

G 6521176

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



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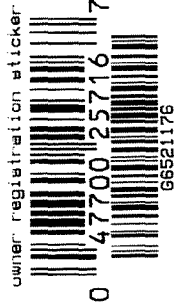
SERIAL NO.



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

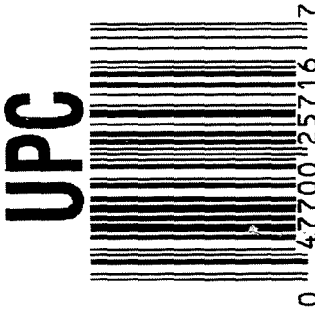
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6521176



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521176

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-3-05	RTZ
440	PROOF		10-3-05	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX	10-3-05	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	10-4-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>UMS</u>	10/7/05	UMS
500	ROLLMARK CALIBER		10-7-05	CW
510	DRILL AND TAP SIGHT HOLES		10-6-05	TRW
520	GOFF BLAST BBL / REC		10/10/05	JD
530 & 540	APPLY COATINGS (BARREL ACTION)		10/14/05	RB
	(BOLT)		10/14/05	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-18-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-18-05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-18-05	RA
	D) OIL FIRING PIN ASSEMBLY		10-21-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	11/9/05	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	11/9/05	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11/9/05	RA
	J) ASSEMBLE STOCK		10-21-05	RTL
	K) ASSEMBLE SWIVEL STUDS		11-28-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-28-05	BG
	M) IRON SIGHT ALIGNMENT		11-28-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-28-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-22-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-22-05	SH
670	FINAL INSPECTION A) HEADSPACE		11-28-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.66</u> <u>2.60</u> <u>2.44</u> <u>2.53</u>	11/9/05	RA
	C) FUNCTION		11-28-05	BG
690	PACK		12/10/05	RA

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 10-21-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.75		2.46	
PULL #2	2.54	2.67		2.58	
PULL #3	2.50	2.60		2.42	
PULL #4	2.63	2.56		2.44	
PULL #5	2.59	2.63		2.47	
TOTAL	12.80	13.21		12.37	
AVERAGE	2.56	2.64		2.47	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.97		
PULL #2	3.07	2.80		
PULL #3	3.07	2.97		
PULL #4	3.11	2.73		
PULL #5	3.04	3.10		
TOTAL	15.29	14.57		
AVERAGE	3.05	2.91		

	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	4.11	3.99		4.00
PULL #2	4.01	3.92		3.97
PULL #3	3.99	3.80		3.90
PULL #4	4.05	3.97		4.10
PULL #5	3.98	3.97		4.05
TOTAL	20.14	19.65		20.02
AVERAGE	4.02	3.93		4.00

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521176.___0
FILE DATE AND TIME: 10/22/2005 05:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.050
The Average Y Centroid of the Five Target Set:	-0.080
The Average Point of Impact of the Five Target Set:	0.094
The Average Mean Radius of the Five Target Set:	0.930
The Distance from POA to Centroid Target #1:	0.090
The Distance from Centroid Target #2 to Centroid Target #1:	0.118
The Distance from Centroid Target #3 to Centroid Target #1:	0.432
The Distance from Centroid Target #4 to Centroid Target #1:	0.398
The Distance from Centroid Target #5 to Centroid Target #1:	0.180

SERIAL NUMBER: G6521176. 0

TARGET NUMBER: 1

FILE DATE: 10/22/2005

FILE TIME: 05:01

X CENTROID: 0.041

Y CENTROID: -0.081

POA TO CENTROID: 0.090

HORZ SPREAD: 1.796

VERT SPREAD: 2.516

GROUP SPREAD: 2.695

MIN RADIUS: 0.218

MAX RADIUS: 1.571

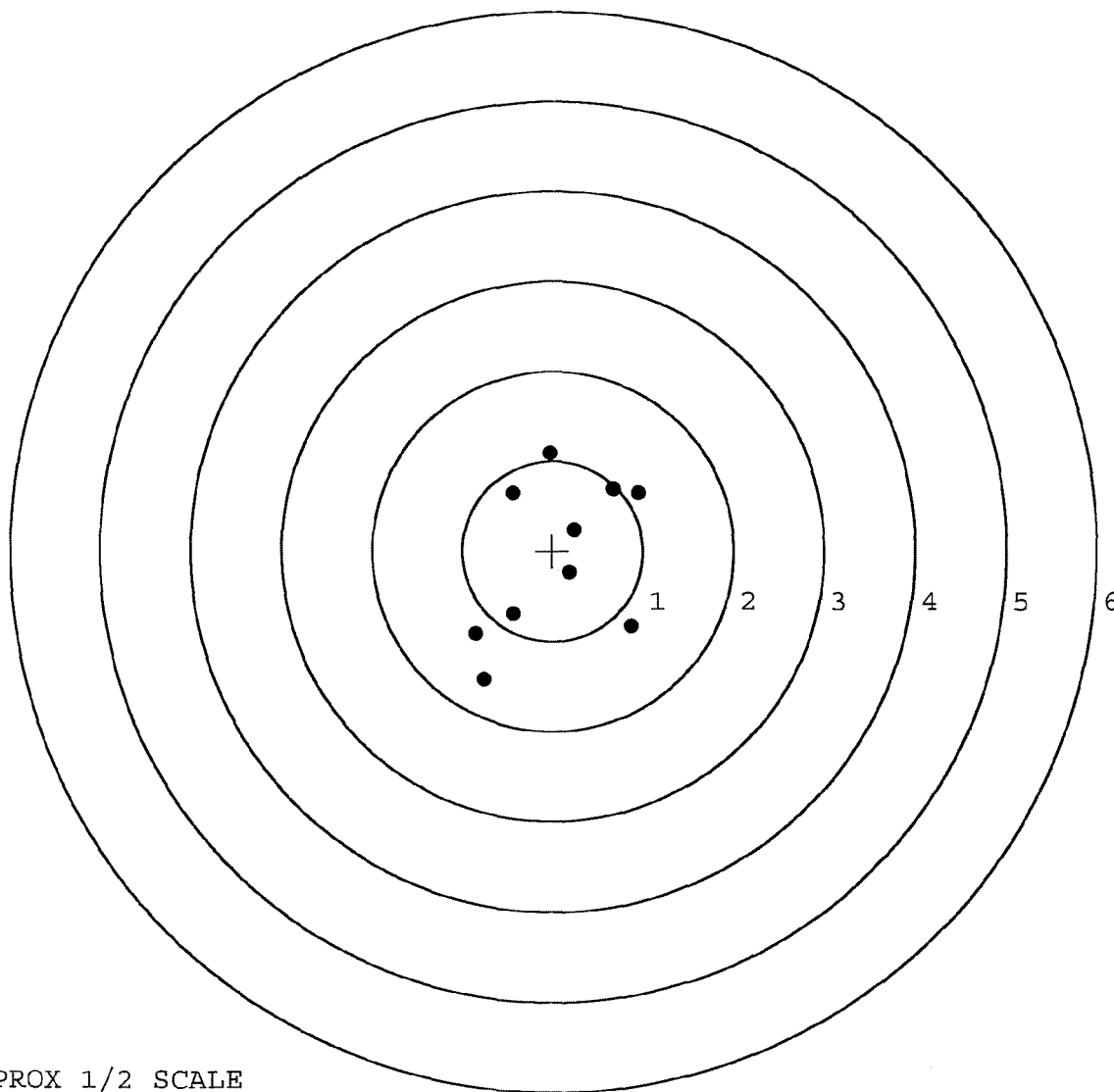
MEAN RADIUS: 0.949

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.874	-0.827
2:	0.947	0.653
3:	0.676	0.693
4:	0.243	0.239
5:	0.192	-0.238
6:	-0.436	-0.698
7:	-0.760	-1.432
8:	-0.849	-0.921
9:	-0.443	0.641
10:	-0.038	1.084



TARGET APPROX 1/2 SCALE

BARBER - M24 0097614

SERIAL NUMBER: G6521176. 0

TARGET NUMBER: 2

FILE DATE: 10/22/2005

FILE TIME: 05:01

POINT#	X	Y
1:	-0.044	-1.796
2:	0.790	-0.446
3:	0.832	0.602
4:	0.468	0.594
5:	0.126	0.780
6:	-0.027	0.553
7:	-0.155	-0.121
8:	0.147	-0.186
9:	-0.225	-0.386
10:	-0.359	-0.686

X CENTROID: 0.155

Y CENTROID: -0.109

POA TO CENTROID: 0.190

HORZ SPREAD: 1.191

VERT SPREAD: 2.576

GROUP SPREAD: 2.582

MIN RADIUS: 0.077

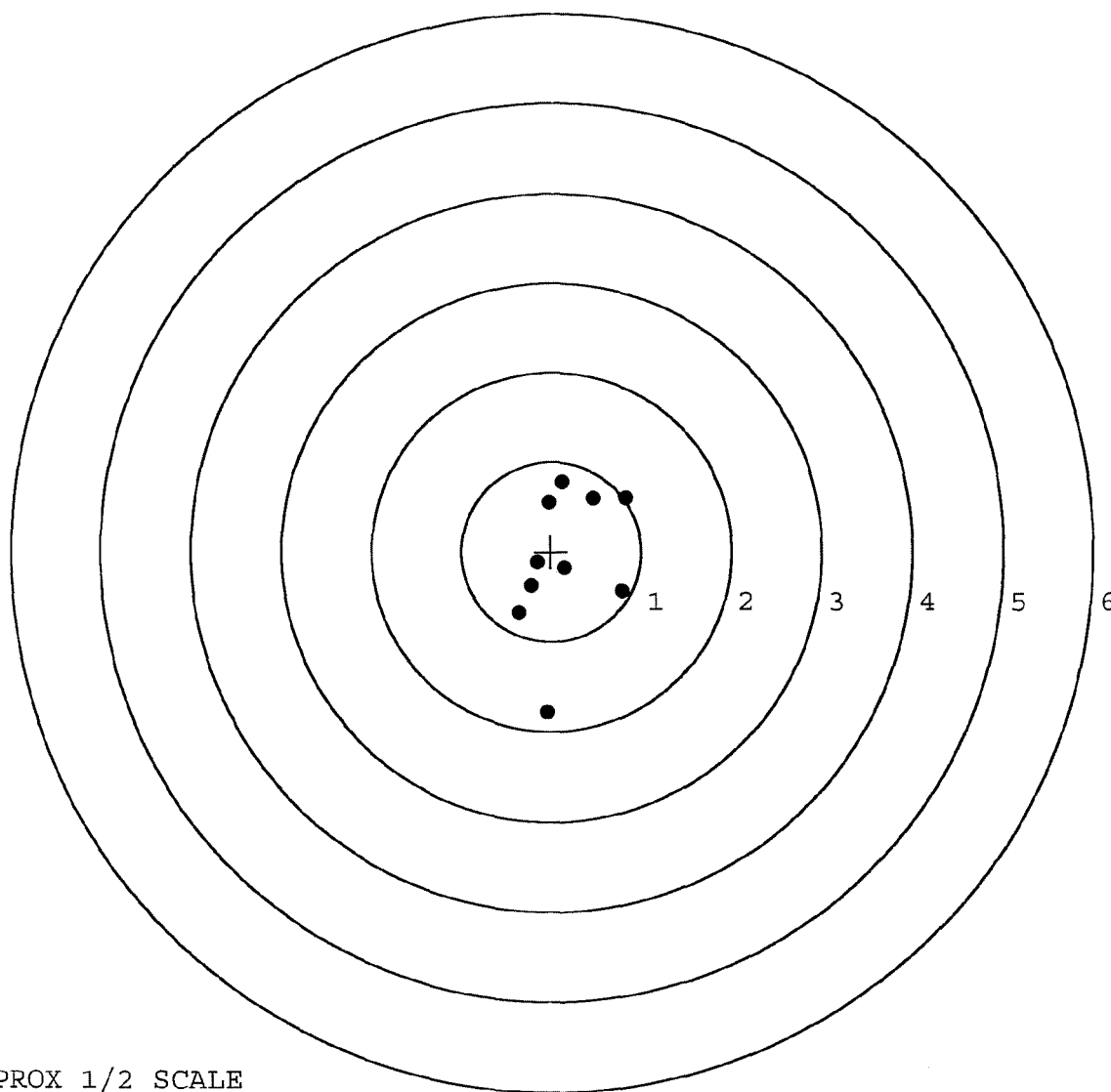
MAX RADIUS: 1.699

MEAN RADIUS: 0.738

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521176. __0

TARGET NUMBER: 3

FILE DATE: 10/22/2005

FILE TIME: 05:01

POINT#	X	Y
1:	1.021	-0.094
2:	0.385	0.474
3:	0.079	1.055
4:	-0.150	1.724
5:	-1.413	2.523
6:	0.126	0.038
7:	-0.046	-0.305
8:	-0.164	-0.678
9:	-0.233	-1.040
10:	-0.528	-0.395

X CENTROID: -0.092

Y CENTROID: 0.330

POA TO CENTROID: 0.343

HORZ SPREAD: 2.434

VERT SPREAD: 3.563

GROUP SPREAD: 3.753

MIN RADIUS: 0.365

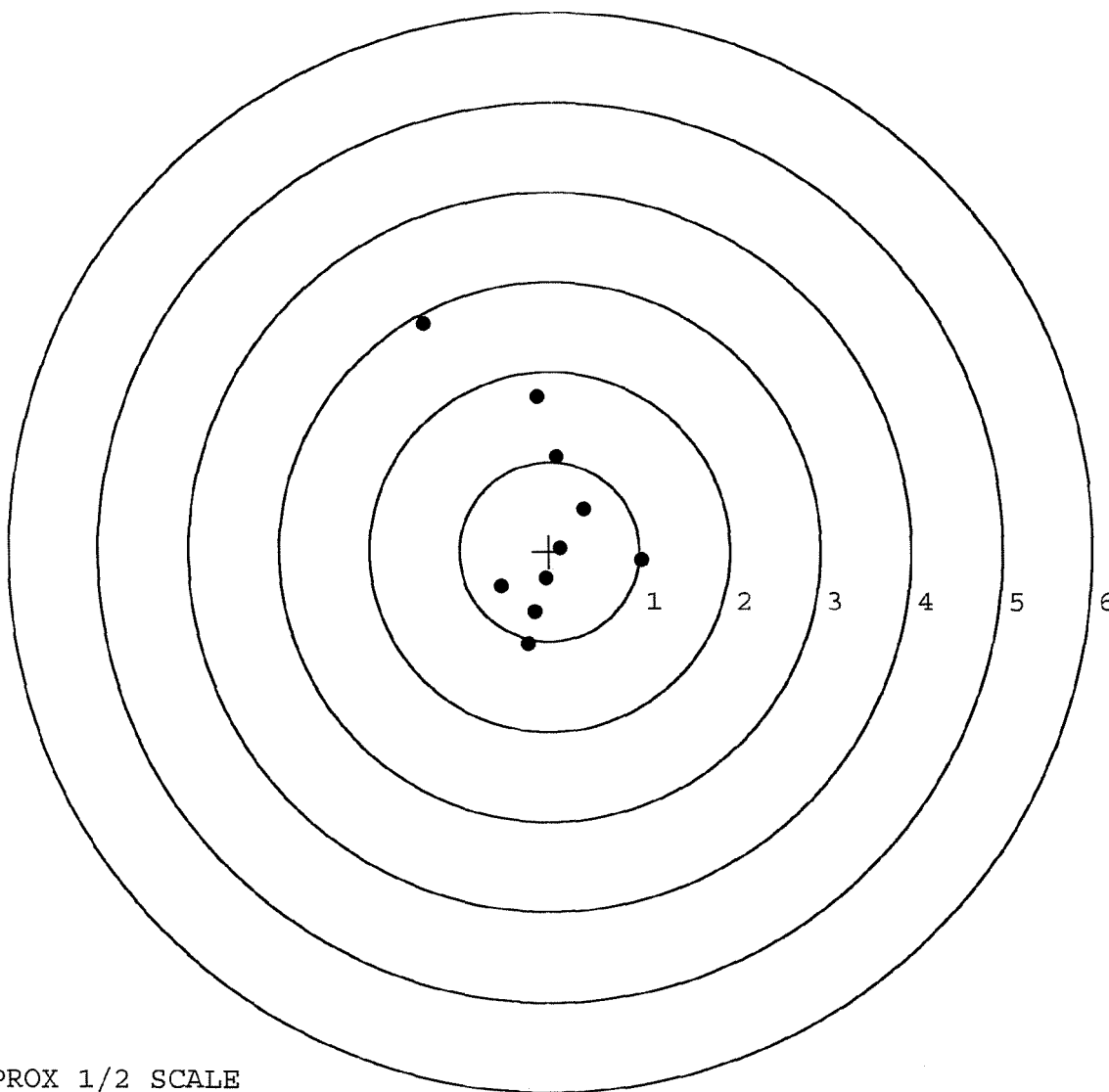
MAX RADIUS: 2.560

MEAN RADIUS: 1.063

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521176. 0

TARGET NUMBER: 4

FILE DATE: 10/22/2005

FILE TIME: 05:01

X CENTROID: -0.247

Y CENTROID: -0.357

POA TO CENTROID: 0.434

HORZ SPREAD: 2.150

VERT SPREAD: 3.550

GROUP SPREAD: 3.585

MIN RADIUS: 0.226

MAX RADIUS: 2.161

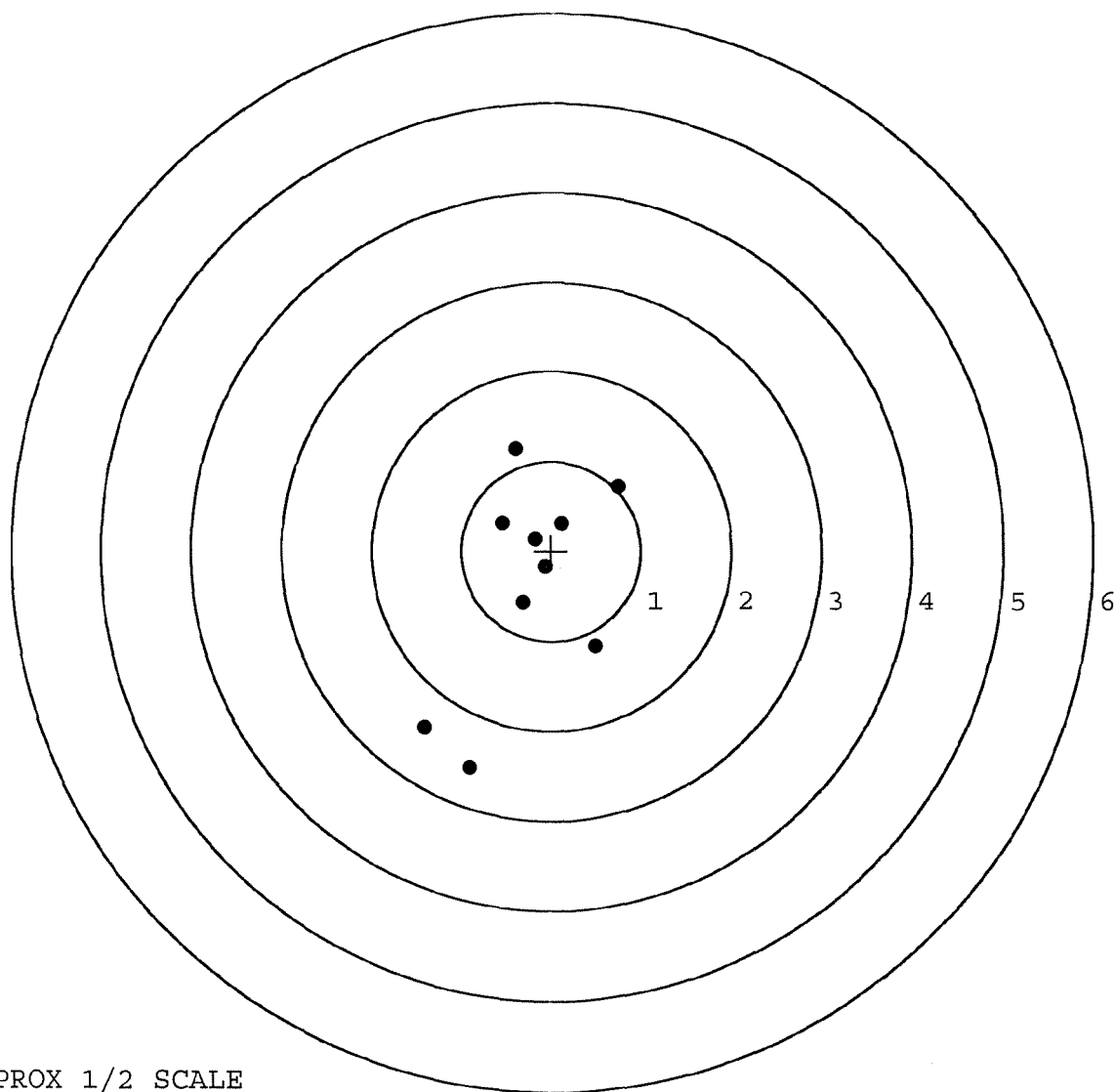
MEAN RADIUS: 1.061

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.904	-2.415
2:	-1.402	-1.967
3:	0.494	-1.059
4:	-0.309	-0.574
5:	-0.071	-0.174
6:	0.115	0.309
7:	-0.179	0.137
8:	0.748	0.722
9:	-0.553	0.320
10:	-0.406	1.135



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521176. 0

TARGET NUMBER: 5

FILE DATE: 10/22/2005

FILE TIME: 05:01

X CENTROID: -0.107

Y CENTROID: -0.183

POA TO CENTROID: 0.212

HORZ SPREAD: 1.242

VERT SPREAD: 3.216

GROUP SPREAD: 3.280

MIN RADIUS: 0.397

MAX RADIUS: 2.048

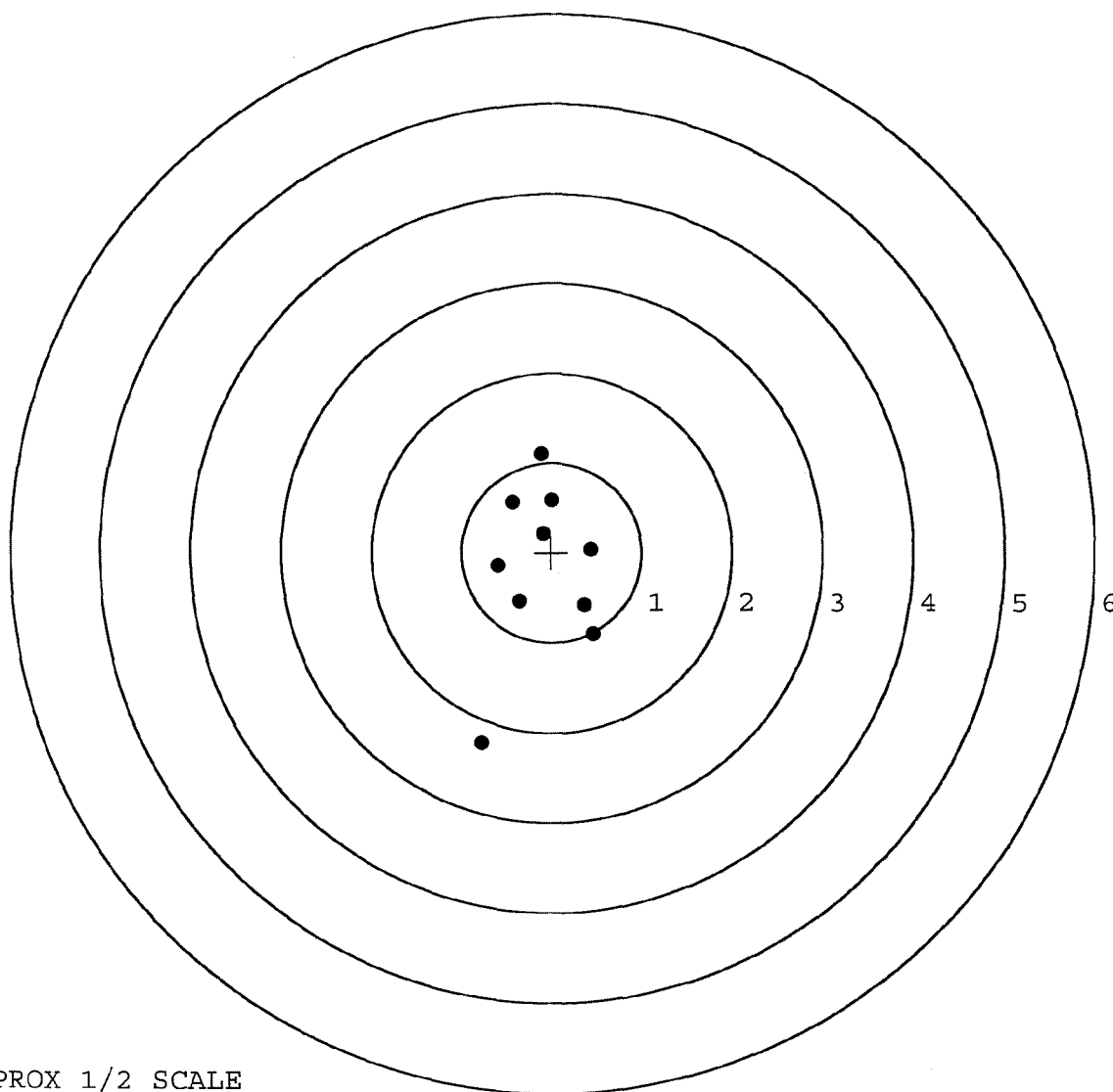
MEAN RADIUS: 0.840

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.769	-2.121
2:	0.473	-0.911
3:	0.375	-0.591
4:	0.446	0.039
5:	-0.349	-0.553
6:	-0.596	-0.149
7:	-0.089	0.213
8:	0.003	0.582
9:	-0.438	0.564
10:	-0.126	1.095



TARGET APPROX 1/2 SCALE