

G 659 1698

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

- INSTRUCTION BOOK 3518

DD FORM

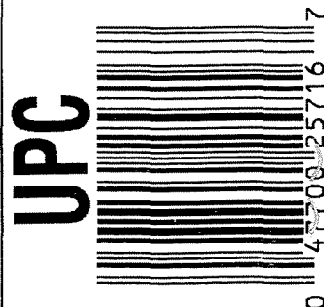


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6591690



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

UPC



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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591690

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-26-06	RTZ
420	ASSEMBLE ACTION		9-28-06	RTZ
430	ASSEMBLE TO STOCK		10-2-06	SD
440	PROOF		10-2-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-2-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 03 2006	10-2-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mmms</u>	10/3/06	u cond
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/4/06	DBB
510	DRILL AND TAP SIGHT HOLES		10-3-06	SD
520	GOFF BLAST BBL / REC		10-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/6/06	RTZ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-6-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-06	DA
	D) OIL FIRING PIN ASSEMBLY		10-12-06	ZLC
	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>8.0</u> <u>8.0</u> <u>8.0</u>	11-10-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.25</u> <u>4.25</u>	11-10-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	11-10-06	TRW
	J) ASSEMBLE STOCK		10-12-06	BLC
	K) ASSEMBLE SWIVEL STUDS		11-13-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-12-06	BLC
	M) IRON SIGHT ALIGNMENT		10-12-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-12-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-12-06	R.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/12	
670	FINAL INSPECTION A) HEADSPACE		11-13-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.53</u> <u>2.57</u> <u>2.75</u> <u>2.52</u>	10-25-06	DA
	C) FUNCTION		11-13-06	RTZ
690	PACK		11/17/06	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 10-10-06

TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.36		2.49	
PULL #2	2.44	2.60		2.57	
PULL #3	2.42	2.72		2.36	
PULL #4	2.34	2.68		2.44	
PULL #5	2.44	2.53		2.38	
TOTAL	1204	1289		1224	
AVERAGE	240	257		244	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	2.79		
PULL #2	3.21	2.82		
PULL #3	3.24	2.94		
PULL #4	3.30	2.98		
PULL #5	3.29	2.94		
TOTAL	1620	1447		
AVERAGE	324	289		

	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	3.98		4.31
PULL #2	4.13	4.10		4.20
PULL #3	4.03	4.22		4.22
PULL #4	4.09	4.16		4.27
PULL #5	4.07	4.28		4.19
TOTAL	2037	2074		2119
AVERAGE	407	414		423

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591690.__0
FILE DATE AND TIME: 10/13/2006 05:24

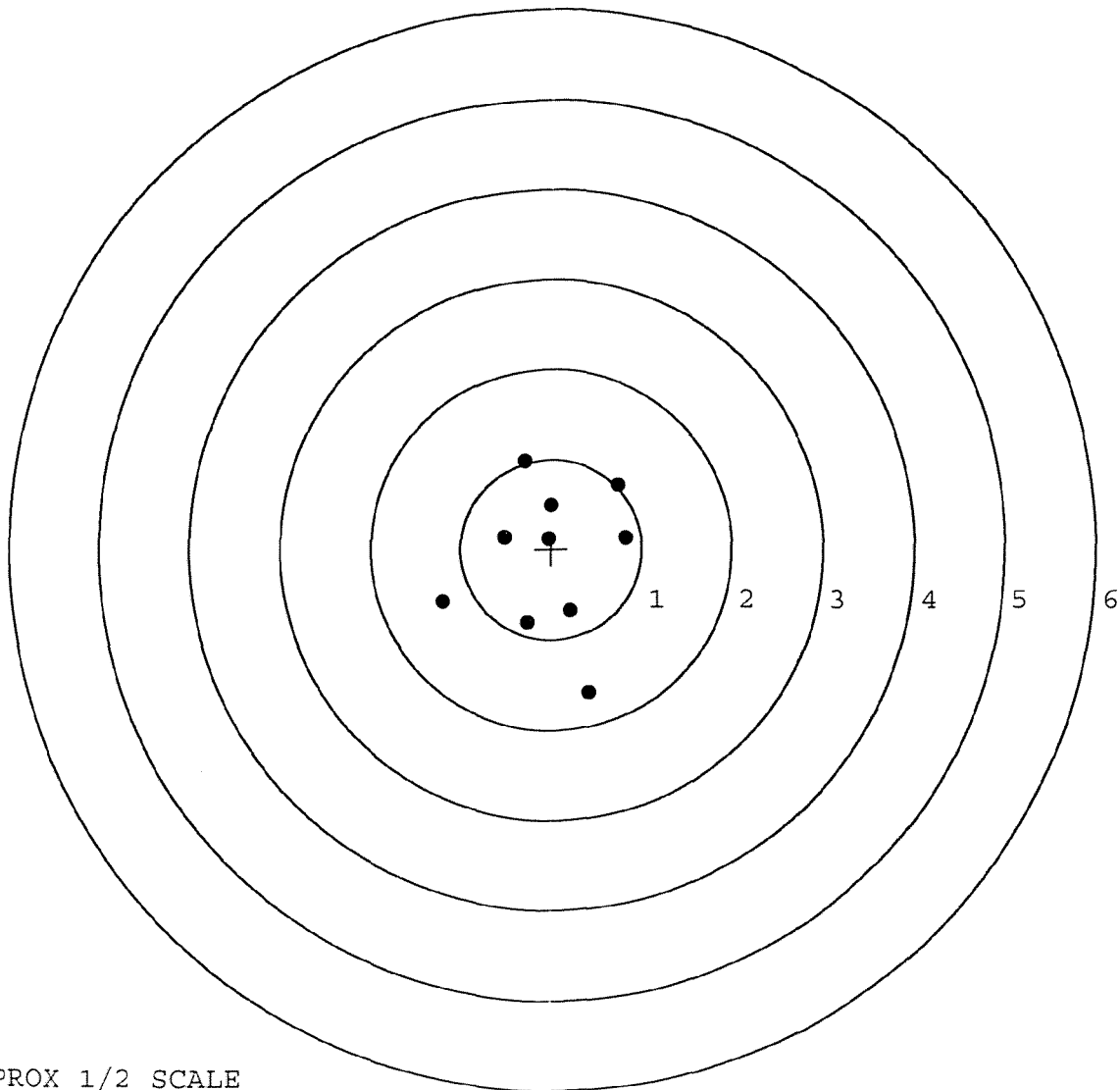
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.011
The Average Y Centroid of the Five Target Set:	-0.021
The Average Point of Impact of the Five Target Set:	0.023
The Average Mean Radius of the Five Target Set:	0.787
The Distance from POA to Centroid Target #1:	0.113
The Distance from Centroid Target #2 to Centroid Target #1:	0.197
The Distance from Centroid Target #3 to Centroid Target #1:	0.104
The Distance from Centroid Target #4 to Centroid Target #1:	0.097
The Distance from Centroid Target #5 to Centroid Target #1:	0.126

SERIAL NUMBER: G6591690. __0
TARGET NUMBER: 1
FILE DATE: 10/13/2006
FILE TIME: 05:24

POINT#	X	Y
1:	0.424	-1.592
2:	-1.195	-0.598
3:	-0.272	-0.817
4:	0.208	-0.688
5:	0.814	0.132
6:	0.737	0.716
7:	-0.297	0.982
8:	-0.009	0.492
9:	-0.033	0.118
10:	-0.526	0.138

X CENTROID: -0.015
Y CENTROID: -0.112
POA TO CENTROID: 0.113
HORZ SPREAD: 2.009
VERT SPREAD: 2.574
GROUP SPREAD: 2.673
MIN RADIUS: 0.230
MAX RADIUS: 1.544
MEAN RADIUS: 0.870
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

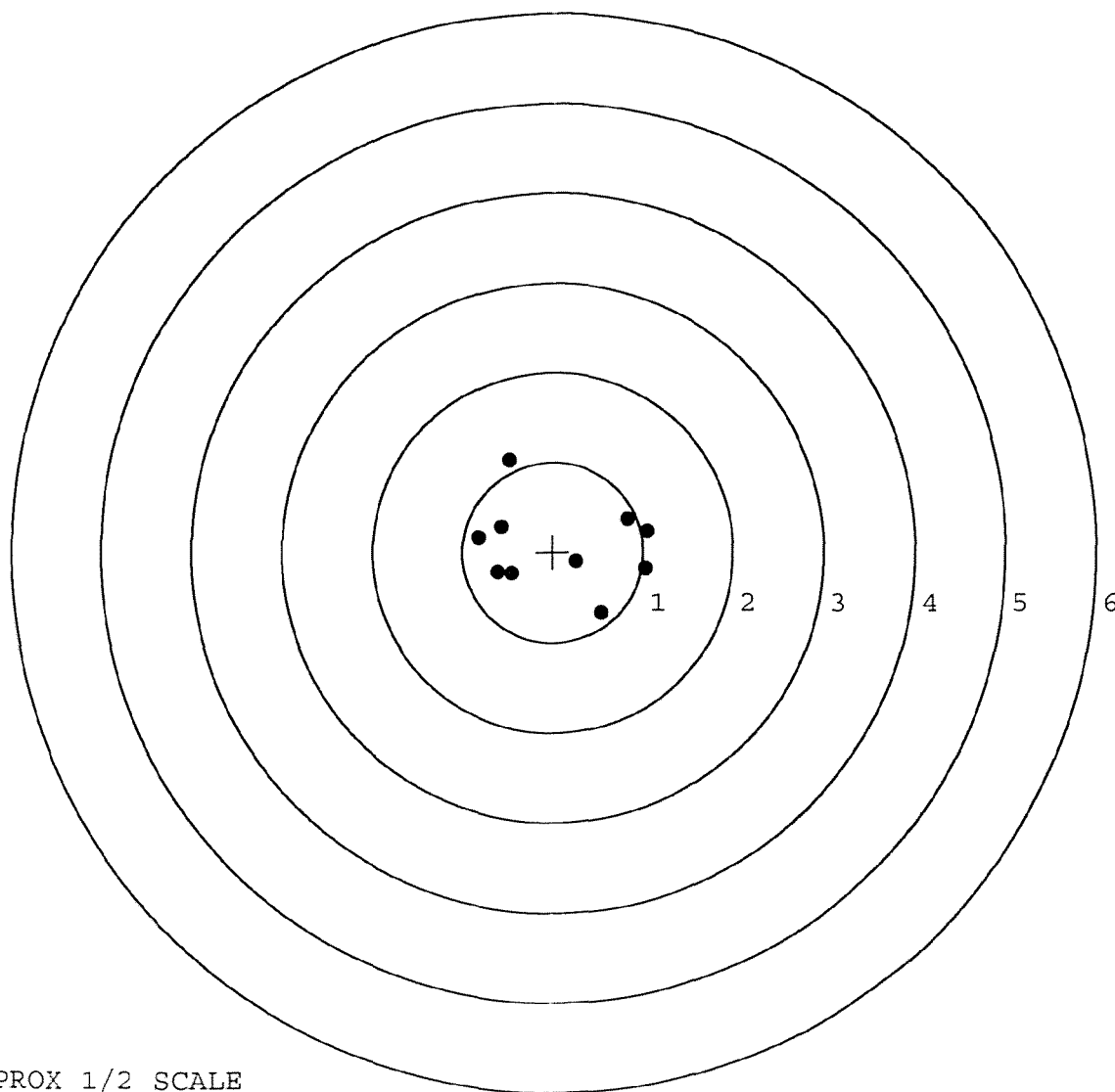


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591690.___0
TARGET NUMBER: 2
FILE DATE: 10/13/2006
FILE TIME: 05:24

POINT#	X	Y
1:	-0.484	1.024
2:	-0.577	0.283
3:	-0.828	0.158
4:	-0.611	-0.226
5:	0.537	-0.677
6:	0.264	-0.112
7:	1.030	-0.179
8:	1.043	0.237
9:	0.822	0.372
10:	-0.457	-0.236

X CENTROID: 0.074
Y CENTROID: 0.064
POA TO CENTROID: 0.098
HORZ SPREAD: 1.871
VERT SPREAD: 1.701
GROUP SPREAD: 1.984
MIN RADIUS: 0.259
MAX RADIUS: 1.110
MEAN RADIUS: 0.797
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

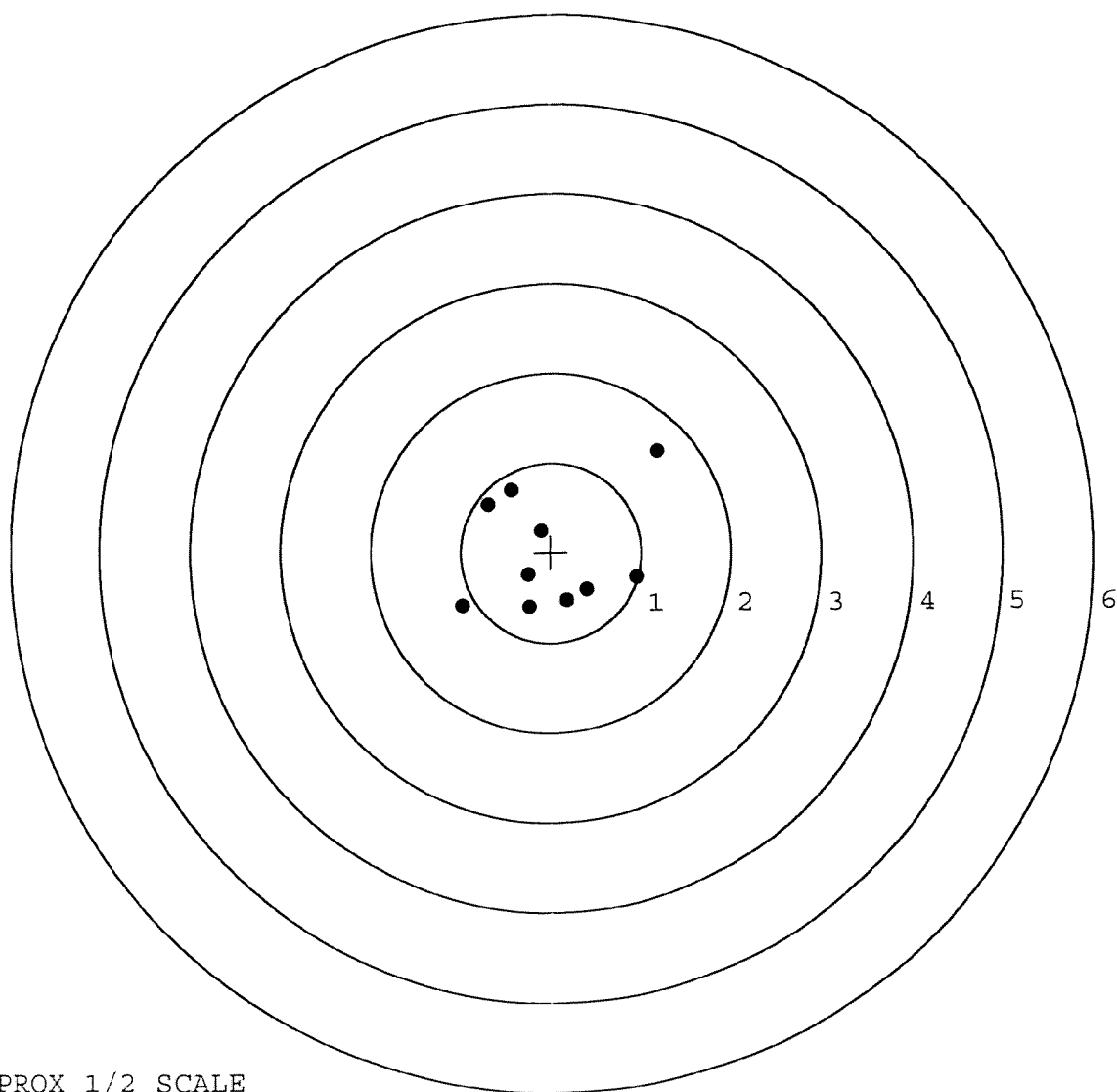


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591690. __0
TARGET NUMBER: 3
FILE DATE: 10/13/2006
FILE TIME: 05:24

X CENTROID: -0.003
Y CENTROID: -0.008
POA TO CENTROID: 0.009
HORZ SPREAD: 2.168
VERT SPREAD: 1.733
GROUP SPREAD: 2.764
MIN RADIUS: 0.266
MAX RADIUS: 1.641
MEAN RADIUS: 0.787
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.182	1.127
2:	0.948	-0.274
3:	0.395	-0.416
4:	0.176	-0.538
5:	-0.242	-0.606
6:	-0.986	-0.588
7:	-0.259	-0.252
8:	-0.107	0.237
9:	-0.443	0.696
10:	-0.696	0.534



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591690.___0

TARGET NUMBER: 4

FILE DATE: 10/13/2006

FILE TIME: 05:24

POINT#	X	Y
1:	0.103	-1.546
2:	-0.349	1.520
3:	0.481	0.888
4:	0.545	0.251
5:	-0.284	0.405
6:	-1.797	-0.051
7:	-0.269	-0.025
8:	0.235	-0.892
9:	0.207	-0.698
10:	0.150	-0.462

X CENTROID: -0.098

Y CENTROID: -0.061

POA TO CENTROID: 0.115

HORZ SPREAD: 2.342

VERT SPREAD: 3.066

GROUP SPREAD: 2.464

MIN RADIUS: 0.175

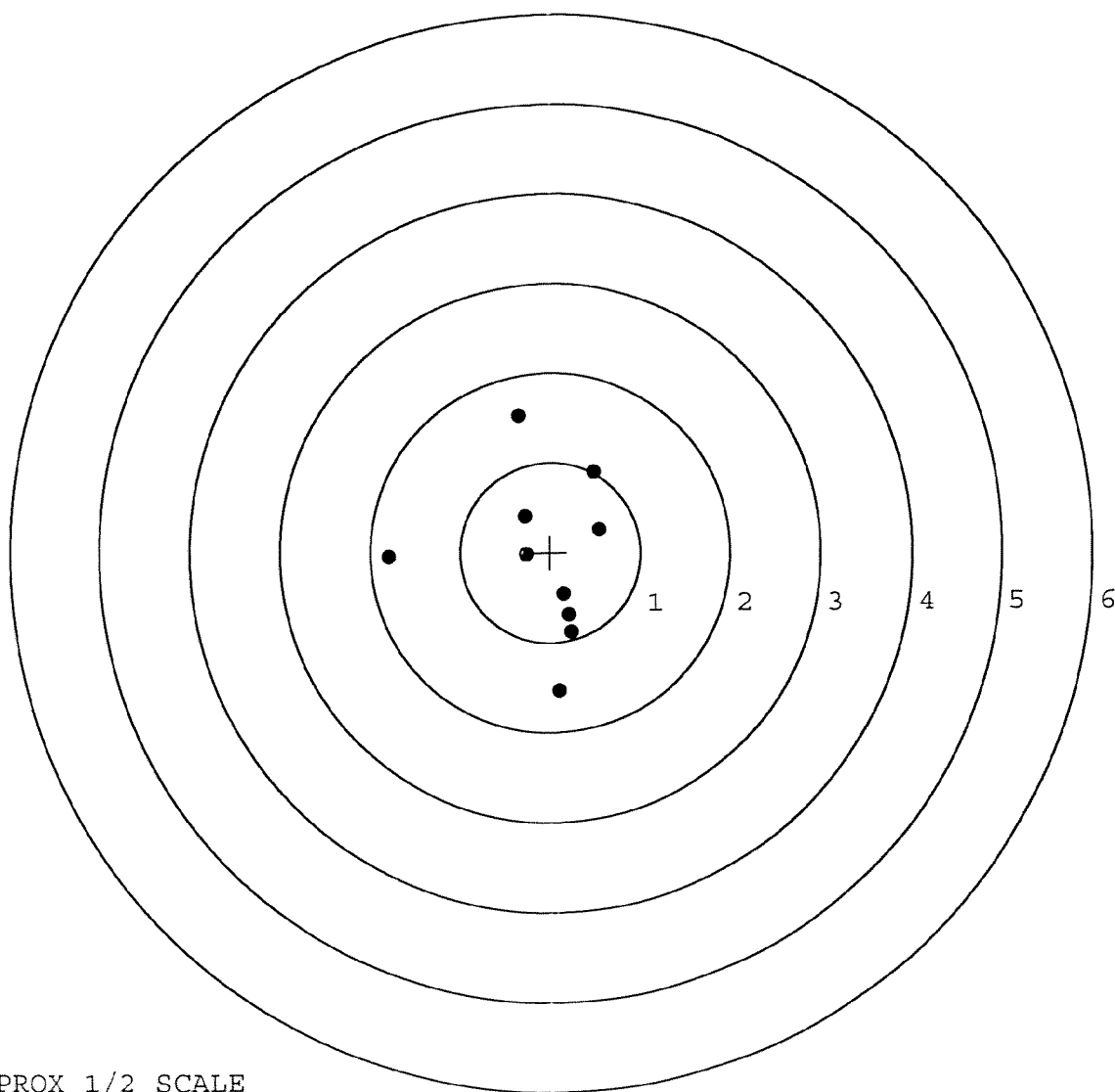
MAX RADIUS: 1.699

MEAN RADIUS: 0.937

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

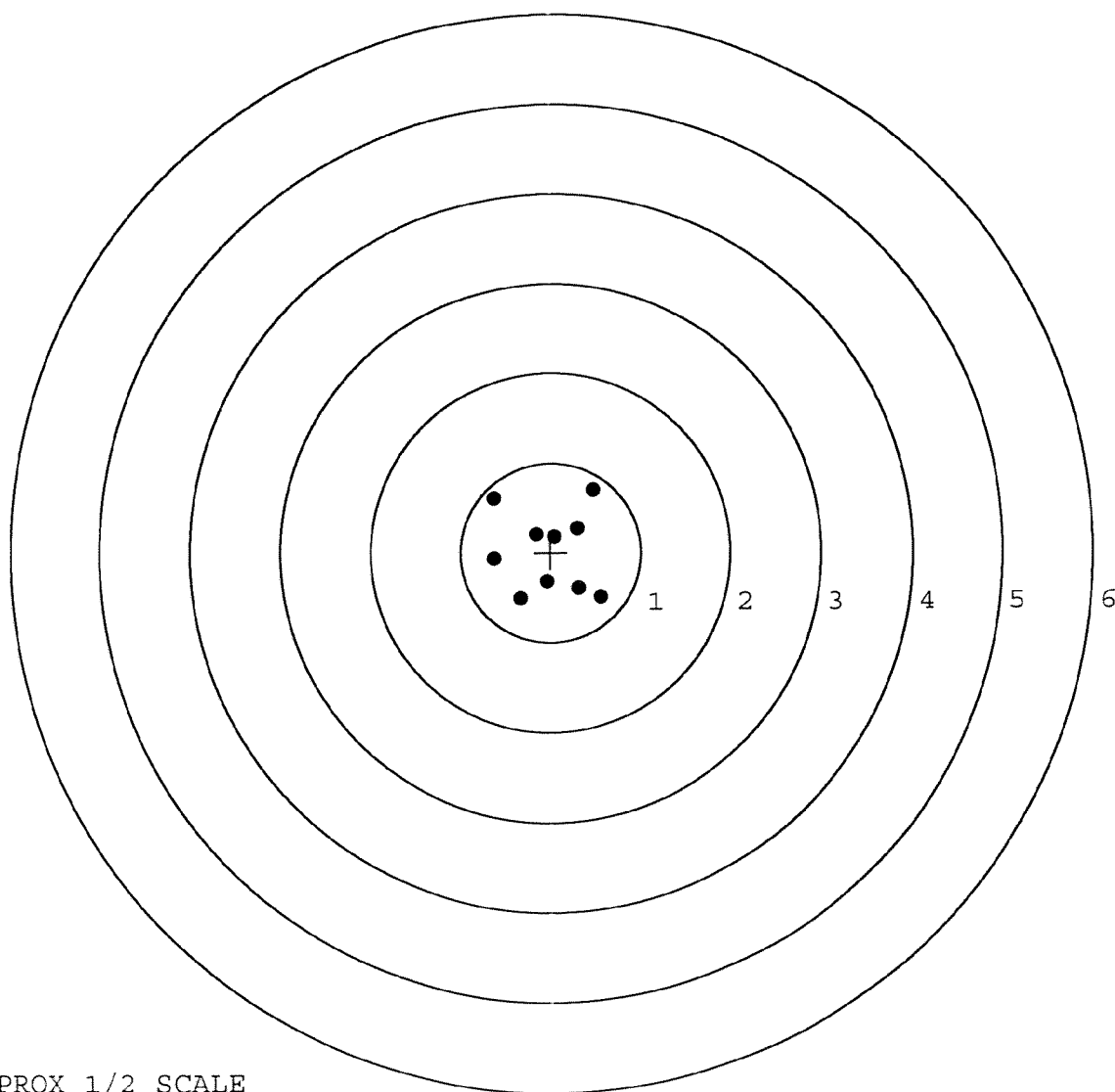


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591690.___0
TARGET NUMBER: 5
FILE DATE: 10/13/2006
FILE TIME: 05:24

POINT#	X	Y
1:	0.557	-0.505
2:	0.307	-0.405
3:	-0.042	-0.331
4:	-0.339	-0.515
5:	-0.629	-0.069
6:	-0.629	0.610
7:	0.470	0.699
8:	0.299	0.269
9:	0.046	0.179
10:	-0.163	0.206

X CENTROID: -0.012
Y CENTROID: 0.014
POA TO CENTROID: 0.018
HORZ SPREAD: 1.186
VERT SPREAD: 1.214
GROUP SPREAD: 1.628
MIN RADIUS: 0.175
MAX RADIUS: 0.858
MEAN RADIUS: 0.540
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE