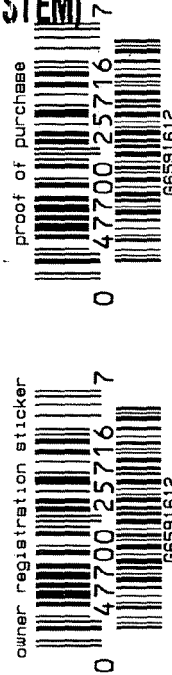


G-6591612

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

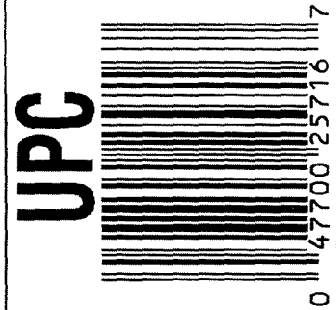
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591612



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 6591612

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	APD
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	mo

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9°</u> <u>8°</u> <u>8°</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>6°</u> <u>6°</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/06	mon
	I) FIRING PIN INDENT .020 MIN	<u>.023</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	mon
	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 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	9-27-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-27-06	BD
670	FINAL INSPECTION A) HEADSPACE		10/16/06	mon
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u> <u>2.73</u> <u>2.55</u> <u>2.57</u> <u>2.75</u>	9-28-06	RA
	C) FUNCTION		10/16/06	mon
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 9-14-06

TESTER MSM

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.53	2.74		2.51	
PULL #2	2.67	2.50		2.52	
PULL #3	2.62	2.52		2.37	
PULL #4	2.67	2.43		2.39	
PULL #5	2.80	2.63		2.77	
TOTAL	13.29	12.82		12.56	
AVERAGE	2.66	2.56		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.03		
PULL #2	3.09	3.01		
PULL #3	3.00	3.12		
PULL #4	3.07	3.06		
PULL #5	3.03	3.01		
TOTAL	15.24	15.23		
AVERAGE	3.05	3.05		

	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	3.89	3.85		4.17
PULL #2	3.89	3.98		4.07
PULL #3	3.95	3.91		4.12
PULL #4	3.92	3.98		4.10
PULL #5	3.88	3.95		4.04
TOTAL	19.51	19.67		20.50
AVERAGE	3.90	3.93		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591612.___0
FILE DATE AND TIME: 09/28/2006 05:26

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.043
The Average Y Centroid of the Five Target Set:	0.019
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.755
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.143
The Distance from Centroid Target #3 to Centroid Target #1:	0.031
The Distance from Centroid Target #4 to Centroid Target #1:	0.202
The Distance from Centroid Target #5 to Centroid Target #1:	0.201

SERIAL NUMBER: G6591612. __0

TARGET NUMBER: 1

FILE DATE: 09/28/2006

FILE TIME: 05:26

X CENTROID: -0.140

Y CENTROID: 0.014

POA TO CENTROID: 0.141

HORZ SPREAD: 3.478

VERT SPREAD: 2.562

GROUP SPREAD: 3.629

MIN RADIUS: 0.513

MAX RADIUS: 2.277

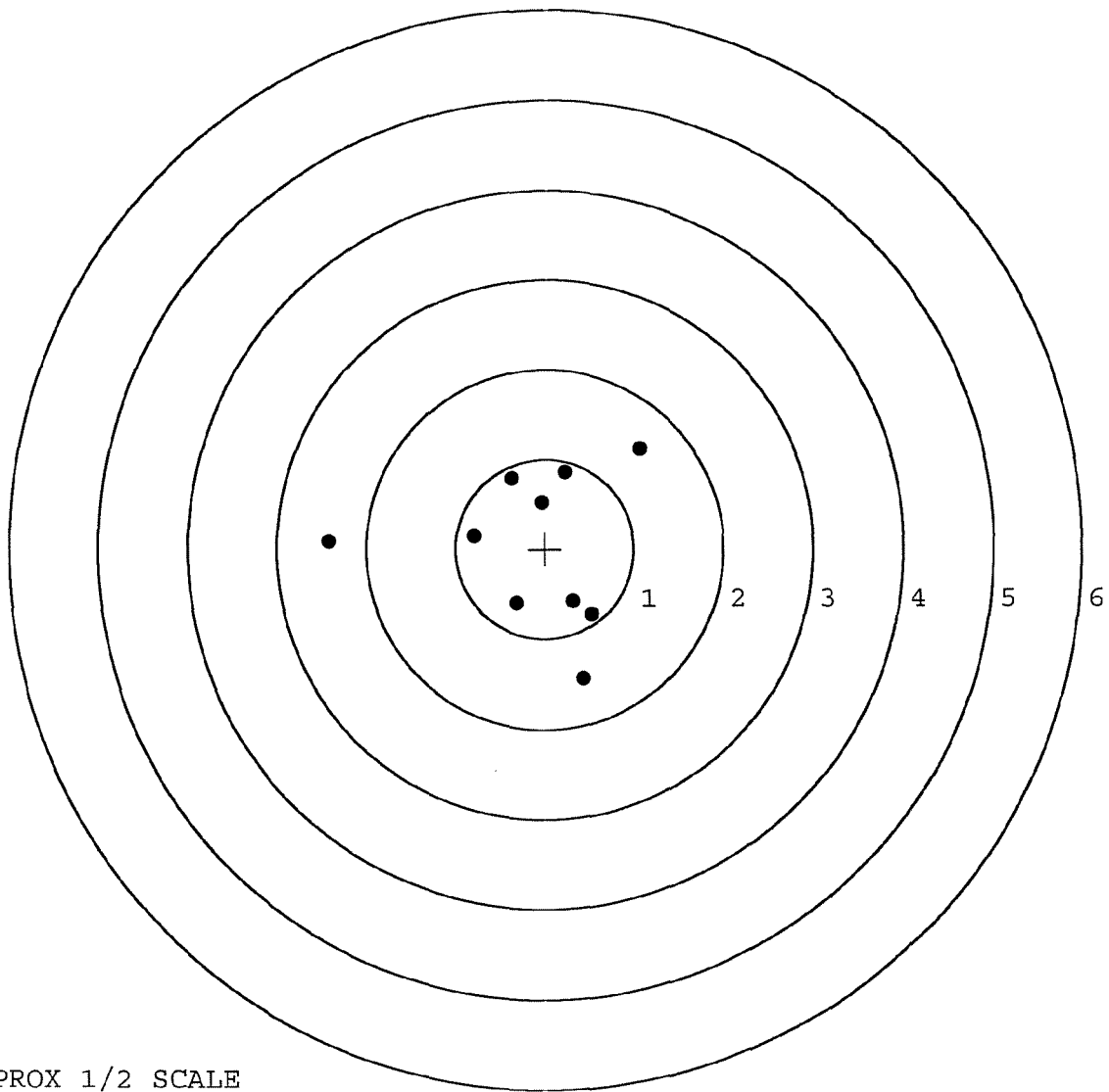
MEAN RADIUS: 1.078

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.427	-1.442
2:	0.528	-0.731
3:	0.312	-0.588
4:	-0.325	-0.609
5:	1.062	1.120
6:	0.222	0.855
7:	-0.045	0.518
8:	-0.375	0.790
9:	-0.793	0.143
10:	-2.416	0.083

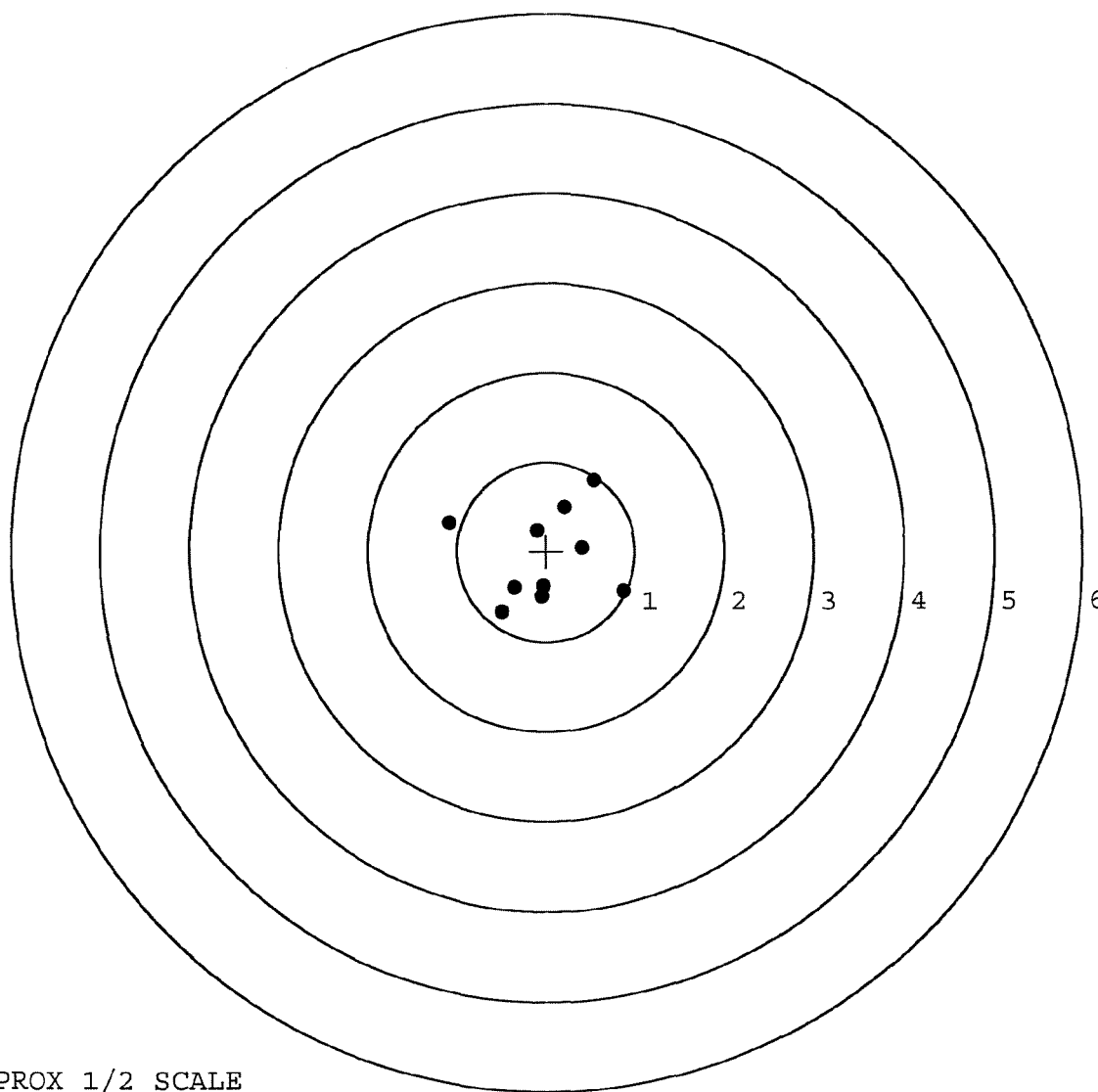


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591612. 0
TARGET NUMBER: 2
FILE DATE: 09/28/2006
FILE TIME: 05:26

X CENTROID: -0.015
Y CENTROID: -0.053
POA TO CENTROID: 0.055
HORZ SPREAD: 1.965
VERT SPREAD: 1.468
GROUP SPREAD: 2.108
MIN RADIUS: 0.300
MAX RADIUS: 1.140
MEAN RADIUS: 0.651
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.535	0.797
2:	0.873	-0.445
3:	0.403	0.045
4:	0.202	0.489
5:	-0.108	0.232
6:	-0.038	-0.393
7:	-0.362	-0.401
8:	-0.501	-0.671
9:	-0.057	-0.503
10:	-1.092	0.319



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591612. __0

TARGET NUMBER: 3

FILE DATE: 09/28/2006

FILE TIME: 05:26

X CENTROID: -0.159

Y CENTROID: 0.039

POA TO CENTROID: 0.163

HORZ SPREAD: 1.769

VERT SPREAD: 2.317

GROUP SPREAD: 2.579

MIN RADIUS: 0.225

MAX RADIUS: 1.589

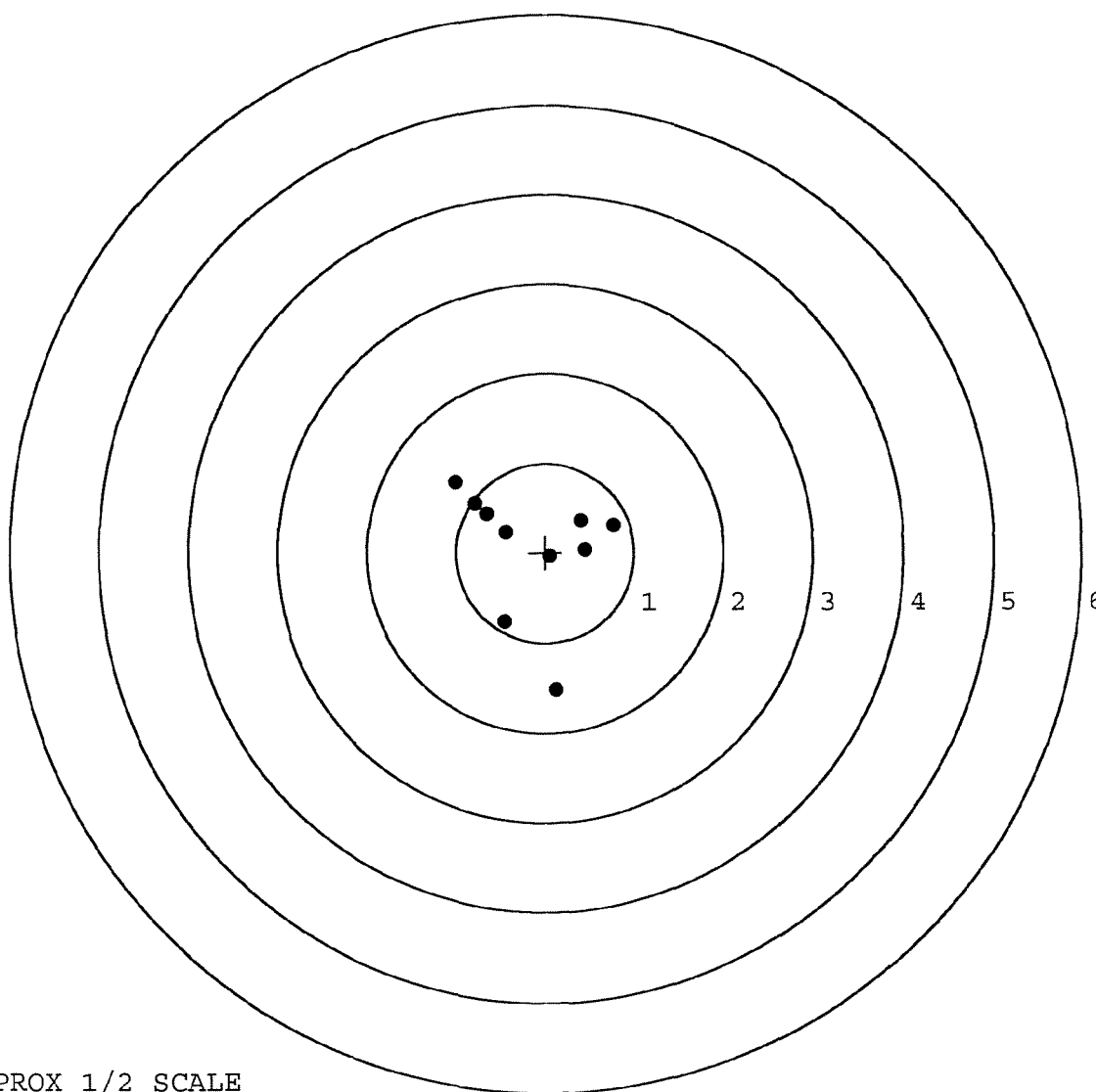
MEAN RADIUS: 0.783

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.124	-1.525
2:	-0.463	-0.772
3:	-1.009	0.792
4:	-0.792	0.556
5:	-0.663	0.444
6:	-0.443	0.231
7:	0.051	-0.043
8:	0.394	0.361
9:	0.453	0.036
10:	0.760	0.309



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591612. 0

TARGET NUMBER: 4

FILE DATE: 09/28/2006

FILE TIME: 05:26

POINT#	X	Y
1:	0.023	1.392
2:	1.172	0.030
3:	0.424	0.443
4:	0.379	-0.004
5:	0.192	-0.230
6:	-0.234	-0.562
7:	-0.817	-0.411
8:	-0.492	-0.223
9:	-0.600	0.103
10:	0.337	0.544

X CENTROID: 0.038

Y CENTROID: 0.108

POA TO CENTROID: 0.115

HORZ SPREAD: 1.989

VERT SPREAD: 1.954

GROUP SPREAD: 1.989

MIN RADIUS: 0.359

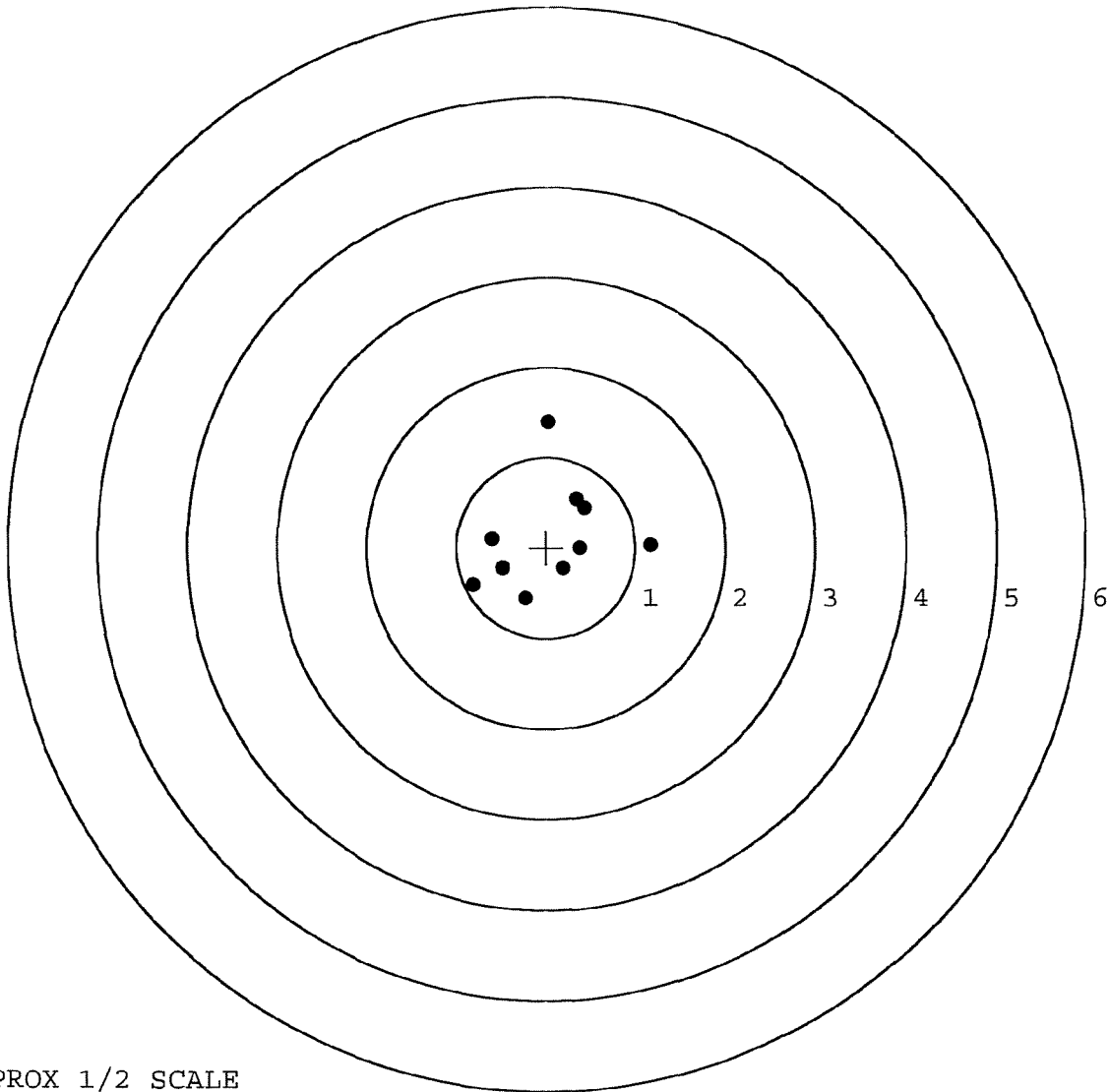
MAX RADIUS: 1.284

MEAN RADIUS: 0.718

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591612.___0

TARGET NUMBER: 5

FILE DATE: 09/28/2006

FILE TIME: 05:26

X CENTROID: 0.060

Y CENTROID: -0.011

POA TO CENTROID: 0.061

HORZ SPREAD: 2.120

VERT SPREAD: 1.220

GROUP SPREAD: 2.200

MIN RADIUS: 0.075

MAX RADIUS: 1.449

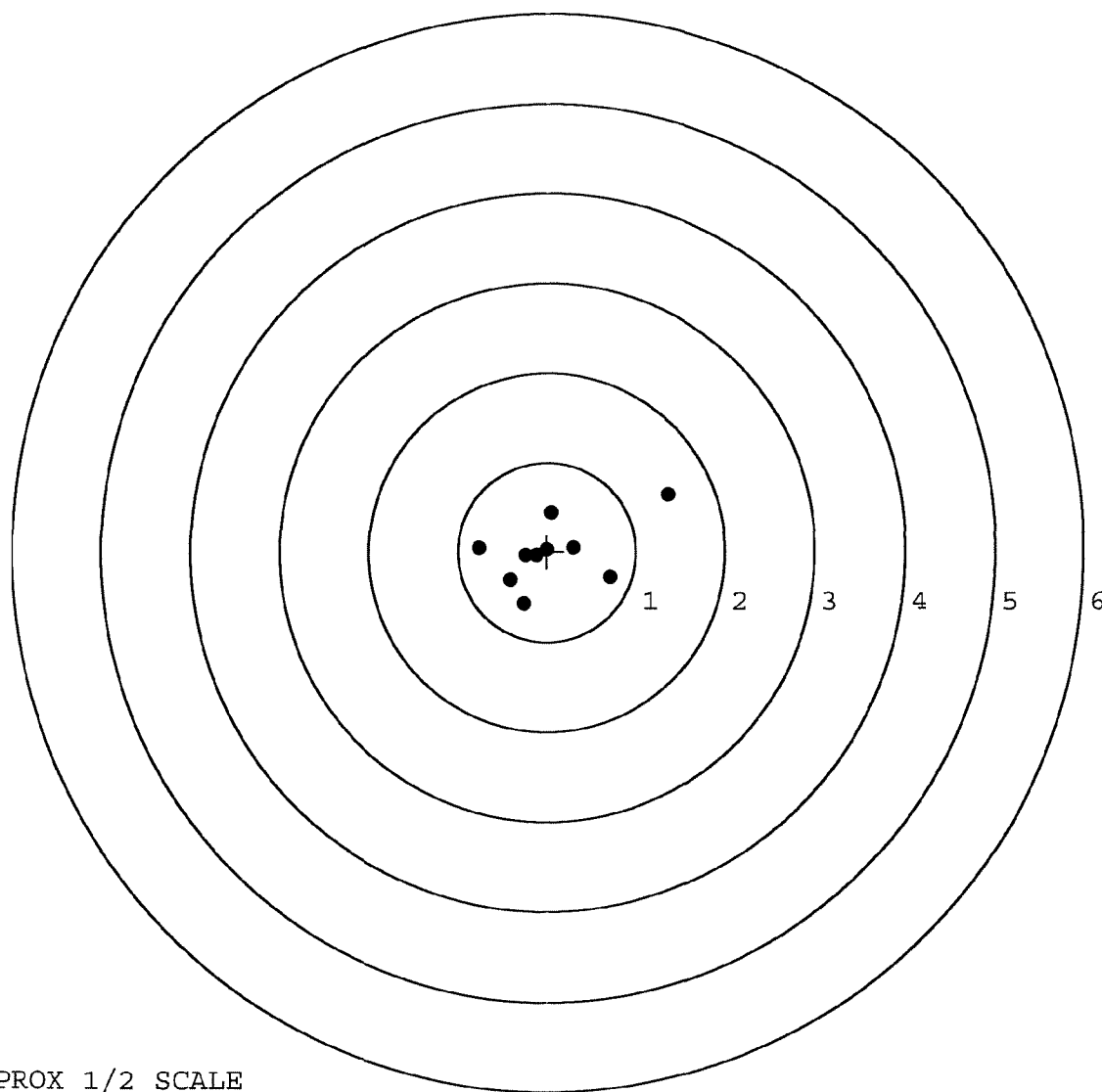
MEAN RADIUS: 0.546

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.357	0.634
2:	0.713	-0.292
3:	0.299	0.040
4:	0.041	0.434
5:	-0.008	0.022
6:	-0.241	-0.044
7:	-0.763	0.045
8:	-0.416	-0.317
9:	-0.263	-0.586
10:	-0.123	-0.044



TARGET APPROX 1/2 SCALE