

G-6591613

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

G6591613



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.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591613

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

F004 REV 5/2006

OP #	OPERATION NAME	2 LBS MIN 10 LBS MAX	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE		<u>6.0</u> <u>6.0</u> <u>6.0</u>	10/9/06	Fm
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>4.5</u>	10/9/06	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			10/9/06	nm
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	10/9/06	Fm
	J) ASSEMBLE STOCK			10-2-06	BLG
	K) ASSEMBLE SWIVEL STUDS			10/9/06	nm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			10-2-06	BLG
	M) IRON SIGHT ALIGNMENT			10-2-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			10-2-06	BLG
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	10-3-06	TRW
	MALFUNCTION <i>BAC</i>		CORRECTION <i>OK</i>	10-5-06	TRW
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			10/3	
670	FINAL INSPECTION A) HEADSPACE			10/9/06	nm
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.43</u> <u>2.38</u> <u>2.46</u> <u>2.39</u>	10-4-06	SD
	C) FUNCTION			10/9/06	nm
690	PACK			11/6/06	DA

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 9-30-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	247	253		256	
PULL #2	252	244		255	
PULL #3	254	232		256	
PULL #4	252	239		257	
PULL #5	251	237		255	
TOTAL	1256	1205		1279	
AVERAGE	251	241		255	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	302	303		
PULL #2	303	303		
PULL #3	303	303		
PULL #4	307	306		
PULL #5	305	306		
TOTAL	1520	1521		
AVERAGE	304	304		

	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	4.04	4.23		4.06
PULL #2	4.07	4.17		4.08
PULL #3	4.07	4.20		3.99
PULL #4	4.06	4.19		4.05
PULL #5	4.02	4.09		4.06
TOTAL	20.26	20.88		20.24
AVERAGE	4.05	4.17		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591613.__1
FILE DATE AND TIME: 10/04/2006 06:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.068
The Average Y Centroid of the Five Target Set:	0.052
The Average Point of Impact of the Five Target Set:	0.085
The Average Mean Radius of the Five Target Set:	0.806
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.342
The Distance from Centroid Target #3 to Centroid Target #1:	0.371
The Distance from Centroid Target #4 to Centroid Target #1:	0.527
The Distance from Centroid Target #5 to Centroid Target #1:	0.648

SERIAL NUMBER: G6591613. 1

TARGET NUMBER: 1

FILE DATE: 10/04/2006

FILE TIME: 06:13

POINT#	X	Y
1:	-0.004	1.516
2:	-1.548	1.080
3:	-1.695	-0.033
4:	-0.476	0.389
5:	0.693	0.600
6:	0.167	-0.034
7:	-0.502	-0.520
8:	-0.762	-1.430
9:	0.697	-1.913
10:	1.588	-1.550

X CENTROID: -0.184

Y CENTROID: -0.189

POA TO CENTROID: 0.264

HORZ SPREAD: 3.283

VERT SPREAD: 3.429

GROUP SPREAD: 4.093

MIN RADIUS: 0.384

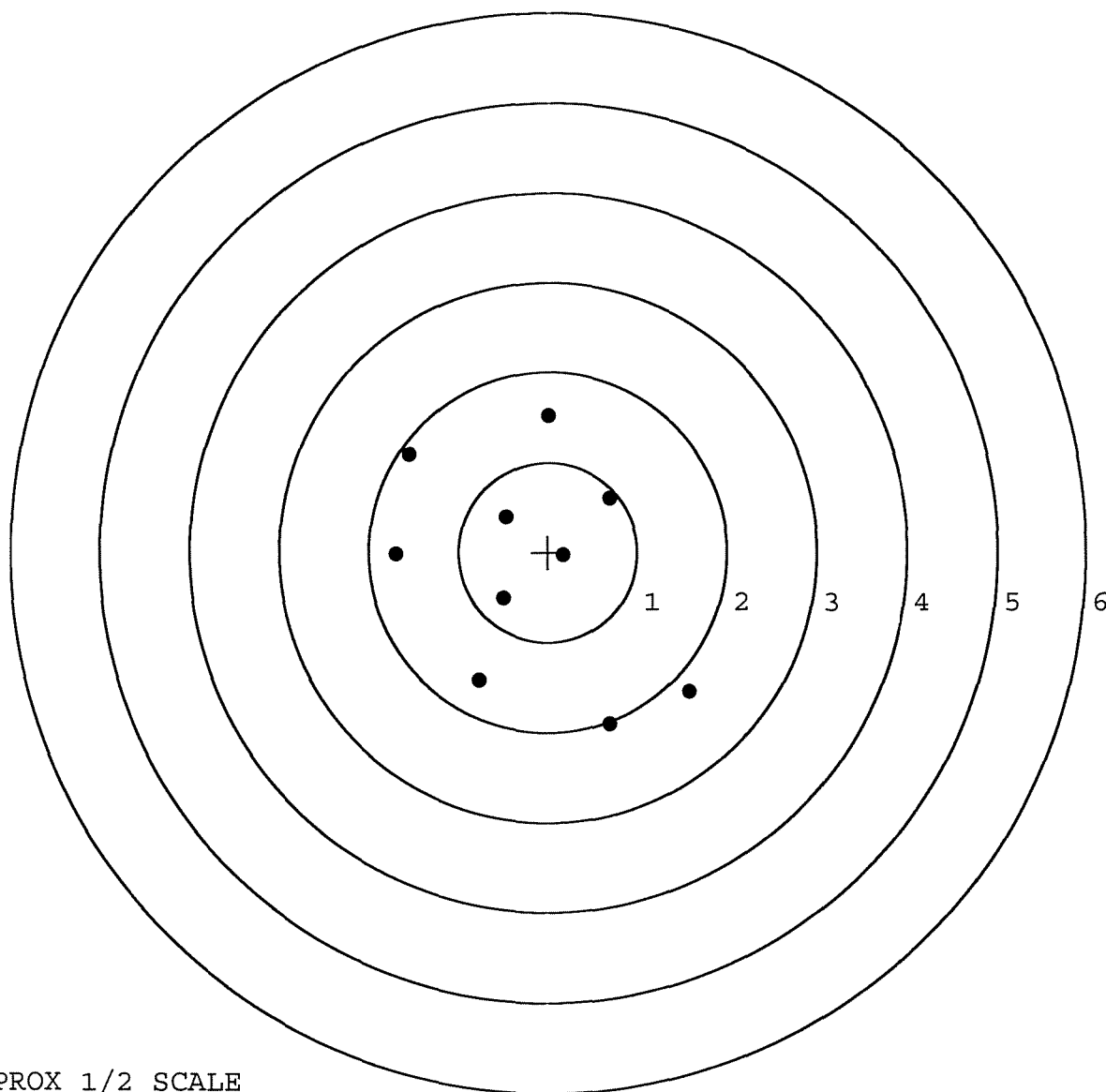
MAX RADIUS: 2.234

MEAN RADIUS: 1.331

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 5

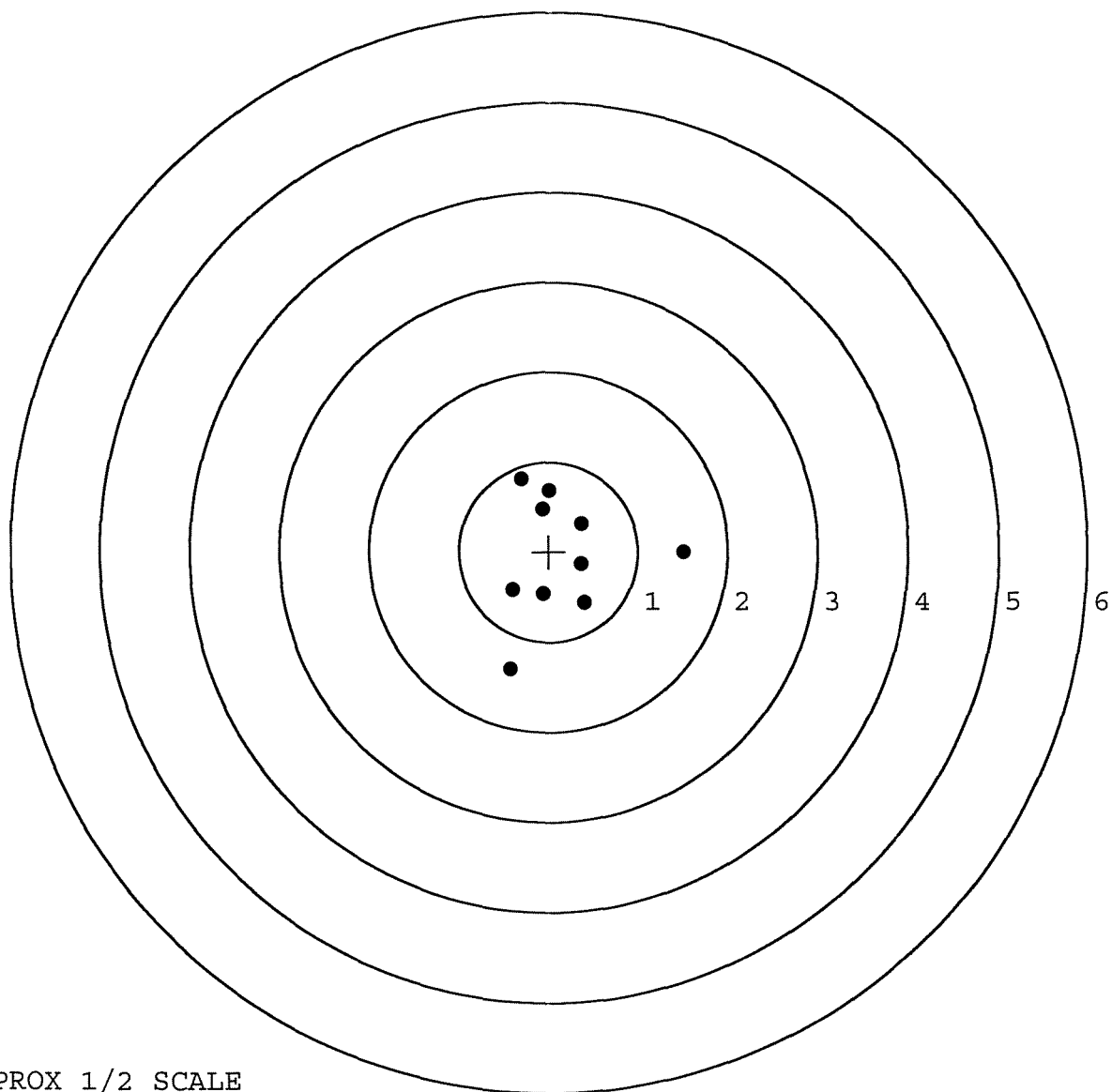


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591613. __1
TARGET NUMBER: 2
FILE DATE: 10/04/2006
FILE TIME: 06:13

POINT#	X	Y
1:	-0.430	-1.304
2:	0.401	-0.570
3:	-0.061	-0.473
4:	-0.406	-0.432
5:	0.365	-0.146
6:	1.510	-0.013
7:	0.364	0.308
8:	0.004	0.680
9:	-0.079	0.468
10:	-0.311	0.808

X CENTROID: 0.136
Y CENTROID: -0.067
POA TO CENTROID: 0.152
HORZ SPREAD: 1.940
VERT SPREAD: 2.112
GROUP SPREAD: 2.330
MIN RADIUS: 0.242
MAX RADIUS: 1.375
MEAN RADIUS: 0.741
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

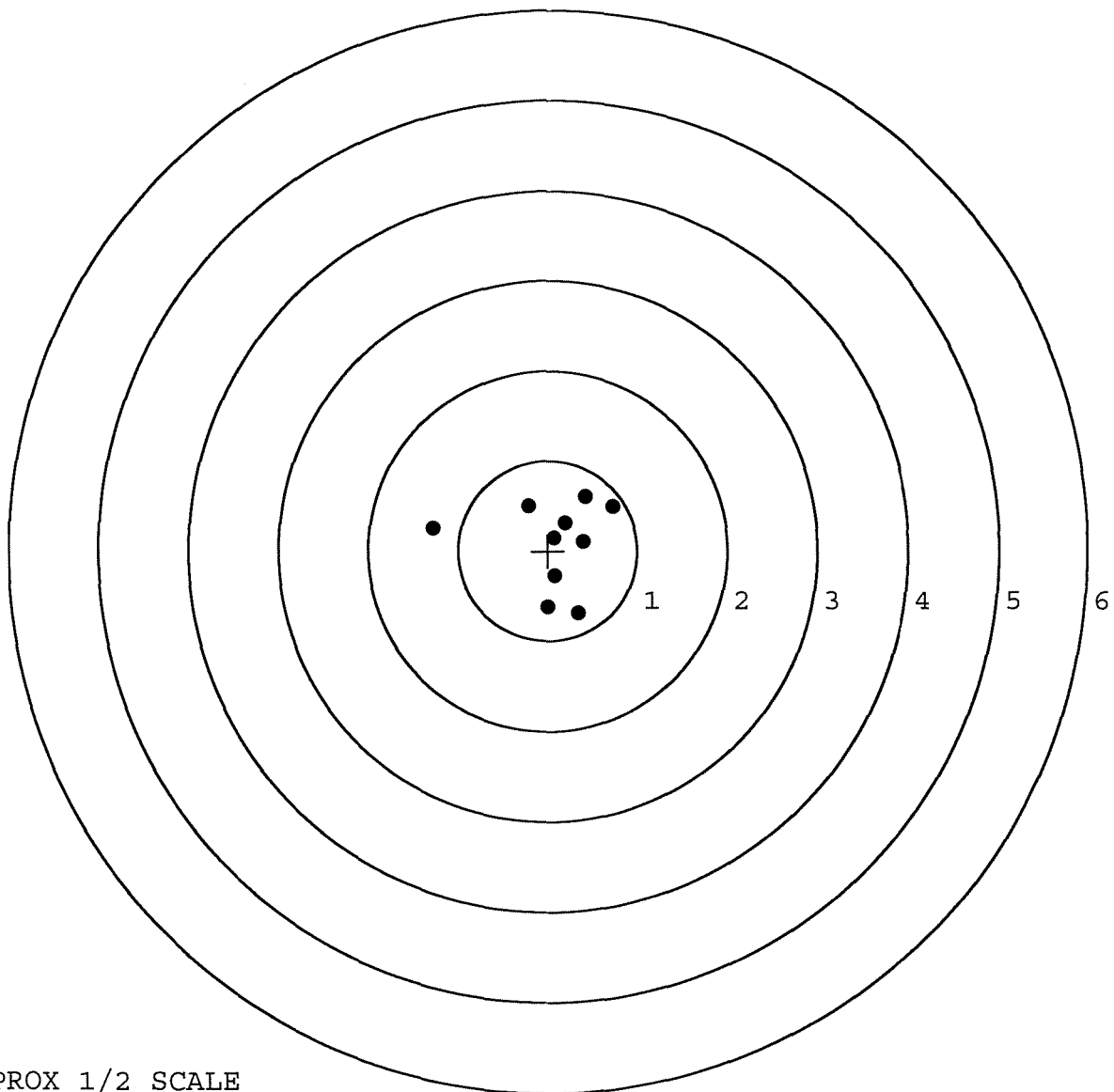


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591613. __1
TARGET NUMBER: 3
FILE DATE: 10/04/2006
FILE TIME: 06:13

POINT#	X	Y
1:	-1.277	0.250
2:	-0.224	0.494
3:	0.419	0.602
4:	0.192	0.312
5:	0.720	0.499
6:	0.397	0.106
7:	0.071	0.142
8:	0.077	-0.283
9:	-0.003	-0.627
10:	0.342	-0.695

X CENTROID: 0.071
Y CENTROID: 0.080
POA TO CENTROID: 0.107
HORZ SPREAD: 1.997
VERT SPREAD: 1.297
GROUP SPREAD: 2.012
MIN RADIUS: 0.062
MAX RADIUS: 1.359
MEAN RADIUS: 0.581
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

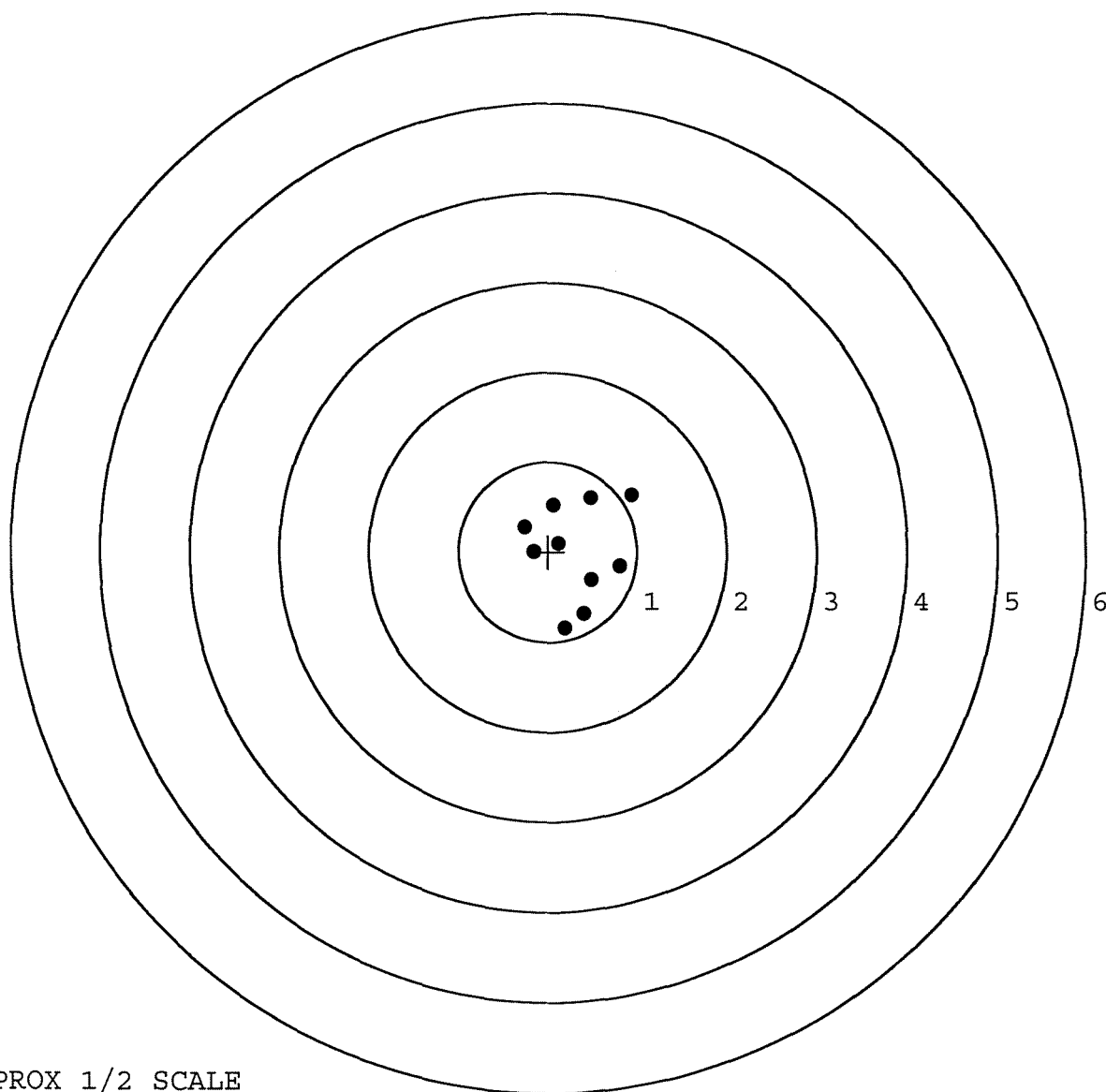


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591613. 1
TARGET NUMBER: 4
FILE DATE: 10/04/2006
FILE TIME: 06:13

POINT#	X	Y
1:	0.935	0.627
2:	0.803	-0.160
3:	0.480	0.597
4:	0.116	0.089
5:	-0.164	0.003
6:	0.485	-0.315
7:	-0.270	0.267
8:	0.058	0.516
9:	0.405	-0.687
10:	0.193	-0.853

X CENTROID: 0.304
Y CENTROID: 0.008
POA TO CENTROID: 0.304
HORZ SPREAD: 1.205
VERT SPREAD: 1.480
GROUP SPREAD: 1.656
MIN RADIUS: 0.205
MAX RADIUS: 0.884
MEAN RADIUS: 0.583
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

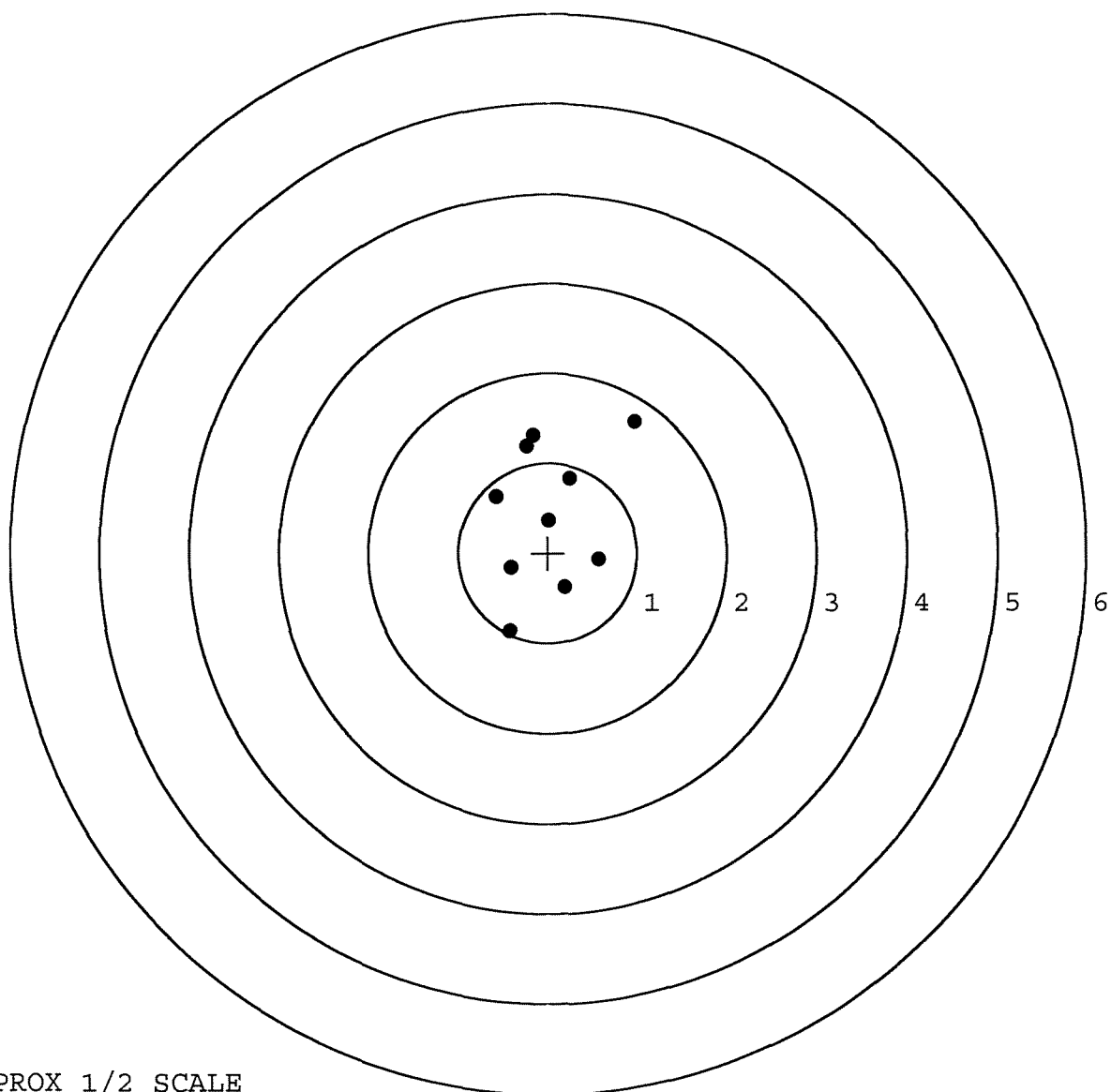


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591613. 1
TARGET NUMBER: 5
FILE DATE: 10/04/2006
FILE TIME: 06:13

POINT#	X	Y
1:	0.244	0.830
2:	-0.581	0.627
3:	-0.002	0.366
4:	0.970	1.456
5:	0.570	-0.071
6:	0.187	-0.386
7:	-0.419	-0.162
8:	-0.433	-0.867
9:	-0.172	1.304
10:	-0.246	1.182

X CENTROID: 0.012
Y CENTROID: 0.428
POA TO CENTROID: 0.428
HORZ SPREAD: 1.551
VERT SPREAD: 2.323
GROUP SPREAD: 2.714
MIN RADIUS: 0.063
MAX RADIUS: 1.405
MEAN RADIUS: 0.793
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE