

G 6535414

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



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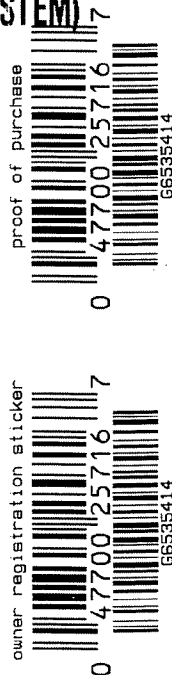
SERIAL NO.



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

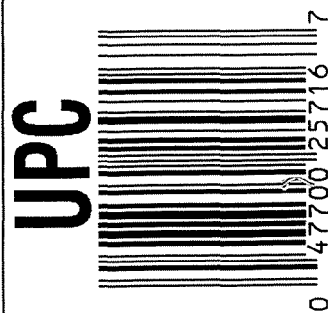
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6535414



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5414

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-27-06	RTZ
440	PROOF		2/27/06	MJD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	2/27/06	MJD
470	DIS-ASSEMBLE ACTION		2-28-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 MAR 01 2006 APD	3-1-06	APD
500	ROLLMARK CALIBER		3-1-06	CW
510	DRILL AND TAP SIGHT HOLES		2-28-06	TRW
520	GOFF BLAST BBL / REC		3-2-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		3/10	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/12/06	MJD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/12/06	MJD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/12/06	MJD
	D) OIL FIRING PIN ASSEMBLY		4-12-06	Ac
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4-12-06	Ac

REV-8405

OP # OPERATION NAME		READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8 lbs</u>	<u>8 lbs</u>	<u>8 lbs</u>	5-3-06	AC		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs</u>	<u>4 lbs</u>	<u>4 lbs</u>	5-3-06	AC		
	H) TRIGGER PULL TEST AND RETAINABILITY				N/A	AC		
	I) FIRING PIN INDENT .020 MIN	<u>.022</u>	<u>.022</u>	<u>.022</u>	5-3-06	AC		
	J) ASSEMBLE STOCK				4-12-06	AC		
	K) ASSEMBLE SWIVEL STUDS				5-3-06	AC		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				4-12-06	AC		
	M) IRON SIGHT ALIGNMENT				4-12-06	AC		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				4-12-06	AC		
640 & 650	FUNCTION TEST AND TARGET	PASS	FAIL		4-19-06	mom		
		PASS	FAIL					
	MALFUNCTION Bolt off	CORRECTION OK			4-21-06	TRW		
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION N/A						
	MALFUNCTION	CORRECTION						
660	INSPECT FOR LIVE AMMO				4-19-06	L.P.D.		
670	FINAL INSPECTION A) HEADSPACE				5-3-06	AC		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u>	<u>2.61</u>	<u>2.80</u>	<u>2.95</u>	<u>2.70</u>	5-3-06	AC
	C) FUNCTION				5-3-06	AC		
690	PACK				6-27-06	DA		

BARBER - M24 0092032AVERAGE 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 4-12-06TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	251	240		242	
PULL #2	256	244		252	
PULL #3	250	240		252	
PULL #4	248	240		251	
PULL #5	253	241		242	
TOTAL	1258	1205		1239	
AVERAGE	251	241		247	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	318	295		
PULL #2	317	3285		
PULL #3	318	315		
PULL #4	297	325		
PULL #5	323	317		
TOTAL	1573	1577		
AVERAGE	314	315		

	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	405	405		408
PULL #2	415	408		405
PULL #3	400	406		421
PULL #4	406	394		409
PULL #5	405	401		408
TOTAL	2031	2014		2051
AVERAGE	406	402		410

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535414.___0
FILE DATE AND TIME: 04/19/2006 16:25

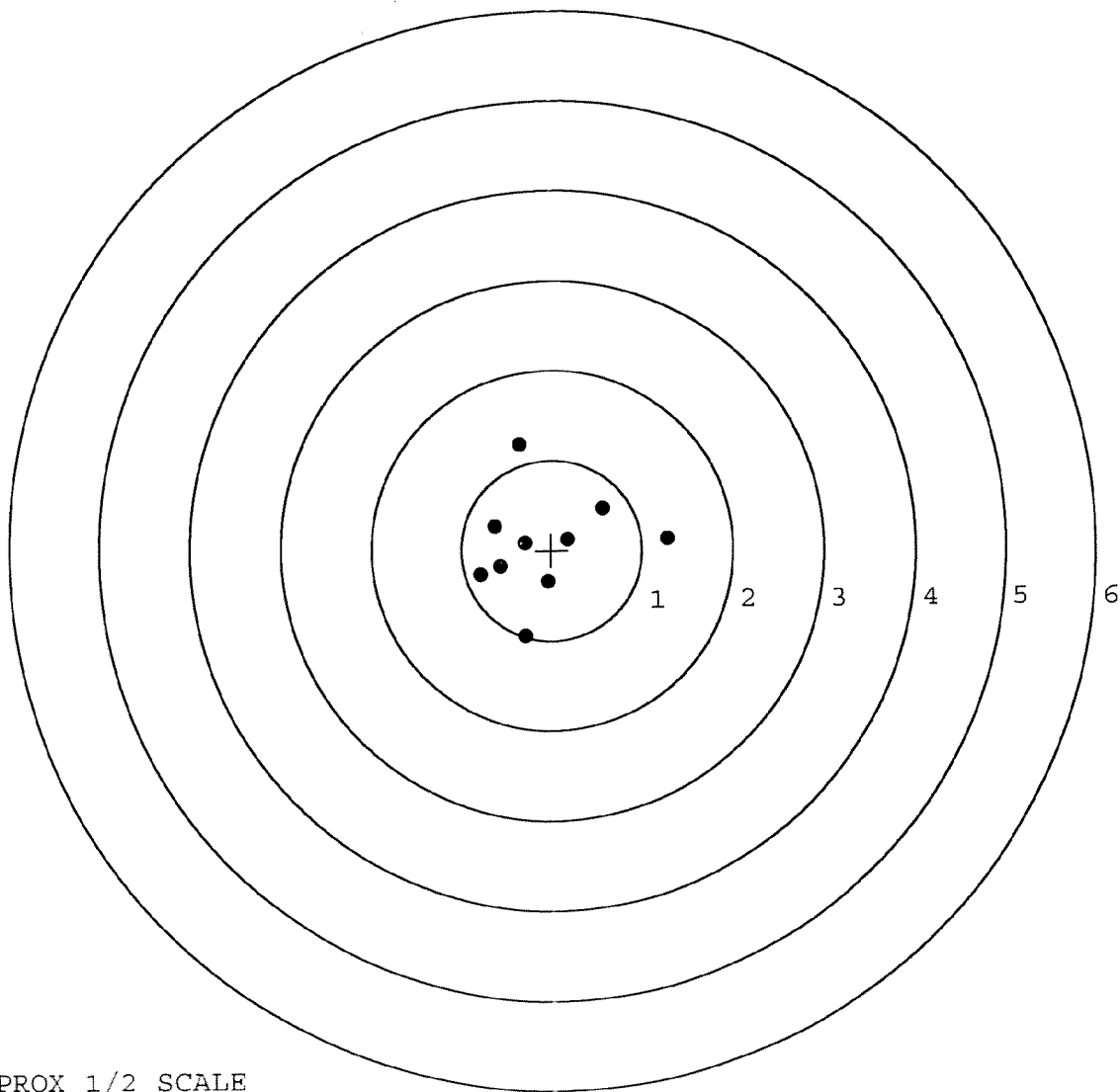
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.011
The Average Y Centroid of the Five Target Set:	0.027
The Average Point of Impact of the Five Target Set:	0.029
The Average Mean Radius of the Five Target Set:	0.676
The Distance from POA to Centroid Target #1:	0.106
The Distance from Centroid Target #2 to Centroid Target #1:	0.383
The Distance from Centroid Target #3 to Centroid Target #1:	0.240
The Distance from Centroid Target #4 to Centroid Target #1:	0.336
The Distance from Centroid Target #5 to Centroid Target #1:	0.448

SERIAL NUMBER: G6535414. 0
 TARGET NUMBER: 1
 FILE DATE: 04/19/2006
 FILE TIME: 16:25

X CENTROID: -0.095
 Y CENTROID: 0.046
 POA TO CENTROID: 0.106
 HORZ SPREAD: 2.064
 VERT SPREAD: 2.129
 GROUP SPREAD: 2.102
 MIN RADIUS: 0.205
 MAX RADIUS: 1.373
 MEAN RADIUS: 0.709
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.181	0.120
2:	0.569	0.457
3:	1.276	0.121
4:	-0.043	-0.351
5:	-0.296	0.085
6:	-0.298	-0.949
7:	-0.629	0.261
8:	-0.353	1.180
9:	-0.568	-0.185
10:	-0.788	-0.278

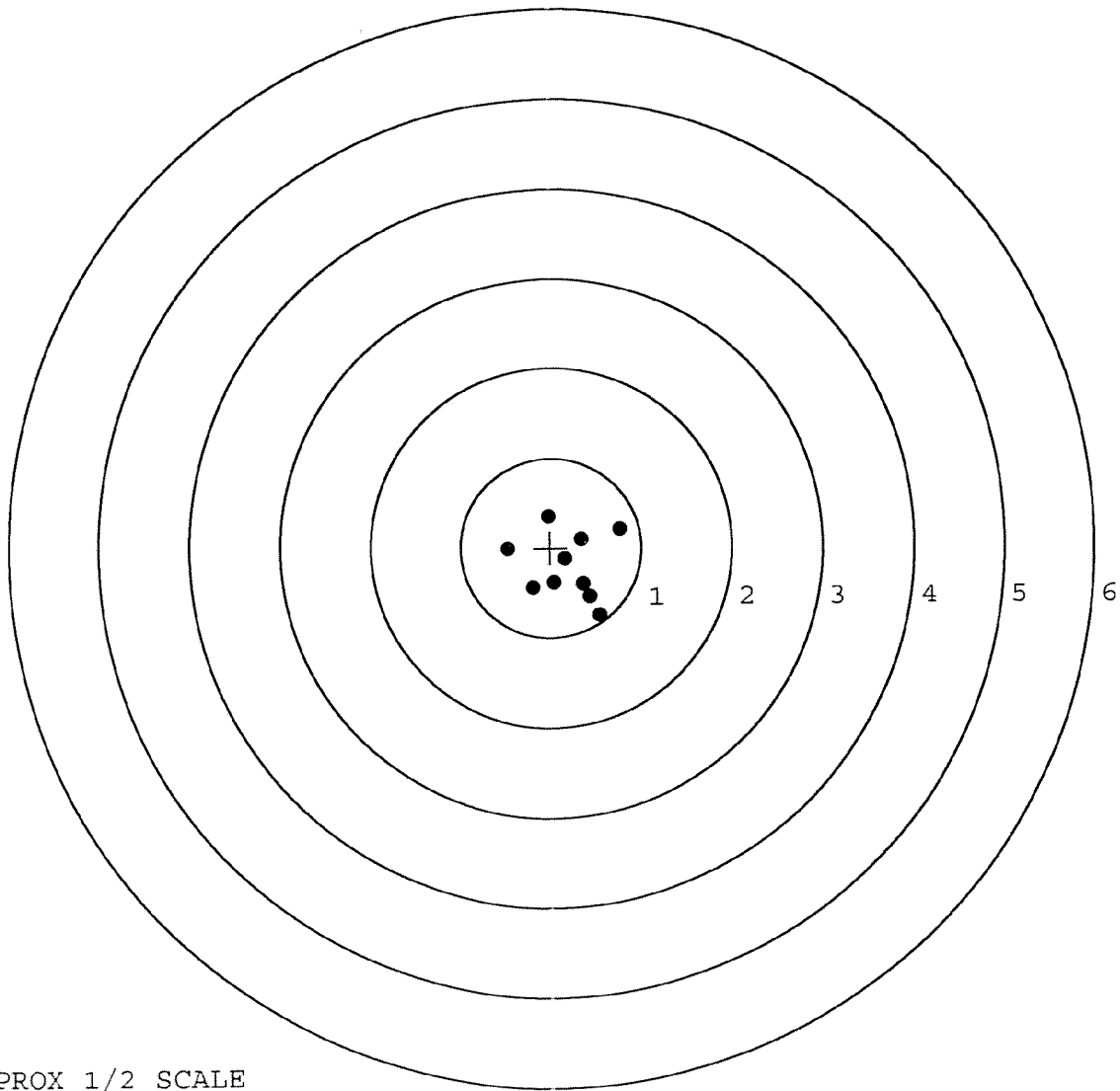


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535414. __0
 TARGET NUMBER: 2
 FILE DATE: 04/19/2006
 FILE TIME: 16:25

X CENTROID: 0.195
 Y CENTROID: -0.204
 POA TO CENTROID: 0.283
 HORZ SPREAD: 1.240
 VERT SPREAD: 1.104
 GROUP SPREAD: 1.261
 MIN RADIUS: 0.085
 MAX RADIUS: 0.705
 MEAN RADIUS: 0.446
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.023	0.348
2:	0.342	0.100
3:	0.764	0.212
4:	0.540	-0.756
5:	0.440	-0.550
6:	0.361	-0.411
7:	0.043	-0.394
8:	-0.198	-0.448
9:	0.161	-0.127
10:	-0.476	-0.018



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535414. __0

TARGET NUMBER: 3

FILE DATE: 04/19/2006

FILE TIME: 16:25

X CENTROID: -0.011

Y CENTROID: 0.271

POA TO CENTROID: 0.271

HORZ SPREAD: 1.367

VERT SPREAD: 1.785

GROUP SPREAD: 1.897

MIN RADIUS: 0.288

MAX RADIUS: 0.995

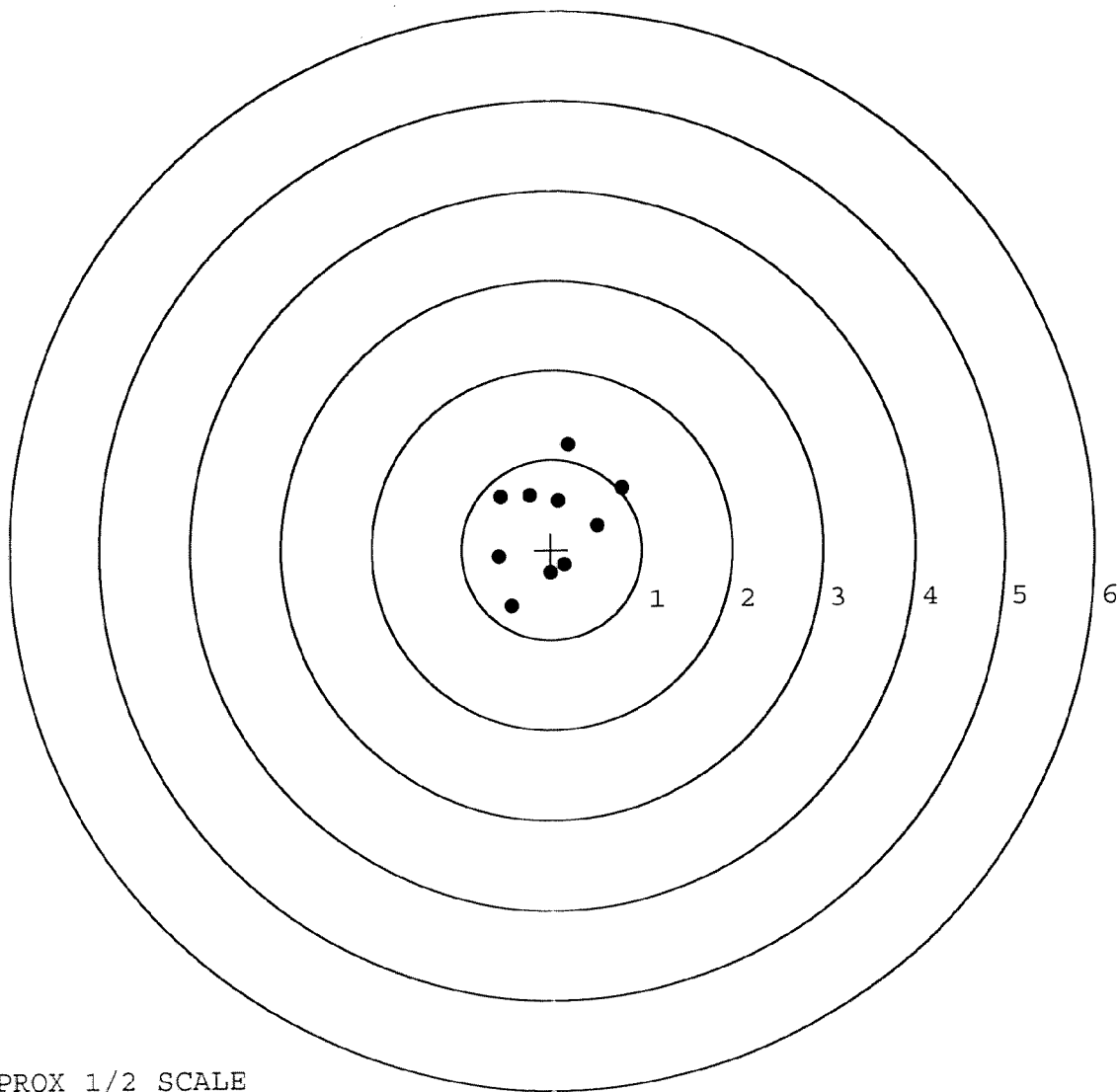
MEAN RADIUS: 0.632

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.086	0.542
2:	0.784	0.681
3:	0.200	1.160
4:	-0.564	0.589
5:	-0.583	-0.080
6:	-0.443	-0.625
7:	0.148	-0.171
8:	0.511	0.271
9:	-0.238	0.602
10:	-0.009	-0.258



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535414. __0

TARGET NUMBER: 4

FILE DATE: 04/19/2006

FILE TIME: 16:25

POINT#	X	Y
1:	0.104	0.323
2:	-0.268	0.245
3:	-0.295	0.529
4:	-0.420	0.733
5:	-0.729	0.325
6:	-0.306	0.217
7:	-0.366	1.403
8:	0.357	0.495
9:	0.786	-0.045
10:	-0.118	-0.416

X CENTROID: -0.125

Y CENTROID: 0.381

POA TO CENTROID: 0.401

HORZ SPREAD: 1.515

VERT SPREAD: 1.819

GROUP SPREAD: 1.850

MIN RADIUS: 0.197

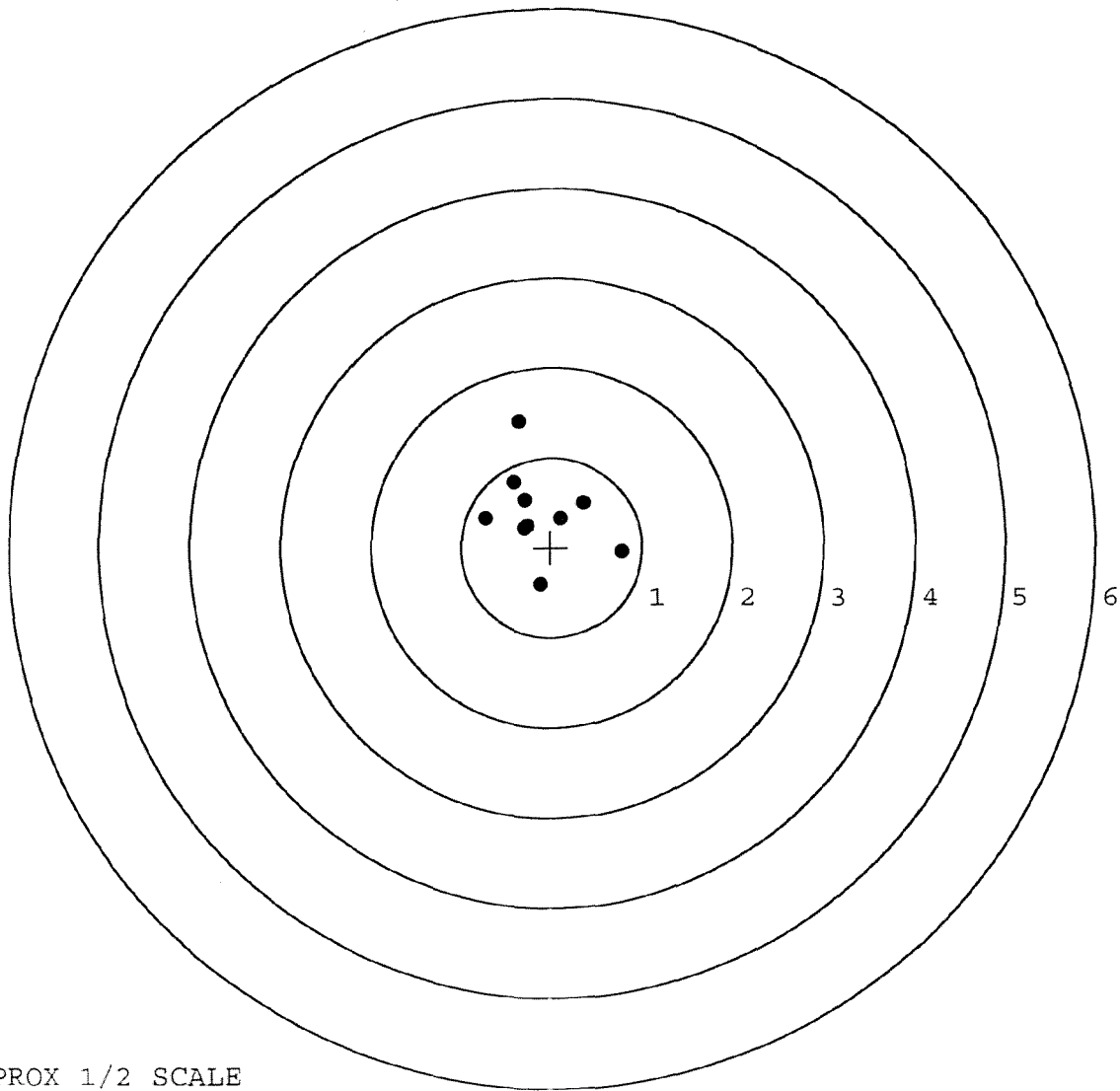
MAX RADIUS: 1.050

MEAN RADIUS: 0.532

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535414. __0

TARGET NUMBER: 5

FILE DATE: 04/19/2006

FILE TIME: 16:25

POINT#	X	Y
1:	-0.109	-0.460
2:	0.039	-1.102
3:	0.092	-1.554
4:	0.737	-1.819
5:	0.572	0.465
6:	0.344	0.841
7:	0.407	1.017
8:	-0.799	0.561
9:	-0.394	0.105
10:	0.042	-1.664

X CENTROID: 0.093

Y CENTROID: -0.361

POA TO CENTROID: 0.373

HORZ SPREAD: 1.536

VERT SPREAD: 2.836

GROUP SPREAD: 2.855

MIN RADIUS: 0.225

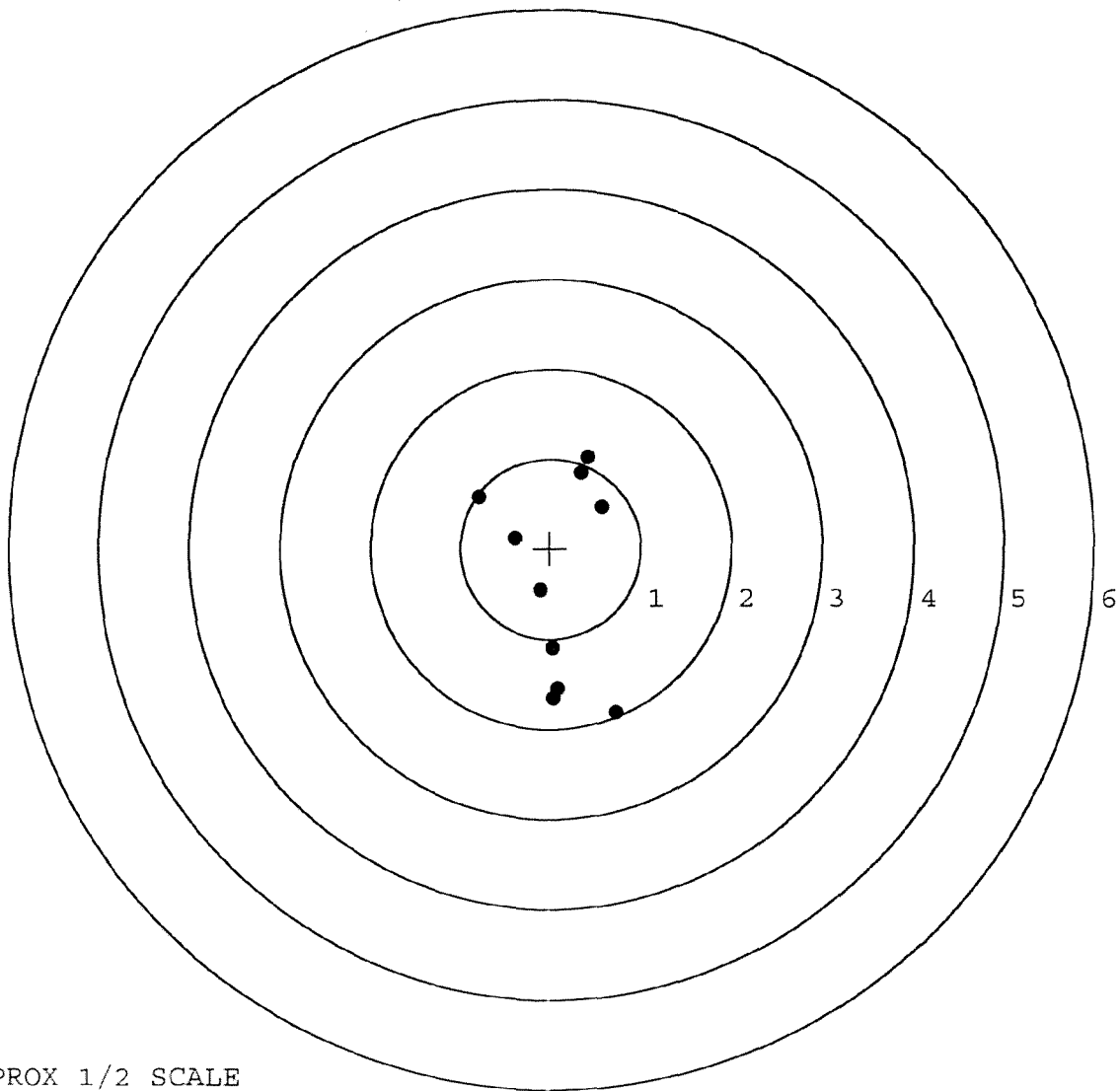
MAX RADIUS: 1.594

MEAN RADIUS: 1.061

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE