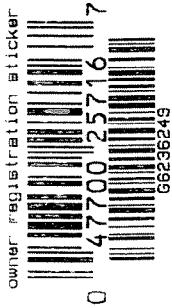


6423 6249

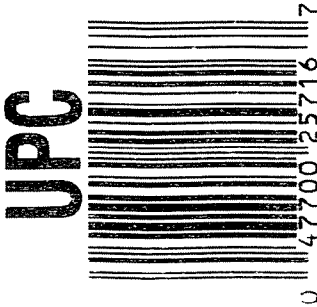
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6236249



46 FORM

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6236249

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		9/5/02	RL
600	PROOF		9/5/02	RL
607	CHECK HEADSPACE		9/9/02	RL
610	DIS-ASSEMBLE GUN		9/9/02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	SEP 10 2002 RL		
615	ROLLMARK CALIBER		9/10	BS
617	DRILL AND TAP SIGHT HOLES		9-20-02	Ac
620	APPLY COATINGS (BARREL ACTION)		9-18	TA
	(BOLT)		9-18	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-20-02	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-20-02	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-20-02	RW
	D) OIL FIRING PIN ASSEMBLY		9-20-02	RW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		11-15-02	RL

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>7.0</u>	03-02	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>2.5</u> <u>2.5</u>	10-8-02	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		11-5-02	RL
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.021</u> <u>.022</u>	10-8-02	DA
	J) ASSEMBLE STOCK		10/4/02	RL
	K) ASSEMBLE SWIVEL STUDS		11-15-02	RL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10/31/02	RL
	M) IRON SIGHT ALIGNMENT		10/31/02	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10/32/02	RL
640	GALLERY TEST AND TARGET	PASS FAIL	10/3/02	TRW
	MALFUNCTION	CORRECTION	10/3/02	TRW
	MALFUNCTION	CORRECTION	10/3/02	TRW
	MALFUNCTION	CORRECTION	10/3/02	TRW
	MALFUNCTION	CORRECTION	10/3/02	TRW
645	INSPECT FOR LIVE AMMO		10/3/02	TRW
655	FINAL INSPECTION A) HEADSPACE		11-15-02	RL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.81</u> <u>2.78</u> <u>2.75</u> <u>2.82</u>	10/4/02	RL
	C) FUNCTION		11-15-02	RL
660	PACK		11/27/02	DA

AVERAGE INITIAL & CYCLE TESTS
 2.50# + 1.50#
 3.00# + .75#
 4.00# + 1.00#

BARBER - M24 0147784

DATE 10-2-02

TESTER TRW
G6136249

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.66	2.73		2.50	MIN. SETTING
PULL #2	2.55	2.47		2.27	NO AVG. OF 5
PULL #3	2.24	2.54		2.65	READINGS ACCEPT-
PULL #4	2.67	2.59		2.60	ABLE LESS THAN 2
PULL #5	2.71	2.50		2.52	
TOTAL	12.83	12.83		12.54	
AVG.	2.56	2.56		2.50	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.24		
PULL #2	3.20	3.20		
PULL #3	3.16	3.12		
PULL #4	3.17	3.26		
PULL #5	3.15	3.13		
TOTAL	15.87	15.95		
AVG.	3.17	3.19		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCUR
PULL #1	4.25	4.34		4.42
PULL #2	4.24	4.36		4.33
PULL #3	4.28	4.30		4.38
PULL #4	4.29	4.35		4.36
PULL #5	4.08	4.34		4.18
TOTAL	21.14	21.69		21.67
AVG.	4.22	4.33		4.33

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236249.___0
FILE DATE AND TIME: 10/04/2002 . 12:02

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.007
The Average Y Centroid of the Five Target Set:	-0.076
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.670
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.151
The Distance from Centroid Target #3 to Centroid Target #1:	0.120
The Distance from Centroid Target #4 to Centroid Target #1:	0.073
The Distance from Centroid Target #5 to Centroid Target #1:	0.101

SERIAL NUMBER: G6236249. 0

TARGET NUMBER: 1

FILE DATE: 10/04/2002

FILE TIME: 12:02

X CENTROID: 0.011

Y CENTROID: -0.125

POA TO CENTROID: 0.126

HORZ SPREAD: 0.927

VERT SPREAD: 1.447

GROUP SPREAD: 1.622

MIN RADIUS: 0.110

MAX RADIUS: 0.860

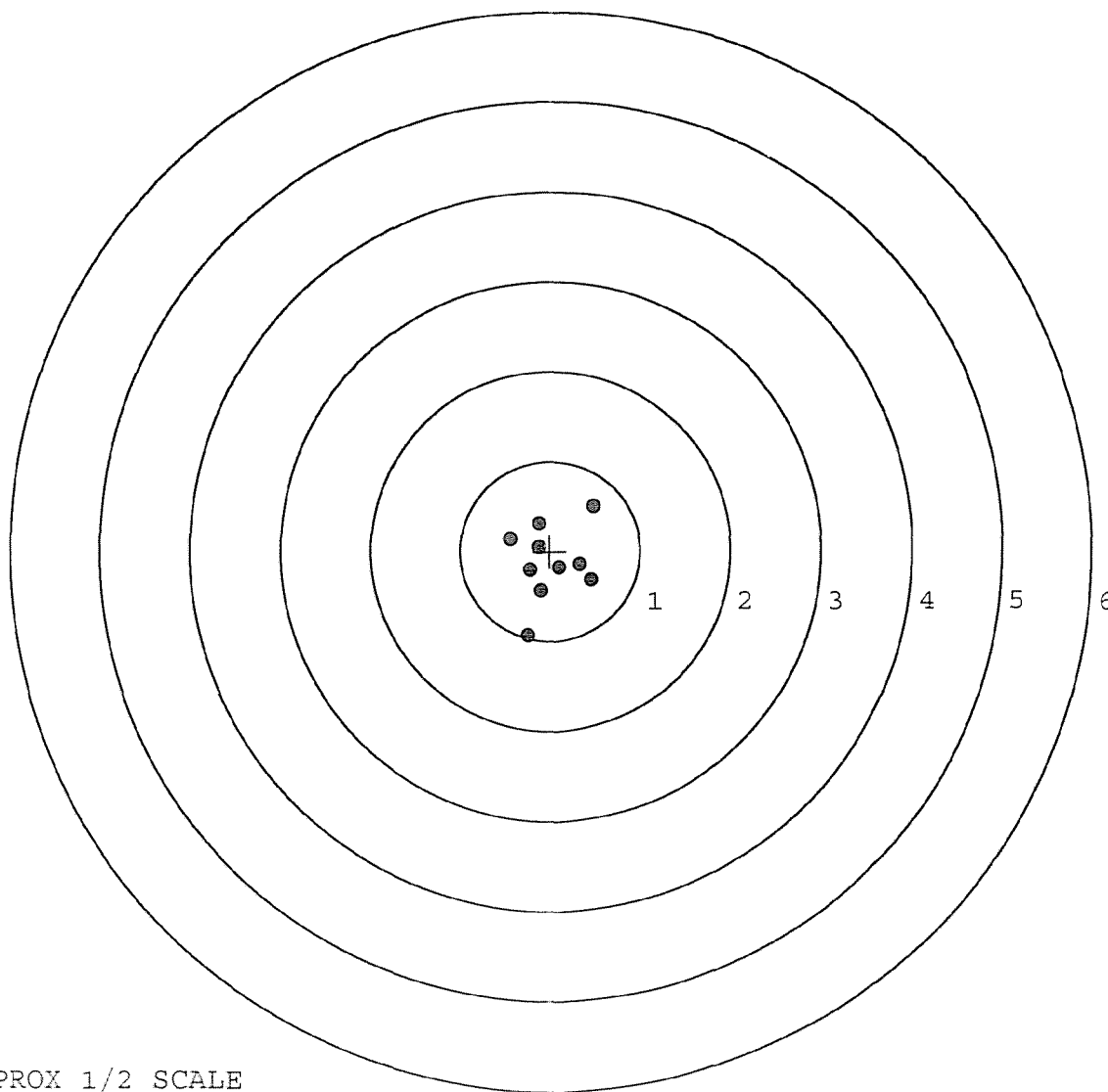
MEAN RADIUS: 0.436

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.461	-0.323
2:	0.337	-0.148
3:	0.481	0.503
4:	-0.127	0.312
5:	-0.446	0.134
6:	-0.251	-0.944
7:	-0.104	-0.443
8:	0.106	-0.182
9:	-0.220	-0.209
10:	-0.122	0.050



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236249. 0

TARGET NUMBER: 2

FILE DATE: 10/04/2002

FILE TIME: 12:02

X CENTROID: -0.021

Y CENTROID: 0.022

POA TO CENTROID: 0.031

HORZ SPREAD: 1.432

VERT SPREAD: 2.343

GROUP SPREAD: 2.526

MIN RADIUS: 0.147

MAX RADIUS: 1.907

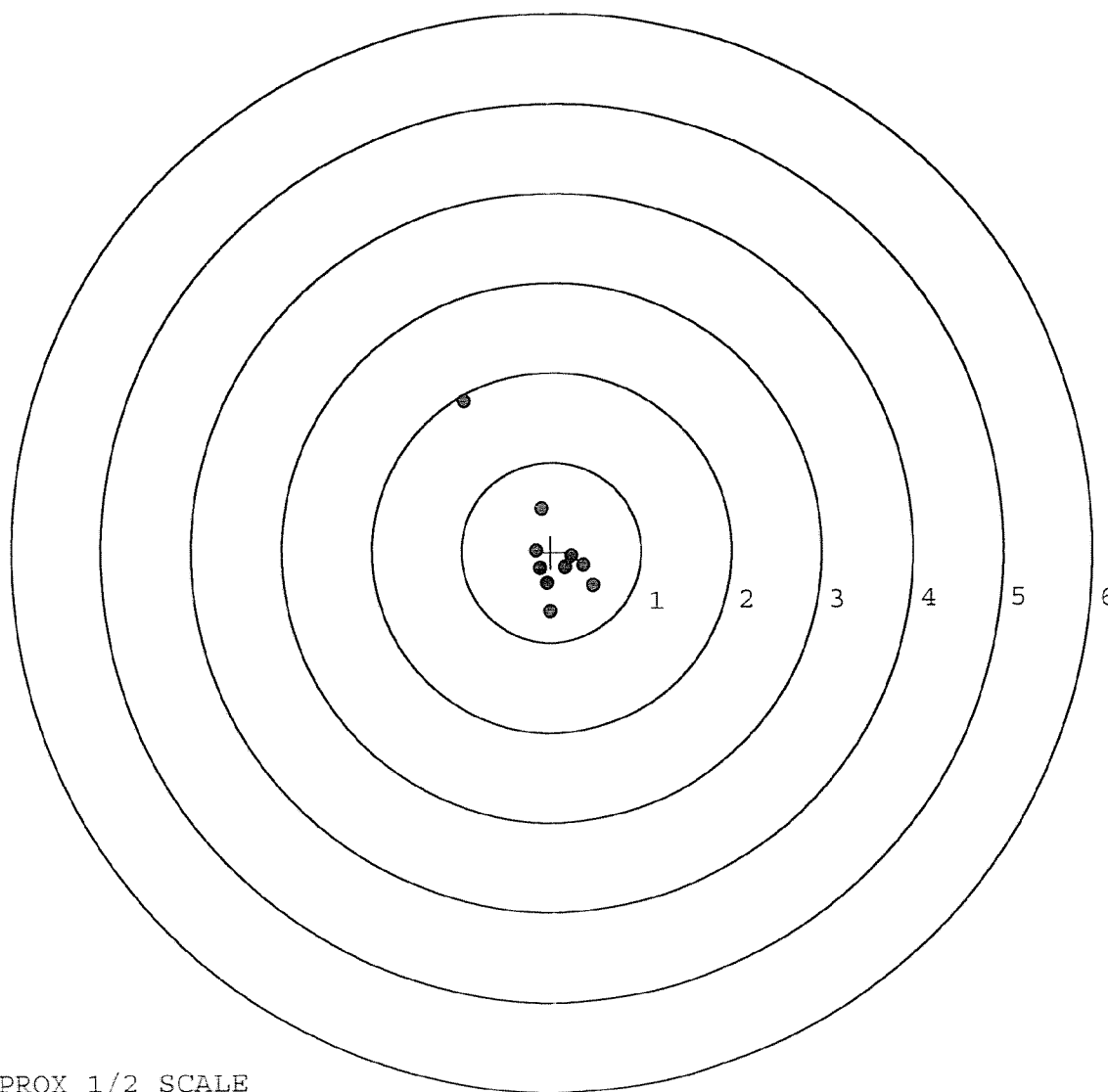
MEAN RADIUS: 0.539

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.019	-0.663
2:	-0.963	1.680
3:	-0.104	0.482
4:	0.469	-0.380
5:	-0.051	-0.348
6:	0.361	-0.155
7:	0.230	-0.052
8:	-0.168	0.018
9:	-0.121	-0.180
10:	0.157	-0.178



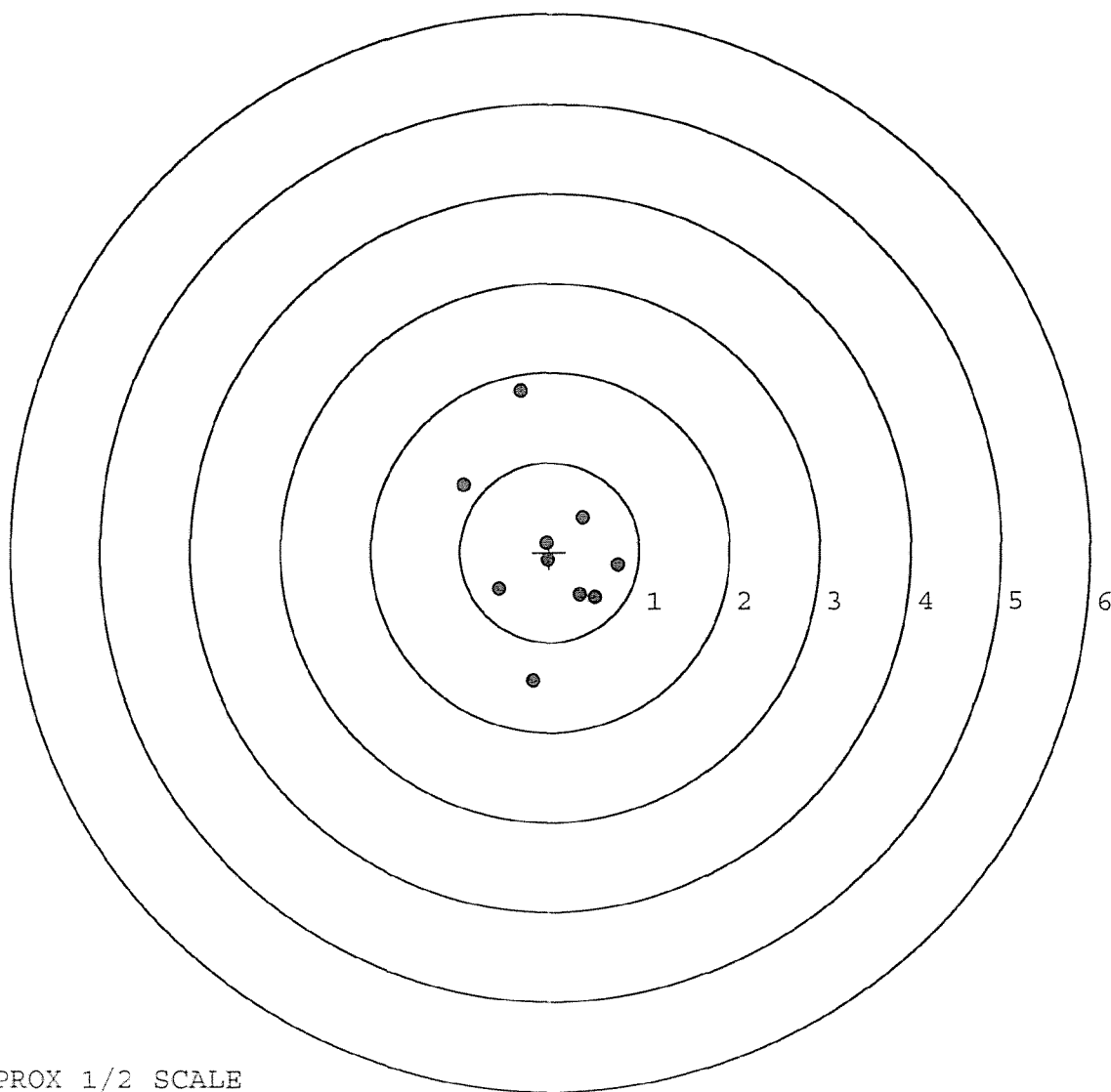
TARGET APPROX 1/2 SCALE

BARBER - M24 0147788

SERIAL NUMBER: G6236249. __0
 TARGET NUMBER: 3
 FILE DATE: 10/04/2002
 FILE TIME: 12:02

POINT#	X	Y
1:	-0.181	-1.437
2:	0.766	-0.153
3:	0.510	-0.512
4:	0.344	-0.476
5:	-0.562	-0.418
6:	-0.018	-0.091
7:	-0.031	0.106
8:	0.367	0.383
9:	-0.965	0.743
10:	-0.323	1.788

X CENTROID: -0.009
 Y CENTROID: -0.007
 POA TO CENTROID: 0.011
 HORZ SPREAD: 1.731
 VERT SPREAD: 3.225
 GROUP SPREAD: 3.228
 MIN RADIUS: 0.085
 MAX RADIUS: 1.822
 MEAN RADIUS: 0.801
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9

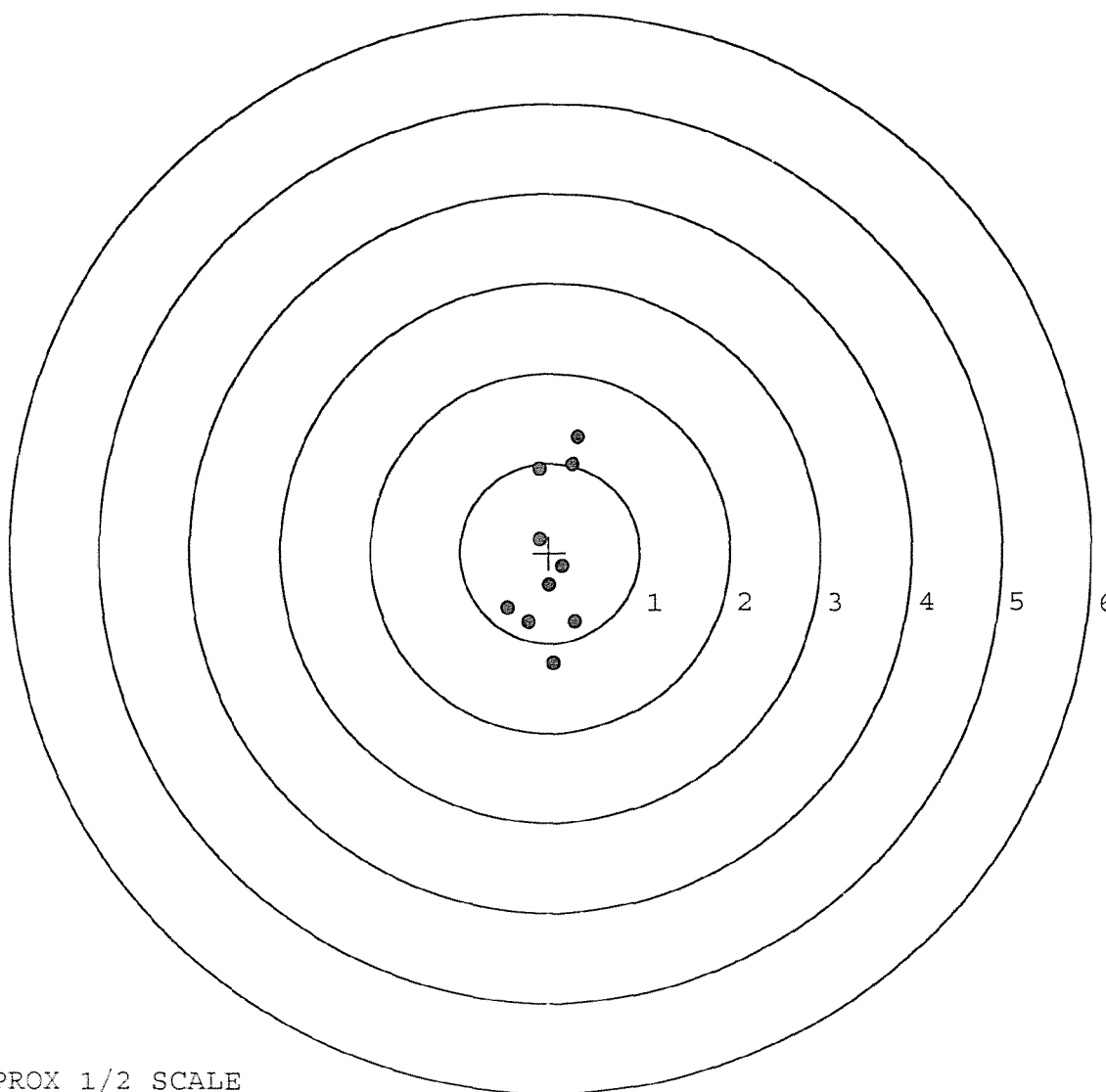


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236249. __0
 TARGET NUMBER: 4
 FILE DATE: 10/04/2002
 FILE TIME: 12:02

X CENTROID: 0.012
 Y CENTROID: -0.052
 POA TO CENTROID: 0.054
 HORZ SPREAD: 0.783
 VERT SPREAD: 2.513
 GROUP SPREAD: 2.527
 MIN RADIUS: 0.166
 MAX RADIUS: 1.377
 MEAN RADIUS: 0.761
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.048	-1.222
2:	0.291	-0.767
3:	-0.230	-0.774
4:	-0.470	-0.624
5:	-0.009	-0.361
6:	0.146	-0.150
7:	-0.112	0.153
8:	0.254	0.991
9:	-0.114	0.940
10:	0.313	1.291



TARGET APPROX 1/2 SCALE

BARBER - M24 0147790

SERIAL NUMBER: G6236249. __ 0

TARGET NUMBER: 5

FILE DATE: 10/04/2002

FILE TIME: 12:02

X CENTROID: -0.029

Y CENTROID: -0.217

POA TO CENTROID: 0.219

HORZ SPREAD: 1.050

VERT SPREAD: 3.433

GROUP SPREAD: 3.433

MIN RADIUS: 0.090

MAX RADIUS: 1.884

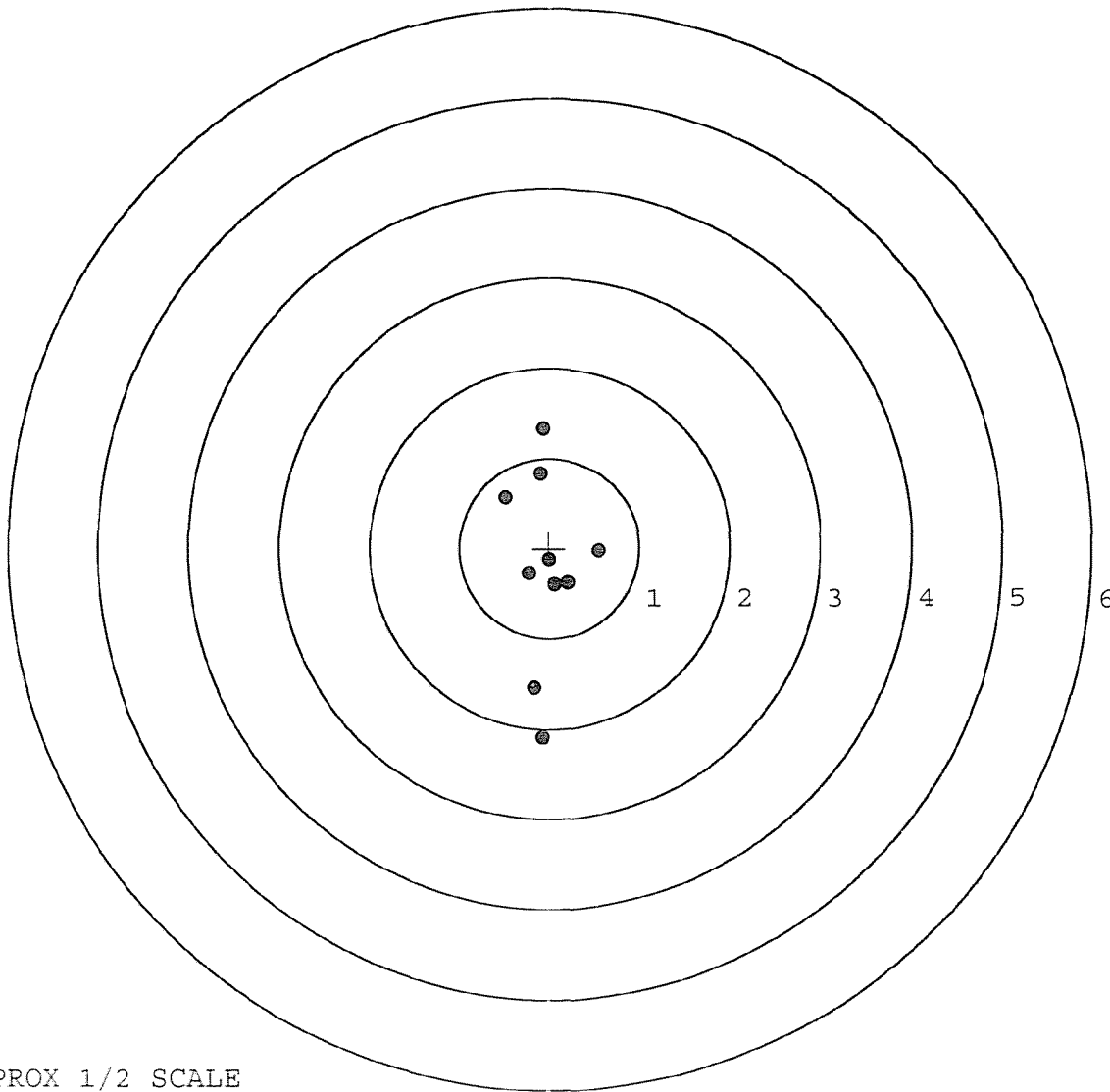
MEAN RADIUS: 0.815

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.068	-2.100
2:	-0.173	-1.557
3:	0.557	-0.027
4:	0.213	-0.386
5:	0.062	-0.404
6:	0.002	-0.133
7:	-0.223	-0.285
8:	-0.493	0.563
9:	-0.105	0.828
10:	-0.067	1.333



TARGET APPROX 1/2 SCALE