

G6590043

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

UPC



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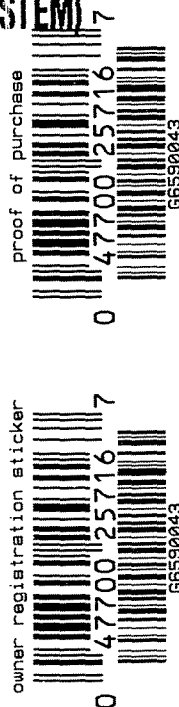
SERIAL NO.



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

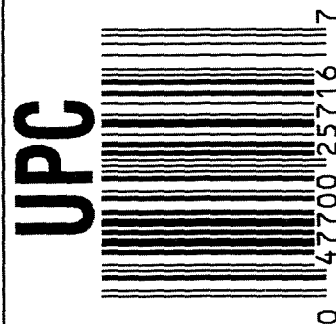
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6590043



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590043

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-1-06	BLG
420	ASSEMBLE ACTION		8-2-06	BLG
430	ASSEMBLE TO STOCK		8-2-06	BLG
440	PROOF		8-2-06	BLG
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-2-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 09 2006	8-2-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	8-9-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-9-06	CW
510	DRILL AND TAP SIGHT HOLES		8-8-06	TRW
520	GOFF BLAST BBL / REC		8-9-06	WB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/10/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-11-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-11-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-11-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-11-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

QTY	OPERATION NAME	2 LBS MIN 10 LBS MAX	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE		<u>6.0</u> <u>6.0</u> <u>6.0</u>	8-17-06	RA
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	8-17-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>10235</u> <u>0235</u> <u>023</u>	8-17-06	RA
	J) ASSEMBLE STOCK			8-11-06	RTZ
	K) ASSEMBLE SWIVEL STUDS			8-31-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			8-11-06	BLG
	M) IRON SIGHT ALIGNMENT			8-11-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			8-11-06	BLG
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	8-11-06	R.P.D.
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			8/11/06	7/19
670	FINAL INSPECTION A) HEADSPACE			8-31-06	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>267</u> <u>2.78</u> <u>265</u> <u>230</u> <u>2.74</u>	8-18-06	R.P.
	C) FUNCTION			8-31-06	RTZ
690	PACK			11/15/06	RA

F004 REV 5/2006

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 8-10-06

TESTER MSM

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.49		2.57	
PULL #2	2.51	2.52		2.64	
PULL #3	2.63	2.52		2.42	
PULL #4	2.72	2.59		2.37	
PULL #5	2.61	2.59		2.53	
TOTAL	13.01	12.71		12.73	
AVERAGE	2.60	2.54		2.55	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.11		
PULL #2	3.08	3.15		
PULL #3	2.99	3.38		
PULL #4	3.16	3.10		
PULL #5	3.00	3.15		
TOTAL	15.29	15.89		
AVERAGE	3.06	3.18		

	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	4.08	4.01		3.94
PULL #2	4.20	4.08		4.16
PULL #3	4.03	4.03		4.08
PULL #4	4.05	4.02		4.14
PULL #5	3.96	3.96		4.00
TOTAL	20.32	20.10		20.32
AVERAGE	4.06	4.02		4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590043.___0
FILE DATE AND TIME: 08/11/2006 18:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.222
The Average Y Centroid of the Five Target Set:	0.075
The Average Point of Impact of the Five Target Set:	0.234
The Average Mean Radius of the Five Target Set:	0.589
The Distance from POA to Centroid Target #1:	0.194
The Distance from Centroid Target #2 to Centroid Target #1:	0.188
The Distance from Centroid Target #3 to Centroid Target #1:	0.112
The Distance from Centroid Target #4 to Centroid Target #1:	0.089
The Distance from Centroid Target #5 to Centroid Target #1:	0.353

SERIAL NUMBER: G6590043. __0

TARGET NUMBER: 1

FILE DATE: 08/11/2006

FILE TIME: 18:24

POINT#	X	Y
1:	-0.899	-0.021
2:	-0.314	-0.907
3:	0.470	-0.294
4:	0.462	0.694
5:	-0.231	0.685
6:	0.088	0.517
7:	-0.278	0.420
8:	-0.368	0.219
9:	-0.362	-0.012
10:	-0.025	-0.027

X CENTROID: -0.146

Y CENTROID: 0.127

POA TO CENTROID: 0.194

HORZ SPREAD: 1.369

VERT SPREAD: 1.601

GROUP SPREAD: 1.779

MIN RADIUS: 0.196

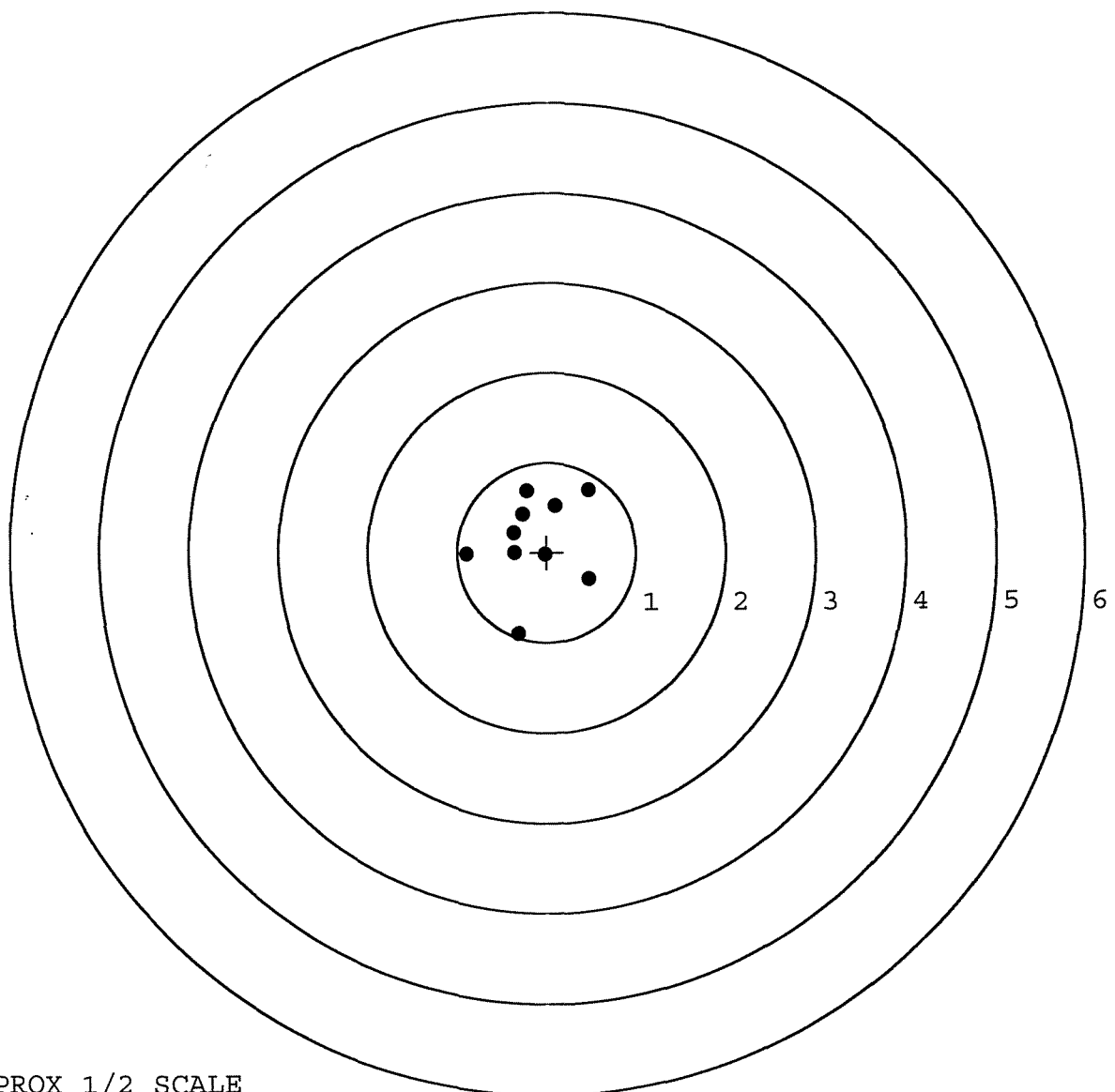
MAX RADIUS: 1.048

MEAN RADIUS: 0.543

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590043. 0

TARGET NUMBER: 2

FILE DATE: 08/11/2006

FILE TIME: 18:24

POINT#	X	Y
1:	0.722	0.773
2:	0.528	-0.267
3:	-0.519	-0.453
4:	-1.008	-0.039
5:	-0.486	0.315
6:	-0.274	0.451
7:	-0.061	0.259
8:	0.316	0.341
9:	-1.532	0.406
10:	-0.729	0.505

X CENTROID: -0.304

Y CENTROID: 0.229

POA TO CENTROID: 0.381

HORZ SPREAD: 2.254

VERT SPREAD: 1.226

GROUP SPREAD: 2.284

MIN RADIUS: 0.201

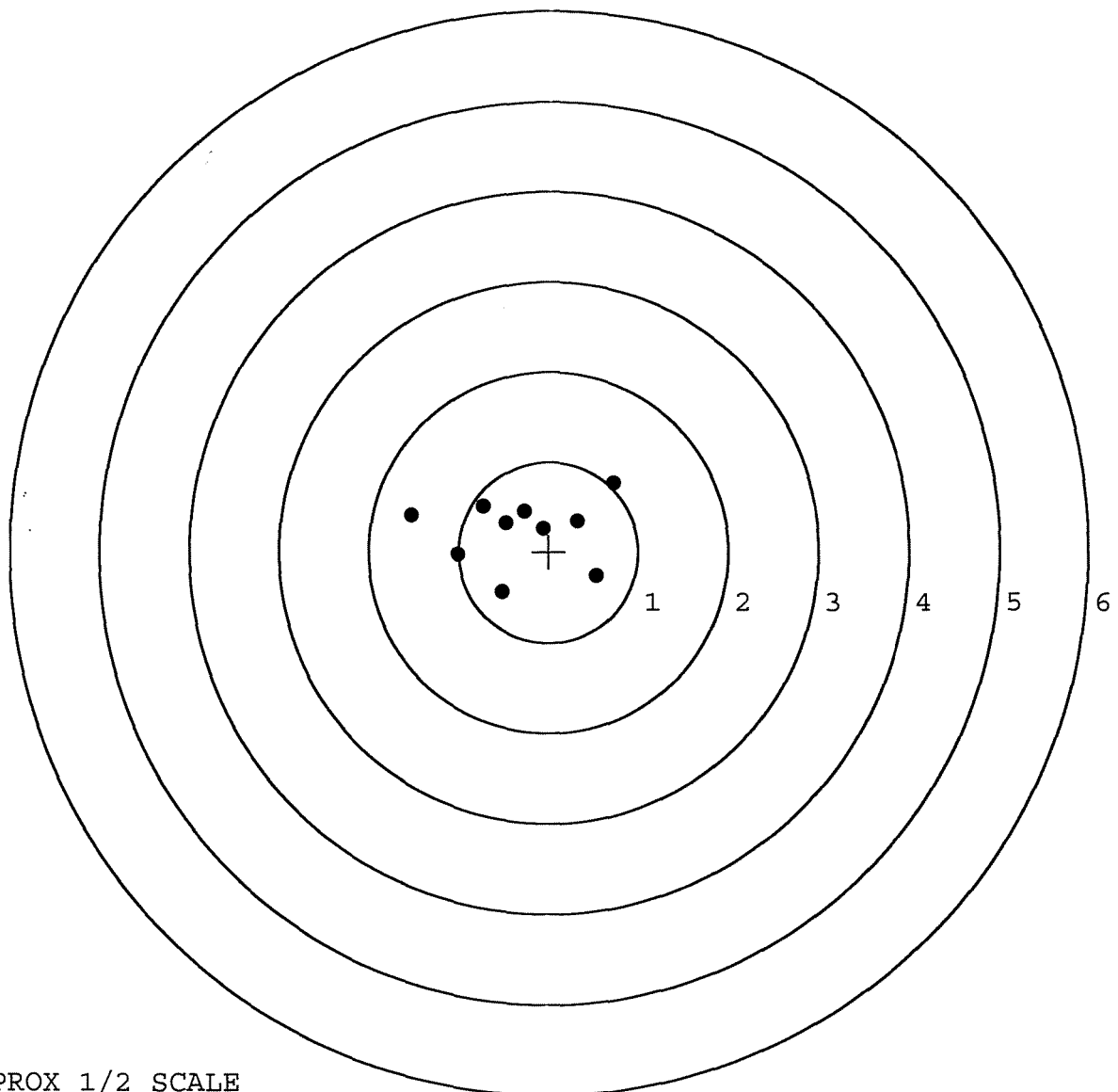
MAX RADIUS: 1.240

MEAN RADIUS: 0.665

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590043. __0

TARGET NUMBER: 3

FILE DATE: 08/11/2006

FILE TIME: 18:24

POINT#	X	Y
1:	0.385	0.456
2:	0.626	0.104
3:	0.060	-0.612
4:	-0.140	-0.251
5:	0.026	0.111
6:	-0.155	0.359
7:	-0.488	0.078
8:	-1.069	0.122
9:	-1.211	-0.333
10:	0.050	0.221

X CENTROID: -0.192

Y CENTROID: 0.025

POA TO CENTROID: 0.193

HORZ SPREAD: 1.837

VERT SPREAD: 1.068

GROUP SPREAD: 1.888

MIN RADIUS: 0.234

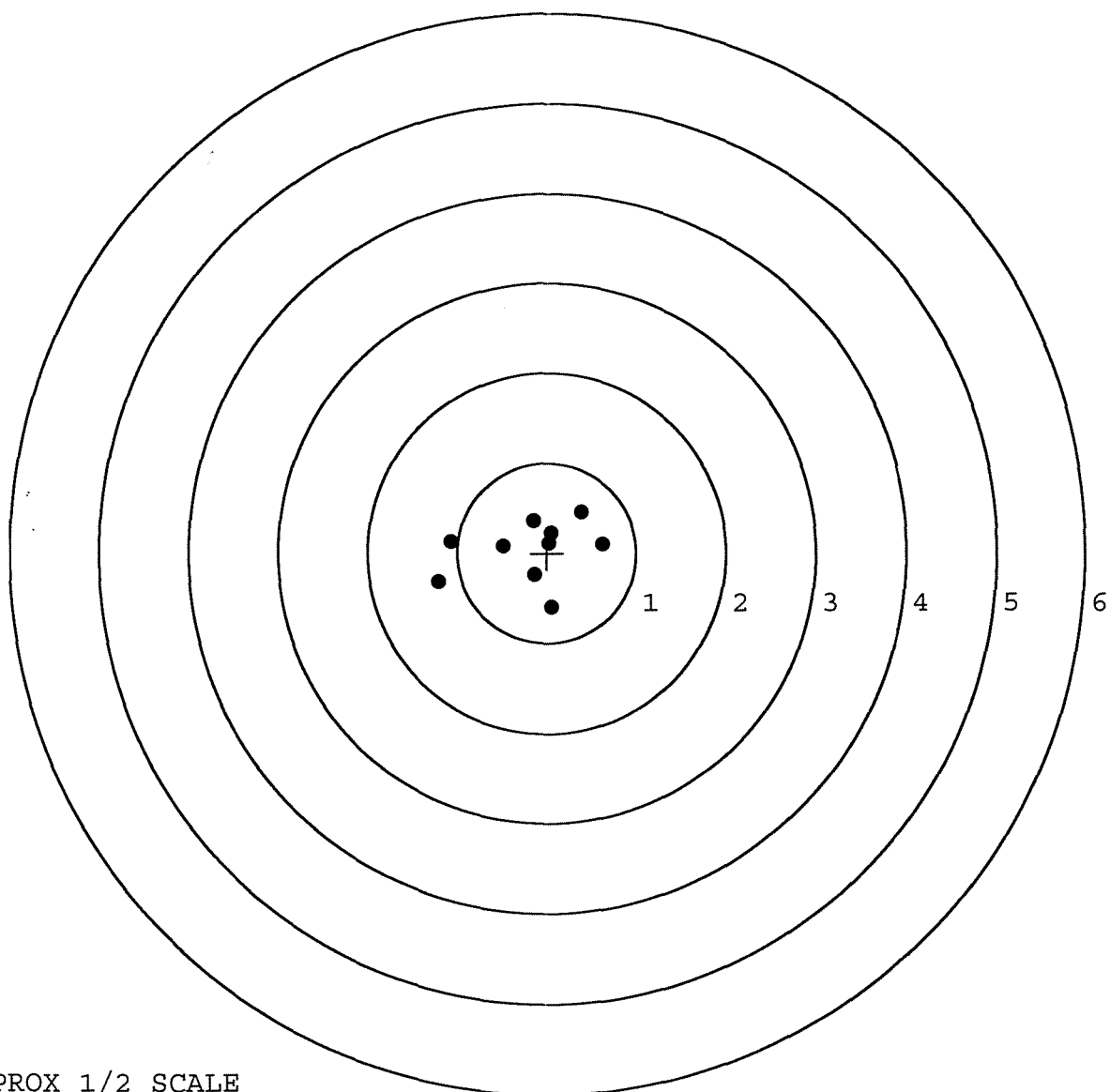
MAX RADIUS: 1.081

MEAN RADIUS: 0.565

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590043. __0

TARGET NUMBER: 4

FILE DATE: 08/11/2006

FILE TIME: 18:24

POINT#	X	Y
1:	0.974	-0.382
2:	0.700	-0.110
3:	0.466	0.135
4:	0.496	0.864
5:	-0.084	0.500
6:	-0.355	0.545
7:	-0.868	0.407
8:	-0.522	0.113
9:	-0.533	-0.437
10:	-0.880	-0.623

X CENTROID: -0.061

Y CENTROID: 0.101

POA TO CENTROID: 0.118

HORZ SPREAD: 1.854

VERT SPREAD: 1.487

GROUP SPREAD: 2.004

MIN RADIUS: 0.399

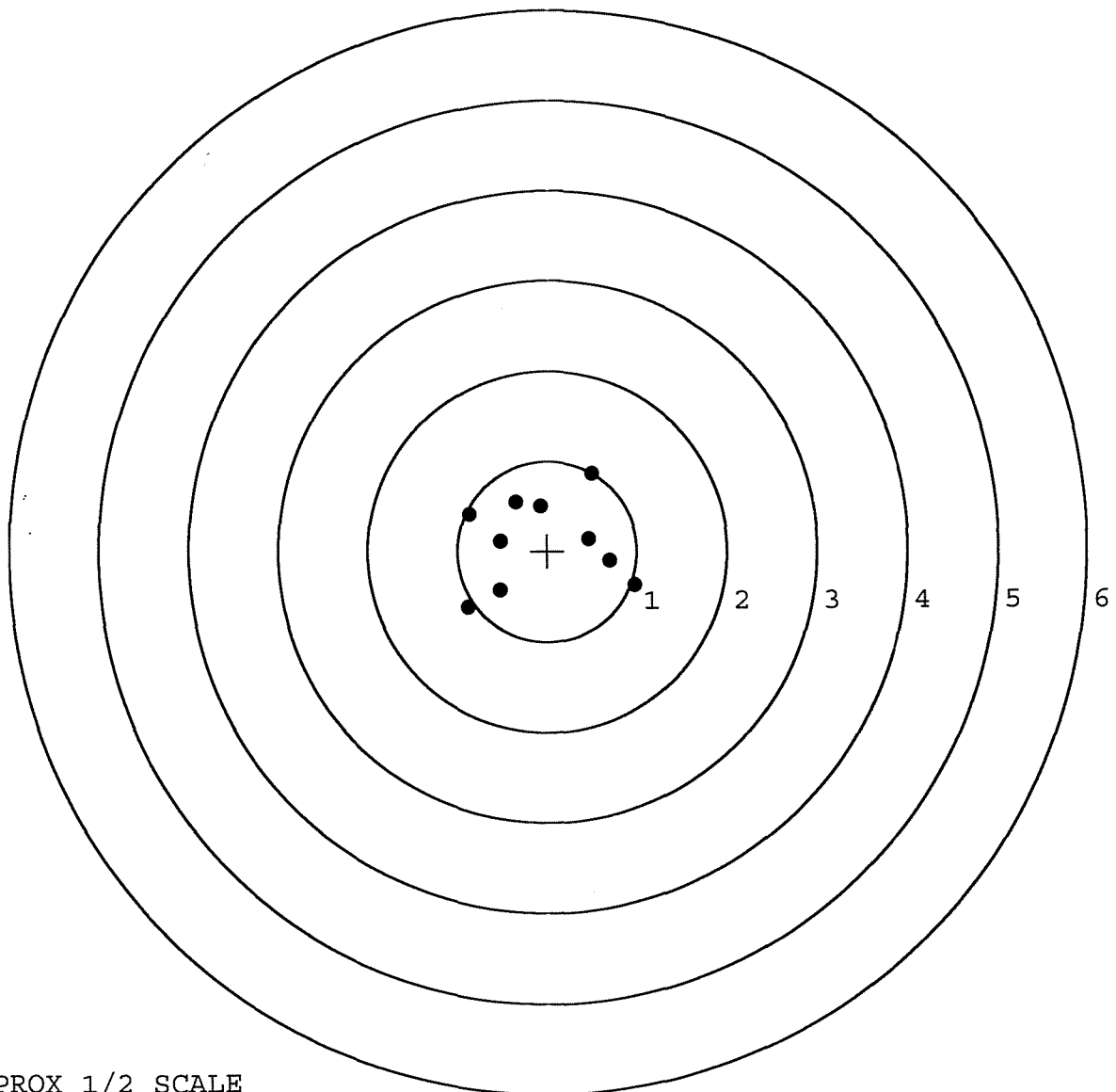
MAX RADIUS: 1.142

MEAN RADIUS: 0.747

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590043. __0

TARGET NUMBER: 5

FILE DATE: 08/11/2006

FILE TIME: 18:24

POINT#	X	Y
1:	0.467	0.091
2:	-0.225	-0.602
3:	-0.157	-0.083
4:	-0.616	-0.480
5:	-0.825	-0.100
6:	-0.538	0.072
7:	-0.733	0.064
8:	-0.601	0.535
9:	-0.585	-0.222
10:	-0.267	-0.357

X CENTROID: -0.408

Y CENTROID: -0.108

POA TO CENTROID: 0.422

HORZ SPREAD: 1.292

VERT SPREAD: 1.137

GROUP SPREAD: 1.306

MIN RADIUS: 0.210

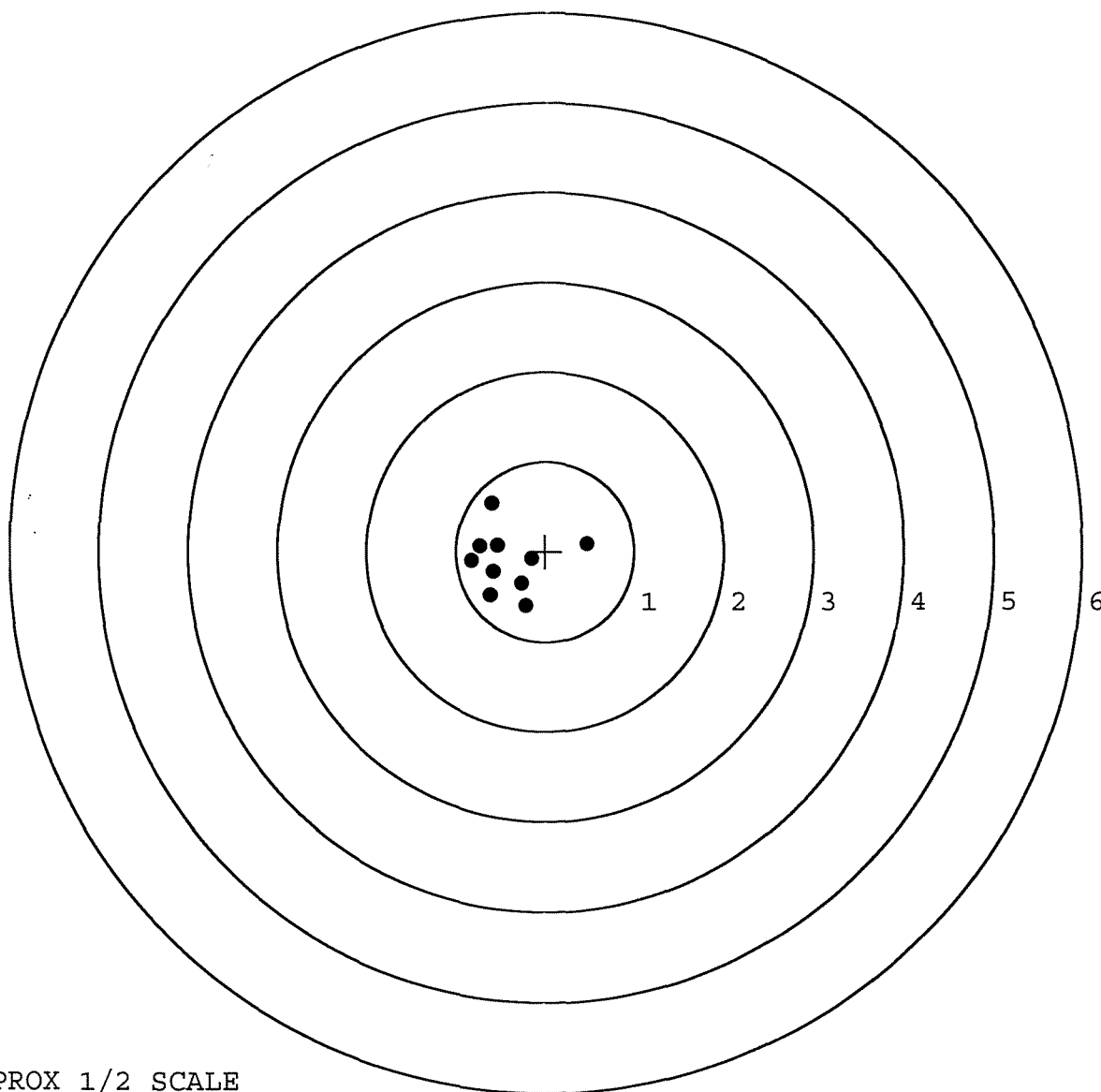
MAX RADIUS: 0.897

MEAN RADIUS: 0.428

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE