

G6590167

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

BM FORM 200348



ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6590167



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

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UPC



SERIAL NO.



5732

M-24

INSPECTION CHECKLIST-NEW GUNS

TRW

GUN SERIAL #

~~G6590167~~

G6590167

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		11-7-07	TRW
420	ASSEMBLE ACTION			
430	ASSEMBLE TO STOCK		11-12-07	TRW
440	PROOF		11-12-07	TRW
460	CHECK HEADSPACE	MAGNA - FLUX	11-12-07	TRW
470	DIS-ASSEMBLE ACTION	11-14-2007	11-12-07	TRW
480	MAGNAFLUX BBL ACTION	OPERATOR JB	11-14-07	JB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		11-3-07	CW
510	DRILL AND TAP SIGHT HOLES		11-13-07	TRW
520	GOFF BLAST BBL / REC		11-14-07	JB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		11/27/07	JB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-28-07	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-28-07	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-28-07	DA
	D) OIL FIRING PIN ASSEMBLY		11-28-07	LTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>55</u> <u>60</u> <u>55</u>	11-30-07	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.75</u> <u>3.75</u>	11-30-07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	11-30-07	DA
	J) ASSEMBLE STOCK		11-28-07	PR
	K) ASSEMBLE SWIVEL STUDS		11-30-07	DA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11-29-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-29-07	PPD
670	FINAL INSPECTION A) HEADSPACE		11-30-07	DA
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.28</u> <u>2.33</u> <u>2.52</u> <u>2.22</u> <u>2.22</u>	11-30-07	DA
	C) FUNCTION			
690	PACK		11-30-07	DA

F004 REV 5/2006

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590167.__0
FILE DATE AND TIME: 11/30/2007 12:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.022
The Average Y Centroid of the Five Target Set:	-0.128
The Average Point of Impact of the Five Target Set:	0.130
The Average Mean Radius of the Five Target Set:	0.713
The Distance from POA to Centroid Target #1:	0.219
The Distance from Centroid Target #2 to Centroid Target #1:	0.201
The Distance from Centroid Target #3 to Centroid Target #1:	0.092
The Distance from Centroid Target #4 to Centroid Target #1:	0.221
The Distance from Centroid Target #5 to Centroid Target #1:	0.114

SERIAL NUMBER: G6590167. __0

TARGET NUMBER: 1

FILE DATE: 11/30/2007

FILE TIME: 12:31

X CENTROID: -0.095

Y CENTROID: -0.198

POA TO CENTROID: 0.219

HORZ SPREAD: 2.007

VERT SPREAD: 1.659

GROUP SPREAD: 2.231

MIN RADIUS: 0.178

MAX RADIUS: 1.278

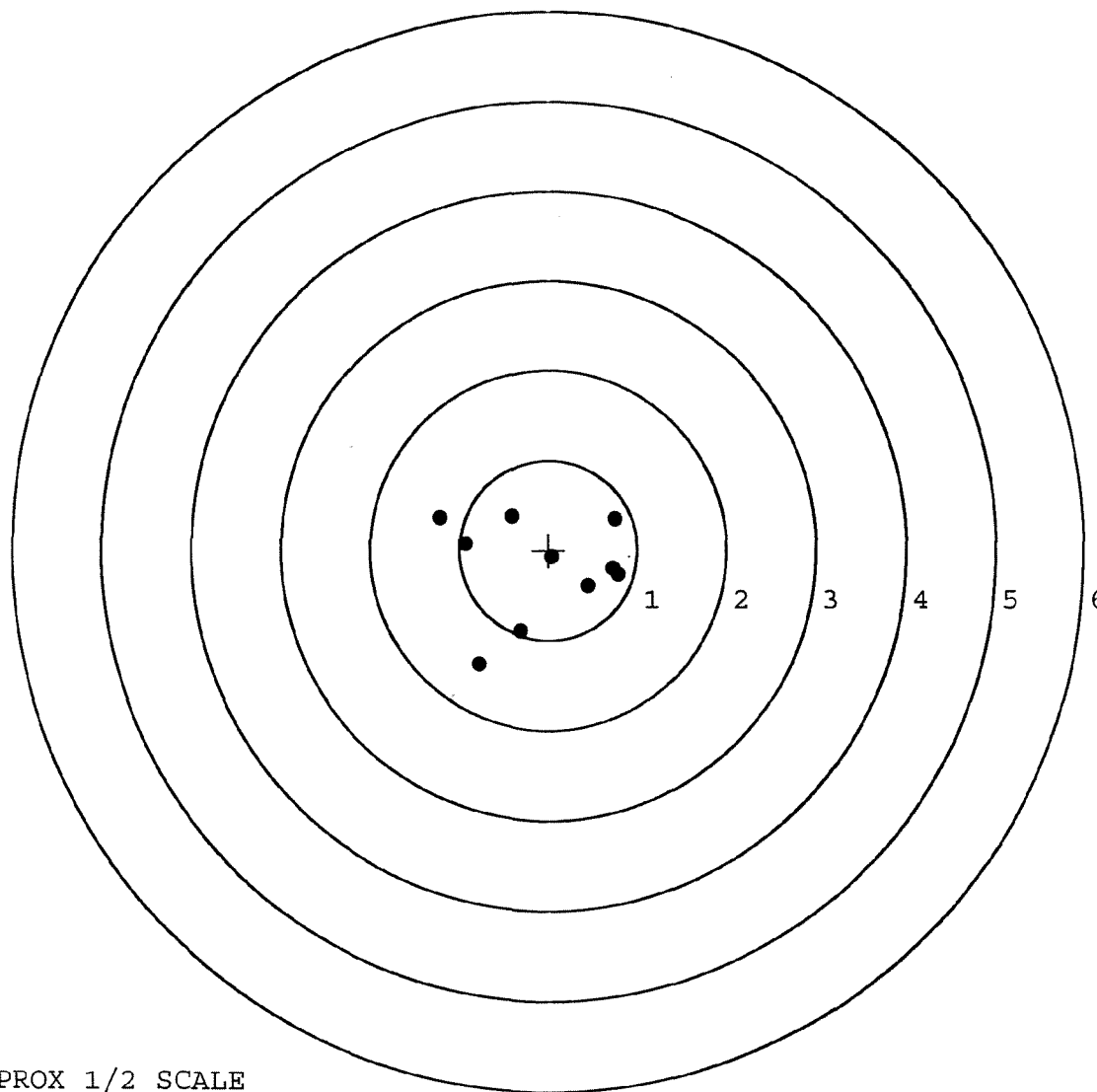
MEAN RADIUS: 0.828

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.783	-1.275
2:	-0.325	-0.900
3:	0.444	-0.400
4:	0.782	-0.278
5:	0.725	-0.212
6:	0.745	0.350
7:	0.038	-0.079
8:	-0.415	0.384
9:	-0.932	0.068
10:	-1.225	0.363

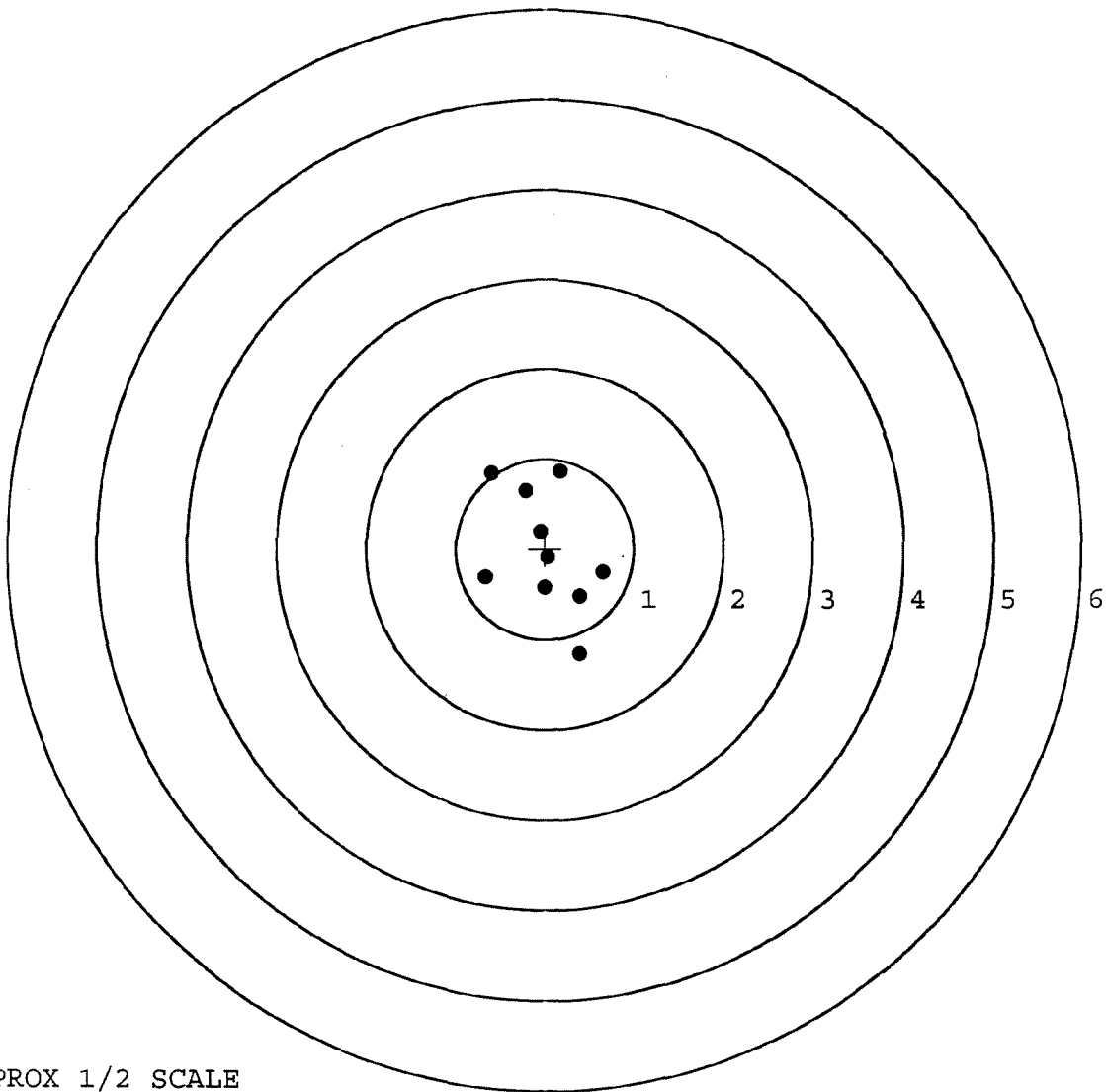


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590167.___0
TARGET NUMBER: 2
FILE DATE: 11/30/2007
FILE TIME: 12:31

X CENTROID: 0.007
Y CENTROID: -0.024
POA TO CENTROID: 0.025
HORZ SPREAD: 1.317
VERT SPREAD: 2.025
GROUP SPREAD: 2.238
MIN RADIUS: 0.078
MAX RADIUS: 1.201
MEAN RADIUS: 0.663
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.387	-1.163
2:	0.648	-0.259
3:	0.392	-0.524
4:	-0.009	-0.431
5:	0.028	-0.099
6:	-0.051	0.194
7:	0.168	0.862
8:	-0.222	0.644
9:	-0.606	0.843
10:	-0.669	-0.308



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590167. __ 0

TARGET NUMBER: 3

FILE DATE: 11/30/2007

FILE TIME: 12:31

X CENTROID: -0.107

Y CENTROID: -0.106

POA TO CENTROID: 0.151

HORZ SPREAD: 1.850

VERT SPREAD: 1.955

GROUP SPREAD: 2.569

MIN RADIUS: 0.265

MAX RADIUS: 1.310

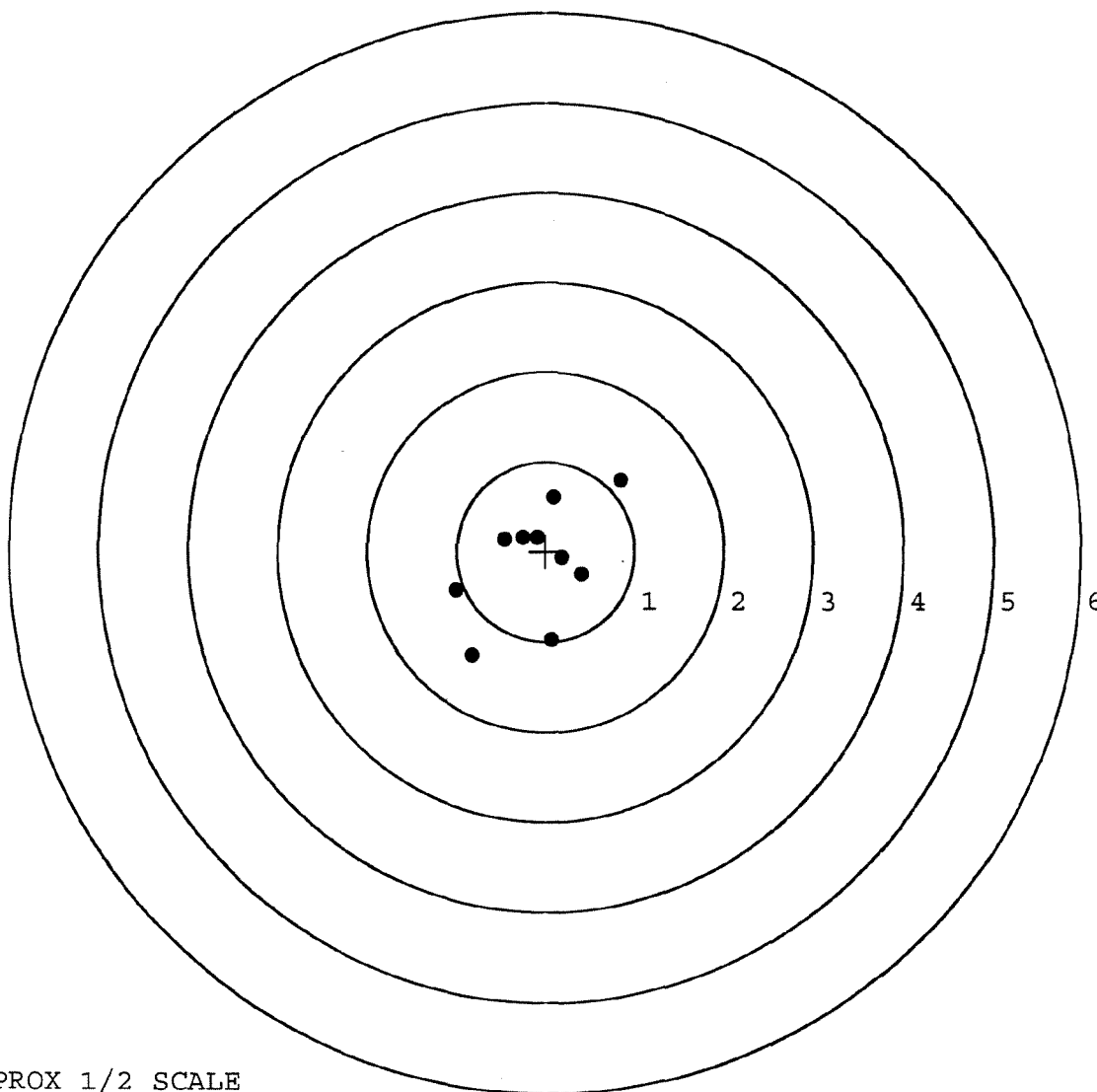
MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.063	-0.991
2:	-0.825	-1.158
3:	-1.008	-0.429
4:	0.401	-0.259
5:	0.186	-0.078
6:	0.842	0.797
7:	0.090	0.603
8:	-0.095	0.158
9:	-0.255	0.158
10:	-0.467	0.134



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590167. __0

TARGET NUMBER: 4

FILE DATE: 11/30/2007

FILE TIME: 12:31

X CENTROID: 0.078

Y CENTROID: -0.059

POA TO CENTROID: 0.098

HORZ SPREAD: 2.615

VERT SPREAD: 1.026

GROUP SPREAD: 2.616

MIN RADIUS: 0.453

MAX RADIUS: 1.413

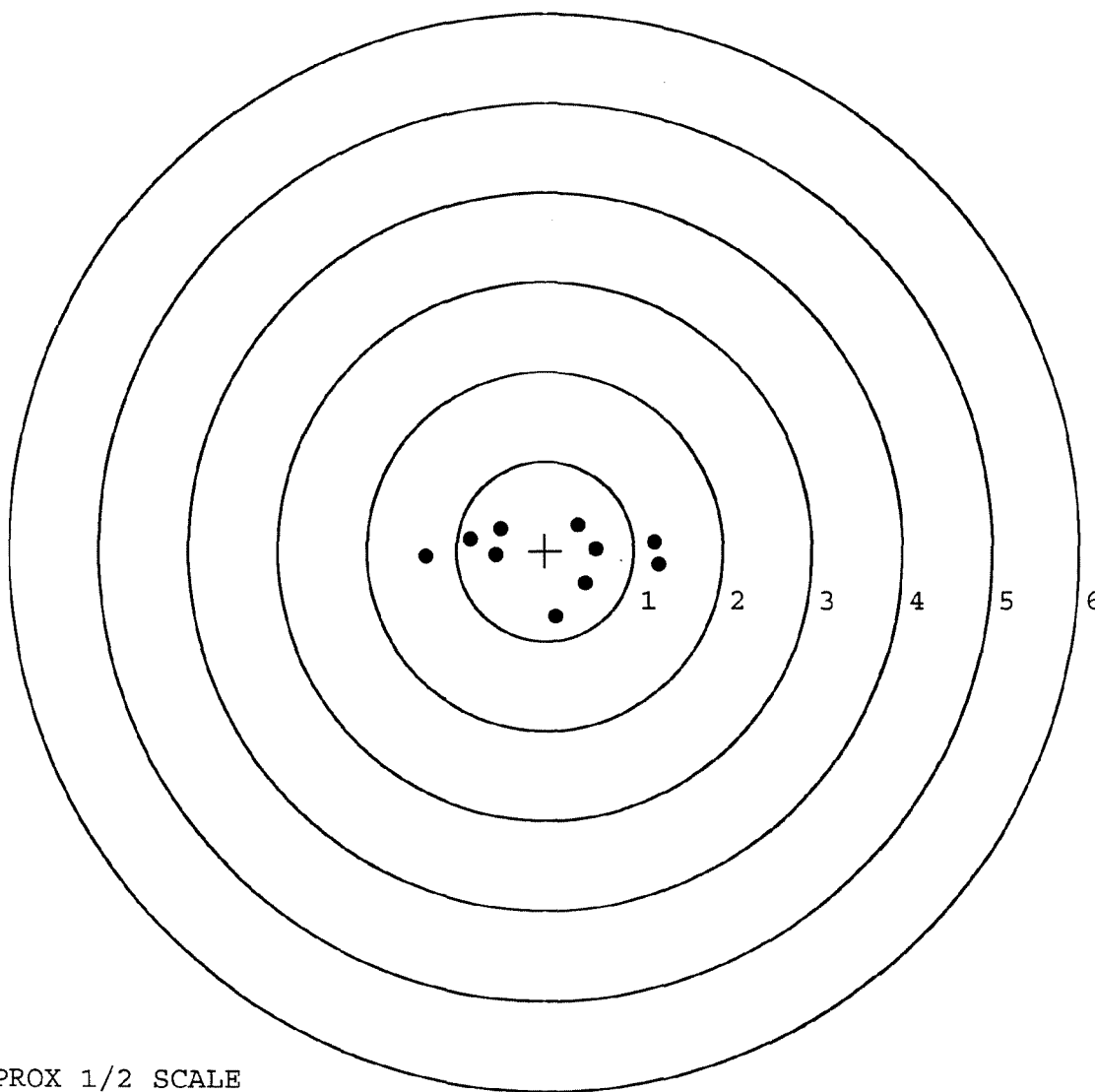
MEAN RADIUS: 0.814

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.280	-0.160
2:	1.231	0.097
3:	0.577	0.023
4:	0.459	-0.361
5:	0.115	-0.737
6:	0.367	0.289
7:	-0.511	0.246
8:	-0.556	-0.048
9:	-0.844	0.129
10:	-1.335	-0.073

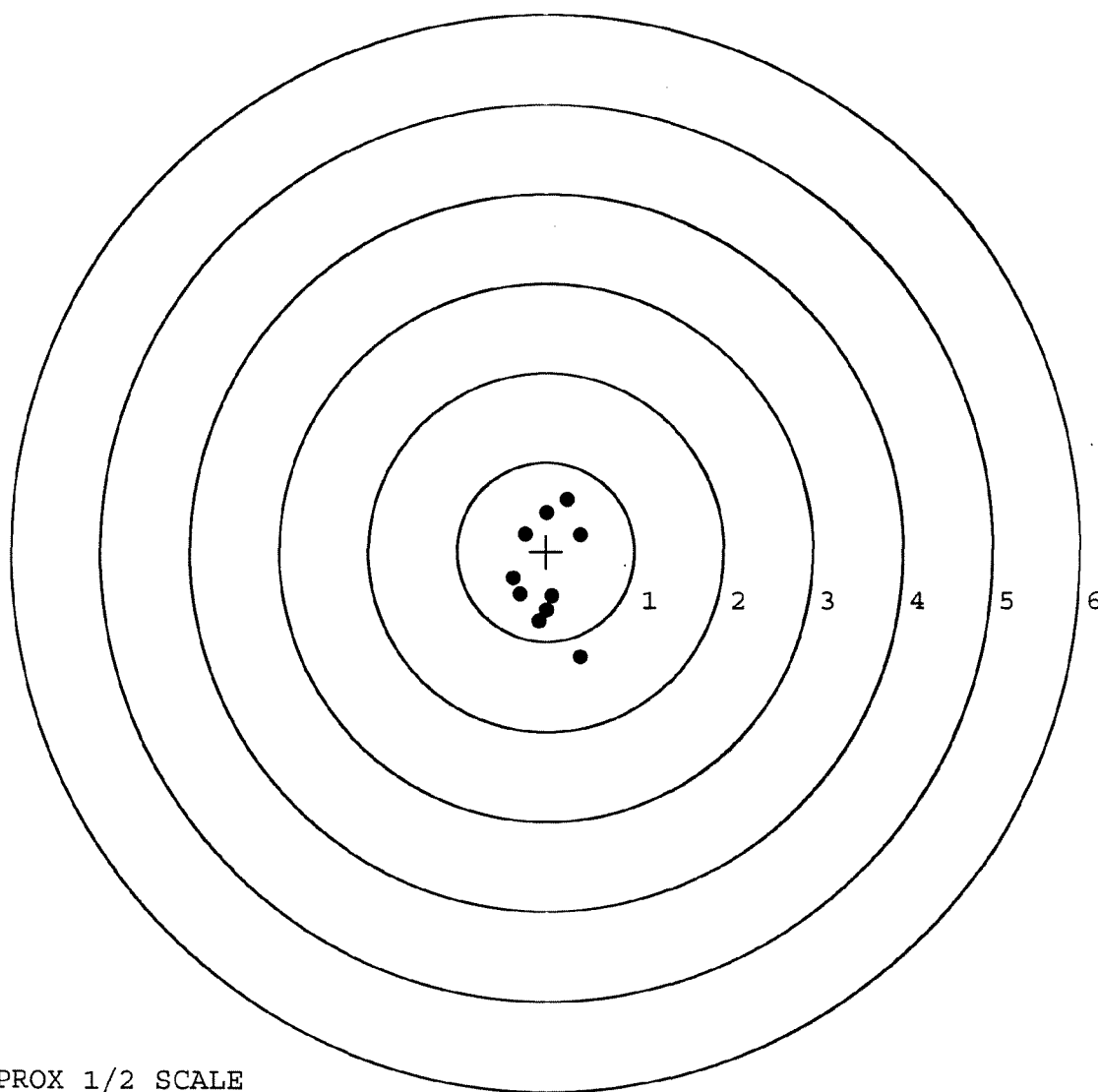


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590167. __0
TARGET NUMBER: 5
FILE DATE: 11/30/2007
FILE TIME: 12:31

X CENTROID: 0.005
Y CENTROID: -0.253
POA TO CENTROID: 0.253
HORZ SPREAD: 0.761
VERT SPREAD: 1.756
GROUP SPREAD: 1.762
MIN RADIUS: 0.254
MAX RADIUS: 0.998
MEAN RADIUS: 0.559
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.383	-1.177
2:	0.062	-0.501
3:	-0.006	-0.662
4:	-0.089	-0.782
5:	-0.295	-0.484
6:	-0.378	-0.306
7:	0.380	0.181
8:	0.234	0.579
9:	0.001	0.431
10:	-0.245	0.189



TARGET APPROX 1/2 SCALE

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 11-26-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.71		2.67	
PULL #2	2.82	2.72		2.65	
PULL #3	2.68	2.81		2.64	
PULL #4	2.70	2.86		2.50	
PULL #5	2.75	2.75		2.61	
TOTAL	13.35	13.85		13.07	
AVERAGE	2.67	2.77		2.61	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.04		
PULL #2	3.17	3.33		
PULL #3	3.15	3.38		
PULL #4	3.32	3.29		
PULL #5	3.27	3.38		
TOTAL	16.15	16.42		
AVERAGE	3.23	3.28		

	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	4.14	4.08		4.36
PULL #2	4.12	4.02		4.37
PULL #3	4.21	4.14		4.33
PULL #4	4.14	3.99		4.47
PULL #5	4.08	3.99		4.38
TOTAL	20.69	20.22		21.91
AVERAGE	4.13	4.04		4.38