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

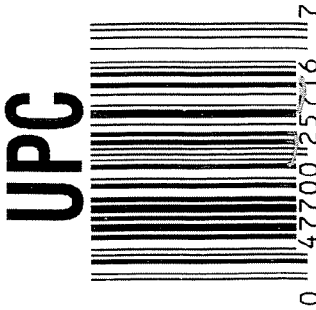
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6637660



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.



GUN SERIAL # G6637660

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-14-07	RTZ
420	ASSEMBLE ACTION		3-12-07	RLD
430	ASSEMBLE TO STOCK		3-13-07	RLD
440	PROOF		3-14-07	Fm
460	CHECK HEADSPACE	INSPECTED	3-14-07	Fm
470	DIS-ASSEMBLE ACTION	MAR 15 2007	3-14-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>www</u>	3/15/07	<u>www</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-15-07	CW
510	DRILL AND TAP SIGHT HOLES		3-14-07	TRLW
520	GOFF BLAST BBL / REC		3-19-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		3-23-07	WJ
560	RE-ASSEMBLE ACTION		3-27-07	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-07	SD
	D) OIL FIRING PIN ASSEMBLY		3/29/07	RLD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4/2/07	<u>www</u>

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>50</u> <u>50</u> <u>50</u>	4/2/07	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>30</u> <u>30</u>	4/2/07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		4/3/07	non
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	4/2/07	DA
	J) ASSEMBLE STOCK		3/29/07	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		4/5/07	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/5/07	non
	M) IRON SIGHT ALIGNMENT		4/5/07	non
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/5/07	non
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3/30/07	non
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-07	SD
670	FINAL INSPECTION A) HEADSPACE		4/5/07	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.18</u> <u>2.20</u> <u>2.36</u> <u>2.51</u>	4/2/07	DA
	C) FUNCTION		4/5/07	non
690	PACK		4/12/07	DA

F004 REV 5/2006

BARBER - M24 0144292AVERAGE 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 3/29/07TESTER Moh

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.59	2.54		2.55	
PULL #2	2.49	2.49		2.46	
PULL #3	2.58	2.58		2.49	
PULL #4	2.50	2.32		2.44	
PULL #5	2.50	2.54		2.46	
TOTAL	12.66	12.52		12.40	
AVERAGE	2.53	2.50		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.97	3.11		
PULL #2	3.04	3.19		
PULL #3	3.01	3.17		
PULL #4	3.05	3.17		
PULL #5	3.16	3.11		
TOTAL	15.23	15.75		
AVERAGE	3.05	3.15		

	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	4.01	3.92		4.04
PULL #2	3.89	4.04		4.06
PULL #3	3.99	3.96		4.02
PULL #4	4.05	4.03		3.97
PULL #5	4.00	3.94		3.95
TOTAL	19.97	19.89		20.04
AVERAGE	3.99	3.98		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6637660.__0
FILE DATE AND TIME: 03/30/2007 22:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.104
The Average Y Centroid of the Five Target Set:	0.176
The Average Point of Impact of the Five Target Set:	0.204
The Average Mean Radius of the Five Target Set:	0.673
The Distance from POA to Centroid Target #1:	0.289
The Distance from Centroid Target #2 to Centroid Target #1:	0.659
The Distance from Centroid Target #3 to Centroid Target #1:	0.532
The Distance from Centroid Target #4 to Centroid Target #1:	0.217
The Distance from Centroid Target #5 to Centroid Target #1:	0.408

BARBER - M24 0144294

SERIAL NUMBER: G6637660. 0

TARGET NUMBER: 1

FILE DATE: 03/30/2007

FILE TIME: 22:43

POINT#	X	Y
1:	-1.198	0.164
2:	-1.096	-0.014
3:	-1.107	-0.566
4:	0.090	0.815
5:	0.442	-0.035
6:	0.051	-0.341
7:	-0.174	-0.239
8:	0.713	-0.611
9:	-0.097	-0.241
10:	-0.221	-0.207

X CENTROID: -0.260

Y CENTROID: -0.128

POA TO CENTROID: 0.289

HORZ SPREAD: 1.911

VERT SPREAD: 1.426

GROUP SPREAD: 2.062

MIN RADIUS: 0.088

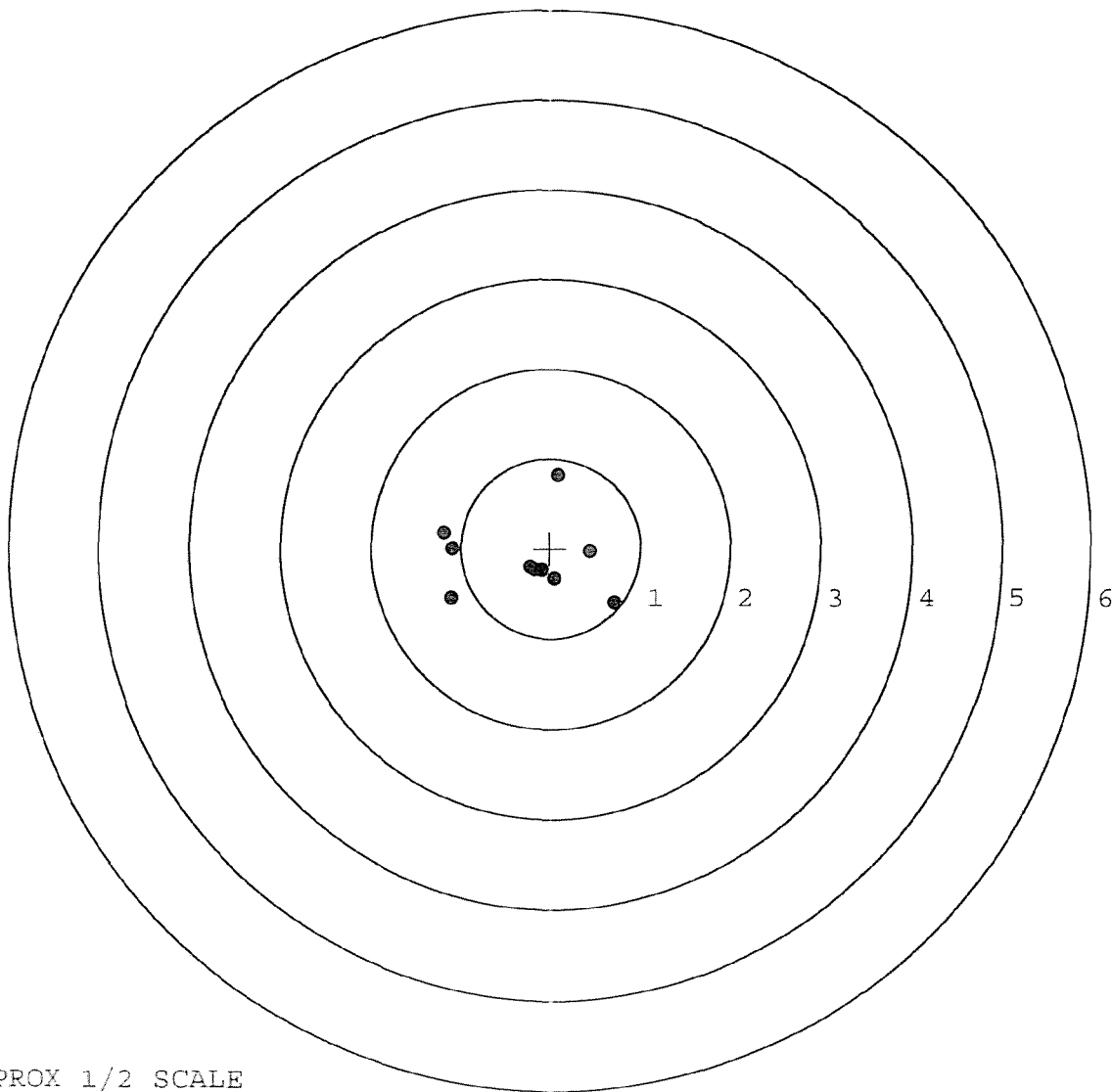
MAX RADIUS: 1.086

MEAN RADIUS: 0.638

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0144295

SERIAL NUMBER: G6637660. 0

TARGET NUMBER: 2

FILE DATE: 03/30/2007

FILE TIME: 22:43

X CENTROID: -0.016

Y CENTROID: 0.485

POA TO CENTROID: 0.485

HORZ SPREAD: 1.504

VERT SPREAD: 2.442

GROUP SPREAD: 2.443

MIN RADIUS: 0.152

MAX RADIUS: 1.349

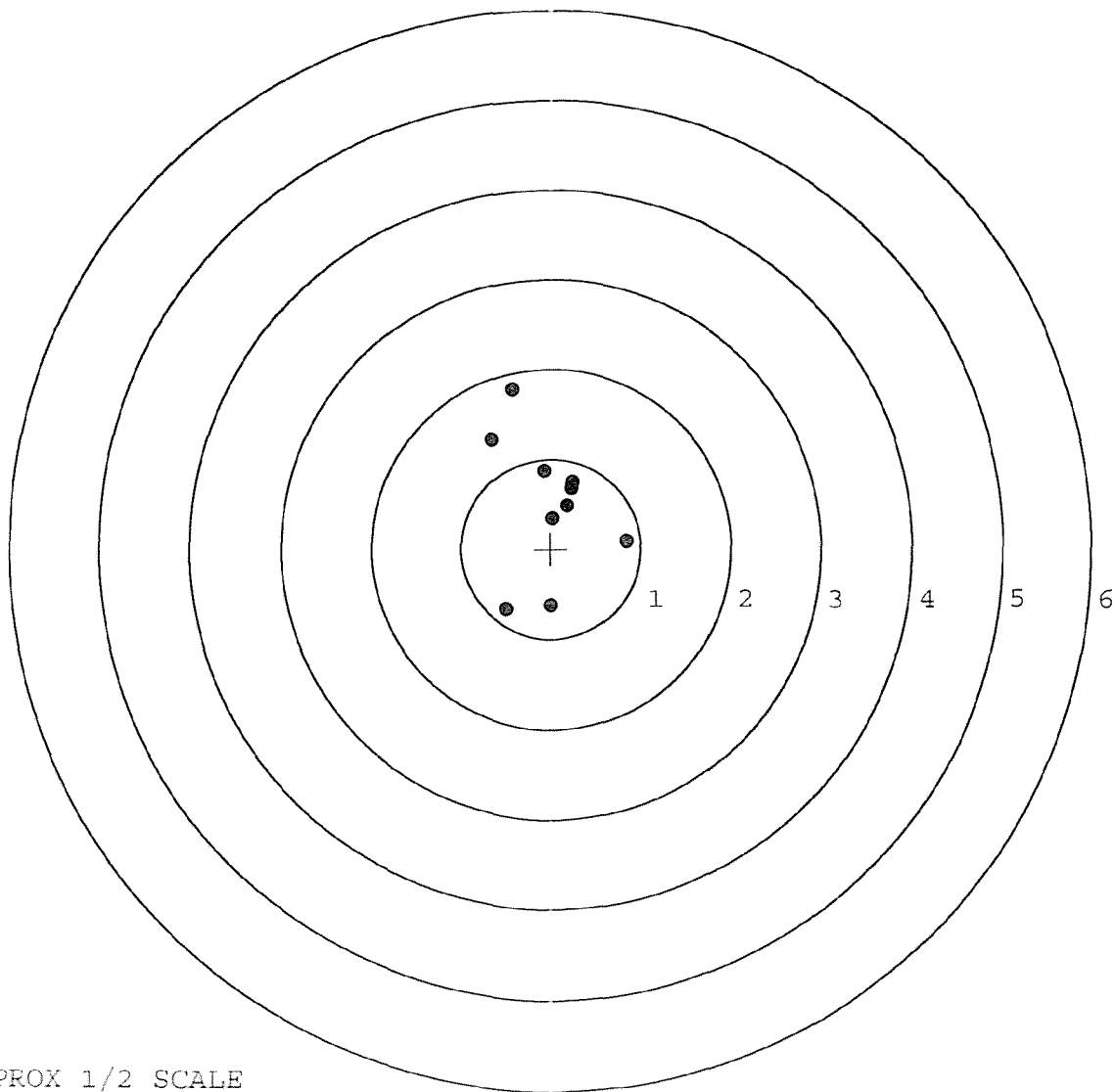
MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.665	1.203
2:	-0.436	1.767
3:	-0.076	0.869
4:	0.246	0.741
5:	0.184	0.476
6:	0.015	0.336
7:	0.839	0.093
8:	0.003	-0.636
9:	-0.501	-0.675
10:	0.233	0.672



TARGET APPROX 1/2 SCALE

BARBER - M24 0144296

SERIAL NUMBER: G6637660. 0

TARGET NUMBER: 3

FILE DATE: 03/30/2007

FILE TIME: 22:43

X CENTROID: 0.088

Y CENTROID: 0.276

POA TO CENTROID: 0.289

HORZ SPREAD: 1.339

VERT SPREAD: 1.656

GROUP SPREAD: 1.657

MIN RADIUS: 0.104

MAX RADIUS: 0.946

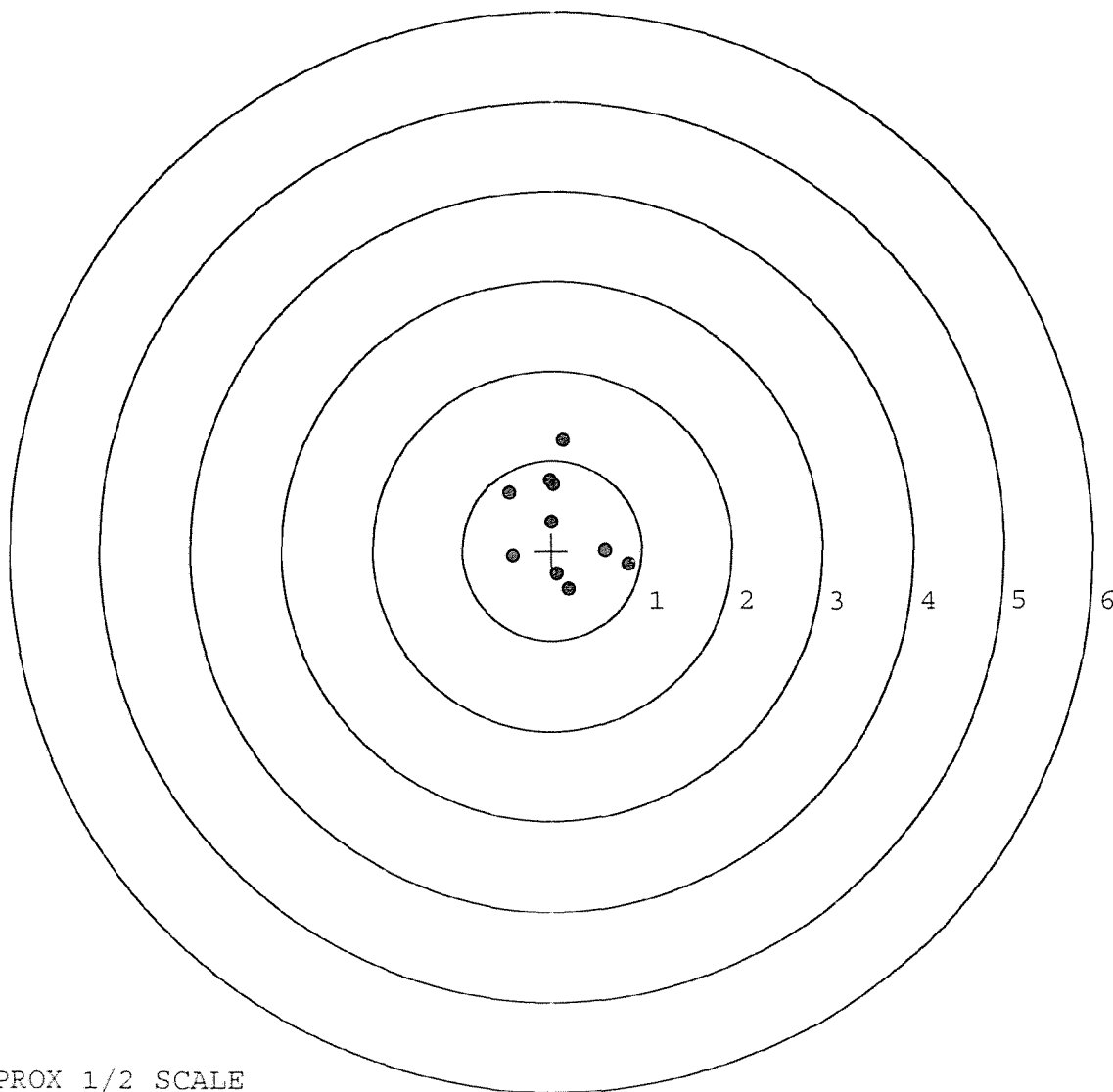
MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

IN 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.012	0.307
2:	-0.025	0.778
3:	-0.480	0.637
4:	-0.438	-0.062
5:	0.057	-0.265
6:	0.187	-0.435
7:	0.859	-0.159
8:	0.594	0.006
9:	0.120	1.221
10:	0.015	0.730



TARGET APPROX 1/2 SCALE

BARBER - M24 0144297

SERIAL NUMBER: G6637660. __0

TARGET NUMBER: 4

FILE DATE: 03/30/2007

FILE TIME: 22:43

POINT#	X	Y
1:	-0.199	0.799
2:	0.297	0.960
3:	-1.599	0.119
4:	-1.730	0.343
5:	-0.402	0.123
6:	-0.333	-0.034
7:	-0.241	-0.285
8:	-0.027	-0.464
9:	0.402	-0.810
10:	0.396	-0.025

X CENTROID: -0.344

Y CENTROID: 0.073

POA TO CENTROID: 0.351

HORZ SPREAD: 2.132

VERT SPREAD: 1.770

GROUP SPREAD: 2.424

MIN RADIUS: 0.077

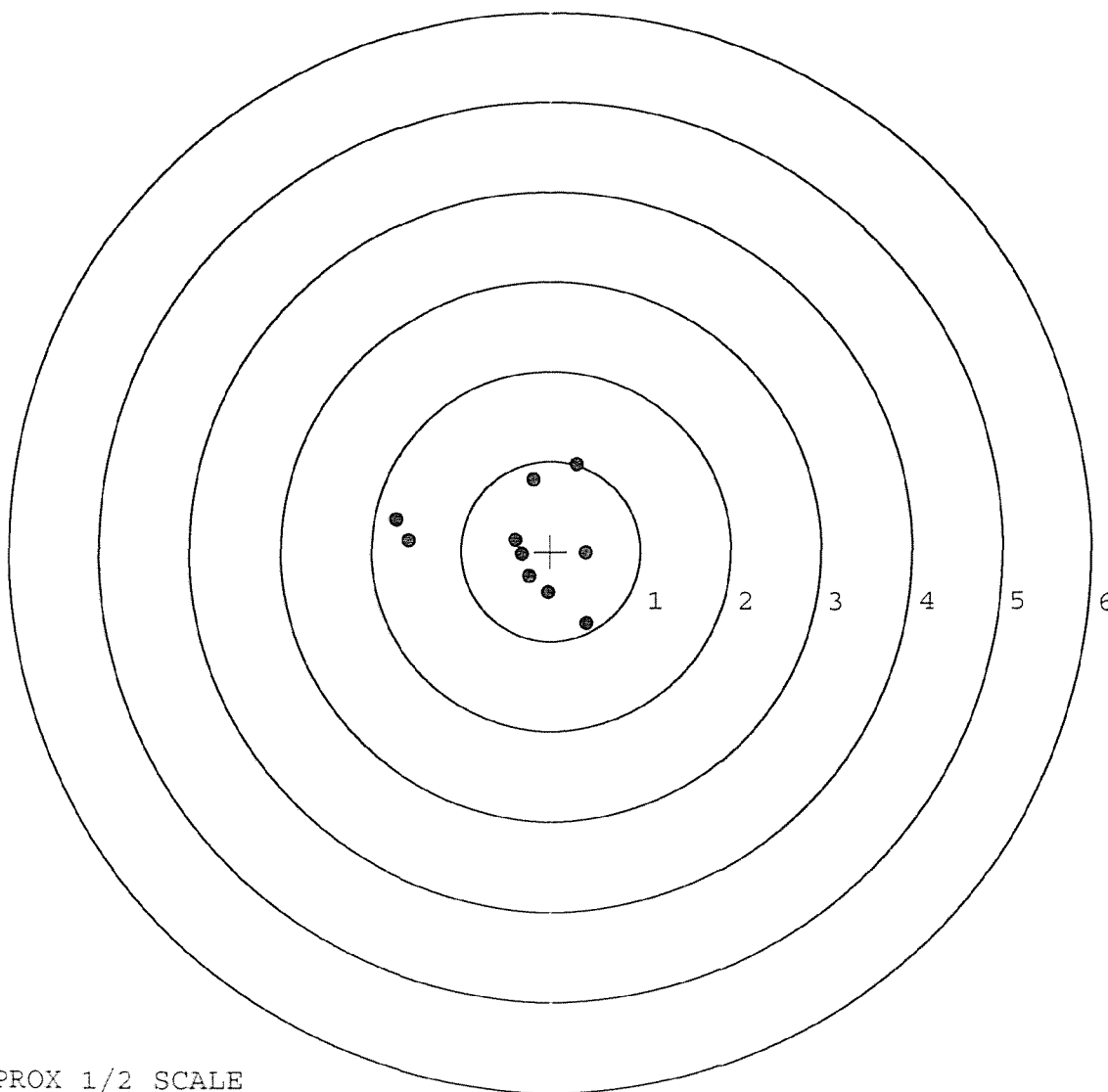
MAX RADIUS: 1.413

MEAN RADIUS: 0.758

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0144298

SERIAL NUMBER: G6637660. 0

TARGET NUMBER: 5

FILE DATE: 03/30/2007

FILE TIME: 22:43

POINT#	X	Y
1:	-0.232	0.643
2:	0.085	0.963
3:	0.200	1.193
4:	0.231	0.377
5:	0.400	0.410
6:	0.439	0.102
7:	-0.163	-0.086
8:	0.219	-0.512
9:	-0.350	-0.540
10:	-0.692	-0.798

X CENTROID: 0.014

Y CENTROID: 0.175

POA TO CENTROID: 0.176

HORZ SPREAD: 1.131

VERT SPREAD: 1.991

GROUP SPREAD: 2.182

MIN RADIUS: 0.297

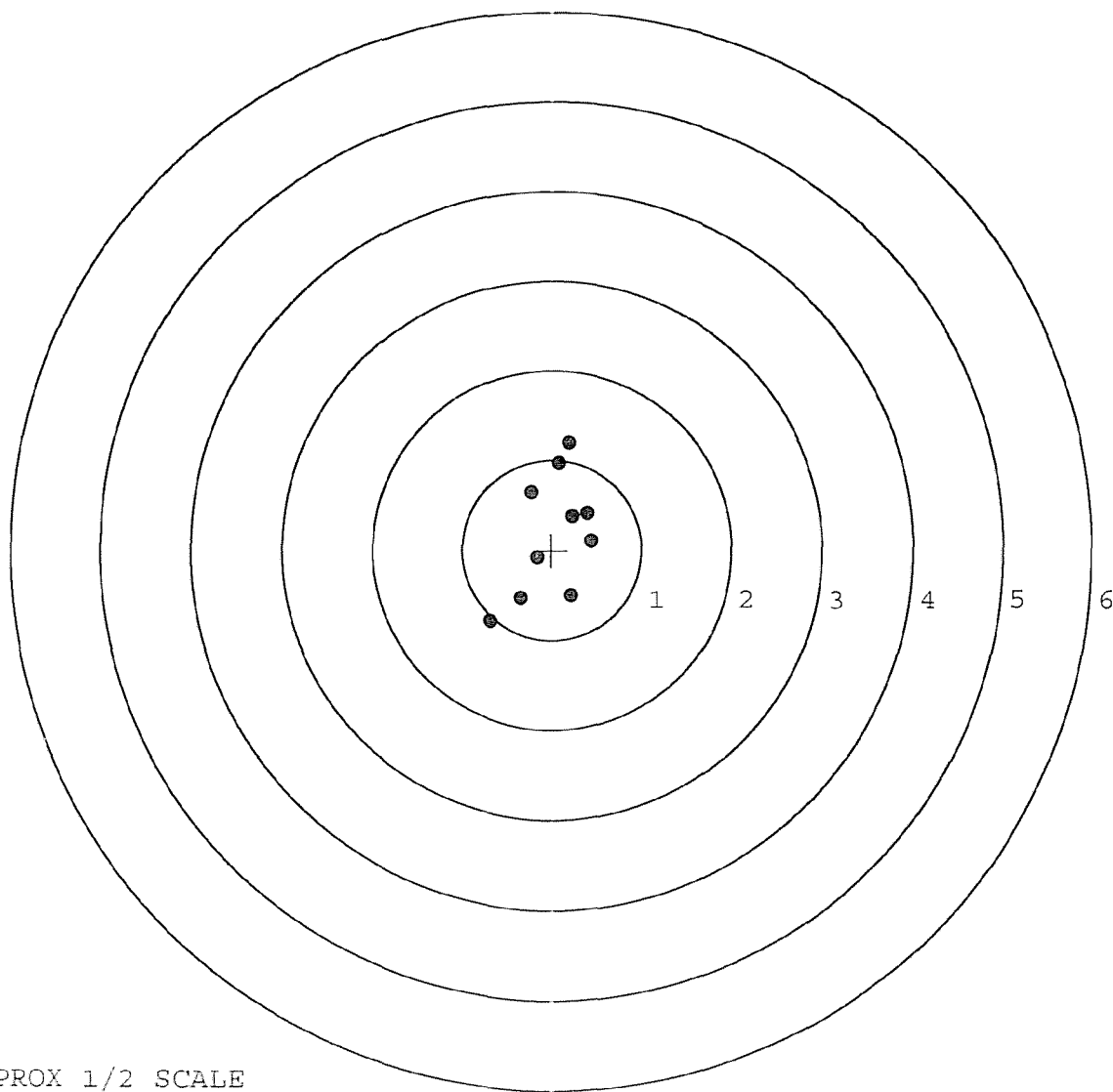
MAX RADIUS: 1.202

MEAN RADIUS: 0.657

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE