

G-6591570

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

- INSTRUCTION BOOK 3518

DD FORM



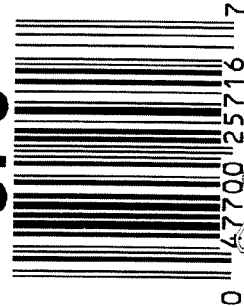
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591570

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6591570

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-16-06	RTZ
420	ASSEMBLE ACTION		8-16-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		8-16-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-16-06	L.P.D.
470	DIS-ASSEMBLE ACTION	AUG 17 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <u>curab</u>	8/17/06	curab
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-17-06	mw
520	GOFF BLAST BBL / REC		8-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/24/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-5-06	BLG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-5-06	BLG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-5-06	BLG
	D) OIL FIRING PIN ASSEMBLY		9-5-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10-11-06	SD

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.2</u> <u>6.2</u> <u>6.2</u>	9-7-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	9-7-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		10-11-06	SD
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	9-6-06	RA
	J) ASSEMBLE STOCK		9-5-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10-11-06	SD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-5-06	BLC
	M) IRON SIGHT ALIGNMENT		9-5-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-5-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-5-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-5-06	BD
670	FINAL INSPECTION A) HEADSPACE		10-11-06	SD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.37</u> <u>2.31</u> <u>2.41</u> <u>2.29</u>	9-7-06	RA
	C) FUNCTION		10-11-06	SD
690	PACK		10-31-06	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 9-5-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.56	2.33		2.39	
PULL #2	2.39	2.36		2.40	
PULL #3	2.39	2.31		2.43	
PULL #4	2.44	2.30		2.59	
PULL #5	2.45	2.30		2.46	
TOTAL	12.23	11.60		12.27	
AVERAGE	2.44	2.32		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.08		
PULL #2	3.18	3.09		
PULL #3	3.08	3.09		
PULL #4	3.10	3.06		
PULL #5	3.06	3.09		
TOTAL	15.52	15.41		
AVERAGE	3.10	3.08		

	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	4.08	4.09		4.26
PULL #2	4.08	4.01		4.05
PULL #3	4.07	4.02		4.07
PULL #4	4.09	4.03		4.09
PULL #5	4.10	4.03		4.08
TOTAL	20.42	20.18		20.55
AVERAGE	4.08	4.03		4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591570.___0
FILE DATE AND TIME: 09/05/2006 15:44

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.042
The Average Y Centroid of the Five Target Set:	-0.022
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.699
The Distance from POA to Centroid Target #1:	0.108
The Distance from Centroid Target #2 to Centroid Target #1:	0.310
The Distance from Centroid Target #3 to Centroid Target #1:	0.053
The Distance from Centroid Target #4 to Centroid Target #1:	0.105
The Distance from Centroid Target #5 to Centroid Target #1:	0.336

SERIAL NUMBER: G6591570. __0

TARGET NUMBER: 1

FILE DATE: 09/05/2006

FILE TIME: 15:44

POINT#	X	Y
1:	-0.122	1.394
2:	-0.071	1.749
3:	0.286	1.179
4:	0.247	0.680
5:	0.495	0.043
6:	0.823	-1.176
7:	-0.330	-0.462
8:	-0.369	-0.596
9:	-0.896	-1.117
10:	-0.450	-0.685

X CENTROID: -0.039

Y CENTROID: 0.101

POA TO CENTROID: 0.108

HORZ SPREAD: 1.719

VERT SPREAD: 2.925

GROUP SPREAD: 3.059

MIN RADIUS: 0.537

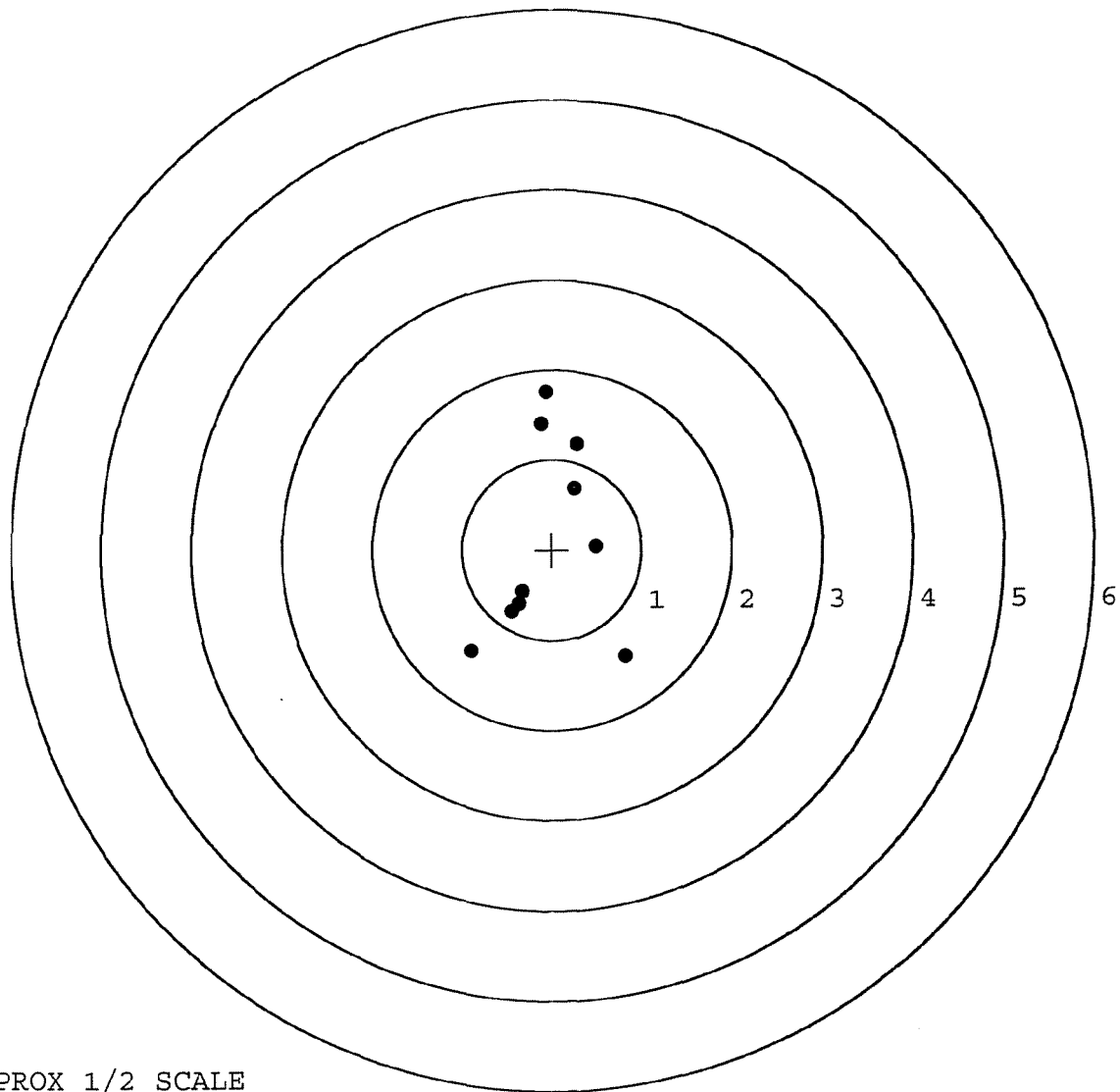
MAX RADIUS: 1.648

MEAN RADIUS: 1.057

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



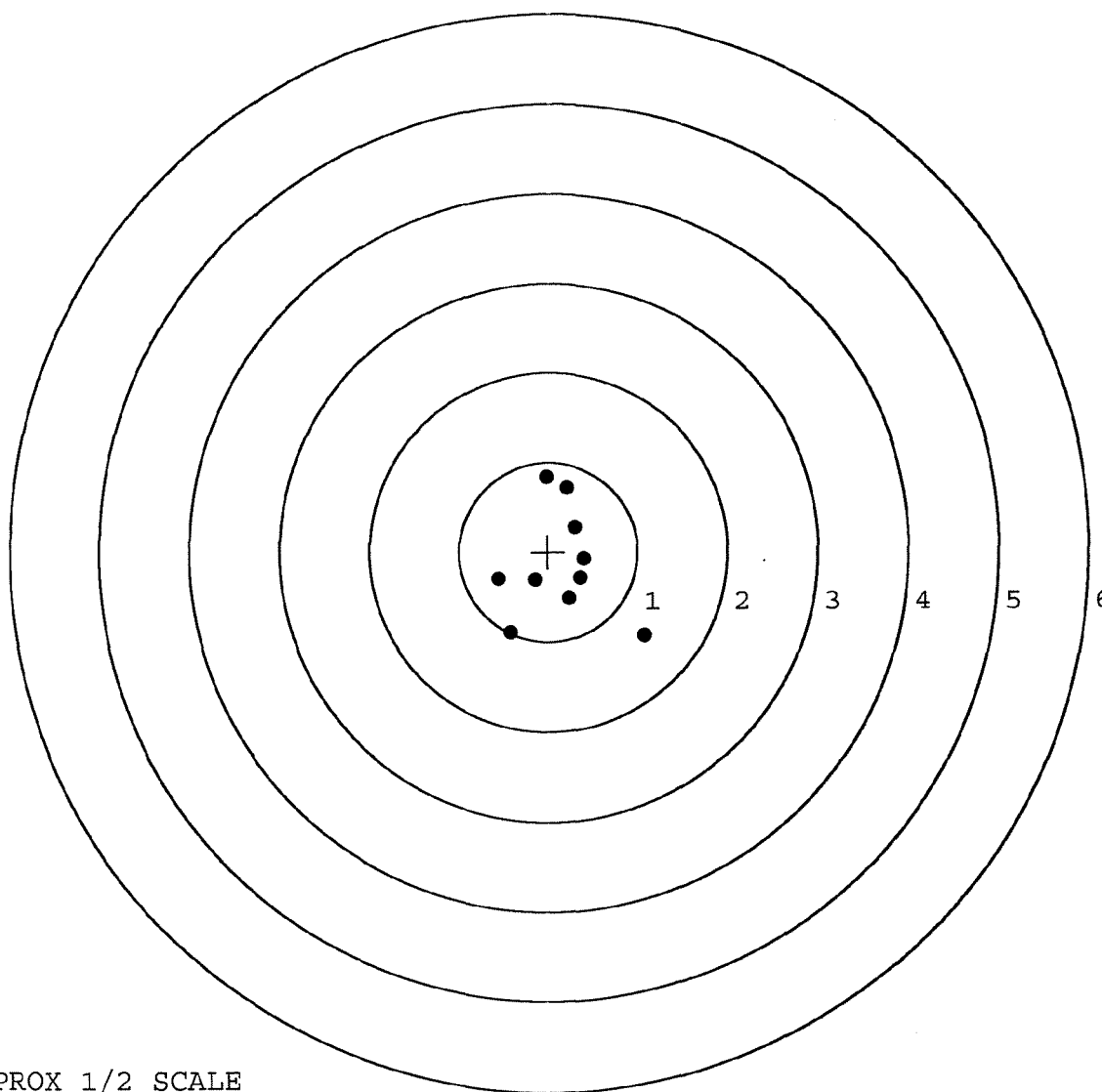
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591570. __0
TARGET NUMBER: 2
FILE DATE: 09/05/2006
FILE TIME: 15:44

X CENTROID: 0.144
Y CENTROID: -0.150
POA TO CENTROID: 0.208
HORZ SPREAD: 1.636
VERT SPREAD: 1.778
GROUP SPREAD: 2.092
MIN RADIUS: 0.261
MAX RADIUS: 1.222
MEAN RADIUS: 0.646

POINT#	X	Y
1:	-0.025	0.840
2:	0.212	0.719
3:	0.295	0.283
4:	0.401	-0.075
5:	0.365	-0.289
6:	0.236	-0.522
7:	-0.142	-0.314
8:	-0.559	-0.302
9:	-0.424	-0.901
10:	1.077	-0.938

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

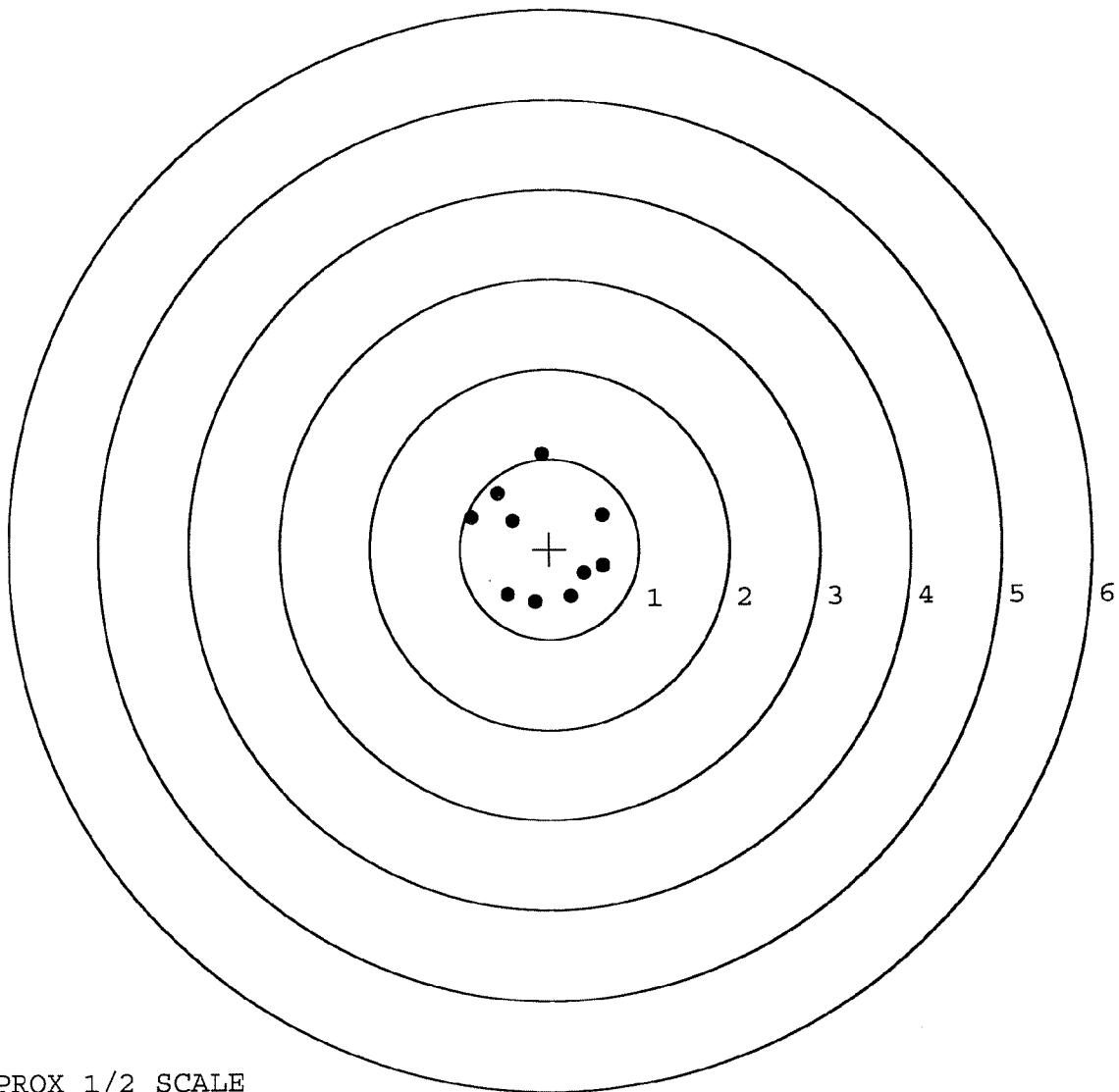


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591570. __0
TARGET NUMBER: 3
FILE DATE: 09/05/2006
FILE TIME: 15:44

POINT#	X	Y
1:	-0.086	1.054
2:	0.588	0.376
3:	0.598	-0.188
4:	0.380	-0.269
5:	0.239	-0.531
6:	-0.163	-0.592
7:	-0.470	-0.512
8:	-0.413	0.316
9:	-0.574	0.626
10:	-0.868	0.357

X CENTROID: -0.077
Y CENTROID: 0.064
POA TO CENTROID: 0.100
HORZ SPREAD: 1.466
VERT SPREAD: 1.646
GROUP SPREAD: 1.648
MIN RADIUS: 0.420
MAX RADIUS: 0.990
MEAN RADIUS: 0.706
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

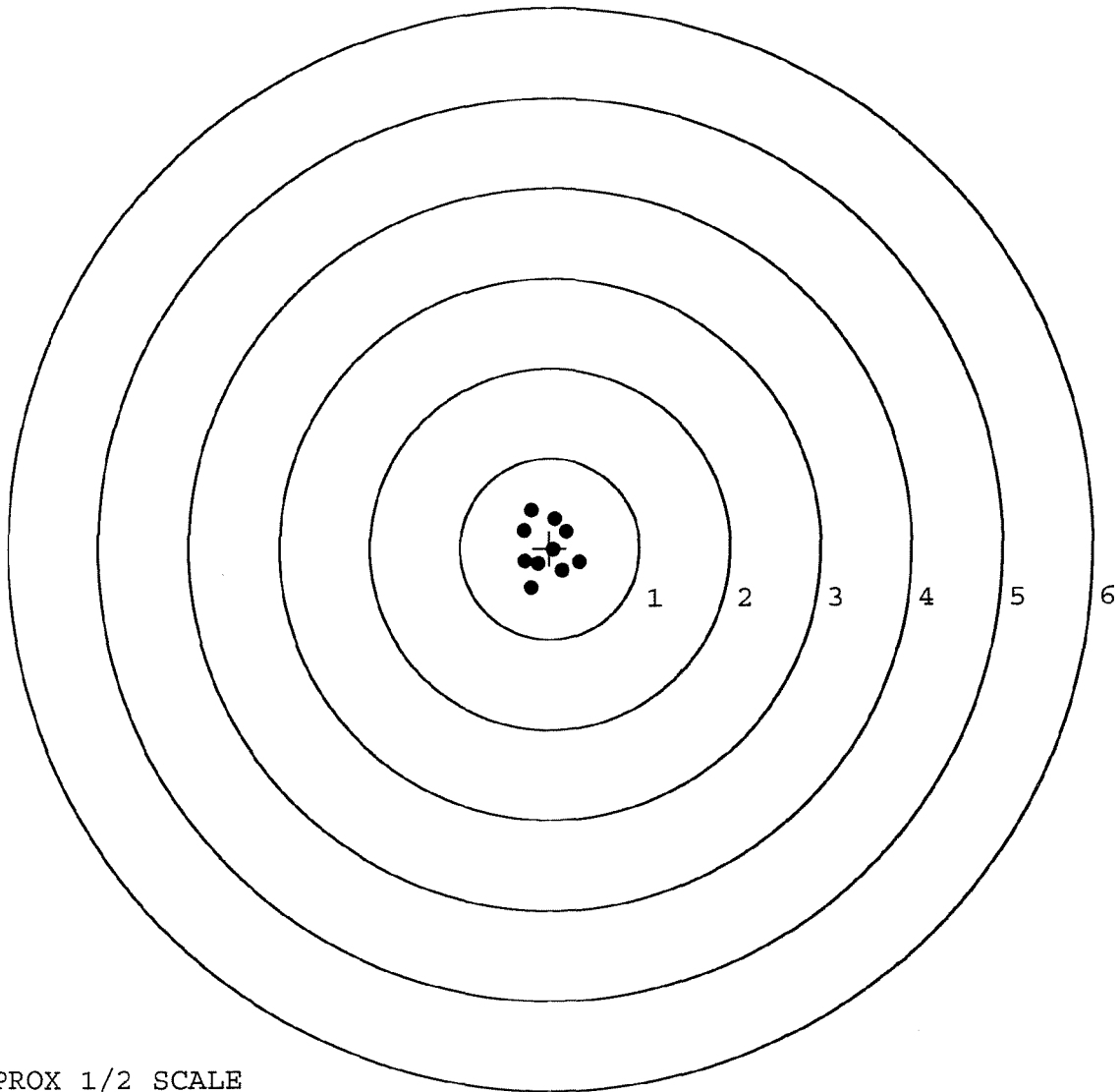


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591570. __0
TARGET NUMBER: 4
FILE DATE: 09/05/2006
FILE TIME: 15:44

X CENTROID: -0.036
Y CENTROID: -0.005
POA TO CENTROID: 0.036
HORZ SPREAD: 0.624
VERT SPREAD: 0.852
GROUP SPREAD: 0.852
MIN RADIUS: 0.078
MAX RADIUS: 0.464
MEAN RADIUS: 0.312
IN 1 IN DIAMETER: 10
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.211	0.417
2:	0.057	0.323
3:	0.182	0.183
4:	0.335	-0.147
5:	0.145	-0.248
6:	-0.208	-0.435
7:	-0.277	-0.146
8:	-0.289	0.195
9:	0.041	-0.019
10:	-0.133	-0.168

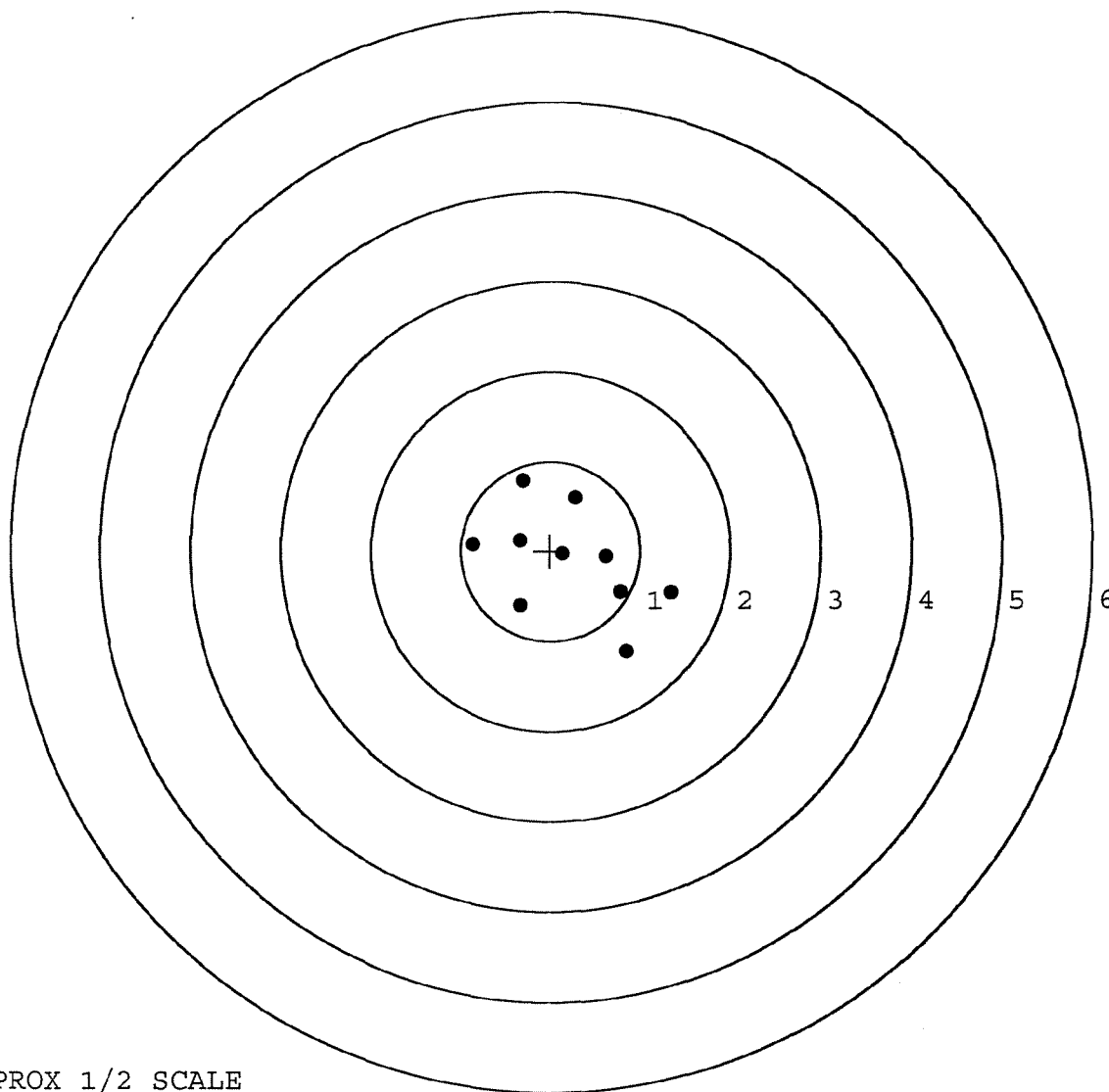


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591570. __0
TARGET NUMBER: 5
FILE DATE: 09/05/2006
FILE TIME: 15:44

X CENTROID: 0.216
Y CENTROID: -0.118
POA TO CENTROID: 0.246
HORZ SPREAD: 2.204
VERT SPREAD: 1.912
GROUP SPREAD: 2.242
MIN RADIUS: 0.112
MAX RADIUS: 1.190
MEAN RADIUS: 0.775
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.312	0.792
2:	0.275	0.594
3:	-0.863	0.074
4:	-0.336	0.114
5:	0.135	-0.040
6:	0.620	-0.061
7:	0.780	-0.459
8:	1.341	-0.468
9:	0.858	-1.120
10:	-0.340	-0.607



TARGET APPROX 1/2 SCALE