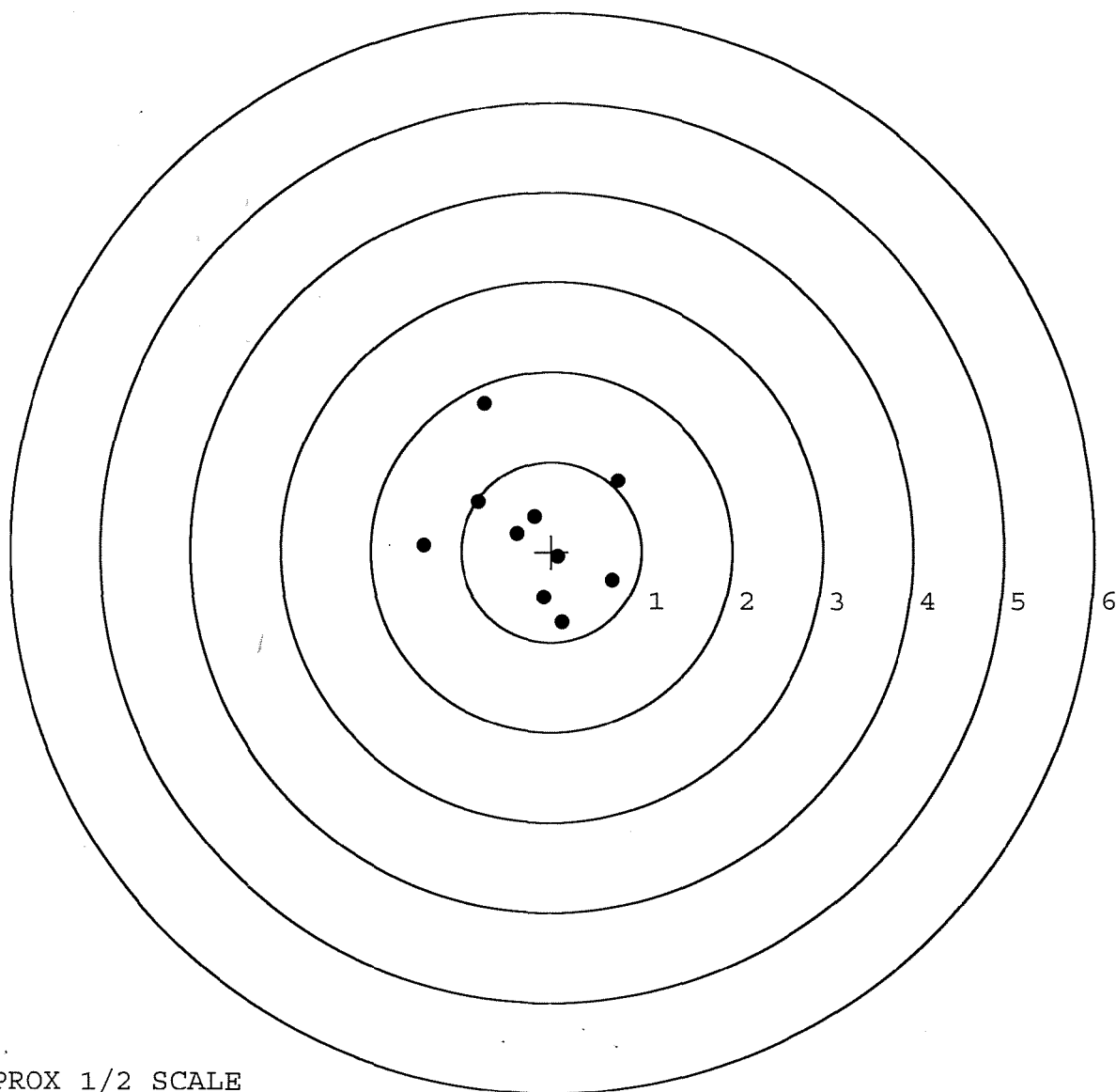


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461571. 0
 TARGET NUMBER: 5
 FILE DATE: 12/29/2005
 FILE TIME: 15:47

X CENTROID: -0.201
 Y CENTROID: 0.196
 POA TO CENTROID: 0.281
 HORZ SPREAD: 2.161
 VERT SPREAD: 2.432
 GROUP SPREAD: 2.584
 MIN RADIUS: 0.180
 MAX RADIUS: 1.550
 MEAN RADIUS: 0.810
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.676	-0.323
2:	0.125	-0.786
3:	-0.083	-0.508
4:	0.069	-0.056
5:	-0.187	0.388
6:	-0.381	0.195
7:	-0.809	0.548
8:	-1.418	0.072
9:	0.743	0.782
10:	-0.747	1.646



TARGET APPROX 1/2 SCALE