

G 6644493

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



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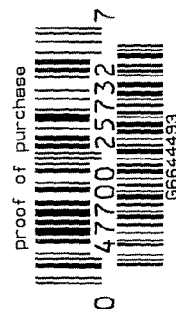
SERIAL NO.



M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

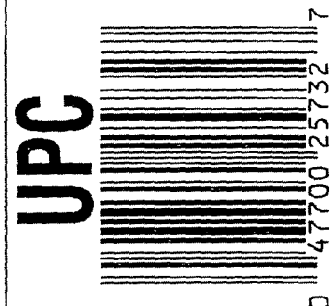
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6644493



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6644493

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-7-07	RTZ
420	ASSEMBLE ACTION		5-4-07	A.P.D.
430	ASSEMBLE TO STOCK		5-7-07	TRW
440	PROOF	MAGNA - FLUX	5-7-07	Fm
460	CHECK HEADSPACE	MAY 10 2000	5-7-07	Fm
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION	OPERATOR <u>amuel</u>	5/10/07	amuel
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-09-07	CW
510	DRILL AND TAP SIGHT HOLES		5-9-07	TRW
520	GOFF BLAST BBL / REC		5-10-07	CB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5-12-07	WJ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-07	A.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-07	A.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-07	A.P.D.
	D) OIL FIRING PIN ASSEMBLY		5-24-07	A.P.D.
	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>7.0</u> <u>7.0</u> <u>7.0</u>	6-07-07	Fm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>3.75</u> <u>3.75</u>	6-7-07	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.025</u>	6-7-07	Fm
	J) ASSEMBLE STOCK		5-24-07	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		6-7-07	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	5/3/07	nm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-31-07	SD
670	FINAL INSPECTION A) HEADSPACE		6-7-07	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.22</u> <u>2.29</u> <u>2.28</u> <u>2.19</u>	6-7-07	Fm
	C) FUNCTION		6-7-07	L.P.D.
690	PACK		6-12-07	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 5-24-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.57	2.70		2.82	
PULL #2	2.62	2.72		2.71	
PULL #3	2.70	2.74		2.66	
PULL #4	2.74	2.74		2.77	
PULL #5	2.71	2.75		2.68	
TOTAL	13.34	13.65		13.64	
AVERAGE	2.66	2.73		2.72	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.22		
PULL #2	3.22	3.17		
PULL #3	3.22	3.21		
PULL #4	3.27	3.26		
PULL #5	3.31	3.17		
TOTAL	16.22	16.03		
AVERAGE	3.24	3.20		

	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	3.98		4.25
PULL #2	4.07	4.17		4.16
PULL #3	4.09	4.36		4.13
PULL #4	4.03	4.30		4.19
PULL #5	4.01	4.18		4.21
TOTAL	20.24	20.99		20.94
AVERAGE	4.04	4.19		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6644493.__0
FILE DATE AND TIME: 06/01/2007 15:30

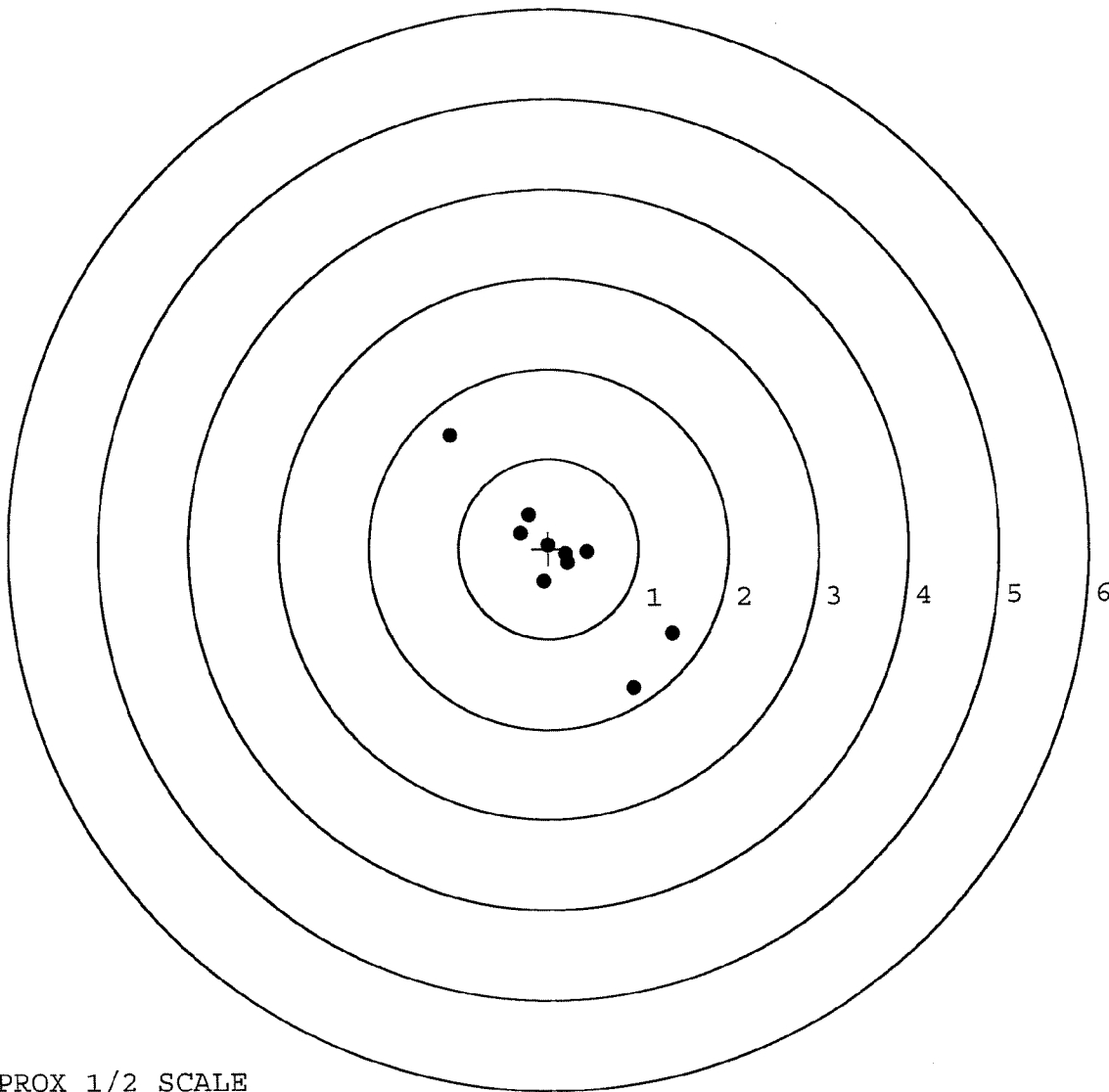
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.056
The Average Y Centroid of the Five Target Set:	-0.076
The Average Point of Impact of the Five Target Set:	0.095
The Average Mean Radius of the Five Target Set:	0.639
The Distance from POA to Centroid Target #1:	0.195
The Distance from Centroid Target #2 to Centroid Target #1:	0.146
The Distance from Centroid Target #3 to Centroid Target #1:	0.229
The Distance from Centroid Target #4 to Centroid Target #1:	0.172
The Distance from Centroid Target #5 to Centroid Target #1:	0.064

SERIAL NUMBER: G6644493. __0
TARGET NUMBER: 1
FILE DATE: 06/01/2007
FILE TIME: 15:30

X CENTROID: 0.145
Y CENTROID: -0.130
POA TO CENTROID: 0.195
HORZ SPREAD: 2.444
VERT SPREAD: 2.828
GROUP SPREAD: 3.470
MIN RADIUS: 0.074
MAX RADIUS: 1.861
MEAN RADIUS: 0.712
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.217	0.379
2:	-0.311	0.169
3:	-0.054	-0.371
4:	0.212	-0.161
5:	0.427	-0.042
6:	0.191	-0.066
7:	-0.008	0.037
8:	-1.081	1.270
9:	0.929	-1.558
10:	1.363	-0.955

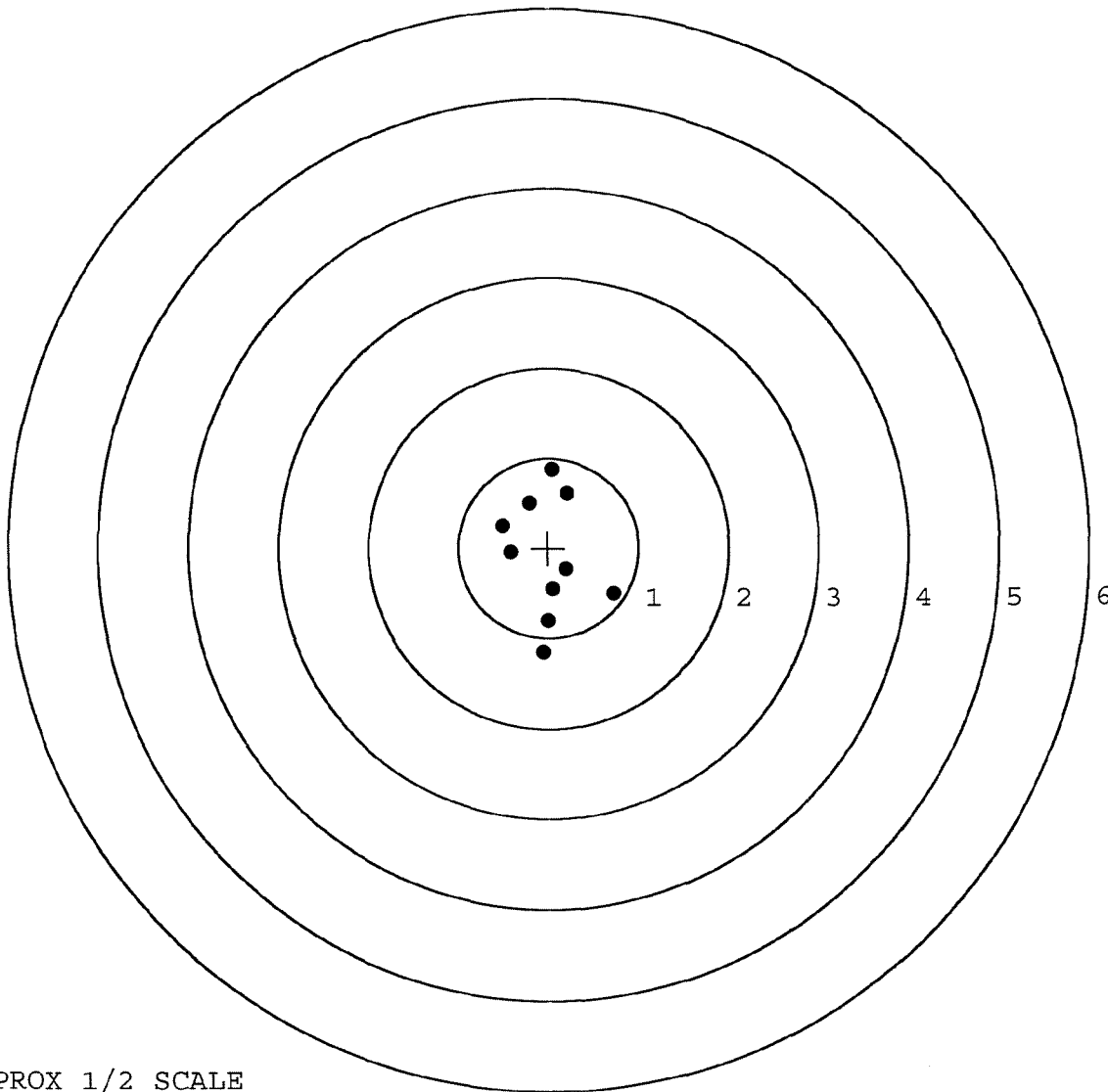


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644493. __0
TARGET NUMBER: 2
FILE DATE: 06/01/2007
FILE TIME: 15:30

X CENTROID: 0.002
Y CENTROID: -0.101
POA TO CENTROID: 0.101
HORZ SPREAD: 1.229
VERT SPREAD: 2.042
GROUP SPREAD: 2.044
MIN RADIUS: 0.234
MAX RADIUS: 1.067
MEAN RADIUS: 0.661
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.208	0.609
2:	0.045	0.876
3:	-0.213	0.503
4:	-0.416	-0.052
5:	0.194	-0.234
6:	0.050	-0.465
7:	-0.009	-0.818
8:	-0.056	-1.166
9:	0.721	-0.511
10:	-0.508	0.250

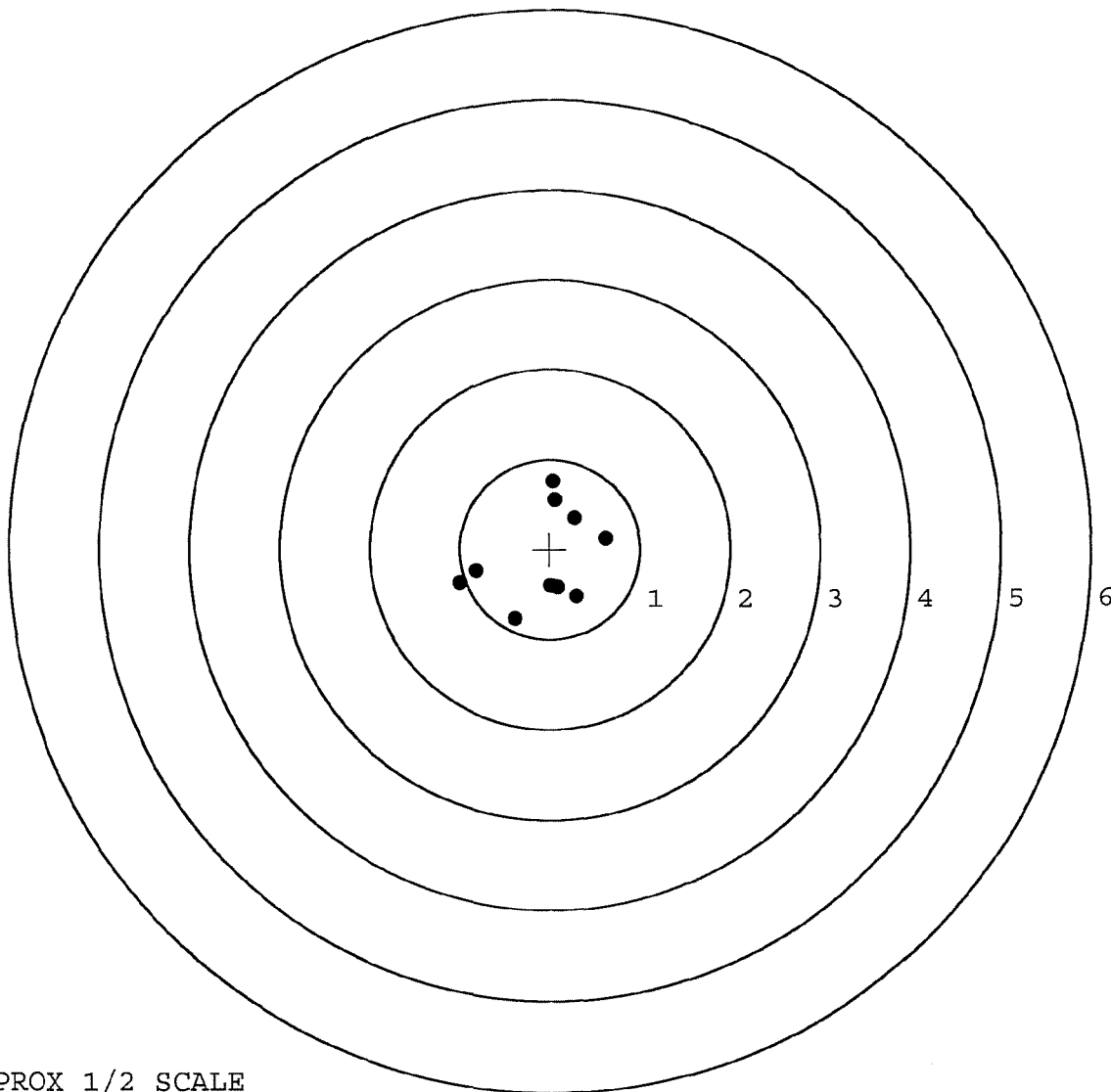


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644493. 0
TARGET NUMBER: 3
FILE DATE: 06/01/2007
FILE TIME: 15:30

X CENTROID: -0.081
Y CENTROID: -0.098
POA TO CENTROID: 0.127
HORZ SPREAD: 1.627
VERT SPREAD: 1.536
GROUP SPREAD: 1.702
MIN RADIUS: 0.325
MAX RADIUS: 0.964
MEAN RADIUS: 0.657
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.038	0.760
2:	0.056	0.550
3:	0.276	0.344
4:	0.623	0.122
5:	0.298	-0.532
6:	0.092	-0.428
7:	0.013	-0.409
8:	-0.389	-0.776
9:	-0.817	-0.234
10:	-1.004	-0.377



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644493. __0

TARGET NUMBER: 4

FILE DATE: 06/01/2007

FILE TIME: 15:30

POINT#	X	Y
1:	0.646	0.651
2:	0.463	0.309
3:	0.105	0.127
4:	-0.712	0.480
5:	-0.394	0.390
6:	-0.381	-0.101
7:	-0.034	-0.232
8:	0.630	-0.568
9:	0.643	-1.046
10:	0.243	0.397

X CENTROID: 0.121

Y CENTROID: 0.041

POA TO CENTROID: 0.128

HORZ SPREAD: 1.358

VERT SPREAD: 1.697

GROUP SPREAD: 2.041

MIN RADIUS: 0.088

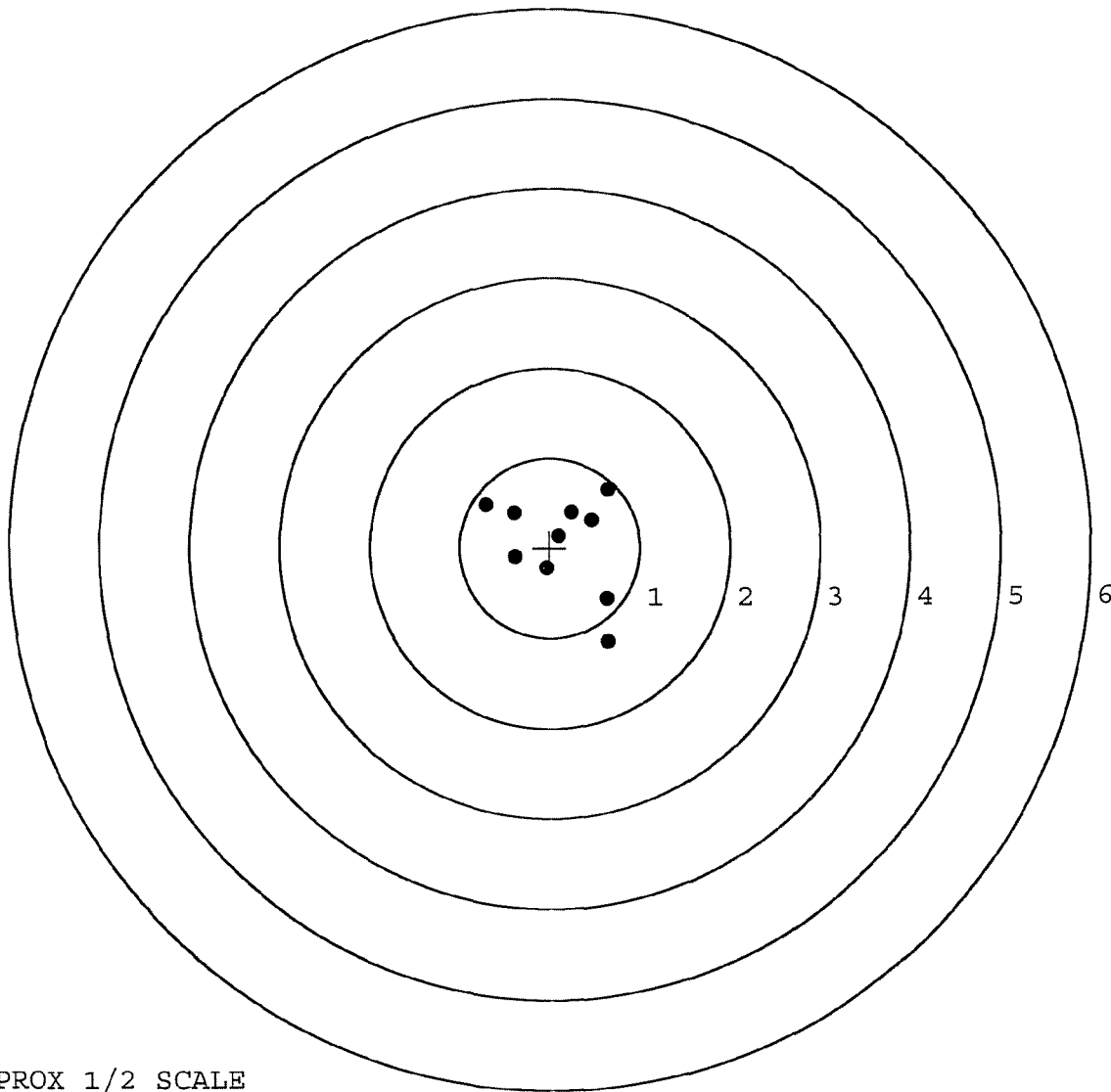
MAX RADIUS: 1.206

MEAN RADIUS: 0.610

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6644493. __0

TARGET NUMBER: 5

FILE DATE: 06/01/2007

FILE TIME: 15:30

POINT#	X	Y
1:	0.243	1.120
2:	-0.346	0.161
3:	-0.708	0.014
4:	0.588	0.083
5:	0.319	0.148
6:	0.075	-0.159
7:	0.417	-0.356
8:	0.103	-0.376
9:	0.003	-0.644
10:	0.235	-0.925

X CENTROID: 0.093

Y CENTROID: -0.093

POA TO CENTROID: 0.132

HORZ SPREAD: 1.296

VERT SPREAD: 2.045

GROUP SPREAD: 2.045

MIN RADIUS: 0.068

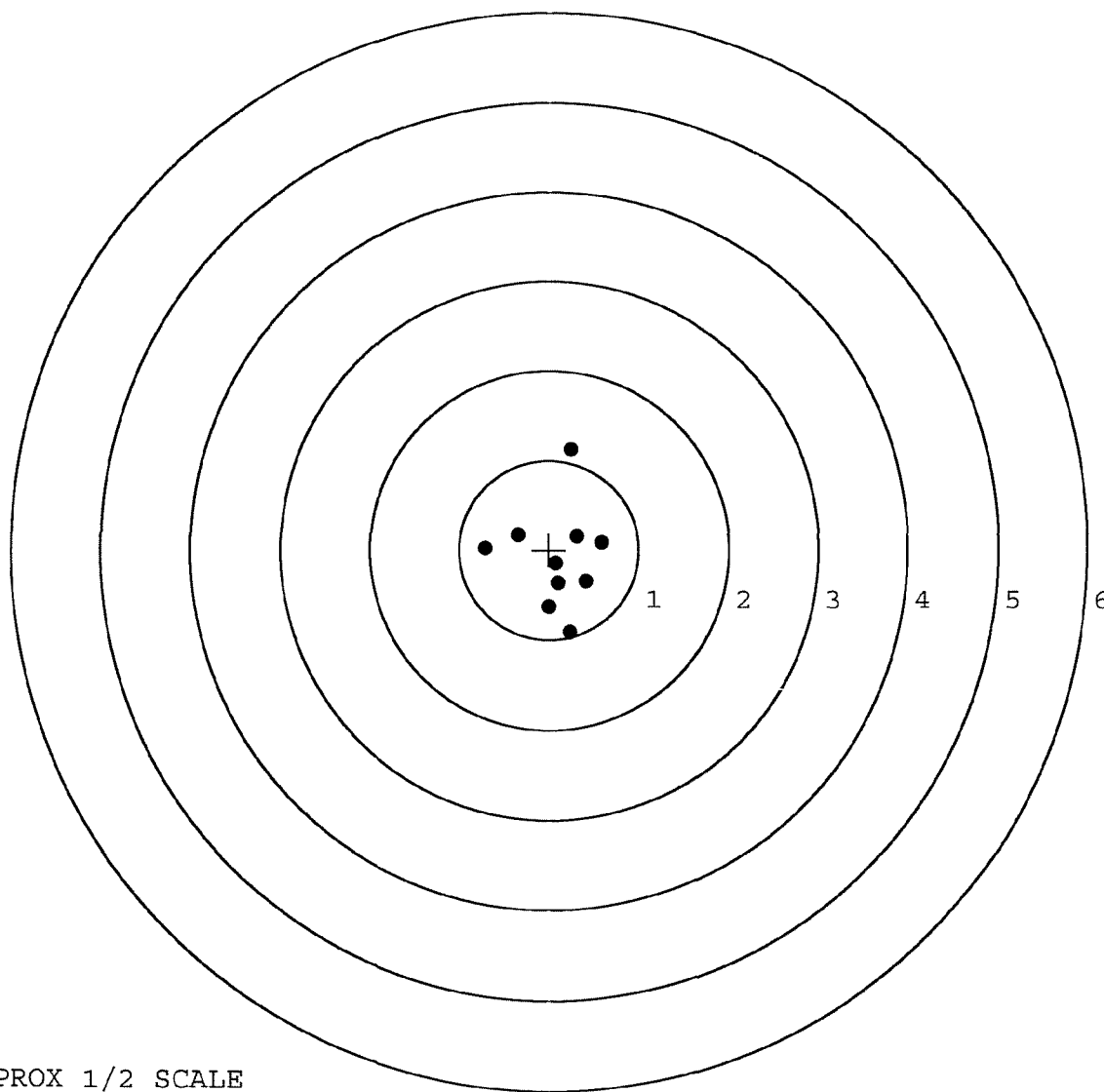
MAX RADIUS: 1.223

MEAN RADIUS: 0.556

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE