

6644 1729

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

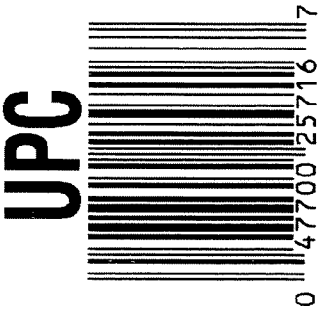
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461729



ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6461729

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-4-05	RT
440	PROOF		10-5-05	BF
460	CHECK HEADSPACE	MAGNA-FLUX	10-5-05	BG
470	DIS-ASSEMBLE ACTION	INSPECTED	10-6-05	RT
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <i>unaf</i>	10/10/05	<i>unaf</i>
500	ROLLMARK CALIBER		10-10-05	CW
510	DRILL AND TAP SIGHT HOLES		10-7-05	TRL
520	GOFF BLAST BBL / REC		10-14-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/19/05	RB
	(BOLT)		10/19/05	RB
560	RE-ASSEMBLE ACTION		10/26/05	WJM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/26/05	WJM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/26/05	WJM
	D) OIL FIRING PIN ASSEMBLY		10-28-05	RT
	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 1/6</u> <u>5 1/6</u> <u>5 1/6</u>	11-15-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 1/6</u> <u>3 1/6</u> <u>3 1/6</u>	11-15-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	11-15-05	BC
	J) ASSEMBLE STOCK		10-28-05	KTL
	K) ASSEMBLE SWIVEL STUDS		11-15-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-15-05	BC
	M) IRON SIGHT ALIGNMENT		11-15-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-15-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/29/05	MJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/29/05	MJM
670	FINAL INSPECTION A) HEADSPACE		11-15-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.17</u> <u>2.21</u> <u>2.23</u> <u>2.39</u> <u>2.19</u>	11-1-05	BC
	C) FUNCTION		11-15-05	BC
690	PACK		12-1-05	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 10-27-05

TESTER S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.61	2.40		2.50	
PULL #2	2.58	2.54		2.66	
PULL #3	2.74	2.44		2.66	
PULL #4	2.51	2.51		2.51	
PULL #5	2.68	2.62		2.60	
TOTAL	13.12	12.51		12.93	
AVERAGE	2.62	2.50		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.98	3.25		
PULL #2	2.97	3.26		
PULL #3	3.04	3.21		
PULL #4	3.11	3.25		
PULL #5	3.08	3.22		
TOTAL	15.18	16.19		
AVERAGE	3.04	3.24		

	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	3.99	3.92		4.12
PULL #2	3.98	4.08		4.05
PULL #3	4.01	4.13		4.15
PULL #4	4.01	3.86		4.14
PULL #5	4.04	3.91		4.09
TOTAL	20.03	19.90		20.55
AVERAGE	4.01	3.98		4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461729.___0
FILE DATE AND TIME: 10/29/2005 12:43

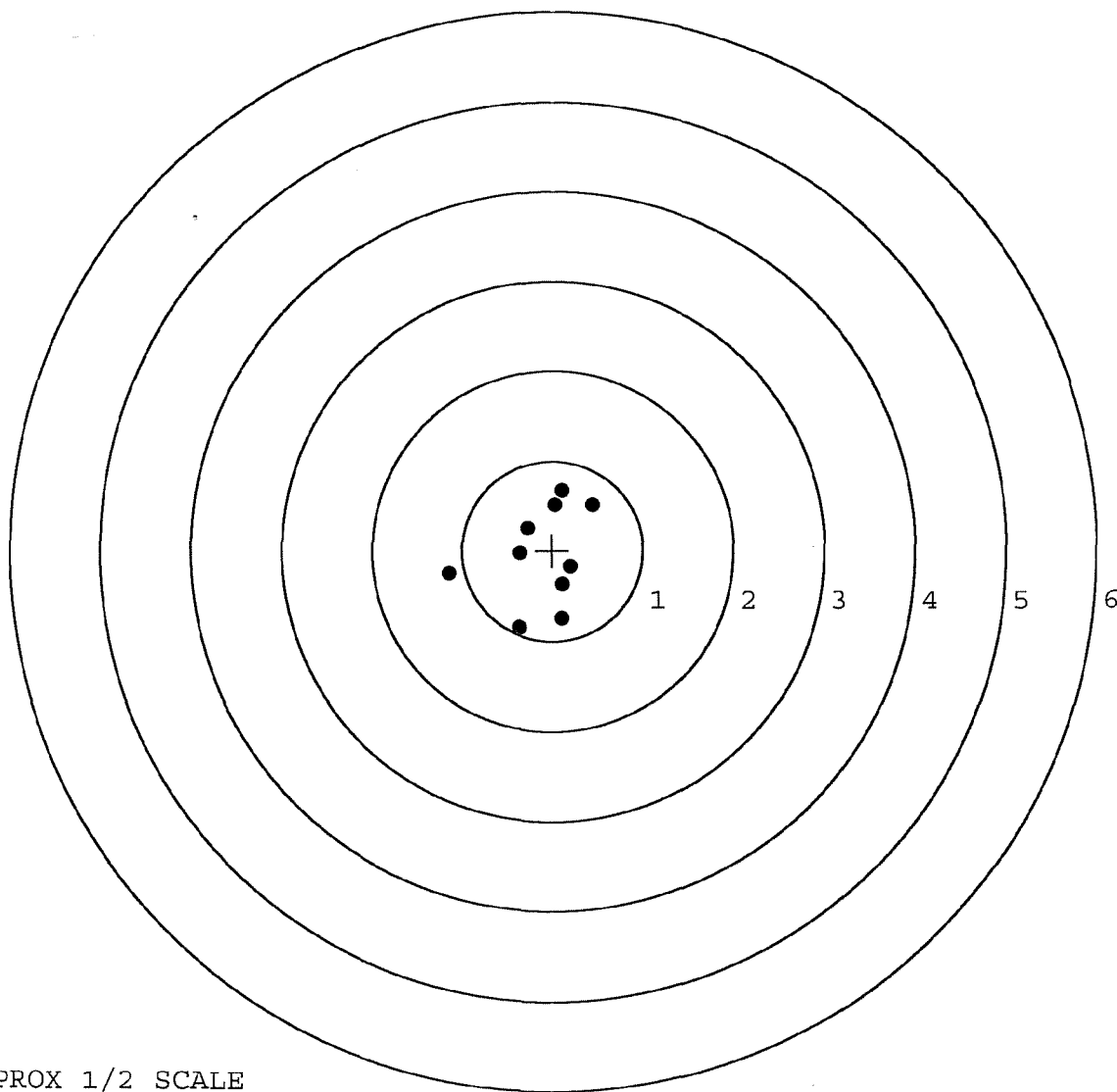
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.066
The Average Y Centroid of the Five Target Set:	-0.156
The Average Point of Impact of the Five Target Set:	0.169
The Average Mean Radius of the Five Target Set:	0.643
The Distance from POA to Centroid Target #1:	0.125
The Distance from Centroid Target #2 to Centroid Target #1:	0.432
The Distance from Centroid Target #3 to Centroid Target #1:	0.108
The Distance from Centroid Target #4 to Centroid Target #1:	0.246
The Distance from Centroid Target #5 to Centroid Target #1:	0.305

SERIAL NUMBER: G6461729. __0
TARGET NUMBER: 1
FILE DATE: 10/29/2005
FILE TIME: 12:43

POINT#	X	Y
1:	-0.277	0.251
2:	0.032	0.513
3:	0.109	0.670
4:	0.446	0.507
5:	0.205	-0.183
6:	0.118	-0.383
7:	0.107	-0.758
8:	-0.366	-0.859
9:	-1.144	-0.266
10:	-0.356	-0.039

X CENTROID: -0.113
Y CENTROID: -0.055
POA TO CENTROID: 0.125
HORZ SPREAD: 1.590
VERT SPREAD: 1.529
GROUP SPREAD: 1.768
MIN RADIUS: 0.244
MAX RADIUS: 1.053
MEAN RADIUS: 0.610
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

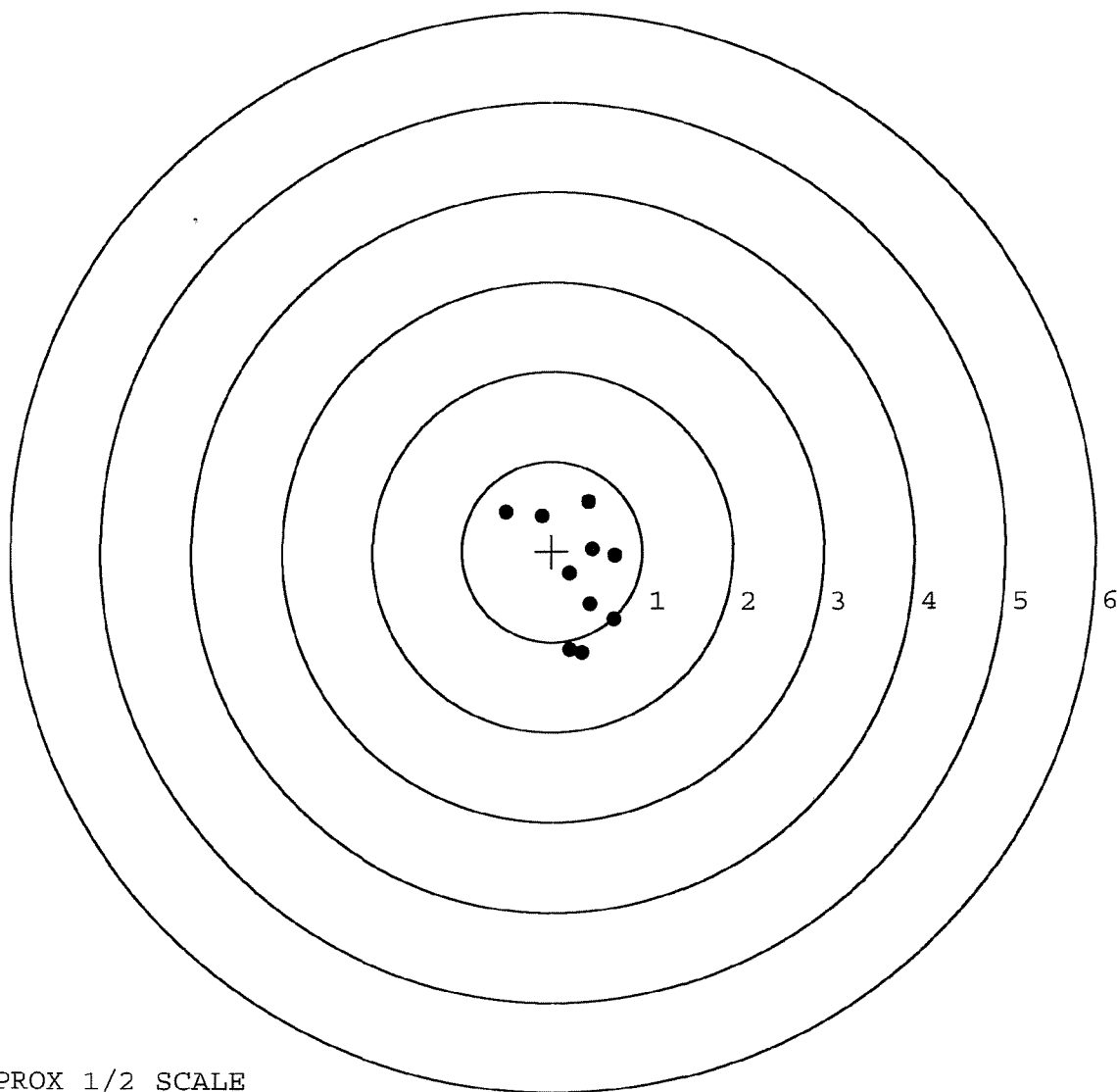


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461729. __0
TARGET NUMBER: 2
FILE DATE: 10/29/2005
FILE TIME: 12:43

X CENTROID: 0.275
Y CENTROID: -0.247
POA TO CENTROID: 0.369
HORZ SPREAD: 1.212
VERT SPREAD: 1.674
GROUP SPREAD: 1.778
MIN RADIUS: 0.079
MAX RADIUS: 1.046
MEAN RADIUS: 0.622
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.115	0.388
2:	-0.517	0.438
3:	0.405	0.549
4:	0.452	0.023
5:	0.196	-0.253
6:	0.695	-0.050
7:	0.422	-0.590
8:	0.683	-0.757
9:	0.330	-1.125
10:	0.194	-1.088

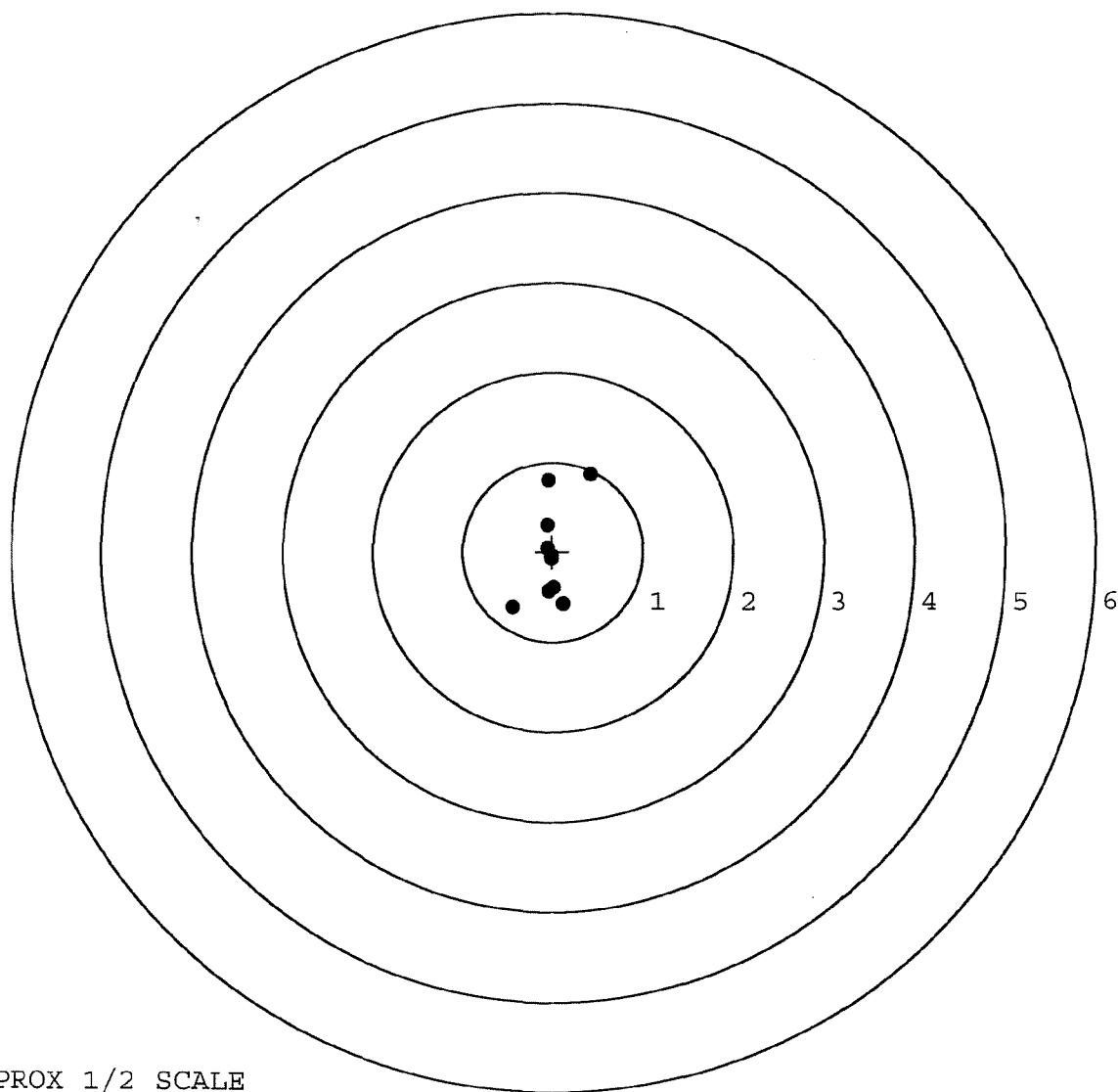


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461729. __0
TARGET NUMBER: 3
FILE DATE: 10/29/2005
FILE TIME: 12:43

X CENTROID: -0.011
Y CENTROID: -0.019
POA TO CENTROID: 0.022
HORZ SPREAD: 0.866
VERT SPREAD: 1.484
GROUP SPREAD: 1.718
MIN RADIUS: 0.022
MAX RADIUS: 0.982
MEAN RADIUS: 0.442
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.061	0.295
2:	-0.059	0.040
3:	-0.008	-0.085
4:	0.016	-0.406
5:	0.123	-0.586
6:	-0.041	-0.445
7:	-0.442	-0.623
8:	-0.053	0.799
9:	0.424	0.861
10:	-0.007	-0.041

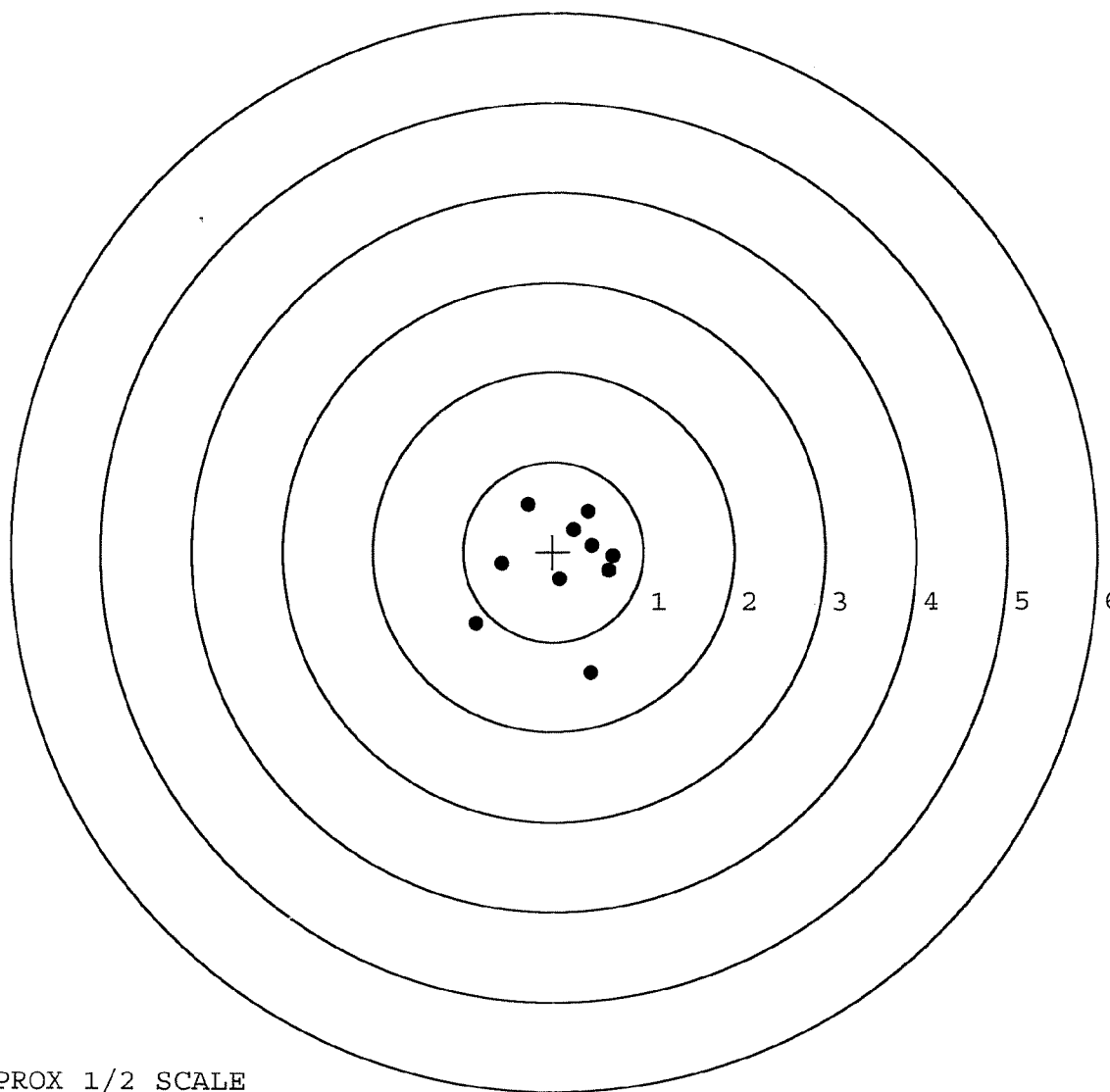


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461729. __0
TARGET NUMBER: 4
FILE DATE: 10/29/2005
FILE TIME: 12:43

POINT#	X	Y
1:	0.389	0.447
2:	0.229	0.246
3:	0.427	0.071
4:	0.661	-0.048
5:	0.617	-0.212
6:	0.075	-0.303
7:	-0.275	0.520
8:	-0.572	-0.130
9:	-0.855	-0.797
10:	0.420	-1.353

X CENTROID: 0.112
Y CENTROID: -0.156
POA TO CENTROID: 0.192
HORZ SPREAD: 1.516
VERT SPREAD: 1.873
GROUP SPREAD: 1.998
MIN RADIUS: 0.152
MAX RADIUS: 1.236
MEAN RADIUS: 0.655
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



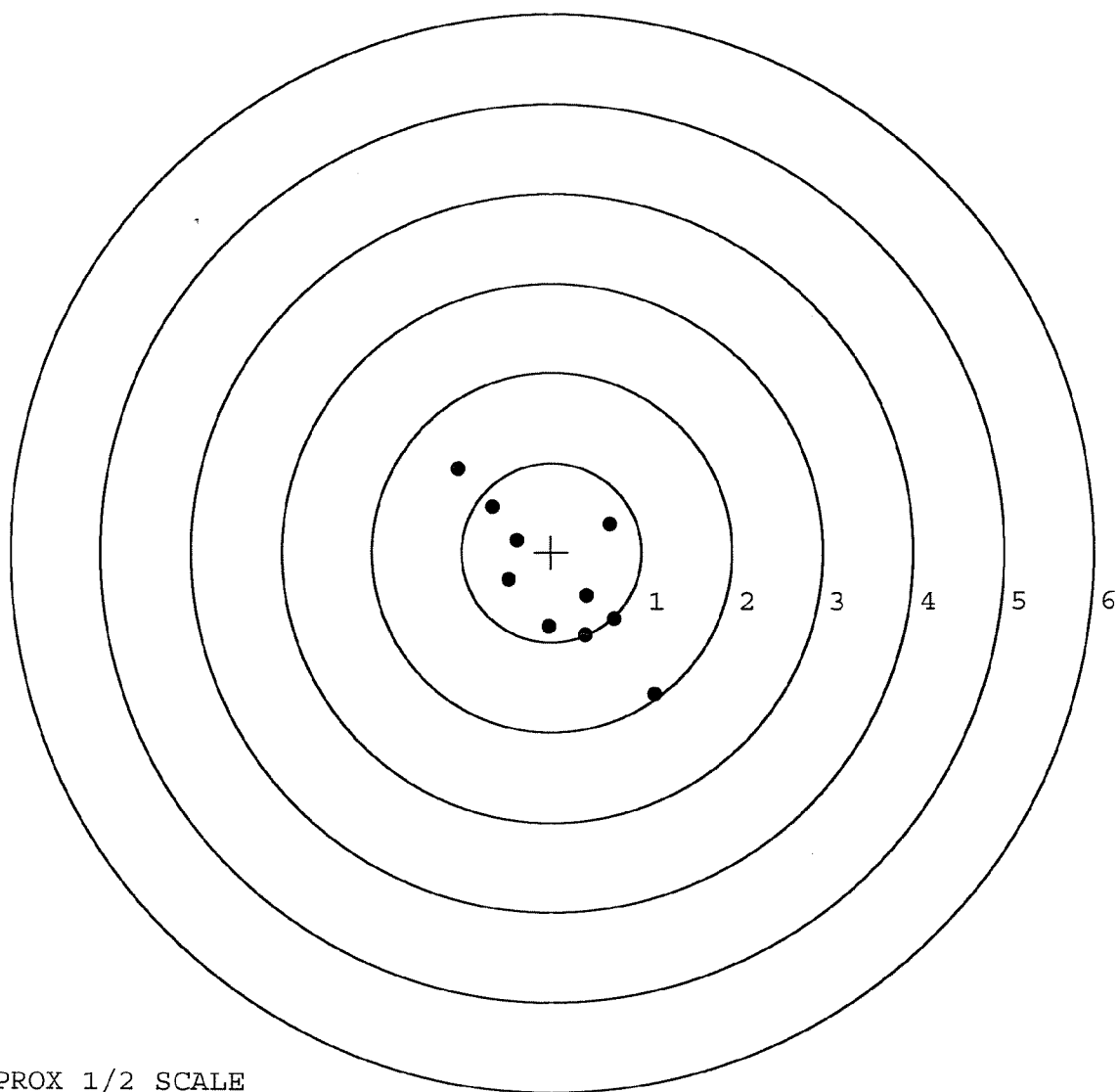
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461729. __0
TARGET NUMBER: 5
FILE DATE: 10/29/2005
FILE TIME: 12:43

X CENTROID: 0.067
Y CENTROID: -0.302
POA TO CENTROID: 0.309
HORZ SPREAD: 2.180
VERT SPREAD: 2.527
GROUP SPREAD: 3.337
MIN RADIUS: 0.376
MAX RADIUS: 1.677
MEAN RADIUS: 0.884

POINT#	X	Y
1:	-0.380	0.138
2:	-0.656	0.509
3:	-1.037	0.939
4:	-0.477	-0.313
5:	0.647	0.315
6:	0.391	-0.493
7:	0.698	-0.753
8:	0.374	-0.930
9:	-0.033	-0.840
10:	1.143	-1.588

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE