

G 664 5631

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



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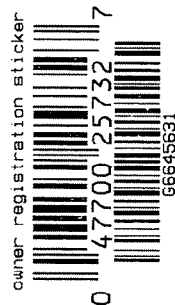
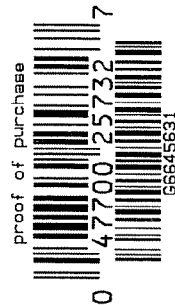
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM 200348



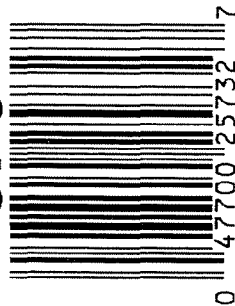
ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6645631

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M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66645631

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-18-07	RT
420	ASSEMBLE ACTION		5-16-07	P.P.D.
430	ASSEMBLE TO STOCK		5-18-07	TRW
440	PROOF	MAGNA - FLUX	5-18-07	TRW
460	CHECK HEADSPACE	MAY 21 2006	5-18-07	TRW
470	DIS-ASSEMBLE ACTION		5-18-07	RT
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unnd</u>	5/21/07	unnd
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-21-07	CW
510	DRILL AND TAP SIGHT HOLES		5-21-07	TRW
520	GOFF BLAST BBL / REC		5-22-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/23/07	TR
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-25-07	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-25-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-25-07	SD
	D) OIL FIRING PIN ASSEMBLY		5-29-07	P.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>6.8</u> <u>6.8</u> <u>6.8</u>	6-1-07	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	6-1-07	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	6-1-07	RA
	J) ASSEMBLE STOCK		5-29-07	S.P.D.
	K) ASSEMBLE SWIVEL STUDS		6-6-07	S.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	5/30/07	RA
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-30-07	SD
670	FINAL INSPECTION A) HEADSPACE		6-6-07	S.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.82</u> <u>2.84</u> <u>2.82</u> <u>2.82</u> <u>2.77</u>	6-1-07	RA
	C) FUNCTION		6-6-07	S.P.D.
690	PACK		6-1-07	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 5-29-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.50		2.40	
PULL #2	2.67	2.50		2.25	
PULL #3	2.71	2.55		2.52	
PULL #4	2.76	2.36		2.28	
PULL #5	2.87	2.44		2.35	
TOTAL	13.41	12.35		11.80	
AVERAGE	2.68	2.47		2.36	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.19		
PULL #2	3.28	3.36		
PULL #3	3.43	3.20		
PULL #4	3.30	3.28		
PULL #5	3.36	3.33		
TOTAL	16.76	16.36		
AVERAGE	3.35	3.27		

	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	4.36	4.26		4.19
PULL #2	4.23	4.17		4.26
PULL #3	4.37	4.29		4.11
PULL #4	4.24	4.07		4.12
PULL #5	4.09	4.09		4.20
TOTAL	21.29	20.88		20.88
AVERAGE	4.25	4.17		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645631.___0
FILE DATE AND TIME: 05/31/2007 01:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.071
The Average Y Centroid of the Five Target Set:	-0.098
The Average Point of Impact of the Five Target Set:	0.121
The Average Mean Radius of the Five Target Set:	0.617
The Distance from POA to Centroid Target #1:	0.263
The Distance from Centroid Target #2 to Centroid Target #1:	0.599
The Distance from Centroid Target #3 to Centroid Target #1:	0.287
The Distance from Centroid Target #4 to Centroid Target #1:	0.362
The Distance from Centroid Target #5 to Centroid Target #1:	0.561

SERIAL NUMBER: G6645631. __0

TARGET NUMBER: 1

FILE DATE: 05/31/2007

FILE TIME: 01:17

POINT#	X	Y
1:	-0.113	1.101
2:	-0.153	0.814
3:	-0.548	0.339
4:	-0.171	-0.716
5:	0.134	-0.484
6:	0.769	-0.381
7:	0.498	1.076
8:	0.432	0.266
9:	-0.123	0.091
10:	-0.243	0.480

X CENTROID: 0.048

Y CENTROID: 0.259

POA TO CENTROID: 0.263

HORZ SPREAD: 1.317

VERT SPREAD: 1.817

GROUP SPREAD: 1.913

MIN RADIUS: 0.240

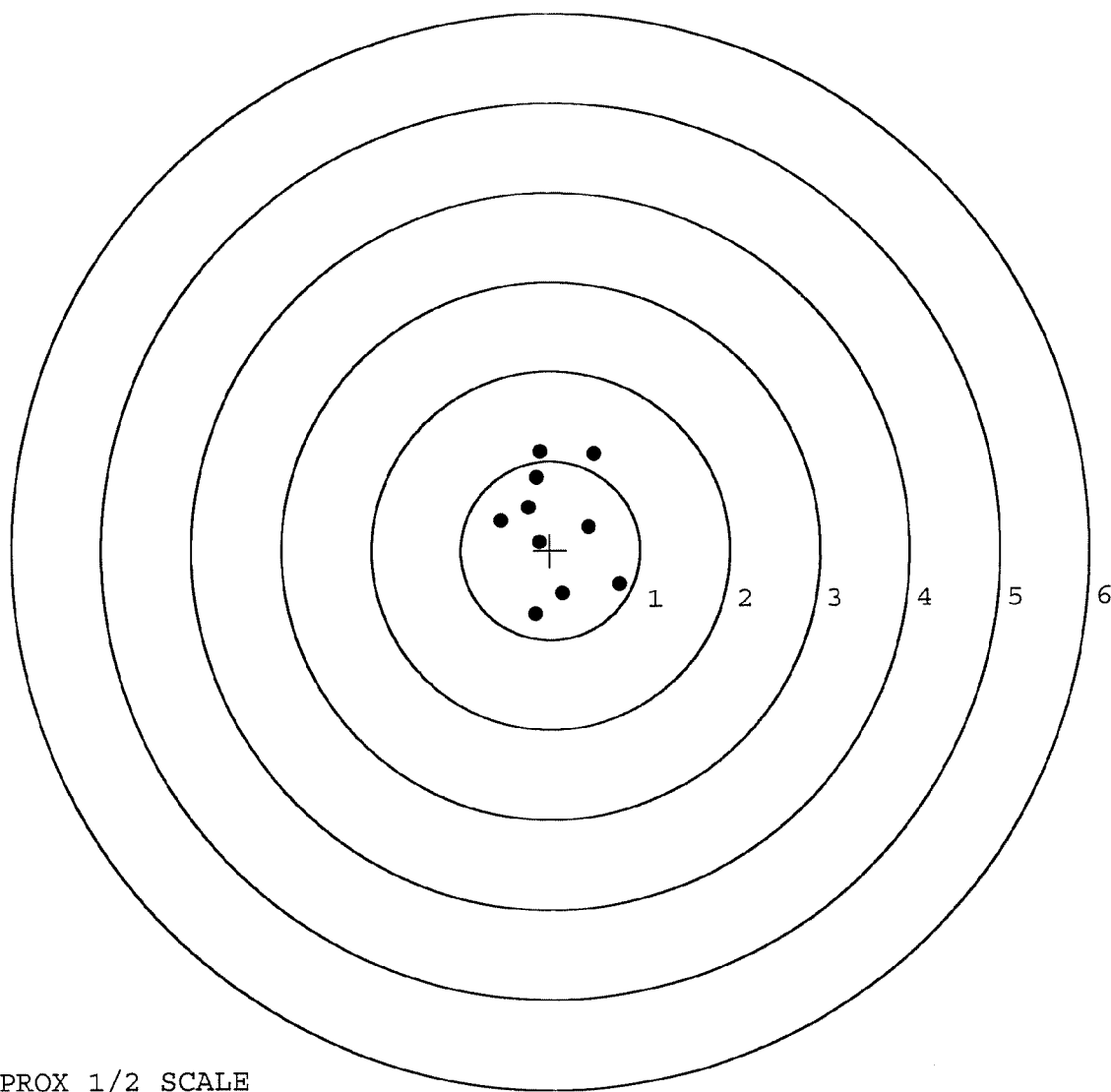
MAX RADIUS: 0.999

MEAN RADIUS: 0.668

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

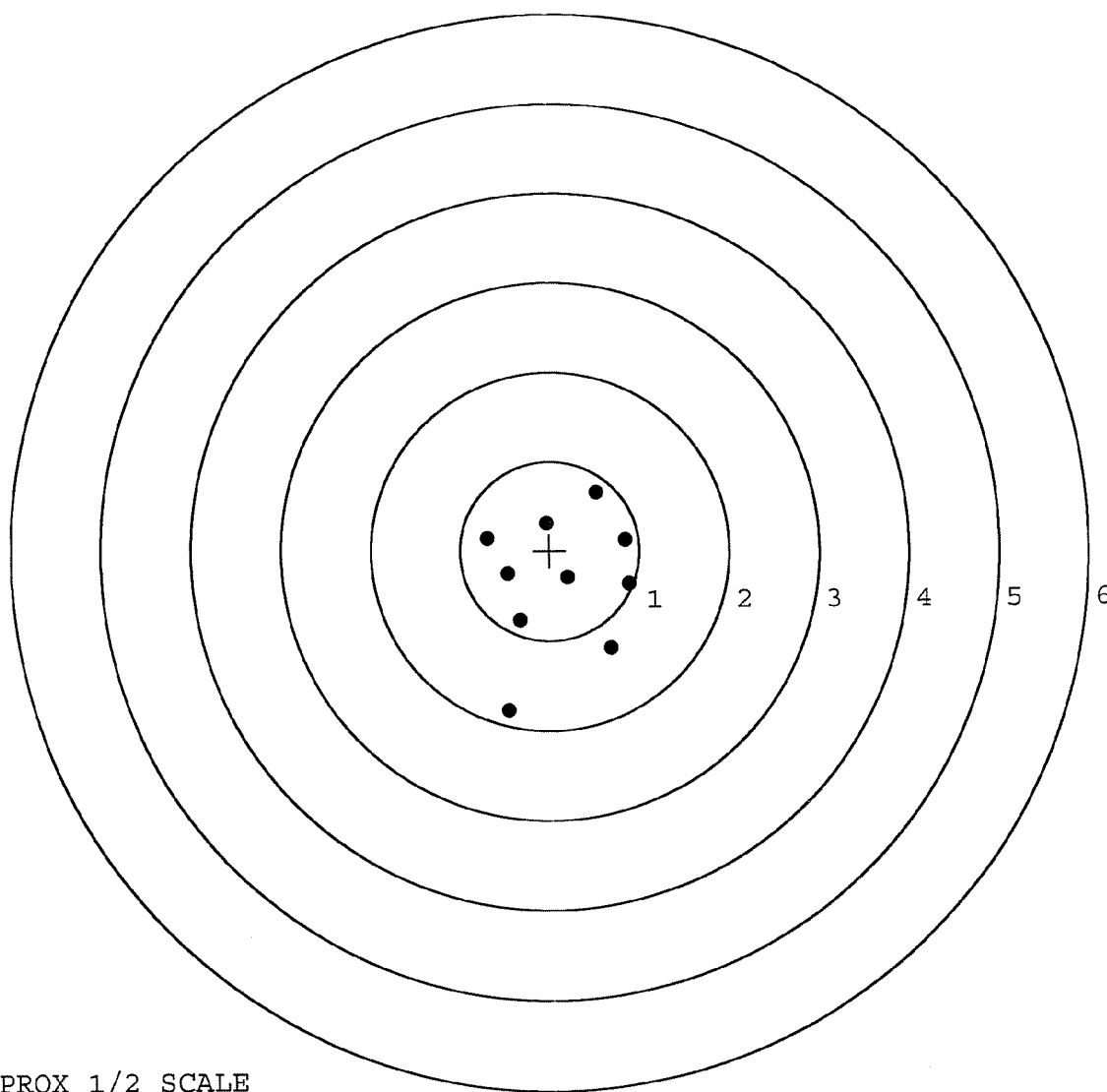


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645631. __0
TARGET NUMBER: 2
FILE DATE: 05/31/2007
FILE TIME: 01:17

X CENTROID: 0.112
Y CENTROID: -0.337
POA TO CENTROID: 0.355
HORZ SPREAD: 1.581
VERT SPREAD: 2.426
GROUP SPREAD: 2.621
MIN RADIUS: 0.099
MAX RADIUS: 1.553
MEAN RADIUS: 0.810
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.698	0.141
2:	-0.473	-0.259
3:	-0.335	-0.777
4:	0.206	-0.306
5:	-0.035	0.306
6:	0.524	0.648
7:	0.840	0.117
8:	0.883	-0.376
9:	0.675	-1.087
10:	-0.467	-1.778



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645631. __0

TARGET NUMBER: 3

FILE DATE: 05/31/2007

FILE TIME: 01:17

POINT#	X	Y
1:	0.078	0.615
2:	0.346	0.381
3:	-0.102	0.278
4:	-0.208	0.161
5:	-0.270	0.005
6:	-0.289	0.186
7:	-0.393	-0.313
8:	-0.172	-0.376
9:	0.440	-0.716
10:	0.540	-0.460

X CENTROID: -0.003

Y CENTROID: -0.024

POA TO CENTROID: 0.024

HORZ SPREAD: 0.933

VERT SPREAD: 1.331

GROUP SPREAD: 1.379

MIN RADIUS: 0.269

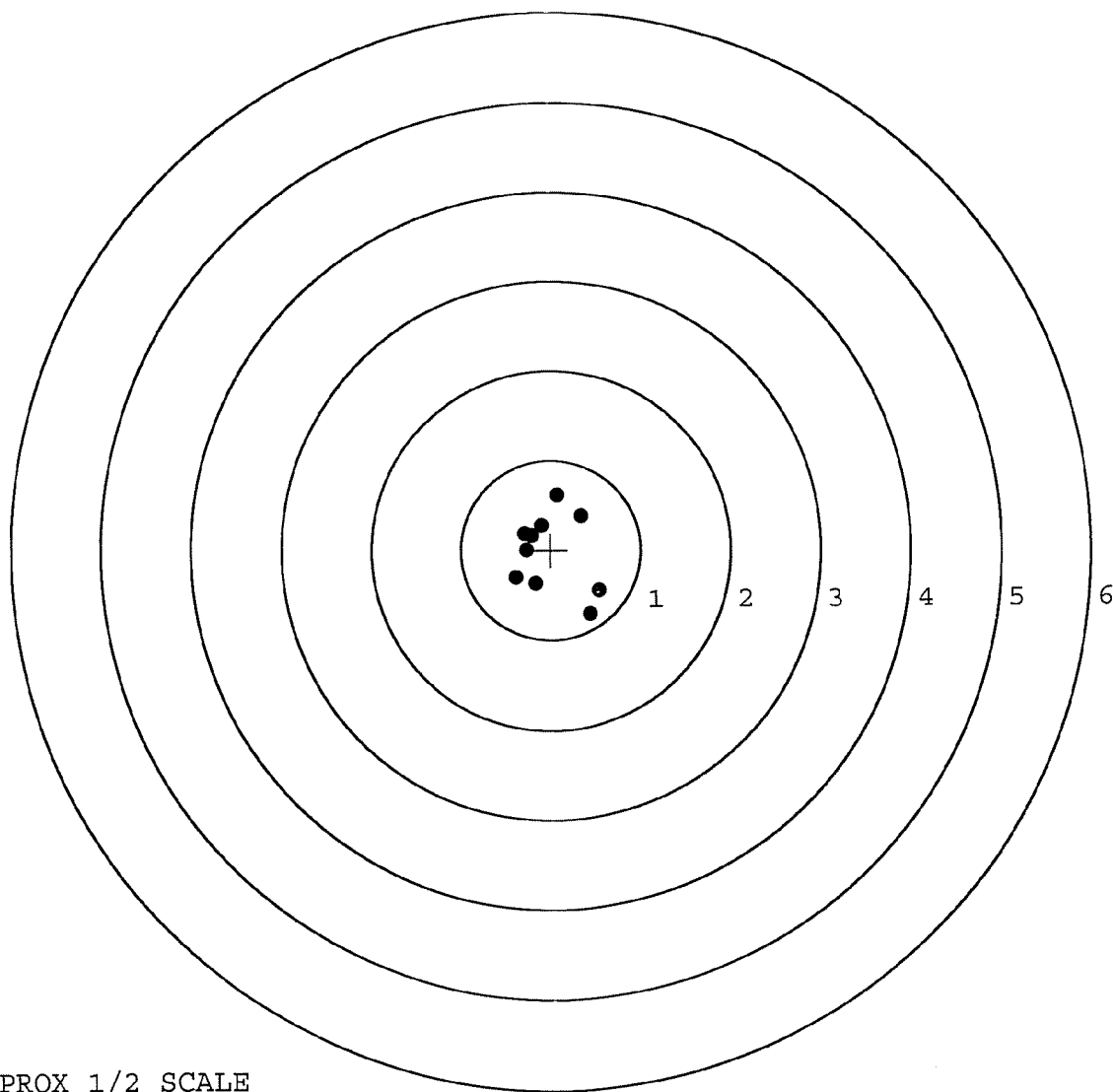
MAX RADIUS: 0.822

MEAN RADIUS: 0.479

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

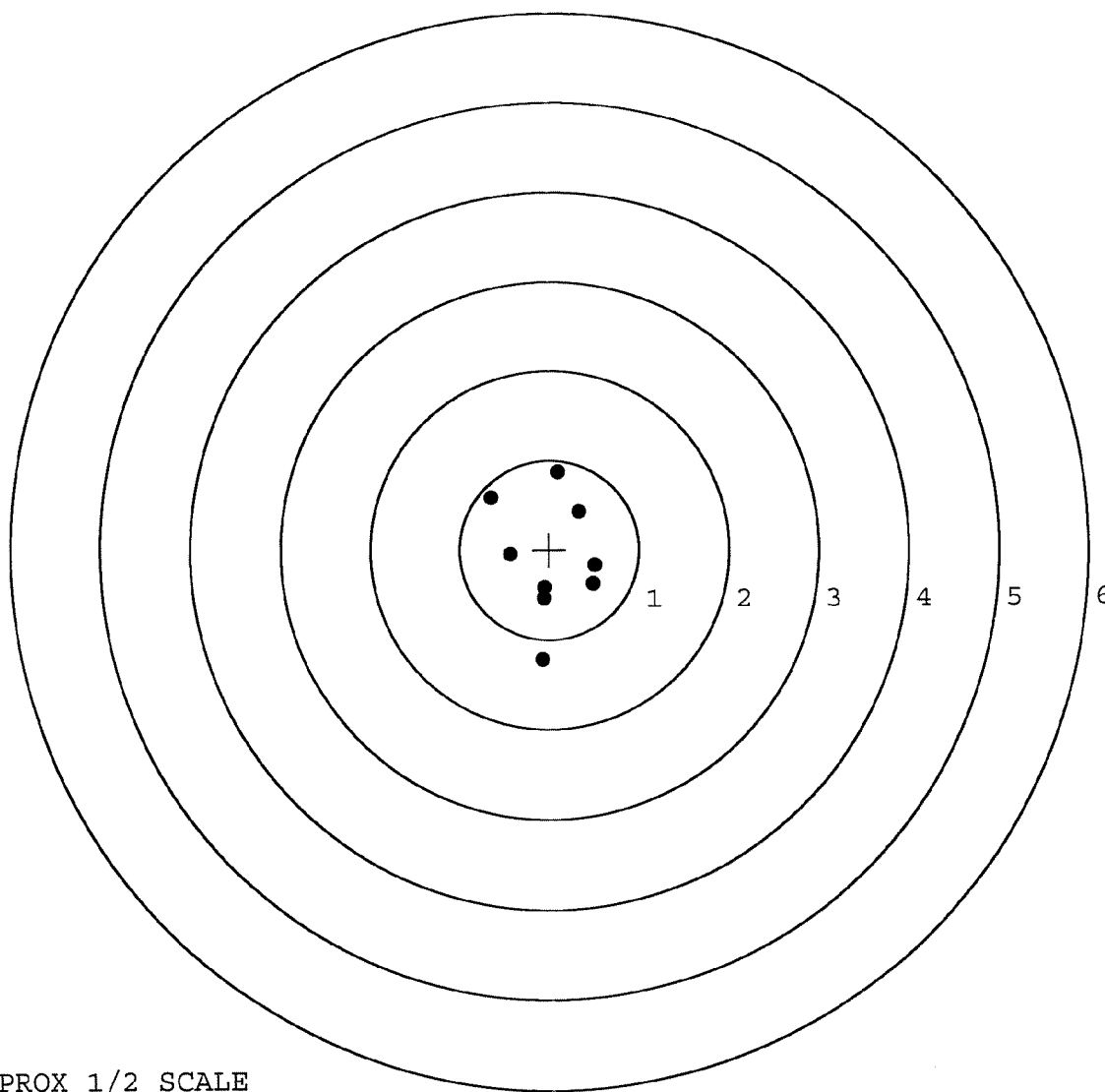


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645631. __0
TARGET NUMBER: 4
FILE DATE: 05/31/2007
FILE TIME: 01:17

X CENTROID: 0.017
Y CENTROID: -0.102
POA TO CENTROID: 0.104
HORZ SPREAD: 1.162
VERT SPREAD: 2.105
GROUP SPREAD: 2.114
MIN RADIUS: 0.331
MAX RADIUS: 1.135
MEAN RADIUS: 0.664
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.650	0.593
2:	-0.436	-0.052
3:	0.106	0.872
4:	0.337	0.425
5:	0.512	-0.177
6:	0.487	-0.383
7:	-0.063	-0.541
8:	-0.058	-0.425
9:	-0.084	-1.233



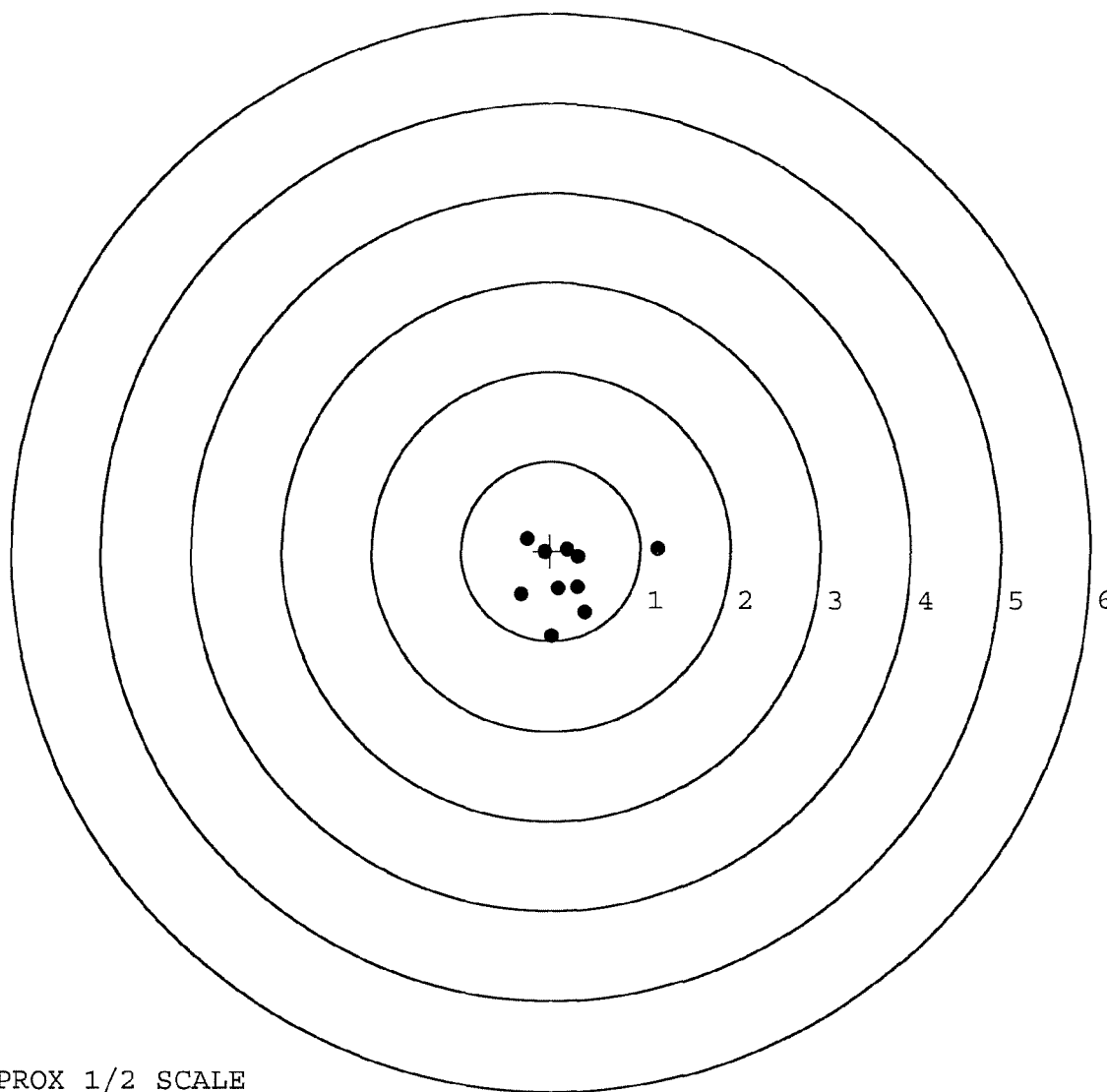
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645631. 0
TARGET NUMBER: 5
FILE DATE: 05/31/2007
FILE TIME: 01:17

X CENTROID: 0.182
Y CENTROID: -0.286
POA TO CENTROID: 0.339
HORZ SPREAD: 1.519
VERT SPREAD: 1.097
GROUP SPREAD: 1.602
MIN RADIUS: 0.164
MAX RADIUS: 1.055
MEAN RADIUS: 0.461

POINT#	X	Y
1:	-0.265	0.140
2:	-0.063	-0.018
3:	0.190	0.019
4:	0.088	-0.421
5:	1.191	0.022
6:	0.304	-0.404
7:	-0.328	-0.488
8:	0.010	-0.957
9:	0.386	-0.683
10:	0.309	-0.073

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE