

G6590145

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590145

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	MAGNA-FLUX INSPECTED	8-4-06	BLG
460	CHECK HEADSPACE	AUG 09 2006	8-4-06	BLG
470	DIS-ASSEMBLE ACTION	OPERATOR <u>APD</u>	8-4-06	BLG
480	MAGNAFLUX BBL ACTION		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	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/10/06	TRW
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	RE
	D) OIL FIRING PIN ASSEMBLY		8-11-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-17-06	WOW

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	8-17-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.5</u> <u>3.5</u>	8-17-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-17-06	WJH
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>.024</u> <u>.023</u>	8-17-06	RA
	J) ASSEMBLE STOCK		8-17-06	RL
	K) ASSEMBLE SWIVEL STUDS		8-17-06	WJH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	8-11-06	J.P.A.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-17-06	WJH
670	FINAL INSPECTION A) HEADSPACE		8-17-06	WJH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.56</u> <u>2.55</u> <u>2.65</u> <u>2.65</u>	8-17-06	R.P.
	C) FUNCTION		8-17-06	WJH
690	PACK		11/14/06	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 8-9-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.52	2.46		2.48	
PULL #2	2.46	2.56		2.39	
PULL #3	2.59	2.51		2.59	
PULL #4	2.47	2.54		2.66	
PULL #5	2.46	2.53		2.61	
TOTAL	12.50	12.60		12.73	
AVERAGE	2.50	2.52		2.54	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.12		
PULL #2	3.08	3.21		
PULL #3	3.01	3.18		
PULL #4	3.10	3.13		
PULL #5	3.10	3.19		
TOTAL	15.33	15.83		
AVERAGE	3.06	3.16		

	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	4.12	4.08		4.25
PULL #2	4.16	4.15		4.12
PULL #3	4.12	4.26		4.11
PULL #4	4.19	4.27		4.19
PULL #5	4.26	4.24		4.22
TOTAL	20.85	21.00		20.89
AVERAGE	4.17	4.20		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590145.___0
FILE DATE AND TIME: 08/11/2006 18:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.096
The Average Y Centroid of the Five Target Set:	0.000
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.713
The Distance from POA to Centroid Target #1:	0.272
The Distance from Centroid Target #2 to Centroid Target #1:	0.236
The Distance from Centroid Target #3 to Centroid Target #1:	0.071
The Distance from Centroid Target #4 to Centroid Target #1:	0.200
The Distance from Centroid Target #5 to Centroid Target #1:	0.531

SERIAL NUMBER: G6590145. __0

TARGET NUMBER: 1

FILE DATE: 08/11/2006

FILE TIME: 18:20

POINT#	X	Y
1:	-0.972	-1.281
2:	-0.982	-0.604
3:	-0.278	-0.446
4:	0.052	-0.318
5:	0.211	-0.496
6:	-0.250	0.051
7:	0.022	0.507
8:	-0.261	1.324
9:	-0.198	0.370
10:	0.041	0.132

X CENTROID: -0.261

Y CENTROID: -0.076

POA TO CENTROID: 0.272

HORZ SPREAD: 1.193

VERT SPREAD: 2.605

GROUP SPREAD: 2.700

MIN RADIUS: 0.128

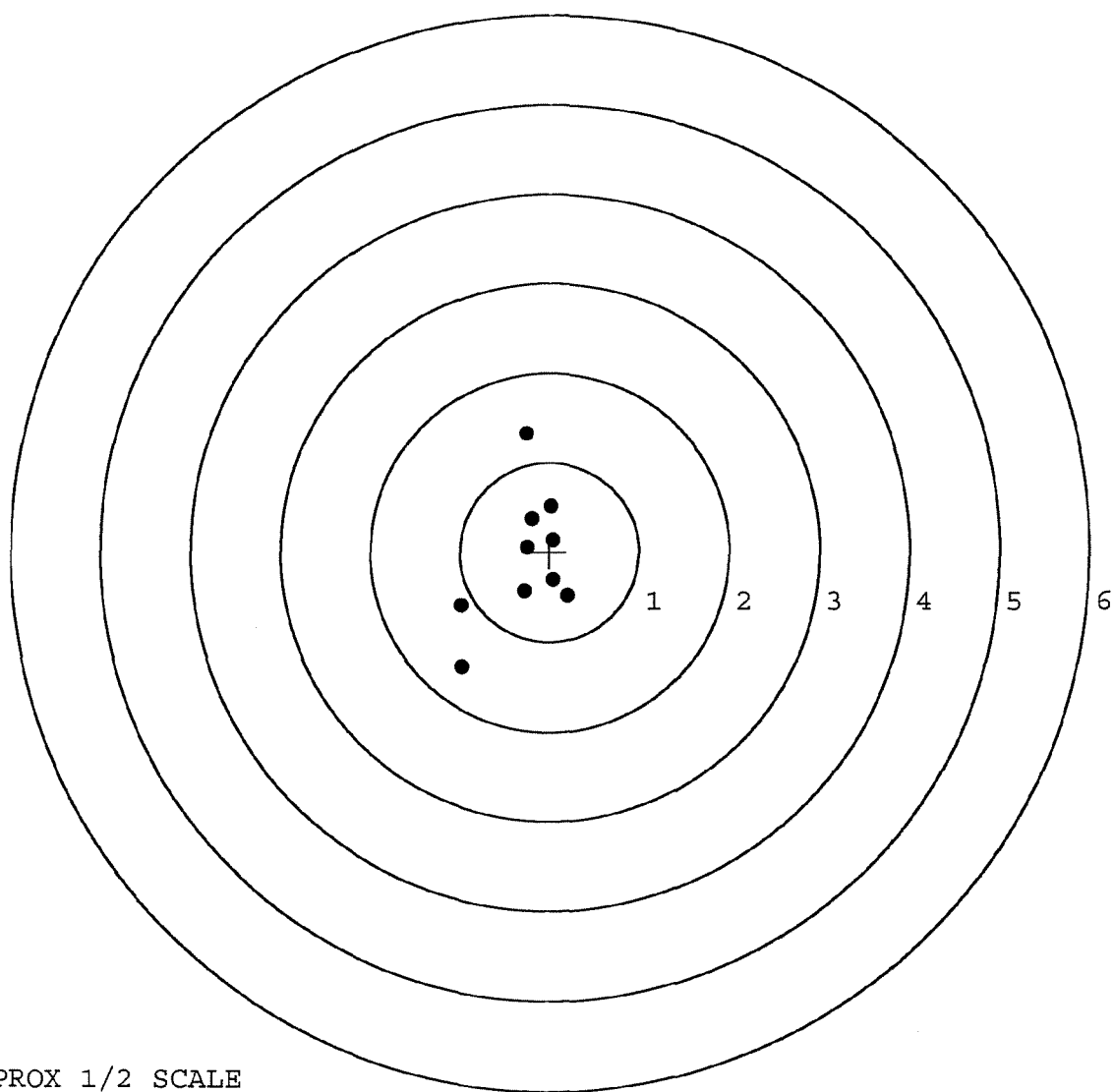
MAX RADIUS: 1.400

MEAN RADIUS: 0.668

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

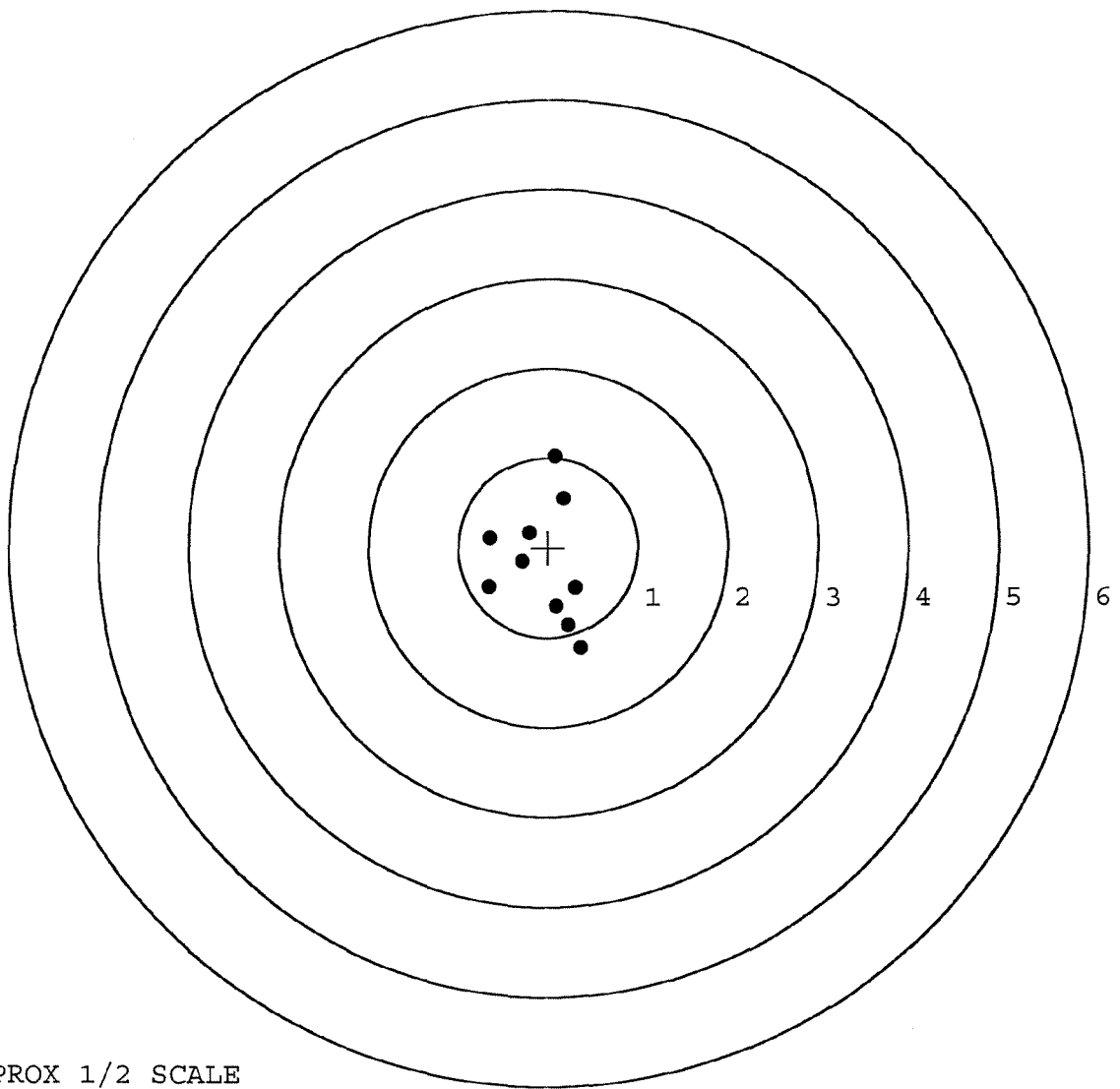


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590145. __0
TARGET NUMBER: 2
FILE DATE: 08/11/2006
FILE TIME: 18:20

X CENTROID: -0.053
Y CENTROID: -0.188
POA TO CENTROID: 0.195
HORZ SPREAD: 1.030
VERT SPREAD: 2.141
GROUP SPREAD: 2.161
MIN RADIUS: 0.233
MAX RADIUS: 1.211
MEAN RADIUS: 0.663
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.375	-1.125
2:	0.231	-0.873
3:	0.097	-0.654
4:	0.310	-0.453
5:	-0.655	-0.445
6:	-0.284	-0.154
7:	-0.649	0.105
8:	-0.212	0.165
9:	0.175	0.541
10:	0.080	1.016



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590145. __0

TARGET NUMBER: 3

FILE DATE: 08/11/2006

FILE TIME: 18:20

X CENTROID: -0.231

Y CENTROID: -0.011

POA TO CENTROID: 0.231

HORZ SPREAD: 2.327

VERT SPREAD: 1.374

GROUP SPREAD: 2.339

MIN RADIUS: 0.251

MAX RADIUS: 1.333

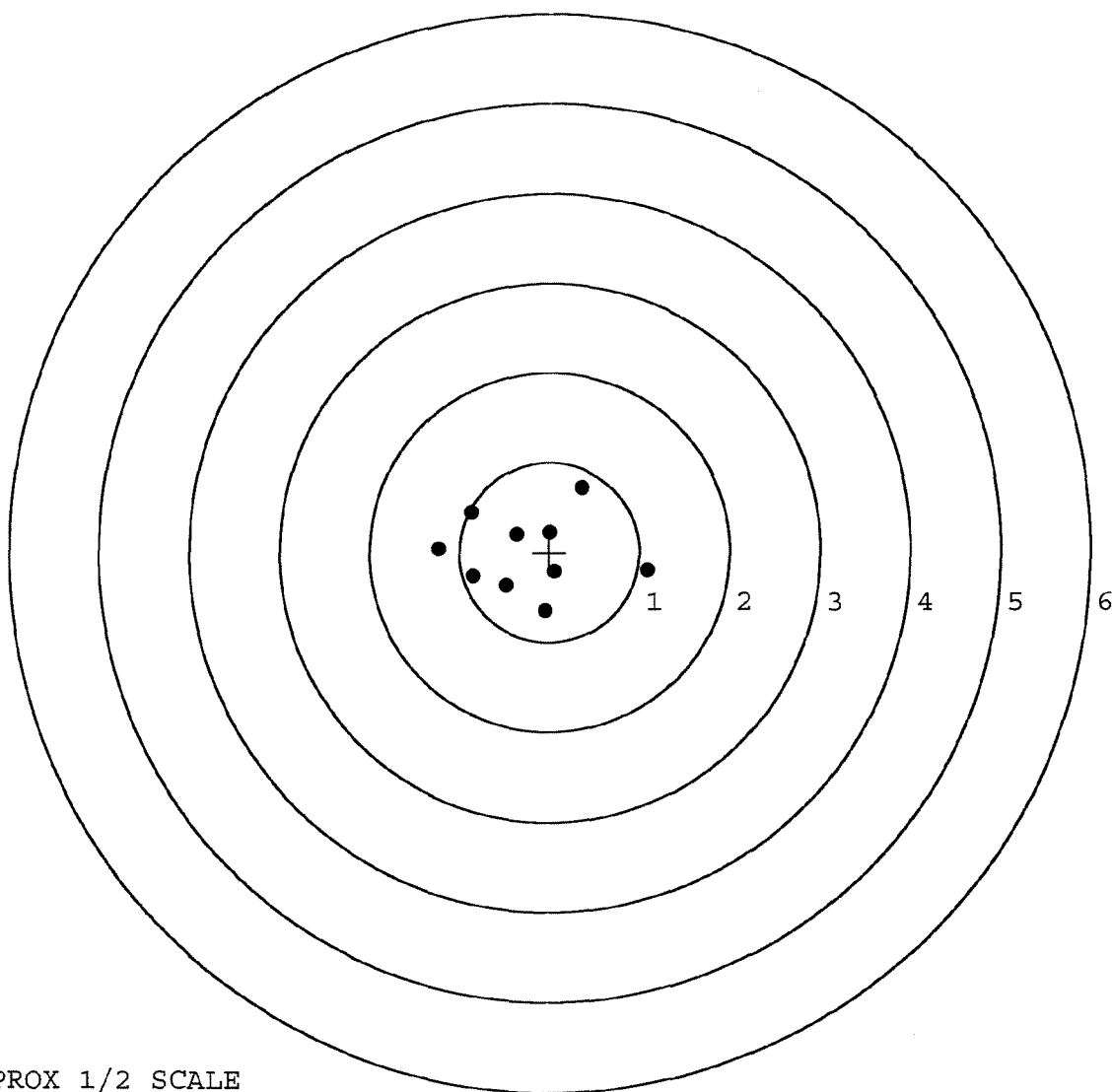
MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.867	0.441
2:	-1.239	0.034
3:	-0.848	-0.271
4:	-0.478	-0.374
5:	0.007	0.220
6:	-0.361	0.203
7:	0.059	-0.219
8:	-0.042	-0.659
9:	1.088	-0.205
10:	0.370	0.715



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590145. __0

TARGET NUMBER: 4

FILE DATE: 08/11/2006

FILE TIME: 18:20

POINT#	X	Y
1:	0.414	1.330
2:	-0.481	0.807
3:	-1.199	0.237
4:	0.492	0.608
5:	0.007	0.344
6:	0.472	-0.194
7:	0.326	-0.626
8:	0.000	-0.304
9:	-0.281	-0.680
10:	-0.796	-1.046

X CENTROID: -0.105

Y CENTROID: 0.048

POA TO CENTROID: 0.115

HORZ SPREAD: 1.691

VERT SPREAD: 2.376

GROUP SPREAD: 2.666

MIN RADIUS: 0.317

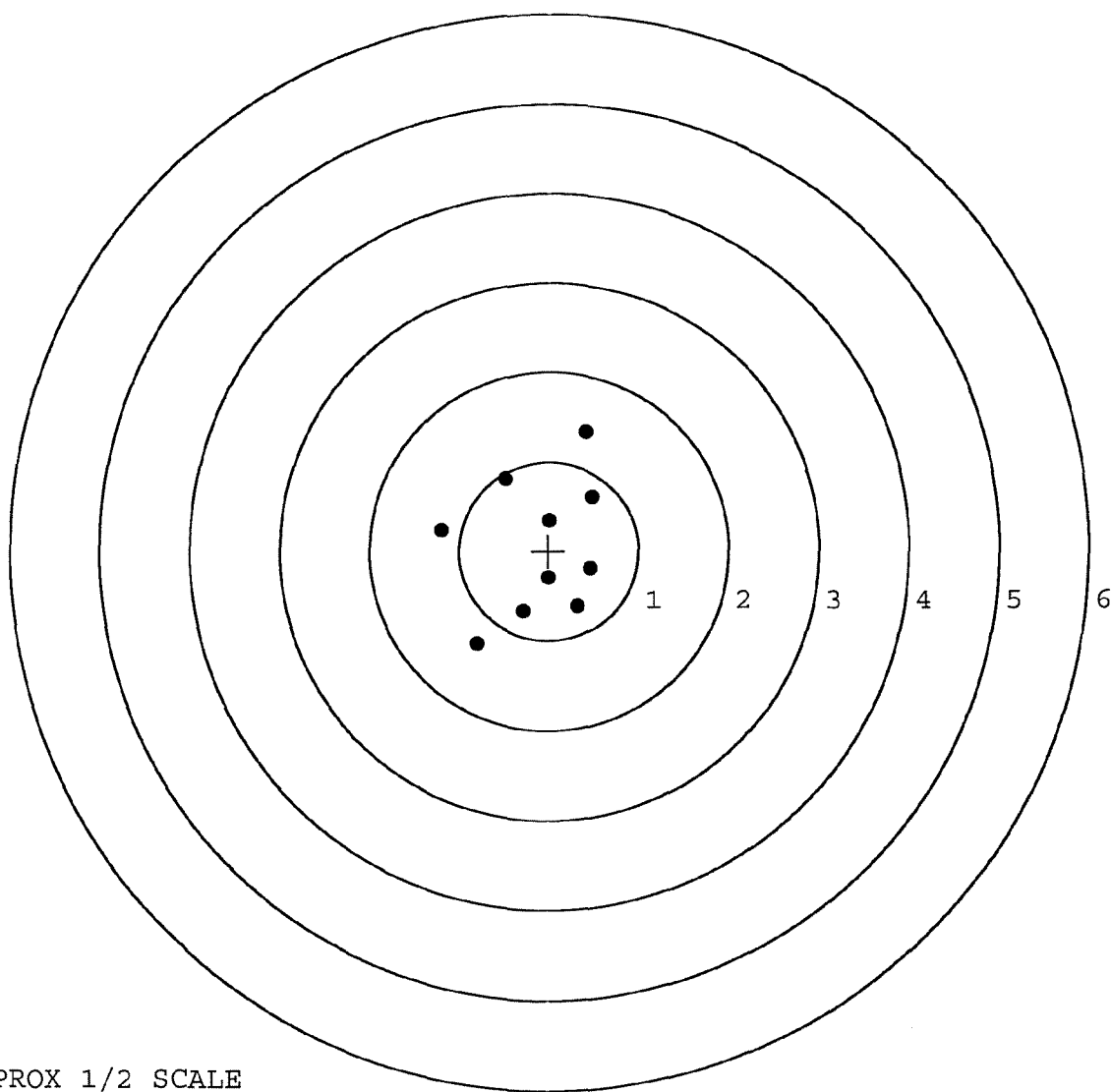
MAX RADIUS: 1.383

MEAN RADIUS: 0.831

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

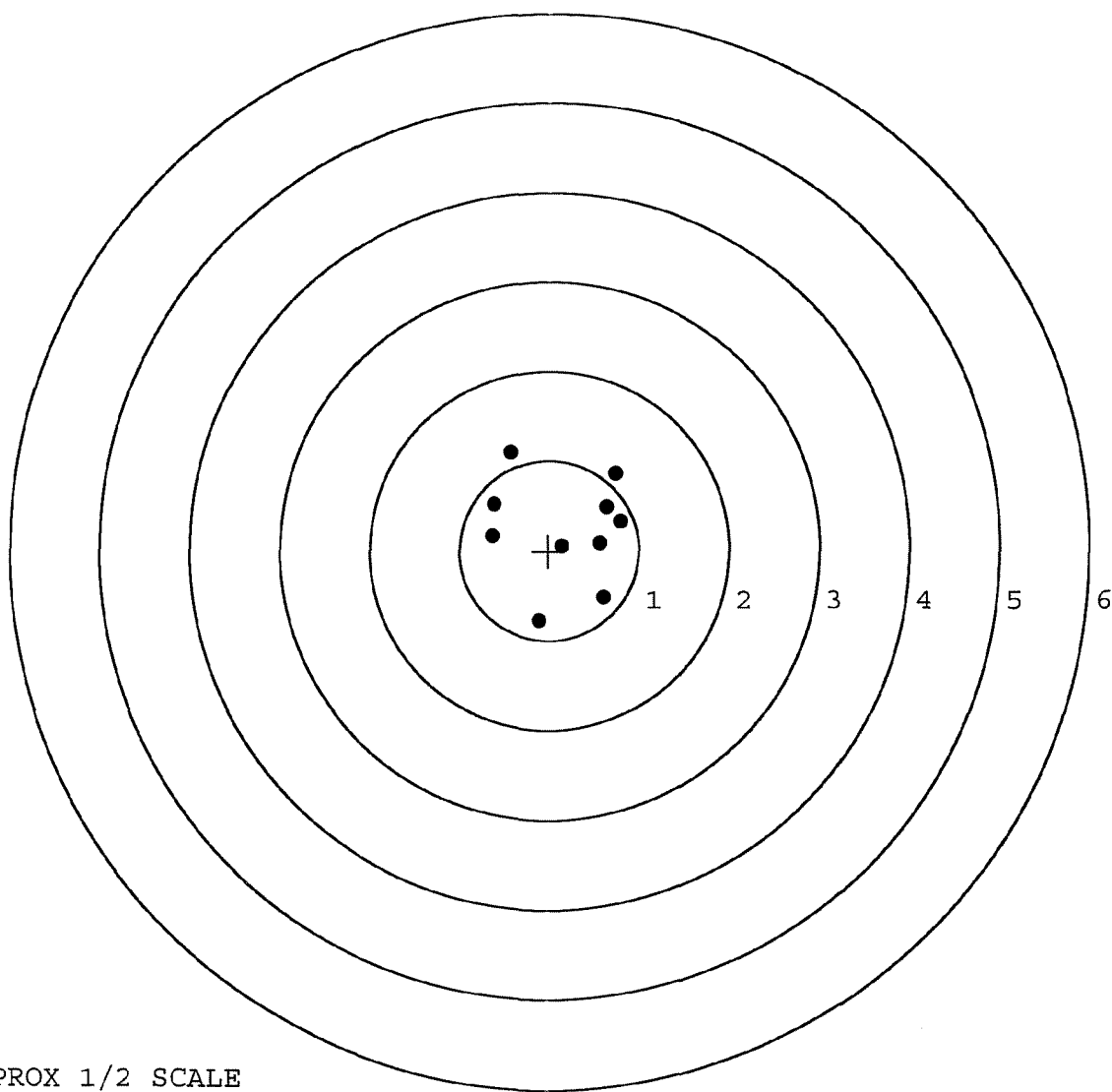


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590145. __0
TARGET NUMBER: 5
FILE DATE: 08/11/2006
FILE TIME: 18:20

POINT#	X	Y
1:	-0.431	1.092
2:	-0.616	0.517
3:	-0.638	0.165
4:	-0.112	-0.784
5:	0.617	-0.521
6:	0.149	0.057
7:	0.570	0.091
8:	0.794	0.330
9:	0.645	0.492
10:	0.746	0.855

X CENTROID: 0.172
Y CENTROID: 0.229
POA TO CENTROID: 0.287
HORZ SPREAD: 1.432
VERT SPREAD: 1.876
GROUP SPREAD: 1.924
MIN RADIUS: 0.174
MAX RADIUS: 1.053
MEAN RADIUS: 0.724
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



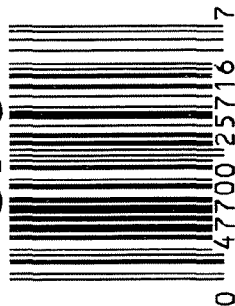
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590145

UPC



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)

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SERIAL NO.

