

G 646 1789

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

UPC



0 47700 25716 7

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SERIAL NO.



66461789

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

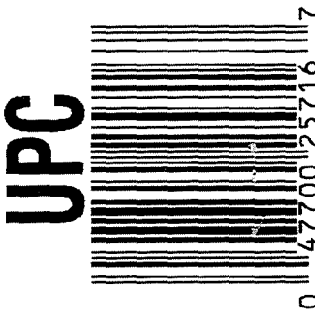
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461789



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G604601789

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-16-05	RTZ
440	PROOF		9-20-05	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX	9-20-05	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED SEP 23 2005	9-21-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>umh</u>	9/23/05	umh
500	ROLLMARK CALIBER		9-23-05	CW
510	DRILL AND TAP SIGHT HOLES		9-23-05	TRL
520	GOFF BLAST BBL / REC		9-26-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/4/05	FB
	(BOLT)		10/4/05	FB
560	RE-ASSEMBLE ACTION		10/6/05	umh
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/6/05	umh
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/6/05	umh
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-20-05	RTZ
	D) OIL FIRING PIN ASSEMBLY			
	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 lb</u> <u>6 lb</u> <u>6 lb</u>	10-31-05	BC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lb</u> <u>2 lb</u> <u>2 lb</u>	10-31-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	10-31-05	BC
	J) ASSEMBLE STOCK		10-28-05	RR
	K) ASSEMBLE SWIVEL STUDS		10-31-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-31-05	BC
	M) IRON SIGHT ALIGNMENT		10-31-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-31-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10/21/05	mgd
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/21/05	mgm
670	FINAL INSPECTION A) HEADSPACE		10-31-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.66</u> <u>2.53</u> <u>2.37</u> <u>2.71</u>	10-28-05	BC
	C) FUNCTION		10-31-05	BC
690	PACK		11-1-05	AA

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 10-19-05

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.48	2.66	2.68	
PULL #2	2.31	2.72	2.74	
PULL #3	2.43	2.65	2.64	
PULL #4	2.56	2.71	2.79	
PULL #5	2.59	2.66	2.48	
TOTAL	12.37	13.40	13.33	
AVERAGE	2.47	2.68	2.66	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.03	3.15	
PULL #2	3.10	3.15	
PULL #3	2.98	3.12	
PULL #4	2.96	3.15	
PULL #5	3.03	3.12	
TOTAL	15.10	15.69	
AVERAGE	3.02	3.13	

	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	4.03	4.10		4.24
PULL #2	4.26	4.32		4.26
PULL #3	4.20	4.19		4.29
PULL #4	4.25	4.20		4.31
PULL #5	4.02	4.19		4.30
TOTAL	20.76	21.00		21.40
AVERAGE	4.15	4.20		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461789.__0
FILE DATE AND TIME: 10/21/2005 17:59

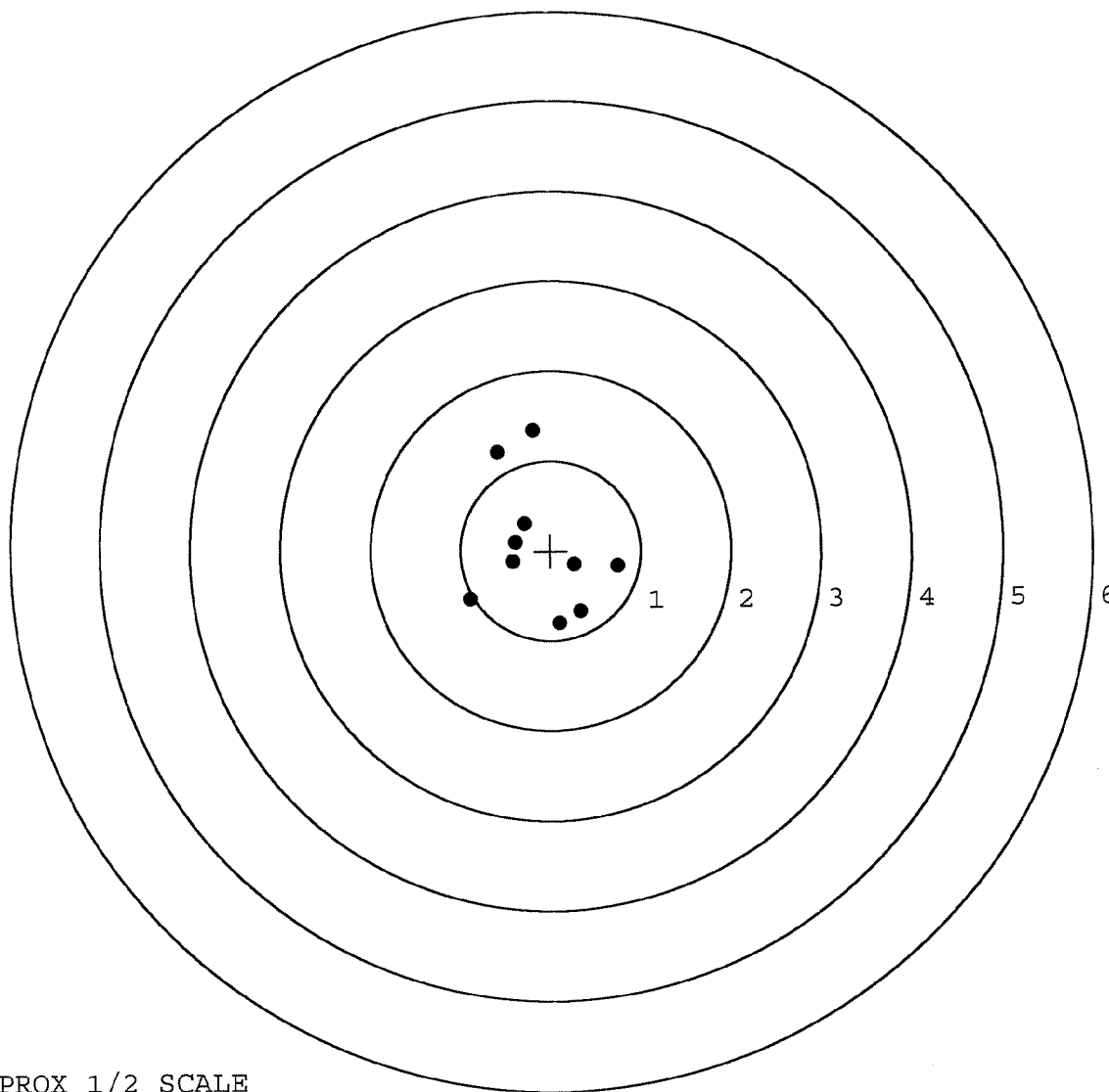
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.036
The Average Y Centroid of the Five Target Set:	-0.035
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.761
The Distance from POA to Centroid Target #1:	0.138
The Distance from Centroid Target #2 to Centroid Target #1:	0.335
The Distance from Centroid Target #3 to Centroid Target #1:	0.068
The Distance from Centroid Target #4 to Centroid Target #1:	0.125
The Distance from Centroid Target #5 to Centroid Target #1:	0.100

SERIAL NUMBER: G6461789. __ 0
 TARGET NUMBER: 1
 FILE DATE: 10/21/2005
 FILE TIME: 17:59

POINT#	X	Y
1:	-0.289	0.305
2:	-0.388	0.095
3:	-0.421	-0.124
4:	-0.900	-0.538
5:	-0.582	1.096
6:	-0.189	1.338
7:	0.746	-0.180
8:	0.261	-0.157
9:	0.329	-0.675
10:	0.095	-0.808

X CENTROID: -0.134
 Y CENTROID: 0.035
 POA TO CENTROID: 0.138
 HORZ SPREAD: 1.646
 VERT SPREAD: 2.146
 GROUP SPREAD: 2.165
 MIN RADIUS: 0.261
 MAX RADIUS: 1.304
 MEAN RADIUS: 0.738
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

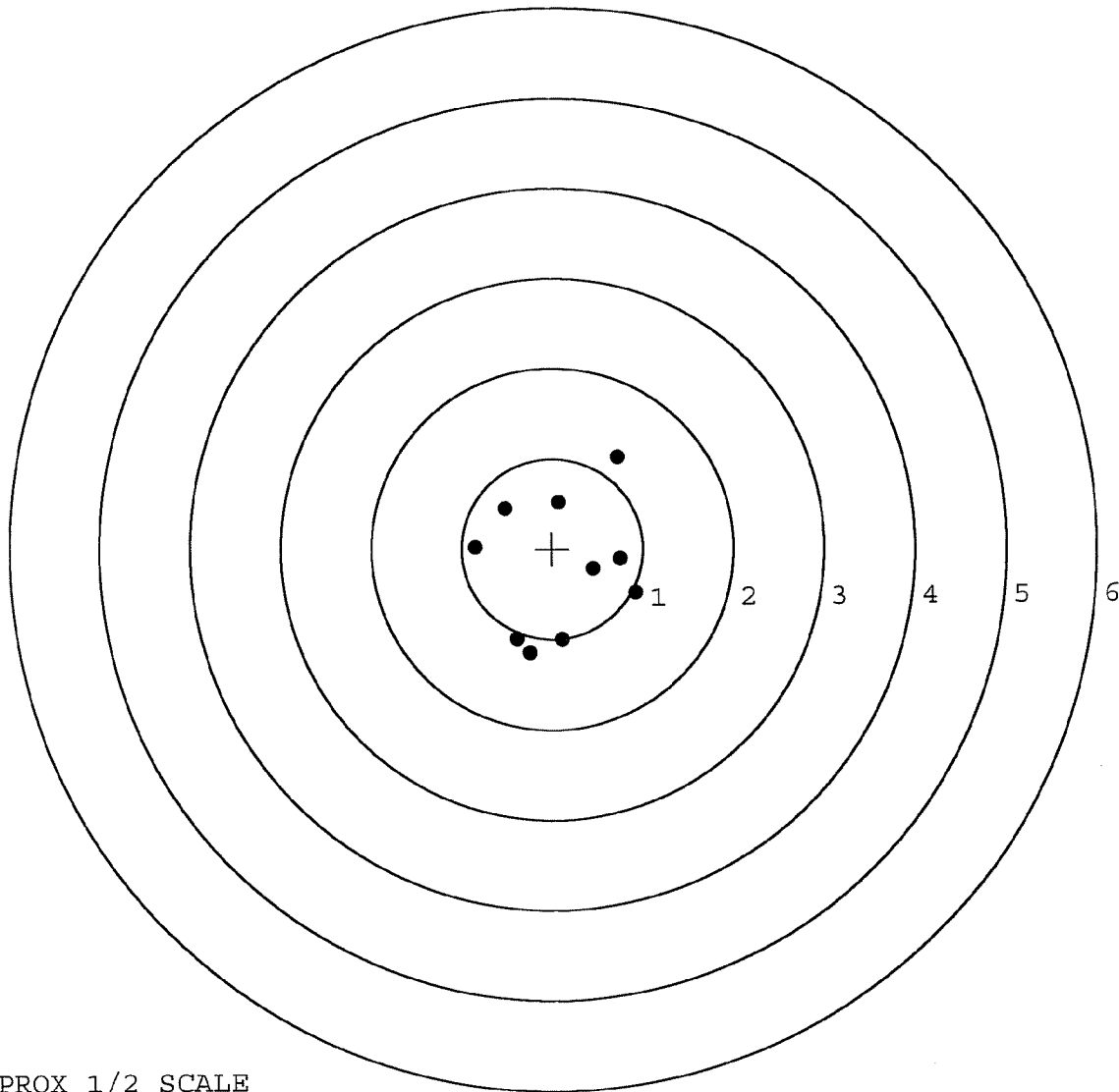


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461789.____0
 TARGET NUMBER: 2
 FILE DATE: 10/21/2005
 FILE TIME: 17:59

POINT#	X	Y
1:	0.728	1.011
2:	0.079	0.516
3:	-0.520	0.448
4:	-0.850	0.021
5:	0.450	-0.233
6:	0.751	-0.126
7:	0.918	-0.504
8:	0.103	-1.009
9:	-0.257	-1.156
10:	-0.396	-1.003

X CENTROID: 0.101
 Y CENTROID: -0.204
 POA TO CENTROID: 0.227
 HORZ SPREAD: 1.768
 VERT SPREAD: 2.167
 GROUP SPREAD: 2.380
 MIN RADIUS: 0.351
 MAX RADIUS: 1.367
 MEAN RADIUS: 0.860
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

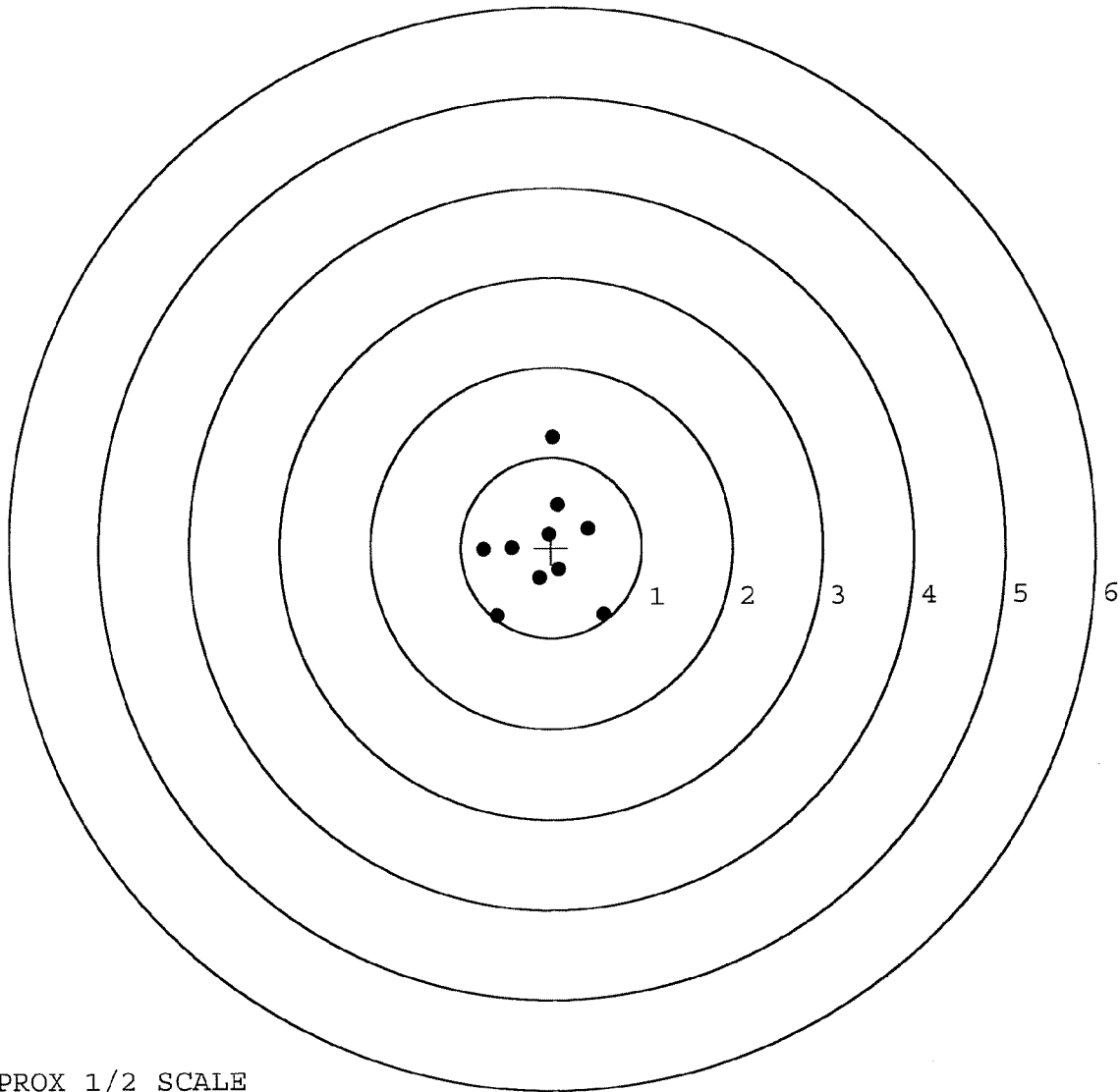


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461789. __0
 TARGET NUMBER: 3
 FILE DATE: 10/21/2005
 FILE TIME: 17:59

POINT#	X	Y
1:	0.023	1.224
2:	0.413	0.211
3:	-0.436	0.006
4:	-0.752	-0.019
5:	-0.139	-0.334
6:	0.085	-0.244
7:	0.578	-0.751
8:	-0.600	-0.756
9:	-0.029	0.152
10:	0.076	0.476

X CENTROID: -0.078
 Y CENTROID: -0.003
 POA TO CENTROID: 0.078
 HORZ SPREAD: 1.330
 VERT SPREAD: 1.980
 GROUP SPREAD: 2.076
 MIN RADIUS: 0.163
 MAX RADIUS: 1.232
 MEAN RADIUS: 0.600
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0156192

SERIAL NUMBER: G6461789. __0

TARGET NUMBER: 4

FILE DATE: 10/21/2005

FILE TIME: 17:59

POINT#	X	Y
1:	0.113	0.408
2:	-0.004	0.187
3:	-0.249	0.442
4:	-0.309	0.691
5:	0.548	0.810
6:	-0.134	-0.313
7:	0.357	-0.641
8:	0.751	-0.806
9:	-1.097	-0.949
10:	-0.065	0.471

X CENTROID: -0.009

Y CENTROID: 0.030

POA TO CENTROID: 0.031

HORZ SPREAD: 1.848

VERT SPREAD: 1.759

GROUP SPREAD: 2.408

MIN RADIUS: 0.157

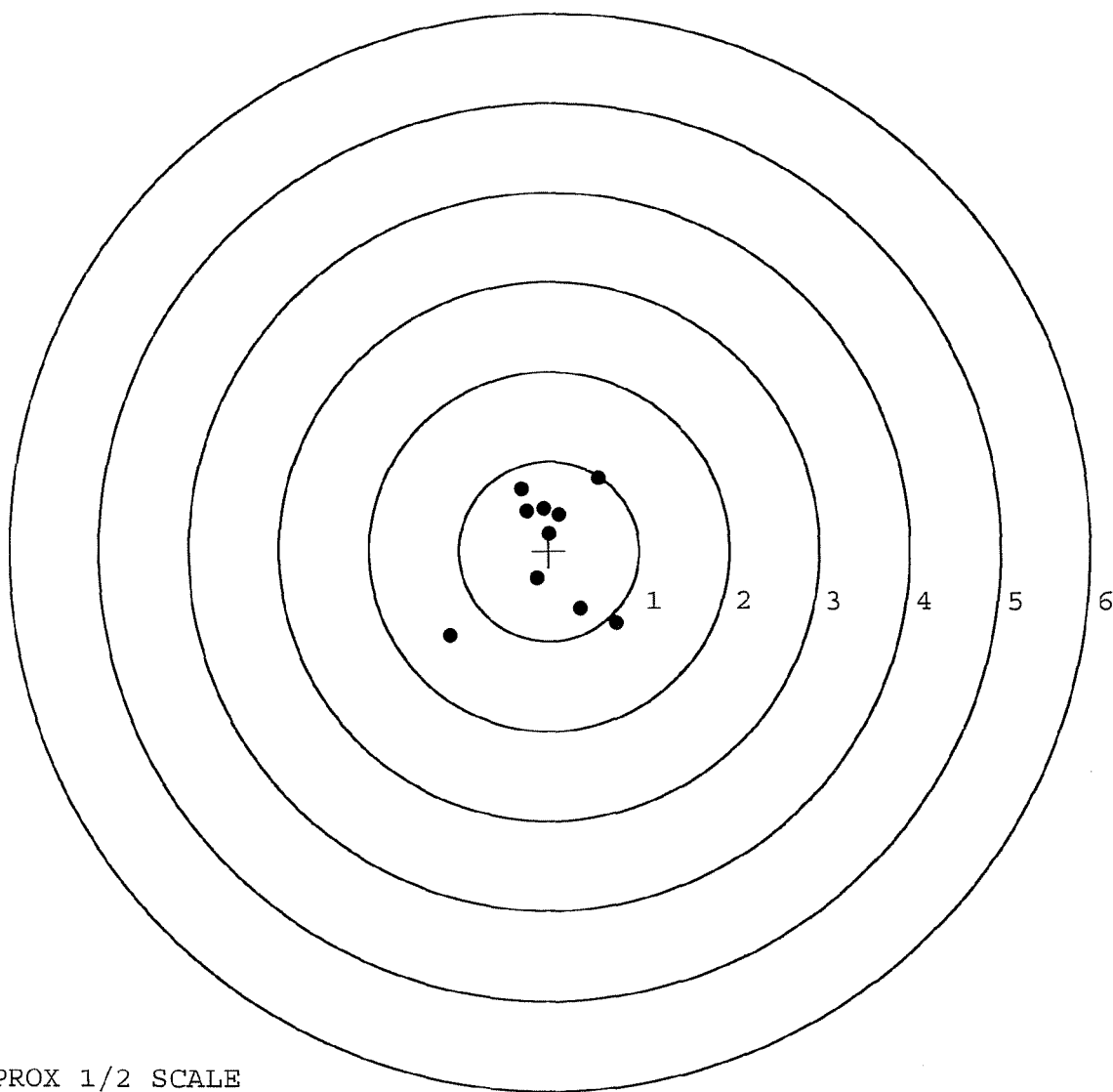
MAX RADIUS: 1.464

MEAN RADIUS: 0.688

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461789. __0

TARGET NUMBER: 5

FILE DATE: 10/21/2005

FILE TIME: 17:59

X CENTROID: -0.061

Y CENTROID: -0.033

POA TO CENTROID: 0.070

HORZ SPREAD: 1.994

VERT SPREAD: 2.575

GROUP SPREAD: 3.257

MIN RADIUS: 0.357

MAX RADIUS: 1.664

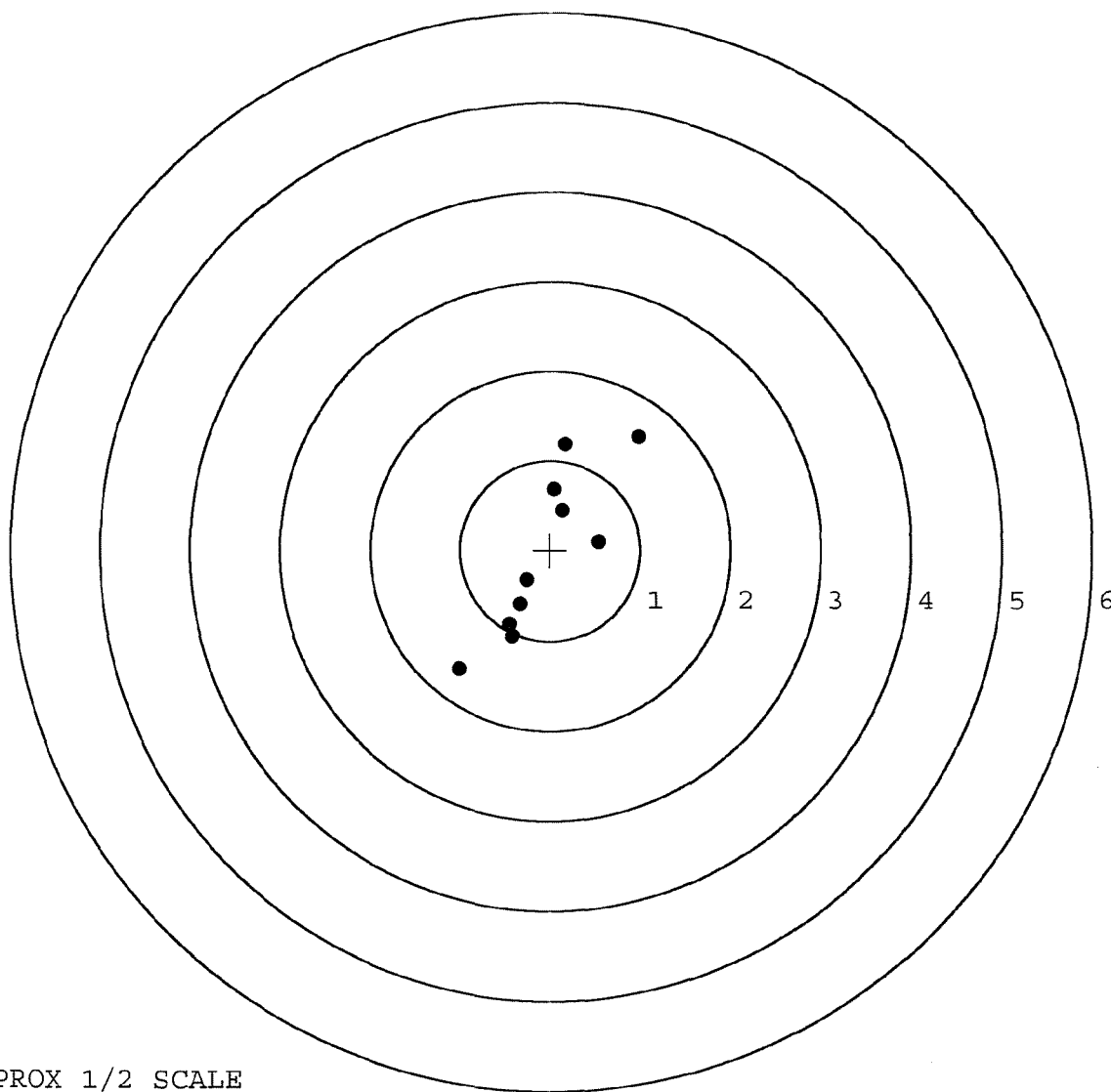
MEAN RADIUS: 0.920

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.985	1.261
2:	0.171	1.186
3:	0.040	0.680
4:	0.138	0.443
5:	0.541	0.099
6:	-0.262	-0.328
7:	-0.336	-0.598
8:	-0.456	-0.816
9:	-1.009	-1.314
10:	-0.423	-0.947



TARGET APPROX 1/2 SCALE