

G-6591659

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

- INSTRUCTION BOOK 3518

DD FORM



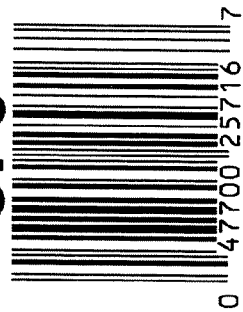
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6591659

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591659

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-8-06	RTZ
420	ASSEMBLE ACTION		9-14-06	RTZ
430	ASSEMBLE TO STOCK		9-15-06	S.P.D.
440	PROOF	MAGNA-FLUX INSPECTED	9-15-06	S.P.D.
460	CHECK HEADSPACE	SEP 21 2006	9-15-06	S.P.D.
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	9-21-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-20-06	CW
510	DRILL AND TAP SIGHT HOLES		9-20-06	TRW
520	GOFF BLAST BBL / REC		9-21-06	IB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/27/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/27/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/27-06	DA
	D) OIL FIRING PIN ASSEMBLY		9-28-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

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OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁵</u> <u>7⁵</u> <u>9⁰</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5⁰</u> <u>5⁵</u> <u>6⁰</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.027</u> <u>.027</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-28-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-7-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-28-06	RTZ
	M) IRON SIGHT ALIGNMENT		9-28-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-28-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9/29/06	MTM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORREC.		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-29-06	SD
670	FINAL INSPECTION A) HEADSPACE		11-7-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.33</u> <u>2.37</u> <u>2.37</u> <u>2.31</u> <u>2.37</u>	10-3-06	RA
	C) FUNCTION		11-7-06	RTZ
690	PACK		11/9/06	RA

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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 R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	257	254		246	
PULL #2	258	245		235	
PULL #3	261	248		249	
PULL #4	257	246		248	
PULL #5	258	245		243	
TOTAL	1291	1238		1221	
AVERAGE	258	247		244	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	306	297		
PULL #2	304	297		
PULL #3	307	297		
PULL #4	303	298		
PULL #5	307	298		
TOTAL	1527	1487		
AVERAGE	305	297		

	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	414	402		409
PULL #2	411	402		407
PULL #3	414	398		405
PULL #4	408	400		408
PULL #5	412	399		404
TOTAL	2059	2001		2033
AVERAGE	411	400		406

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591659.__0
FILE DATE AND TIME: 10/02/2006 23:08

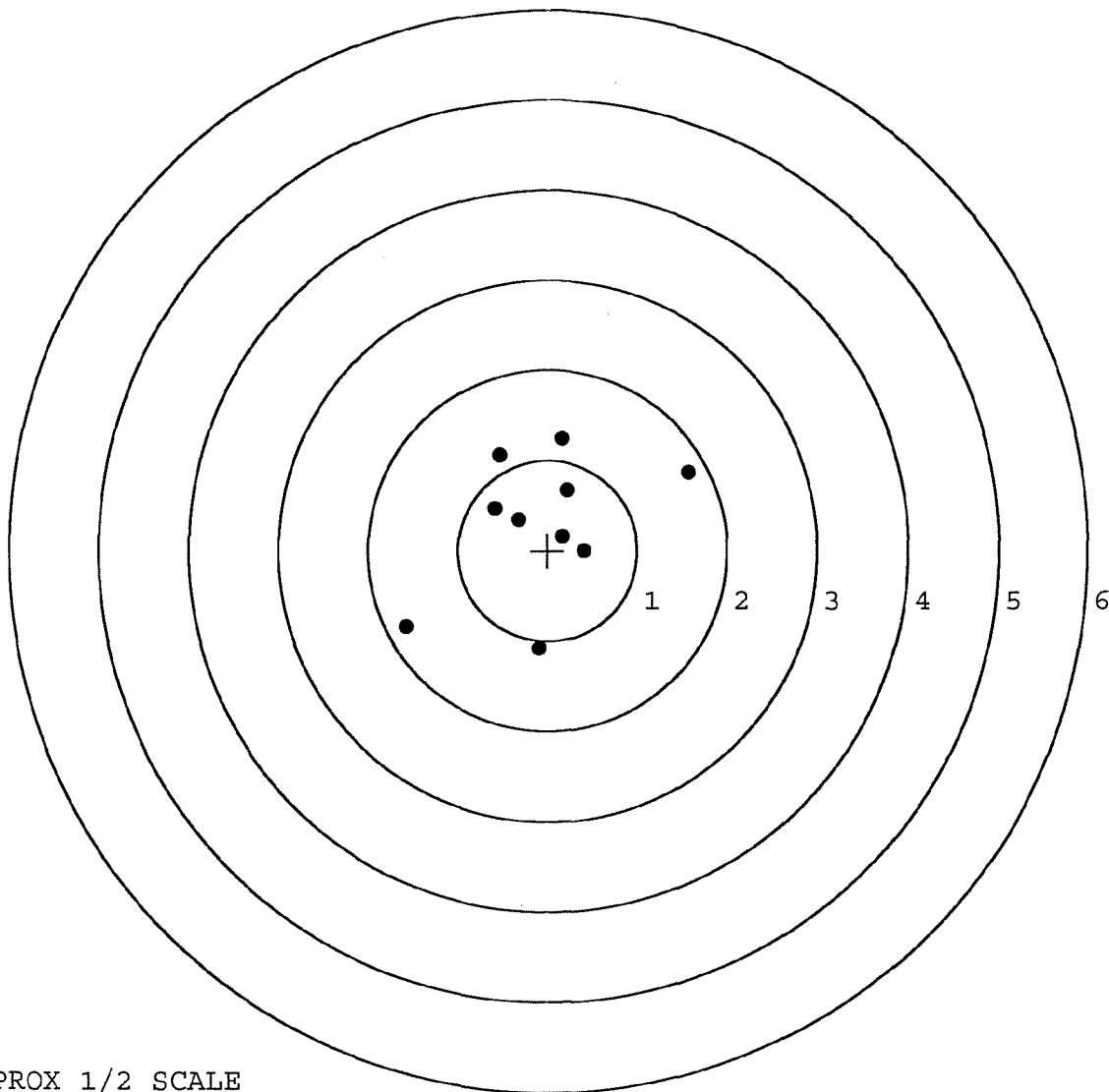
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.123
The Average Y Centroid of the Five Target Set:	0.189
The Average Point of Impact of the Five Target Set:	0.225
The Average Mean Radius of the Five Target Set:	0.816
The Distance from POA to Centroid Target #1:	0.293
The Distance from Centroid Target #2 to Centroid Target #1:	0.132
The Distance from Centroid Target #3 to Centroid Target #1:	0.219
The Distance from Centroid Target #4 to Centroid Target #1:	0.050
The Distance from Centroid Target #5 to Centroid Target #1:	0.338

SERIAL NUMBER: G6591659. __0
TARGET NUMBER: 1
FILE DATE: 10/02/2006
FILE TIME: 23:08

POINT#	X	Y
1:	-0.098	-1.091
2:	-1.580	-0.850
3:	1.572	0.871
4:	0.409	-0.006
5:	0.163	0.154
6:	-0.333	0.346
7:	-0.588	0.471
8:	0.219	0.673
9:	0.162	1.239
10:	-0.535	1.055

X CENTROID: -0.061
Y CENTROID: 0.286
POA TO CENTROID: 0.293
HORZ SPREAD: 3.152
VERT SPREAD: 2.330
GROUP SPREAD: 3.591
MIN RADIUS: 0.260
MAX RADIUS: 1.897
MEAN RADIUS: 0.902
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

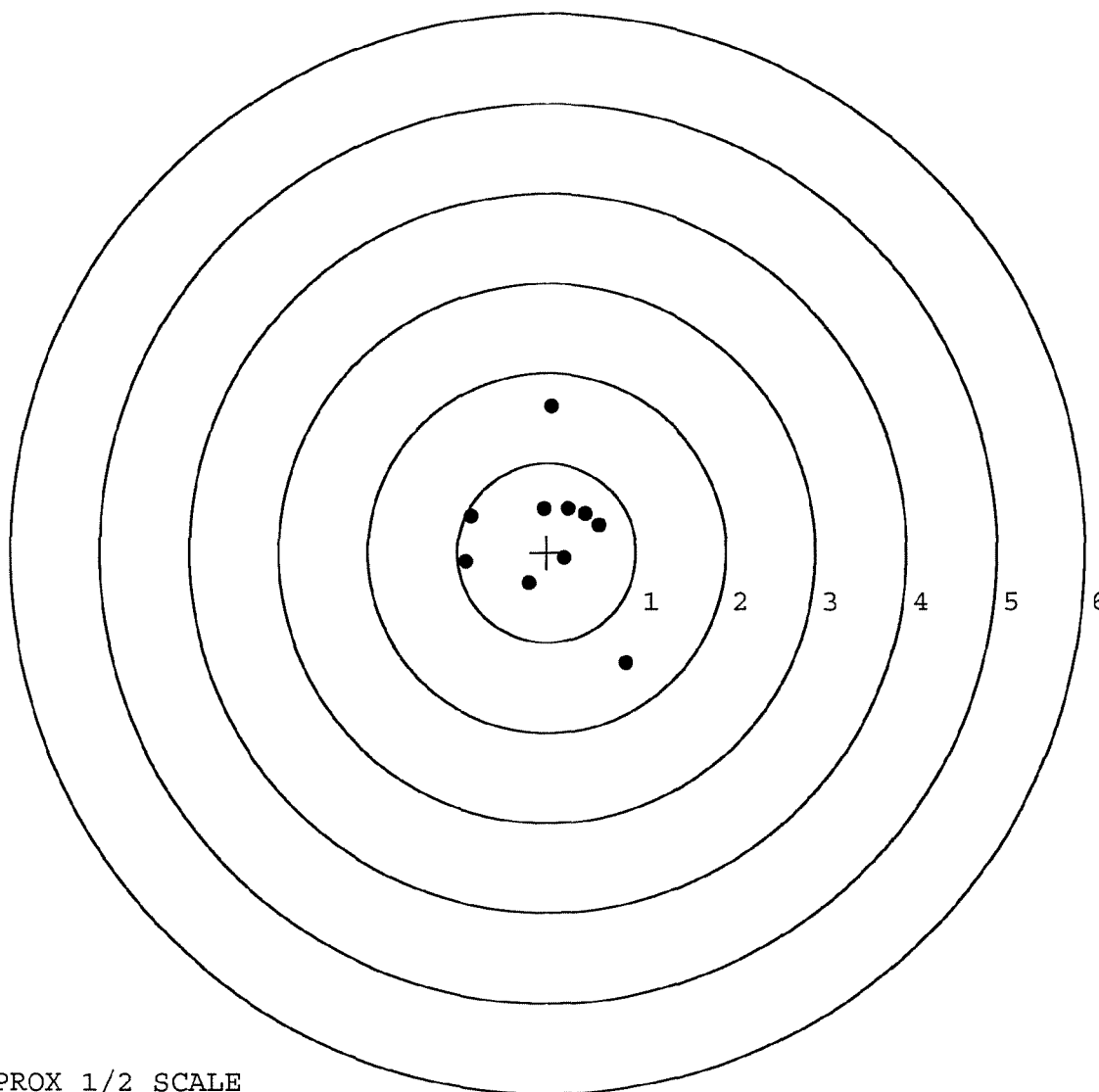


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591659. __ 0
TARGET NUMBER: 2
FILE DATE: 10/02/2006
FILE TIME: 23:08

X CENTROID: 0.039
Y CENTROID: 0.201
POA TO CENTROID: 0.205
HORZ SPREAD: 1.791
VERT SPREAD: 2.852
GROUP SPREAD: 2.973
MIN RADIUS: 0.299
MAX RADIUS: 1.662
MEAN RADIUS: 0.756
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.586	0.310
2:	0.429	0.436
3:	0.235	0.488
4:	-0.035	0.491
5:	-0.847	0.413
6:	-0.903	-0.104
7:	-0.202	-0.353
8:	0.196	-0.067
9:	0.888	-1.228
10:	0.047	1.624



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591659. 0

TARGET NUMBER: 3

FILE DATE: 10/02/2006

FILE TIME: 23:08

X CENTROID: -0.266

Y CENTROID: 0.211

POA TO CENTROID: 0.339

HORZ SPREAD: 2.314

VERT SPREAD: 2.055

GROUP SPREAD: 2.460

MIN RADIUS: 0.406

MAX RADIUS: 1.394

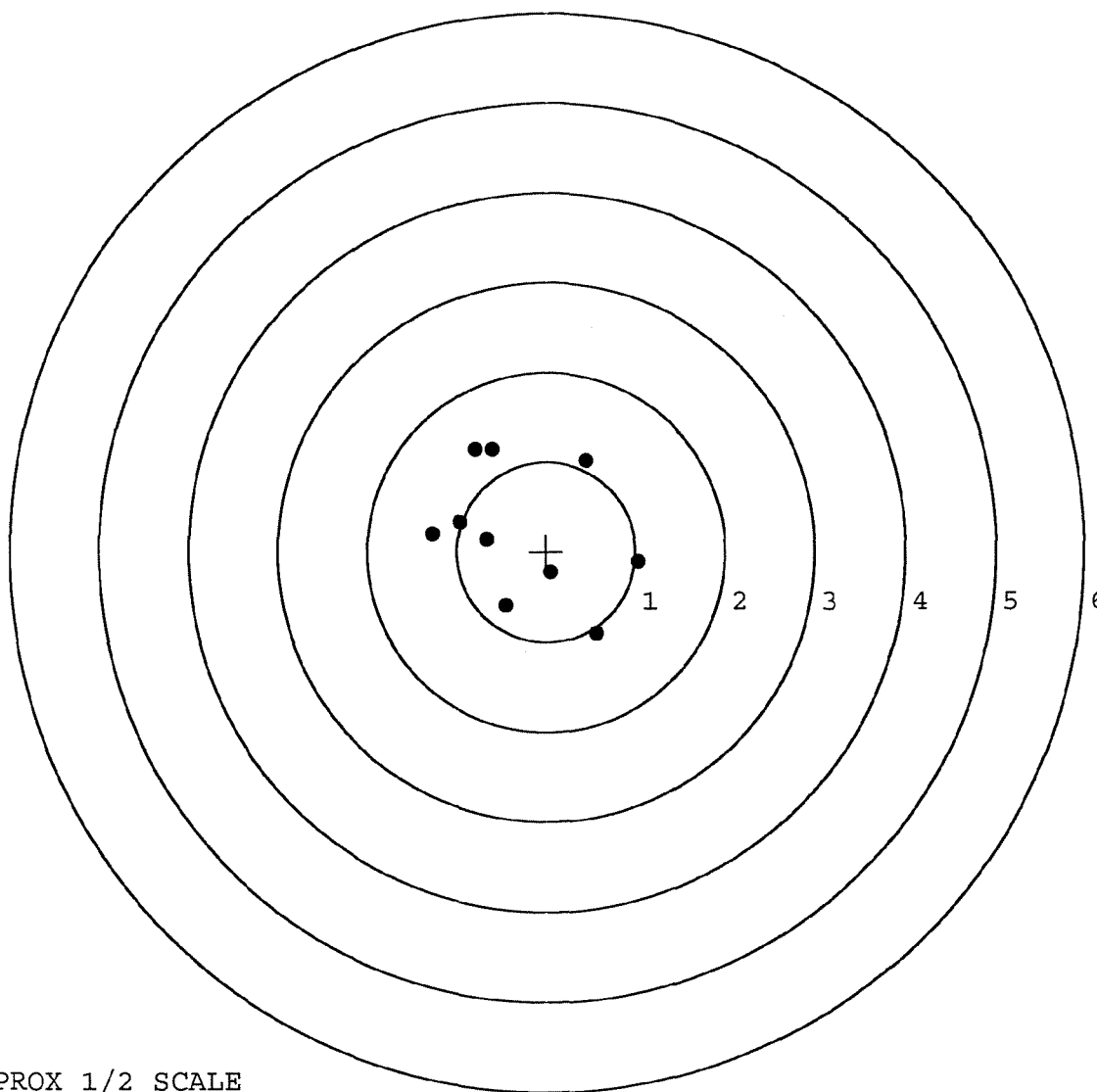
MEAN RADIUS: 0.940

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.036	-0.117
2:	0.565	-0.909
3:	0.053	-0.236
4:	-0.458	-0.605
5:	-0.665	0.135
6:	-0.972	0.330
7:	-1.278	0.198
8:	-0.788	1.145
9:	-0.605	1.146
10:	0.451	1.019



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591659.___0

TARGET NUMBER: 4

FILE DATE: 10/02/2006

FILE TIME: 23:08

X CENTROID: -0.094

Y CENTROID: 0.249

POA TO CENTROID: 0.266

HORZ SPREAD: 2.360

VERT SPREAD: 1.876

GROUP SPREAD: 2.932

MIN RADIUS: 0.085

MAX RADIUS: 1.542

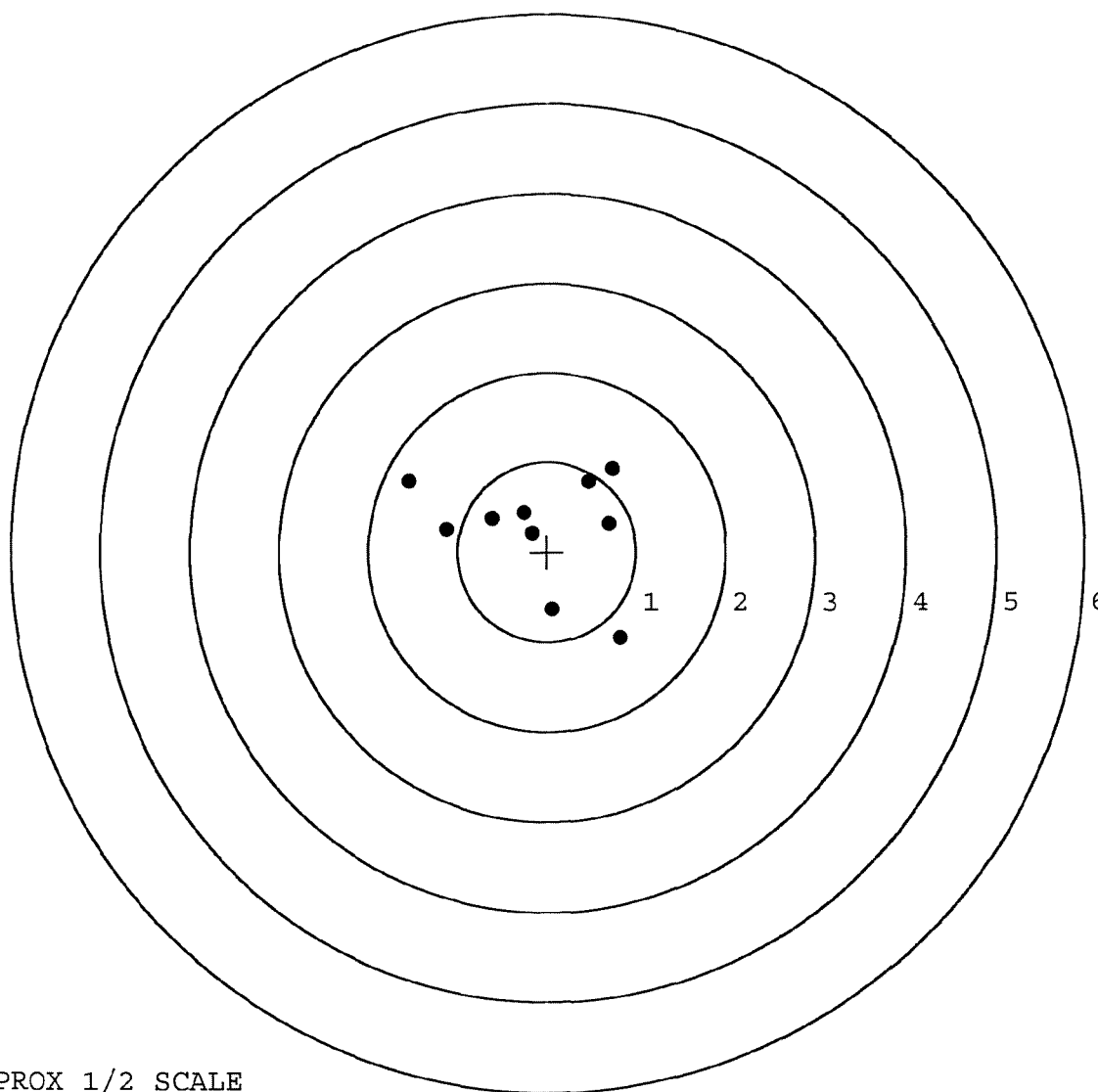
MEAN RADIUS: 0.850

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.820	-0.954
2:	0.059	-0.644
3:	0.689	0.318
4:	0.740	0.922
5:	0.467	0.784
6:	-0.172	0.213
7:	-0.262	0.436
8:	-0.616	0.375
9:	-1.128	0.250
10:	-1.540	0.785



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591659. 0

TARGET NUMBER: 5

FILE DATE: 10/02/2006

FILE TIME: 23:08

X CENTROID: -0.235

Y CENTROID: -0.003

POA TO CENTROID: 0.235

HORZ SPREAD: 1.355

VERT SPREAD: 2.311

GROUP SPREAD: 2.611

MIN RADIUS: 0.021

MAX RADIUS: 1.316

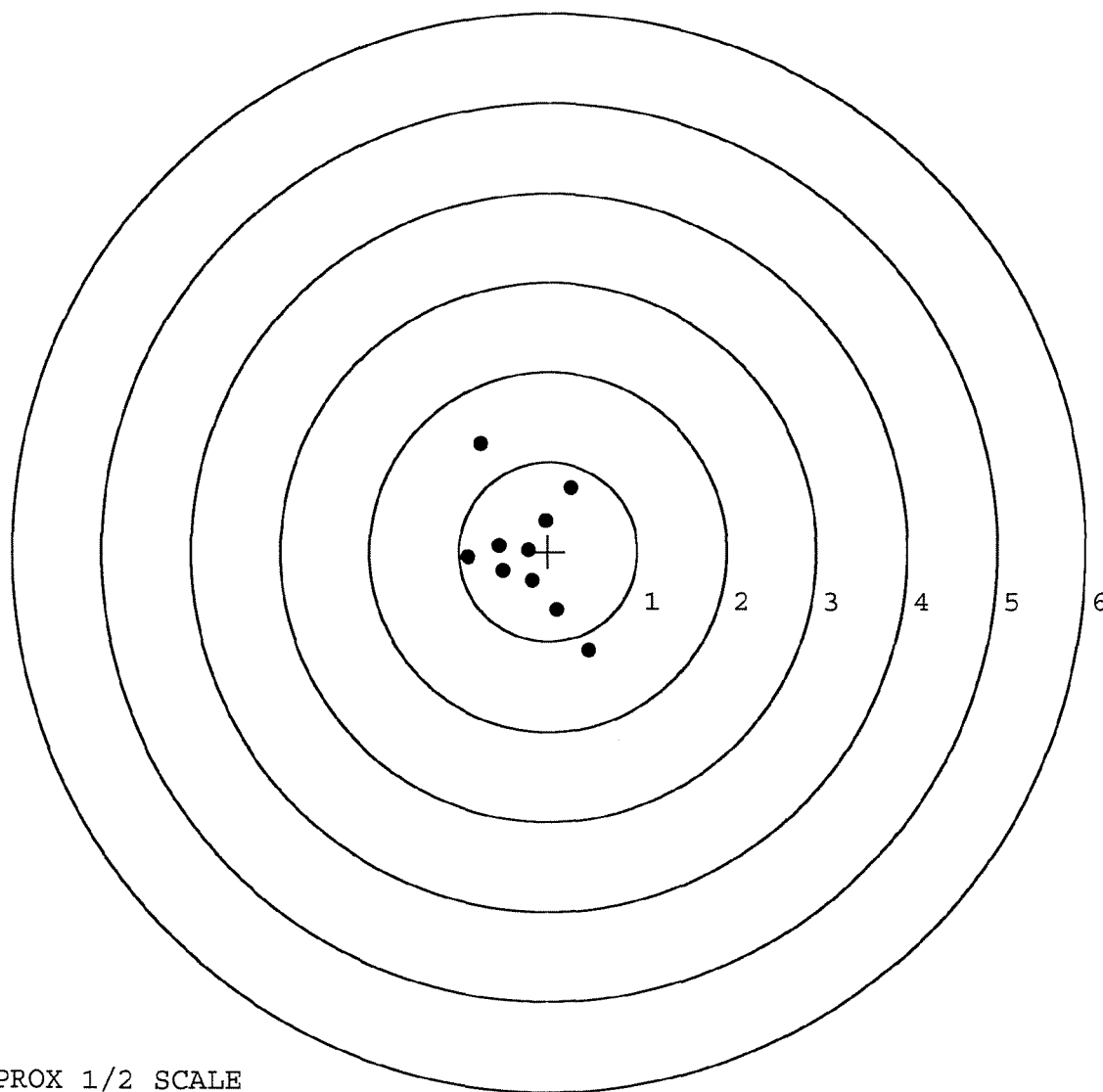
MEAN RADIUS: 0.629

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.460	-1.105
2:	0.096	-0.658
3:	-0.755	1.206
4:	0.247	0.710
5:	-0.039	0.340
6:	-0.895	-0.062
7:	-0.550	0.069
8:	-0.223	0.014
9:	-0.184	-0.329
10:	-0.511	-0.218



TARGET APPROX 1/2 SCALE