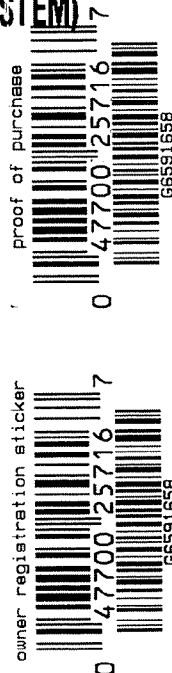


G 65-91658

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

- INSTRUCTION BOOK 3518

DD FORM

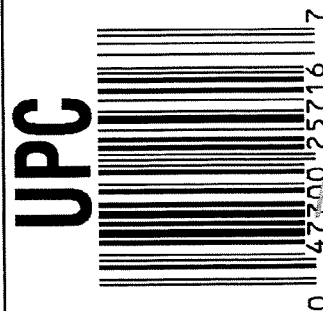


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591658



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.



66591658

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591658

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>CAPD</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		9/27	DK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/27	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/27	DK
	D) OIL FIRING PIN ASSEMBLY		9-27-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6°</u> <u>6°</u> <u>6°</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>4°</u> <u>4°</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.027</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-27-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-8-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-27-06	RTZ
	M) IRON SIGHT ALIGNMENT		9-27-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-27-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-27-06	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/27/06	M/P
670	FINAL INSPECTION A) HEADSPACE		11-8-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.67</u> <u>2.71</u> <u>2.52</u> <u>2.61</u>	9-29-06	DA
	C) FUNCTION		11-8-06	RTZ
690	PACK		11/9/06	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 9-26-06

TESTER MSL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.48	2.39	2.13	
PULL #2	2.46	2.43	2.14	
PULL #3	2.45	2.32	2.21	
PULL #4	2.50	2.33	2.19	
PULL #5	2.58	2.39	2.15	
TOTAL	12.47	11.86	10.82	
AVERAGE	2.49	2.37	2.16	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.16	3.15	
PULL #2	3.15	3.14	
PULL #3	3.22	3.21	
PULL #4	3.20	2.93	
PULL #5	3.10	3.10	
TOTAL	15.83	15.53	
AVERAGE	3.17	3.11	

	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	4.05	3.95		4.08
PULL #2	4.02	4.02		4.08
PULL #3	4.03	3.97		4.16
PULL #4	4.01	3.99		4.02
PULL #5	3.98	4.02		4.09
TOTAL	20.09	19.95		20.43
AVERAGE	4.02	3.99		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591658.__0
FILE DATE AND TIME: 09/28/2006 05:58

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.012
The Average Y Centroid of the Five Target Set:	0.083
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.596
The Distance from POA to Centroid Target #1:	0.154
The Distance from Centroid Target #2 to Centroid Target #1:	0.119
The Distance from Centroid Target #3 to Centroid Target #1:	0.213
The Distance from Centroid Target #4 to Centroid Target #1:	0.185
The Distance from Centroid Target #5 to Centroid Target #1:	0.085

SERIAL NUMBER: G6591658. 0

TARGET NUMBER: 1

FILE DATE: 09/28/2006

FILE TIME: 05:58

X CENTROID: -0.048

Y CENTROID: 0.146

POA TO CENTROID: 0.154

HORZ SPREAD: 1.149

VERT SPREAD: 1.282

GROUP SPREAD: 1.446

MIN RADIUS: 0.093

MAX RADIUS: 0.810

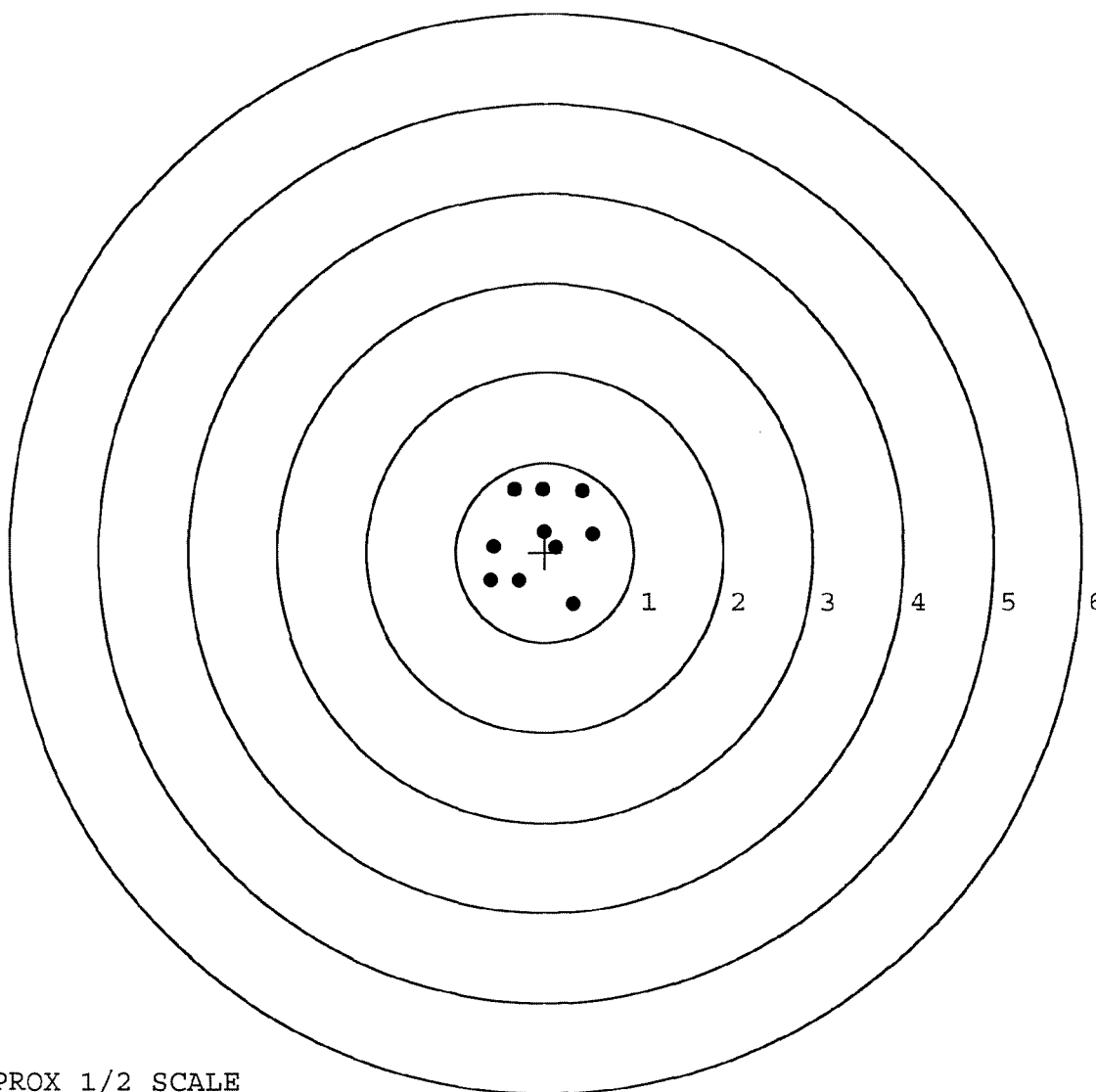
MEAN RADIUS: 0.538

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.317	-0.577
2:	0.538	0.213
3:	0.414	0.690
4:	-0.353	0.704
5:	-0.030	0.705
6:	0.125	0.054
7:	-0.008	0.230
8:	-0.294	-0.317
9:	-0.611	-0.313
10:	-0.576	0.070



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591658. 0

TARGET NUMBER: 2

FILE DATE: 09/28/2006

FILE TIME: 05:58

X CENTROID: -0.083

Y CENTROID: 0.033

POA TO CENTROID: 0.089

HORZ SPREAD: 2.328

VERT SPREAD: 1.712

GROUP SPREAD: 2.426

MIN RADIUS: 0.117

MAX RADIUS: 1.228

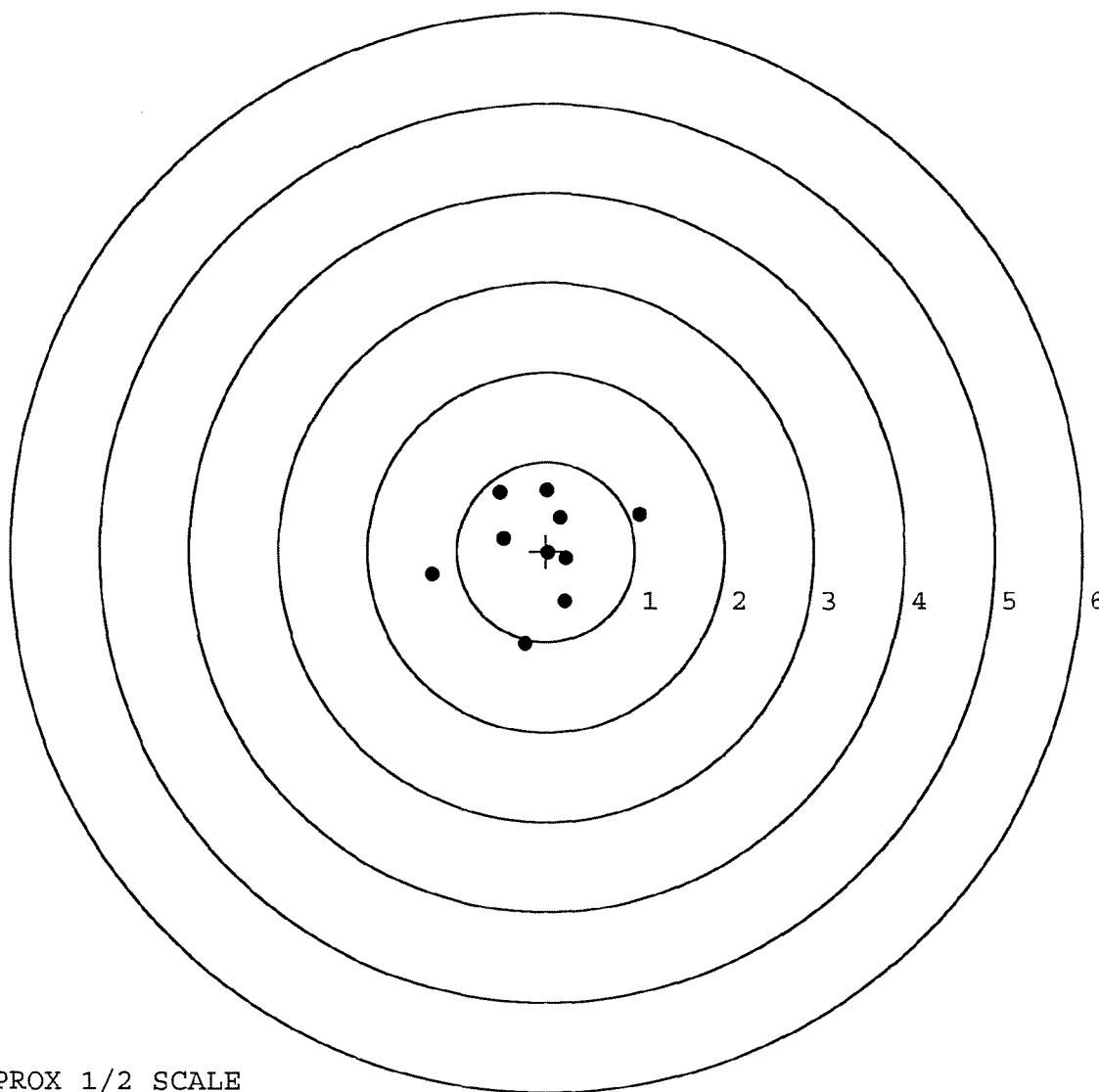
MEAN RADIUS: 0.688

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.275	-0.265
2:	-0.524	0.666
3:	-0.479	0.148
4:	1.053	0.417
5:	-0.237	-1.032
6:	0.208	-0.564
7:	0.023	-0.016
8:	0.160	0.377
9:	0.013	0.680
10:	0.226	-0.085



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591658. __0

TARGET NUMBER: 3

FILE DATE: 09/28/2006

FILE TIME: 05:58

POINT#	X	Y
1:	1.006	0.842
2:	0.308	0.516
3:	-0.458	0.421
4:	0.152	-0.648
5:	0.146	-0.295
6:	-0.301	-0.548
7:	-0.366	-0.156
8:	-0.035	0.167
9:	-0.166	-0.218
10:	0.282	-0.480

X CENTROID: 0.057

Y CENTROID: -0.040

POA TO CENTROID: 0.069

HORZ SPREAD: 1.464

VERT SPREAD: 1.490

GROUP SPREAD: 1.908

MIN RADIUS: 0.226

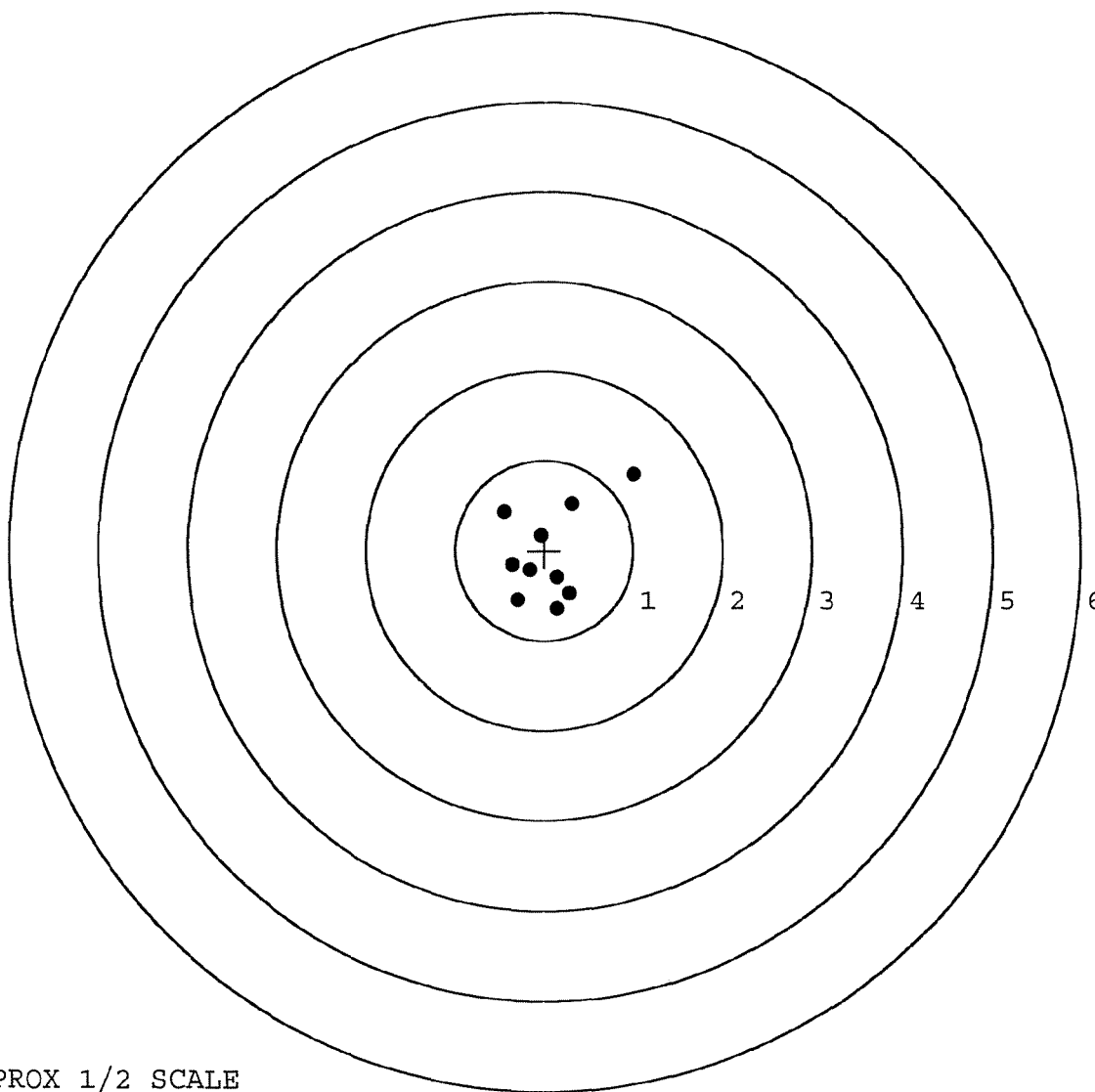
MAX RADIUS: 1.296

MEAN RADIUS: 0.555

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

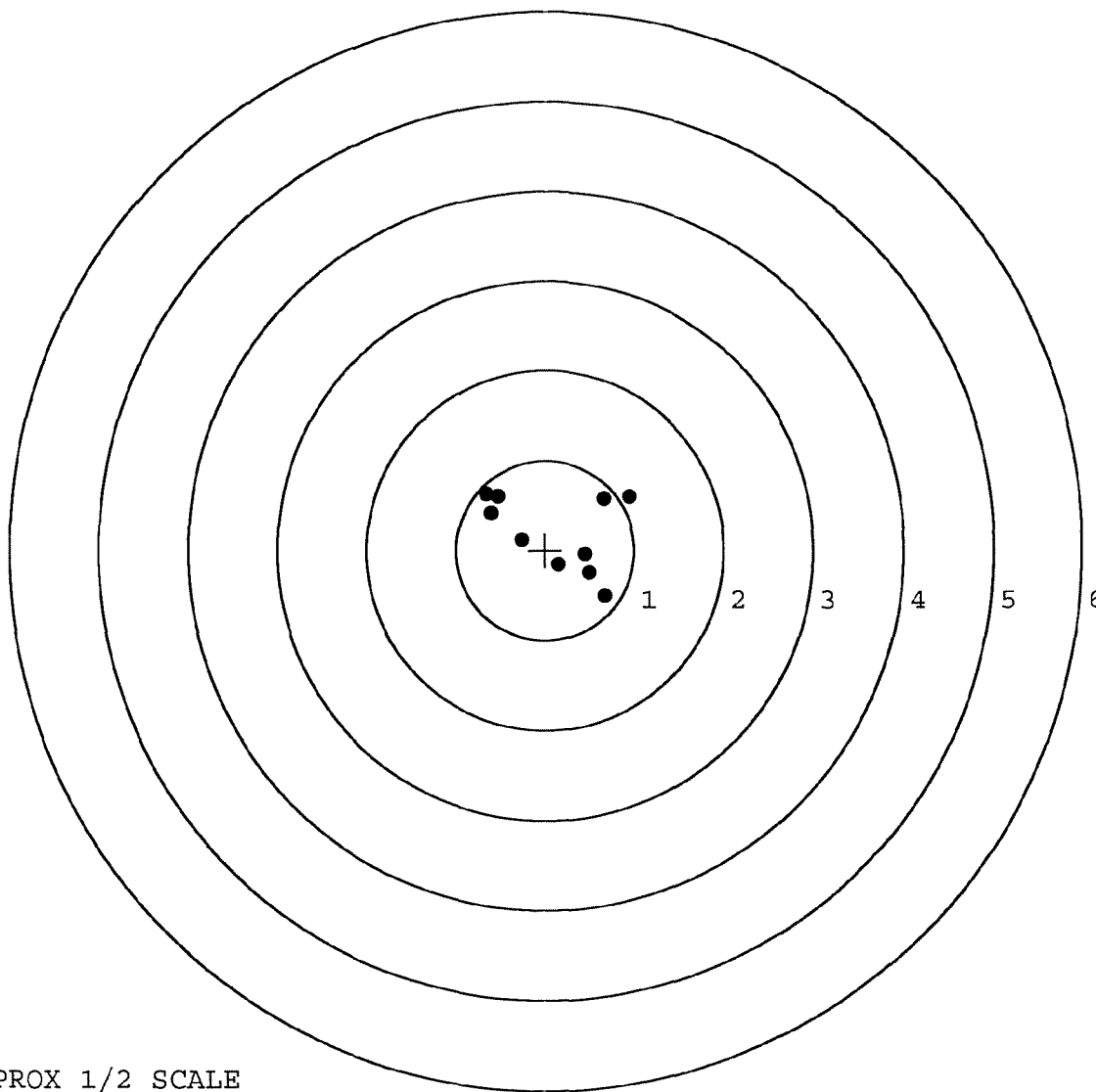


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591658. 0
TARGET NUMBER: 4
FILE DATE: 09/28/2006
FILE TIME: 05:58

X CENTROID: 0.130
Y CENTROID: 0.199
POA TO CENTROID: 0.237
HORZ SPREAD: 1.608
VERT SPREAD: 1.143
GROUP SPREAD: 1.608
MIN RADIUS: 0.359
MAX RADIUS: 0.909
MEAN RADIUS: 0.664
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.945	0.600
2:	0.656	0.575
3:	0.670	-0.511
4:	0.495	-0.249
5:	0.451	-0.041
6:	0.153	-0.160
7:	-0.262	0.119
8:	-0.539	0.604
9:	-0.663	0.632
10:	-0.611	0.417



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591658. 0

TARGET NUMBER: 5

FILE DATE: 09/28/2006

FILE TIME: 05:58

X CENTROID: 0.006

Y CENTROID: 0.080

POA TO CENTROID: 0.080

HORZ SPREAD: 1.570

VERT SPREAD: 1.611

GROUP SPREAD: 1.625

MIN RADIUS: 0.185

MAX RADIUS: 1.040

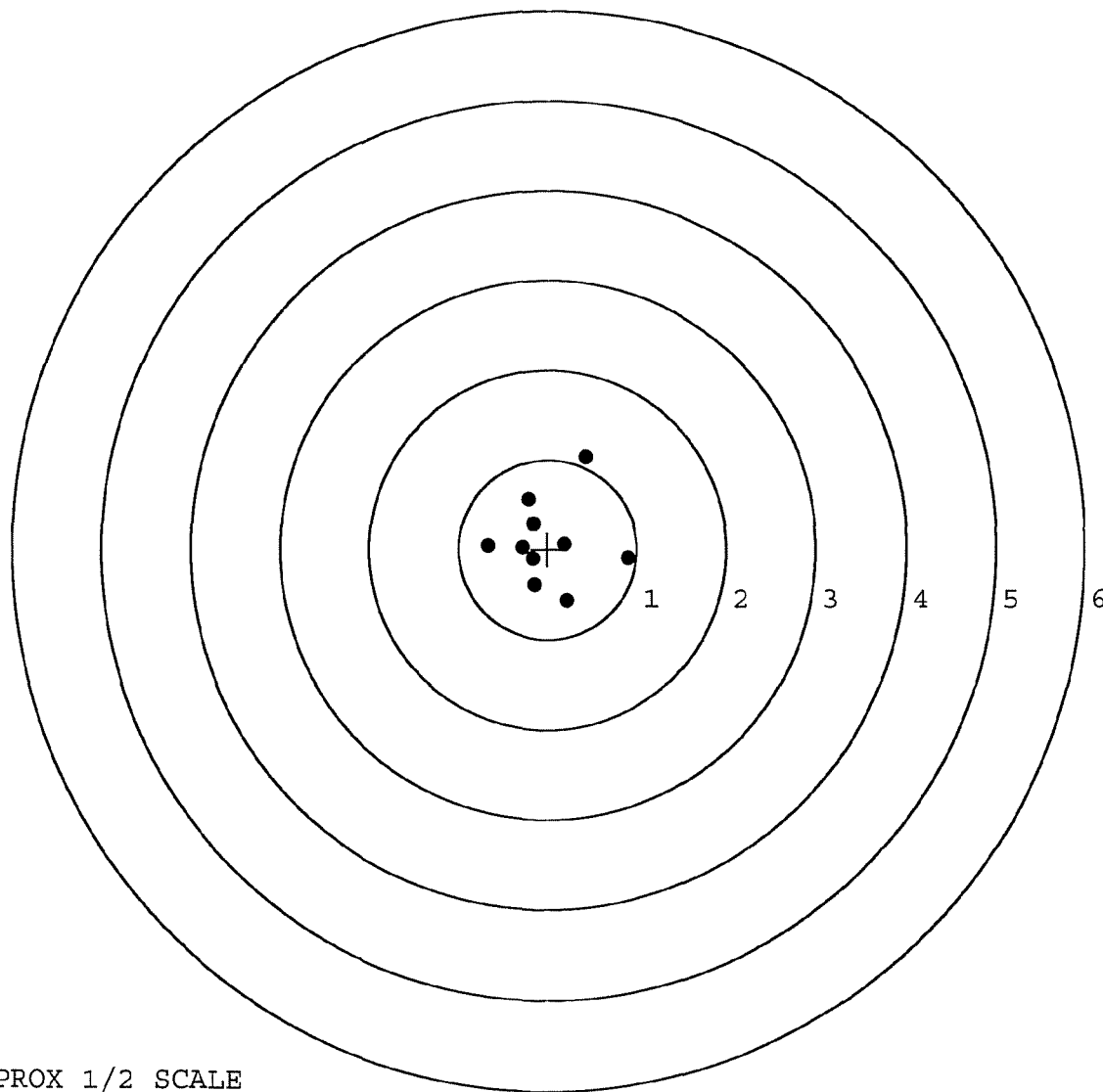
MEAN RADIUS: 0.537

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.425	1.031
2:	0.902	-0.106
3:	0.214	-0.580
4:	0.190	0.058
5:	-0.153	-0.402
6:	-0.171	-0.107
7:	-0.668	0.038
8:	-0.222	0.557
9:	-0.172	0.286
10:	-0.284	0.021



TARGET APPROX 1/2 SCALE