

G 457 7178

ORDER 25716

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

UPC



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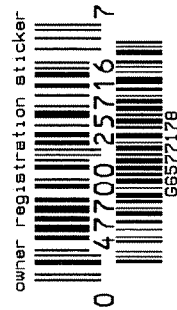
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

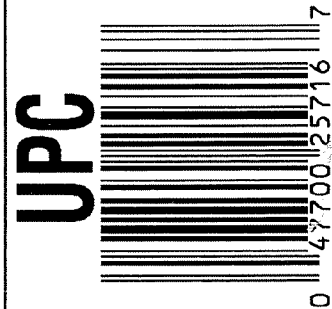


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6577178



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577178

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLC
420	ASSEMBLE ACTION		7-10-06	RTZ
430	ASSEMBLE TO STOCK		7-10-06	RTZ
440	PROOF		7-11-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	7-11-06	TRW
470	DIS-ASSEMBLE ACTION	JUL 13 2006	7-11-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	7-13-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-12-06	CW
510	DRILL AND TAP SIGHT HOLES		7-12-06	TRW
520	GOFF BLAST BBL / REC		7-13-06	CB
530 & 540	APPLY COATINGS (BARREL ACTION)		7/14	HO
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-2-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-2-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-2-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-2-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/11/06	WZ

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>6.5</u> <u>6.5</u>	8-21-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.5</u> <u>5.5</u>	8-21-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	WPH
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	8-21-06	RA
	J) ASSEMBLE STOCK		8-2-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		10/11/06	WPH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-2-06	RTZ
	M) IRON SIGHT ALIGNMENT		8-2-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-2-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-3-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/3/06	WPH
670	FINAL INSPECTION A) HEADSPACE		10/11/06	WPH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>282</u> <u>2.75</u> <u>2.70</u> <u>2.49</u> <u>2.66</u> ^{270 RA}	8-27-06	RA
	C) FUNCTION		10/11/06	WPH
690	PACK		11/2/06	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

7-25-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.58	2.31		2.48	
PULL #2	2.40	2.39		2.48	
PULL #3	2.56	2.37		2.59	
PULL #4	2.54	2.37		2.41	
PULL #5	2.56	2.50		2.52	
TOTAL	12.64	11.94		12.48	
AVERAGE	2.52	2.38		2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	2.90		
PULL #2	3.05	3.02		
PULL #3	3.02	3.03		
PULL #4	3.16	2.79		
PULL #5	3.10	2.78		
TOTAL	15.48	14.52		
AVERAGE	3.09	2.90		

	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	4.12	3.99		4.20
PULL #2	3.99	4.01		4.16
PULL #3	3.93	4.04		4.14
PULL #4	3.84	4.04		4.11
PULL #5	4.15	3.98		4.21
TOTAL	20.03	20.06		20.82
AVERAGE	4.00	4.01		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577178.___0
FILE DATE AND TIME: 08/03/2006 08:14

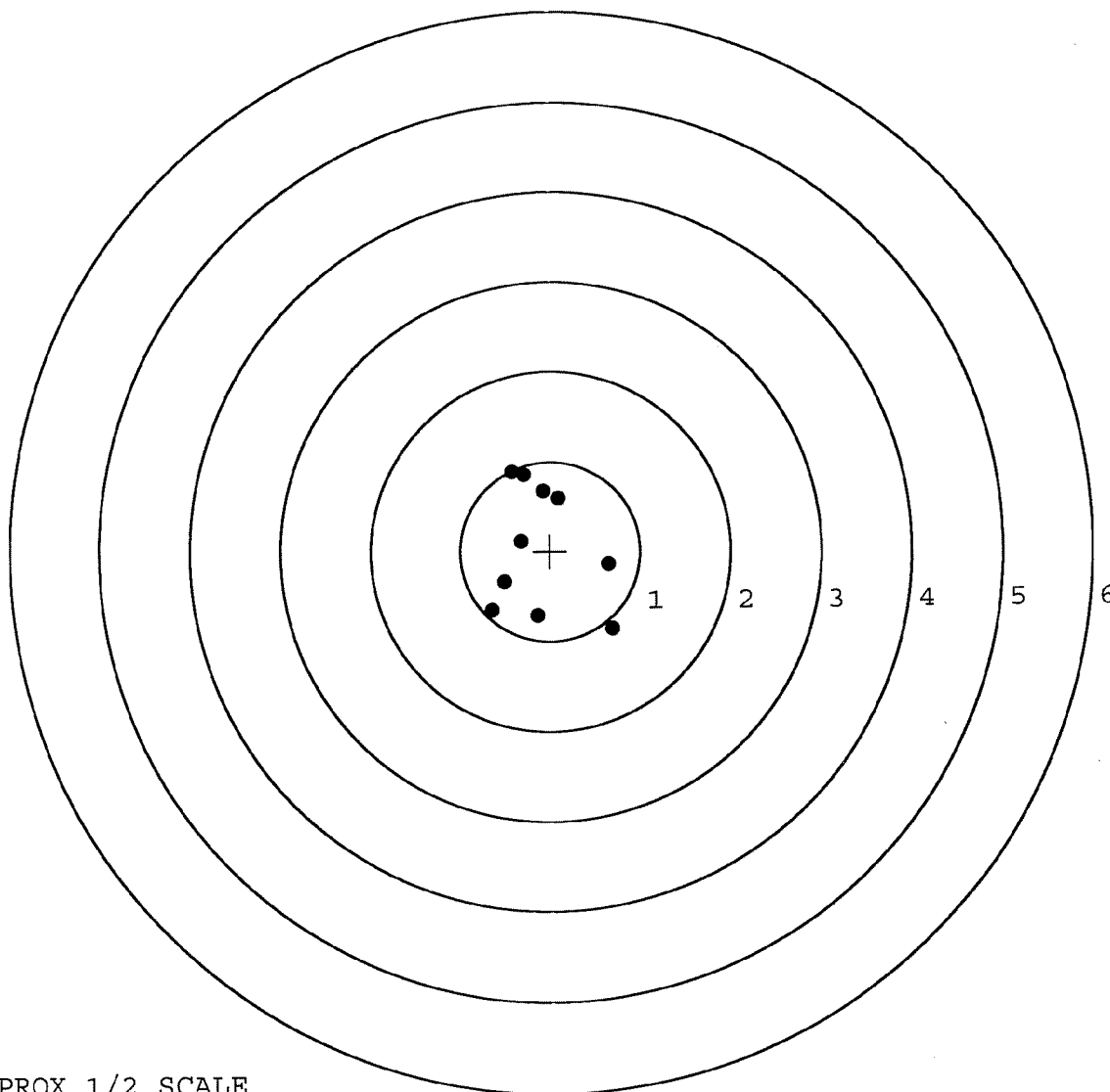
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.226
The Average Y Centroid of the Five Target Set:	0.022
The Average Point of Impact of the Five Target Set:	0.227
The Average Mean Radius of the Five Target Set:	0.698
The Distance from POA to Centroid Target #1:	0.105
The Distance from Centroid Target #2 to Centroid Target #1:	0.148
The Distance from Centroid Target #3 to Centroid Target #1:	0.044
The Distance from Centroid Target #4 to Centroid Target #1:	0.215
The Distance from Centroid Target #5 to Centroid Target #1:	0.296

SERIAL NUMBER: G6577178. __0
 TARGET NUMBER: 1
 FILE DATE: 08/03/2006
 FILE TIME: 08:14

POINT#	X	Y
1:	-0.144	-0.722
2:	-0.649	-0.658
3:	-0.513	-0.345
4:	0.690	-0.869
5:	0.649	-0.149
6:	-0.323	0.107
7:	0.099	0.592
8:	-0.077	0.671
9:	-0.291	0.857
10:	-0.423	0.890

X CENTROID: -0.098
 Y CENTROID: 0.037
 POA TO CENTROID: 0.105
 HORZ SPREAD: 1.339
 VERT SPREAD: 1.759
 GROUP SPREAD: 2.082
 MIN RADIUS: 0.235
 MAX RADIUS: 1.201
 MEAN RADIUS: 0.740
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

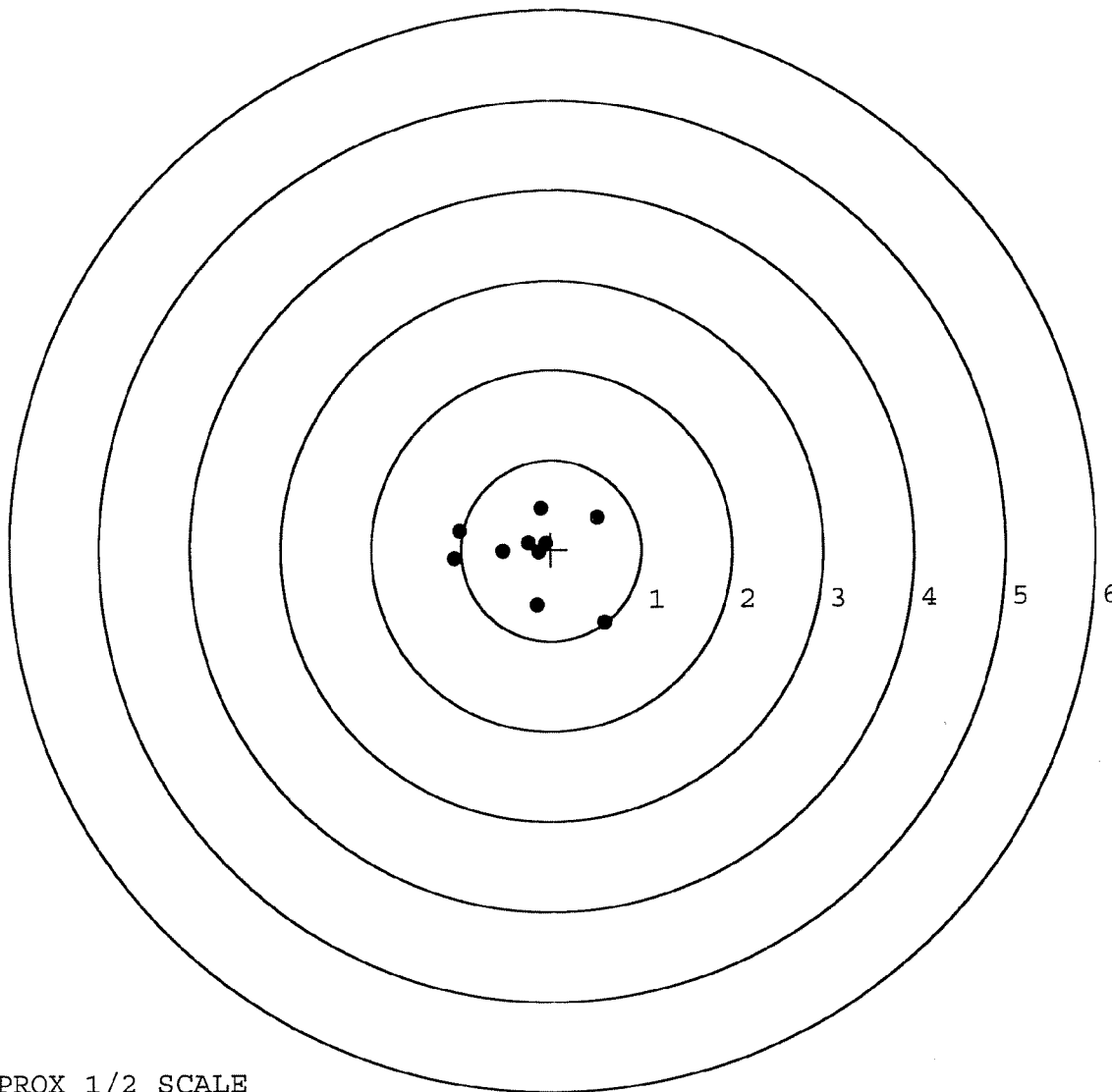


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577178. __0
 TARGET NUMBER: 2
 FILE DATE: 08/03/2006
 FILE TIME: 08:14

POINT#	X	Y
1:	-0.163	-0.607
2:	0.593	-0.806
3:	0.519	0.355
4:	-0.117	0.464
5:	-1.015	0.216
6:	-1.074	-0.100
7:	-0.537	-0.016
8:	-0.254	0.075
9:	-0.066	0.068
10:	-0.143	-0.033

X CENTROID: -0.226
 Y CENTROID: -0.038
 POA TO CENTROID: 0.229
 HORZ SPREAD: 1.667
 VERT SPREAD: 1.270
 GROUP SPREAD: 1.905
 MIN RADIUS: 0.083
 MAX RADIUS: 1.122
 MEAN RADIUS: 0.543
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

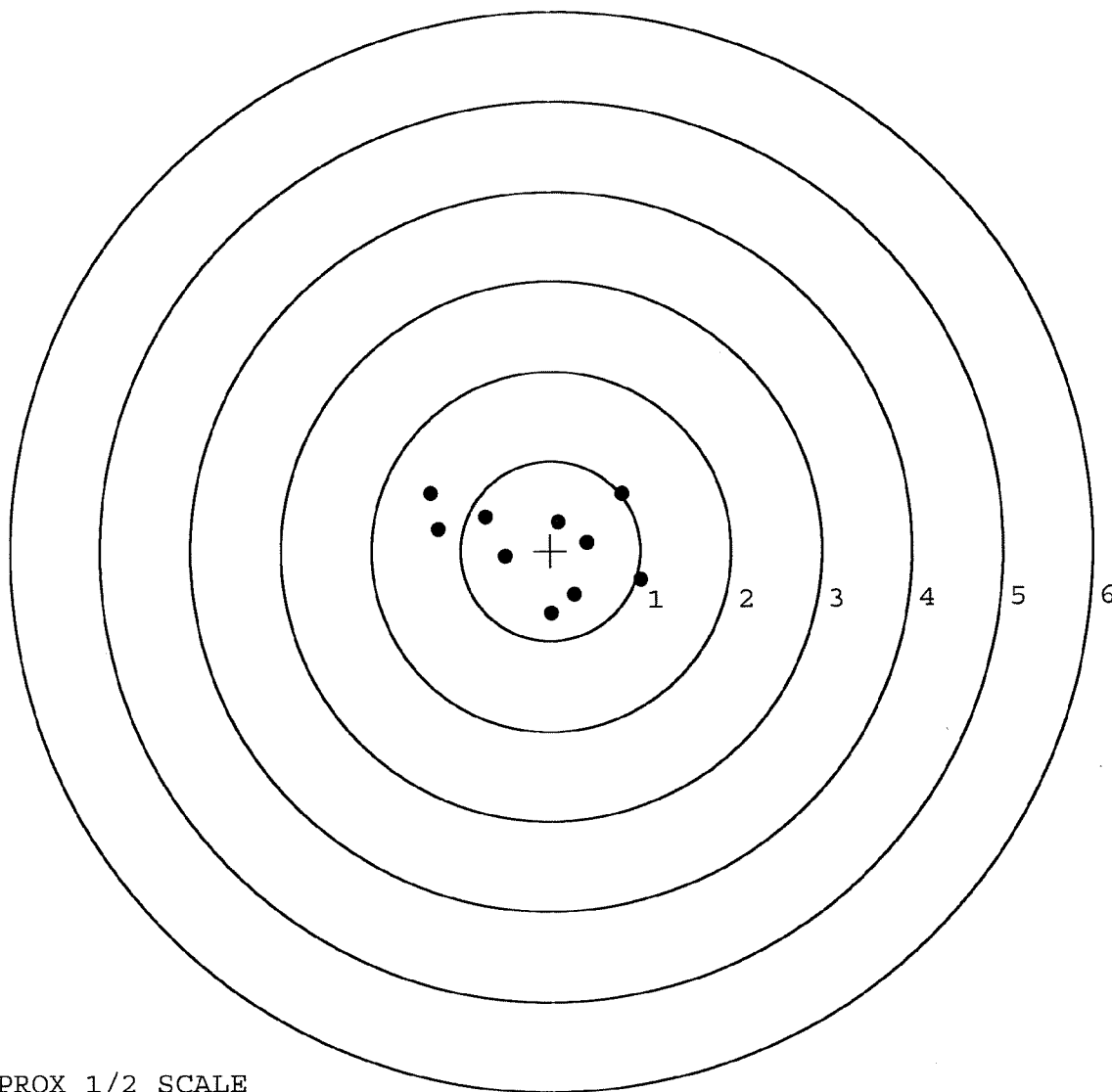


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577178. __0
 TARGET NUMBER: 3
 FILE DATE: 08/03/2006
 FILE TIME: 08:14

POINT#	X	Y
1:	-1.337	0.651
2:	-1.248	0.251
3:	-0.724	0.384
4:	-0.503	-0.064
5:	0.009	-0.700
6:	0.268	-0.495
7:	1.003	-0.335
8:	0.798	0.630
9:	0.090	0.319
10:	0.411	0.090

X CENTROID: -0.123
 Y CENTROID: 0.073
 POA TO CENTROID: 0.143
 HORZ SPREAD: 2.340
 VERT SPREAD: 1.351
 GROUP SPREAD: 2.539
 MIN RADIUS: 0.326
 MAX RADIUS: 1.344
 MEAN RADIUS: 0.817
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577178. 0

TARGET NUMBER: 4

FILE DATE: 08/03/2006

FILE TIME: 08:14

X CENTROID: -0.293

Y CENTROID: -0.053

POA TO CENTROID: 0.298

HORZ SPREAD: 1.934

VERT SPREAD: 2.285

GROUP SPREAD: 2.305

MIN RADIUS: 0.111

MAX RADIUS: 1.354

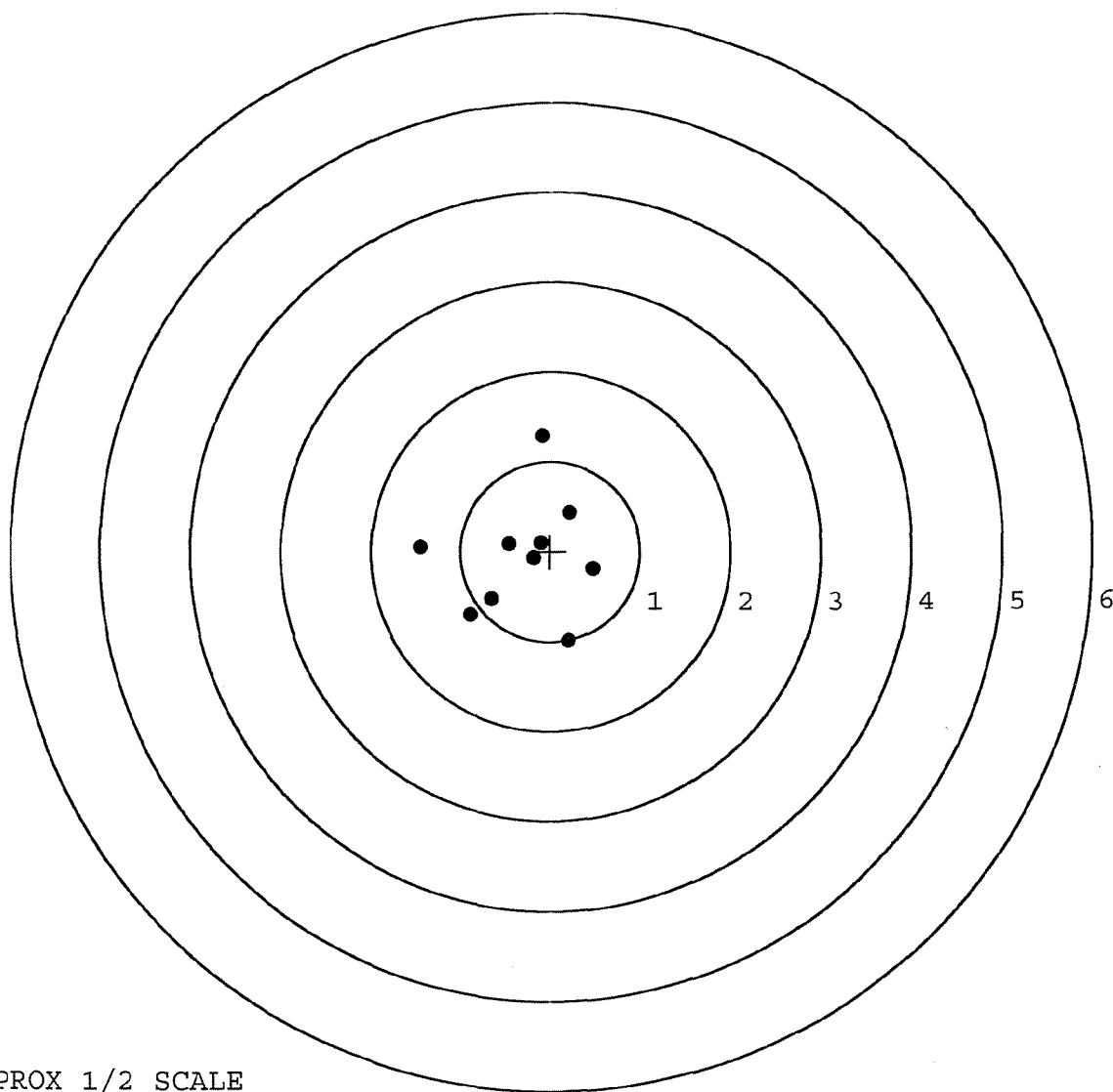
MEAN RADIUS: 0.713

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.092	1.286
2:	0.218	0.432
3:	0.483	-0.193
4:	0.209	-0.999
5:	-0.893	-0.701
6:	-0.659	-0.522
7:	-1.451	0.059
8:	-0.460	0.088
9:	-0.184	-0.074
10:	-0.106	0.094



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577178. 0

TARGET NUMBER: 5

FILE DATE: 08/03/2006

FILE TIME: 08:14

X CENTROID: -0.389

Y CENTROID: 0.092

POA TO CENTROID: 0.400

HORZ SPREAD: 1.944

VERT SPREAD: 1.689

GROUP SPREAD: 2.018

MIN RADIUS: 0.030

MAX RADIUS: 1.327

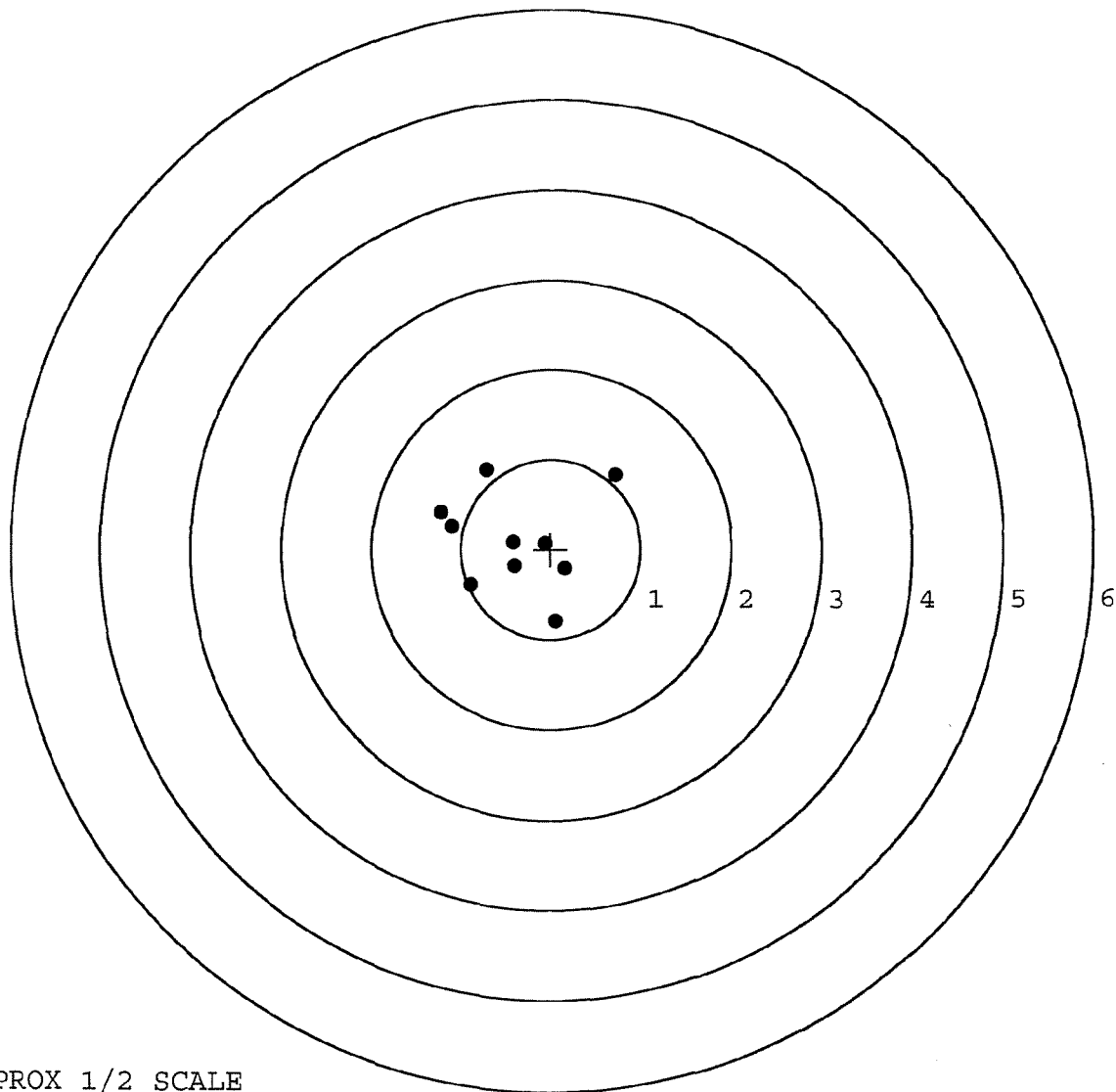
MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.716	0.827
2:	-0.719	0.888
3:	-1.228	0.414
4:	-1.109	0.255
5:	-0.890	-0.395
6:	0.058	-0.801
7:	0.164	-0.220
8:	-0.063	0.060
9:	-0.417	0.081
10:	-0.401	-0.185



TARGET APPROX 1/2 SCALE