

G-641 4424

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

- INSTRUCTION BOOK 3518



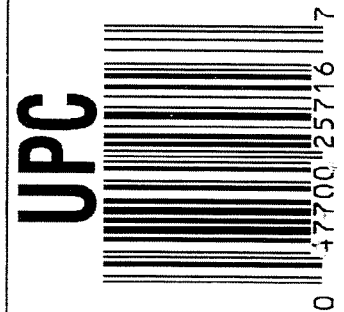
DD FORM

ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6414424



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

UPC



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

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414424

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-9-04	RTL
600	PROOF		11-9-04	RTL
607	CHECK HEADSPACE		11-9-04	RTL
610	DIS-ASSEMBLE GUN		11-10-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		11/11/04	KB
617	DRILL AND TAP SIGHT HOLES		11-10-04	TRL
620	APPLY COATINGS (BARREL ACTION)		11/13	HR
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11/29/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/29/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/29/04	DA
	D) OIL FIRING PIN ASSEMBLY		11-30-04	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE			
		2.50 LBS +/- .5 LBS		

OP # OPERATION NAME			READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>7.2</u>	<u>7.5</u>	<u>7.5</u>	12/2/04	RA		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.2</u>	<u>2.5</u>	<u>2.5</u>	12/2/04	RA		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>1023</u>	<u>1023</u>	<u>1024</u>	12/2/04	RA		
	J) ASSEMBLE STOCK					12-30-04	RTL		
	K) ASSEMBLE SWIVEL STUDS					12-3-04	A		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					N/A			
	M) IRON SIGHT ALIGNMENT								
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER								
640	GALLERY TEST AND TARGET		PASS FAIL			12-1-04	A		
	MALFUNCTION		CORRECTION			N/A			
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
645	INSPECT FOR LIVE AMMO					12-1-04	A		
655	FINAL INSPECTION A) HEADSPACE					12-3-04	Ac		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u>	<u>2.31</u>	<u>2.45</u>	<u>2.74</u>	<u>2.51</u>	12/2/04	RA
	C) FUNCTION					12-3-04	Ac		
660	PACK					12/4/04	RA		

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)

SERIAL NO.

DATE

11-30-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.40		2.65	
PULL #2	2.58	2.26		2.65	
PULL #3	2.46	2.49		2.52	
PULL #4	2.71	2.46		2.67	
PULL #5	2.88	2.53		2.64	
TOTAL	13.13	13.14		13.13	
AVERAGE	2.62	2.42		2.62	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.02		
PULL #2	3.24	3.11		
PULL #3	3.29	3.10		
PULL #4	3.34	3.13		
PULL #5	3.21	3.14		
TOTAL	16.31	15.50		
AVERAGE	3.26	3.10		

	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	4.45	4.31		4.52
PULL #2	4.45	4.25		4.48
PULL #3	4.18	4.29		4.52
PULL #4	4.45	4.35		4.38
PULL #5	4.40	4.30		4.45
TOTAL	21.93	21.50		22.35
AVERAGE	4.38	4.30		4.47

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414424.___1
FILE DATE AND TIME: 10/10/2005 11:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

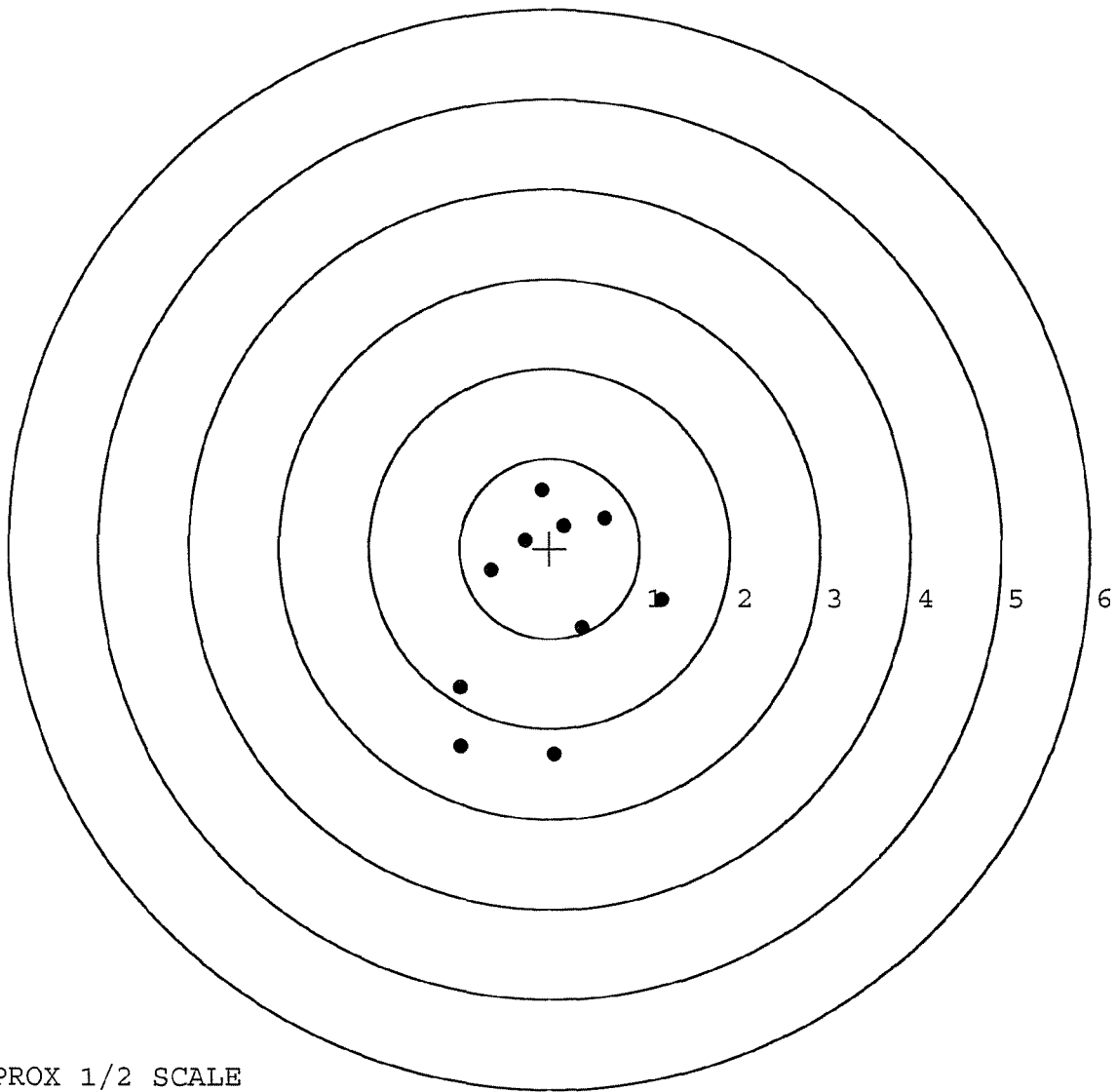
The Average X Centroid of the Five Target Set:	-0.068
The Average Y Centroid of the Five Target Set:	-0.136
The Average Point of Impact of the Five Target Set:	0.152
The Average Mean Radius of the Five Target Set:	0.896
The Distance from POA to Centroid Target #1:	0.643
The Distance from Centroid Target #2 to Centroid Target #1:	0.723
The Distance from Centroid Target #3 to Centroid Target #1:	0.623
The Distance from Centroid Target #4 to Centroid Target #1:	0.650
The Distance from Centroid Target #5 to Centroid Target #1:	0.550

BARBER - M24 0152221

SERIAL NUMBER: G6414424. 1
 TARGET NUMBER: 1
 FILE DATE: 10/10/2005
 FILE TIME: 11:00

POINT#	X	Y
1:	1.242	-0.567
2:	0.356	-0.878
3:	-0.652	-0.241
4:	-0.273	0.091
5:	0.157	0.253
6:	0.611	0.344
7:	-0.089	0.651
8:	-0.991	-1.558
9:	-0.991	-2.208
10:	0.057	-2.292

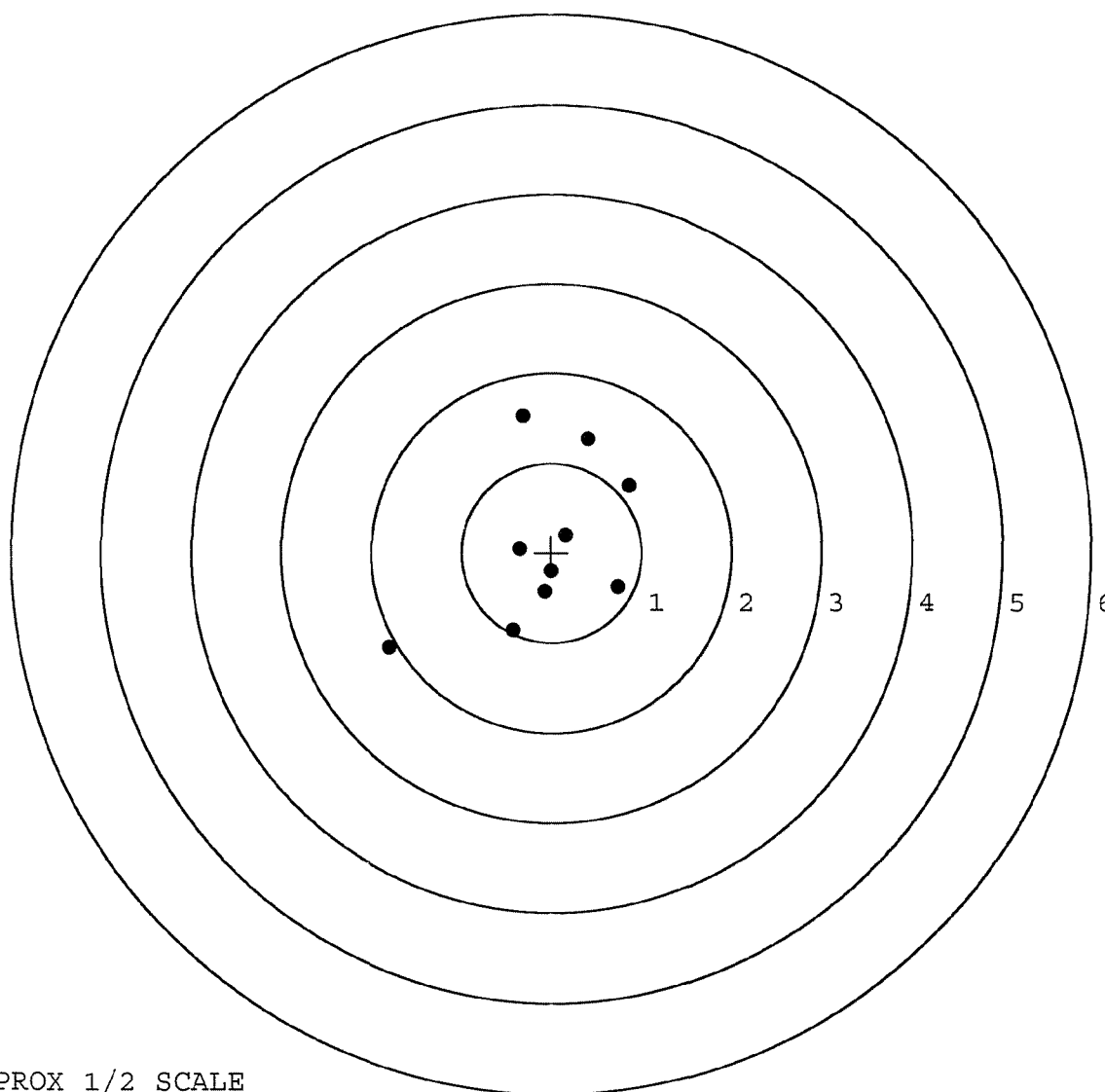
X CENTROID: -0.057
 Y CENTROID: -0.640
 POA TO CENTROID: 0.643
 HORZ SPREAD: 2.233
 VERT SPREAD: 2.943
 GROUP SPREAD: 3.013
 MIN RADIUS: 0.477
 MAX RADIUS: 1.825
 MEAN RADIUS: 1.145
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0152222

SERIAL NUMBER: G6414424. __1	POINT#	X	Y
TARGET NUMBER: 2	1:	-0.431	-0.871
FILE DATE: 10/10/2005	2:	0.737	-0.385
FILE TIME: 11:00	3:	0.855	0.753
	4:	0.401	1.267
X CENTROID: -0.086	5:	-0.325	1.526
Y CENTROID: 0.082	6:	0.151	0.199
POA TO CENTROID: 0.119	7:	-0.354	0.046
HORZ SPREAD: 2.660	8:	-0.011	-0.213
VERT SPREAD: 2.590	9:	-0.075	-0.437
GROUP SPREAD: 3.221	10:	-1.805	-1.064
MIN RADIUS: 0.264			
MAX RADIUS: 2.066			
MEAN RADIUS: 0.928			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 5			
# in 3 IN DIAMETER: 9			



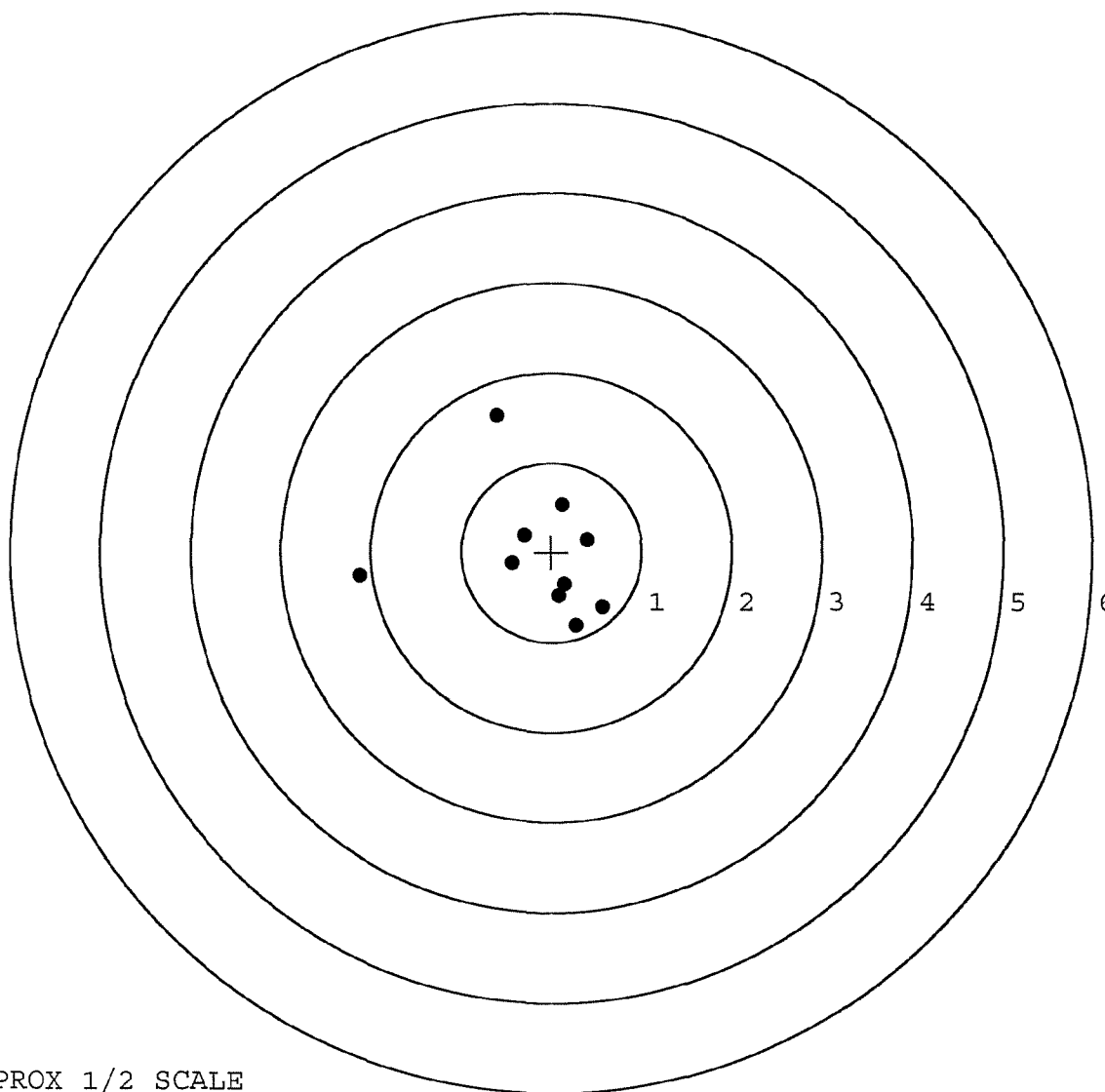
TARGET APPROX 1/2 SCALE

BARBER - M24 0152223

SERIAL NUMBER: G6414424. __1
 TARGET NUMBER: 3
 FILE DATE: 10/10/2005
 FILE TIME: 11:00

POINT#	X	Y
1:	0.561	-0.610
2:	0.272	-0.816
3:	0.084	-0.492
4:	0.142	-0.360
5:	0.393	0.135
6:	0.117	0.527
7:	-0.312	0.186
8:	-0.436	-0.130
9:	-2.123	-0.279
10:	-0.613	1.514

X CENTROID: -0.191
 Y CENTROID: -0.033
 POA TO CENTROID: 0.194
 HORZ SPREAD: 2.684
 VERT SPREAD: 2.330
 GROUP SPREAD: 2.704
 MIN RADIUS: 0.250
 MAX RADIUS: 1.947
 MEAN RADIUS: 0.817
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 8



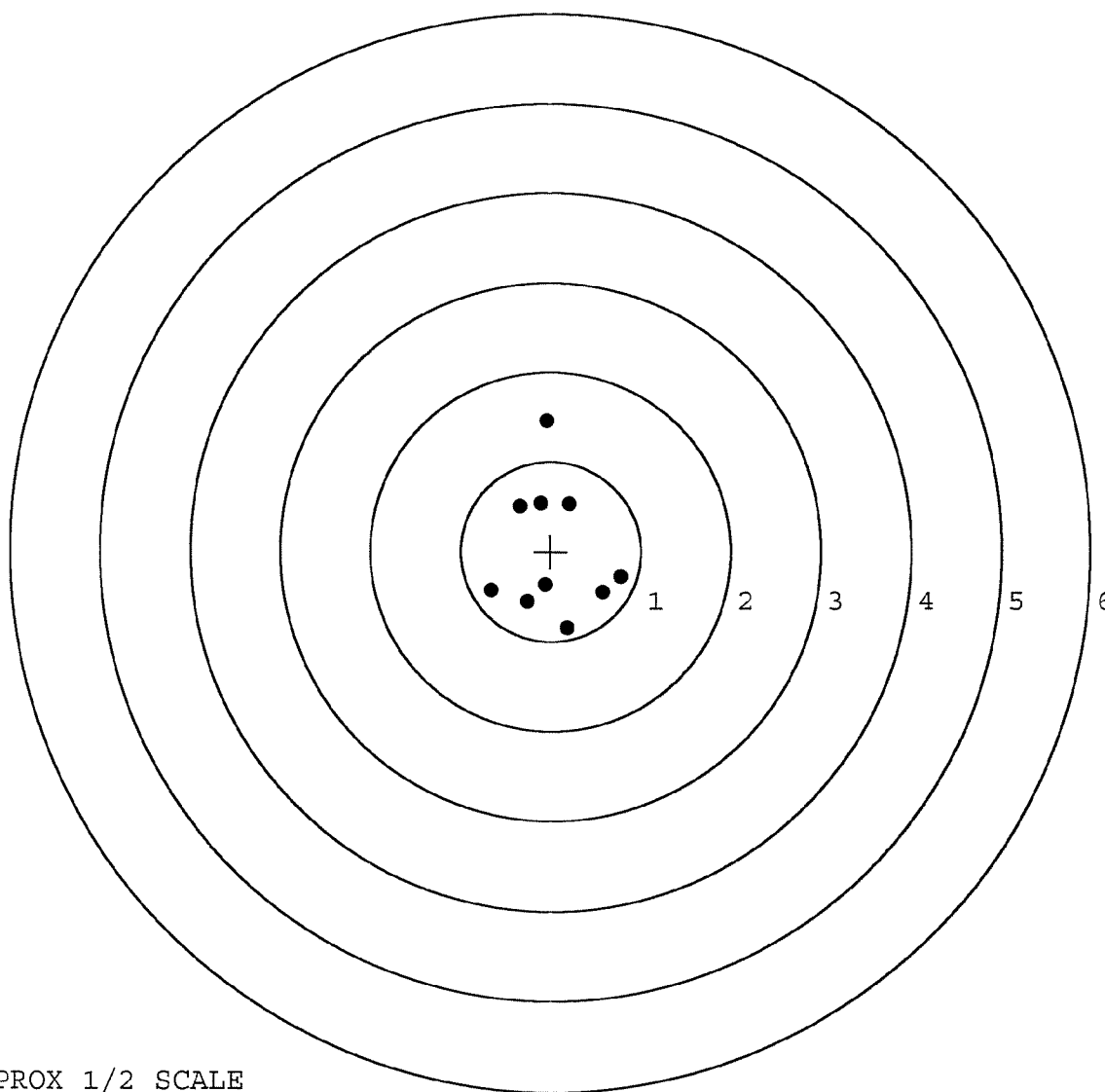
TARGET APPROX 1/2 SCALE

BARBER - M24 0152224

SERIAL NUMBER: G6414424. __1
 TARGET NUMBER: 4
 FILE DATE: 10/10/2005
 FILE TIME: 11:00

POINT#	X	Y
1:	0.776	-0.283
2:	0.580	-0.457
3:	0.184	-0.858
4:	-0.063	-0.378
5:	-0.265	-0.565
6:	-0.661	-0.435
7:	-0.341	0.501
8:	-0.109	0.539
9:	0.208	0.528
10:	-0.045	1.447

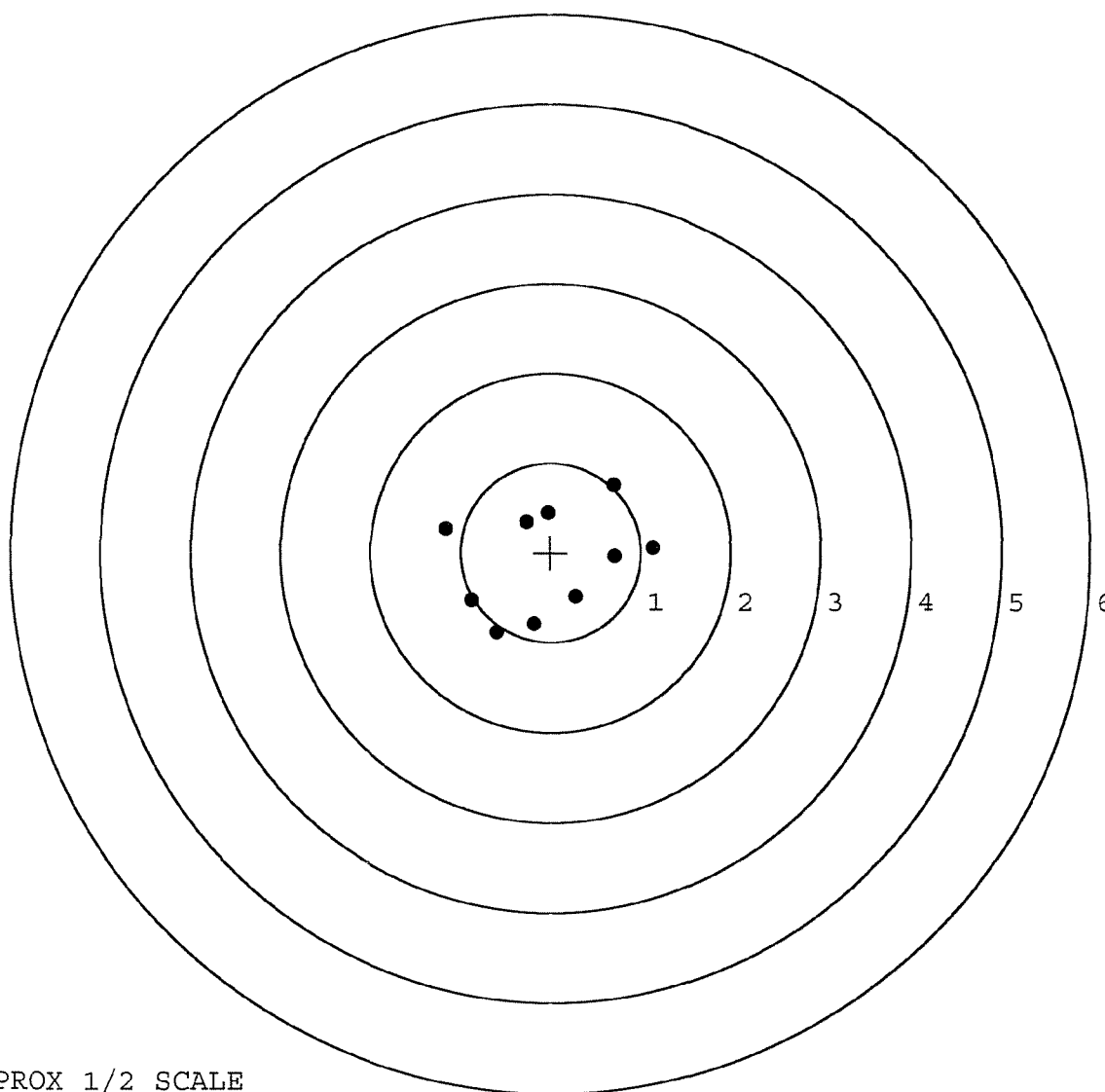
X CENTROID: 0.026
 Y CENTROID: 0.004
 POA TO CENTROID: 0.027
 HORZ SPREAD: 1.437
 VERT SPREAD: 2.305
 GROUP SPREAD: 2.316
 MIN RADIUS: 0.392
 MAX RADIUS: 1.445
 MEAN RADIUS: 0.742
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0152225

SERIAL NUMBER: G6414424. _1	POINT#	X	Y
TARGET NUMBER: 5	1:	1.136	0.059
FILE DATE: 10/10/2005	2:	0.709	-0.045
FILE TIME: 11:00	3:	0.705	0.759
	4:	-0.036	0.445
X CENTROID: -0.034	5:	-0.277	0.346
Y CENTROID: -0.091	6:	0.278	-0.498
POA TO CENTROID: 0.097	7:	-0.191	-0.804
HORZ SPREAD: 2.305	8:	-0.604	-0.896
VERT SPREAD: 1.655	9:	-0.886	-0.536
GROUP SPREAD: 2.314	10:	-1.169	0.261
MIN RADIUS: 0.500			
MAX RADIUS: 1.189			
MEAN RADIUS: 0.847			
# IN 1 IN DIAMETER: 0			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE