

G6645610

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

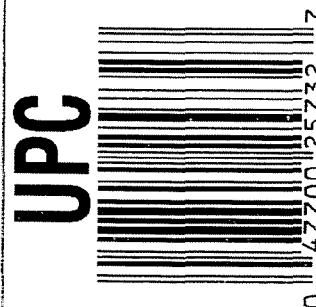


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6645610



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66645610

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-7-07	RJL
420	ASSEMBLE ACTION		5-4-07	SPD
430	ASSEMBLE TO STOCK		5-7-07	TRW
440	PROOF	MAGNA FLUX	5-7-07	Fm
460	CHECK HEADSPACE	MAY 10 2008	5-7-07	Fm
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION	OPERATOR <i>unm</i>	5/10/07	<i>unm</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-9-07	CW
510	DRILL AND TAP SIGHT HOLES		5-9-07	TRW
520	GOFF BLAST BBL / REC		5-10-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5-12-07	W
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-07	SPD
	D) OIL FIRING PIN ASSEMBLY		5-25-07	SPD
	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>6.0</u> <u>6.0</u> <u>6.0</u>	6-7-07	Fm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>3.5</u>	6-7-07	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	6-7-07	Fm
	J) ASSEMBLE STOCK		5-25-07	SPD
	K) ASSEMBLE SWIVEL STUDS		6-13-07	SPD
	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	5/29/07	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5/29/07	SD
670	FINAL INSPECTION A) HEADSPACE		6/8/07	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u> <u>2.72</u> <u>2.78</u> <u>2.71</u> <u>2.73</u>	6-7-07	Fm
	C) FUNCTION		6/8/07	mm
690	PACK		6/14/07	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 5-25-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.59		2.38	
PULL #2	2.50	2.36		2.45	
PULL #3	2.59	2.37		2.50	
PULL #4	2.60	2.48		2.46	
PULL #5	2.59	2.65		2.51	
TOTAL	12.62	12.45		12.30	
AVERAGE	2.52	2.49		2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.15		
PULL #2	3.02	3.28		
PULL #3	3.37	3.27		
PULL #4	3.34	3.44		
PULL #5	3.39	3.31		
TOTAL	16.29	16.49		
AVERAGE	3.25	3.29		

	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	4.46	4.16		4.00
PULL #2	4.34	4.22		4.00
PULL #3	4.37	4.36		4.03
PULL #4	4.54	4.44		4.10
PULL #5	4.50	4.32		3.99
TOTAL	22.21	21.50		20.12
AVERAGE	4.44	4.30		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645610.__0
FILE DATE AND TIME: 05/30/2007 05:03

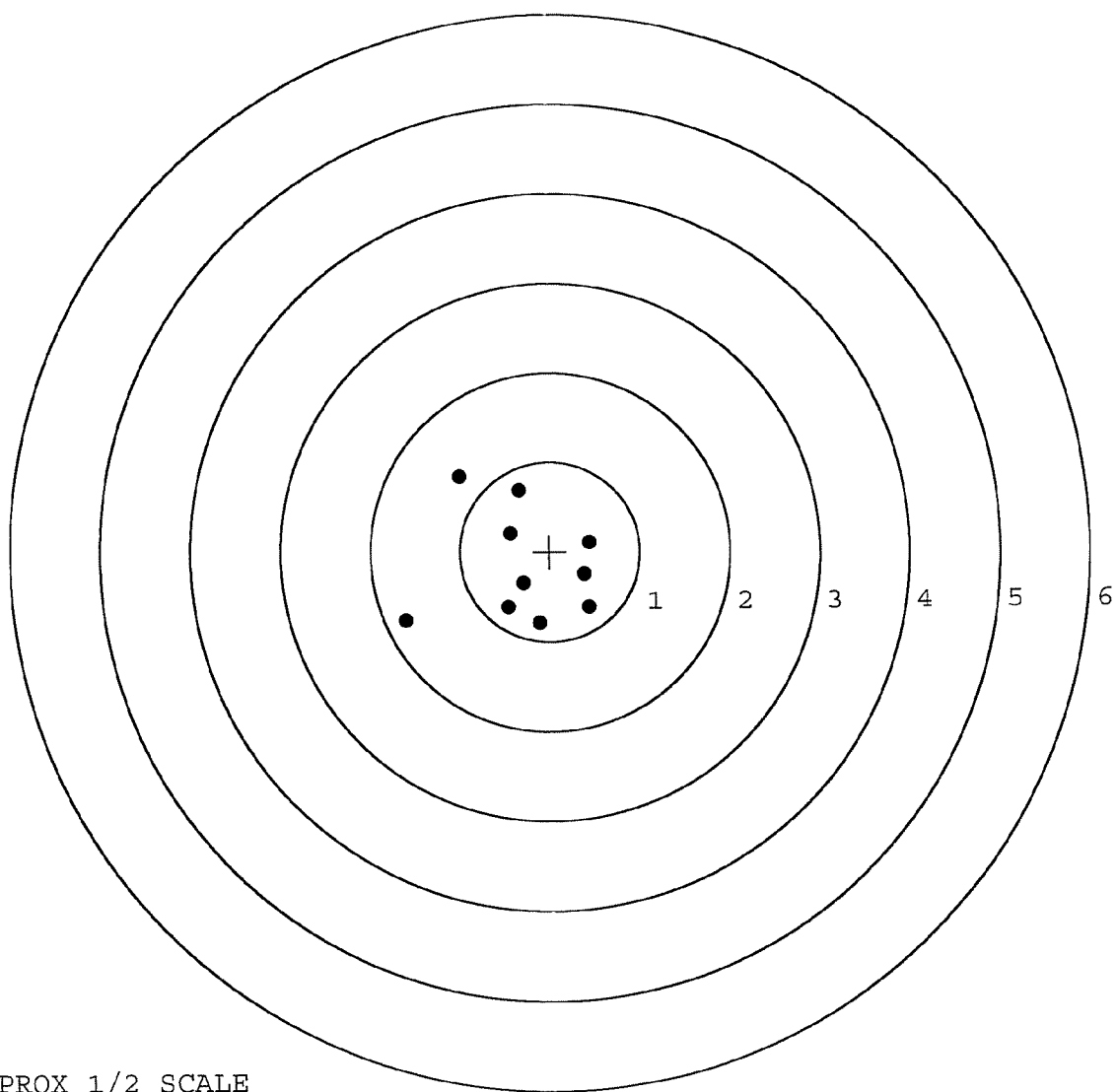
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.186
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.198
The Average Mean Radius of the Five Target Set:	0.697
The Distance from POA to Centroid Target #1:	0.338
The Distance from Centroid Target #2 to Centroid Target #1:	0.164
The Distance from Centroid Target #3 to Centroid Target #1:	0.232
The Distance from Centroid Target #4 to Centroid Target #1:	0.239
The Distance from Centroid Target #5 to Centroid Target #1:	0.226

SERIAL NUMBER: G6645610.___0
TARGET NUMBER: 1
FILE DATE: 05/30/2007
FILE TIME: 05:03

X CENTROID: -0.300
Y CENTROID: -0.156
POA TO CENTROID: 0.338
HORZ SPREAD: 2.055
VERT SPREAD: 1.638
GROUP SPREAD: 2.227
MIN RADIUS: 0.195
MAX RADIUS: 1.443
MEAN RADIUS: 0.757
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.994	0.844
2:	-0.336	0.681
3:	-0.437	0.201
4:	0.444	0.102
5:	0.385	-0.248
6:	0.435	-0.619
7:	-0.118	-0.794
8:	-0.466	-0.615
9:	-0.300	-0.351
10:	-1.611	-0.757



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645610.___0

TARGET NUMBER: 2

FILE DATE: 05/30/2007

FILE TIME: 05:03

X CENTROID: -0.182

Y CENTROID: -0.041

POA TO CENTROID: 0.187

HORZ SPREAD: 1.723

VERT SPREAD: 1.484

GROUP SPREAD: 1.912

MIN RADIUS: 0.191

MAX RADIUS: 1.056

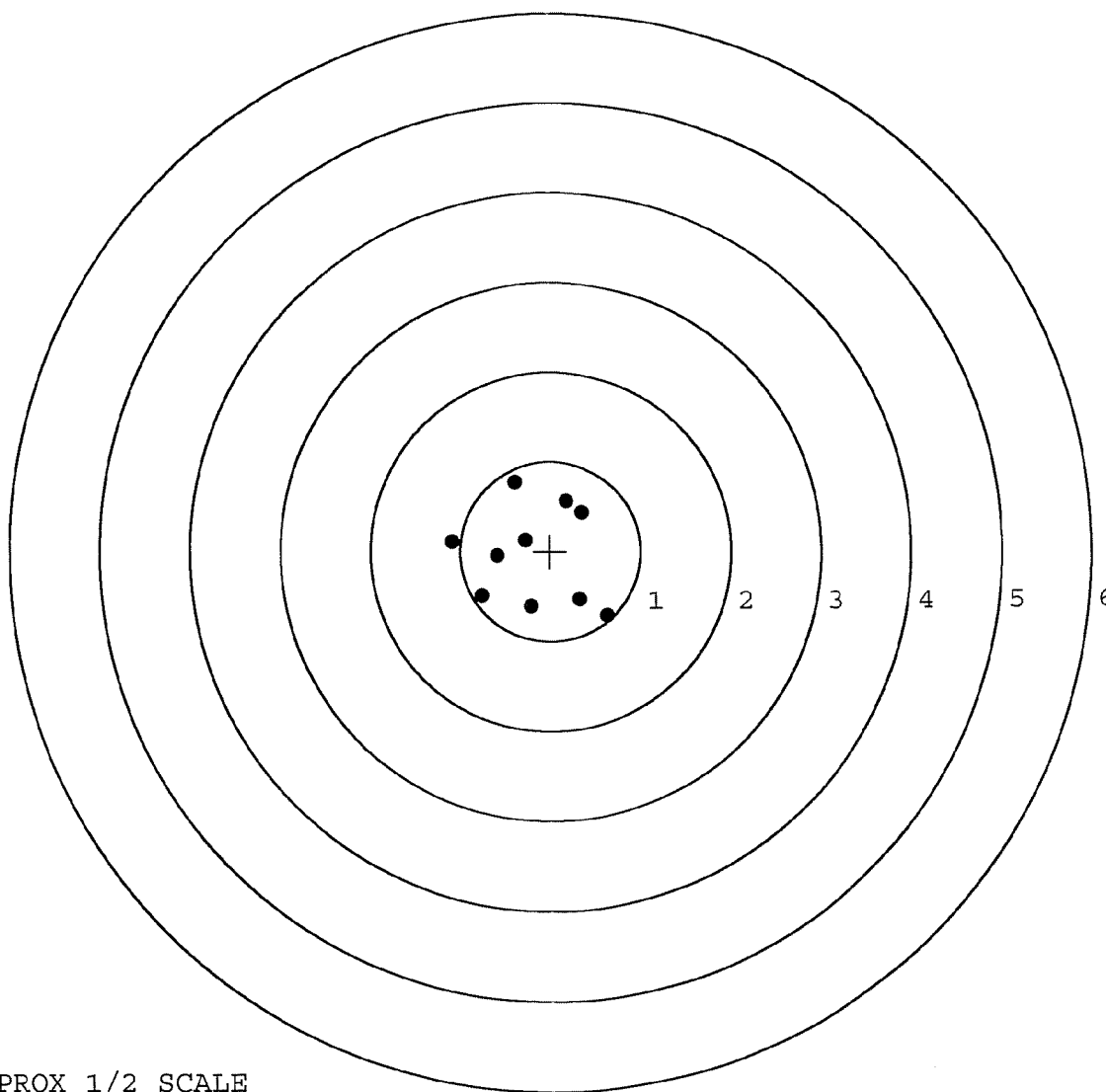
MEAN RADIUS: 0.686

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.632	-0.714
2:	0.330	-0.536
3:	-0.216	-0.617
4:	-0.763	-0.490
5:	-0.593	-0.050
6:	-0.279	0.123
7:	0.359	0.427
8:	0.186	0.557
9:	-0.387	0.770
10:	-1.091	0.116

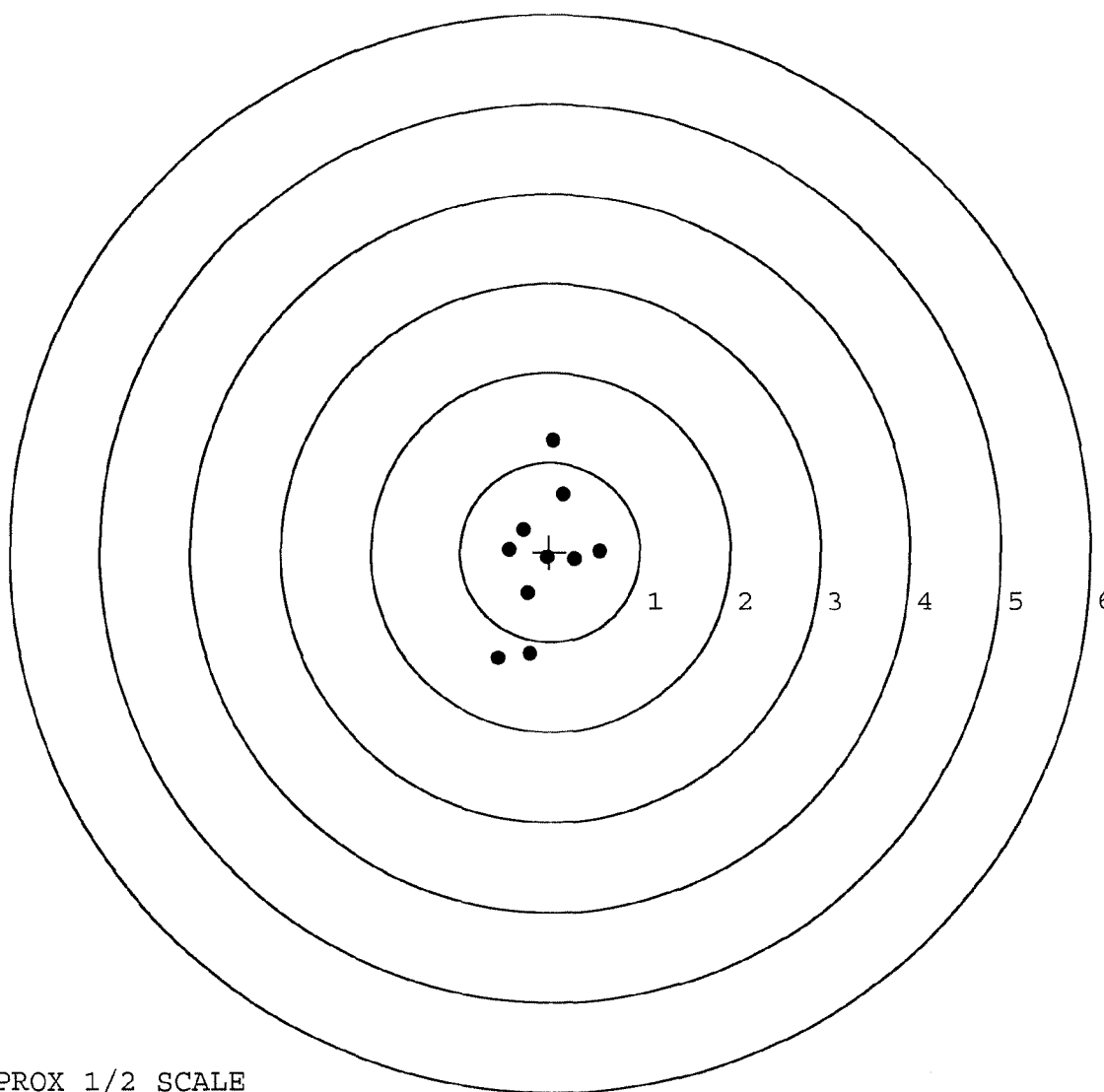


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645610. __ 0
TARGET NUMBER: 3
FILE DATE: 05/30/2007
FILE TIME: 05:03

X CENTROID: -0.083
Y CENTROID: -0.074
POA TO CENTROID: 0.111
HORZ SPREAD: 1.139
VERT SPREAD: 2.431
GROUP SPREAD: 2.508
MIN RADIUS: 0.057
MAX RADIUS: 1.324
MEAN RADIUS: 0.664
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.035	1.245
2:	0.150	0.646
3:	0.556	0.016
4:	0.278	-0.074
5:	-0.027	-0.061
6:	-0.251	-0.464
7:	-0.230	-1.140
8:	-0.583	-1.186
9:	-0.457	0.029
10:	-0.298	0.251

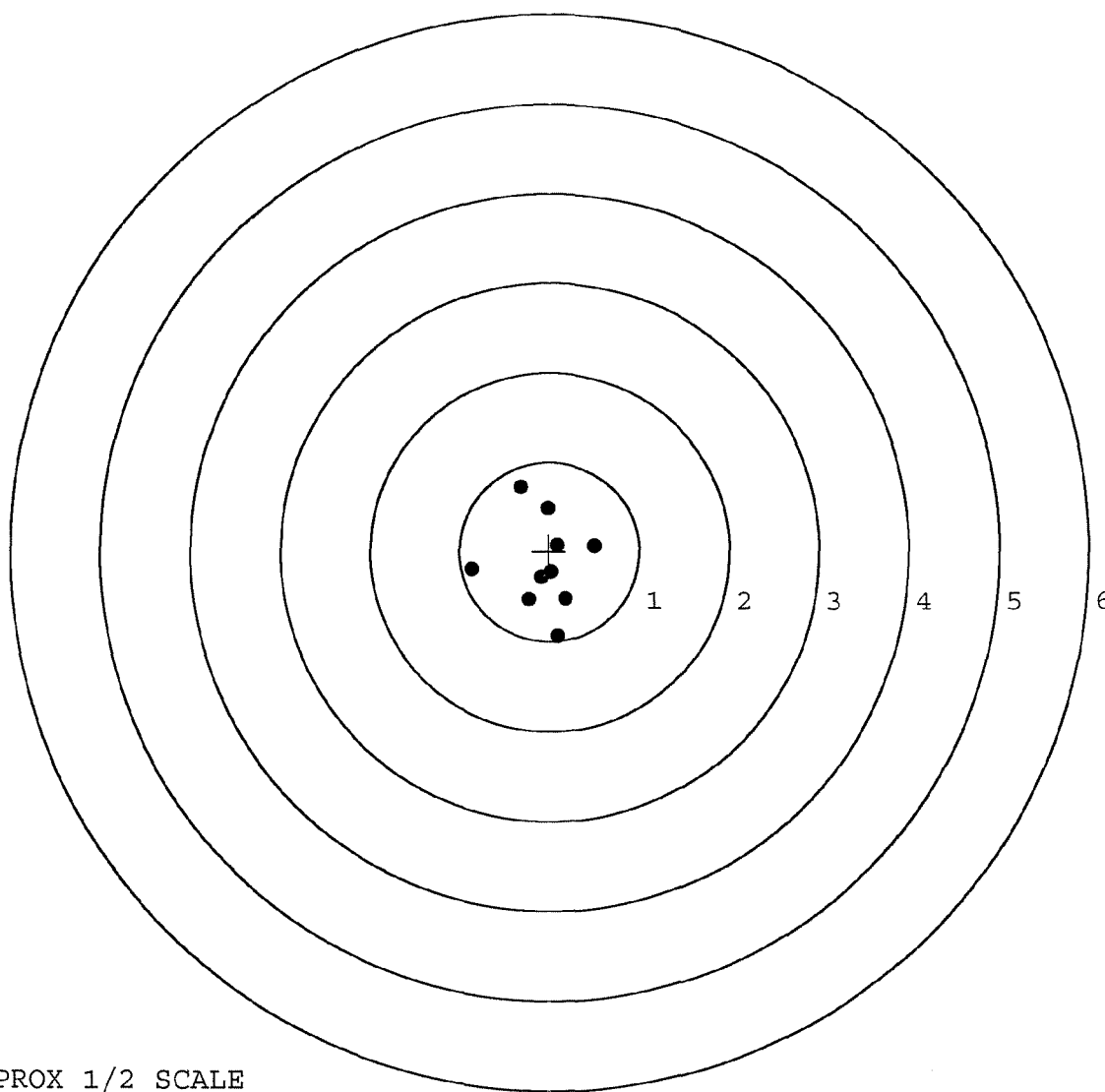


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645610. __0
TARGET NUMBER: 4
FILE DATE: 05/30/2007
FILE TIME: 05:03

X CENTROID: -0.061
Y CENTROID: -0.145
POA TO CENTROID: 0.157
HORZ SPREAD: 1.368
VERT SPREAD: 1.670
GROUP SPREAD: 1.721
MIN RADIUS: 0.125
MAX RADIUS: 0.901
MEAN RADIUS: 0.519
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.095	-0.952
2:	-0.863	-0.201
3:	-0.320	0.718
4:	-0.019	0.479
5:	0.505	0.061
6:	0.098	0.062
7:	-0.088	-0.295
8:	-0.227	-0.546
9:	0.184	-0.537
10:	0.026	-0.235

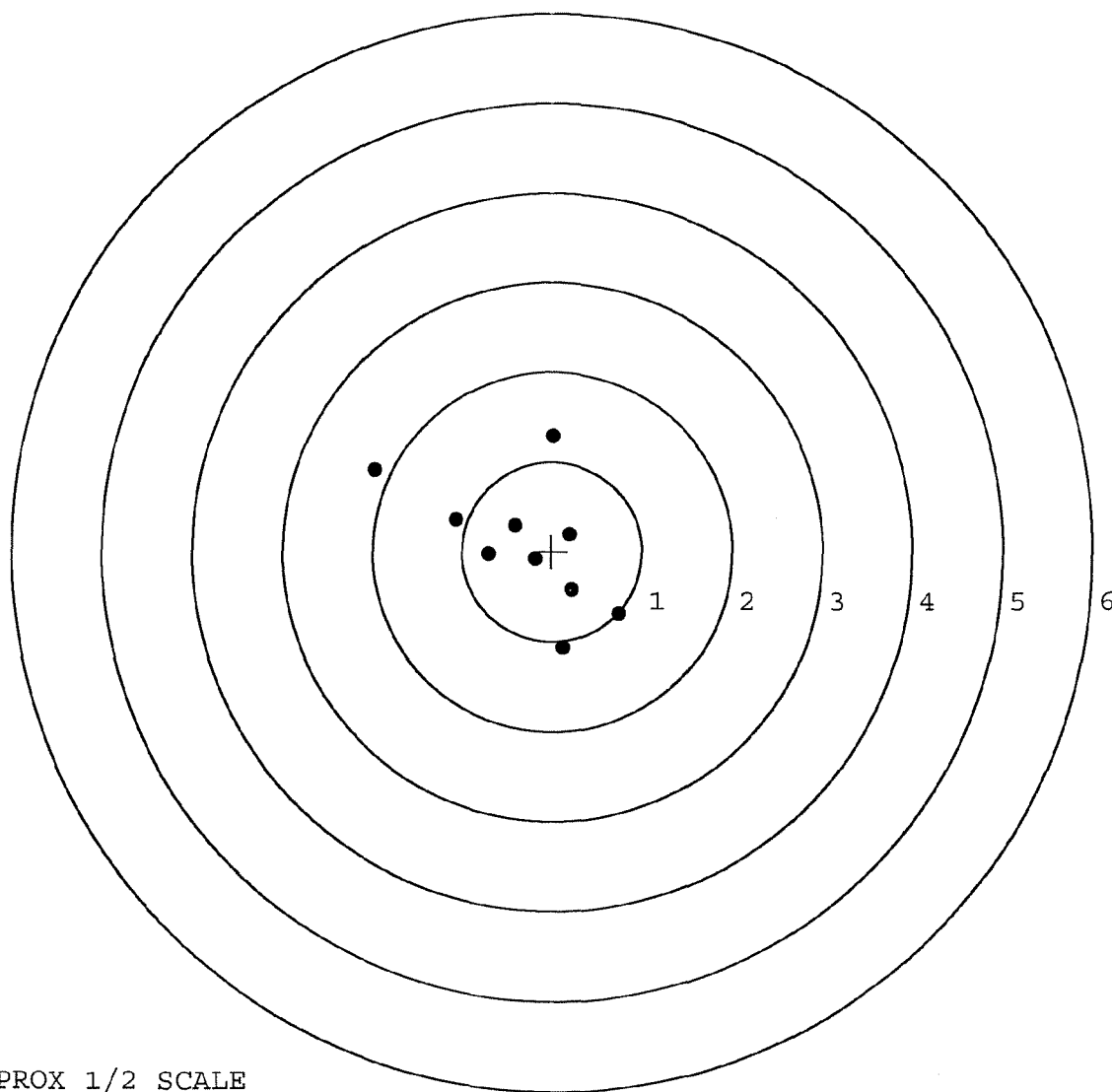


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645610. __0
TARGET NUMBER: 5
FILE DATE: 05/30/2007
FILE TIME: 05:03

X CENTROID: -0.304
Y CENTROID: 0.071
POA TO CENTROID: 0.312
HORZ SPREAD: 2.720
VERT SPREAD: 2.364
GROUP SPREAD: 3.161
MIN RADIUS: 0.200
MAX RADIUS: 1.873
MEAN RADIUS: 0.856
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.019	1.285
2:	-1.976	0.915
3:	-1.068	0.359
4:	-0.412	0.288
5:	0.194	0.187
6:	-0.183	-0.088
7:	-0.703	-0.033
8:	0.221	-0.433
9:	0.744	-0.696
10:	0.122	-1.079



TARGET APPROX 1/2 SCALE