

G 659 0213

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

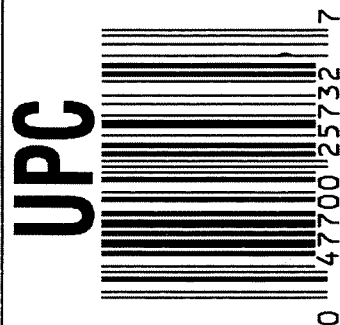
- INSTRUCTION BOOK 3518

BM FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6590213



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



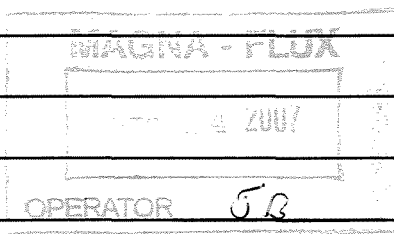
SERIAL NO.



3732

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G659 0213

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		11-7-07	RTZ
420	ASSEMBLE ACTION			
430	ASSEMBLE TO STOCK		11-12-07	TRW
440	PROOF		11-12-07	TRW
460	CHECK HEADSPACE		11-12-07	TRW
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION		11-14-07	JB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		11-13-07	CW
510	DRILL AND TAP SIGHT HOLES		11-13-07	TRW
520	GOFF BLAST BBL / REC		11-14-07	YJ
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		11/27/07	RB
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	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

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560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>55</u> <u>55</u> <u>5.75</u>	11-30-07	DA
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	11-30-07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	11-30-07	DA
	J) ASSEMBLE STOCK			11-28-07	RTZ
	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	11-30-07	TRW
	MALFUNCTION	CORRECTION	N/A		
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
	MALFUNCTION	CORRECTION			
660	INSPECT FOR LIVE AMMO			11-30-07	SPD
670	FINAL INSPECTION A) HEADSPACE			11-30-07	DA
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u> <u>2.28</u> <u>2.28</u> <u>2.31</u> <u>2.23</u>	11-30-07	DA
	C) FUNCTION				
690	PACK			11-30-07	DA

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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 11-27-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.69	2.77		2.45	
PULL #2	2.68	2.55		2.29	
PULL #3	2.34	2.66		2.51	
PULL #4	2.47	2.68		2.57	
PULL #5	2.53	2.27		2.77	
TOTAL	12.71	12.93		12.59	
AVERAGE	2.54	2.58		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.53		
PULL #2	3.16	3.43		
PULL #3	3.21	3.53		
PULL #4	3.27	3.61		
PULL #5	3.29	3.54		
TOTAL	16.10	17.64		
AVERAGE	3.22	3.52		

	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	4.60	4.18		4.10
PULL #2	4.51	4.41		4.02
PULL #3	4.50	4.42		4.12
PULL #4	4.52	4.38		4.19
PULL #5	4.52	4.48		4.24
TOTAL	22.65	21.87		20.67
AVERAGE	4.53	4.37		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590213.__0
FILE DATE AND TIME: 12/03/2007 06:49

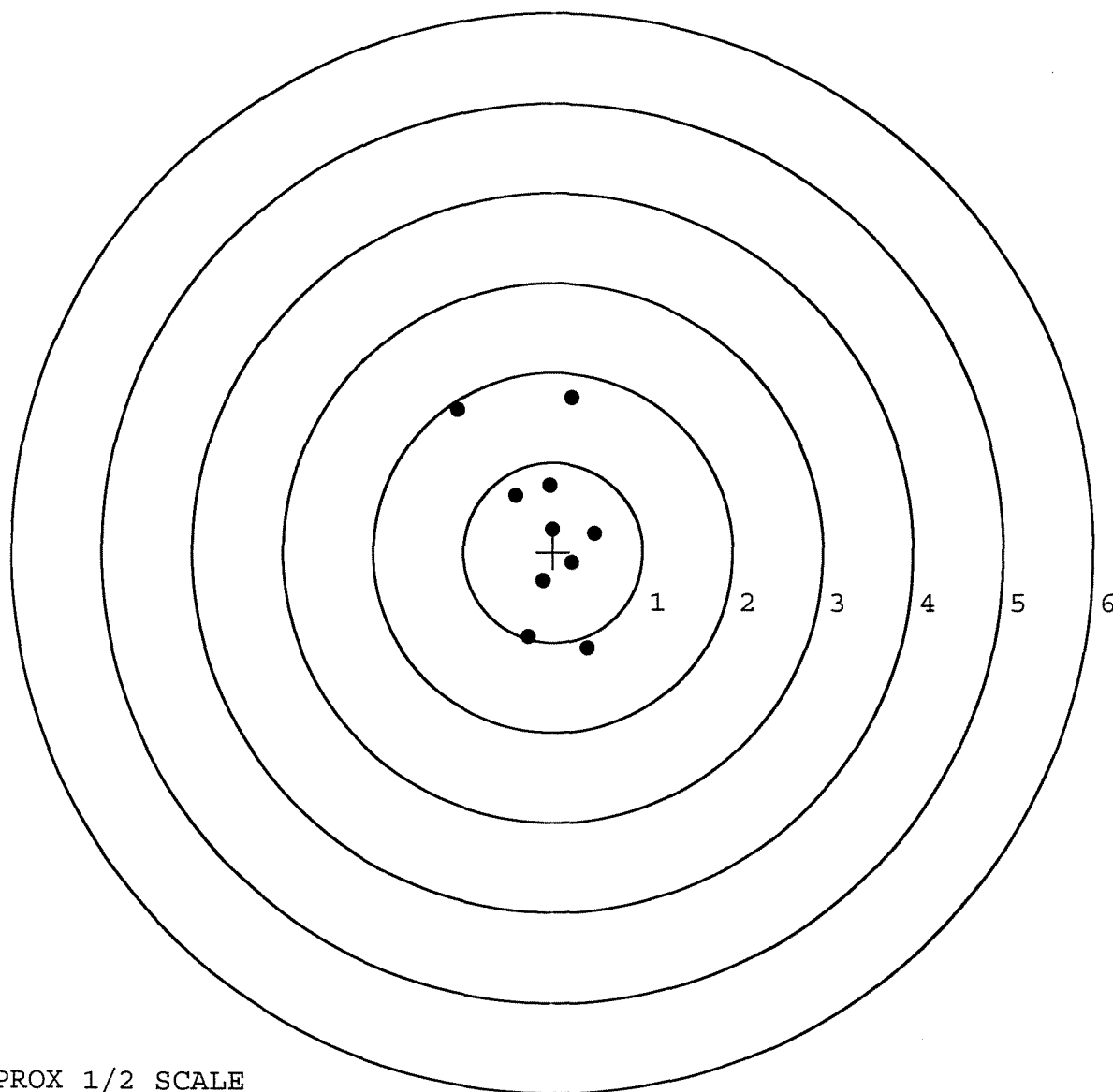
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.054
The Average Y Centroid of the Five Target Set:	0.042
The Average Point of Impact of the Five Target Set:	0.069
The Average Mean Radius of the Five Target Set:	0.626
The Distance from POA to Centroid Target #1:	0.278
The Distance from Centroid Target #2 to Centroid Target #1:	0.421
The Distance from Centroid Target #3 to Centroid Target #1:	0.228
The Distance from Centroid Target #4 to Centroid Target #1:	0.301
The Distance from Centroid Target #5 to Centroid Target #1:	0.400

SERIAL NUMBER: G6590213. __0
TARGET NUMBER: 1
FILE DATE: 12/03/2007
FILE TIME: 06:49

X CENTROID: -0.066
Y CENTROID: 0.270
POA TO CENTROID: 0.278
HORZ SPREAD: 1.528
VERT SPREAD: 2.788
GROUP SPREAD: 3.014
MIN RADIUS: 0.058
MAX RADIUS: 1.649
MEAN RADIUS: 0.841
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.380	-1.063
2:	-0.279	-0.945
3:	0.461	0.210
4:	-0.011	0.253
5:	-0.419	0.633
6:	-0.038	0.746
7:	-1.067	1.581
8:	0.210	1.725
9:	0.216	-0.118
10:	-0.112	-0.320

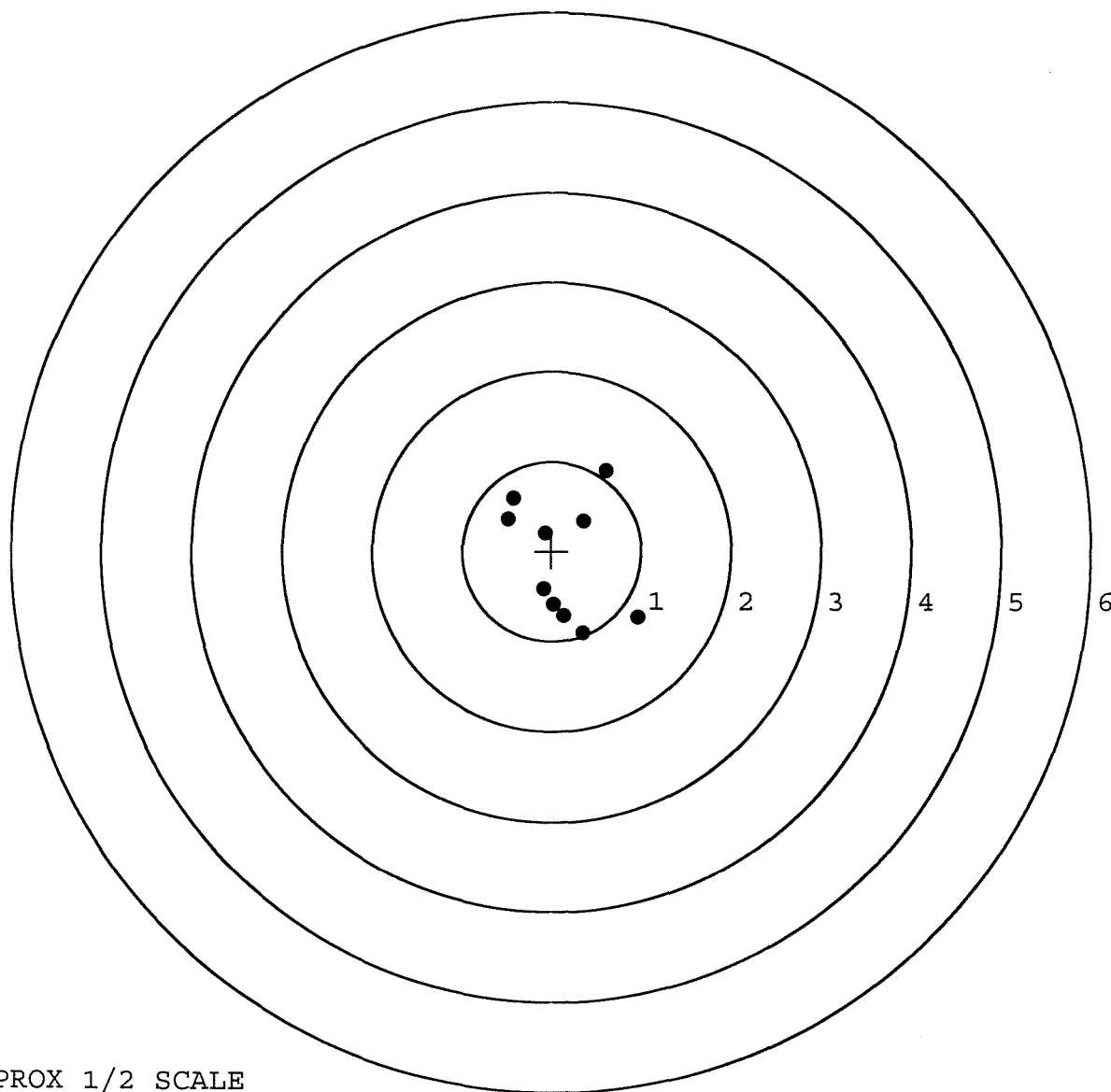


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590213. __0
TARGET NUMBER: 2
FILE DATE: 12/03/2007
FILE TIME: 06:49

X CENTROID: 0.136
Y CENTROID: -0.099
POA TO CENTROID: 0.168
HORZ SPREAD: 1.447
VERT SPREAD: 1.814
GROUP SPREAD: 1.833
MIN RADIUS: 0.368
MAX RADIUS: 1.108
MEAN RADIUS: 0.706
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.960	-0.735
2:	0.613	0.901
3:	0.356	0.342
4:	-0.071	0.205
5:	-0.430	0.597
6:	-0.487	0.360
7:	-0.091	-0.426
8:	0.021	-0.598
9:	0.137	-0.725
10:	0.353	-0.913



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590213. 0

TARGET NUMBER: 3

FILE DATE: 12/03/2007

FILE TIME: 06:49

X CENTROID: 0.133

Y CENTROID: 0.158

POA TO CENTROID: 0.207

HORZ SPREAD: 1.205

VERT SPREAD: 1.565

GROUP SPREAD: 1.654

MIN RADIUS: 0.098

MAX RADIUS: 0.933

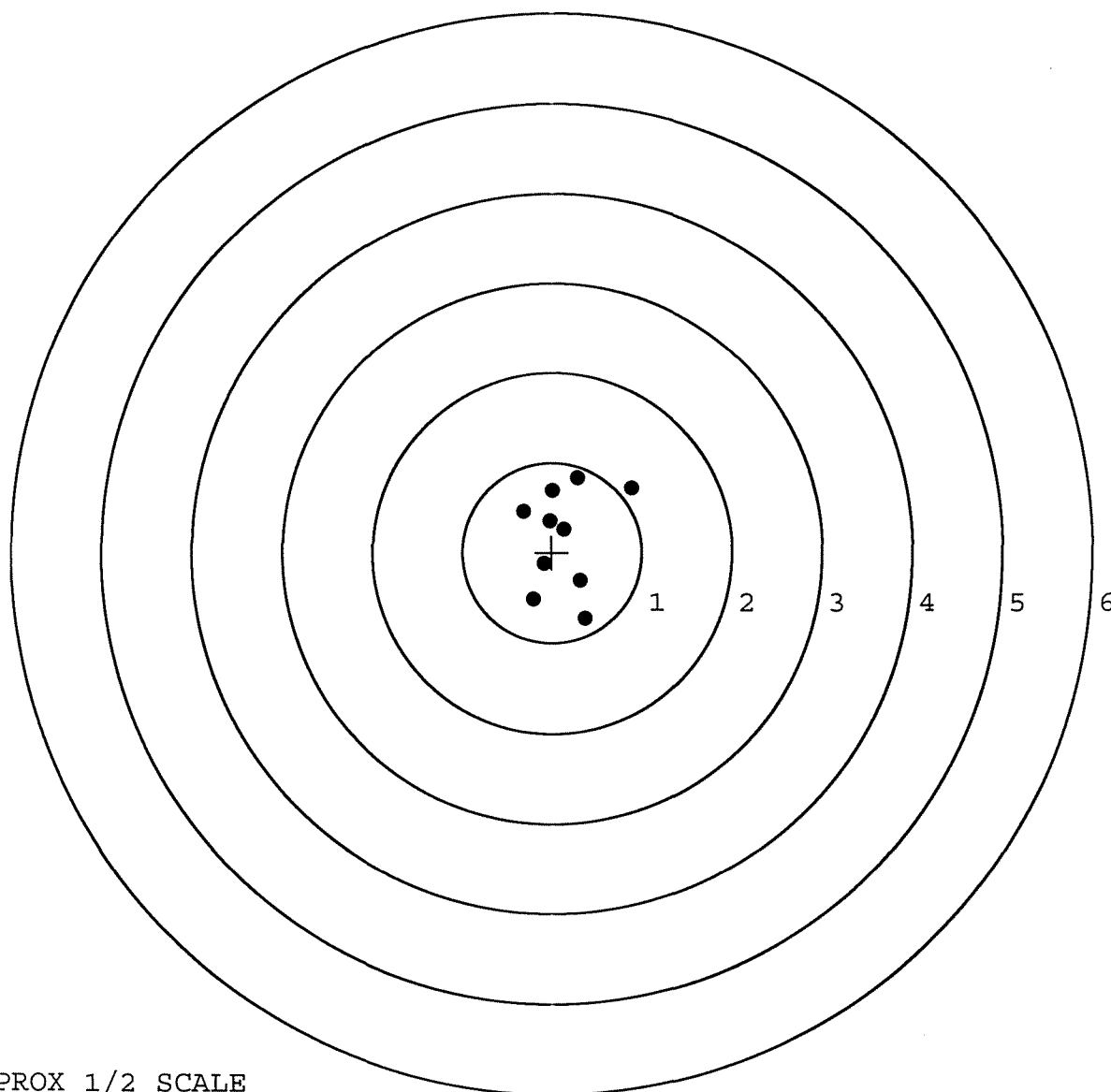
MEAN RADIUS: 0.562

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.883	0.714
2:	0.286	0.827
3:	0.373	-0.738
4:	0.314	-0.315
5:	-0.213	-0.525
6:	-0.091	-0.129
7:	0.129	0.256
8:	-0.322	0.455
9:	0.005	0.690
10:	-0.032	0.347



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590213. __0

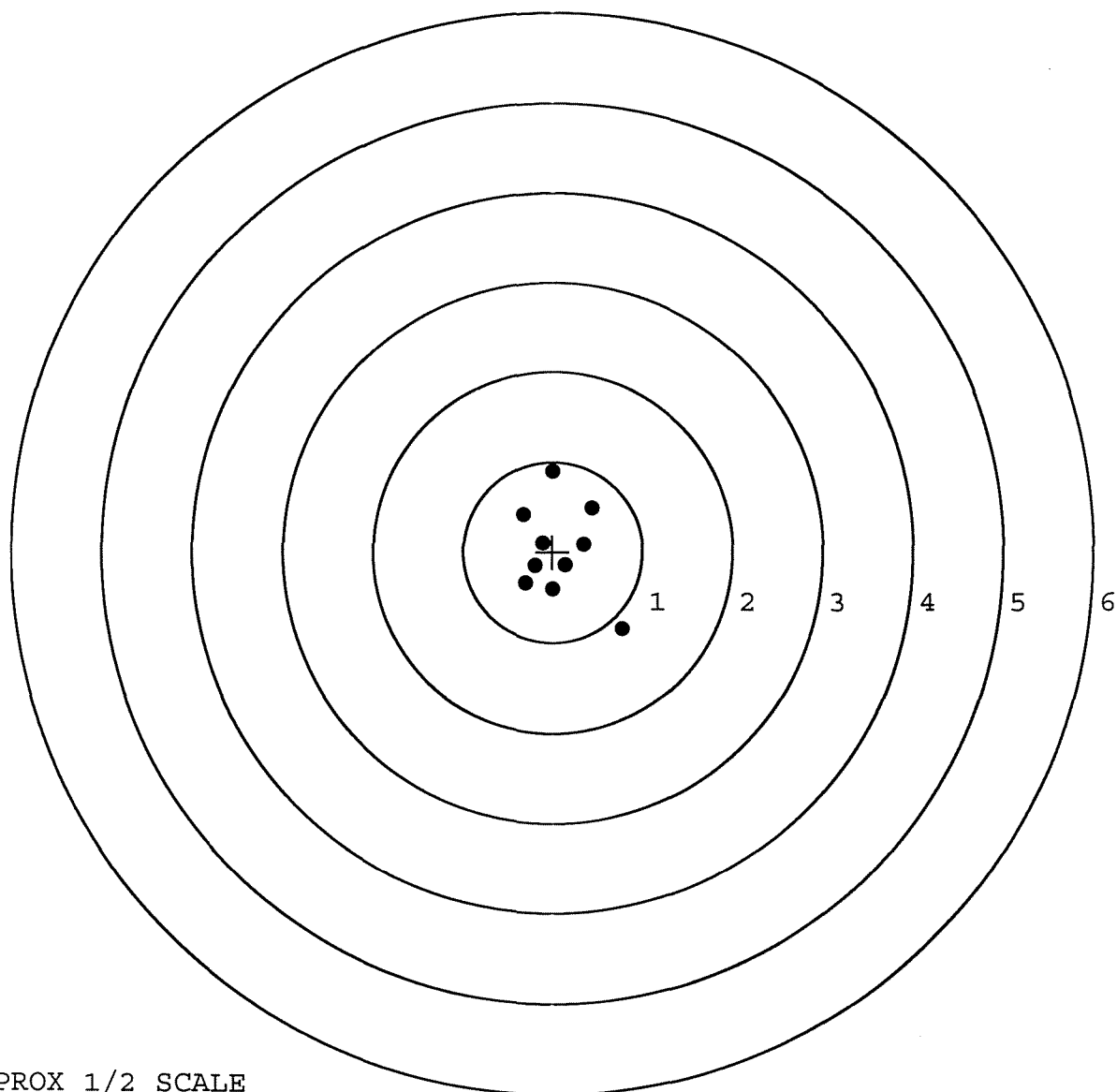
TARGET NUMBER: 4

FILE DATE: 12/03/2007

FILE TIME: 06:49

X CENTROID: 0.077
Y CENTROID: 0.006
POA TO CENTROID: 0.077
HORZ SPREAD: 1.111
VERT SPREAD: 1.748
GROUP SPREAD: 1.913
MIN RADIUS: 0.170
MAX RADIUS: 1.109
MEAN RADIUS: 0.511
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.778	-0.854
2:	0.436	0.489
3:	0.000	0.894
4:	-0.333	0.414
5:	0.353	0.085
6:	-0.111	0.099
7:	0.142	-0.151
8:	-0.198	-0.158
9:	0.002	-0.415
10:	-0.302	-0.347



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590213. 0

TARGET NUMBER: 5

FILE DATE: 12/03/2007

FILE TIME: 06:49

X CENTROID: -0.008

Y CENTROID: -0.126

POA TO CENTROID: 0.126

HORZ SPREAD: 1.353

VERT SPREAD: 1.229

GROUP SPREAD: 1.483

MIN RADIUS: 0.095

MAX RADIUS: 0.926

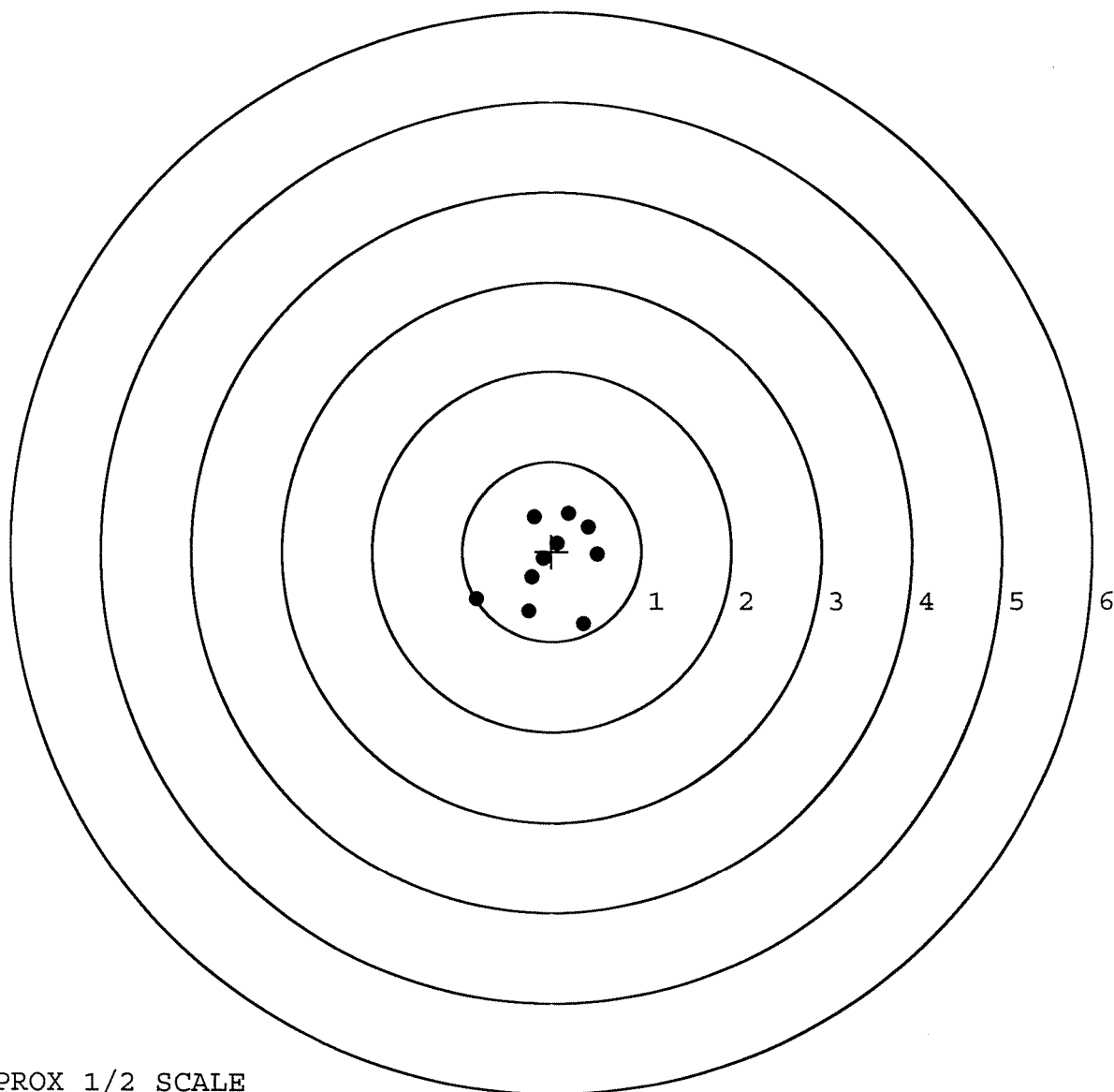
MEAN RADIUS: 0.511

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.357	-0.807
2:	-0.255	-0.669
3:	-0.843	-0.527
4:	0.510	-0.038
5:	0.407	0.271
6:	0.192	0.422
7:	-0.198	0.381
8:	0.062	0.090
9:	-0.094	-0.085
10:	-0.220	-0.293



TARGET APPROX 1/2 SCALE