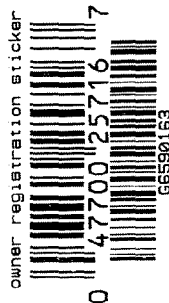
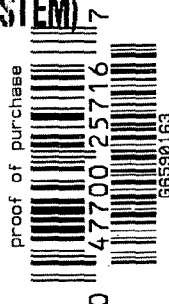


G-6590163

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

- INSTRUCTION BOOK 3518

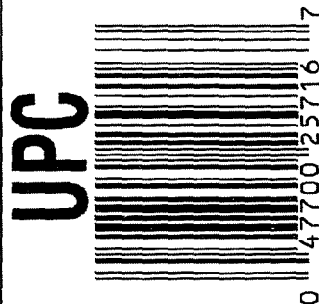


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590163



DD FORM

ORDER — 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590163

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 AUG 09 2006	8-2-06	BLG
460	CHECK HEADSPACE		8-2-06	BLG
470	DIS-ASSEMBLE ACTION		8-2-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	8-9-04	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	TRB
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	8-17-04	WTH
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.2</u> <u>65</u> <u>4.2</u>	8-17-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7.5</u> <u>25</u> <u>25</u>	8-17-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-17-06	MOH
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	8-17-06	DA
	J) ASSEMBLE STOCK		8-11-06	RTL
	K) ASSEMBLE SWIVEL STUDS		8-11-06	MOH
	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	PASS FAIL PASS FAIL	8-11-06	R.P.D.
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/11/06	M.P.D.
670	FINAL INSPECTION A) HEADSPACE		8-17-06	MOH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>244</u> <u>223</u> <u>228</u> <u>221</u> <u>217</u>	8-17-06	R.P.
	C) FUNCTION		8-17-06	MOH
690	PACK		11-16-06	BLG

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 8-14-06
TESTER mo

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.61	2.44		2.54	
PULL #2	2.45	2.31		2.49	
PULL #3	2.49	2.45		2.56	
PULL #4	2.39	2.34		2.52	
PULL #5	2.58	2.32		2.49	
TOTAL	12.52	12.06		12.80	
AVERAGE	2.50	2.41		2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.24		
PULL #2	3.17	2.93		
PULL #3	3.12	2.85		
PULL #4	3.04	2.89		
PULL #5	3.17	3.14		
TOTAL	15.57	15.02		
AVERAGE	3.11	3.00		

	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	4.04	4.08		4.18
PULL #2	3.99	4.17		4.08
PULL #3	4.29	3.90		4.01
PULL #4	4.11	4.31		4.12
PULL #5	4.12	4.18		4.04
TOTAL	20.55	20.64		20.48
AVERAGE	4.11	4.13		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590163.__0
FILE DATE AND TIME: 08/11/2006 18:15

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.153
The Average Y Centroid of the Five Target Set:	-0.062
The Average Point of Impact of the Five Target Set:	0.165
The Average Mean Radius of the Five Target Set:	0.744
The Distance from POA to Centroid Target #1:	0.350
The Distance from Centroid Target #2 to Centroid Target #1:	0.433
The Distance from Centroid Target #3 to Centroid Target #1:	0.228
The Distance from Centroid Target #4 to Centroid Target #1:	0.162
The Distance from Centroid Target #5 to Centroid Target #1:	0.278

SERIAL NUMBER: G6590163. __0

TARGET NUMBER: 1

FILE DATE: 08/11/2006

FILE TIME: 18:15

X CENTROID: -0.338

Y CENTROID: -0.092

POA TO CENTROID: 0.350

HORZ SPREAD: 2.484

VERT SPREAD: 2.266

GROUP SPREAD: 2.894

MIN RADIUS: 0.224

MAX RADIUS: 1.822

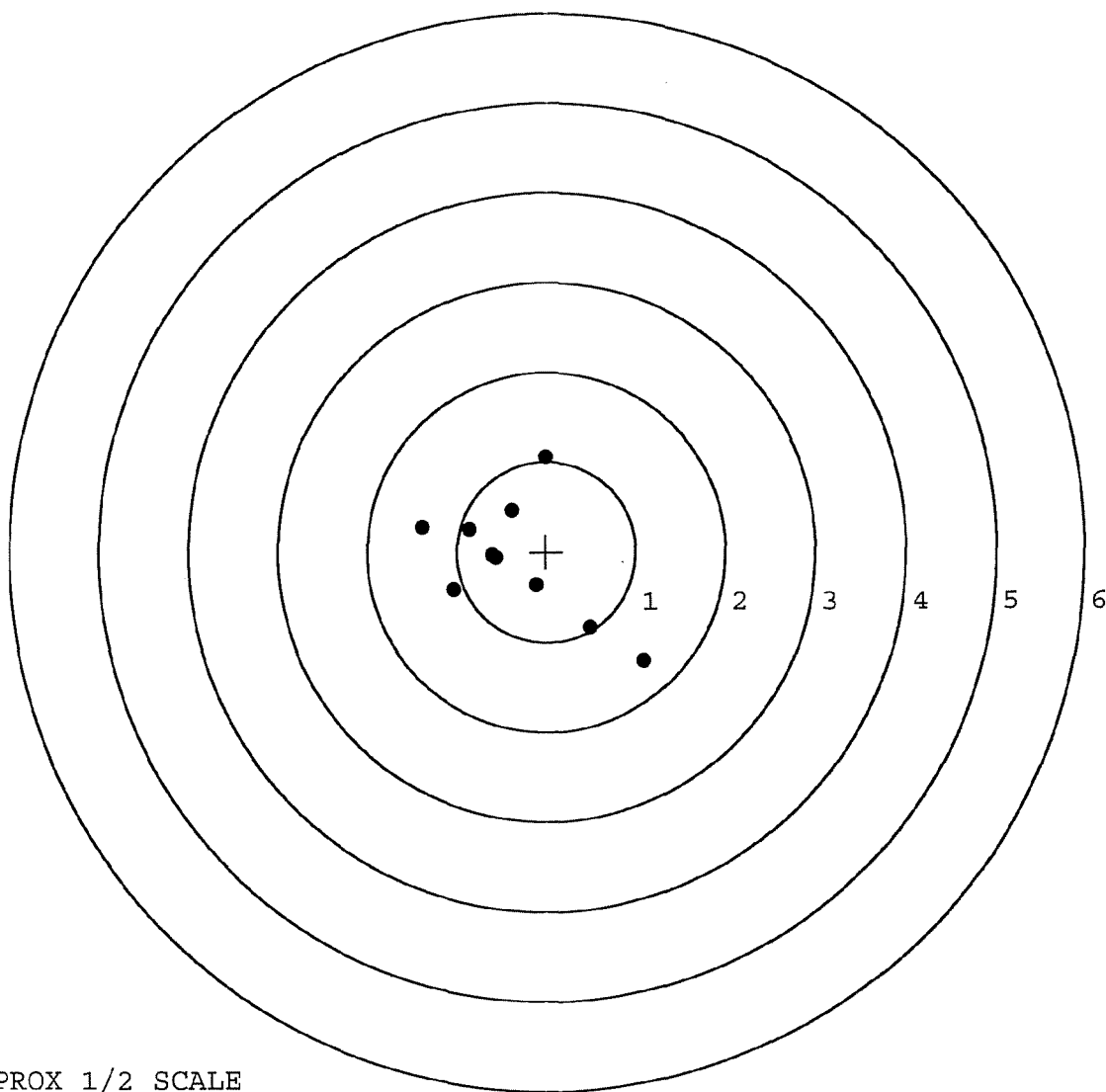
MEAN RADIUS: 0.804

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.009	1.048
2:	-0.391	0.458
3:	-0.865	0.251
4:	-0.560	-0.064
5:	-1.389	0.267
6:	-1.035	-0.415
7:	1.095	-1.218
8:	0.493	-0.839
9:	-0.116	-0.371
10:	-0.601	-0.035



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590163. 0

TARGET NUMBER: 2

FILE DATE: 08/11/2006

FILE TIME: 18:15

X CENTROID: 0.093

Y CENTROID: -0.046

POA TO CENTROID: 0.104

HORZ SPREAD: 2.440

VERT SPREAD: 2.142

GROUP SPREAD: 2.437

MIN RADIUS: 0.276

MAX RADIUS: 1.356

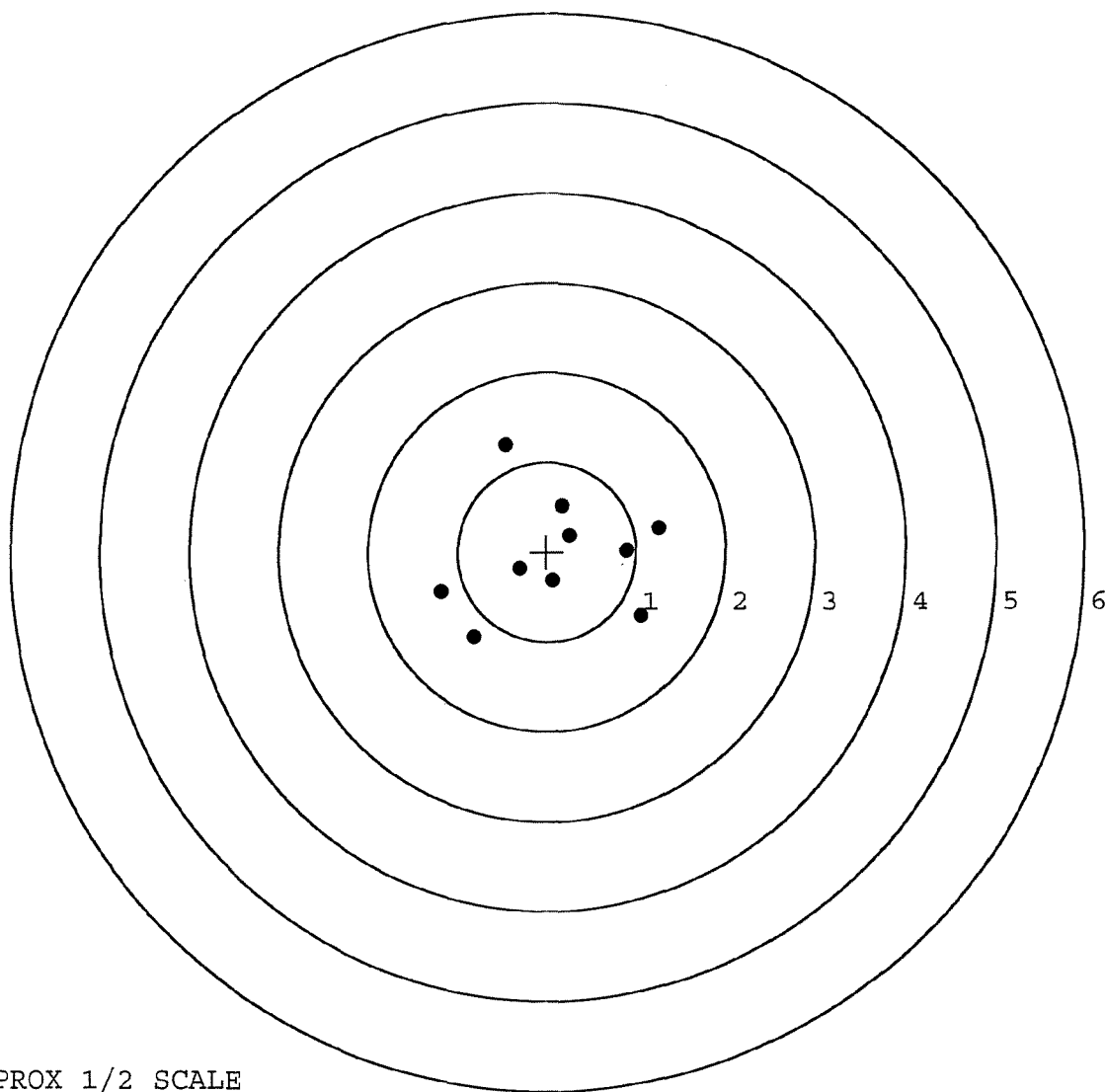
MEAN RADIUS: 0.870

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.255	0.265
2:	0.896	0.015
3:	1.056	-0.715
4:	-0.815	-0.951
5:	-1.185	-0.452
6:	-0.305	-0.188
7:	0.069	-0.321
8:	0.250	0.181
9:	0.171	0.517
10:	-0.463	1.191



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590163. 0

TARGET NUMBER: 3

FILE DATE: 08/11/2006

FILE TIME: 18:15

X CENTROID: -0.113

Y CENTROID: -0.053

POA TO CENTROID: 0.125

HORZ SPREAD: 2.005

VERT SPREAD: 1.312

GROUP SPREAD: 2.178

MIN RADIUS: 0.183

MAX RADIUS: 1.159

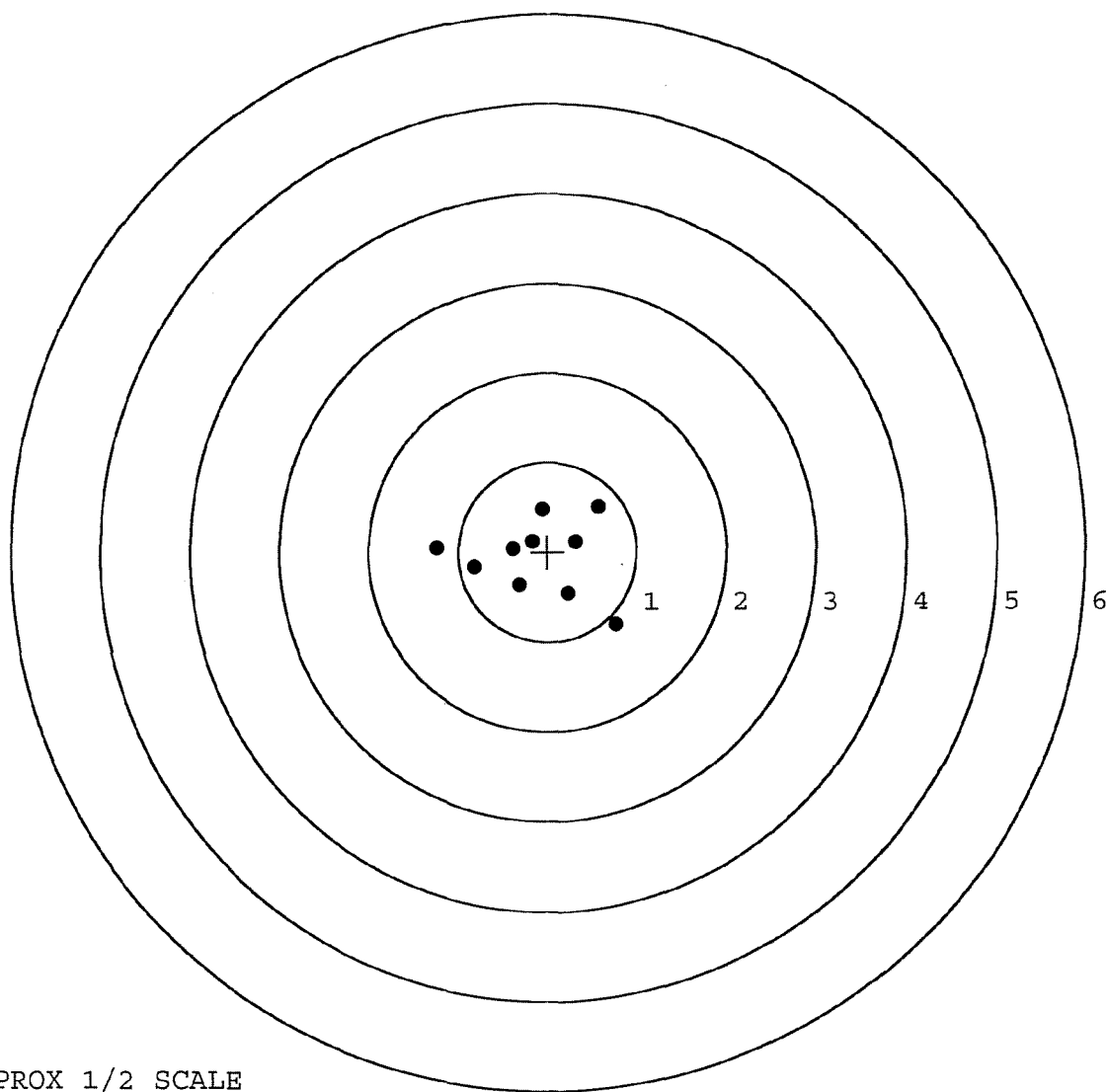
MEAN RADIUS: 0.625

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.567	0.503
2:	0.312	0.117
3:	-0.063	0.468
4:	0.766	-0.809
5:	0.231	-0.466
6:	-0.179	0.118
7:	-0.389	0.037
8:	-0.315	-0.369
9:	-0.819	-0.169
10:	-1.239	0.042



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590163. 0

TARGET NUMBER: 4

FILE DATE: 08/11/2006

FILE TIME: 18:15

X CENTROID: -0.256

Y CENTROID: -0.232

POA TO CENTROID: 0.346

HORZ SPREAD: 2.193

VERT SPREAD: 1.760

GROUP SPREAD: 2.195

MIN RADIUS: 0.030

MAX RADIUS: 1.168

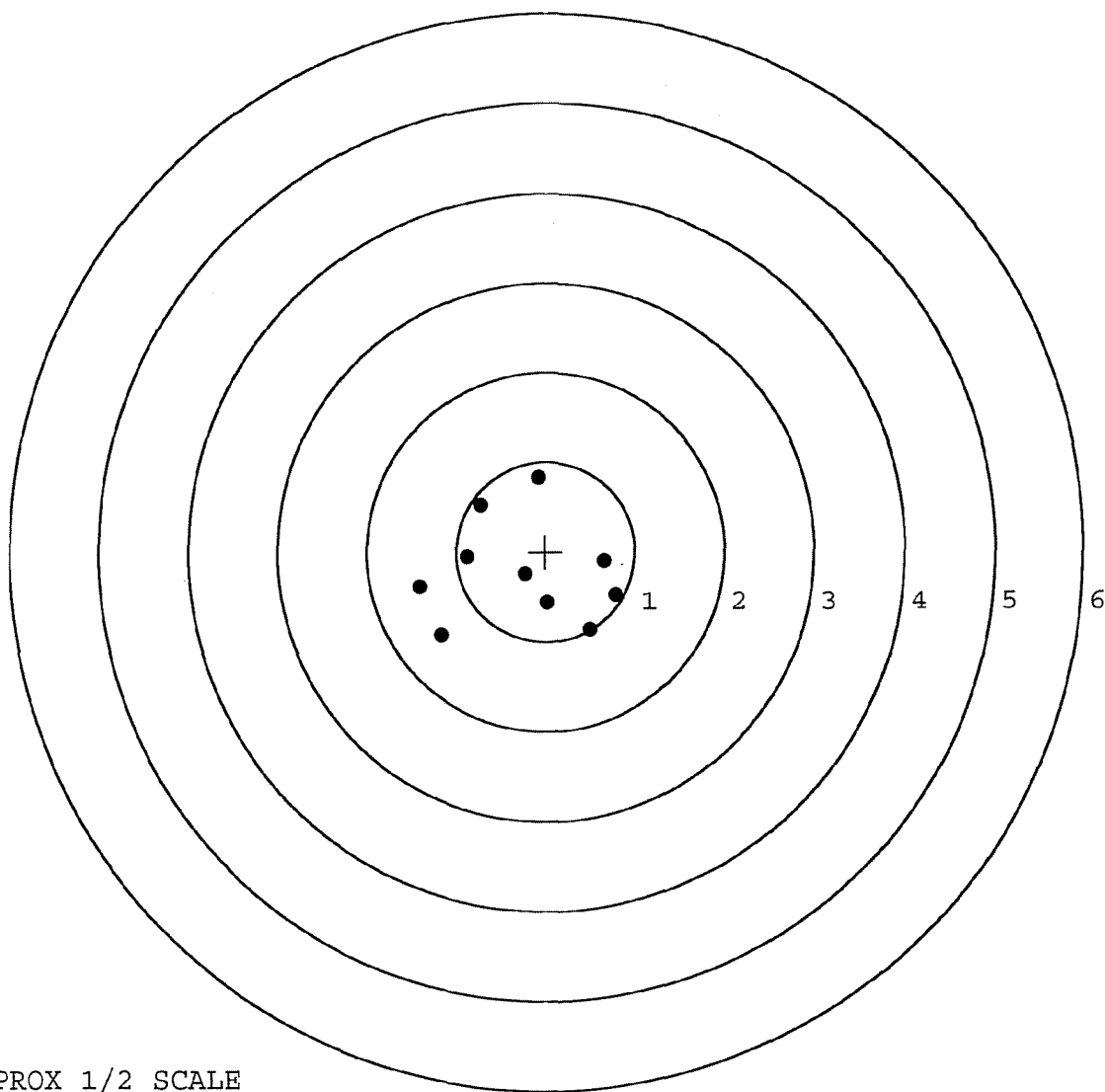
MEAN RADIUS: 0.837

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.655	-0.106
2:	0.781	-0.485
3:	0.498	-0.873
4:	0.014	-0.568
5:	-0.232	-0.250
6:	-1.173	-0.934
7:	-1.412	-0.398
8:	-0.877	-0.059
9:	-0.728	0.525
10:	-0.086	0.826



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590163. __0

TARGET NUMBER: 5

FILE DATE: 08/11/2006

FILE TIME: 18:15

X CENTROID: -0.149

Y CENTROID: 0.112

POA TO CENTROID: 0.186

HORZ SPREAD: 1.598

VERT SPREAD: 1.215

GROUP SPREAD: 1.763

MIN RADIUS: 0.311

MAX RADIUS: 0.981

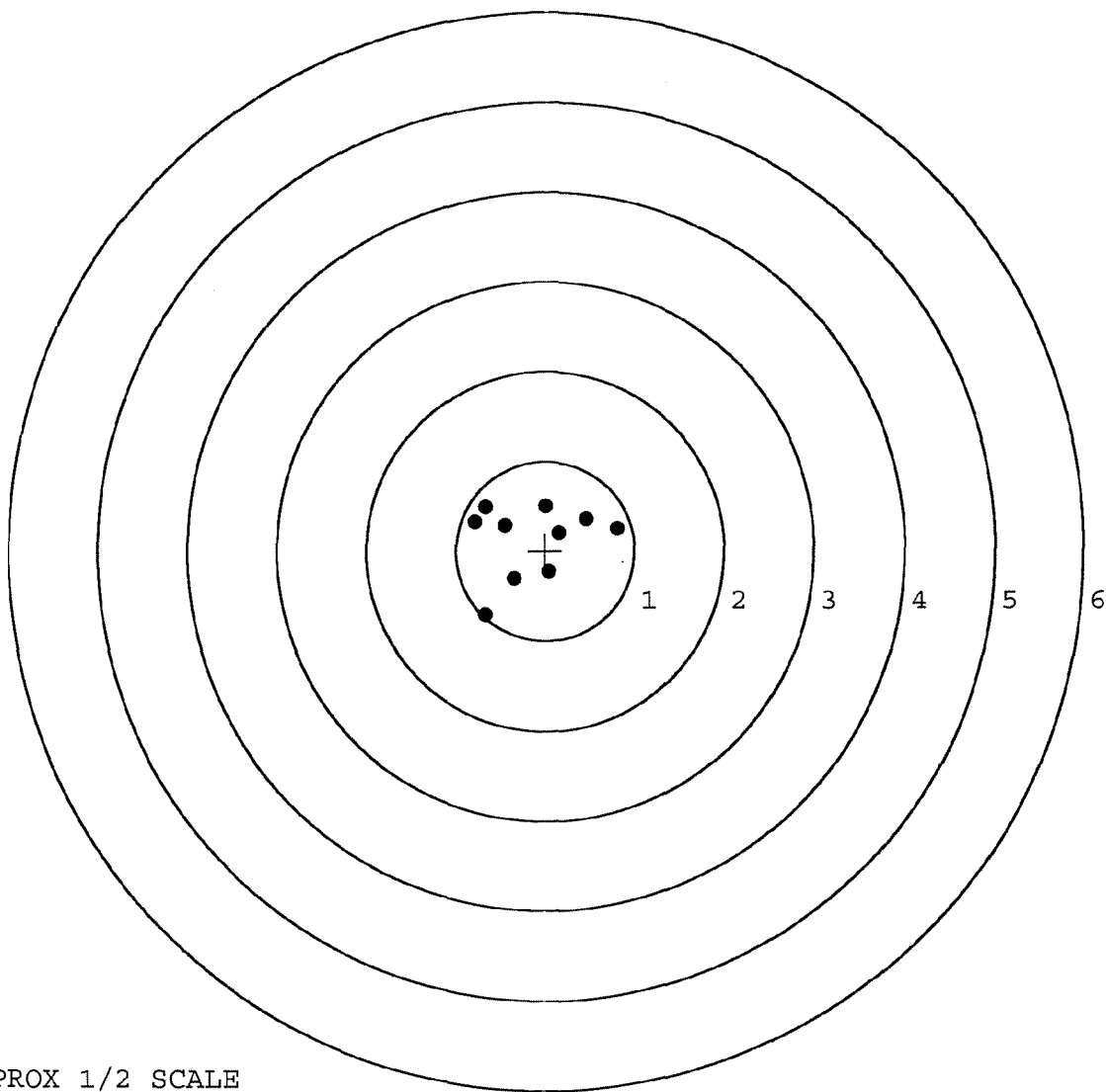
MEAN RADIUS: 0.586

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.805	0.248
2:	0.459	0.355
3:	-0.006	0.496
4:	0.149	0.203
5:	-0.456	0.282
6:	-0.667	0.487
7:	-0.793	0.322
8:	-0.353	-0.316
9:	0.042	-0.236
10:	-0.669	-0.719



TARGET APPROX 1/2 SCALE