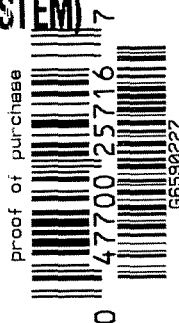


G 6590227

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

- INSTRUCTION BOOK 3518

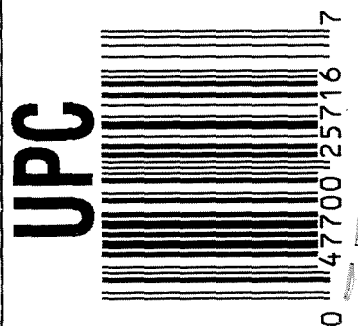


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590227



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 # G 6590227

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-20-06	RTZ
420	ASSEMBLE ACTION		9-25-06	RTZ
430	ASSEMBLE TO STOCK		9-25-06	TK
440	PROOF		9-25-06	TRLW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-25-06	TRLW
470	DIS-ASSEMBLE ACTION	SEP 26 2006	9-25-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>Ummid</u>	9/26/06	Ummid
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-27-06	CW
510	DRILL AND TAP SIGHT HOLES		9-26-06	TRLW
520	GOFF BLAST BBL / REC		9-28-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/29/06	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-2-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-2-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-2-06	DA
	D) OIL FIRING PIN ASSEMBLY		10-3-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/4/06	MTM

F004 REV 5/2006

OP #	OPERATION NAME	READING	DATE	INITIALS
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>50</u> <u>50</u> <u>50</u>	10-5-06	BA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	10-5-06	BA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/9/06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.027</u>	10-5-06	SD
	J) ASSEMBLE STOCK		10-3-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		10/9/06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-3-06	RTZ
	M) IRON SIGHT ALIGNMENT		10-3-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-3-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-4-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/4/06	
670	FINAL INSPECTION A) HEADSPACE		10/9/06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.39</u> <u>2.20</u> <u>2.20</u> <u>2.20</u> <u>2.15</u>	10-5-06	BA
	C) FUNCTION		10/9/06	MTM
690	PACK		11/7/06	BA

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 10/2/06TESTER moh

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.43	2.62		2.53	
PULL #2	2.56	2.46		2.63	
PULL #3	2.57	2.70		2.46	
PULL #4	2.59	2.56		2.36	
PULL #5	2.53	2.53		2.26	
TOTAL	12.68	12.87		12.24	
AVERAGE	2.54	2.57		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.89	2.93		
PULL #2	2.86	2.83		
PULL #3	3.02	3.09		
PULL #4	2.96	2.93		
PULL #5	3.15	2.90		
TOTAL	14.88	14.68		
AVERAGE	2.98	2.94		

	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	4.02	3.79		4.18
PULL #2	4.10	3.74		4.09
PULL #3	4.22	3.75		4.14
PULL #4	4.09	3.82		4.27
PULL #5	4.17	3.78		4.22
TOTAL	20.60	18.88		20.90
AVERAGE	4.12	3.78		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590227.___0

FILE DATE AND TIME: 10/05/2006 05:35

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.004
The Average Y Centroid of the Five Target Set:	-0.117
The Average Point of Impact of the Five Target Set:	0.117
The Average Mean Radius of the Five Target Set:	0.770
The Distance from POA to Centroid Target #1:	0.035
The Distance from Centroid Target #2 to Centroid Target #1:	0.213
The Distance from Centroid Target #3 to Centroid Target #1:	0.432
The Distance from Centroid Target #4 to Centroid Target #1:	0.068
The Distance from Centroid Target #5 to Centroid Target #1:	0.141

SERIAL NUMBER: G6590227. __0

TARGET NUMBER: 1

FILE DATE: 10/05/2006

FILE TIME: 05:35

POINT#	X	Y
1:	0.957	-0.596
2:	1.256	0.335
3:	-0.223	0.767
4:	-0.569	0.769
5:	-0.606	0.448
6:	-0.838	-0.459
7:	-0.230	-0.215
8:	0.067	-0.537
9:	0.216	-0.286
10:	0.254	-0.026

X CENTROID: 0.028

Y CENTROID: 0.020

POA TO CENTROID: 0.035

HORZ SPREAD: 2.094

VERT SPREAD: 1.365

GROUP SPREAD: 2.239

MIN RADIUS: 0.230

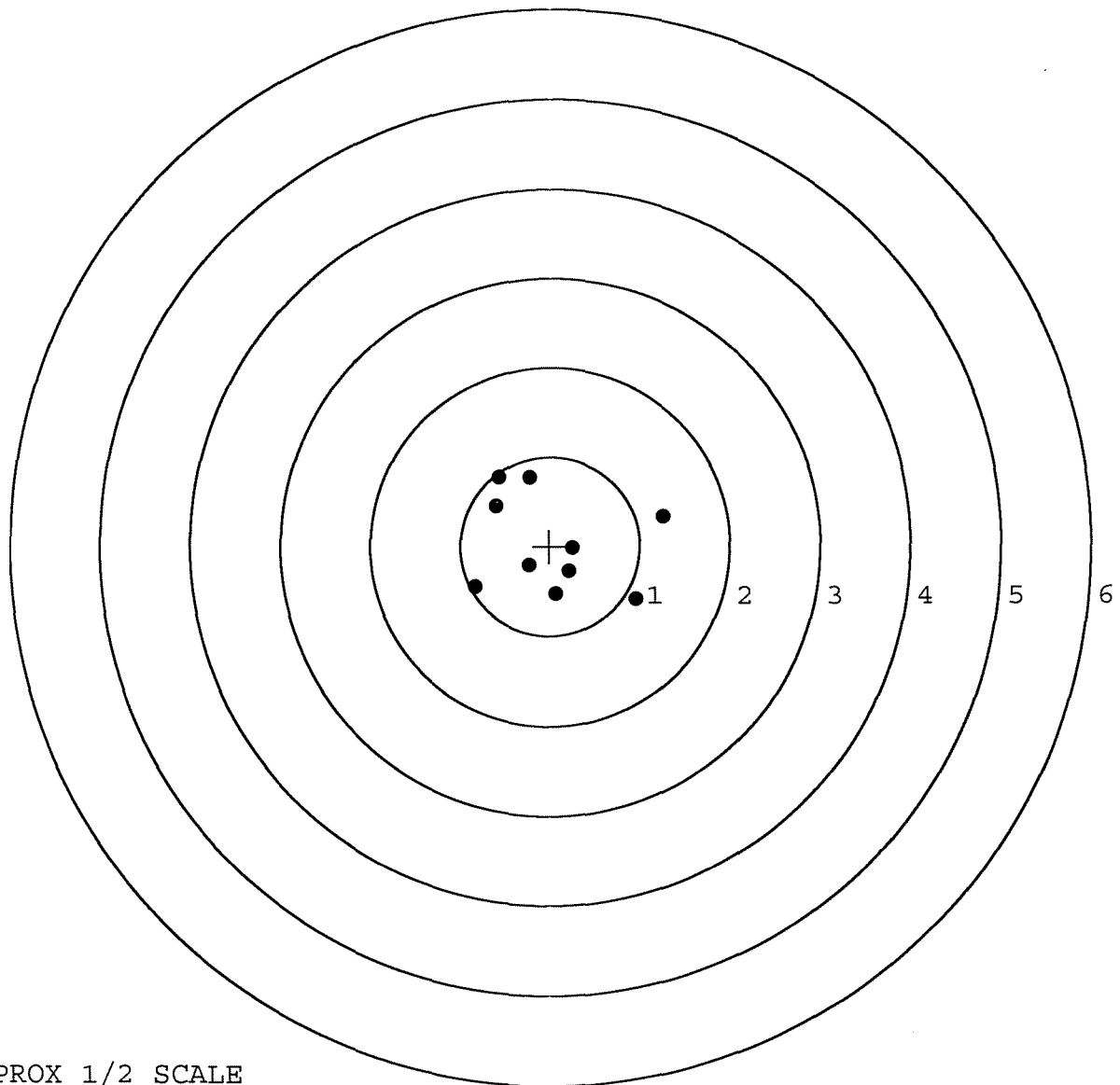
MAX RADIUS: 1.267

MEAN RADIUS: 0.738

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590227. __0

TARGET NUMBER: 2

FILE DATE: 10/05/2006

FILE TIME: 05:35

X CENTROID: -0.049

Y CENTROID: -0.179

POA TO CENTROID: 0.185

HORZ SPREAD: 1.831

VERT SPREAD: 1.699

GROUP SPREAD: 2.205

MIN RADIUS: 0.210

MAX RADIUS: 1.169

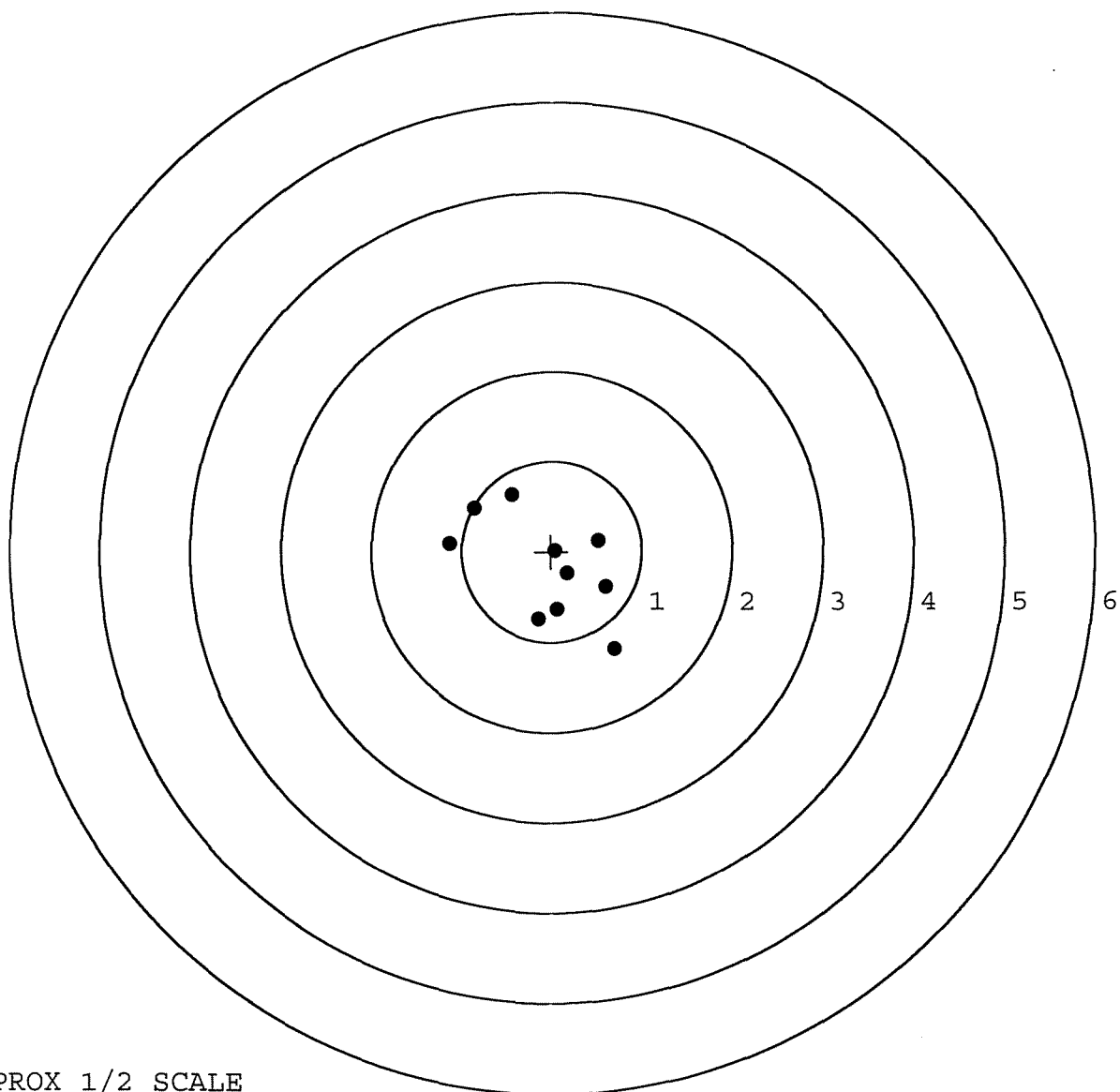
MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.446	0.622
2:	-0.863	0.479
3:	-1.131	0.087
4:	0.700	-1.077
5:	-0.147	-0.751
6:	0.065	-0.646
7:	0.600	-0.393
8:	0.517	0.125
9:	0.174	-0.240
10:	0.045	0.009



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590227. 0

TARGET NUMBER: 3

FILE DATE: 10/05/2006

FILE TIME: 05:35

X CENTROID: -0.102

Y CENTROID: -0.392

POA TO CENTROID: 0.405

HORZ SPREAD: 1.302

VERT SPREAD: 2.661

GROUP SPREAD: 2.716

MIN RADIUS: 0.272

MAX RADIUS: 1.703

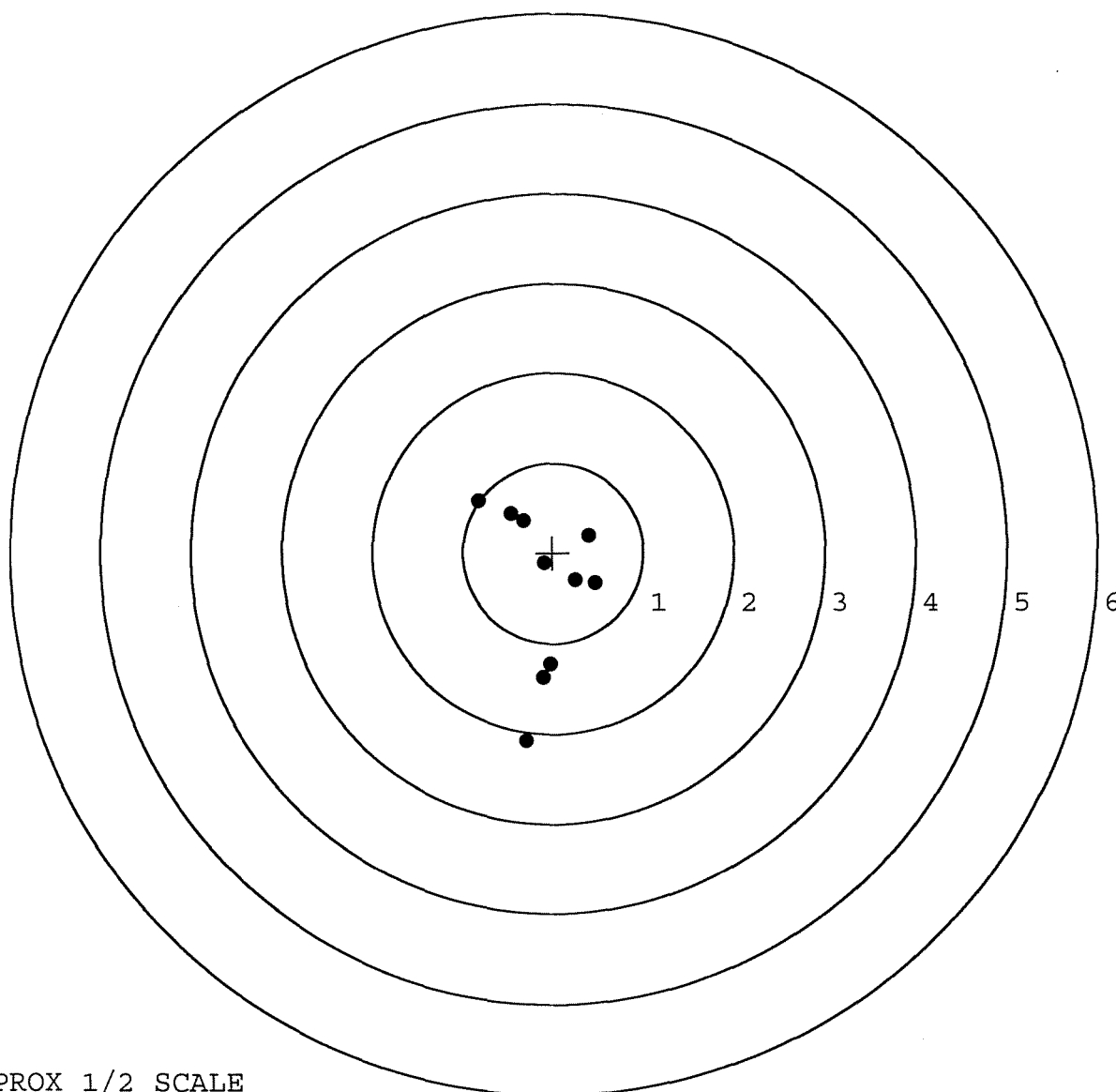
MEAN RADIUS: 0.842

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.287	-2.085
2:	-0.829	0.576
3:	-0.473	0.435
4:	-0.327	0.356
5:	0.398	0.193
6:	0.473	-0.346
7:	0.247	-0.308
8:	-0.094	-0.120
9:	-0.024	-1.237
10:	-0.105	-1.386



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590227. 0

TARGET NUMBER: 4

FILE DATE: 10/05/2006

FILE TIME: 05:35

X CENTROID: -0.037

Y CENTROID: 0.037

POA TO CENTROID: 0.052

HORZ SPREAD: 2.222

VERT SPREAD: 1.722

GROUP SPREAD: 2.757

MIN RADIUS: 0.270

MAX RADIUS: 1.455

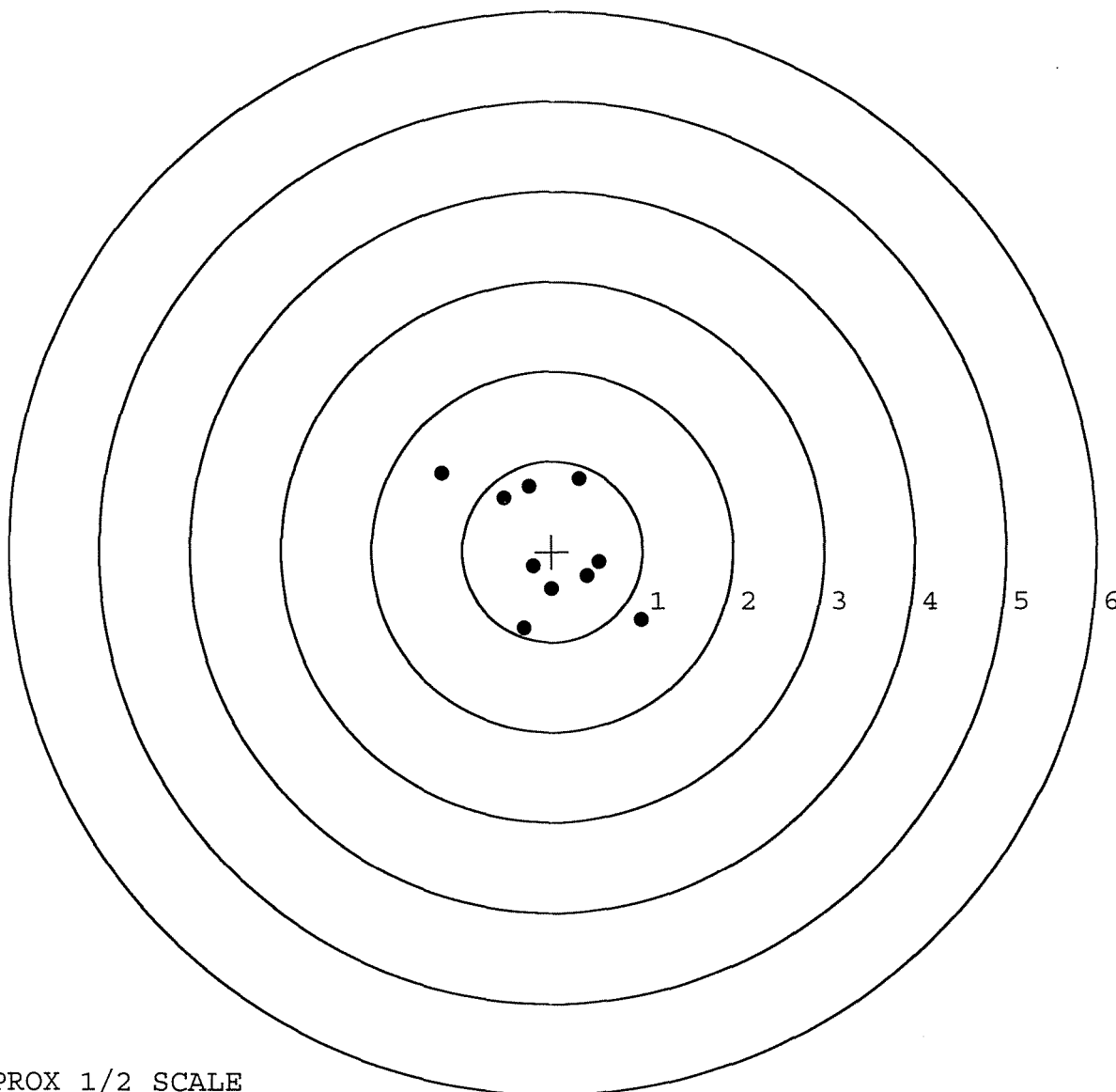
MEAN RADIUS: 0.782

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.233	0.866
2:	-0.538	0.591
3:	-0.259	0.715
4:	0.294	0.805
5:	0.989	-0.766
6:	0.522	-0.120
7:	0.387	-0.278
8:	-0.012	-0.418
9:	-0.210	-0.170
10:	-0.310	-0.856



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590227.___0

TARGET NUMBER: 5

FILE DATE: 10/05/2006

FILE TIME: 05:35

X CENTROID: 0.137

Y CENTROID: -0.069

POA TO CENTROID: 0.154

HORZ SPREAD: 1.842

VERT SPREAD: 2.047

GROUP SPREAD: 2.111

MIN RADIUS: 0.409

MAX RADIUS: 1.225

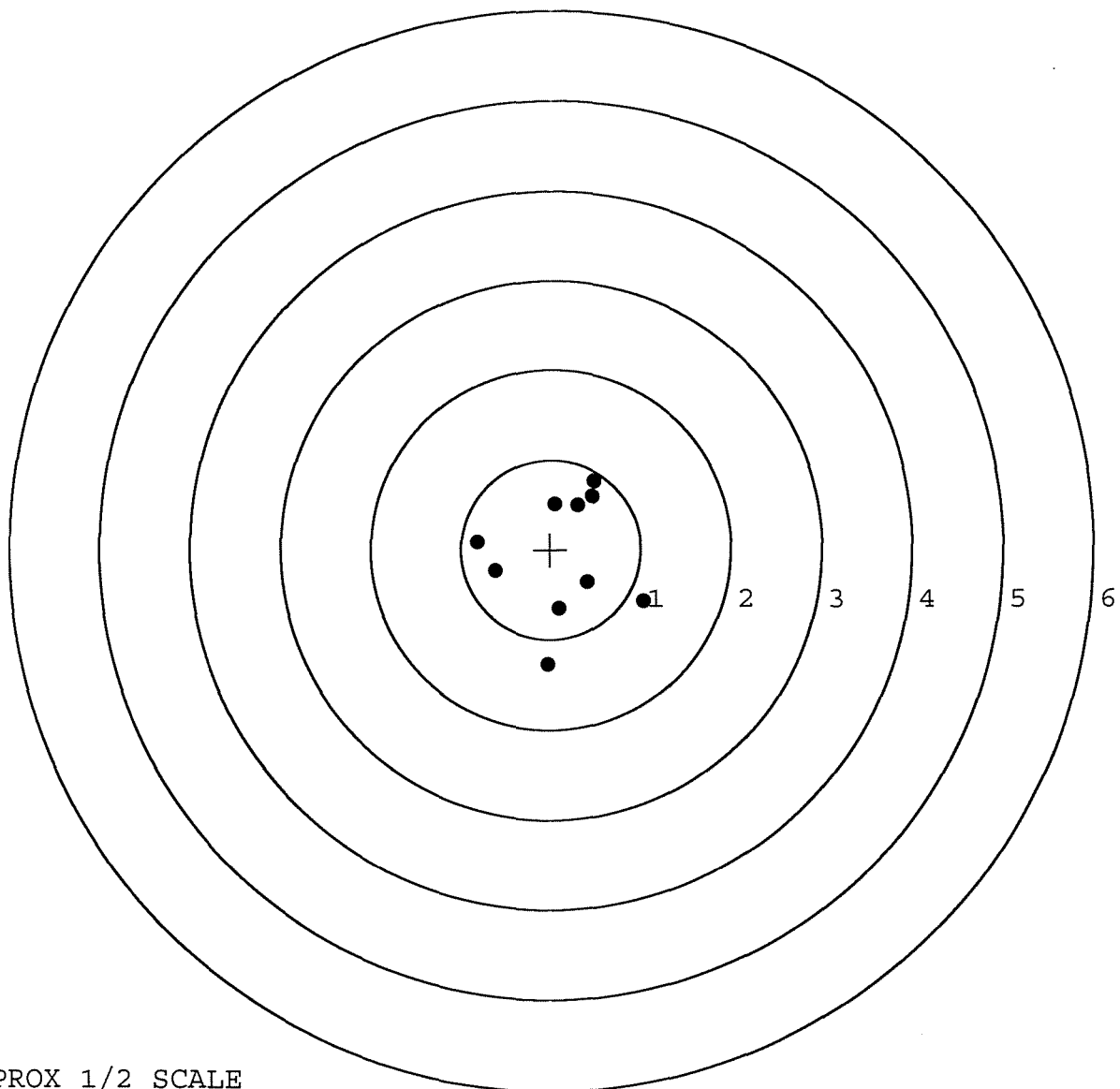
MEAN RADIUS: 0.782

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.031	-1.282
2:	0.099	-0.663
3:	0.411	-0.373
4:	1.027	-0.582
5:	-0.619	-0.244
6:	-0.815	0.084
7:	0.485	0.765
8:	0.463	0.600
9:	0.301	0.496
10:	0.052	0.509



TARGET APPROX 1/2 SCALE