

G-6591581

ORDER 25716

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

UPC



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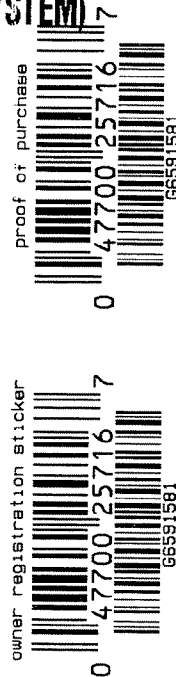
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

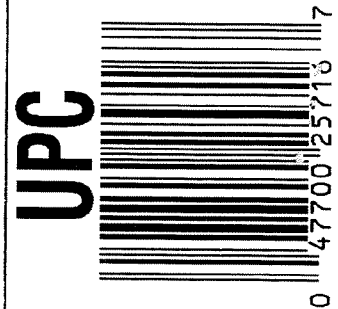


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6591581



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591581

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-12-06	RTZ
420	ASSEMBLE ACTION		9-20-06	RTZ
430	ASSEMBLE TO STOCK		9-21-06	RP
440	PROOF		9-21-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-21-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 22 2006	9-21-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	9-22-06	CPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-22-06	CW
510	DRILL AND TAP SIGHT HOLES		9-21-06	TRW
520	GOFF BLAST BBL / REC		9-22-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/25	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/26/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/26/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/26/06	DA
	D) OIL FIRING PIN ASSEMBLY		9-26-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/16/06	W

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁵</u> <u>7⁰</u> <u>7⁵</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5²</u> <u>5²</u> <u>5⁵</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/06	non
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-26-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		10/16/06	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-26-06	RTZ
	M) IRON SIGHT ALIGNMENT		9-26-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-26-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-26-06	H.P.H.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/26/06	MGD
670	FINAL INSPECTION A) HEADSPACE		10/16/06	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.87</u> <u>2.84</u> <u>2.58</u> <u>2.58</u>	9/27/06	RA
	C) FUNCTION		10/16/06	non
690	PACK		11/7/06	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 9-25-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.52	2.52		2.40	
PULL #2	2.52	2.40		2.44	
PULL #3	2.50	2.41		2.36	
PULL #4	2.50	2.44		2.49	
PULL #5	2.46	2.41		2.52	
TOTAL	12.50	12.18		12.21	
AVERAGE	2.50	2.43		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	310	296		
PULL #2	318	300		
PULL #3	300	309		
PULL #4	307	305		
PULL #5	295	306		
TOTAL	1530	1516		
AVERAGE	306	303		

	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	4.04		4.13
PULL #2	3.99	4.09		4.08
PULL #3	4.01	3.96		4.11
PULL #4	4.07	4.02		4.10
PULL #5	4.02	4.02		4.08
TOTAL	20.11	20.13		20.50
AVERAGE	4.02	4.02		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591581.__0
FILE DATE AND TIME: 09/27/2006 05:28

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.019
The Average Y Centroid of the Five Target Set:	0.004
The Average Point of Impact of the Five Target Set:	0.020
The Average Mean Radius of the Five Target Set:	0.711
The Distance from POA to Centroid Target #1:	0.055
The Distance from Centroid Target #2 to Centroid Target #1:	0.039
The Distance from Centroid Target #3 to Centroid Target #1:	0.034
The Distance from Centroid Target #4 to Centroid Target #1:	0.179
The Distance from Centroid Target #5 to Centroid Target #1:	0.063

SERIAL NUMBER: G6591581. __ 0

TARGET NUMBER: 1

FILE DATE: 09/27/2006

FILE TIME: 05:28

POINT#	X	Y
1:	-0.386	1.144
2:	-0.514	0.452
3:	-0.375	0.164
4:	0.087	0.185
5:	0.848	0.350
6:	0.642	-0.463
7:	-0.570	-0.650
8:	0.286	-0.242
9:	-0.046	-0.197
10:	-0.278	-0.290

X CENTROID: -0.031

Y CENTROID: 0.045

POA TO CENTROID: 0.055

HORZ SPREAD: 1.418

VERT SPREAD: 1.794

GROUP SPREAD: 1.908

MIN RADIUS: 0.183

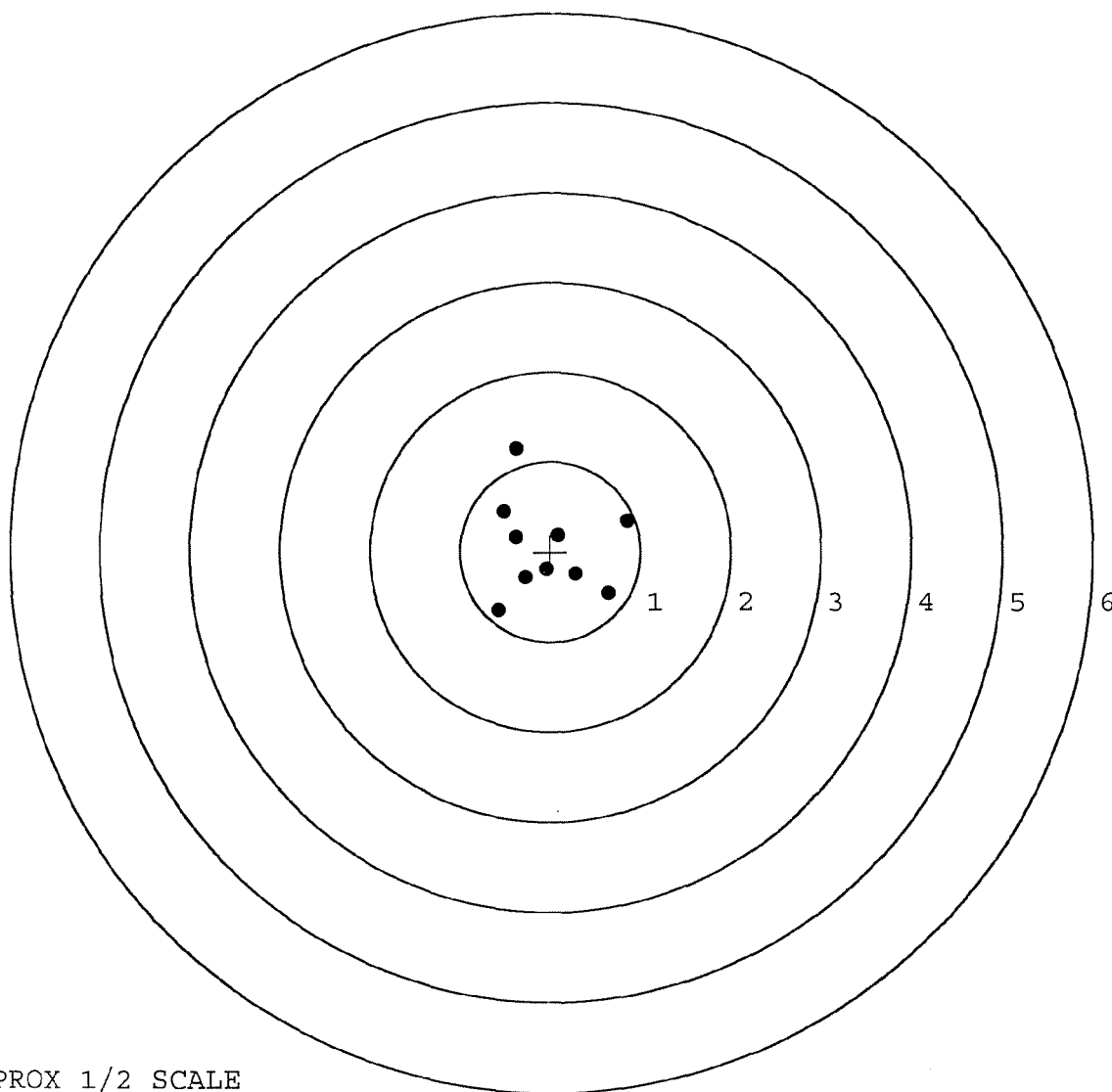
MAX RADIUS: 1.155

MEAN RADIUS: 0.607

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591581. __0

TARGET NUMBER: 2

FILE DATE: 09/27/2006

FILE TIME: 05:28

POINT#	X	Y
1:	1.044	0.156
2:	0.602	0.151
3:	0.149	-0.838
4:	-0.162	-1.099
5:	-0.193	-0.377
6:	-1.308	-0.237
7:	-0.844	1.059
8:	0.210	0.698
9:	0.150	0.330
10:	-0.244	0.343

X CENTROID: -0.060

Y CENTROID: 0.019

POA TO CENTROID: 0.062

HORZ SPREAD: 2.352

VERT SPREAD: 2.158

GROUP SPREAD: 2.263

MIN RADIUS: 0.373

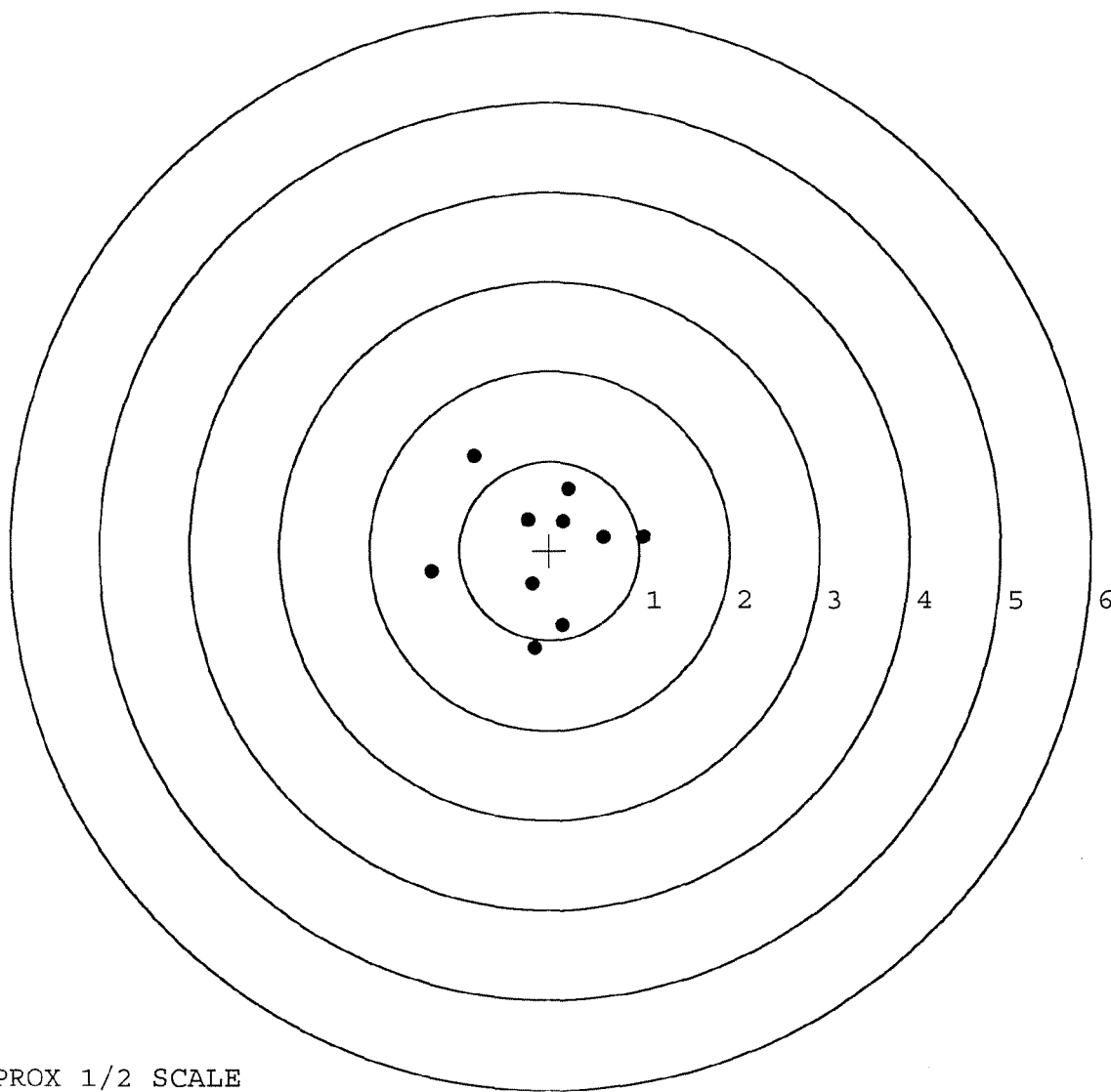
MAX RADIUS: 1.303

MEAN RADIUS: 0.826

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591581.___0

TARGET NUMBER: 3

FILE DATE: 09/27/2006

FILE TIME: 05:28

POINT#	X	Y
1:	1.152	-0.229
2:	0.657	-0.085
3:	0.590	0.355
4:	0.303	0.106
5:	-0.145	0.816
6:	-0.190	0.457
7:	-1.066	-0.229
8:	-0.852	0.040
9:	-0.511	0.061
10:	-0.491	-0.602

X CENTROID: -0.055

Y CENTROID: 0.069

POA TO CENTROID: 0.088

HORZ SPREAD: 2.218

VERT SPREAD: 1.418

GROUP SPREAD: 2.218

MIN RADIUS: 0.360

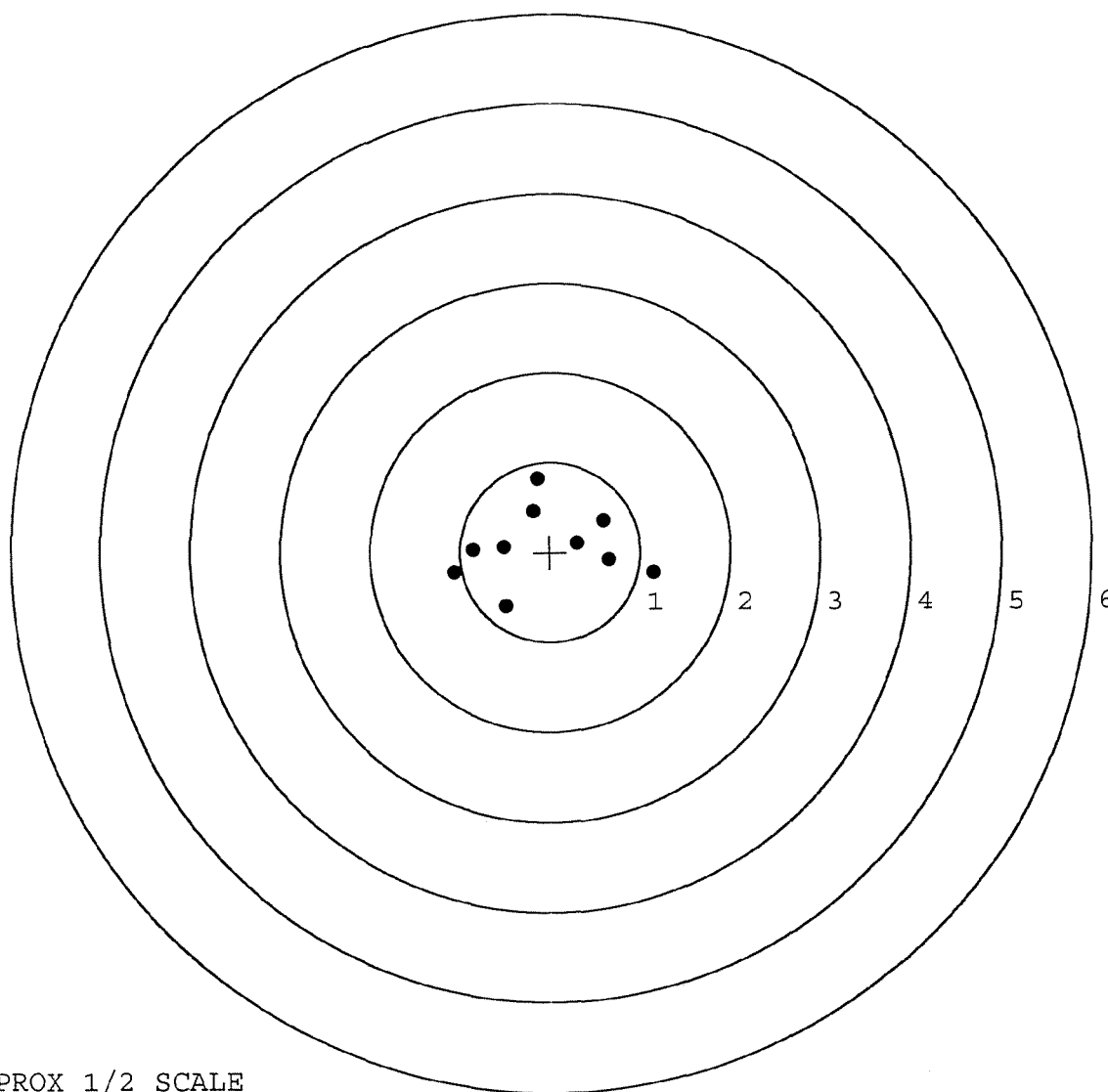
MAX RADIUS: 1.244

MEAN RADIUS: 0.731

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591581. __0

TARGET NUMBER: 4

FILE DATE: 09/27/2006

FILE TIME: 05:28

POINT#	X	Y
1:	1.476	-0.684
2:	0.867	0.391
3:	0.703	0.546
4:	0.359	-0.427
5:	0.003	-0.018
6:	-0.376	0.493
7:	-0.826	0.162
8:	-0.869	-0.609
9:	-0.861	-0.331
10:	0.344	-0.458

X CENTROID: 0.082

Y CENTROID: -0.094

POA TO CENTROID: 0.124

HORZ SPREAD: 2.345

VERT SPREAD: 1.230

GROUP SPREAD: 2.453

MIN RADIUS: 0.109

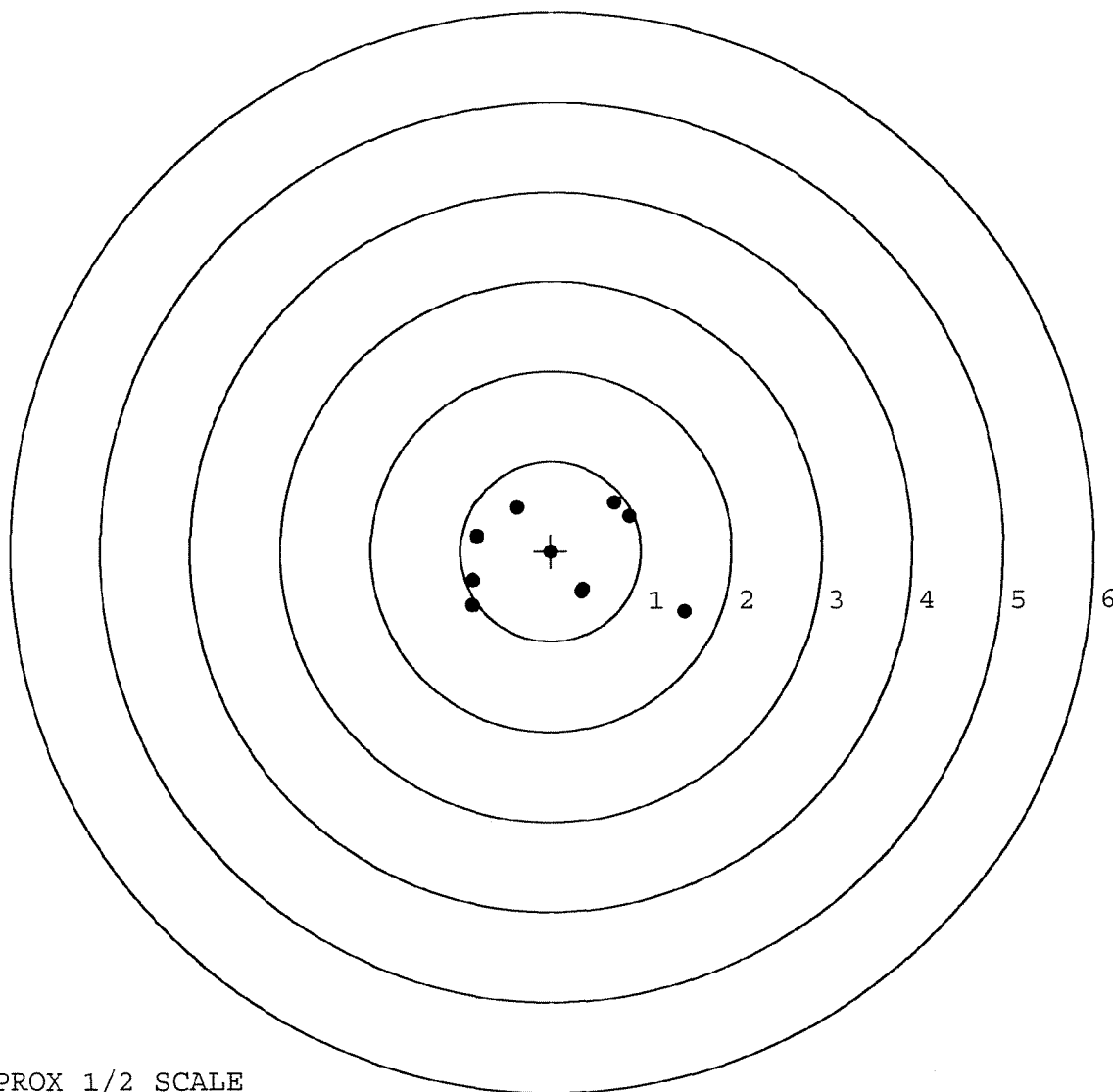
MAX RADIUS: 1.514

MEAN RADIUS: 0.806

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

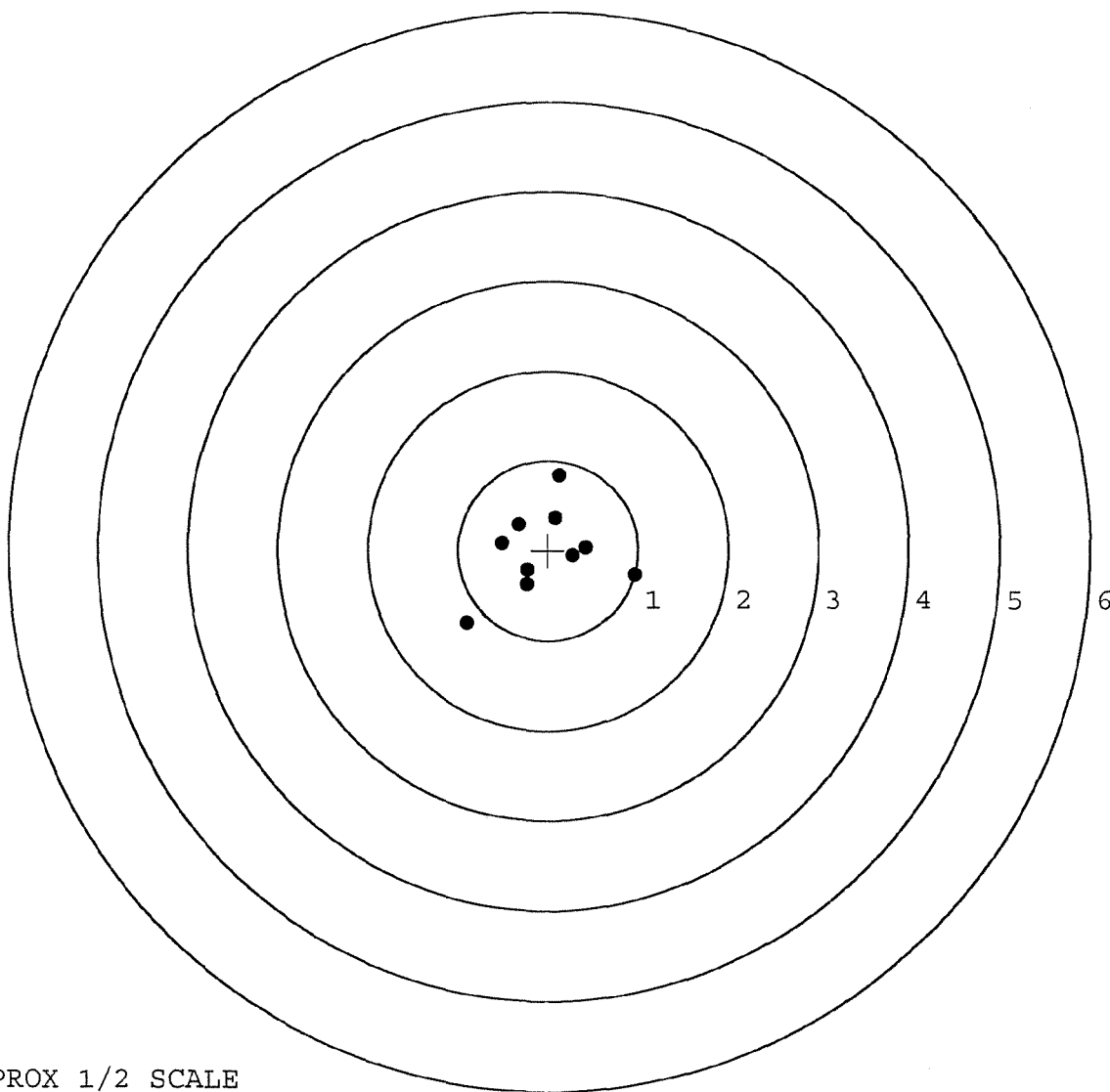


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591581. __0
TARGET NUMBER: 5
FILE DATE: 09/27/2006
FILE TIME: 05:28

POINT#	X	Y
1:	-0.894	-0.812
2:	0.961	-0.277
3:	0.421	0.029
4:	0.279	-0.061
5:	-0.236	-0.386
6:	0.074	0.361
7:	-0.327	0.282
8:	-0.512	0.077
9:	0.126	0.835
10:	-0.229	-0.226

X CENTROID: -0.034
Y CENTROID: -0.018
POA TO CENTROID: 0.038
HORZ SPREAD: 1.855
VERT SPREAD: 1.647
GROUP SPREAD: 1.937
MIN RADIUS: 0.285
MAX RADIUS: 1.171
MEAN RADIUS: 0.585
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE