

G-652 / 280

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

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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

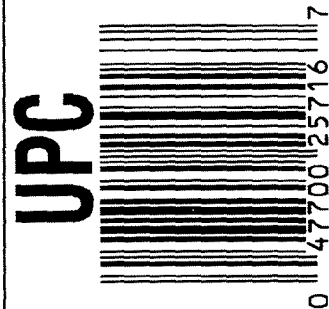


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521280



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521280

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 INSPECTED	10-3-05	RTZ
470	DIS-ASSEMBLE ACTION		10-4-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OCT 6 2005 OPERATOR <u>wms</u>	10/7/05	wms
500	ROLLMARK CALIBER		10-7-05	CW
510	DRILL AND TAP SIGHT HOLES		10-6-05	TRCJ
520	GOFF BLAST BBL / REC		10/10/05	JJ
530 & 540	APPLY COATINGS (BARREL ACTION)		10/14/05	PB
	(BOLT)		10/14/05	PB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-17-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-05	RA
	D) OIL FIRING PIN ASSEMBLY		10-21-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-15-05	BG
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.0</u> <u>6.5</u> <u>7.0</u>	11/15/05	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>2.5</u>	11/15/05	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1023</u> <u>1024</u>	11/15/05	RA
	J) ASSEMBLE STOCK		10-21-05	RL
	K) ASSEMBLE SWIVEL STUDS		12-15-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-15-05	BG
	M) IRON SIGHT ALIGNMENT		12-15-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-15-05	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	R.P.
670	FINAL INSPECTION A) HEADSPACE		12-15-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.86</u> <u>2.91</u> <u>2.64</u> <u>2.91</u> <u>2.77</u>	11-8-05	BG
	C) FUNCTION		12-15-05	BG
690	PACK		1-9-06	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	2.59	2.71		2.57	
PULL #2	2.65	2.51		2.61	
PULL #3	2.55	2.58		2.56	
PULL #4	2.54	2.57		2.60	
PULL #5	2.60	2.62		2.60	
TOTAL	12.93	12.99		12.94	
AVERAGE	2.58	2.59		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.76		
PULL #2	2.86	2.83		
PULL #3	2.94	2.96		
PULL #4	2.93	2.91		
PULL #5	3.21	2.76		
TOTAL	14.94	14.22		
AVERAGE	2.98	2.84		

	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	4.14	4.13		4.06
PULL #2	4.09	4.03		4.10
PULL #3	4.14	4.15		4.12
PULL #4	4.03	4.17		4.04
PULL #5	4.19	4.14		4.15
TOTAL	20.59	20.62		20.47
AVERAGE	4.11	4.12		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521280.___0
FILE DATE AND TIME: 10/22/2005 04:52

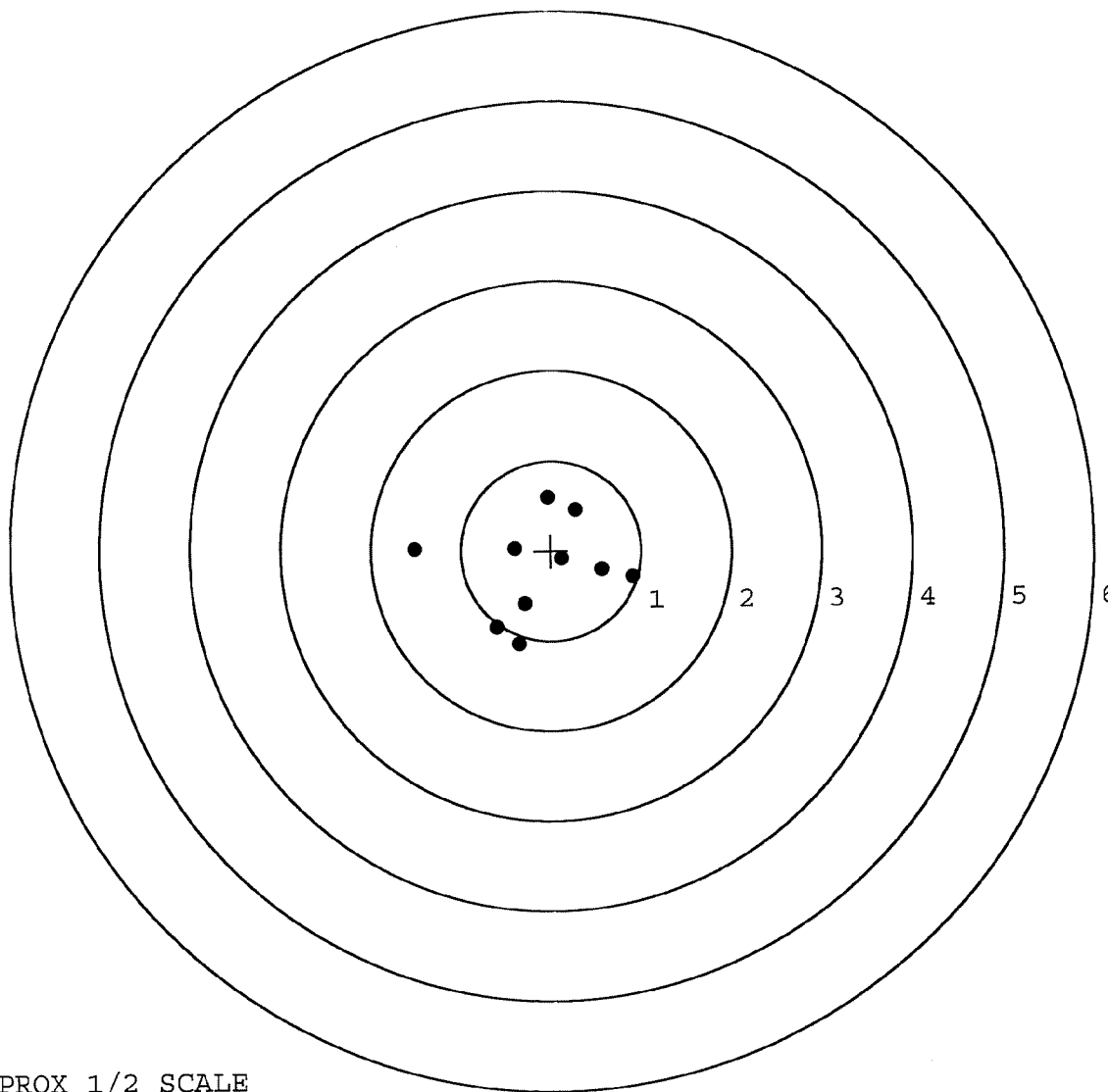
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.058
The Average Y Centroid of the Five Target Set:	0.009
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.790
The Distance from POA to Centroid Target #1:	0.238
The Distance from Centroid Target #2 to Centroid Target #1:	0.222
The Distance from Centroid Target #3 to Centroid Target #1:	0.576
The Distance from Centroid Target #4 to Centroid Target #1:	0.400
The Distance from Centroid Target #5 to Centroid Target #1:	0.250

SERIAL NUMBER: G6521280. __0
 TARGET NUMBER: 1
 FILE DATE: 10/22/2005
 FILE TIME: 04:52

POINT#	X	Y
1:	-0.365	-1.038
2:	-0.612	-0.851
3:	-0.294	-0.593
4:	0.903	-0.295
5:	0.565	-0.207
6:	0.116	-0.087
7:	-0.404	0.031
8:	0.274	0.456
9:	-0.034	0.599
10:	-1.517	0.032

X CENTROID: -0.137
 Y CENTROID: -0.195
 POA TO CENTROID: 0.238
 HORZ SPREAD: 2.420
 VERT SPREAD: 1.637
 GROUP SPREAD: 2.442
 MIN RADIUS: 0.275
 MAX RADIUS: 1.399
 MEAN RADIUS: 0.745
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521280. __0

TARGET NUMBER: 2

FILE DATE: 10/22/2005

FILE TIME: 04:52

X CENTROID: 0.071

Y CENTROID: -0.118

POA TO CENTROID: 0.138

HORZ SPREAD: 2.407

VERT SPREAD: 1.805

GROUP SPREAD: 3.009

MIN RADIUS: 0.116

MAX RADIUS: 1.529

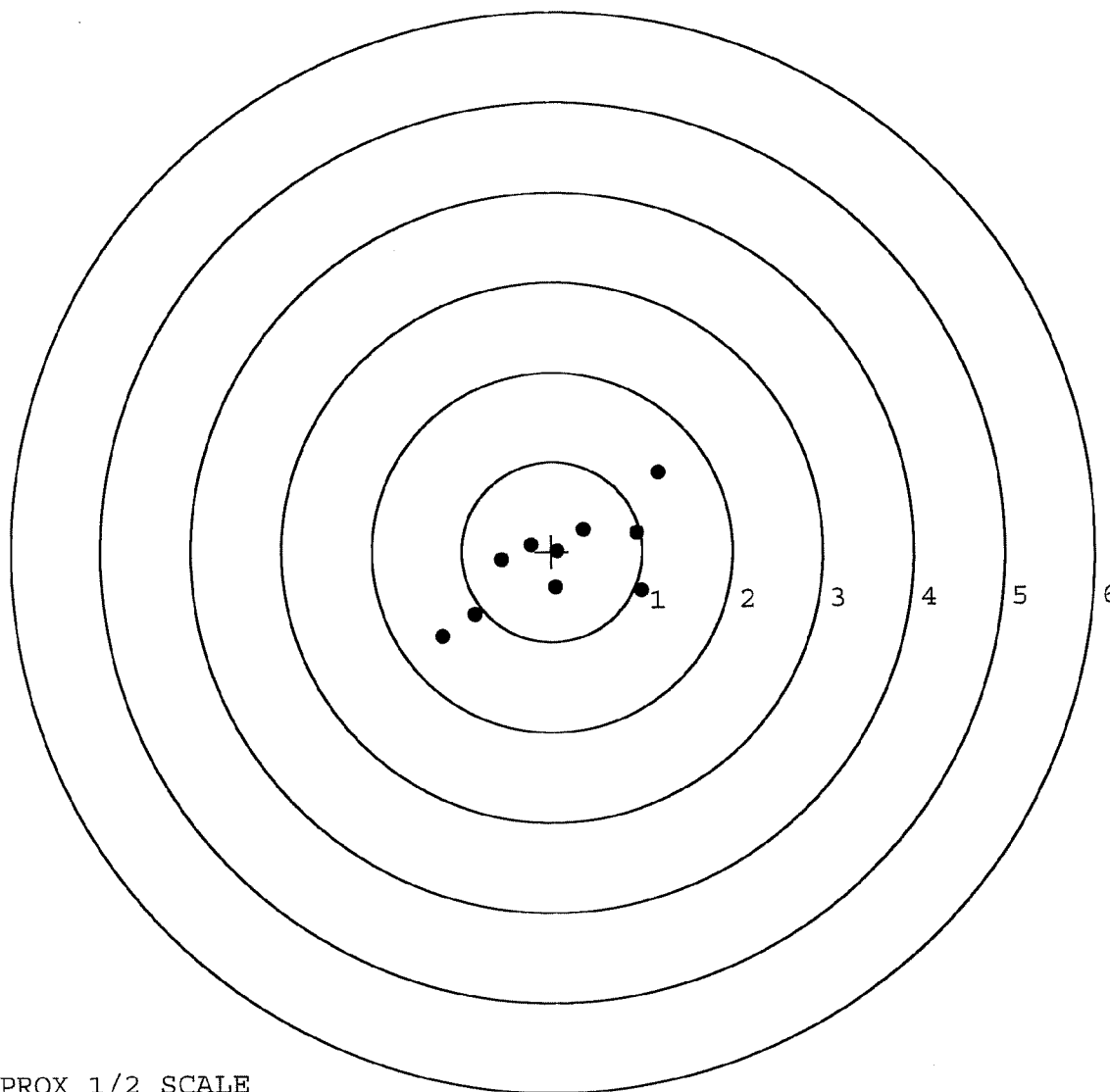
MEAN RADIUS: 0.787

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.989	-0.447
2:	0.946	0.201
3:	1.185	0.871
4:	0.357	0.245
5:	0.043	-0.402
6:	0.061	-0.002
7:	-0.233	0.077
8:	-0.557	-0.089
9:	-0.858	-0.697
10:	-1.222	-0.934



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521280. __0

TARGET NUMBER: 3

FILE DATE: 10/22/2005

FILE TIME: 04:52

POINT#	X	Y
1:	0.149	-1.145
2:	-0.375	-0.920
3:	0.352	-0.384
4:	0.682	-0.005
5:	-0.071	0.309
6:	-0.244	0.668
7:	0.248	0.739
8:	-0.693	-0.033
9:	0.306	1.492
10:	2.231	1.521

X CENTROID: 0.259

Y CENTROID: 0.224

POA TO CENTROID: 0.342

HORZ SPREAD: 2.924

VERT SPREAD: 2.666

GROUP SPREAD: 3.571

MIN RADIUS: 0.340

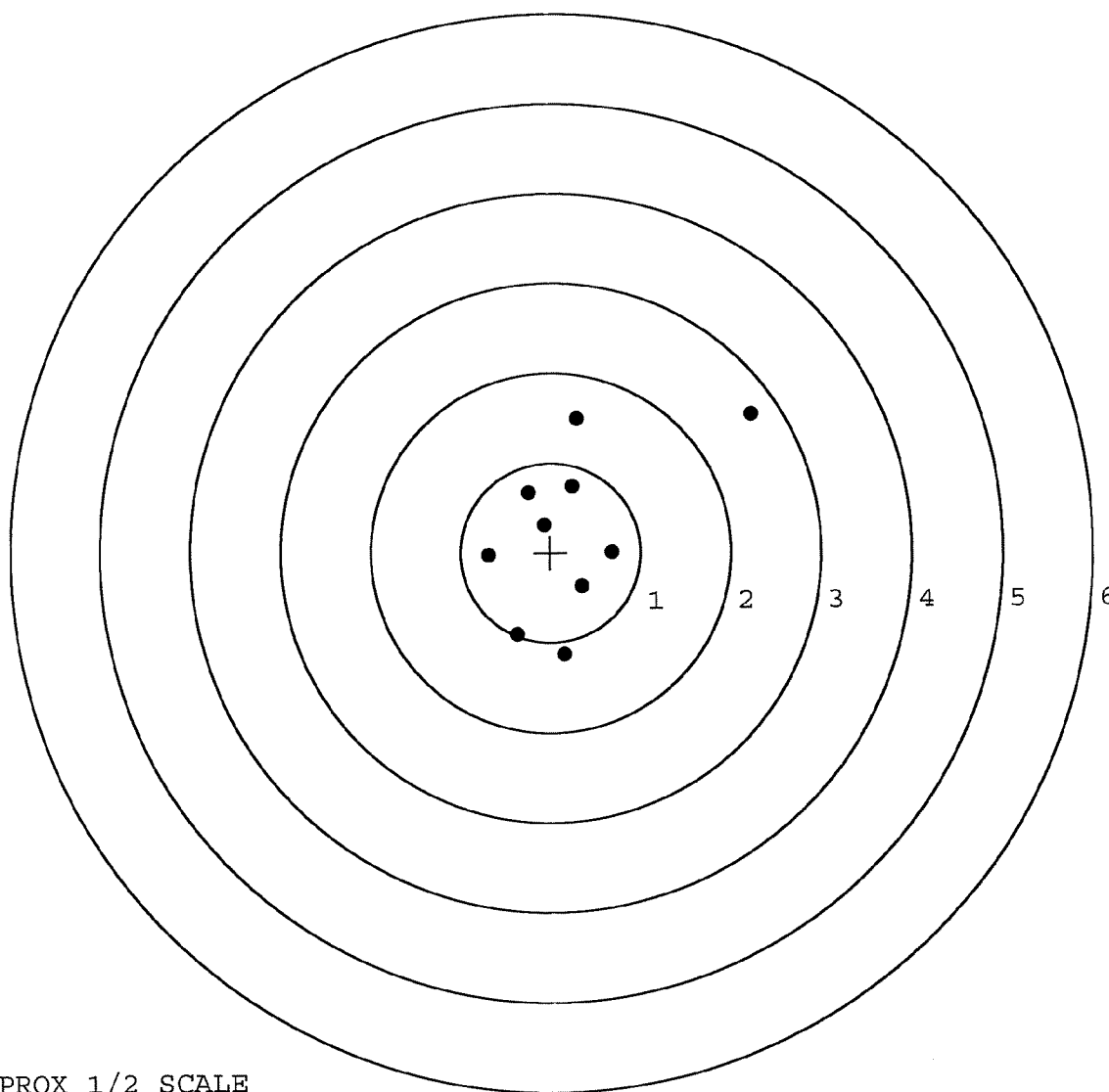
MAX RADIUS: 2.361

MEAN RADIUS: 0.992

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521280. __0

TARGET NUMBER: 4

FILE DATE: 10/22/2005

FILE TIME: 04:52

POINT#	X	Y
1:	0.590	-0.831
2:	0.019	-0.550
3:	-0.616	-0.859
4:	-0.515	-0.013
5:	0.645	0.504
6:	0.717	0.240
7:	0.192	0.186
8:	0.067	0.451
9:	-0.400	0.658
10:	0.599	1.248

X CENTROID: 0.130

Y CENTROID: 0.103

POA TO CENTROID: 0.166

HORZ SPREAD: 1.333

VERT SPREAD: 2.107

GROUP SPREAD: 2.432

MIN RADIUS: 0.103

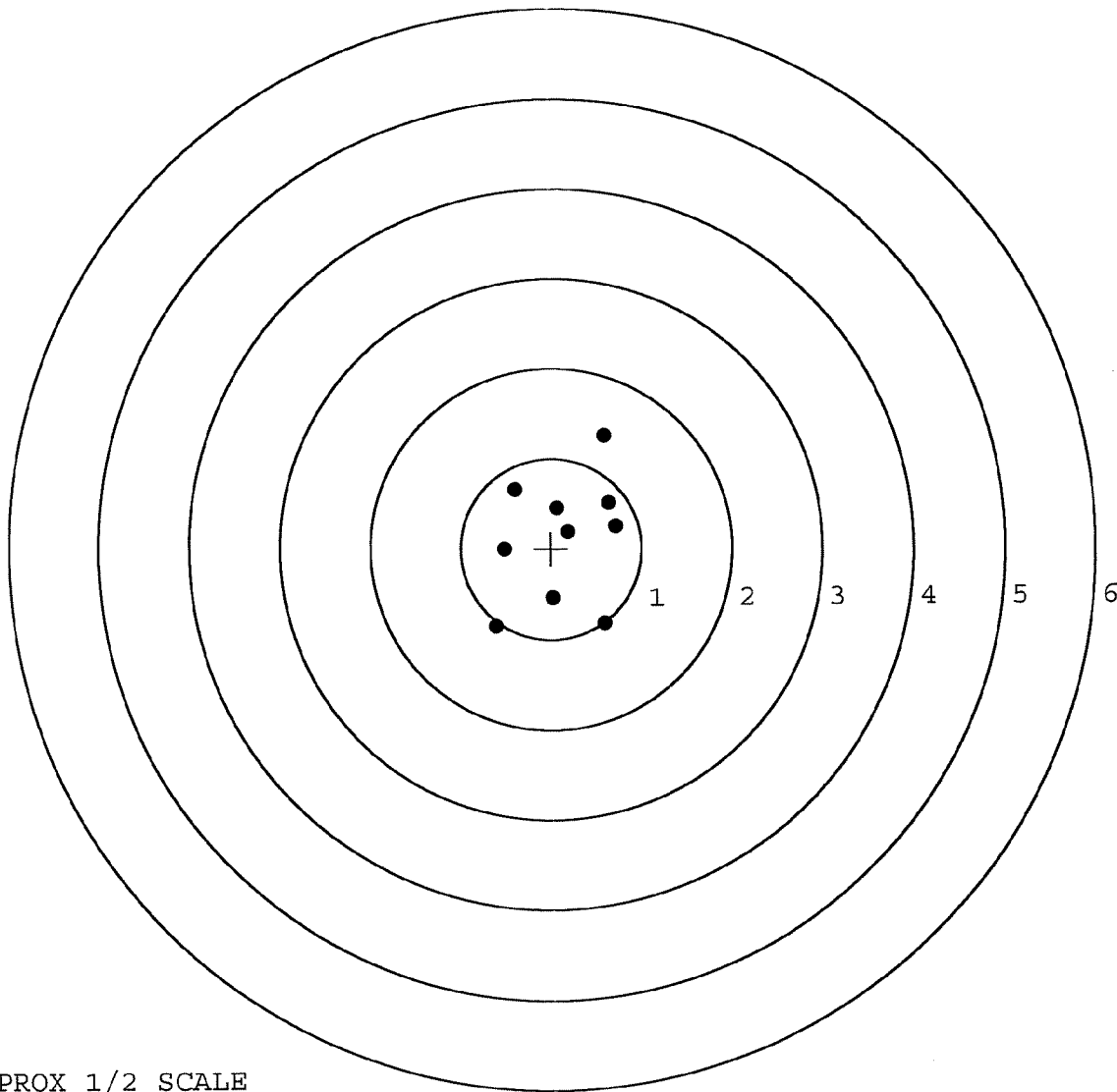
MAX RADIUS: 1.237

MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0098867

SERIAL NUMBER: G6521280. 0

TARGET NUMBER: 5

FILE DATE: 10/22/2005

FILE TIME: 04:52

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X  CENTROID:      -0.034
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Y CENTROID: 0.032

POA TO CENTROID: 0.047

HORZ SPREAD: 1.682

VERT SPREAD: 1.791

GROUP SPREAD: 1.921

MIN RADIUS: 0.177

MAX RADIUS: 1.134

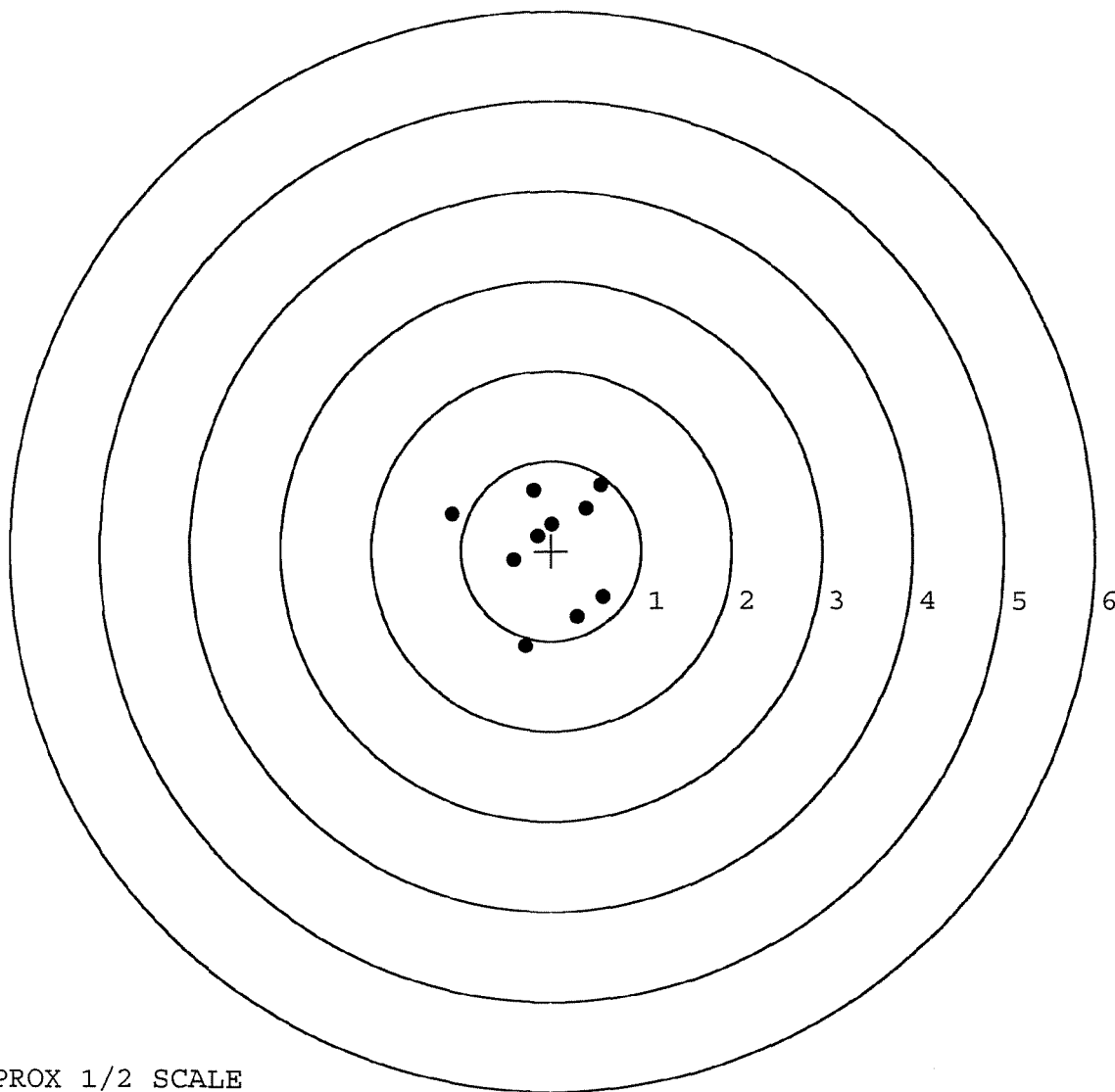
MEAN RADIUS: 0.695

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

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# in 3 IN DIAMETER:      10
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POINT#	X	Y
1:	0.578	-0.518
2:	0.296	-0.738
3:	-0.286	-1.061
4:	-1.104	0.409
5:	0.550	0.730
6:	0.385	0.472
7:	-0.195	0.674
8:	0.004	0.297
9:	-0.150	0.166
10:	-0.418	-0.109



TARGET APPROX 1/2 SCALE