

G 657 0060

ORDER 25716

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

UPC



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SERIAL NO.



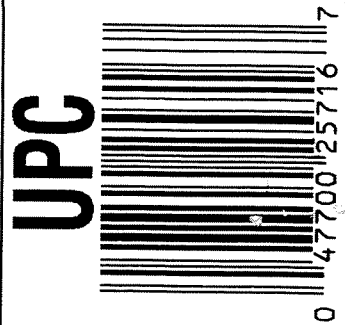
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6590060



DD FORM

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590060

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-24-06	RTZ
420	ASSEMBLE ACTION		8-24-06	RTZ
430	ASSEMBLE TO STOCK		8-24-06	BD
440	PROOF		8-24-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 01 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <i>unb</i>	9/1/06	<i>unb</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-1-06	CW
510	DRILL AND TAP SIGHT HOLES		9-1-06	TRW
520	GOFF BLAST BBL / REC		9-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/1/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-11-06	Ac
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-11-06	Ac
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-11-06	Ac
	D) OIL FIRING PIN ASSEMBLY		9-14-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

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560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>6.0</u>	9/25/06	RA
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	9/25/06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.020</u> <u>.025</u> <u>.025</u>	9/25/06	RA
	J) ASSEMBLE STOCK			9-14-06	RTZ
	K) ASSEMBLE SWIVEL STUDS			10-7-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			9-14-06	RTZ
	M) IRON SIGHT ALIGNMENT			9-14-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			9-14-06	RTZ
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	9-15-06	TRW
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			9/15/06	BD
670	FINAL INSPECTION A) HEADSPACE			10-7-06	L.P.D.
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.56</u> <u>2.53</u> <u>2.46</u> <u>2.60</u>	9-16-06	RA
	C) FUNCTION			10-7-06	L.P.D.
690	PACK			10-27-06	RA

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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)

 DATE 9-12-06

 TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.21		2.48	
PULL #2	2.39	2.23		2.51	
PULL #3	2.29	2.31		2.57	
PULL #4	2.60	2.39		2.51	
PULL #5	2.68	2.41		2.48	
TOTAL	12.46	11.55		12.55	
AVERAGE	2.49	2.31		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.17		
PULL #2	3.10	3.13		
PULL #3	2.92	3.04		
PULL #4	3.02	3.02		
PULL #5	2.96	3.09		
TOTAL	15.13	15.45		
AVERAGE	3.02	3.09		

	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	4.05	4.22		4.05
PULL #2	3.99	4.02		3.97
PULL #3	4.03	4.01		4.00
PULL #4	3.98	3.98		3.95
PULL #5	4.01	3.99		3.97
TOTAL	20.06	20.22		19.94
AVERAGE	4.01	4.04		3.98

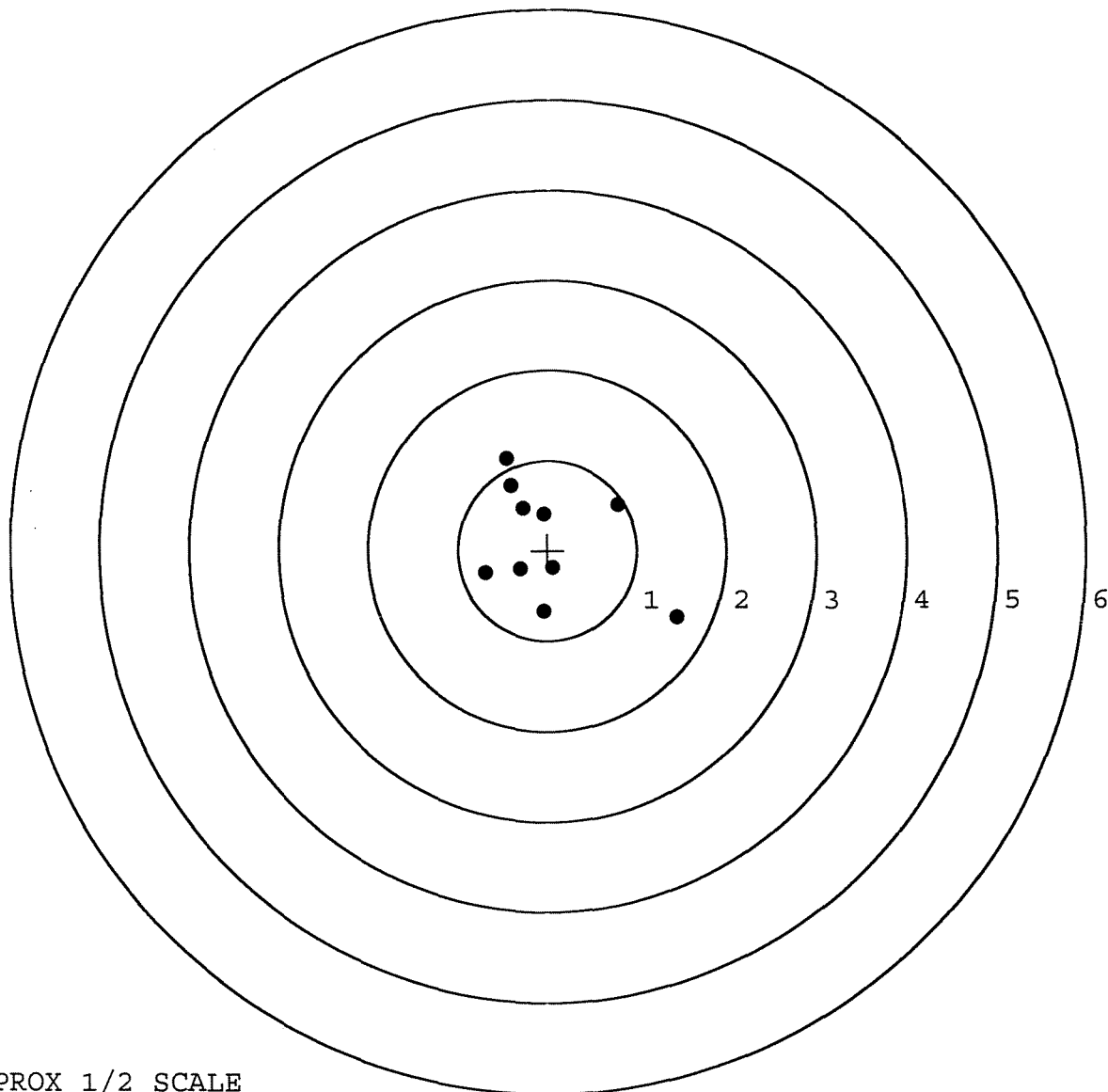
SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590060.___0
FILE DATE AND TIME: 09/16/2006 01:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.095
The Average Y Centroid of the Five Target Set:	0.087
The Average Point of Impact of the Five Target Set:	0.129
The Average Mean Radius of the Five Target Set:	0.854
The Distance from POA to Centroid Target #1:	0.103
The Distance from Centroid Target #2 to Centroid Target #1:	0.102
The Distance from Centroid Target #3 to Centroid Target #1:	0.215
The Distance from Centroid Target #4 to Centroid Target #1:	0.197
The Distance from Centroid Target #5 to Centroid Target #1:	0.131

SERIAL NUMBER: G6590060. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	0.785	0.511
FILE DATE: 09/16/2006	2:	1.448	-0.741
FILE TIME: 01:55	3:	-0.045	-0.686
	4:	0.057	-0.195
X CENTROID: 0.003	5:	-0.310	-0.210
Y CENTROID: 0.103	6:	-0.694	-0.258
POA TO CENTROID: 0.103	7:	-0.050	0.403
HORZ SPREAD: 2.142	8:	-0.285	0.473
VERT SPREAD: 1.755	9:	-0.414	0.719
GROUP SPREAD: 2.595	10:	-0.463	1.014
MIN RADIUS: 0.303			
MAX RADIUS: 1.674			
MEAN RADIUS: 0.742			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 9			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590060. __0

TARGET NUMBER: 2

FILE DATE: 09/16/2006

FILE TIME: 01:55

POINT#	X	Y
1:	-0.306	1.705
2:	0.519	0.352
3:	0.324	-0.168
4:	0.064	0.283
5:	0.246	-1.269
6:	-0.059	-0.793
7:	-0.345	-0.415
8:	-0.280	-0.087
9:	-0.526	0.272
10:	-0.409	0.513

X CENTROID: -0.077

Y CENTROID: 0.039

POA TO CENTROID: 0.087

HORZ SPREAD: 1.045

VERT SPREAD: 2.974

GROUP SPREAD: 3.025

MIN RADIUS: 0.239

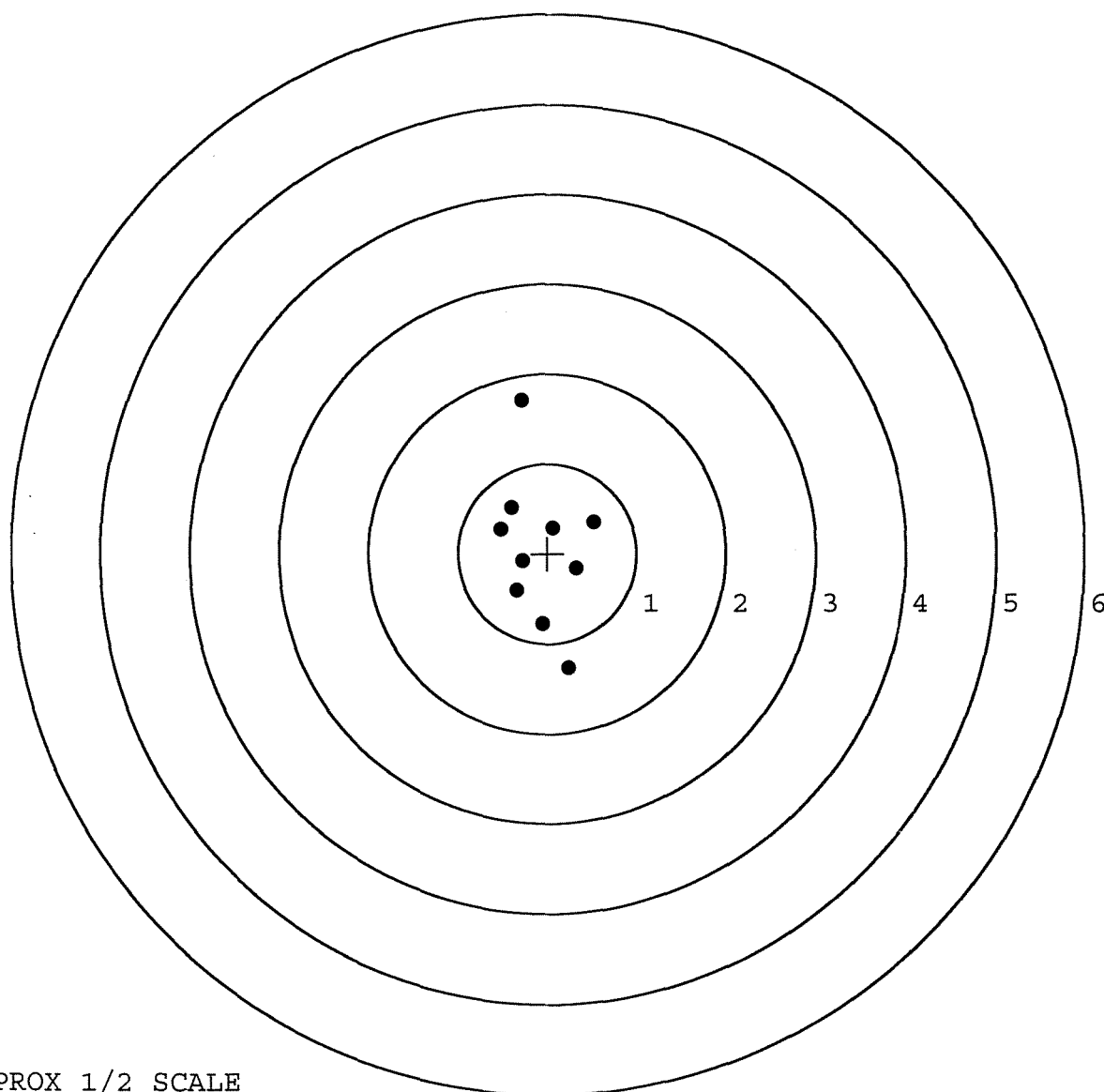
MAX RADIUS: 1.681

MEAN RADIUS: 0.712

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590060. __0

TARGET NUMBER: 3

FILE DATE: 09/16/2006

FILE TIME: 01:55

POINT#	X	Y
1:	0.429	1.233
2:	-0.108	0.972
3:	-0.496	0.631
4:	-0.888	0.373
5:	-0.264	0.140
6:	0.155	-0.437
7:	0.128	-0.659
8:	0.336	-1.041
9:	-0.419	-1.086
10:	-0.475	-0.503

X CENTROID: -0.160

Y CENTROID: -0.038

POA TO CENTROID: 0.165

HORZ SPREAD: 1.317

VERT SPREAD: 2.319

GROUP SPREAD: 2.469

MIN RADIUS: 0.206

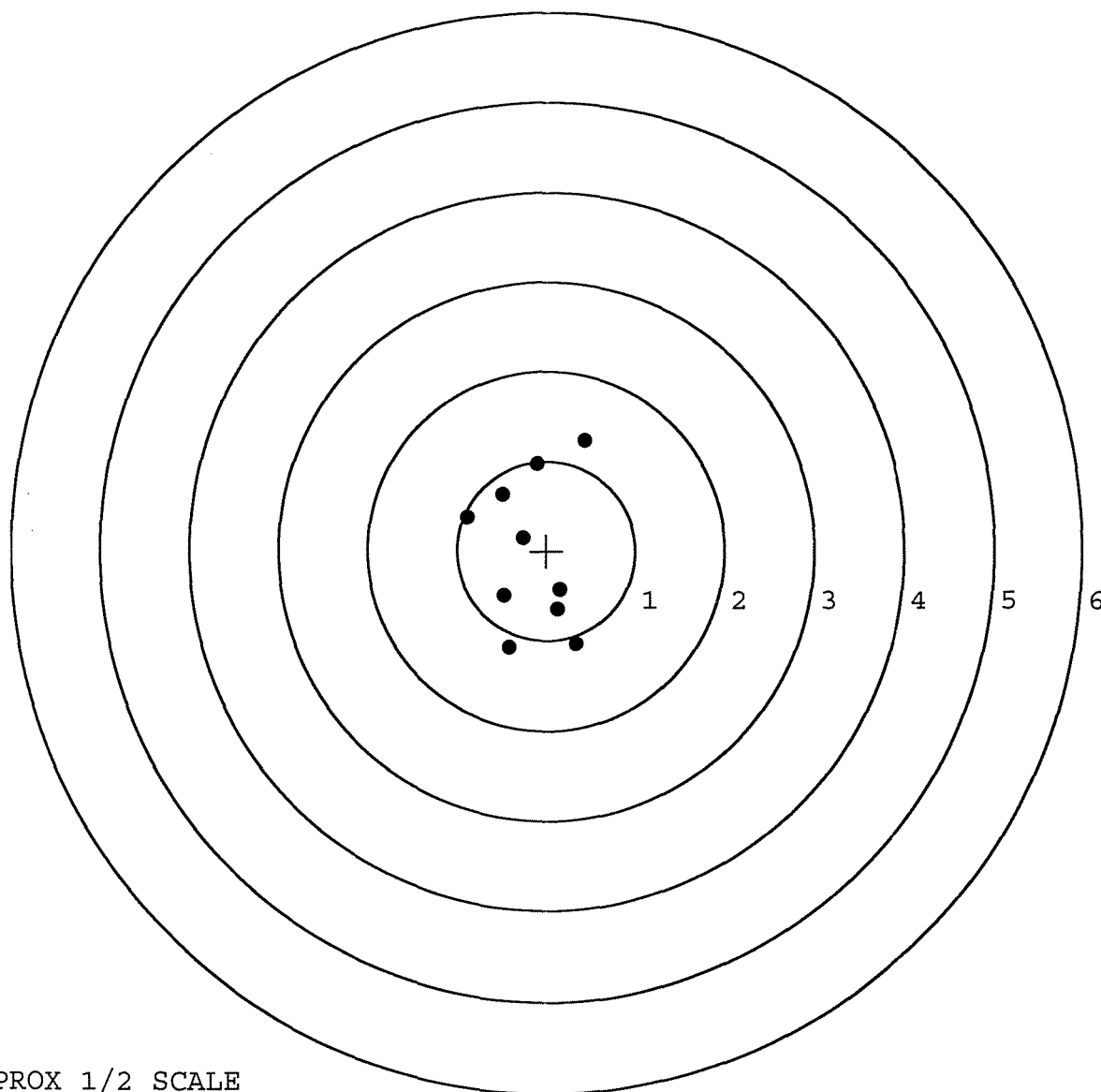
MAX RADIUS: 1.401

MEAN RADIUS: 0.816

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590060. 0

TARGET NUMBER: 4

FILE DATE: 09/16/2006

FILE TIME: 01:55

POINT#	X	Y
1:	-1.225	1.794
2:	0.016	1.217
3:	0.095	0.290
4:	-0.590	0.462
5:	-0.814	0.815
6:	0.444	-0.164
7:	0.261	-0.324
8:	-0.020	-0.670
9:	-0.014	-0.969
10:	-0.089	-1.401

X CENTROID: -0.194

Y CENTROID: 0.105

POA TO CENTROID: 0.220

HORZ SPREAD: 1.669

VERT SPREAD: 3.195

GROUP SPREAD: 3.391

MIN RADIUS: 0.343

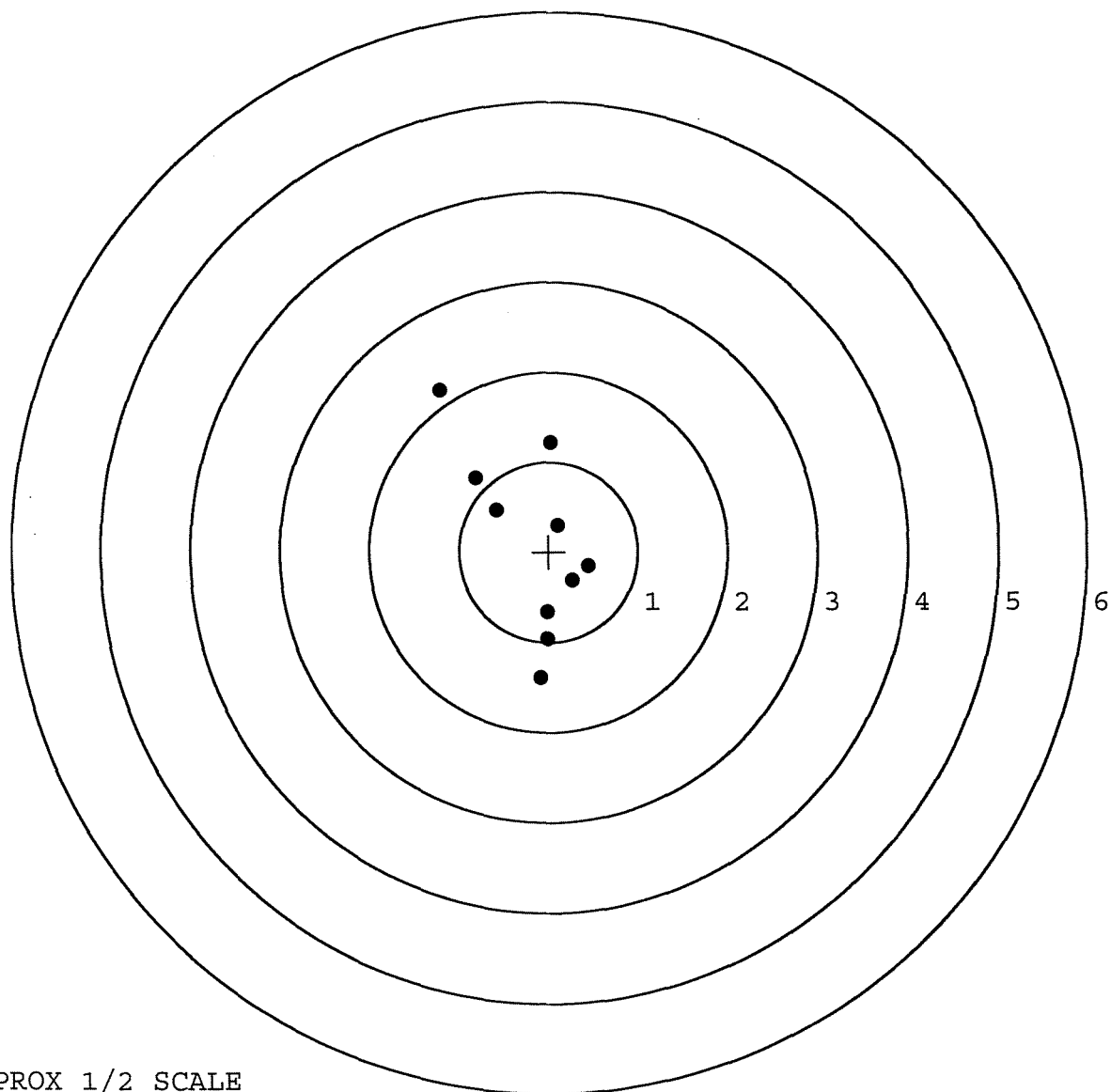
MAX RADIUS: 1.979

MEAN RADIUS: 0.964

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590060. 0

TARGET NUMBER: 5

FILE DATE: 09/16/2006

FILE TIME: 01:55

POINT#	X	Y
1:	-0.573	1.114
2:	-0.232	0.501
3:	-0.112	0.300
4:	0.238	0.861
5:	0.463	0.135
6:	0.296	-0.656
7:	1.118	-1.155
8:	-0.139	-0.899
9:	-0.378	-0.750
10:	-1.141	2.796

X CENTROID: -0.046

Y CENTROID: 0.225

POA TO CENTROID: 0.229

HORZ SPREAD: 2.259

VERT SPREAD: 3.951

GROUP SPREAD: 4.551

MIN RADIUS: 0.100

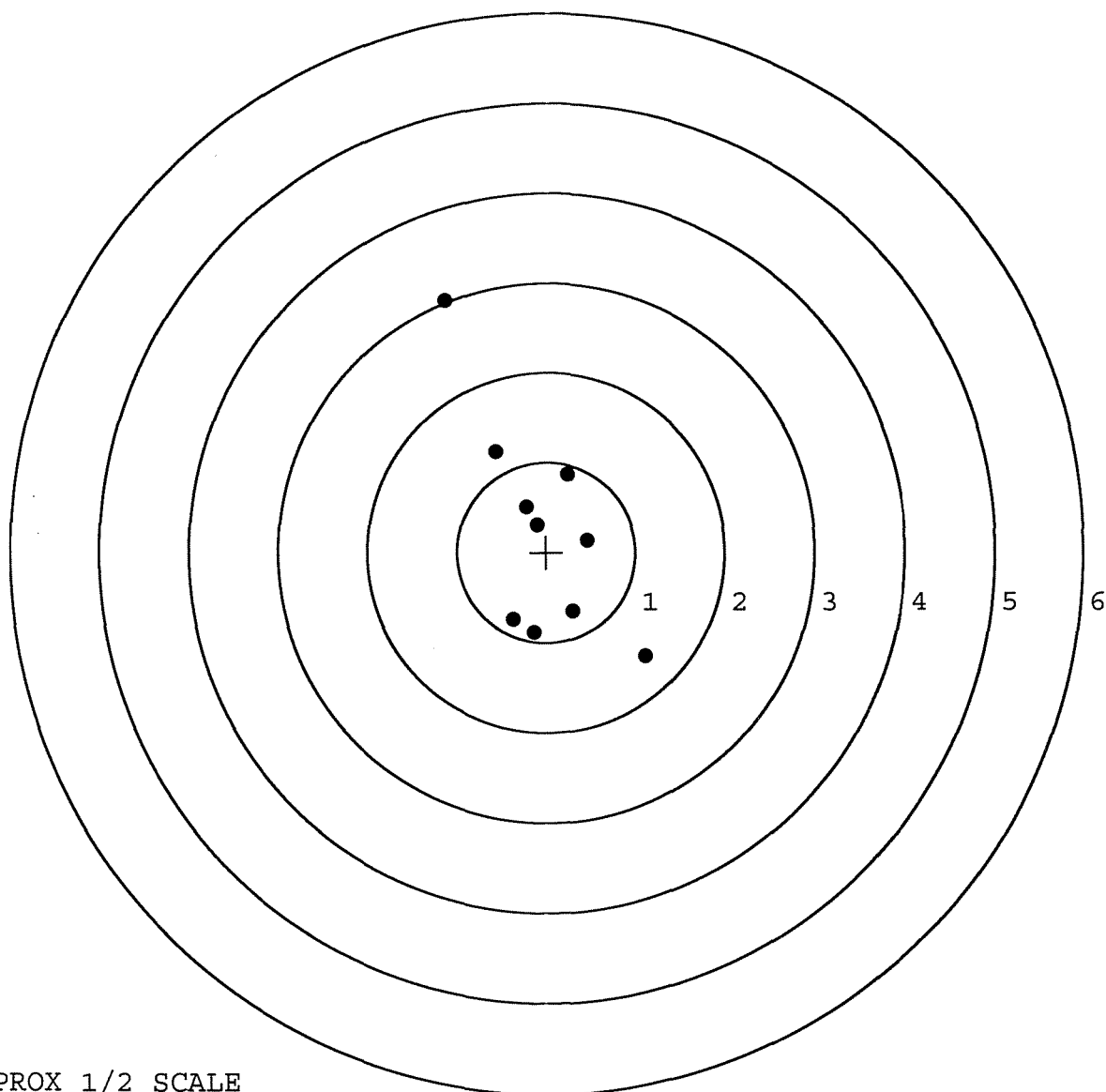
MAX RADIUS: 2.795

MEAN RADIUS: 1.038

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE