

G-657 2240

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

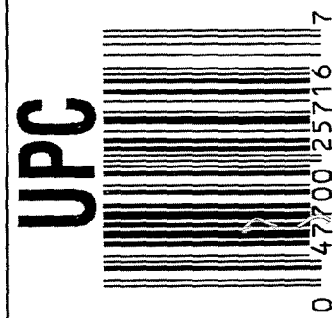
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6577240



ORDER 25716

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

UPC



0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



66577240

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577240

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-24-06	RTZ
420	ASSEMBLE ACTION		8-24-06	RTZ
430	ASSEMBLE TO STOCK		8-24-06	BD
440	PROOF	MAGNA-FLUX	8-24-06	TRW
460	CHECK HEADSPACE	INSPECTED	8-24-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 01 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <i>unab</i>	9/1/06	<i>unab</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-1-06	CW
510	DRILL AND TAP SIGHT HOLES		9-1-06	TRW
520	GOFF BLAST BBL / REC		9-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/11/06	TRB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-11-06	A
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-11-06	A
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-11-06	A
	D) OIL FIRING PIN ASSEMBLY		9-14-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	9-25-06	MM
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	9-25-06	MM
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	9-25-06	MM
	J) ASSEMBLE STOCK		9-14-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10-6-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-14-06	BLC
	M) IRON SIGHT ALIGNMENT		9-14-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-14-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-14-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-14-06	MM
670	FINAL INSPECTION A) HEADSPACE		10-6-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.53</u> <u>2.57</u> <u>2.60</u> <u>2.57</u>	9-15-06	DA
	C) FUNCTION		10-6-06	L.P.D.
690	PACK		10-27-06	DA

F004 REV 5/2006

BARBER - M24 0087301AVERAGE 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 9-9-06TESTER MTM

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.44	2.42	2.49	
PULL #2	2.46	2.33	2.46	
PULL #3	2.54	2.41	2.66	
PULL #4	2.50	2.58	2.72	
PULL #5	2.58	2.63	2.48	
TOTAL	12.52	12.37	12.81	
AVERAGE	2.50	2.47	2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	2.98	2.88	
PULL #2	2.99	2.72	
PULL #3	2.98	2.79	
PULL #4	2.94	3.02	
PULL #5	2.91	2.83	
TOTAL	14.80	14.24	
AVERAGE	2.96	2.85	

	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	4.01	4.12		3.99
PULL #2	3.96	3.97		3.98
PULL #3	4.00	3.92		4.22
PULL #4	3.99	3.96		4.22
PULL #5	3.99	3.91		3.93
TOTAL	19.95	19.88		20.34
AVERAGE	3.99	3.98		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577240.__0
FILE DATE AND TIME: 09/15/2006 05:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.041
The Average Y Centroid of the Five Target Set:	-0.033
The Average Point of Impact of the Five Target Set:	0.053
The Average Mean Radius of the Five Target Set:	0.561
The Distance from POA to Centroid Target #1:	0.101
The Distance from Centroid Target #2 to Centroid Target #1:	0.125
The Distance from Centroid Target #3 to Centroid Target #1:	0.133
The Distance from Centroid Target #4 to Centroid Target #1:	0.189
The Distance from Centroid Target #5 to Centroid Target #1:	0.170

SERIAL NUMBER: G6577240. __ 0

TARGET NUMBER: 1

FILE DATE: 09/15/2006

FILE TIME: 05:54

POINT#	X	Y
1:	-0.090	-1.502
2:	1.210	0.850
3:	-0.215	-0.446
4:	0.270	-0.391
5:	-0.848	0.075
6:	0.375	0.391
7:	0.251	0.683
8:	-0.073	0.309
9:	-0.147	0.192
10:	-0.246	0.728

X CENTROID: 0.049

Y CENTROID: 0.089

POA TO CENTROID: 0.101

HORZ SPREAD: 2.058

VERT SPREAD: 2.352

GROUP SPREAD: 2.687

MIN RADIUS: 0.221

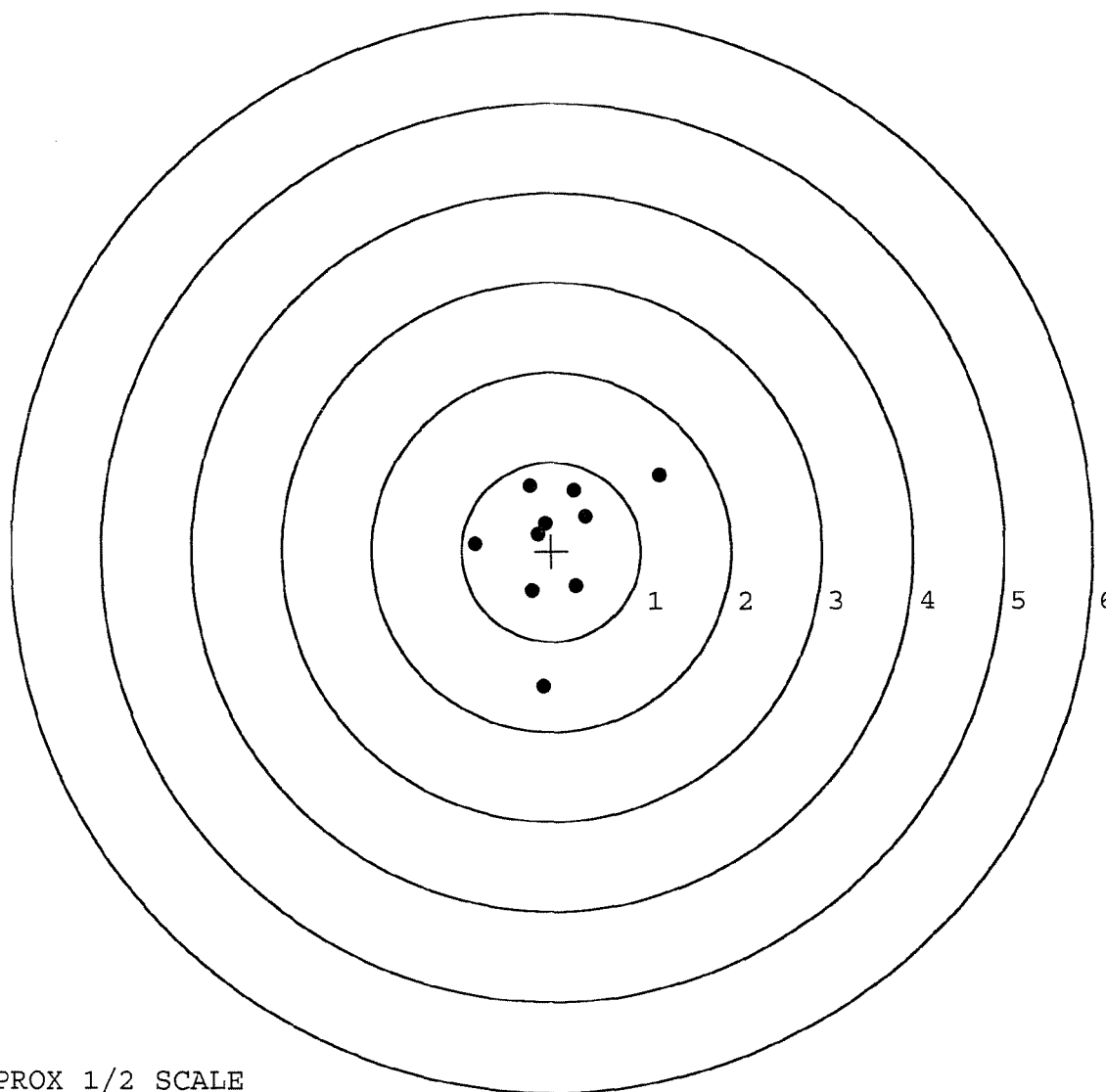
MAX RADIUS: 1.597

MEAN RADIUS: 0.726

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577240. 0

TARGET NUMBER: 2

FILE DATE: 09/15/2006

FILE TIME: 05:54

X CENTROID: 0.033

Y CENTROID: -0.035

POA TO CENTROID: 0.048

HORZ SPREAD: 1.224

VERT SPREAD: 2.763

GROUP SPREAD: 2.786

MIN RADIUS: 0.340

MAX RADIUS: 1.472

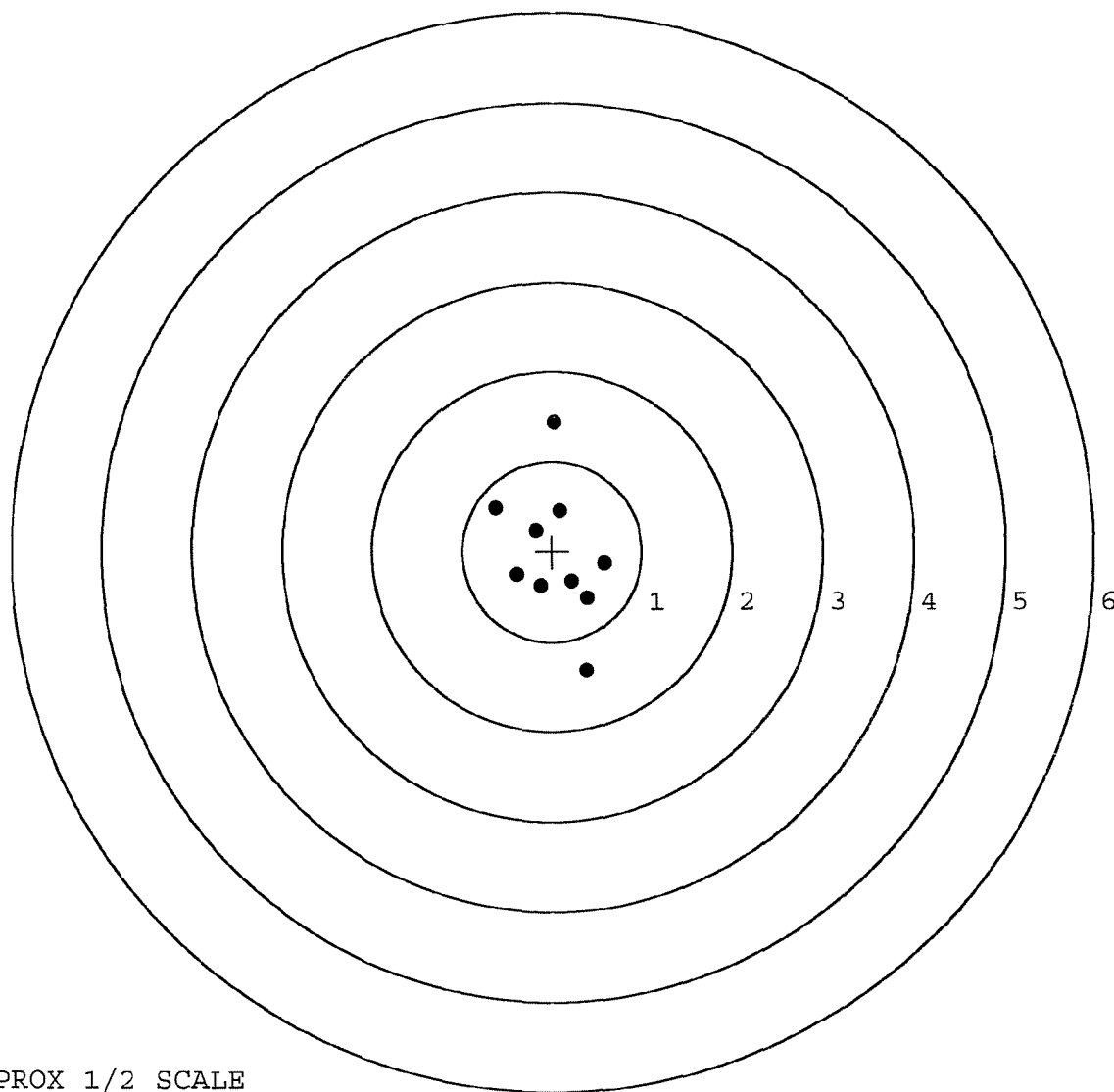
MEAN RADIUS: 0.685

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.381	-1.326
2:	0.022	1.437
3:	-0.639	0.480
4:	0.081	0.447
5:	-0.183	0.227
6:	-0.400	-0.263
7:	-0.127	-0.381
8:	0.585	-0.130
9:	0.388	-0.517
10:	0.218	-0.327



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577240. __0

TARGET NUMBER: 3

FILE DATE: 09/15/2006

FILE TIME: 05:54

X CENTROID: 0.063

Y CENTROID: -0.044

POA TO CENTROID: 0.076

HORZ SPREAD: 0.623

VERT SPREAD: 1.580

GROUP SPREAD: 1.608

MIN RADIUS: 0.102

MAX RADIUS: 0.988

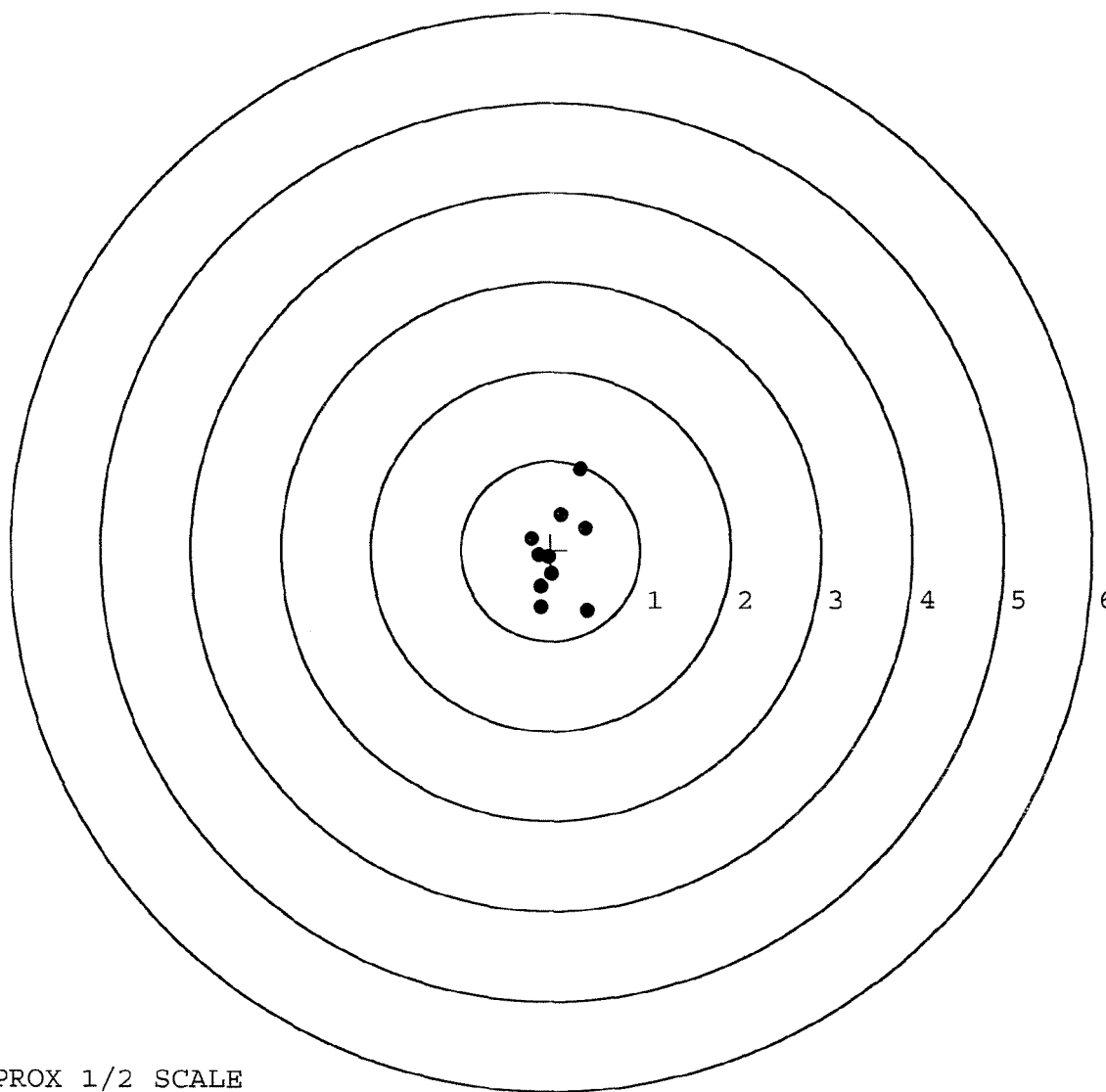
MEAN RADIUS: 0.448

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.327	0.908
2:	0.382	0.250
3:	0.113	0.400
4:	0.407	-0.672
5:	-0.112	-0.639
6:	0.011	-0.270
7:	-0.216	0.132
8:	-0.135	-0.058
9:	-0.033	-0.078
10:	-0.117	-0.411



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577240. 0

TARGET NUMBER: 4

FILE DATE: 09/15/2006

FILE TIME: 05:54

X CENTROID: 0.046

Y CENTROID: -0.100

POA TO CENTROID: 0.110

HORZ SPREAD: 1.238

VERT SPREAD: 1.374

GROUP SPREAD: 1.403

MIN RADIUS: 0.041

MAX RADIUS: 0.852

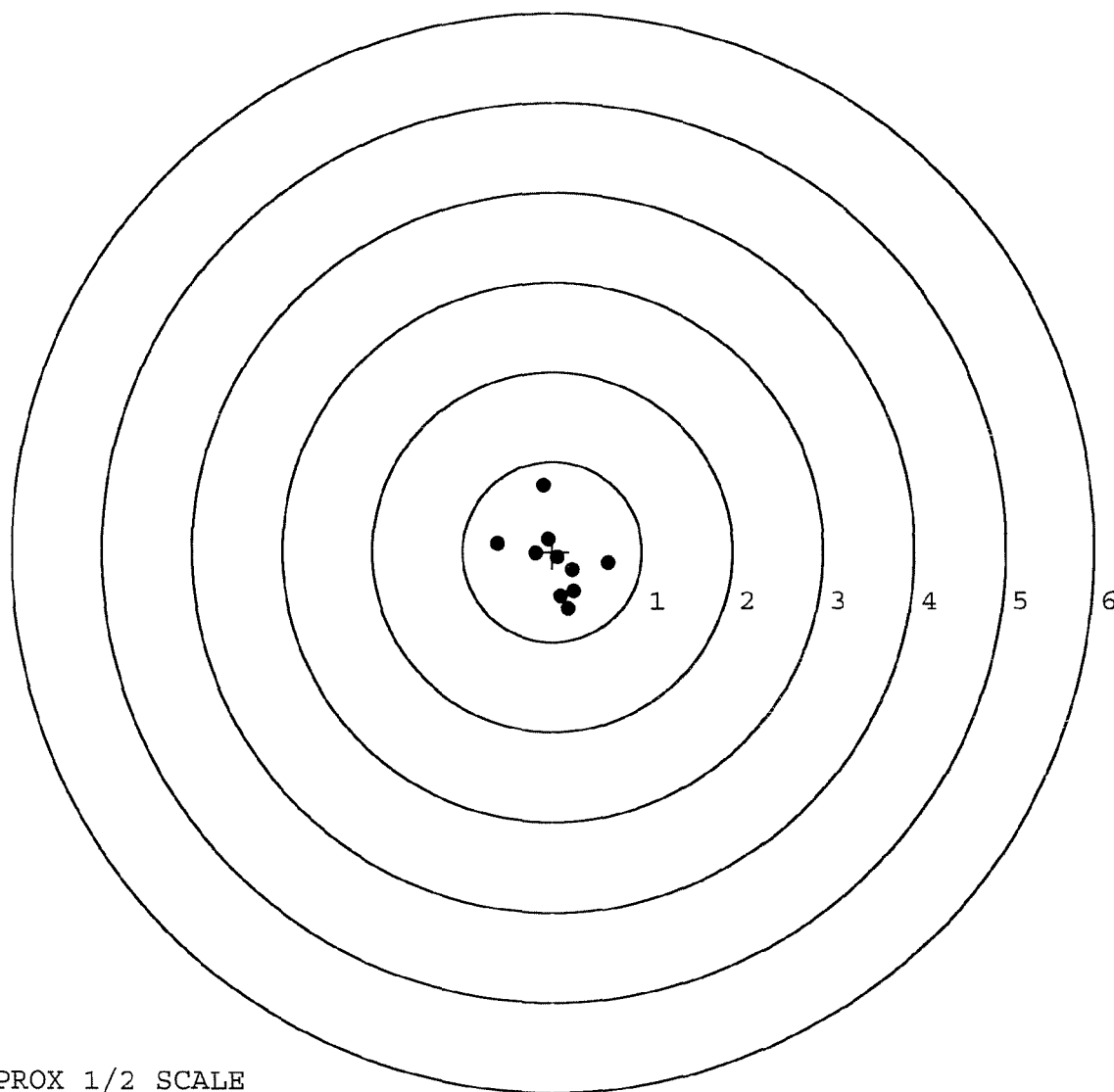
MEAN RADIUS: 0.422

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.104	0.739
2:	-0.612	0.092
3:	-0.193	-0.016
4:	-0.049	0.146
5:	0.626	-0.124
6:	0.178	-0.635
7:	0.092	-0.497
8:	0.238	-0.442
9:	0.224	-0.202
10:	0.059	-0.061



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577240. __0

TARGET NUMBER: 5

FILE DATE: 09/15/2006

FILE TIME: 05:54

X CENTROID: 0.014

Y CENTROID: -0.077

POA TO CENTROID: 0.078

HORZ SPREAD: 0.913

VERT SPREAD: 1.693

GROUP SPREAD: 1.700

MIN RADIUS: 0.184

MAX RADIUS: 0.987

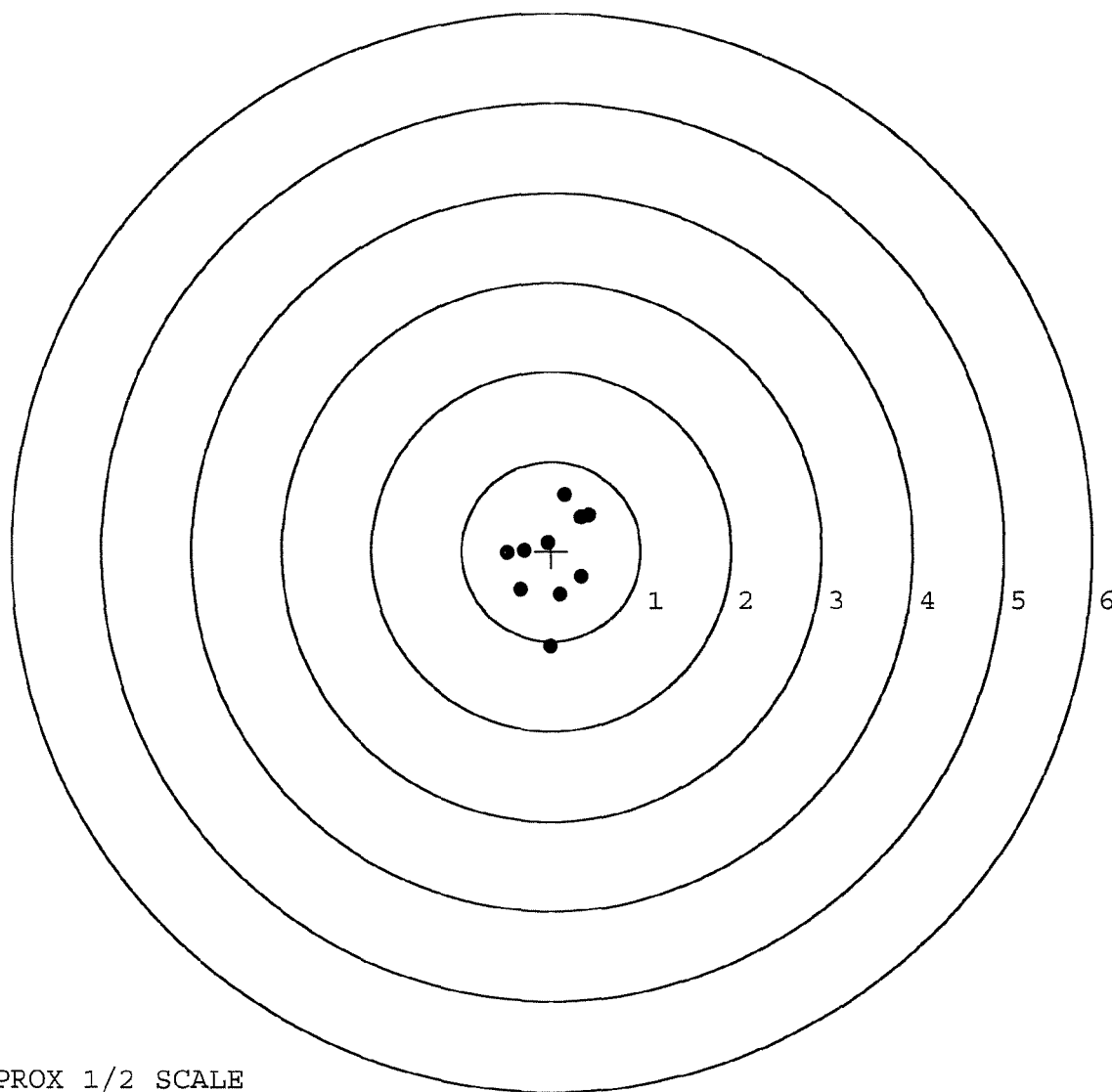
MEAN RADIUS: 0.523

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.008	-1.064
2:	0.338	-0.287
3:	0.096	-0.481
4:	-0.353	-0.437
5:	-0.494	-0.023
6:	0.151	0.629
7:	0.419	0.405
8:	-0.041	0.099
9:	-0.302	0.009
10:	0.333	0.379



TARGET APPROX 1/2 SCALE