

G-644 159c

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

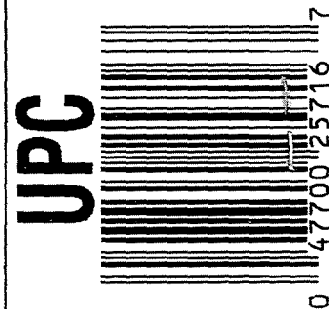
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461596



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 # G 6461596

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/1/05	CD
440	PROOF		11/1/05	CD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	11/1/05	CD
470	DIS-ASSEMBLE ACTION	JAN 5 2006	11/1/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <i>unab</i>	1/5/06	<i>unab</i>
500	ROLLMARK CALIBER		1/5/06	CW
510	DRILL AND TAP SIGHT HOLES		1-5-06	BR
520	GOFF BLAST BBL / REC		1-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1/6/06	<i>HR</i>
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-9-06	BG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-9-06	BG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-9-06	RG
	D) OIL FIRING PIN ASSEMBLY		1-9-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1-12-06	AC

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.2</u> <u>5.2</u>	1-27-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7.5</u> <u>2.2</u> <u>2.2</u>	1-27-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			A
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.021</u> <u>.021</u>	2-14-06	AC
	J) ASSEMBLE STOCK		1-9-06	RT
	K) ASSEMBLE SWIVEL STUDS		2/14/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-9-06	BC-
	M) IRON SIGHT ALIGNMENT		1-9-06	BC-
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-9-06	BC-
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1/11/06	MJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-11-06	MJM
670	FINAL INSPECTION A) HEADSPACE		2-14-06	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.33</u> <u>2.40</u> <u>2.61</u> <u>2.51</u> <u>2.38</u>	1-12-06	A
	C) FUNCTION		2-14-06	A
690	PACK		3-29-06	DA

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 1-7-06TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.58	2.24		2.64	
PULL #2	2.32	2.29		2.41	
PULL #3	2.37	2.28		2.51	
PULL #4	2.46	2.45		2.21	
PULL #5	2.25	2.40		2.64	
TOTAL	11.98	11.66		12.41	
AVERAGE	2.39	2.33		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.17		
PULL #2	3.13	3.08		
PULL #3	2.85	3.21		
PULL #4	3.13	3.01		
PULL #5	3.16	3.11		
TOTAL	15.35	15.58		
AVERAGE	3.07	3.11		

	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	4.13	4.22		4.02
PULL #2	4.16	4.27		4.27
PULL #3	3.85	4.27		4.06
PULL #4	3.75	4.27		4.24
PULL #5	4.28	4.20		4.17
TOTAL	20.17	21.23		20.76
AVERAGE	4.03	4.24		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461596.___0
FILE DATE AND TIME: 01/11/2006 22:46

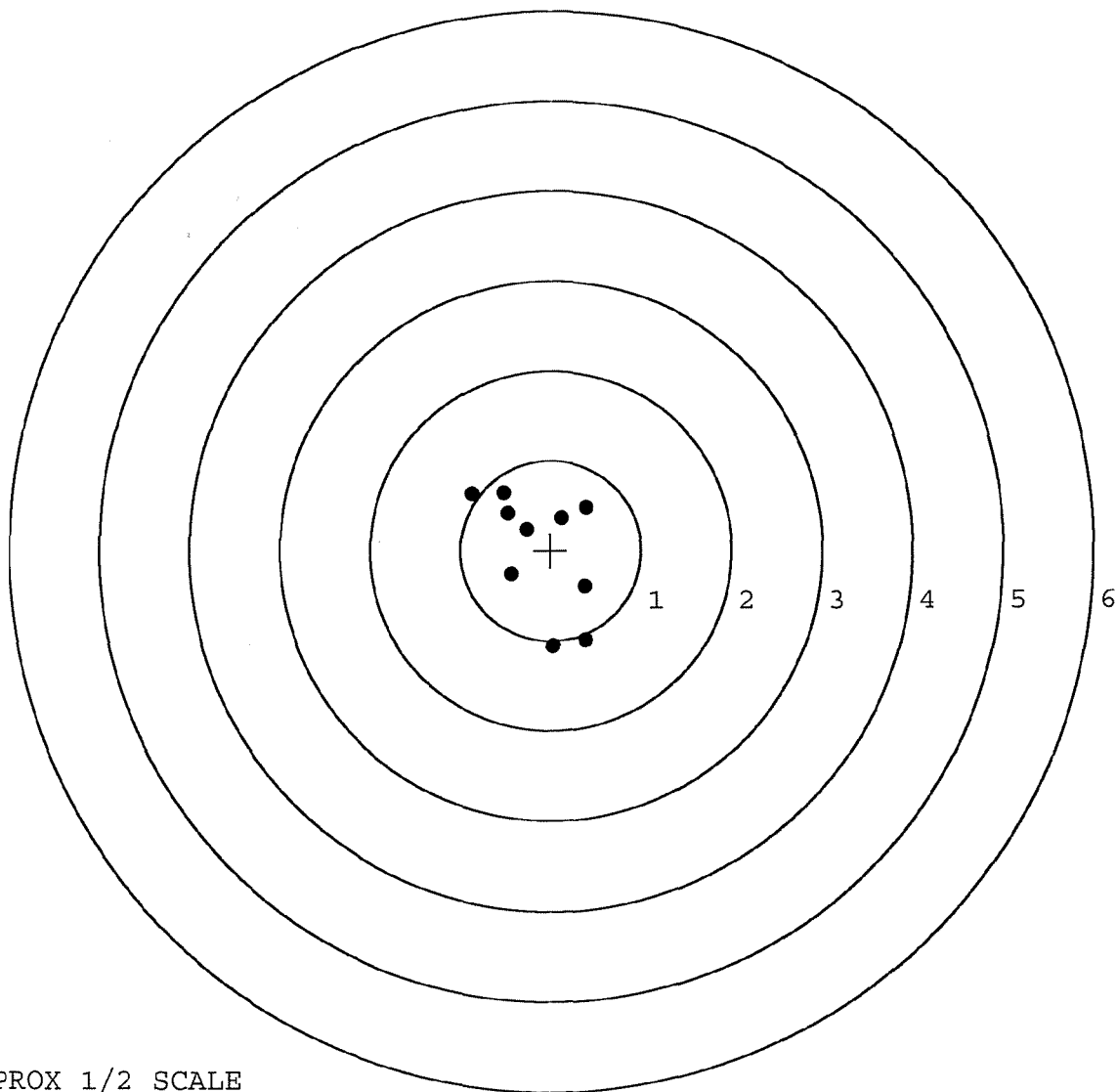
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.025
The Average Y Centroid of the Five Target Set:	0.043
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.567
The Distance from POA to Centroid Target #1:	0.127
The Distance from Centroid Target #2 to Centroid Target #1:	0.071
The Distance from Centroid Target #3 to Centroid Target #1:	0.110
The Distance from Centroid Target #4 to Centroid Target #1:	0.157
The Distance from Centroid Target #5 to Centroid Target #1:	0.216

SERIAL NUMBER: G6461596. 0
 TARGET NUMBER: 1
 FILE DATE: 01/11/2006
 FILE TIME: 22:46

POINT#	X	Y
1:	0.027	-1.064
2:	0.387	-0.994
3:	-0.435	-0.261
4:	0.384	-0.398
5:	-0.879	0.630
6:	-0.525	0.640
7:	-0.474	0.413
8:	-0.270	0.227
9:	0.124	0.358
10:	0.395	0.477

X CENTROID: -0.127
 Y CENTROID: 0.003
 POA TO CENTROID: 0.127
 HORZ SPREAD: 1.274
 VERT SPREAD: 1.704
 GROUP SPREAD: 2.059
 MIN RADIUS: 0.266
 MAX RADIUS: 1.121
 MEAN RADIUS: 0.693
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0153479

SERIAL NUMBER: G6461596. __0

TARGET NUMBER: 2

FILE DATE: 01/11/2006

FILE TIME: 22:46

POINT#	X	Y
1:	0.398	0.465
2:	0.175	0.405
3:	0.341	0.274
4:	0.251	0.032
5:	-0.041	0.201
6:	-0.150	-0.212
7:	-0.085	-0.453
8:	-0.342	-0.220
9:	-0.504	-0.210
10:	-0.606	-0.168

X CENTROID: -0.056

Y CENTROID: 0.011

POA TO CENTROID: 0.057

HORZ SPREAD: 1.004

VERT SPREAD: 0.918

GROUP SPREAD: 1.187

MIN RADIUS: 0.190

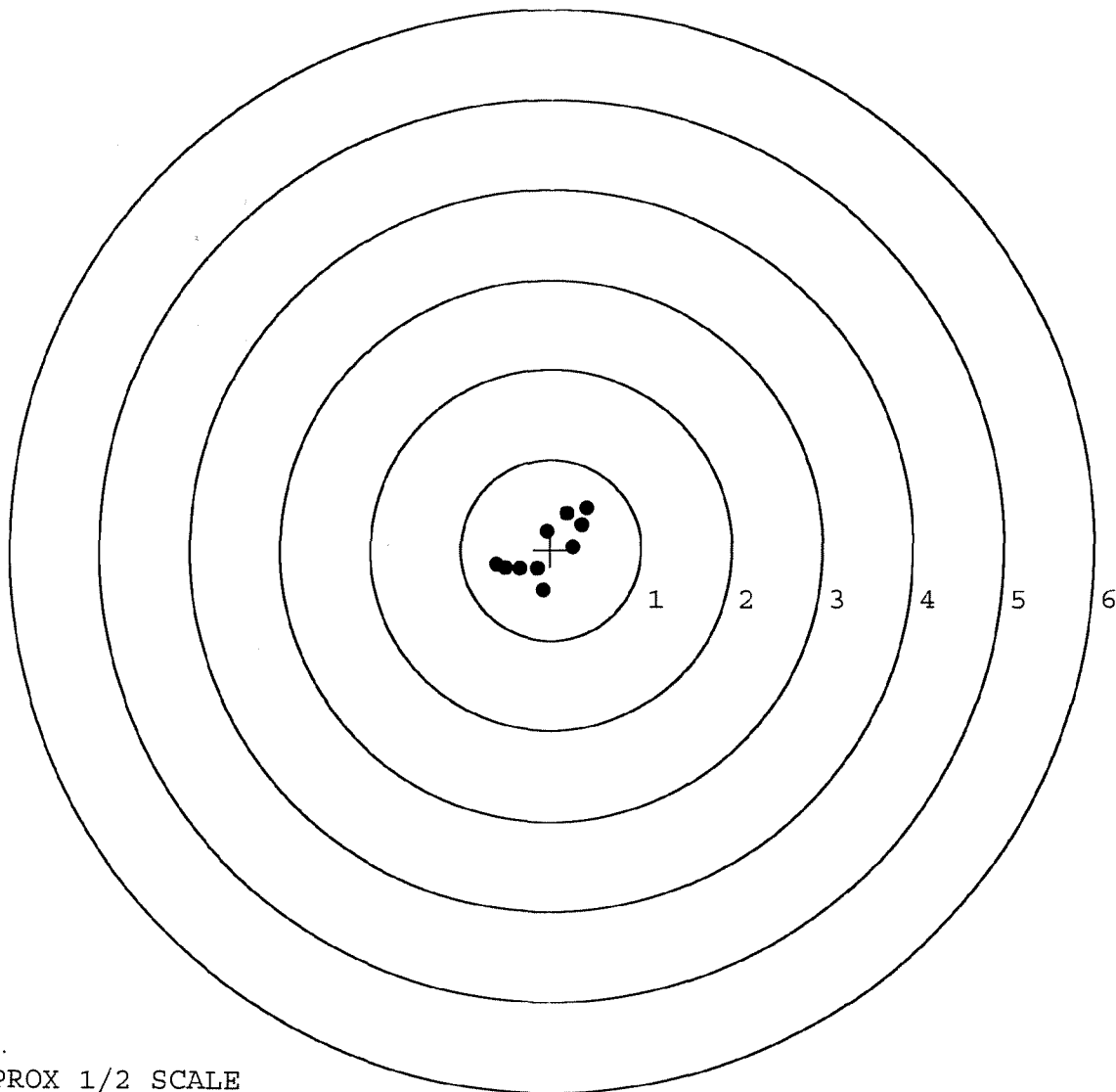
MAX RADIUS: 0.642

MEAN RADIUS: 0.423

IN 1 IN DIAMETER: 8

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0153480

SERIAL NUMBER: G6461596. __0

TARGET NUMBER: 3

FILE DATE: 01/11/2006

FILE TIME: 22:46

POINT#	X	Y
1:	0.248	0.897
2:	-0.590	-0.632
3:	-0.459	-0.412
4:	0.284	-1.108
5:	-0.304	0.549
6:	-0.228	0.216
7:	-0.044	0.556
8:	0.140	0.125
9:	0.291	0.403
10:	0.388	-0.096

X CENTROID: -0.027

Y CENTROID: 0.050

POA TO CENTROID: 0.057

HORZ SPREAD: 0.978

VERT SPREAD: 2.005

GROUP SPREAD: 2.005

MIN RADIUS: 0.184

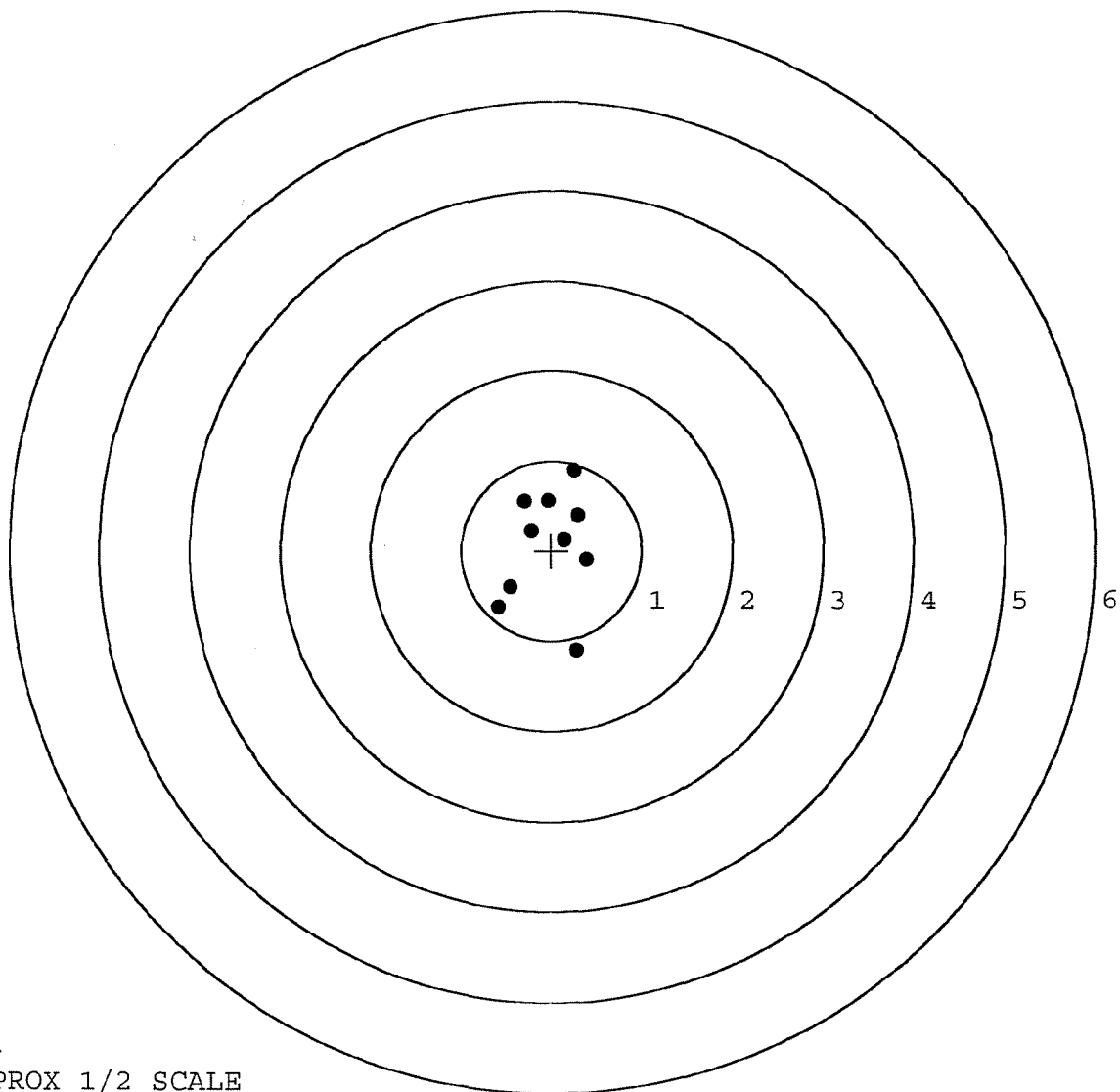
MAX RADIUS: 1.199

MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

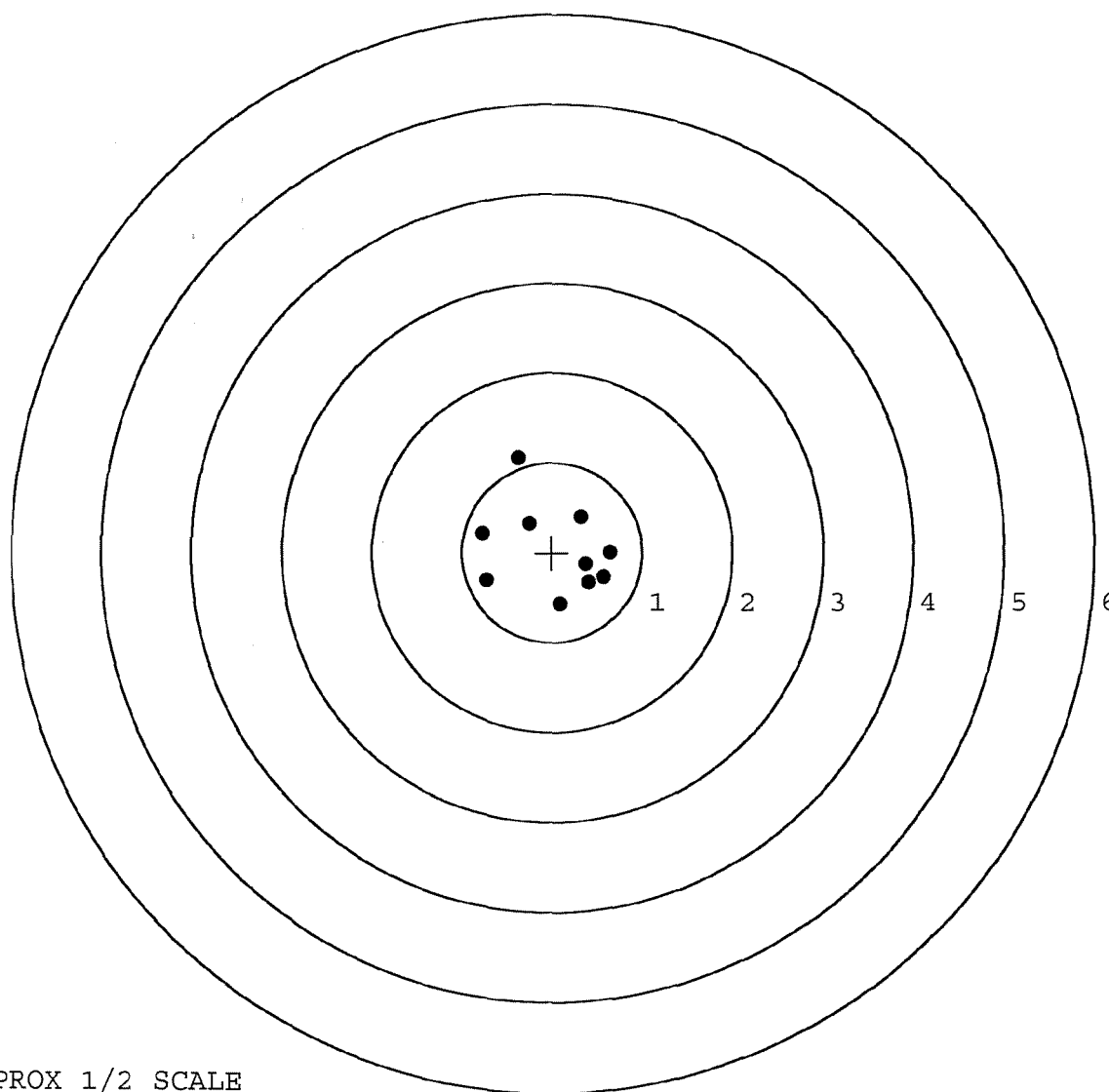
BARBER - M24 0153481

SERIAL NUMBER: G6461596. __0
 TARGET NUMBER: 4
 FILE DATE: 01/11/2006
 FILE TIME: 22:46

POINT#	X	Y
1:	-0.730	-0.312
2:	-0.780	0.212
3:	-0.255	0.326
4:	-0.383	1.053
5:	0.322	0.395
6:	0.647	0.001
7:	0.375	-0.131
8:	0.577	-0.280
9:	0.407	-0.340
10:	0.092	-0.576

X CENTROID: 0.027
 Y CENTROID: 0.035
 POA TO CENTROID: 0.044
 HORZ SPREAD: 1.427
 VERT SPREAD: 1.629
 GROUP SPREAD: 1.697
 MIN RADIUS: 0.385
 MAX RADIUS: 1.098
 MEAN RADIUS: 0.642

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



TARGET APPROX 1/2 SCALE

BARBER - M24 0153482

SERIAL NUMBER: G6461596. __0

TARGET NUMBER: 5

FILE DATE: 01/11/2006

FILE TIME: 22:46

POINT#	X	Y
1:	0.455	0.986
2:	-0.740	0.290
3:	-0.118	0.328
4:	-0.165	-0.304
5:	0.412	-0.490
6:	0.305	-0.326
7:	0.280	-0.085
8:	0.295	0.276
9:	-0.131	0.383
10:	-0.020	0.100

X CENTROID: 0.057

Y CENTROID: 0.116

POA TO CENTROID: 0.129

HORZ SPREAD: 1.195

VERT SPREAD: 1.476

GROUP SPREAD: 1.477

MIN RADIUS: 0.079

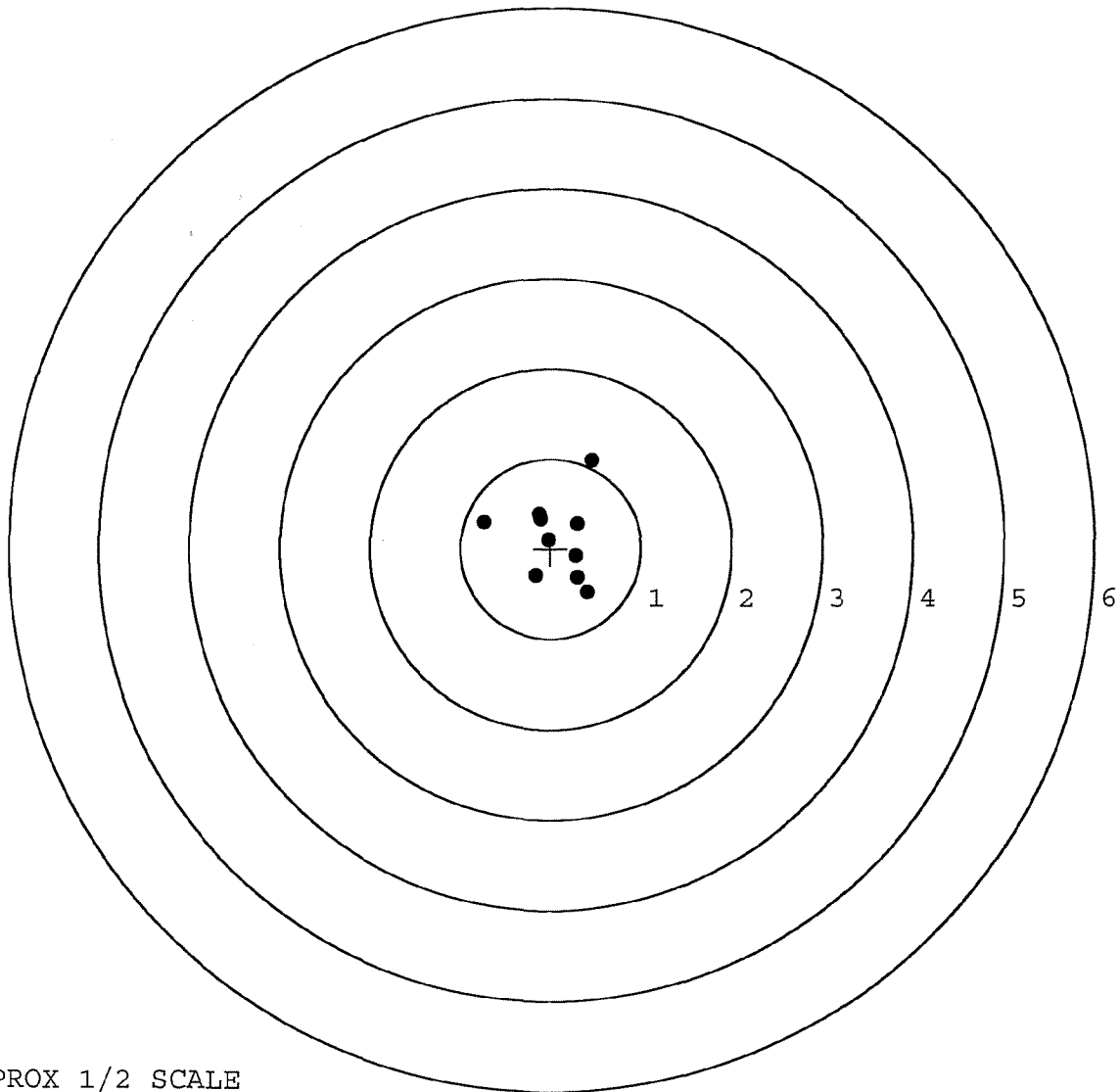
MAX RADIUS: 0.957

MEAN RADIUS: 0.472

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE