

G-652 1164

ORDER 25716

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

UPC



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UPC



SERIAL NO.



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

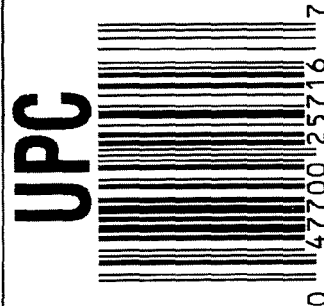
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6521164



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521164

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/12/05	CD
440	PROOF		10/12/05	CD
460	CHECK HEADSPACE		10/12/05	CD
470	DIS-ASSEMBLE ACTION		10/12/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	L180 <i>unsub</i>	10/18/05	<i>unsub</i>
500	ROLLMARK CALIBER		10/18/05	CW
510	DRILL AND TAP SIGHT HOLES		10/14/05	BR
520	GOFF BLAST BBL / REC		10/15/05	DG
530 & 540	APPLY COATINGS (BARREL ACTION)		10/24/05	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		10/28/05	MSM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/28/05	MSM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/28/05	MSM
	D) OIL FIRING PIN ASSEMBLY		11-1-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-16-05	BG

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.25</u> <u>7.0</u> <u>6.5</u>	12-16-05	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.25</u> <u>3.5</u> <u>3.5</u>	12-16-05	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0245</u> <u>.025</u> <u>.025</u>	12-16-05	TRW
	J) ASSEMBLE STOCK		11-1-05	RJL
	K) ASSEMBLE SWIVEL STUDS		12-16-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-8-05	h
	M) IRON SIGHT ALIGNMENT		12-8-05	h
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-8-05	h
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11/2/05	MM
	Bolt tight on ejection MALFUNCTION Lazy shell ejection	CORRECTION OK	11-7-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/2/05	MM
670	FINAL INSPECTION A) HEADSPACE		12-16-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.31</u> <u>2.33</u> <u>2.40</u> <u>2.60</u>	12/12/05	R.P.
	C) FUNCTION		12-16-05	BG
690	PACK		1-6-06	DA

BARBER - M24 0097467

 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)

SERIAL NO.

DATE

10-28-05

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.40		2.69	
PULL #2	2.55	2.43		2.70	
PULL #3	2.55	2.50		2.68	
PULL #4	2.60	2.50		2.62	
PULL #5	2.68	2.55		2.66	
TOTAL	12.88	12.38		13.35	
AVERAGE	2.57	2.47		2.67	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.18		
PULL #2	3.03	3.09		
PULL #3	2.98	3.06		
PULL #4	3.09	3.05		
PULL #5	3.08	3.16		
TOTAL	15.19	15.54		
AVERAGE	3.03	3.10		

	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	4.10	4.06		4.09
PULL #2	4.13	4.16		4.09
PULL #3	4.13	3.97		4.04
PULL #4	4.18	4.11		4.07
PULL #5	4.14	4.10		4.10
TOTAL	20.68	20.40		20.39
AVERAGE	4.13	4.08		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521164.__0
FILE DATE AND TIME: 11/02/2005 19:44

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.058
The Average Y Centroid of the Five Target Set:	0.026
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.600
The Distance from POA to Centroid Target #1:	0.130
The Distance from Centroid Target #2 to Centroid Target #1:	0.324
The Distance from Centroid Target #3 to Centroid Target #1:	0.057
The Distance from Centroid Target #4 to Centroid Target #1:	0.098
The Distance from Centroid Target #5 to Centroid Target #1:	0.153

SERIAL NUMBER: G6521164. 0

TARGET NUMBER: 1

FILE DATE: 11/02/2005

FILE TIME: 19:44

X CENTROID: 0.124

Y CENTROID: -0.038

POA TO CENTROID: 0.130

HORZ SPREAD: 1.366

VERT SPREAD: 2.094

GROUP SPREAD: 2.156

MIN RADIUS: 0.223

MAX RADIUS: 1.269

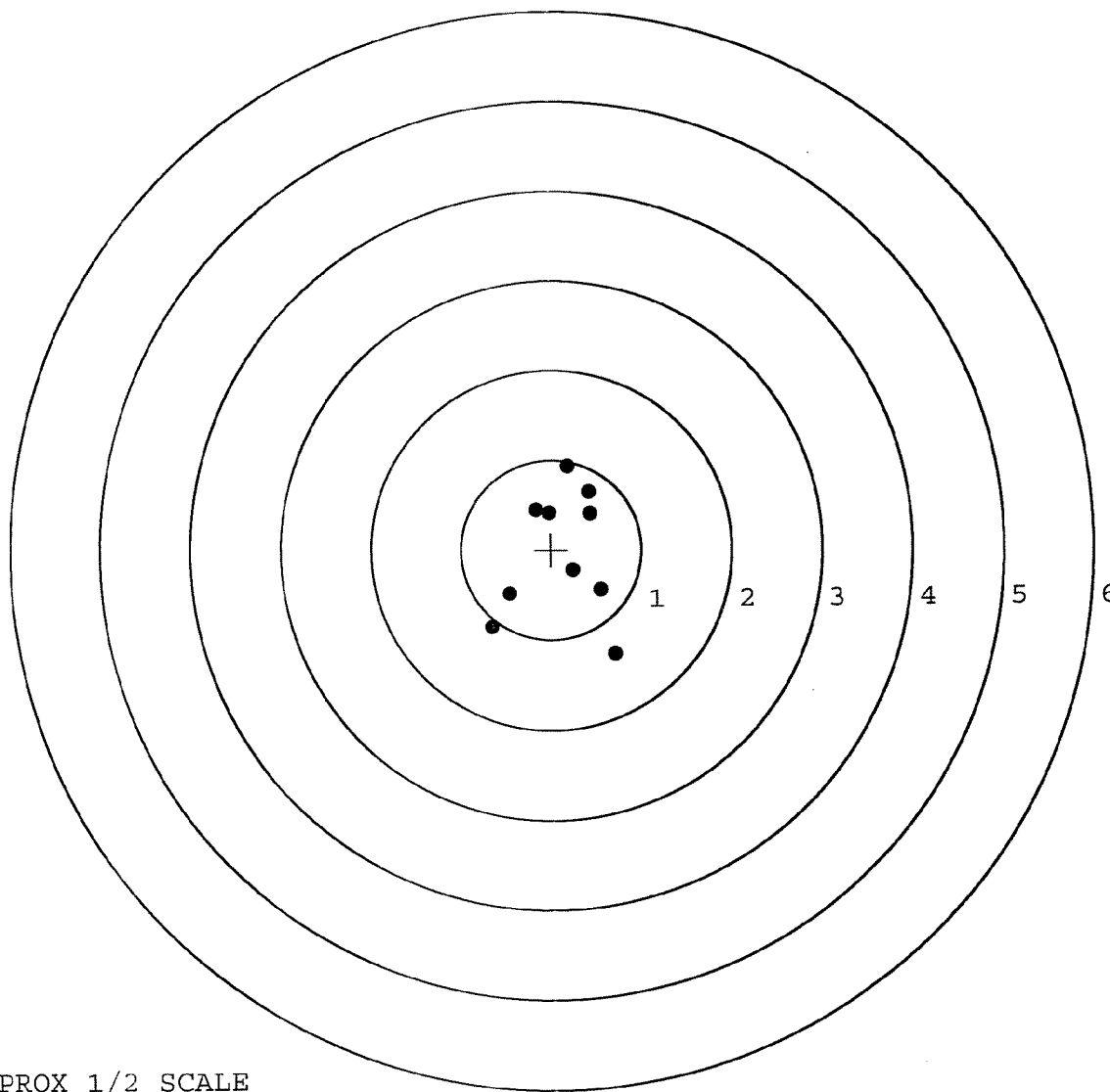
MEAN RADIUS: 0.726

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.241	-0.228
2:	0.553	-0.451
3:	0.440	0.405
4:	0.422	0.641
5:	0.192	0.928
6:	-0.022	0.407
7:	-0.168	0.442
8:	-0.464	-0.492
9:	-0.661	-0.866
10:	0.705	-1.166



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521164. 0

TARGET NUMBER: 2

FILE DATE: 11/02/2005

FILE TIME: 19:44

POINT#	X	Y
1:	0.025	0.241
2:	-0.228	0.329
3:	0.173	0.739
4:	-0.229	1.159
5:	-0.578	0.114
6:	-0.721	-0.666
7:	0.412	-0.365
8:	0.392	0.004
9:	0.242	0.397
10:	0.112	0.463

X CENTROID: -0.040

Y CENTROID: 0.241

POA TO CENTROID: 0.245

HORZ SPREAD: 1.133

VERT SPREAD: 1.825

GROUP SPREAD: 1.890

MIN RADIUS: 0.065

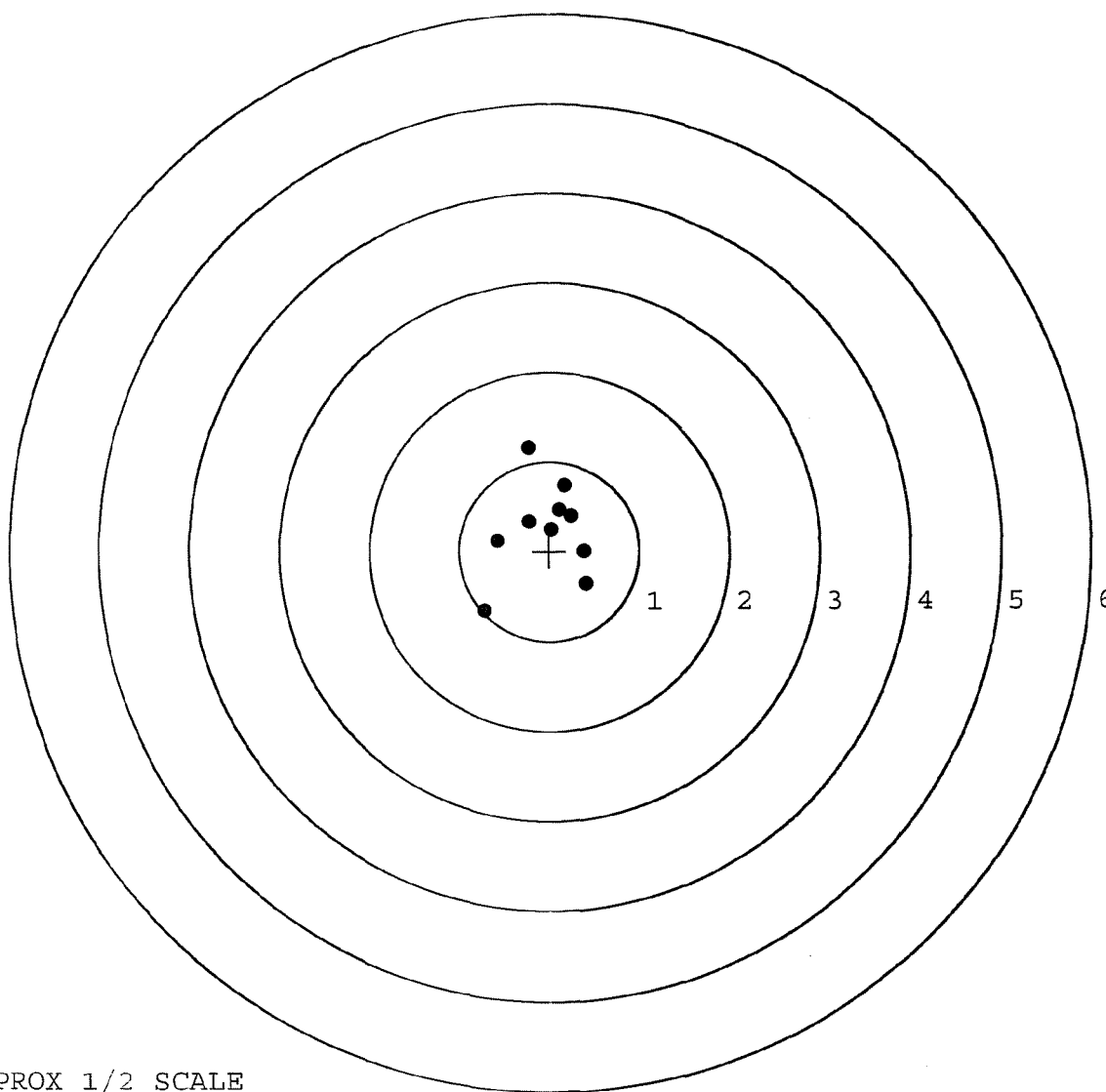
MAX RADIUS: 1.135

MEAN RADIUS: 0.528

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521164. __0

TARGET NUMBER: 3

FILE DATE: 11/02/2005

FILE TIME: 19:44

POINT#	X	Y
1:	0.267	-0.159
2:	0.629	-0.147
3:	0.969	-0.014
4:	0.822	0.483
5:	0.266	0.654
6:	0.252	0.751
7:	-0.686	0.035
8:	-0.932	-0.170
9:	0.214	-1.064
10:	-0.132	-0.373

X CENTROID: 0.167

Y CENTROID: 0.000

POA TO CENTROID: 0.167

HORZ SPREAD: 1.901

VERT SPREAD: 1.815

GROUP SPREAD: 1.907

MIN RADIUS: 0.188

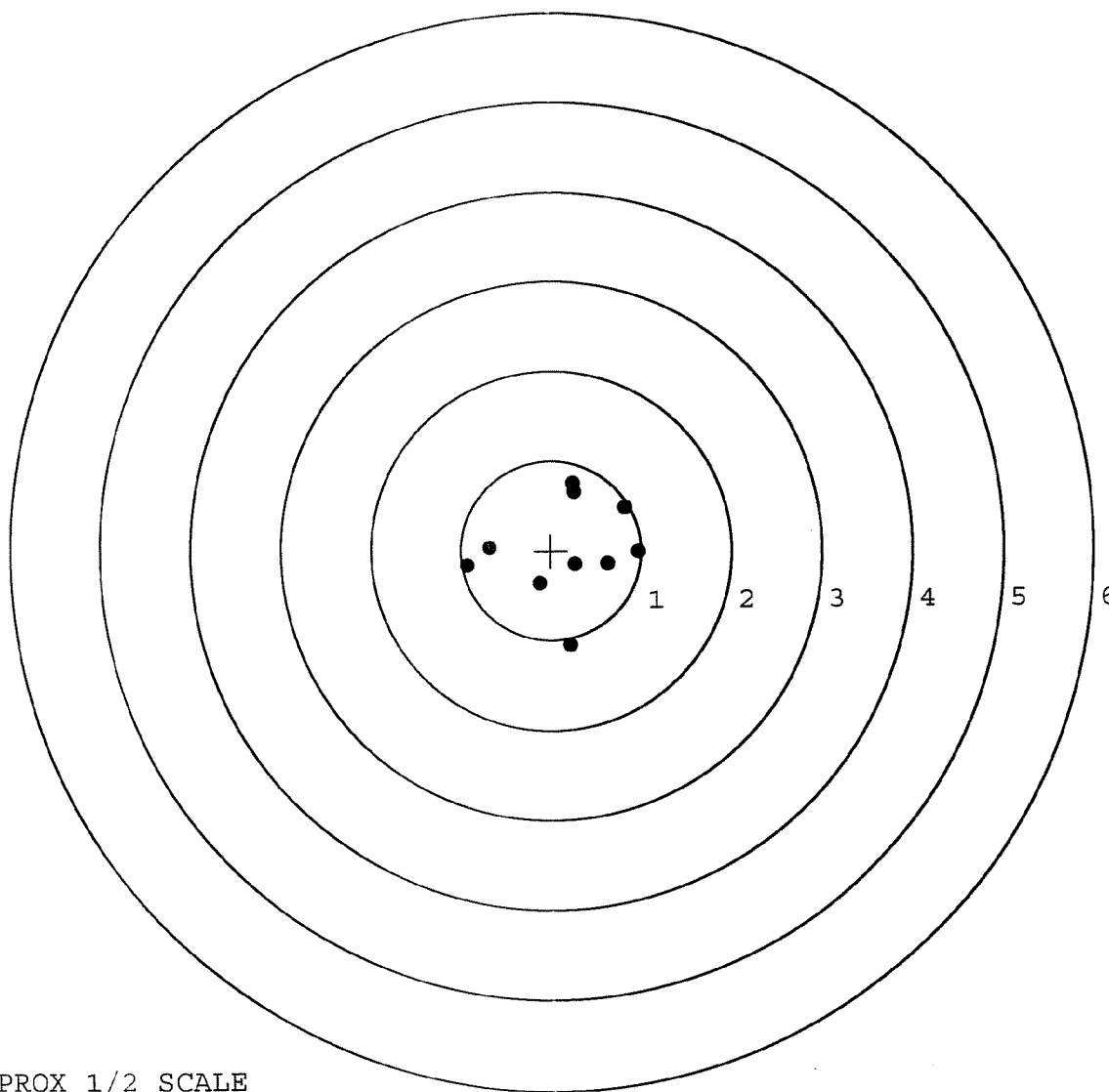
MAX RADIUS: 1.112

MEAN RADIUS: 0.721

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

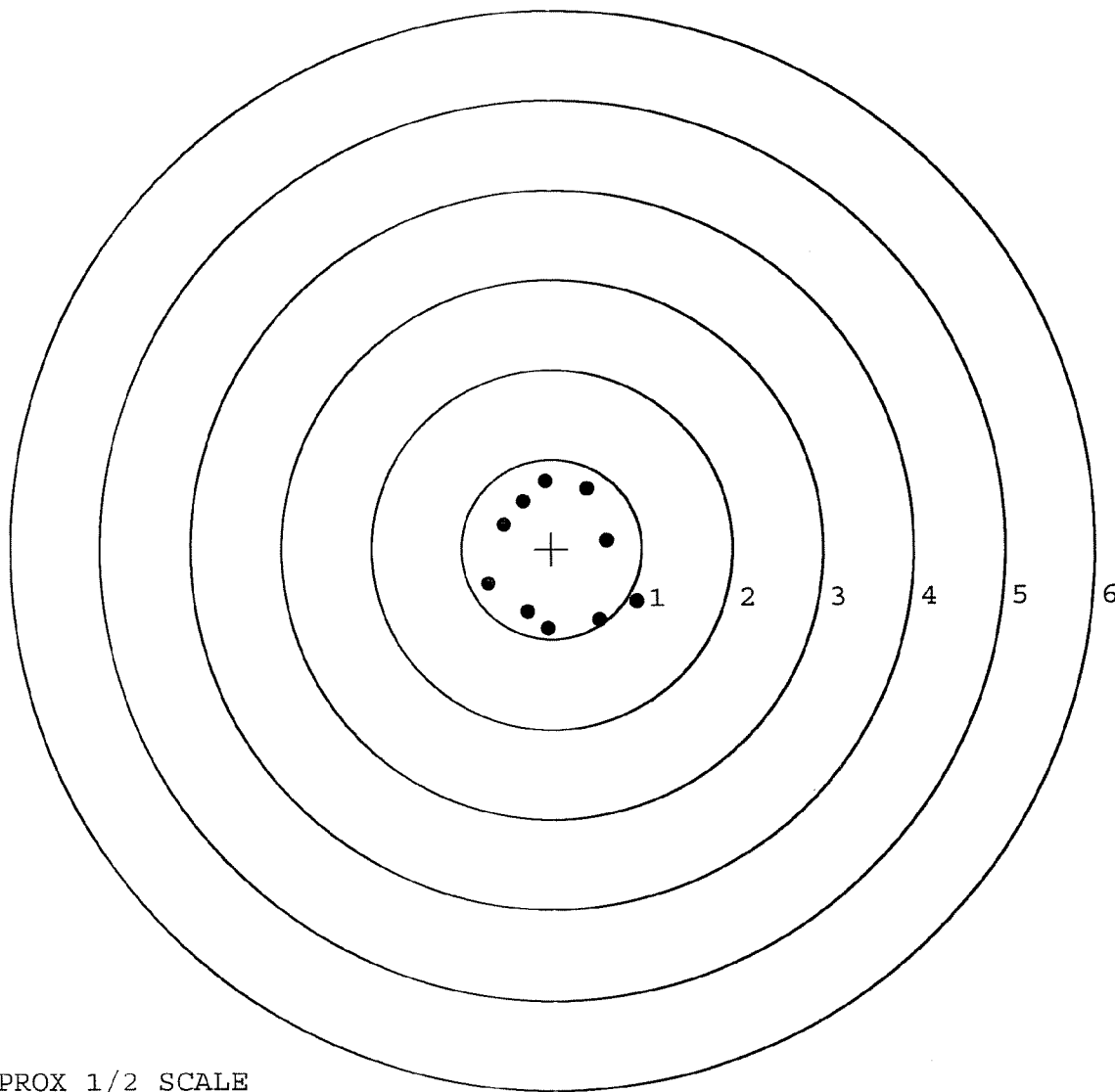


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521164. __0
 TARGET NUMBER: 4
 FILE DATE: 11/02/2005
 FILE TIME: 19:44

POINT#	X	Y
1:	0.609	0.089
2:	0.394	0.671
3:	-0.073	0.754
4:	-0.314	0.533
5:	-0.528	0.270
6:	-0.702	-0.391
7:	-0.273	-0.701
8:	-0.053	-0.893
9:	0.528	-0.800
10:	0.946	-0.600

X CENTROID: 0.053
 Y CENTROID: -0.107
 POA TO CENTROID: 0.119
 HORZ SPREAD: 1.648
 VERT SPREAD: 1.647
 GROUP SPREAD: 1.712
 MIN RADIUS: 0.589
 MAX RADIUS: 1.020
 MEAN RADIUS: 0.788
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521164. __0

TARGET NUMBER: 5

FILE DATE: 11/02/2005

FILE TIME: 19:44

POINT#	X	Y
1:	-0.195	-0.077
2:	-0.189	0.028
3:	-0.330	0.179
4:	0.184	0.203
5:	0.326	-0.031
6:	0.074	0.078
7:	-0.226	0.011
8:	-0.170	-0.149
9:	0.171	-0.052
10:	0.234	0.138

X CENTROID: -0.012

Y CENTROID: 0.033

POA TO CENTROID: 0.035

HORZ SPREAD: 0.656

VERT SPREAD: 0.352

GROUP SPREAD: 0.689

MIN RADIUS: 0.097

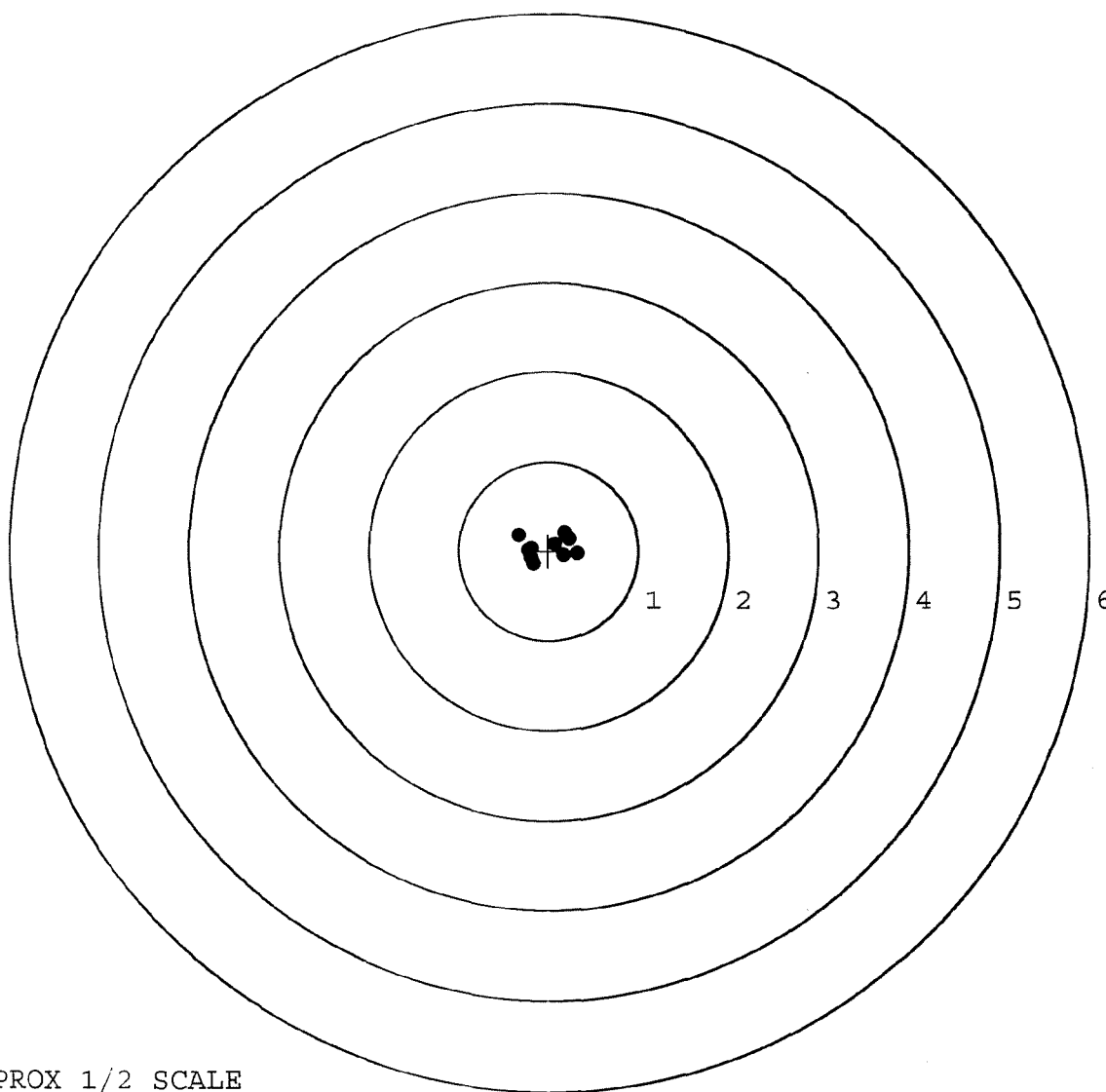
MAX RADIUS: 0.350

MEAN RADIUS: 0.237

IN 1 IN DIAMETER: 10

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE