

G-6535368

ORDER 25716

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

UPC



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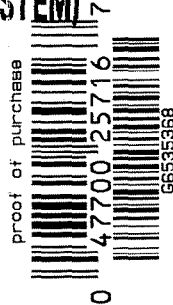
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

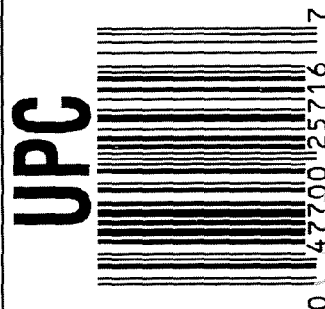


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6535368



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6535368

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-22-06	RTZ
420	ASSEMBLE ACTION		8-22-06	RTZ
430	ASSEMBLE TO STOCK		8-23-06	RP
440	PROOF	MAGNA-FLUX INSPECTED	8-23-06	TRL
460	CHECK HEADSPACE	AUG 24 2006	8-23-06	TRL
470	DIS-ASSEMBLE ACTION		8-23-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unus</u>	8/24/06	<u>unus</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-24-06	CW
510	DRILL AND TAP SIGHT HOLES		8-23-06	TRL
520	GOFF BLAST BBL / REC		8-25-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/31/06	RE
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-6-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-6-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-6-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		9-6-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/12/06	mon

F004 REV 5/2006

OP #	OPERATION	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>60</u> <u>5.5</u> <u>5.5</u>	9-8-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>30</u> <u>30</u>	9-8-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/12/06	mom
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	9-8-06	RA
	J) ASSEMBLE STOCK		9-6-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		10/12/06	mom
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-6-06	RTZ
	M) IRON SIGHT ALIGNMENT		9-6-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-6-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	9-6-06	S.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/6/06	M.P.D.
670	FINAL INSPECTION A) HEADSPACE		10/12/06	mom
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.22</u> <u>2.36</u> <u>2.25</u> <u>2.20</u>	9-7-06	mom
	C) FUNCTION		10/12/06	mom
690	PACK		10-30-06	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 8-30-06

TESTER mjm

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.44	2.32	2.44	
PULL #2	2.32	2.58	2.38	
PULL #3	2.44	2.68	2.46	
PULL #4	2.43	2.60	2.46	
PULL #5	2.43	2.72	2.50	
TOTAL	12.06	12.96	12.30	
AVERAGE	2.41	2.59	2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.05	2.99	
PULL #2	2.91	3.05	
PULL #3	3.15	3.04	
PULL #4	3.01	2.92	
PULL #5	3.09	3.02	
TOTAL	15.21	15.02	
AVERAGE	3.04	3.00	

	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	3.94	4.12		3.98
PULL #2	3.84	4.18		4.05
PULL #3	3.88	4.14		4.08
PULL #4	3.79	4.02		4.10
PULL #5	4.03	4.08		4.19
TOTAL	19.51	20.54		20.40
AVERAGE	3.90	4.11		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535368.___0
FILE DATE AND TIME: 09/06/2006 05:52

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.013
The Average Y Centroid of the Five Target Set:	-0.012
The Average Point of Impact of the Five Target Set:	0.018
The Average Mean Radius of the Five Target Set:	0.683
The Distance from POA to Centroid Target #1:	0.073
The Distance from Centroid Target #2 to Centroid Target #1:	0.056
The Distance from Centroid Target #3 to Centroid Target #1:	0.135
The Distance from Centroid Target #4 to Centroid Target #1:	0.144
The Distance from Centroid Target #5 to Centroid Target #1:	0.078

SERIAL NUMBER: G6535368. 0

TARGET NUMBER: 1

FILE DATE: 09/06/2006

FILE TIME: 05:52

POINT#	X	Y
1:	-0.652	1.130
2:	-0.634	-0.156
3:	-0.854	-0.606
4:	0.415	-0.623
5:	0.603	-0.138
6:	0.202	0.231
7:	0.001	-0.025
8:	0.332	-0.039
9:	0.211	-0.186
10:	0.258	-0.305

X CENTROID: -0.012

Y CENTROID: -0.072

POA TO CENTROID: 0.073

HORZ SPREAD: 1.457

VERT SPREAD: 1.753

GROUP SPREAD: 2.052

MIN RADIUS: 0.048

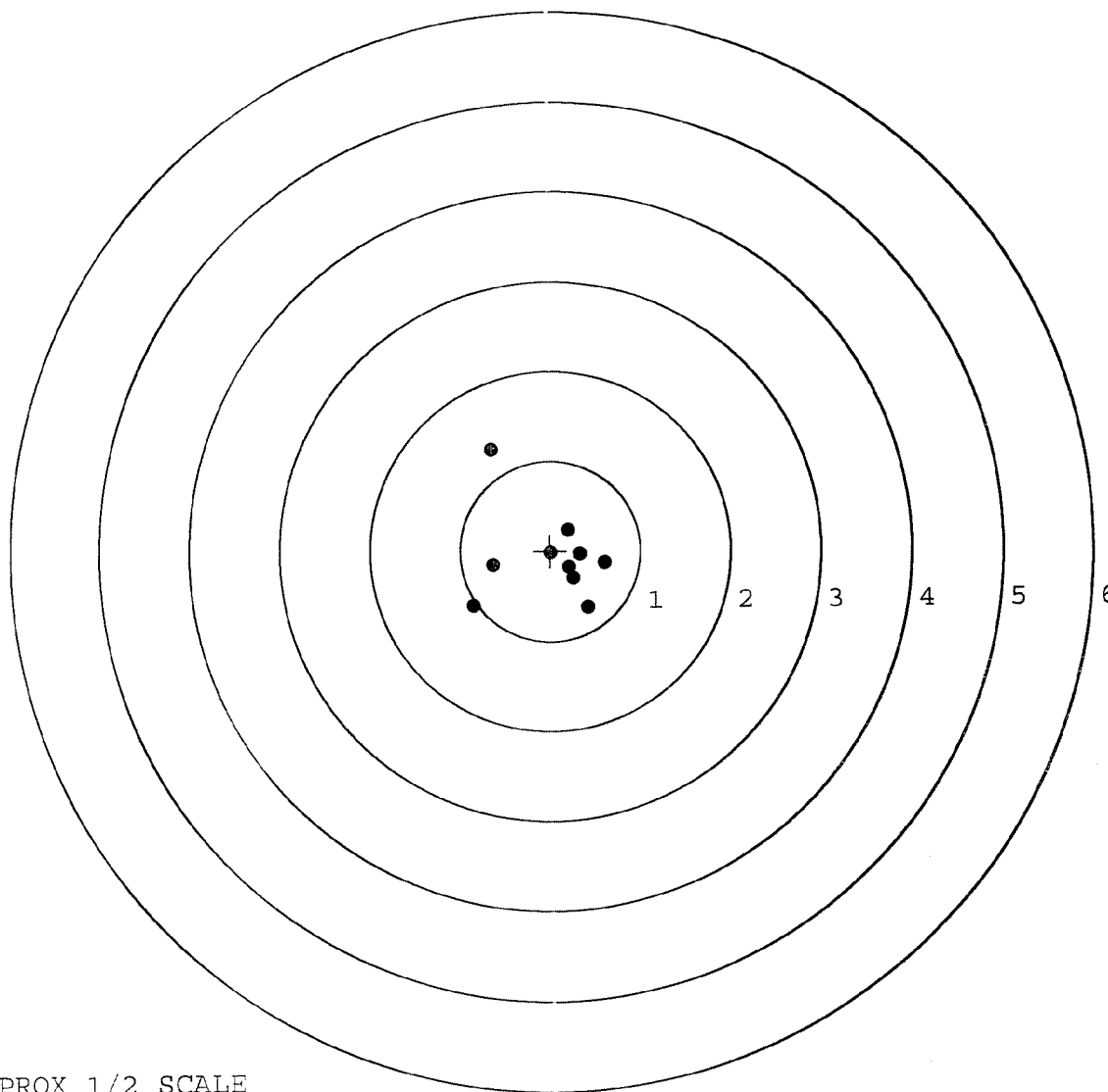
MAX RADIUS: 1.362

MEAN RADIUS: 0.567

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

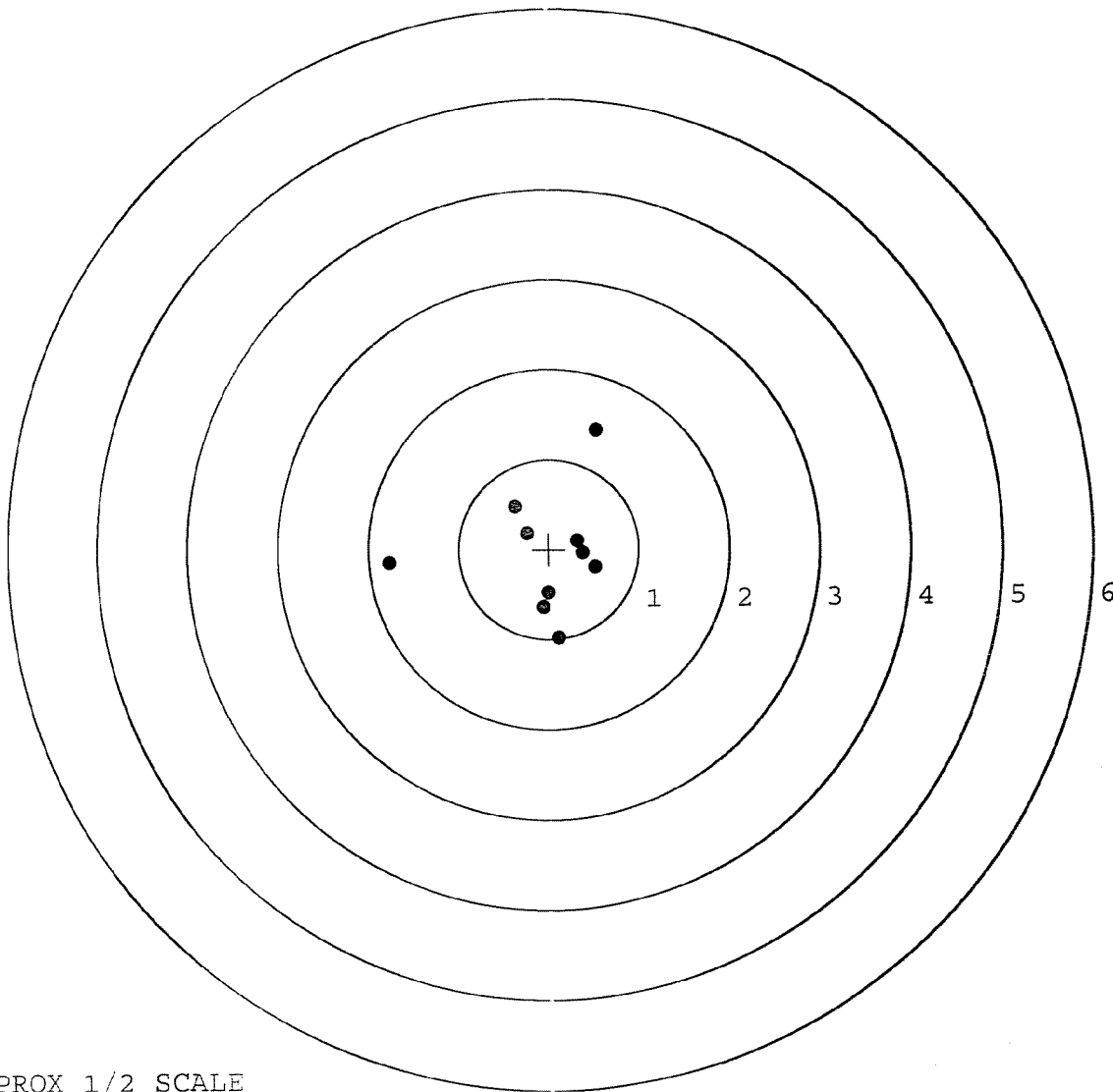


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535368. __0
 TARGET NUMBER: 2
 FILE DATE: 09/06/2006
 FILE TIME: 05:52

X CENTROID: -0.061
 Y CENTROID: -0.045
 POA TO CENTROID: 0.076
 HORZ SPREAD: 2.298
 VERT SPREAD: 2.314
 GROUP SPREAD: 2.729
 MIN RADIUS: 0.287
 MAX RADIUS: 1.713
 MEAN RADIUS: 0.755
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.771	-0.150
2:	0.527	1.322
3:	-0.376	0.480
4:	-0.243	0.177
5:	0.315	0.094
6:	0.379	-0.042
7:	0.520	-0.200
8:	0.113	-0.992
9:	-0.065	-0.647
10:	-0.011	-0.488



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535368. __0

TARGET NUMBER: 3

FILE DATE: 09/06/2006

FILE TIME: 05:52

POINT#	X	Y
1:	-0.214	-0.817
2:	0.352	0.431
3:	0.774	0.289
4:	0.674	-0.269
5:	0.382	-0.313
6:	0.056	-0.378
7:	-0.167	-0.136
8:	-0.509	0.248
9:	-0.194	0.375
10:	-0.190	0.662

X CENTROID: 0.096

Y CENTROID: 0.009

POA TO CENTROID: 0.097

HORZ SPREAD: 1.283

VERT SPREAD: 1.479

GROUP SPREAD: 1.483

MIN RADIUS: 0.301

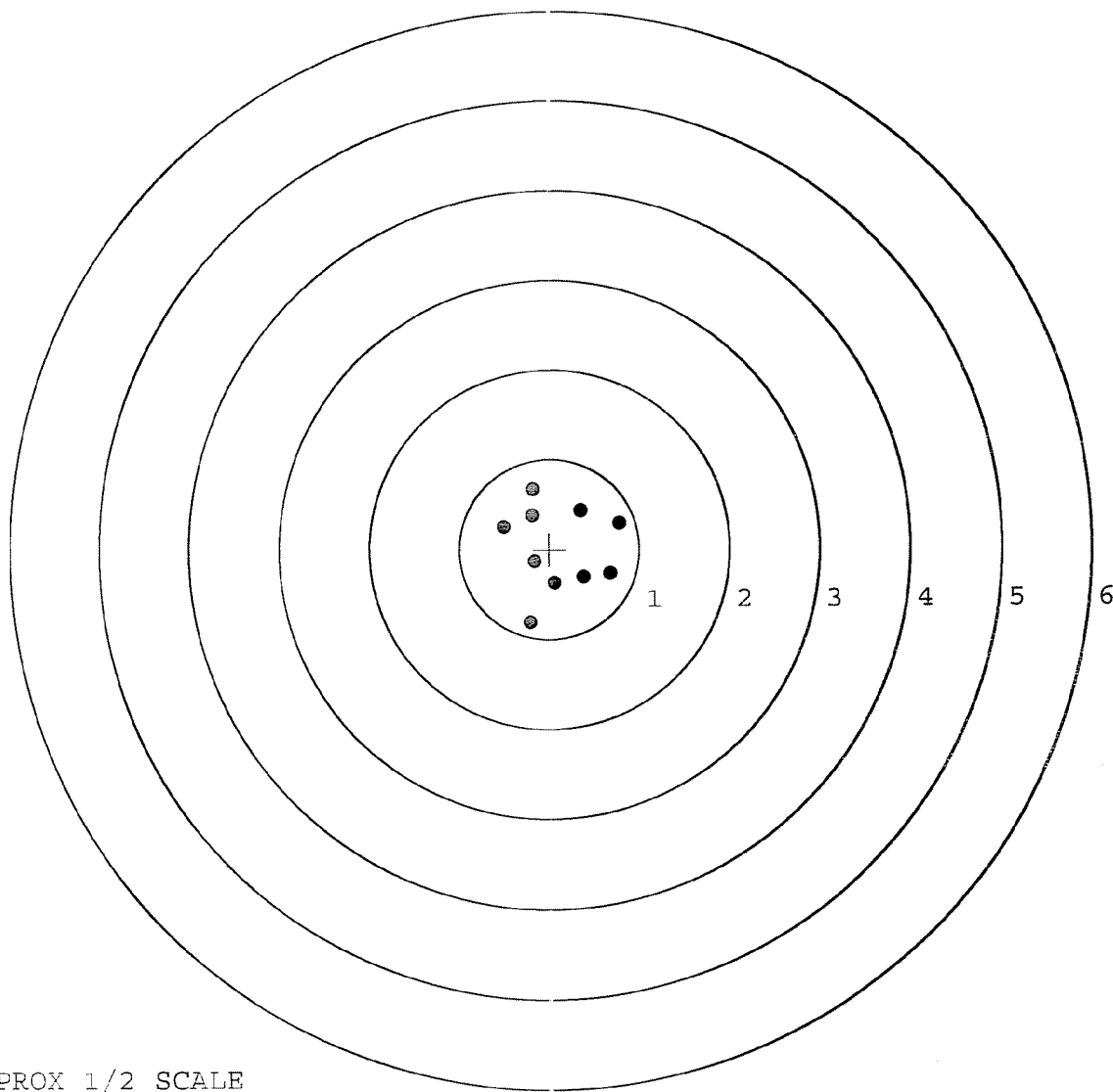
MAX RADIUS: 0.883

MEAN RADIUS: 0.570

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

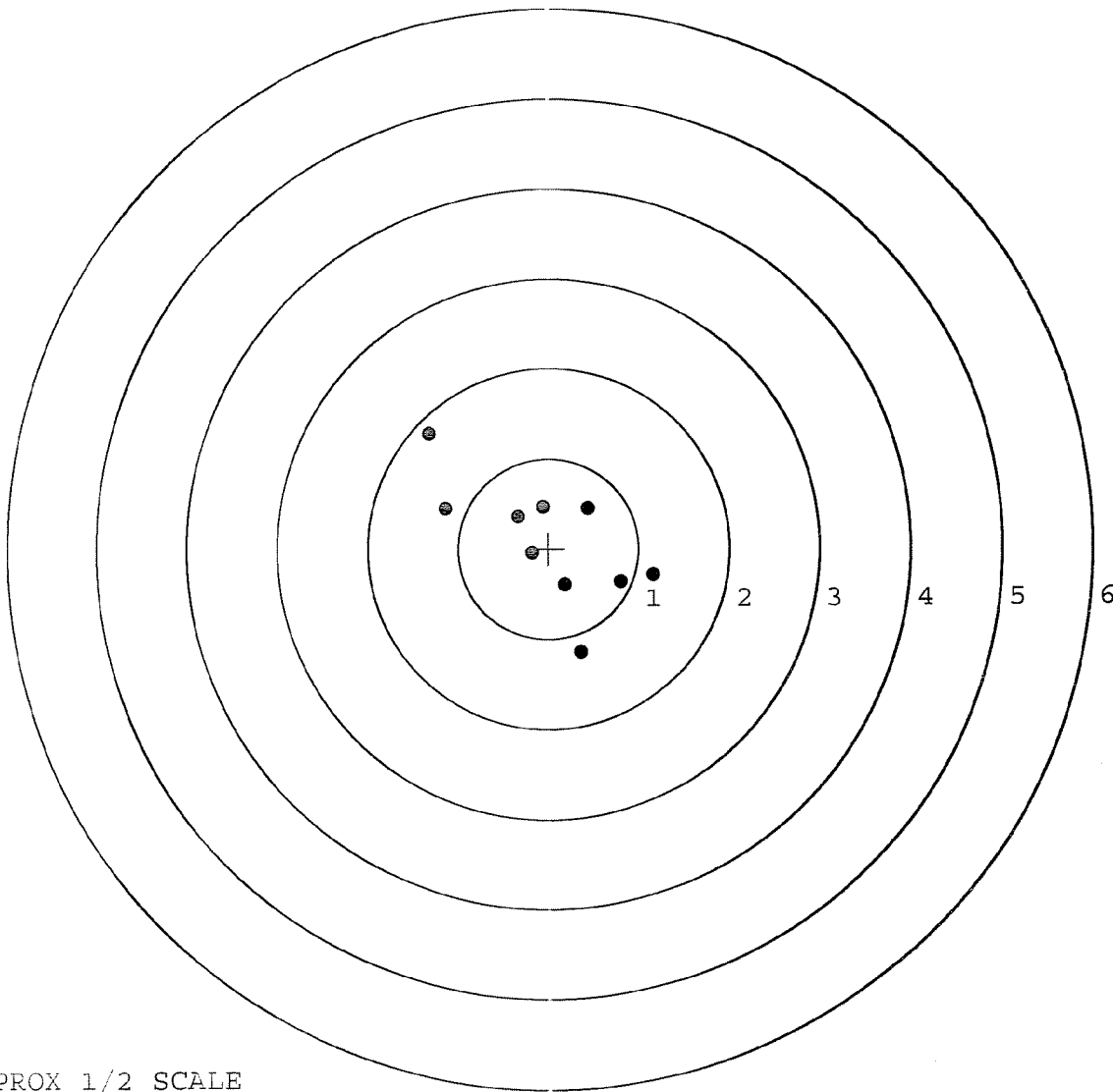


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535368. 0
 TARGET NUMBER: 4
 FILE DATE: 09/06/2006
 FILE TIME: 05:52

POINT#	X	Y
1:	-1.321	1.274
2:	-1.143	0.452
3:	-0.337	0.355
4:	-0.065	0.464
5:	0.445	0.447
6:	-0.185	-0.049
7:	0.186	-0.401
8:	0.363	-1.147
9:	1.162	-0.296
10:	0.804	-0.372

X CENTROID: -0.009
 Y CENTROID: 0.073
 POA TO CENTROID: 0.073
 HORZ SPREAD: 2.483
 VERT SPREAD: 2.421
 GROUP SPREAD: 2.949
 MIN RADIUS: 0.214
 MAX RADIUS: 1.779
 MEAN RADIUS: 0.855
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535368. 0

TARGET NUMBER: 5

FILE DATE: 09/06/2006

FILE TIME: 05:52

POINT#	X	Y
1:	-0.667	-1.207
2:	-0.307	0.867
3:	-0.351	0.405
4:	-0.051	0.340
5:	-0.571	-0.132
6:	-0.144	-0.146
7:	0.326	-0.159
8:	0.699	-0.363
9:	0.837	0.117
10:	0.739	0.023

X CENTROID: 0.051

Y CENTROID: -0.026

POA TO CENTROID: 0.057

HORZ SPREAD: 1.504

VERT SPREAD: 2.074

GROUP SPREAD: 2.105

MIN RADIUS: 0.229

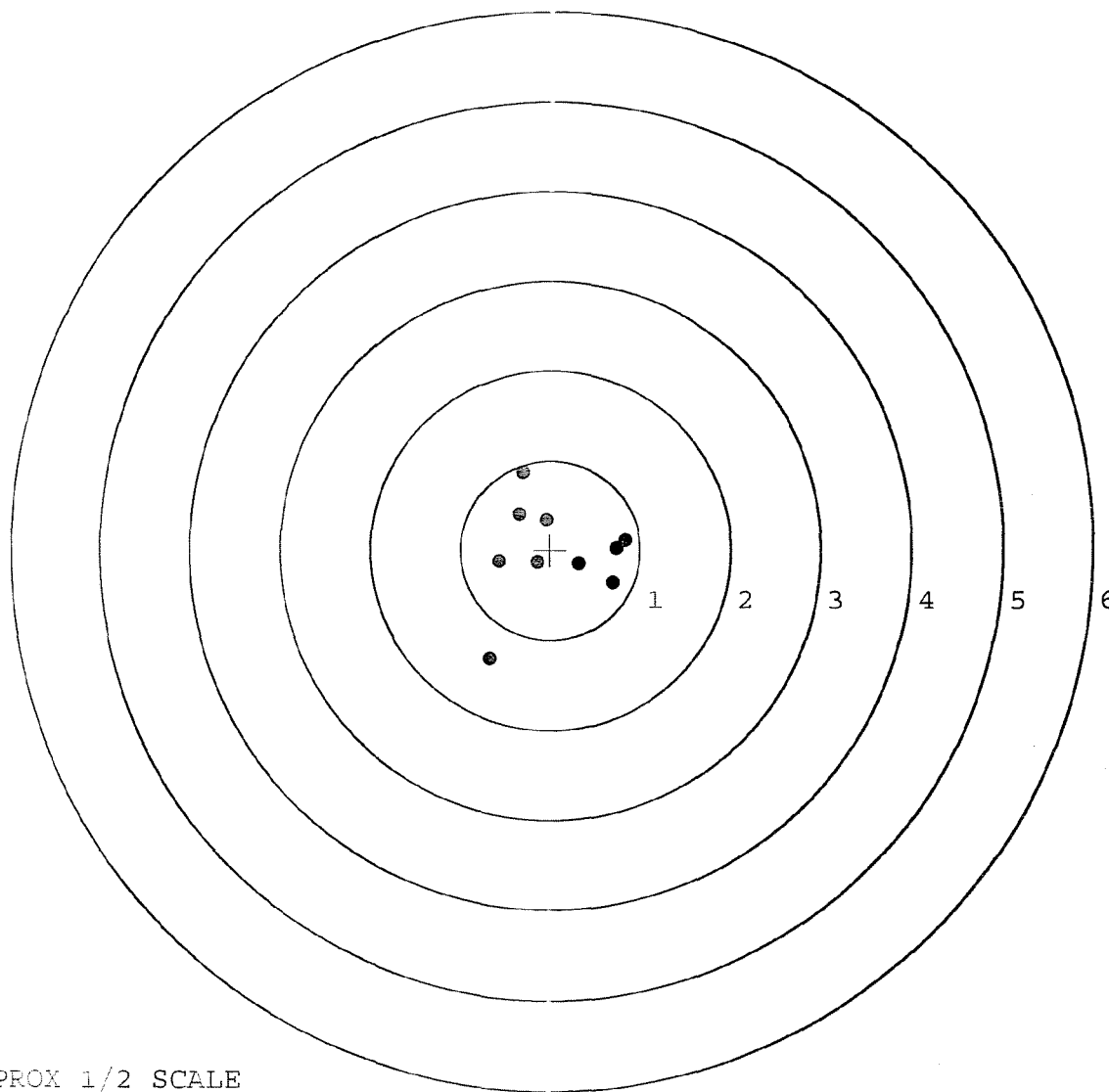
MAX RADIUS: 1.383

MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE