

G646 1625

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

- INSTRUCTION BOOK 3518

DD FORM

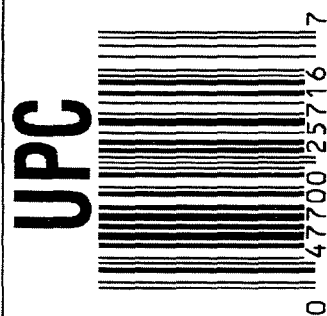


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461625



ORDER 25716

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

UPC



0 47700 25716 7

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UPC



0 47700 25716 7

SERIAL NO.



66461625

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6461625

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/20/05	CD
440	PROOF		10/20/05	CD
460	CHECK HEADSPACE		10/20/05	CD
470	DIS-ASSEMBLE ACTION		10/20/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	6480	10/26/05	unint
500	ROLLMARK CALIBER		10/20/05	CW
510	DRILL AND TAP SIGHT HOLES		10/26/05	BR
520	GOFF BLAST BBL / REC		10-28-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		11/3/05	RB
	(BOLT)		11/3/05	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		11/4/05	mm
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/4/05	mm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/4/05	mm
	D) OIL FIRING PIN ASSEMBLY		12-16-05	BG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-16-05	BG

REV-8405

OP # OPERATION NAME			READINGS			DATE	INITIAL	
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.5	5.5	5.0	12-16-05	TRW	
CONT.								
	G) SAFETY OFF FORCE	2 LBS MIN	2.5	2.25	2.25	12-16-05	TRW	
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT	.020 MIN	.024	.0245	.023	12-16-05	TRW	
	J) ASSEMBLE STOCK					11-22-05	BG	
	K) ASSEMBLE SWIVEL STUDS					12-16-05	BG	
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					11-22-05	BG	
	M) IRON SIGHT ALIGNMENT					11-22-05	BG	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					11-22-05	BG	
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		12-8-05	TRW	
			PASS	FAIL				
	MALFUNCTION		CORRECTION					
	MALFUNCTION		CORRECTION					
	MALFUNCTION		CORRECTION					
	MALFUNCTION		CORRECTION					
660	INSPECT FOR LIVE AMMO					12-7-05	R.P.	
670	FINAL INSPECTION A) HEADSPACE					12-16-05	BG	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.60	2.27	2.49	2.44	2.43	12/12/05 R.P.
	C) FUNCTION					12-16-05	BG	
690	PACK					1-6-06	R.P.	

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 9-27-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.64	2.75		2.80	
PULL #2	2.85	2.97		2.63	
PULL #3	2.82	2.85		2.41	
PULL #4	2.82	2.90		2.37	
PULL #5	2.78	2.82		2.33	
TOTAL	13.91	14.29		12.54	
AVERAGE	2.78	2.85		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.58		
PULL #2	3.27	3.62		
PULL #3	3.41	3.62		
PULL #4	3.49	3.64		
PULL #5	3.47	3.63		
TOTAL	17.0	18.1		
AVERAGE	3.40	3.62		

	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	4.66	4.58		4.38
PULL #2	4.57	4.58		4.21
PULL #3	4.62	4.62		4.30
PULL #4	4.56	4.64		4.33
PULL #5	4.39	4.37		4.30
TOTAL	22.8	22.7		21.5
AVERAGE	4.56	4.55		4.30

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461625.___0
FILE DATE AND TIME: 12/07/2005 14:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.057
The Average Y Centroid of the Five Target Set:	-0.077
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.727
The Distance from POA to Centroid Target #1:	0.077
The Distance from Centroid Target #2 to Centroid Target #1:	0.107
The Distance from Centroid Target #3 to Centroid Target #1:	0.089
The Distance from Centroid Target #4 to Centroid Target #1:	0.030
The Distance from Centroid Target #5 to Centroid Target #1:	0.182

BARBER - M24 0153928

SERIAL NUMBER: G6461625. __ 0

TARGET NUMBER: 1

FILE DATE: 12/07/2005

FILE TIME: 14:25

POINT#	X	Y
1:	0.067	0.711
2:	0.439	0.400
3:	-0.375	0.002
4:	-1.015	0.601
5:	-1.445	-0.357
6:	0.878	-0.164
7:	0.584	-0.062
8:	0.421	-0.287
9:	0.088	-0.568
10:	-0.094	-0.904

X CENTROID: -0.045

Y CENTROID: -0.063

POA TO CENTROID: 0.077

HORZ SPREAD: 2.323

VERT SPREAD: 1.615

GROUP SPREAD: 2.331

MIN RADIUS: 0.336

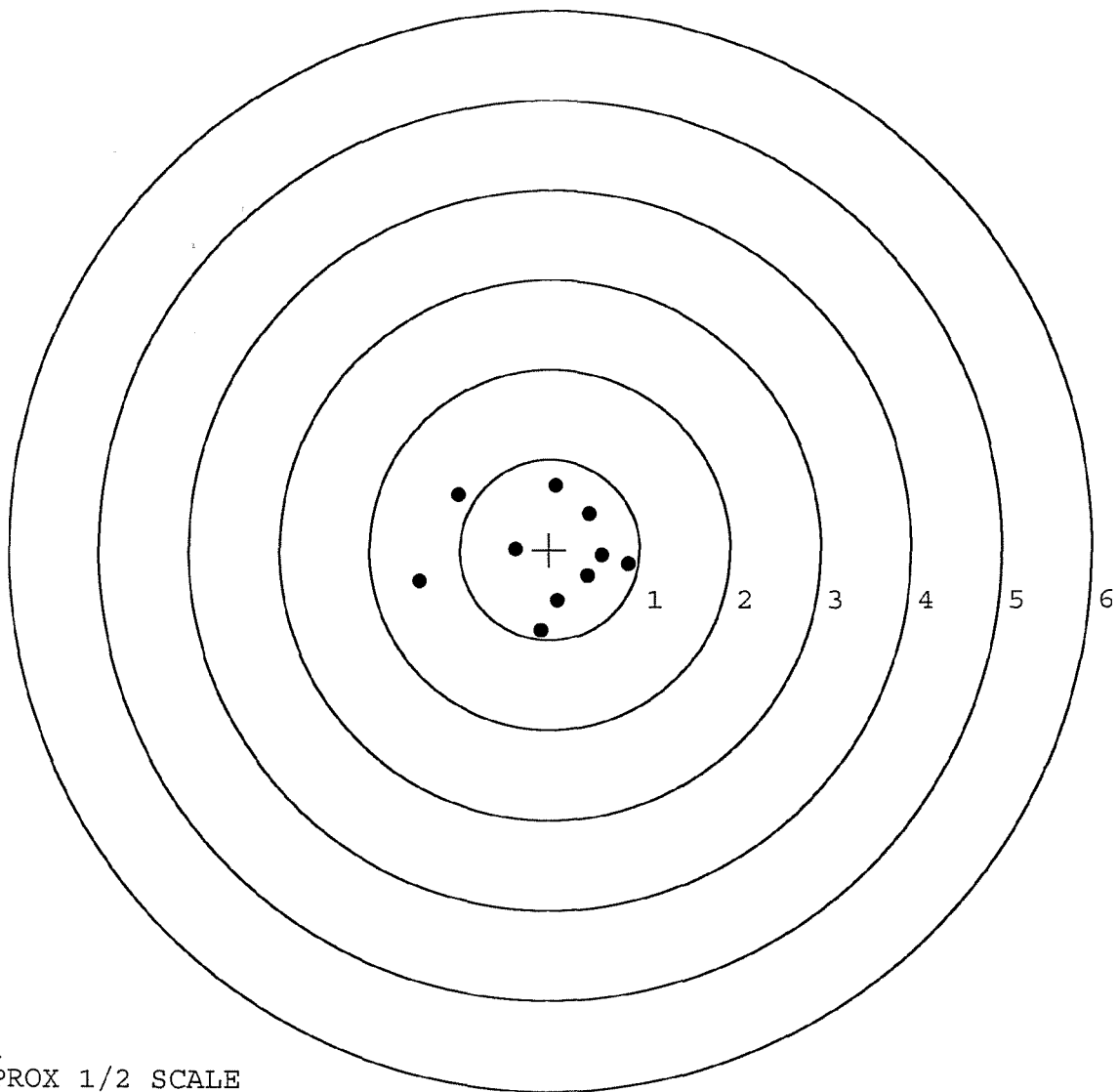
MAX RADIUS: 1.430

MEAN RADIUS: 0.783

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0153929

SERIAL NUMBER: G6461625. __ 0

TARGET NUMBER: 2

FILE DATE: 12/07/2005

FILE TIME: 14:25

POINT#	X	Y
1:	0.638	-0.864
2:	0.537	0.098
3:	0.390	0.466
4:	-0.043	0.664
5:	-0.261	0.546
6:	-0.104	-0.139
7:	-0.283	-0.239
8:	-0.540	-0.286
9:	-0.687	-0.595
10:	-1.167	-0.160

X CENTROID: -0.152

Y CENTROID: -0.051

POA TO CENTROID: 0.160

HORZ SPREAD: 1.805

VERT SPREAD: 1.528

GROUP SPREAD: 1.937

MIN RADIUS: 0.100

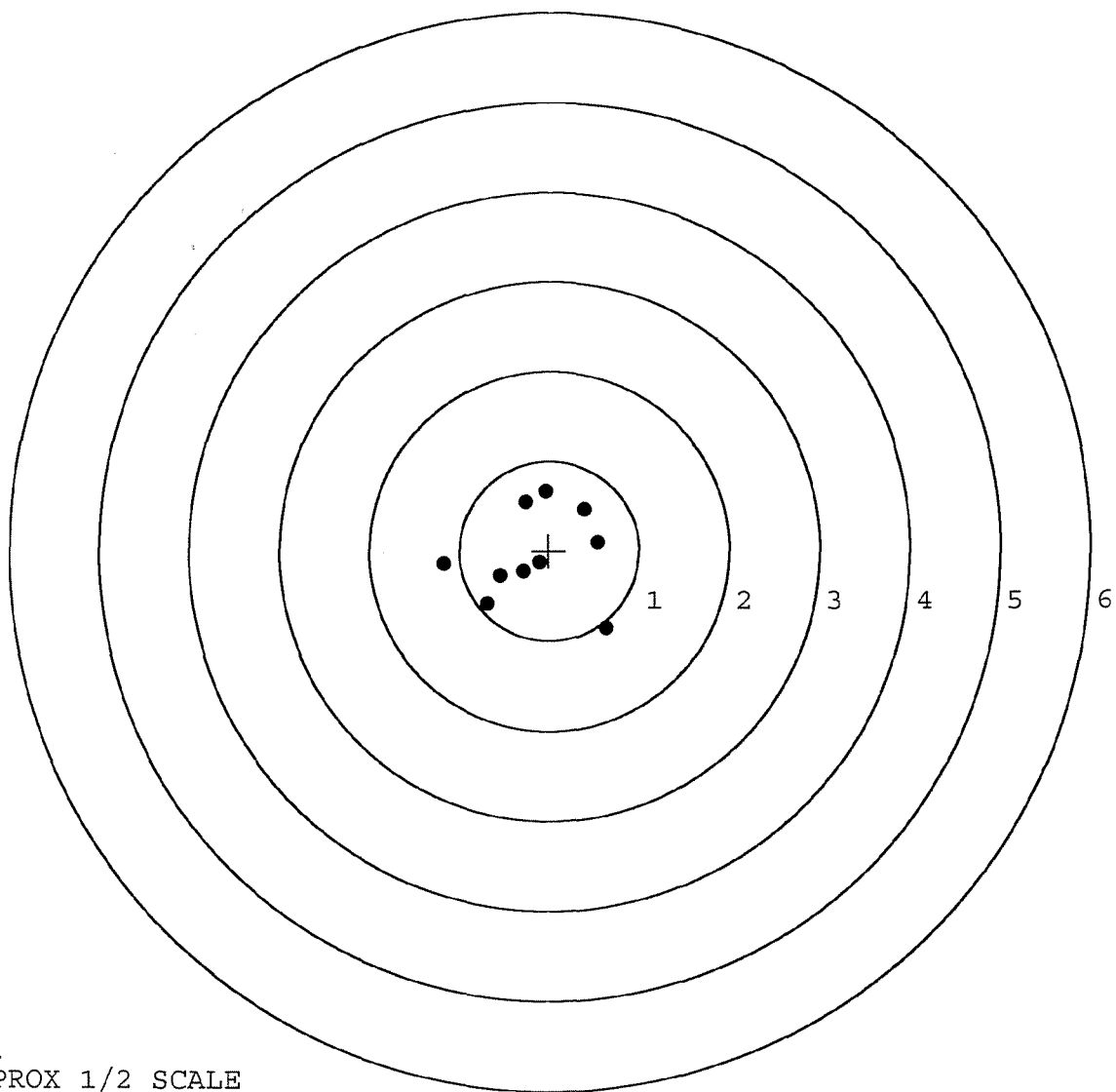
MAX RADIUS: 1.134

MEAN RADIUS: 0.648

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0153930

SERIAL NUMBER: G6461625. __ 0

TARGET NUMBER: 3

FILE DATE: 12/07/2005

FILE TIME: 14:25

POINT#	X	Y
1:	0.699	0.747
2:	-0.122	0.519
3:	-0.435	0.771
4:	0.461	0.038
5:	0.114	-0.902
6:	0.066	-0.440
7:	-0.599	-0.430
8:	-0.363	-0.046
9:	-0.097	0.068
10:	0.072	-0.095

X CENTROID: -0.020

Y CENTROID: 0.023

POA TO CENTROID: 0.031

HORZ SPREAD: 1.298

VERT SPREAD: 1.673

GROUP SPREAD: 1.752

MIN RADIUS: 0.089

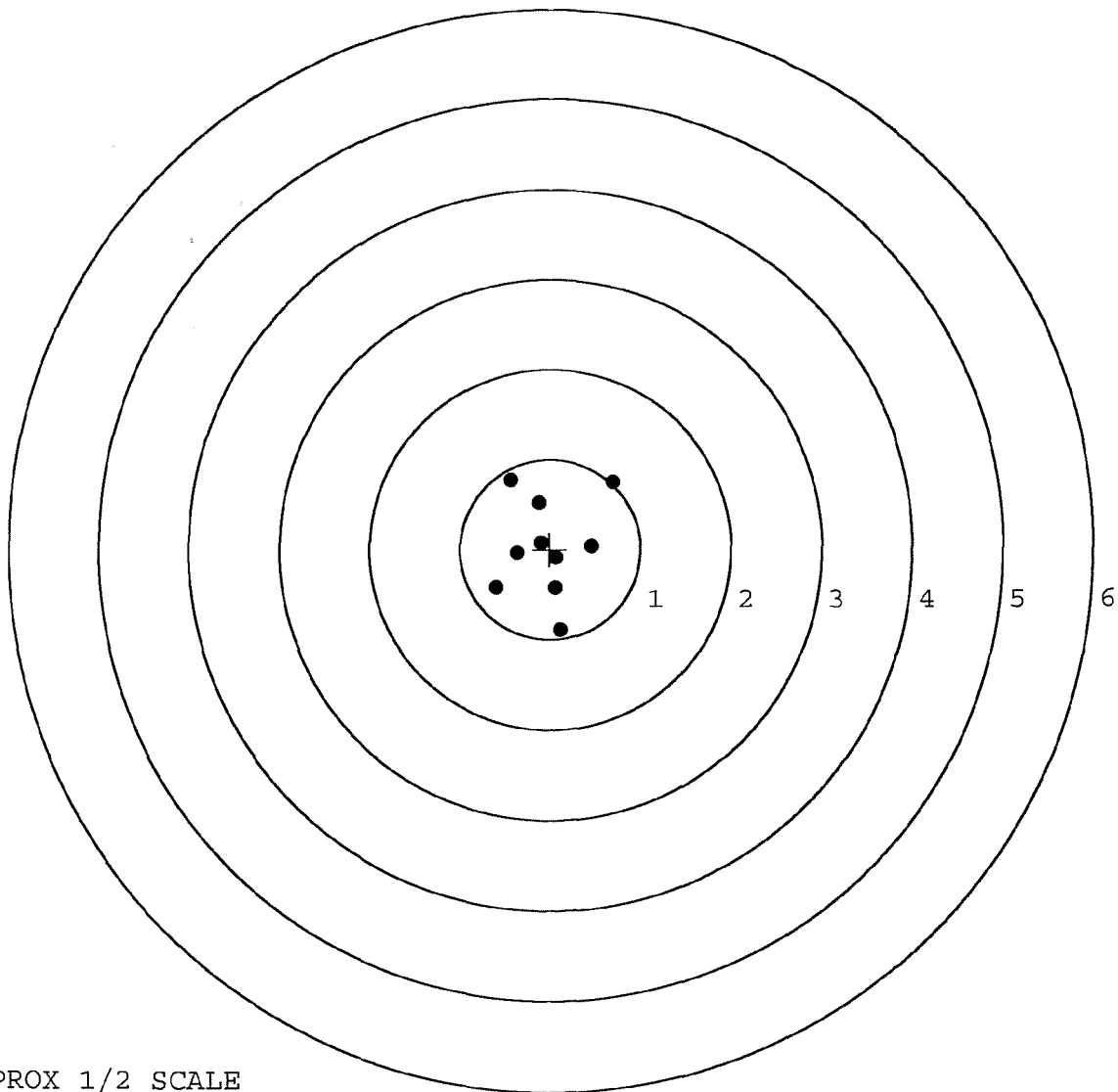
MAX RADIUS: 1.021

MEAN RADIUS: 0.559

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0153931

SERIAL NUMBER: G6461625. __ 0

TARGET NUMBER: 4

FILE DATE: 12/07/2005

FILE TIME: 14:25

POINT#	X	Y
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1:	1.617	-0.130
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2:	0.768	0.612
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3:	0.490	-0.096
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4:	0.334	-0.165
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5:	0.044	0.018
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6:	0.044	0.372
----	-------	-------

7:	-0.197	-0.496
----	--------	--------

8:	-1.004	-0.093
----	--------	--------

9:	-1.033	0.226
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10:	-1.244	-0.741
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X CENTROID: -0.018

Y CENTROID: -0.049

POA TO CENTROID: 0.053

HORZ SPREAD: 2.861

VERT SPREAD: 1.353

GROUP SPREAD: 2.926

MIN RADIUS: 0.092

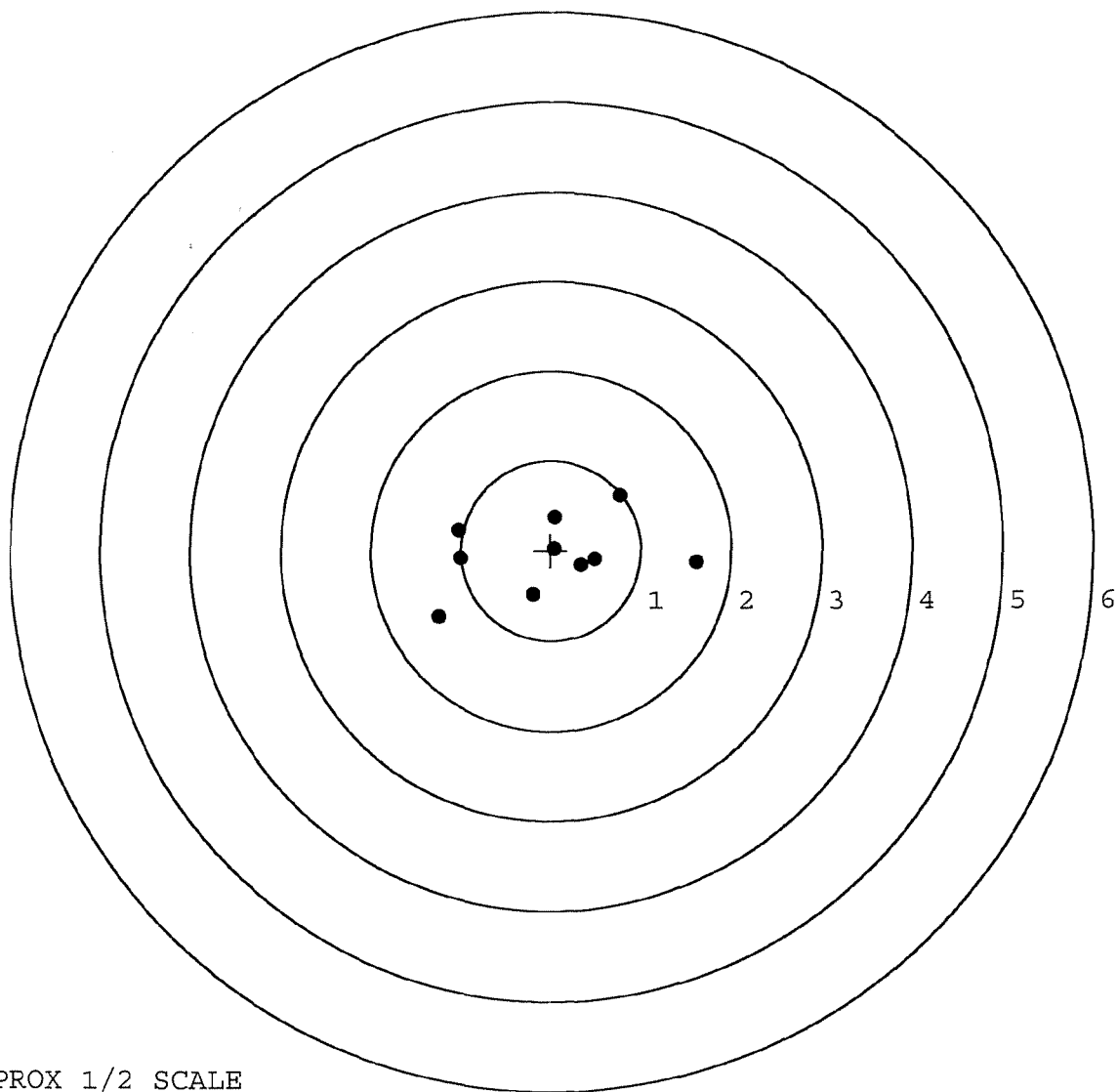
MAX RADIUS: 1.637

MEAN RADIUS: 0.799

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0153932

SERIAL NUMBER: G6461625. __ 0

TARGET NUMBER: 5

FILE DATE: 12/07/2005

FILE TIME: 14:25

POINT#	X	Y
1:	0.030	-1.906
2:	-0.403	-1.402
3:	0.314	-1.016
4:	0.517	0.580
5:	-0.190	1.766
6:	0.243	-0.298
7:	0.057	0.038
8:	-0.151	-0.093
9:	-0.356	-0.185
10:	-0.557	0.067

X CENTROID: -0.050

Y CENTROID: -0.245

POA TO CENTROID: 0.250

HORZ SPREAD: 1.074

VERT SPREAD: 3.672

GROUP SPREAD: 3.679

MIN RADIUS: 0.183

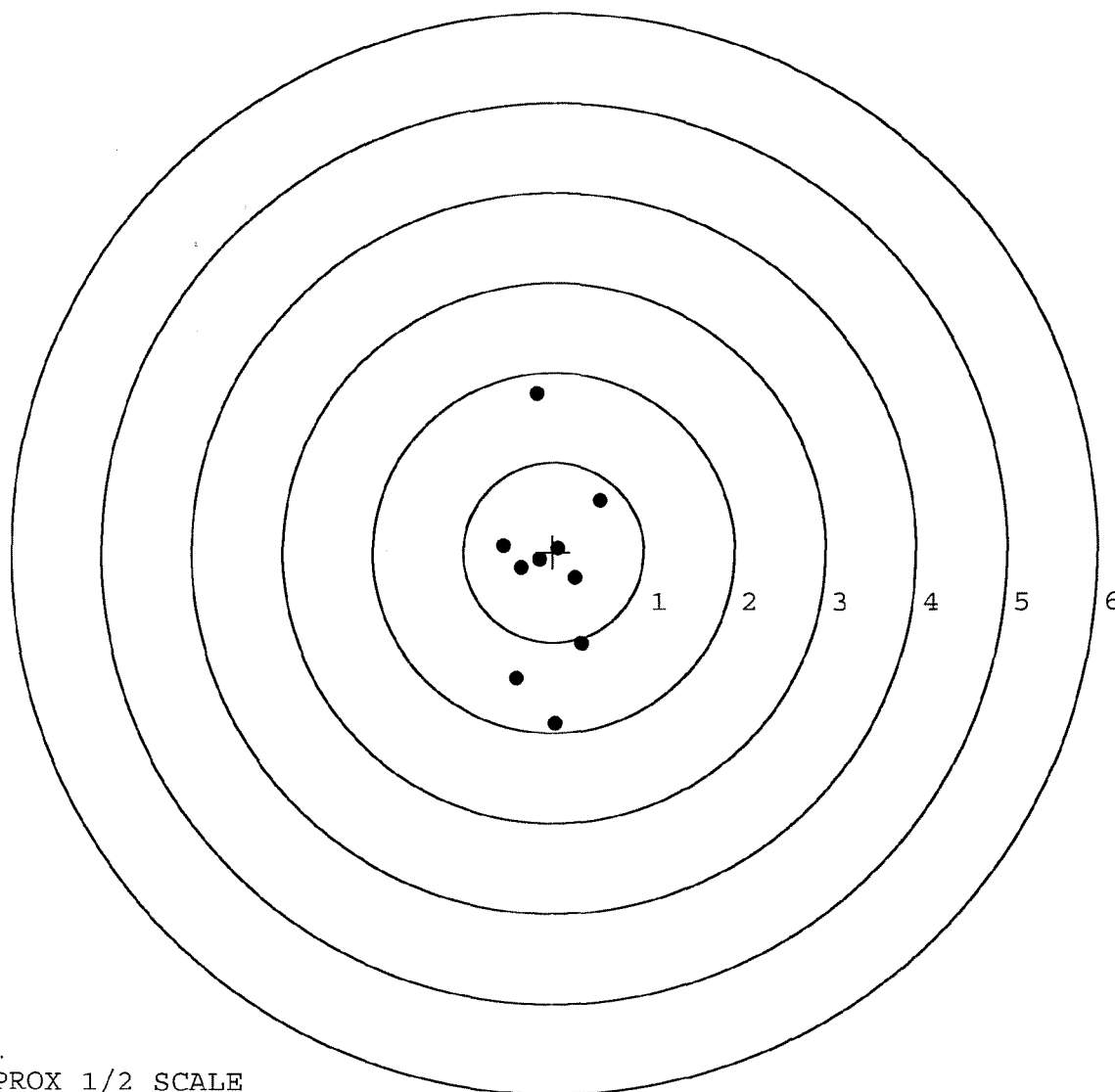
MAX RADIUS: 2.016

MEAN RADIUS: 0.843

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE