

G-644 1785

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



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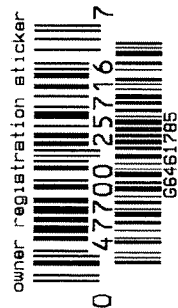
SERIAL NO.



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

G6461785



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461285

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	CD
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	WTH
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	WTH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	WTH
	D) OIL FIRING PIN ASSEMBLY		10-10-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6/6</u> <u>6/6</u> <u>6/6</u>	10-18-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3/6</u> <u>3/6</u> <u>3/6</u>	10-18-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-18-05	R
	J) ASSEMBLE STOCK		10-10-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-18-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-13-05	AC
	M) IRON SIGHT ALIGNMENT		10-13-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-13-05	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	10-17-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-17-05	ST
670	FINAL INSPECTION A) HEADSPACE		10-18-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>243</u> <u>219</u> <u>253</u> <u>260</u> <u>230</u>	10-17-05	TRW
	C) FUNCTION		10-18-05	BC
690	PACK		10/28/05	DAH

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 10-5-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.38	2.34		2.39 R.P.	
PULL #2	2.39	2.24		2.41	
PULL #3	2.50	2.42		2.18	
PULL #4	2.52	2.41		2.37	
PULL #5	2.57	2.30		2.34	
TOTAL	12.36	11.71		11.69	
AVERAGE	2.47	2.34		2.33	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.29		
PULL #2	3.32	3.01		
PULL #3	3.32	3.27		
PULL #4	3.31	3.21		
PULL #5	3.12	3.13		
TOTAL	16.13	15.91		
AVERAGE	3.22	3.18		

	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	4.02	4.36		4.19
PULL #2	4.24	4.38		4.26
PULL #3	4.07	4.43		4.42
PULL #4	4.17	4.07		4.28
PULL #5	4.08	4.44		4.36
TOTAL	20.68	21.68		21.51
AVERAGE	4.13	4.33		4.30

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461785.___0
FILE DATE AND TIME: 10/17/2005 09:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.031
The Average Y Centroid of the Five Target Set:	-0.134
The Average Point of Impact of the Five Target Set:	0.138
The Average Mean Radius of the Five Target Set:	0.874
The Distance from POA to Centroid Target #1:	0.623
The Distance from Centroid Target #2 to Centroid Target #1:	0.635
The Distance from Centroid Target #3 to Centroid Target #1:	0.597
The Distance from Centroid Target #4 to Centroid Target #1:	0.770
The Distance from Centroid Target #5 to Centroid Target #1:	0.557

SERIAL NUMBER: G6461785. 0

TARGET NUMBER: 1

FILE DATE: 10/17/2005

FILE TIME: 09:59

X CENTROID: -0.159

Y CENTROID: -0.603

POA TO CENTROID: 0.623

HORZ SPREAD: 1.764

VERT SPREAD: 4.590

GROUP SPREAD: 4.599

MIN RADIUS: 0.043

MAX RADIUS: 2.815

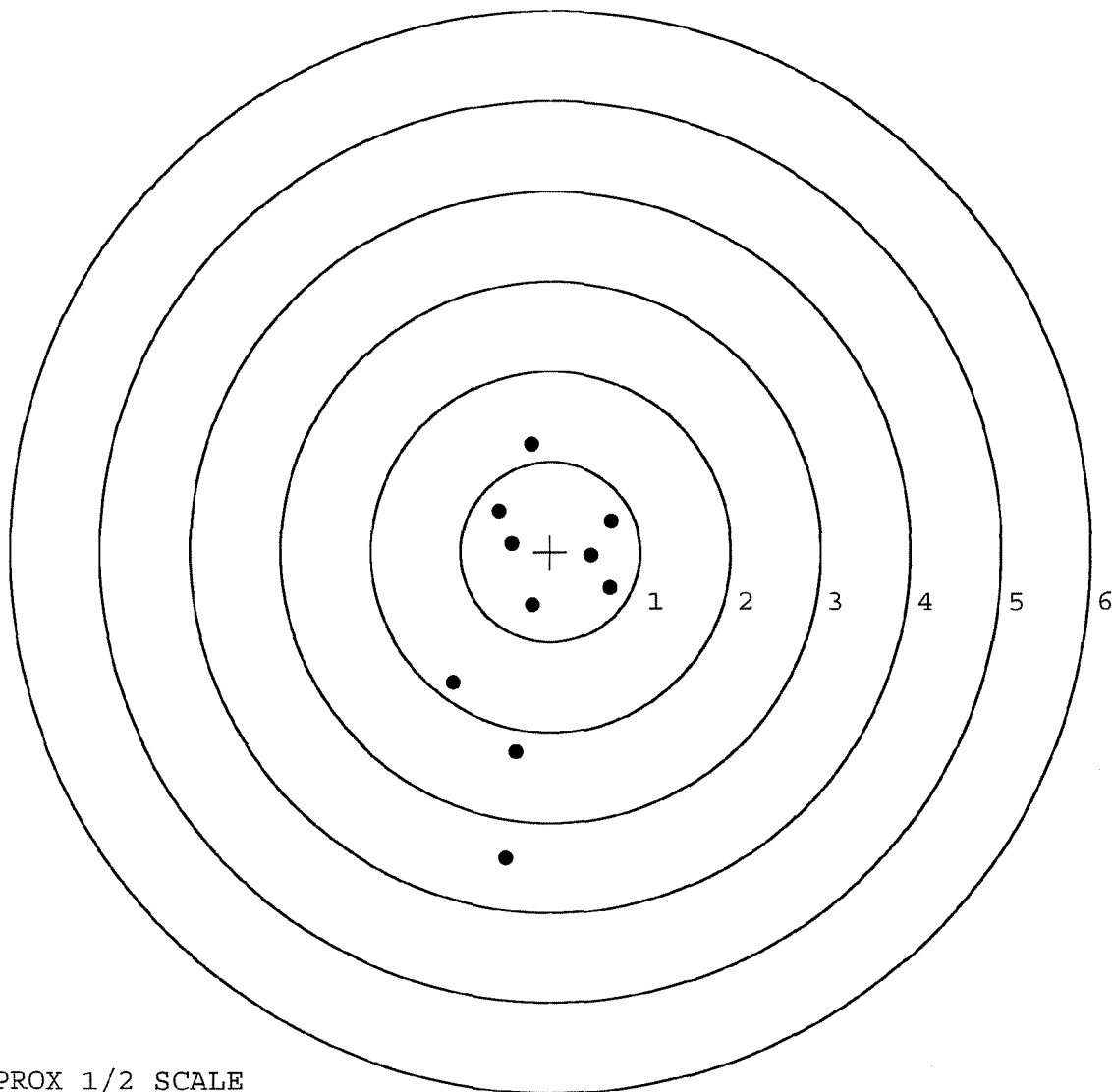
MEAN RADIUS: 1.239

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.666	-0.404
2:	0.454	-0.036
3:	0.678	0.345
4:	-0.213	1.192
5:	-0.580	0.459
6:	-0.429	0.096
7:	-0.202	-0.596
8:	-1.086	-1.465
9:	-0.384	-2.221
10:	-0.495	-3.398



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461785. 0

TARGET NUMBER: 2

FILE DATE: 10/17/2005

FILE TIME: 09:59

X CENTROID: 0.089

Y CENTROID: -0.019

POA TO CENTROID: 0.091

HORZ SPREAD: 1.848

VERT SPREAD: 2.598

GROUP SPREAD: 3.188

MIN RADIUS: 0.175

MAX RADIUS: 1.754

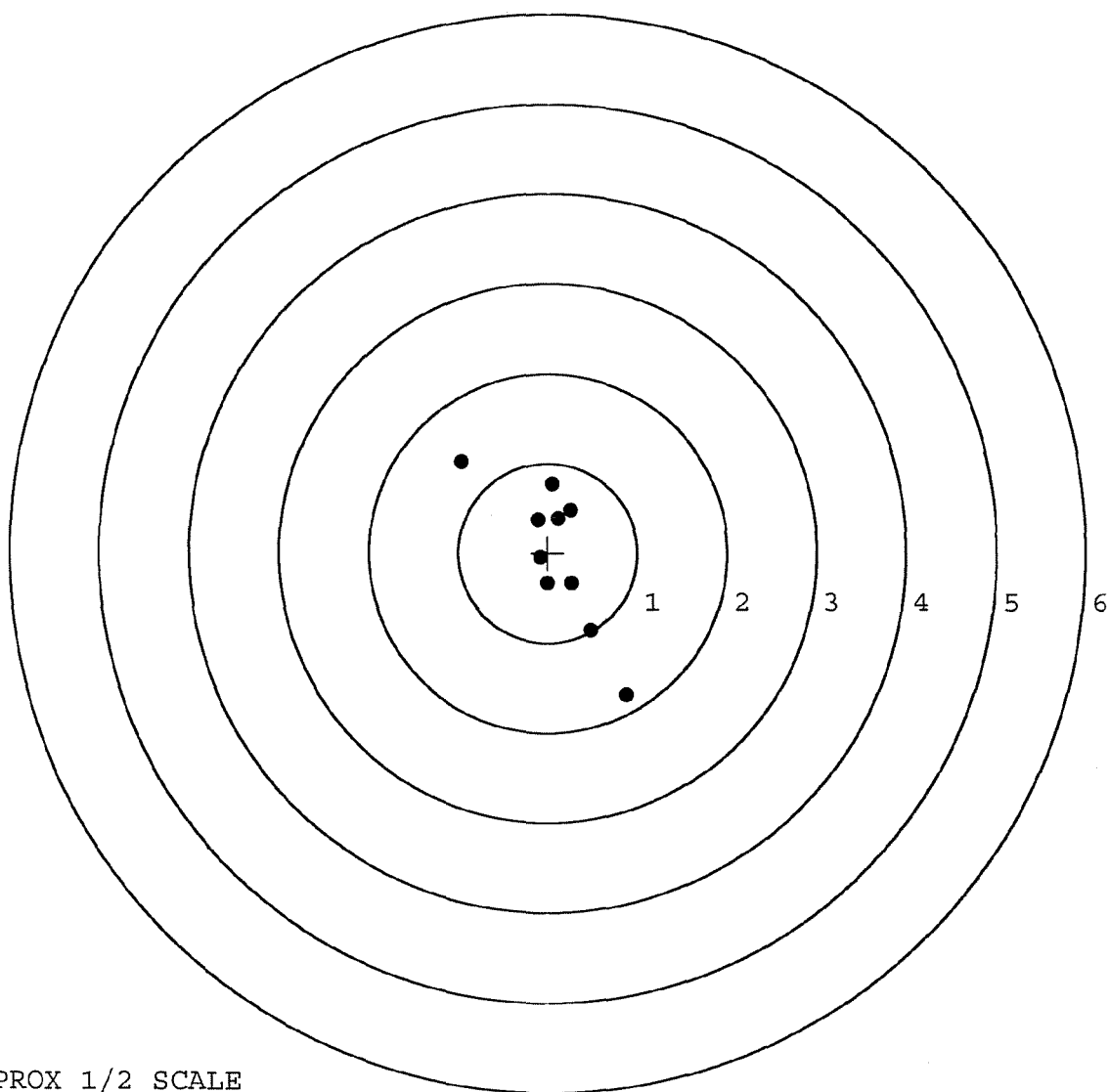
MEAN RADIUS: 0.722

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.883	-1.583
2:	0.483	-0.871
3:	-0.965	1.015
4:	0.051	0.772
5:	0.258	0.479
6:	0.119	0.380
7:	-0.114	0.368
8:	-0.082	-0.057
9:	-0.012	-0.346
10:	0.271	-0.346



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461785. 0

TARGET NUMBER: 3

FILE DATE: 10/17/2005

FILE TIME: 09:59

X CENTROID: 0.181

Y CENTROID: -0.113

POA TO CENTROID: 0.213

HORZ SPREAD: 2.806

VERT SPREAD: 2.043

GROUP SPREAD: 2.946

MIN RADIUS: 0.389

MAX RADIUS: 1.812

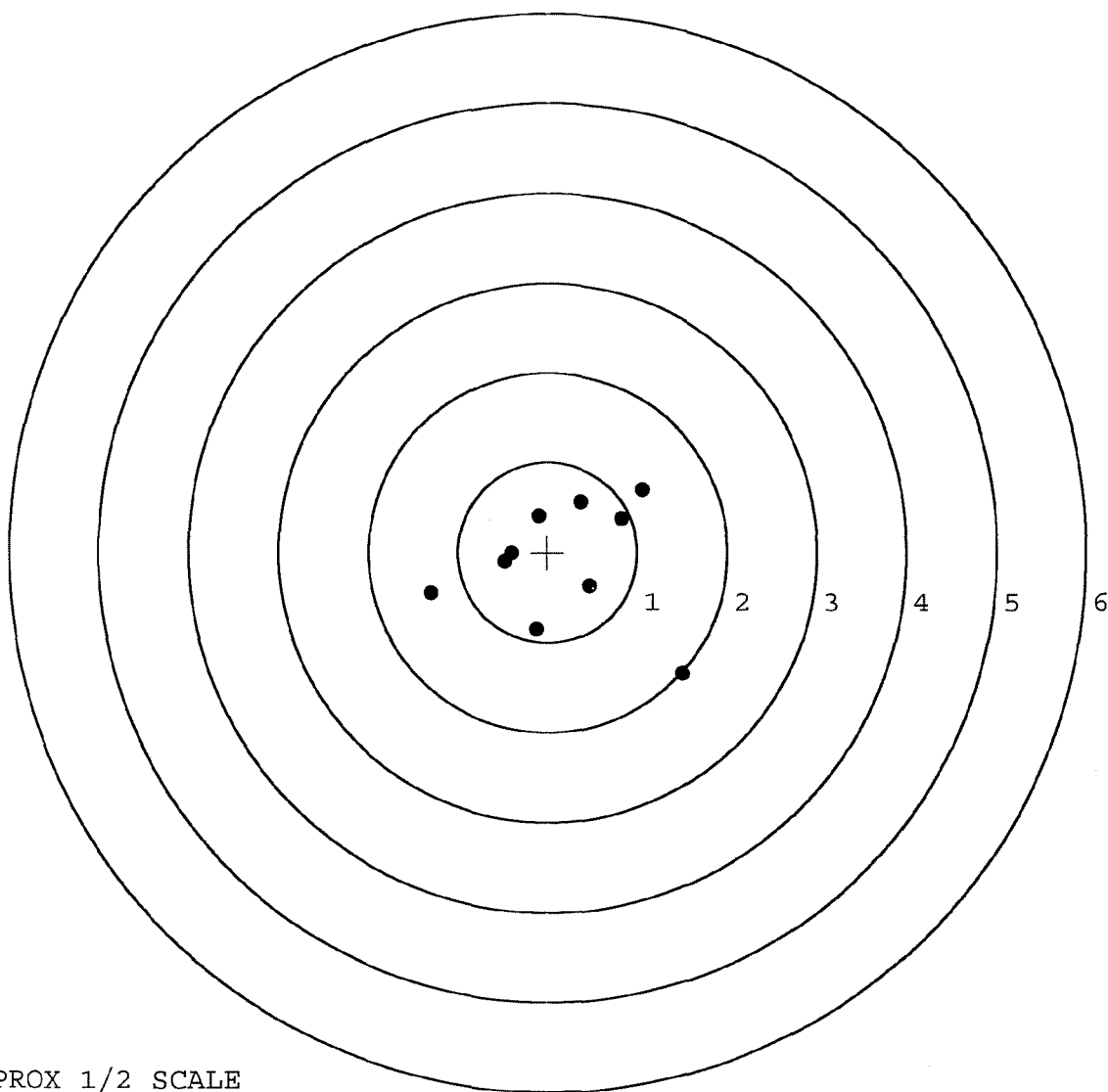
MEAN RADIUS: 0.908

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.500	-1.355
2:	-0.131	-0.866
3:	0.473	-0.369
4:	0.826	0.380
5:	1.055	0.688
6:	0.373	0.564
7:	-0.103	0.405
8:	-0.478	-0.105
9:	-0.401	-0.011
10:	-1.306	-0.457



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461785. 0

TARGET NUMBER: 4

FILE DATE: 10/17/2005

FILE TIME: 09:59

X CENTROID: -0.017

Y CENTROID: 0.154

POA TO CENTROID: 0.155

HORZ SPREAD: 0.981

VERT SPREAD: 2.778

GROUP SPREAD: 2.794

MIN RADIUS: 0.192

MAX RADIUS: 1.838

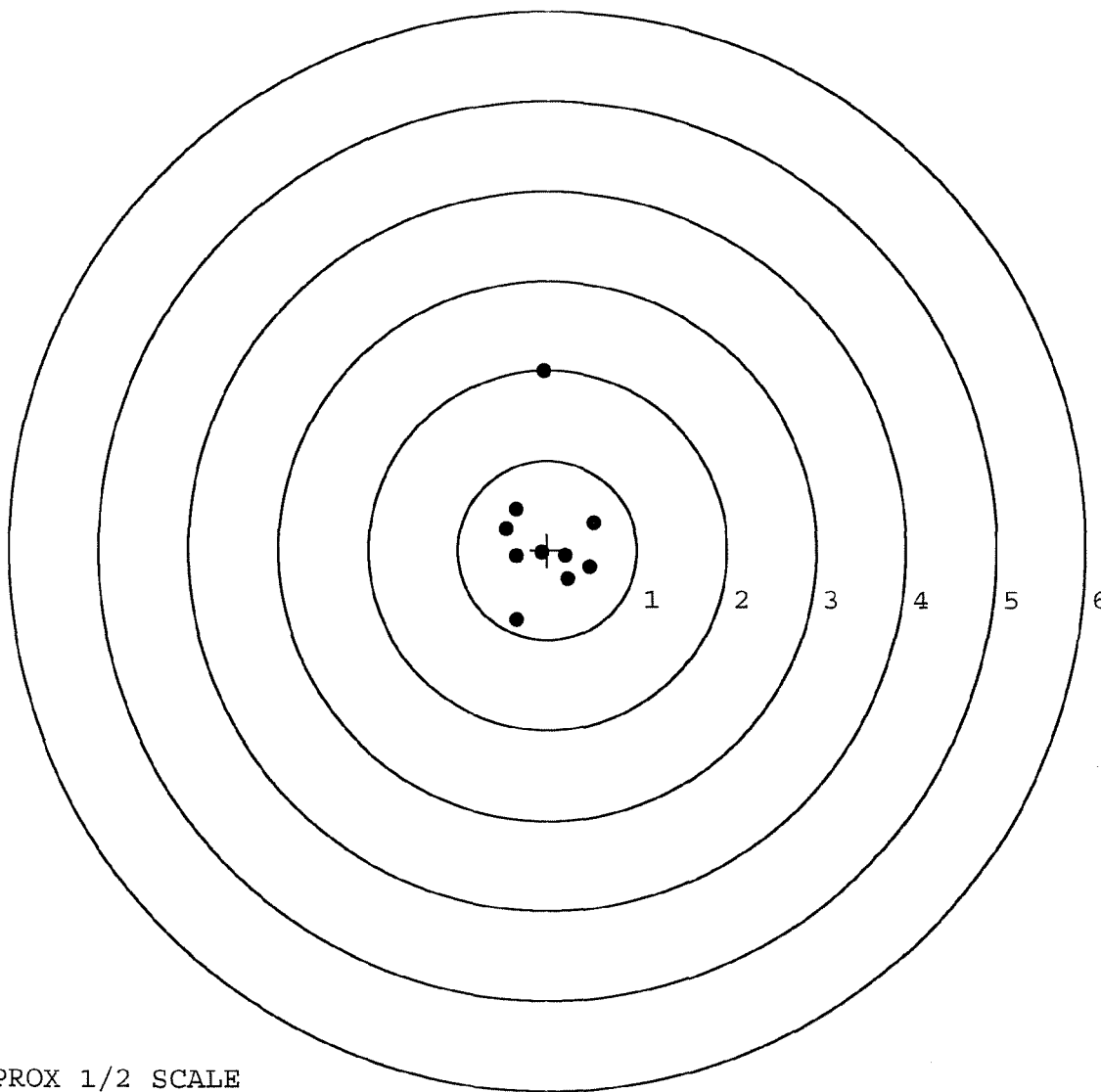
MEAN RADIUS: 0.633

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.045	1.992
2:	-0.345	-0.786
3:	-0.345	-0.067
4:	-0.462	0.238
5:	-0.348	0.459
6:	0.519	0.307
7:	0.478	-0.181
8:	0.231	-0.324
9:	0.205	-0.062
10:	-0.061	-0.033



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461785. 0

TARGET NUMBER: 5

FILE DATE: 10/17/2005

FILE TIME: 09:59

POINT#	X	Y
1:	1.242	-0.210
2:	-0.320	-1.603
3:	-0.700	-0.692
4:	0.266	-0.513
5:	0.266	-0.730
6:	-0.852	0.626
7:	0.178	0.953
8:	0.161	0.658
9:	0.287	0.253
10:	0.081	0.351

X CENTROID: 0.061

Y CENTROID: -0.091

POA TO CENTROID: 0.109

HORZ SPREAD: 2.094

VERT SPREAD: 2.556

GROUP SPREAD: 2.604

MIN RADIUS: 0.411

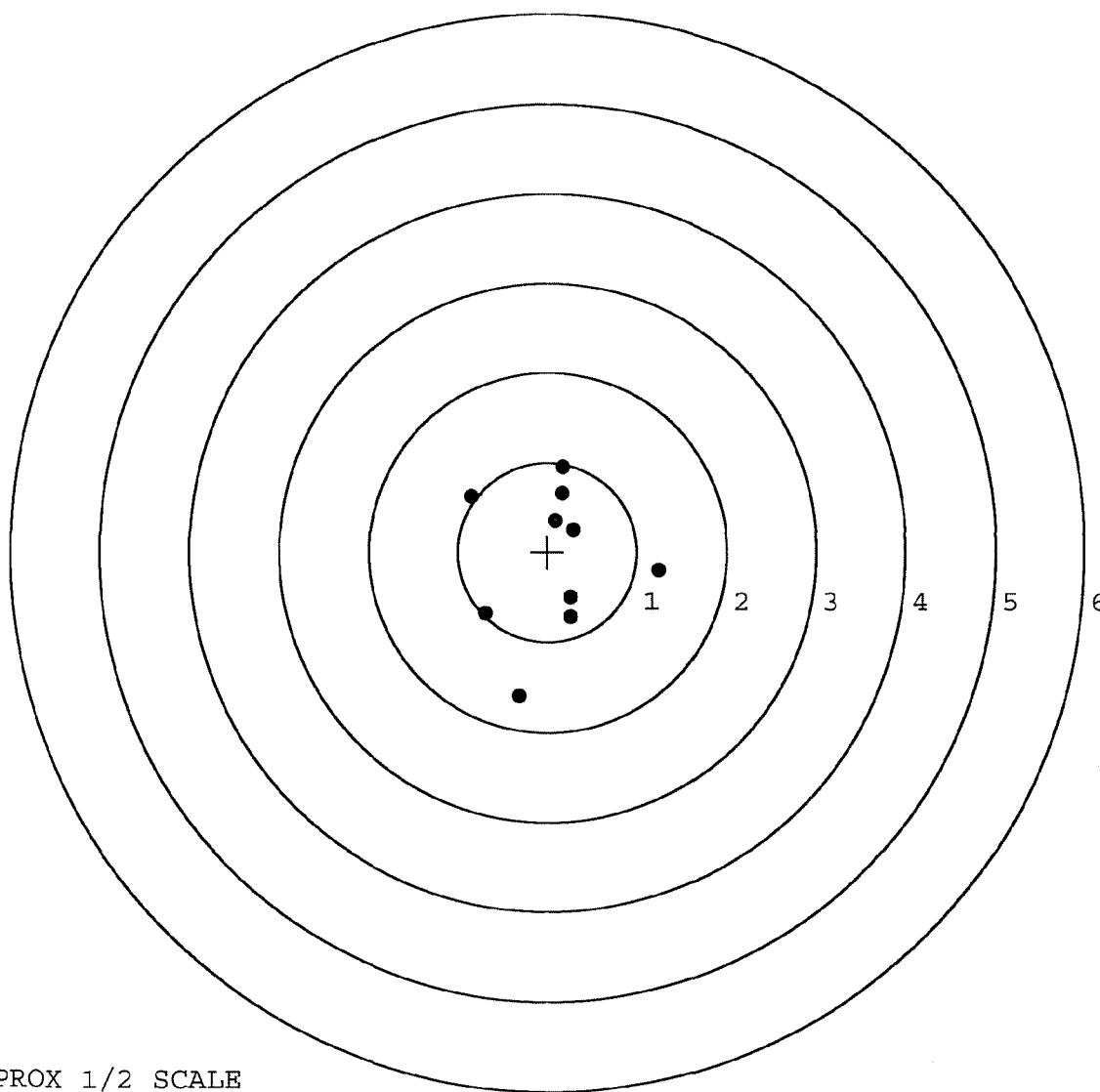
MAX RADIUS: 1.560

MEAN RADIUS: 0.868

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE