

G-657 7182

ORDER 25716

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

UPC



0 47700 25716 7

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SERIAL NO.



66577182

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

- INSTRUCTION BOOK 3518

DD FORM

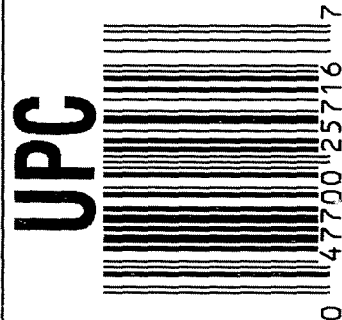


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6577182



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577182

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	MAGNA - FLUX	7-11-06	TRW
460	CHECK HEADSPACE	INSPECTED	7-11-06	TRW
470	DIS-ASSEMBLE ACTION	JUL 13 2006	7-11-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</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	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-14-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-14-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-14-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-14-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-17-06	MTM

F004 REV 5/2006

OP #	BARBER M24 0086460	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.2</u> <u>5.2</u> <u>5.2</u>	8-16-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	8-16-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-17-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.023</u>	8-16-06	DA
	J) ASSEMBLE STOCK		8-14-06	RTC
	K) ASSEMBLE SWIVEL STUDS		8-17-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-14-06	BLC-
	M) IRON SIGHT ALIGNMENT		8-14-06	BLC-
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-14-06	BLC-
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-14-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/14/06	N/P
670	FINAL INSPECTION A) HEADSPACE		8-17-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.35</u> <u>2.30</u> <u>2.30</u> <u>2.26</u>	8-16-06	DA
	C) FUNCTION		8-17-06	MTM
690	PACK		11/14/06	DA

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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

8-11-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	249	254		259	
PULL #2	242	253		242	
PULL #3	245	259		250	
PULL #4	261	263		252	
PULL #5	260	261		249	
TOTAL	1257	1290		1252	
AVERAGE	251	258		250	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	301	308		
PULL #2	318	312		
PULL #3	318	299		
PULL #4	314	311		
PULL #5	317	308		
TOTAL	1568	1538		
AVERAGE	313	307		

	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	4.16		4.10
PULL #2	4.19	3.90		3.96
PULL #3	4.15	4.03		3.99
PULL #4	4.03	4.21		3.97
PULL #5	4.08	4.21		3.98
TOTAL	20.57	20.51		20.00
AVERAGE	4.11	4.10		4.00

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577182.___0

FILE DATE AND TIME: 08/15/2006 19:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.033
The Average Y Centroid of the Five Target Set:	-0.076
The Average Point of Impact of the Five Target Set:	0.082
The Average Mean Radius of the Five Target Set:	0.737
The Distance from POA to Centroid Target #1:	0.171
The Distance from Centroid Target #2 to Centroid Target #1:	0.322
The Distance from Centroid Target #3 to Centroid Target #1:	0.260
The Distance from Centroid Target #4 to Centroid Target #1:	0.329
The Distance from Centroid Target #5 to Centroid Target #1:	0.365

SERIAL NUMBER: G6577182. __0

TARGET NUMBER: 1

FILE DATE: 08/15/2006

FILE TIME: 19:30

POINT#	X	Y
1:	0.897	0.550
2:	0.469	0.816
3:	0.188	0.584
4:	-0.203	0.813
5:	-0.288	1.005
6:	0.381	-1.321
7:	0.108	-0.623
8:	-0.378	-0.325
9:	-0.848	-0.196
10:	-1.455	-0.017

X CENTROID: -0.113

Y CENTROID: 0.129

POA TO CENTROID: 0.171

HORZ SPREAD: 2.352

VERT SPREAD: 2.326

GROUP SPREAD: 2.420

MIN RADIUS: 0.525

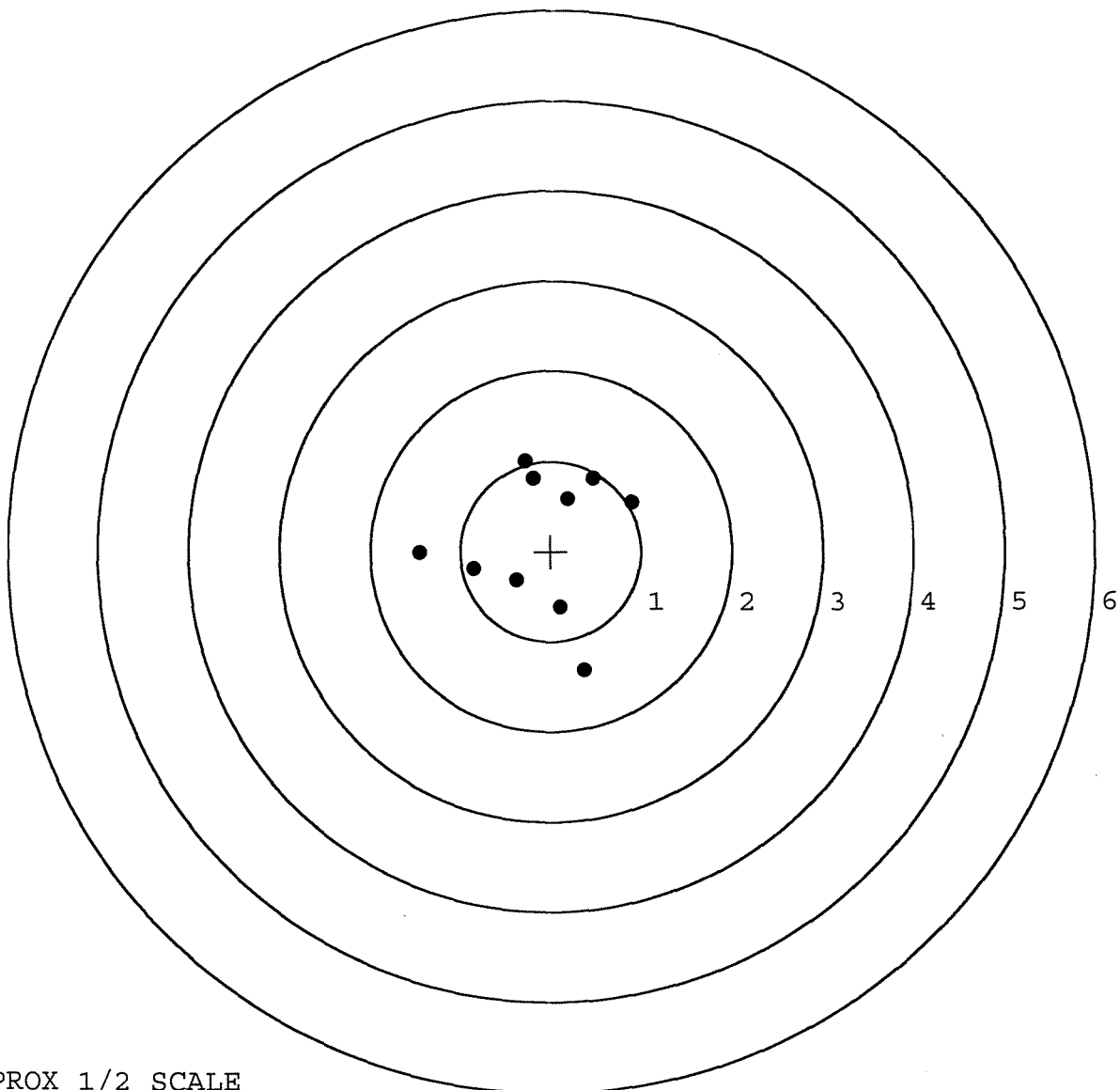
MAX RADIUS: 1.531

MEAN RADIUS: 0.912

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

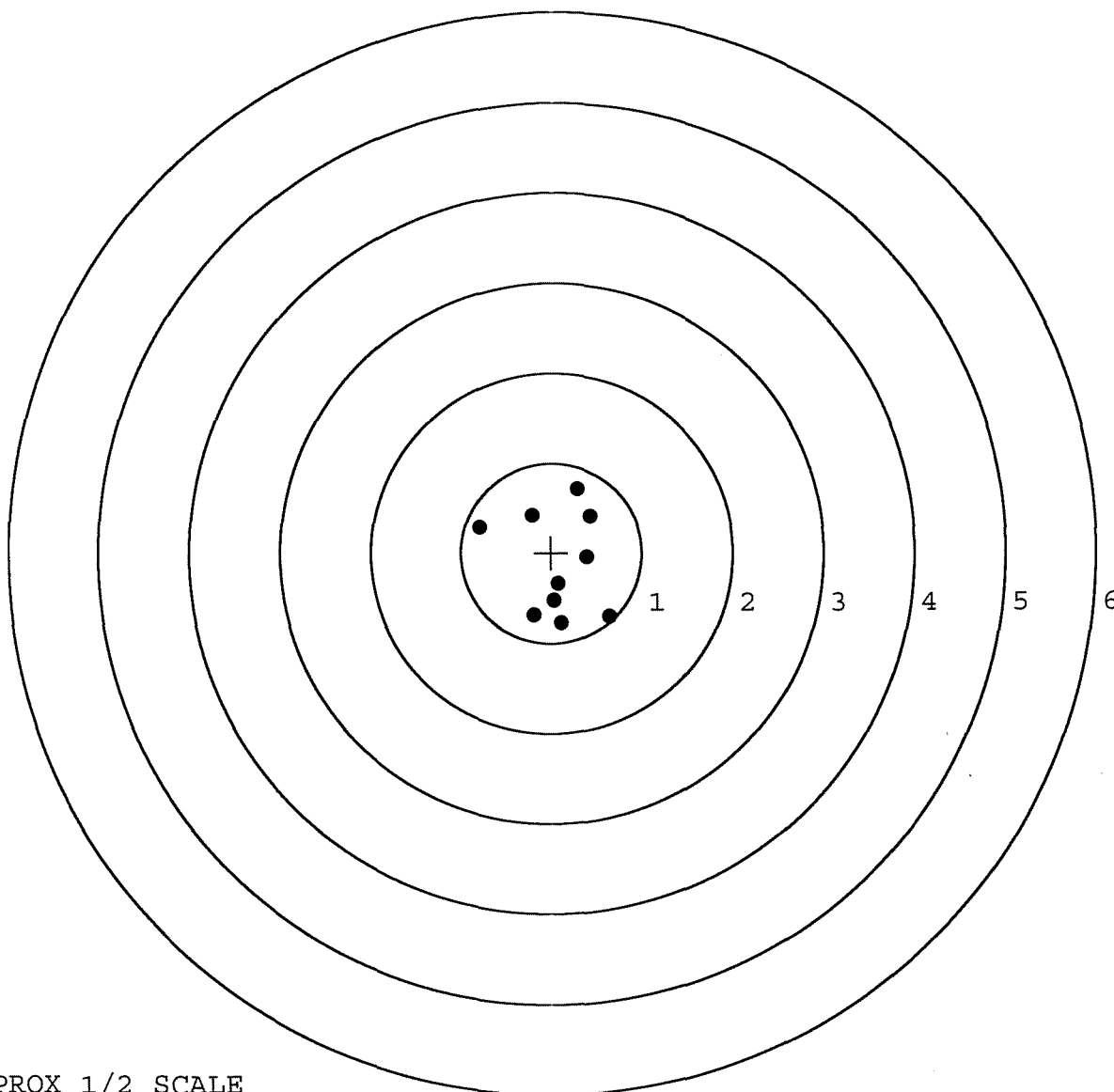


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577182. __0
 TARGET NUMBER: 2
 FILE DATE: 08/15/2006
 FILE TIME: 19:30

X CENTROID: 0.077
 Y CENTROID: -0.131
 POA TO CENTROID: 0.152
 HORZ SPREAD: 1.436
 VERT SPREAD: 1.490
 GROUP SPREAD: 1.743
 MIN RADIUS: 0.218
 MAX RADIUS: 0.960
 MEAN RADIUS: 0.614
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.791	0.280
2:	-0.217	0.416
3:	0.645	-0.708
4:	0.290	0.708
5:	0.432	0.408
6:	0.398	-0.051
7:	0.075	-0.349
8:	0.107	-0.782
9:	-0.197	-0.700
10:	0.027	-0.536

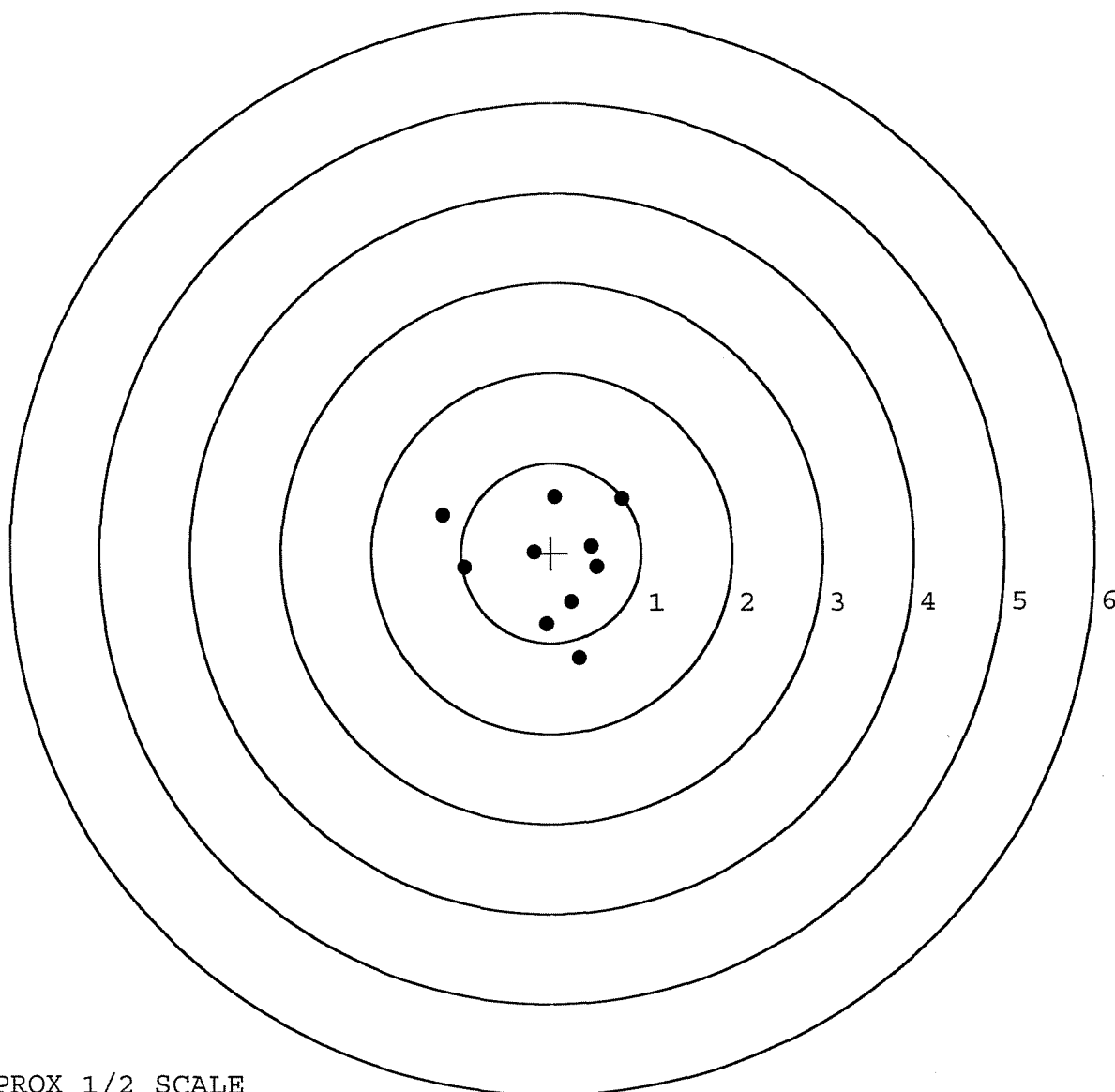


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577182. 0
 TARGET NUMBER: 3
 FILE DATE: 08/15/2006
 FILE TIME: 19:30

X CENTROID: -0.012
 Y CENTROID: -0.111
 POA TO CENTROID: 0.111
 HORZ SPREAD: 1.992
 VERT SPREAD: 1.801
 GROUP SPREAD: 2.210
 MIN RADIUS: 0.213
 MAX RADIUS: 1.313
 MEAN RADIUS: 0.760
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.315	-1.176
2:	-0.060	-0.799
3:	0.220	-0.551
4:	0.781	0.604
5:	0.034	0.625
6:	-0.187	0.011
7:	-1.211	0.423
8:	-0.965	-0.166
9:	0.507	-0.155
10:	0.448	0.077

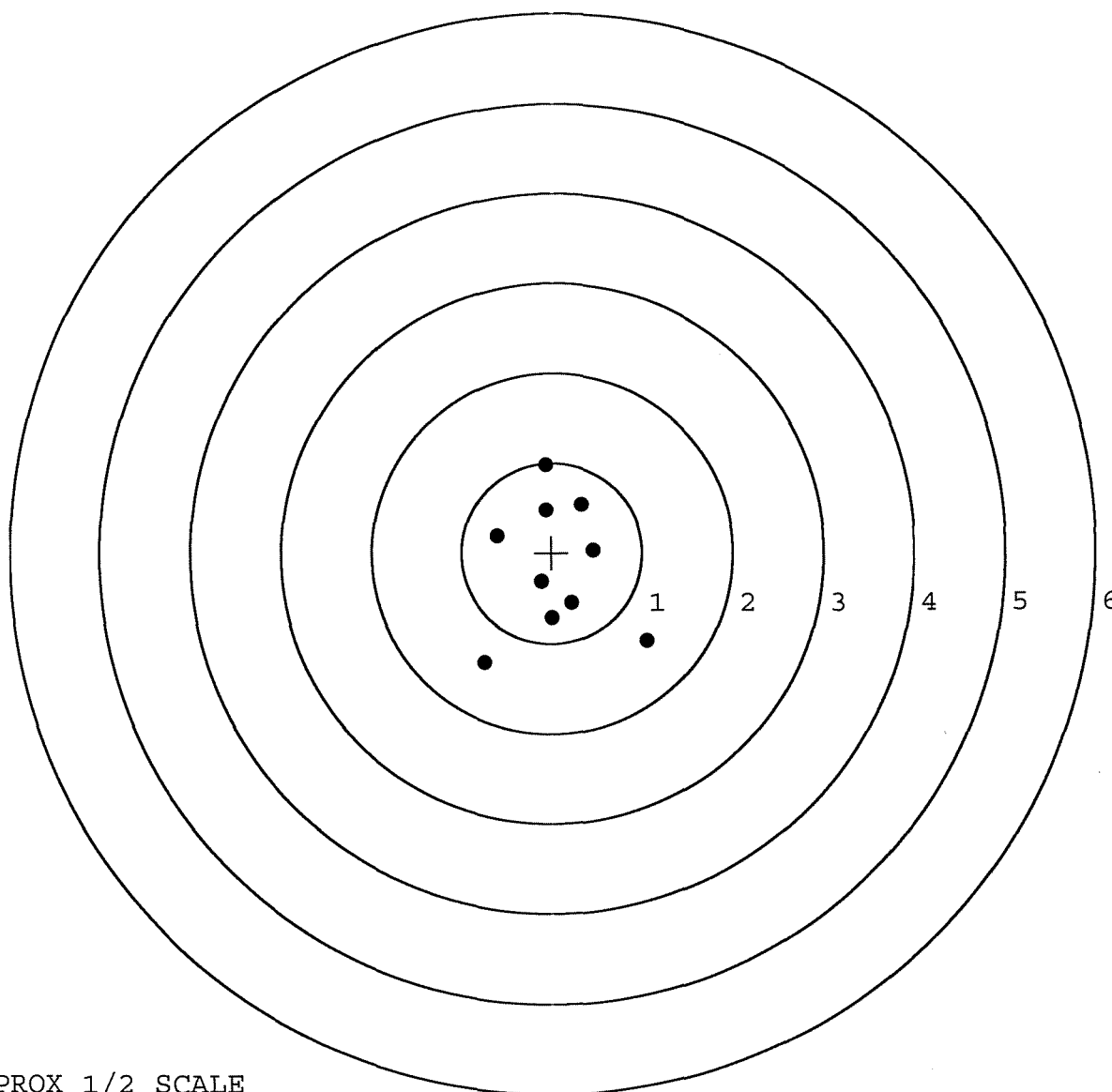


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577182. __0
 TARGET NUMBER: 4
 FILE DATE: 08/15/2006
 FILE TIME: 19:30

X CENTROID: 0.047
 Y CENTROID: -0.159
 POA TO CENTROID: 0.166
 HORZ SPREAD: 1.802
 VERT SPREAD: 2.189
 GROUP SPREAD: 2.291
 MIN RADIUS: 0.233
 MAX RADIUS: 1.317
 MEAN RADIUS: 0.757
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.057	-0.978
2:	-0.745	-1.211
3:	-0.602	0.190
4:	-0.072	0.467
5:	0.328	0.533
6:	0.464	0.031
7:	-0.068	0.978
8:	-0.120	-0.322
9:	0.222	-0.556
10:	0.001	-0.721

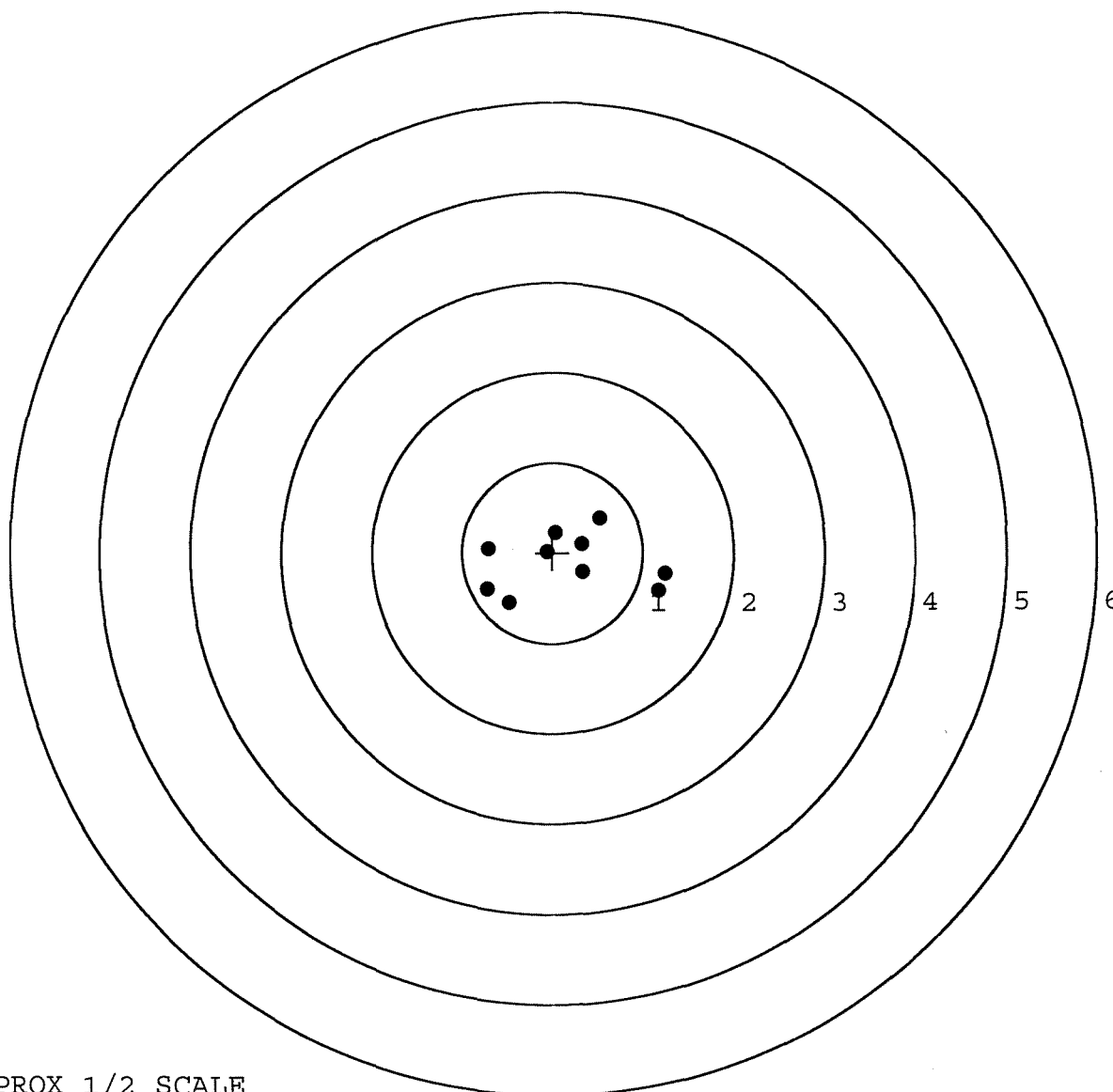


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577182. __0
 TARGET NUMBER: 5
 FILE DATE: 08/15/2006
 FILE TIME: 19:30

X CENTROID: 0.167
 Y CENTROID: -0.105
 POA TO CENTROID: 0.197
 HORZ SPREAD: 1.963
 VERT SPREAD: 0.936
 GROUP SPREAD: 1.970
 MIN RADIUS: 0.197
 MAX RADIUS: 1.083
 MEAN RADIUS: 0.643
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.171	-0.424
2:	1.242	-0.235
3:	-0.483	-0.553
4:	-0.721	-0.399
5:	-0.707	0.052
6:	0.526	0.383
7:	0.040	0.226
8:	-0.065	0.008
9:	0.335	-0.208
10:	0.330	0.098



TARGET APPROX 1/2 SCALE