

G-652 1451

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

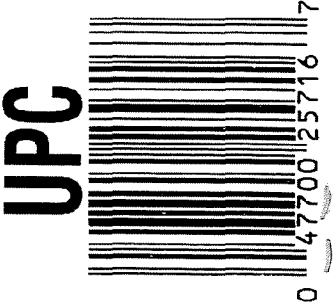
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6521451



ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521451

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-11-06	RTZ
440	PROOF		1-11-06	A
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-11-06	AC
470	DIS-ASSEMBLE ACTION	JAN 11 2006	1-12-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/80 OPERATOR <u>unwed</u>	1/13/06	<u>unwed</u>
500	ROLLMARK CALIBER		1-13-06	CW
510	DRILL AND TAP SIGHT HOLES		1-12-06	TRW
520	GOFF BLAST BBL / REC		1-16-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		1/15/06	TB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		1-17-06	Ac
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-19-06	Ac
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-19-06	Ac
	D) OIL FIRING PIN ASSEMBLY		1-19-06	Ac
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		2-22-06	mm

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>52</u> <u>55</u> <u>52</u>	1-28-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>22</u> <u>20</u> <u>20</u>	1-28-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		2-22-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	2-22-06	MTM
	J) ASSEMBLE STOCK		1-20-06	BG
	K) ASSEMBLE SWIVEL STUDS		2-22-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-20-06	BG
	M) IRON SIGHT ALIGNMENT		1-20-06	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-20-06	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1/20/06	MTM
	MALFUNCTION <i>rings around shells</i>	CORRECTION <i>OK</i>	1-24-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-20-06	MTM
670	FINAL INSPECTION A) HEADSPACE		2-22-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>283</u> <u>280</u> <u>274</u> <u>274</u> <u>289</u>	1-28-06	DA
	C) FUNCTION		2-22-06	MTM
690	PACK		3-30-06	DA

BARBER - M24 0100931
**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 1-19-06

 TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.46		2.50	
PULL #2	2.52	2.54		2.51	
PULL #3	2.55	2.66		2.48	
PULL #4	2.51	2.58		2.38	
PULL #5	2.60	2.66		2.47	
TOTAL	12.64	12.90		12.34	
AVERAGE	2.52	2.58		2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	2.96		
PULL #2	3.32	2.90		
PULL #3	3.07	3.11		
PULL #4	2.86	3.03		
PULL #5	2.96	3.02		
TOTAL	15.46	15.02		
AVERAGE	3.09	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	4.17	3.71		4.00
PULL #2	4.15	3.93		4.07
PULL #3	4.21	3.85		4.15
PULL #4	4.13	3.95		3.97
PULL #5	3.95	3.84		4.09
TOTAL	20.61	19.28		20.28
AVERAGE	4.12	3.85		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521451.___0
FILE DATE AND TIME: 01/20/2006 22:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.103
The Average Y Centroid of the Five Target Set:	0.042
The Average Point of Impact of the Five Target Set:	0.111
The Average Mean Radius of the Five Target Set:	0.746
The Distance from POA to Centroid Target #1:	0.168
The Distance from Centroid Target #2 to Centroid Target #1:	0.256
The Distance from Centroid Target #3 to Centroid Target #1:	0.247
The Distance from Centroid Target #4 to Centroid Target #1:	0.450
The Distance from Centroid Target #5 to Centroid Target #1:	0.072

SERIAL NUMBER: G6521451. __0

TARGET NUMBER: 1

FILE DATE: 01/20/2006

FILE TIME: 22:31

POINT#	X	Y
1:	0.075	1.334
2:	-0.443	0.817
3:	0.121	0.856
4:	-1.079	-0.352
5:	-0.023	-0.288
6:	0.132	0.374
7:	0.193	0.155
8:	0.367	0.003
9:	0.449	-0.338
10:	0.645	-0.938

X CENTROID: 0.044

Y CENTROID: 0.162

POA TO CENTROID: 0.168

HORZ SPREAD: 1.724

VERT SPREAD: 2.272

GROUP SPREAD: 2.342

MIN RADIUS: 0.149

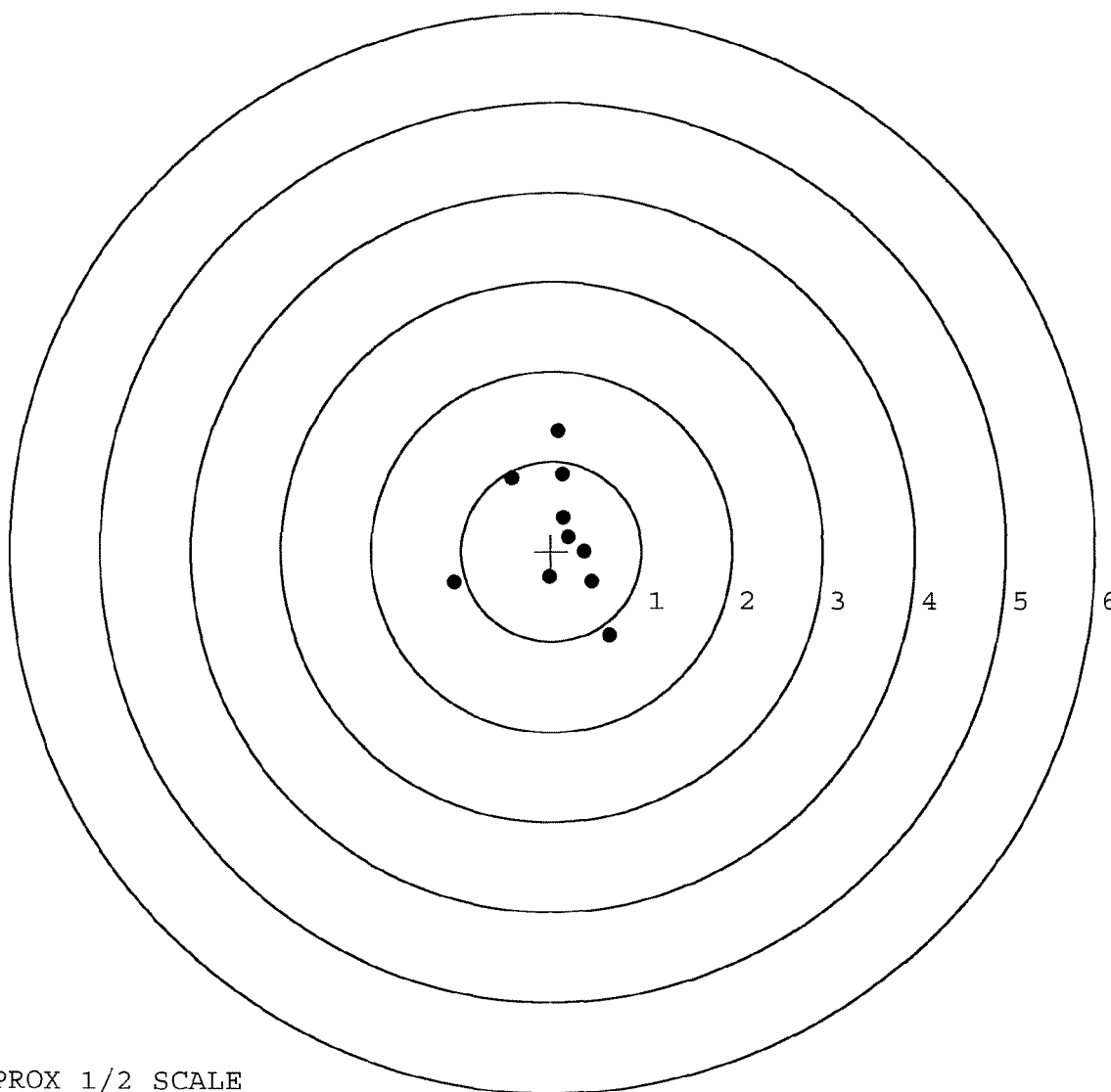
MAX RADIUS: 1.254

MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



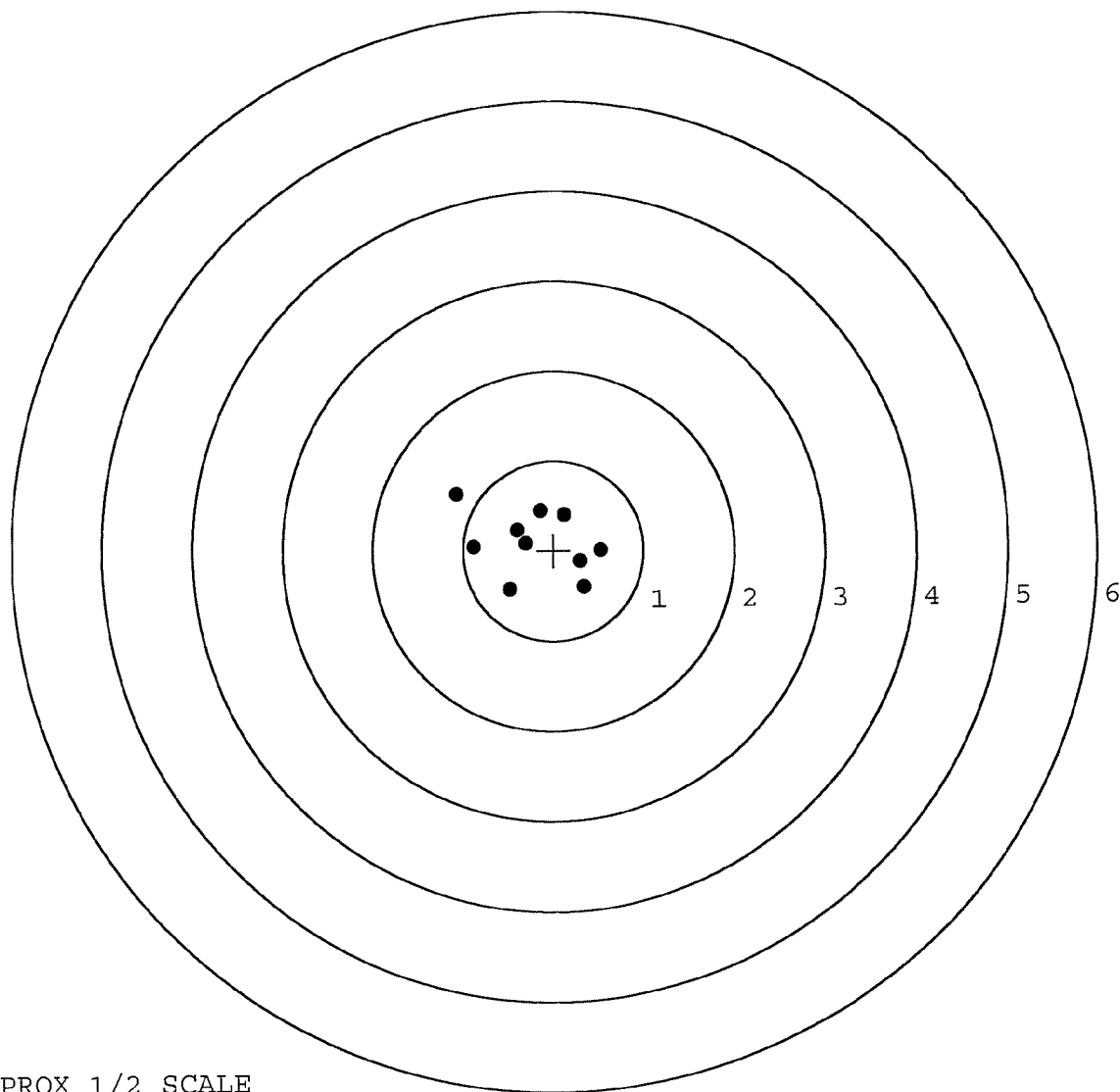
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521451. __0
 TARGET NUMBER: 2
 FILE DATE: 01/20/2006
 FILE TIME: 22:31

POINT#	X	Y
1:	0.126	0.397
2:	-0.141	0.442
3:	-0.401	0.231
4:	-0.309	0.081
5:	-0.490	-0.430
6:	-0.883	0.051
7:	-1.073	0.638
8:	0.524	0.003
9:	0.300	-0.121
10:	0.336	-0.407

X CENTROID: -0.201
 Y CENTROID: 0.088
 POA TO CENTROID: 0.220
 HORZ SPREAD: 1.597
 VERT SPREAD: 1.068
 GROUP SPREAD: 1.754
 MIN RADIUS: 0.108
 MAX RADIUS: 1.031
 MEAN RADIUS: 0.547

IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

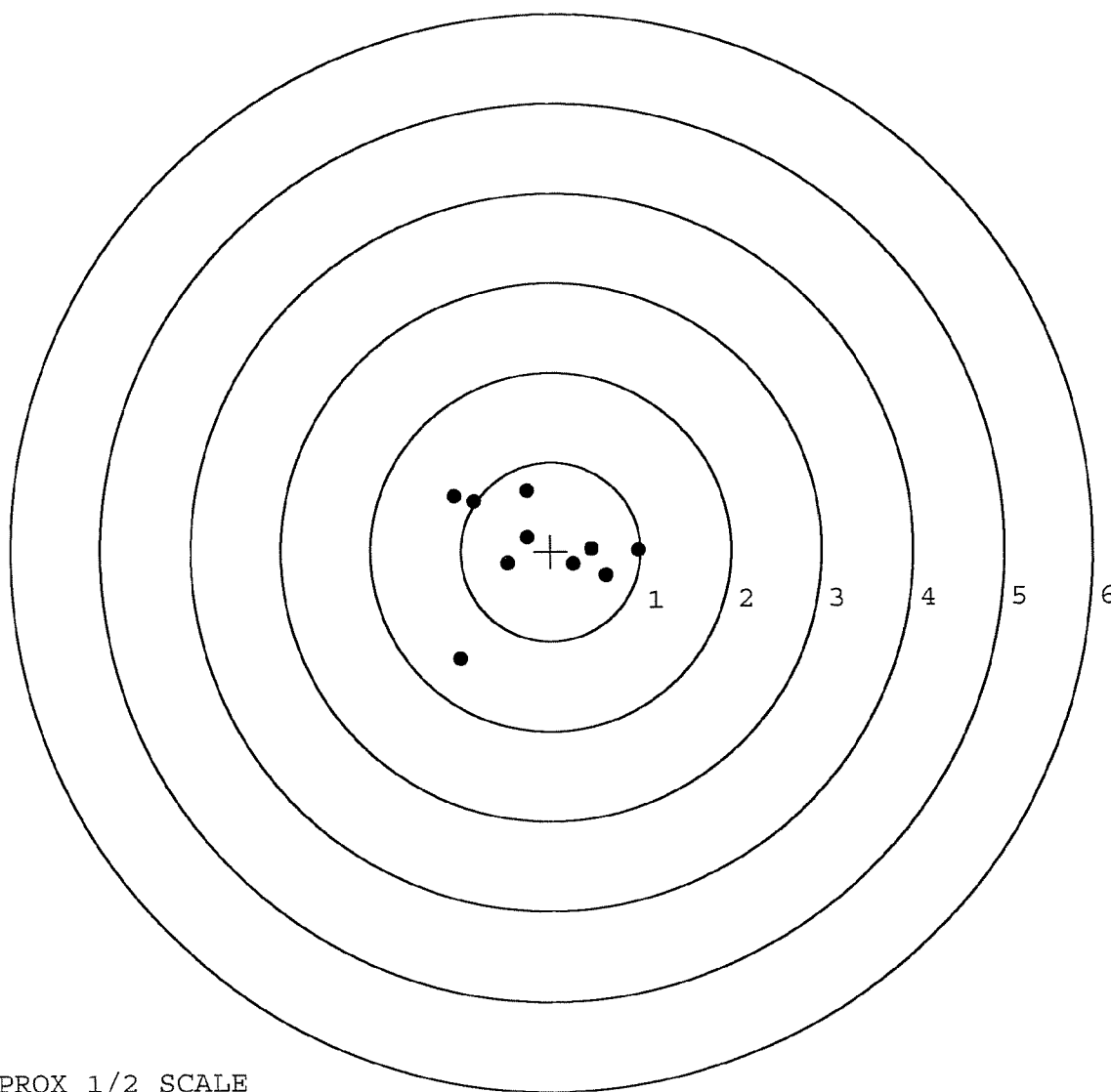


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521451. __0
 TARGET NUMBER: 3
 FILE DATE: 01/20/2006
 FILE TIME: 22:31

POINT#	X	Y
1:	-0.265	0.682
2:	-0.852	0.569
3:	-1.073	0.630
4:	-0.265	0.155
5:	-0.484	-0.134
6:	0.249	-0.153
7:	0.459	0.022
8:	0.616	-0.277
9:	0.976	-0.003
10:	-1.011	-1.188

X CENTROID: -0.165
 Y CENTROID: 0.030
 POA TO CENTROID: 0.168
 HORZ SPREAD: 2.049
 VERT SPREAD: 1.870
 GROUP SPREAD: 2.314
 MIN RADIUS: 0.160
 MAX RADIUS: 1.483
 MEAN RADIUS: 0.768
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521451. __ 0

TARGET NUMBER: 4

FILE DATE: 01/20/2006

FILE TIME: 22:31

POINT#	X	Y
1:	0.407	0.951
2:	0.141	0.578
3:	-0.314	0.689
4:	-1.405	0.433
5:	-0.913	-1.012
6:	0.815	-2.281
7:	0.048	-0.167
8:	-0.368	-0.249
9:	-0.150	-0.516
10:	0.077	-0.784

X CENTROID: -0.166

Y CENTROID: -0.236

POA TO CENTROID: 0.288

HORZ SPREAD: 2.220

VERT SPREAD: 3.232

GROUP SPREAD: 3.506

MIN RADIUS: 0.202

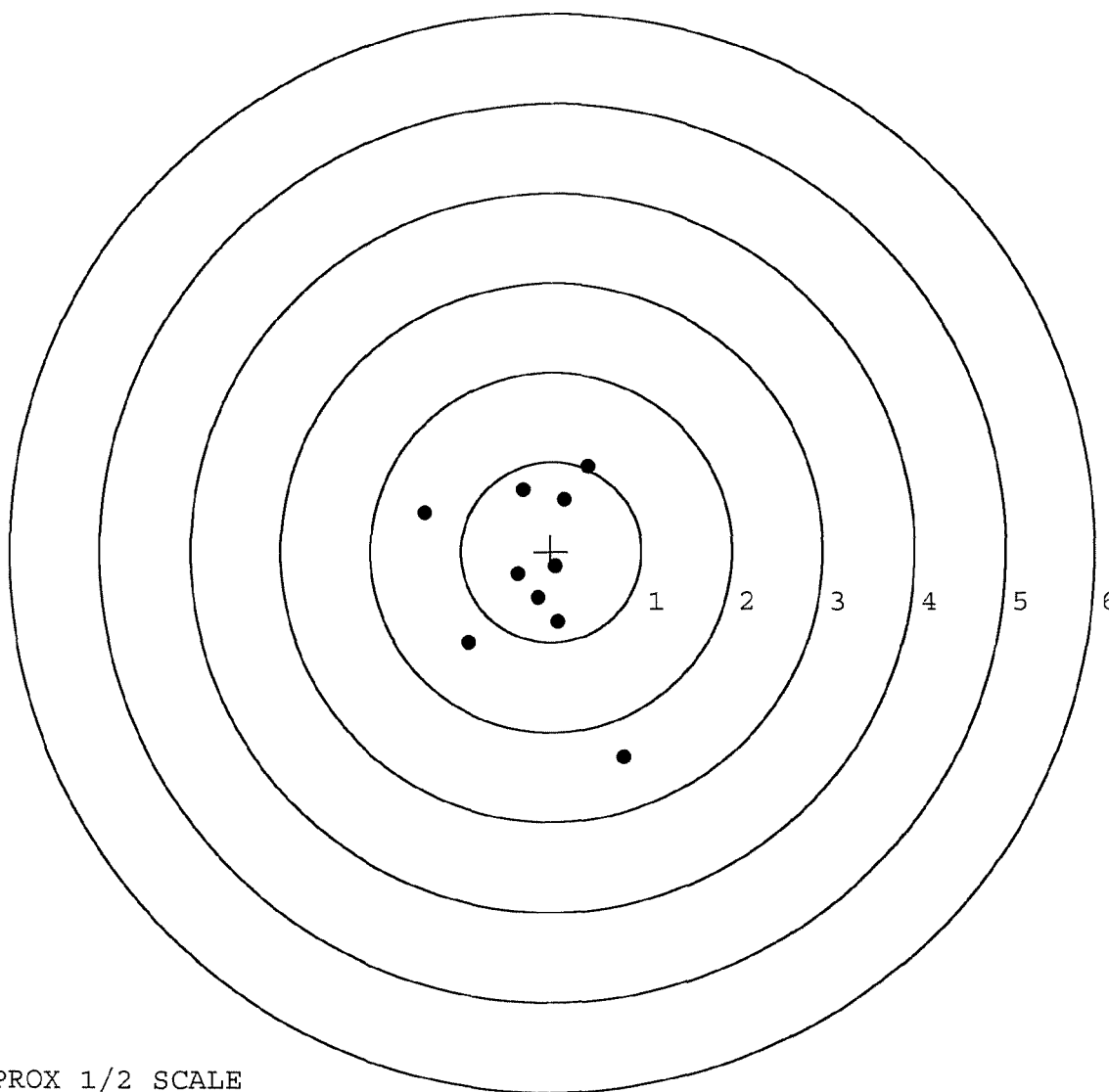
MAX RADIUS: 2.268

MEAN RADIUS: 0.919

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521451. __0

TARGET NUMBER: 5

FILE DATE: 01/20/2006

FILE TIME: 22:31

POINT#	X	Y
1:	0.971	0.973
2:	-0.054	1.162
3:	1.188	0.214
4:	0.264	0.368
5:	0.276	0.098
6:	-0.088	-0.315
7:	-0.547	-0.589
8:	-0.542	-0.081
9:	-0.922	-0.298
10:	-0.829	0.091

X CENTROID: -0.028

Y CENTROID: 0.162

POA TO CENTROID: 0.165

HORZ SPREAD: 2.110

VERT SPREAD: 1.751

GROUP SPREAD: 2.280

MIN RADIUS: 0.311

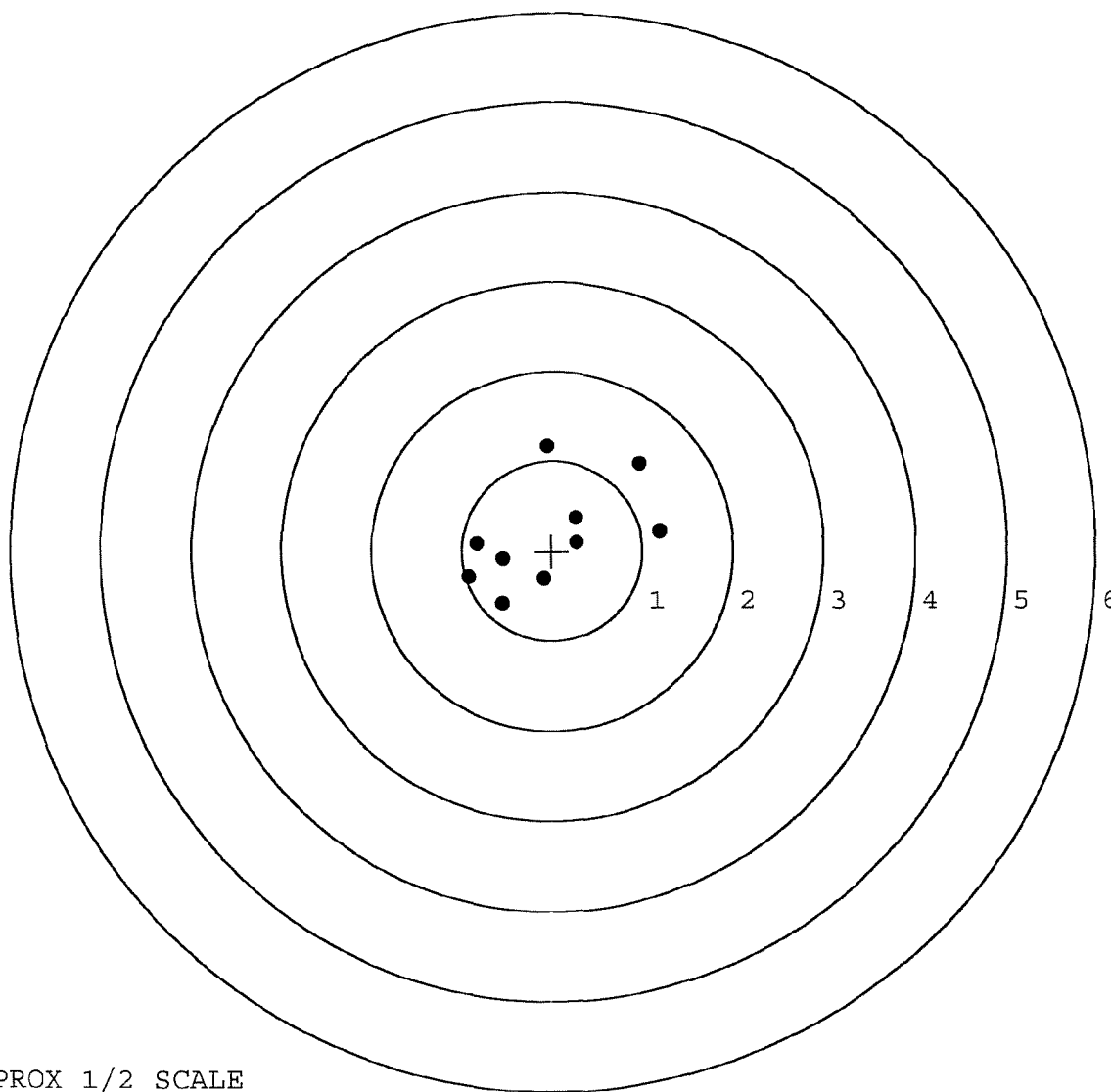
MAX RADIUS: 1.287

MEAN RADIUS: 0.794

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE