

G6591576

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYST
UPC



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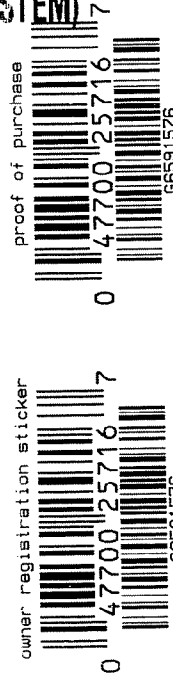
SERIAL NO.



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**

G6591576



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591576

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	RTZ
420	ASSEMBLE ACTION		10-6-06	BLG
430	ASSEMBLE TO STOCK		10-7-06	WR
440	PROOF		10-7-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-7-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 10 2006	10-9-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPLD</u>	10-10-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-06	W
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/18/06	BB
560	RE-ASSEMBLE ACTION		10-25-06	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-25-06	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-25-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-3-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP BARBER M240N168151			READINGS			DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5th</u> <u>6th</u> <u>6th</u>			11-14-06	SD
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	<u>8th</u> <u>7th</u> <u>6th</u>			11-14-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>			11-14-06	SD
	J) ASSEMBLE STOCK					11-3-06	BLG
	K) ASSEMBLE SWIVEL STUDS					11-17-06	R.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S						
	M) IRON SIGHT ALIGNMENT						
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER						
640 & 650	FUNCTION TEST AND TARGET		PASS FAIL			11-6-06	TRW
			PASS FAIL				
	MALFUNCTION	CORRECTION	N/A				
	MALFUNCTION	CORRECTION					
	MALFUNCTION	CORRECTION					
	MALFUNCTION	CORRECTION					
660	INSPECT FOR LIVE AMMO					11-6-06	SD
670	FINAL INSPECTION A) HEADSPACE					11-13-06	R.P.D.
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.23</u> <u>2.21</u> <u>2.22</u> <u>2.12</u>			11-13-06	SD
	C) FUNCTION					11-17-06	R.P.D.
690	PACK					12-5-07	RA

F004 REV 5/2006

BARBER - M24 0168152

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 11-1-06TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.67	2.52		2.35	
PULL #2	2.59	2.07		2.26	
PULL #3	2.67	2.24		2.24	
PULL #4	2.68	2.05		2.23	
PULL #5	2.65	2.06		2.31	
TOTAL	1326	1094		1139	
AVERAGE	265	218		227	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.27		
PULL #2	3.15	3.09		
PULL #3	3.13	3.11		
PULL #4	3.19	3.09		
PULL #5	3.14	3.15		
TOTAL	1576	1571		
AVERAGE	315	314		

	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	4.01	4.18		4.28
PULL #2	4.08	4.12		4.32
PULL #3	4.02	4.08		4.29
PULL #4	4.01	4.15		4.29
PULL #5	4.04	4.07		4.32
TOTAL	2016	2060		2150
AVERAGE	403	412		430

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591576.___0
FILE DATE AND TIME: 11/07/2006 05:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.060
The Average Y Centroid of the Five Target Set:	-0.012
The Average Point of Impact of the Five Target Set:	0.061
The Average Mean Radius of the Five Target Set:	0.732
The Distance from POA to Centroid Target #1:	0.240
The Distance from Centroid Target #2 to Centroid Target #1:	0.147
The Distance from Centroid Target #3 to Centroid Target #1:	0.308
The Distance from Centroid Target #4 to Centroid Target #1:	0.344
The Distance from Centroid Target #5 to Centroid Target #1:	0.259

BARBER - M24 0168154

SERIAL NUMBER: G6591576. __0

TARGET NUMBER: 1

FILE DATE: 11/07/2006

FILE TIME: 05:31

POINT#	X	Y
1:	0.948	-1.223
2:	0.007	-1.533
3:	-0.810	-1.096
4:	-0.762	1.324
5:	0.315	0.712
6:	-0.289	0.582
7:	-0.648	-0.049
8:	0.140	0.004
9:	-0.225	-0.052
10:	-0.595	-0.106

X CENTROID: -0.192

Y CENTROID: -0.144

POA TO CENTROID: 0.240

HORZ SPREAD: 1.758

VERT SPREAD: 2.857

GROUP SPREAD: 3.068

MIN RADIUS: 0.097

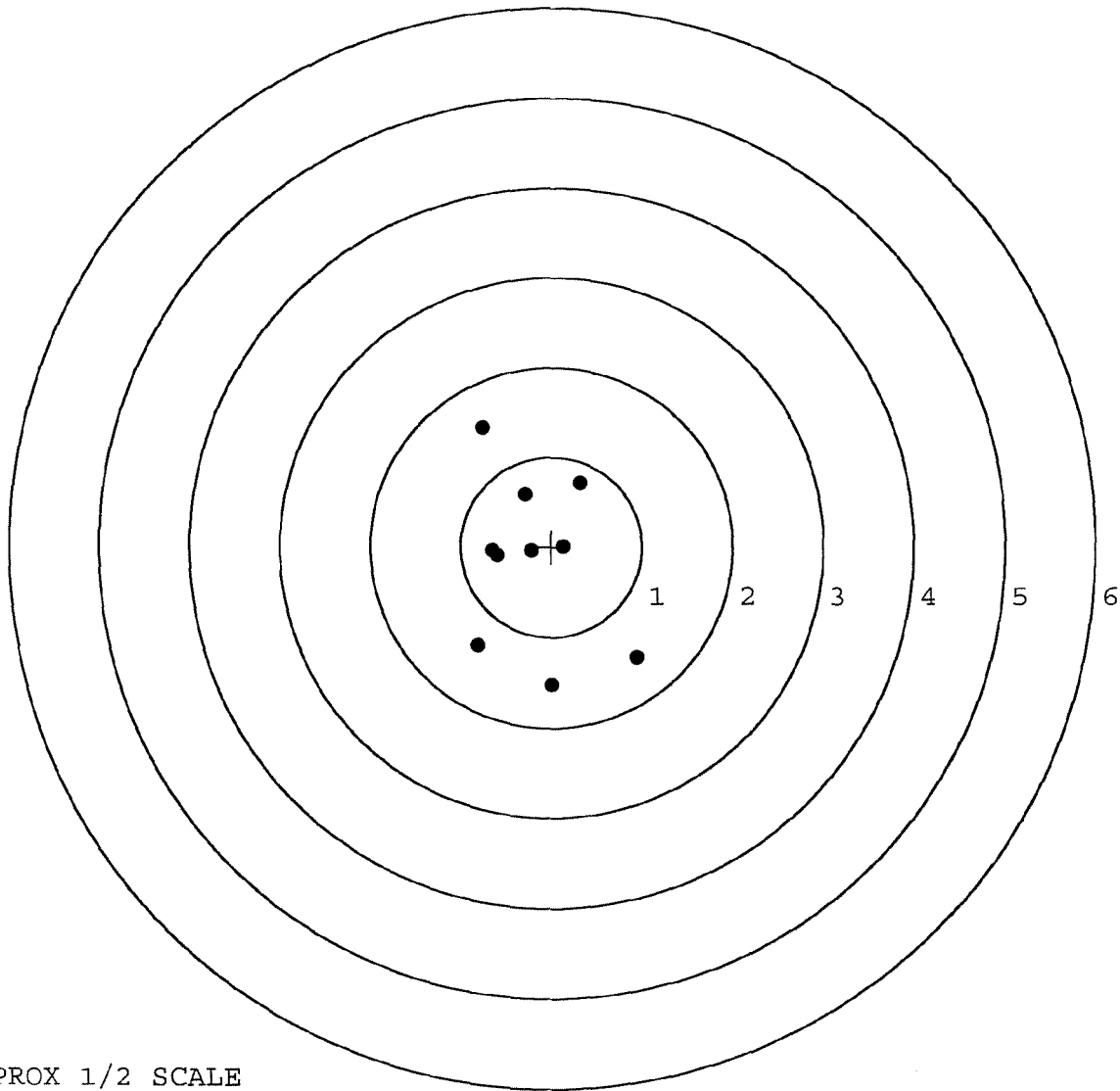
MAX RADIUS: 1.575

MEAN RADIUS: 0.874

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

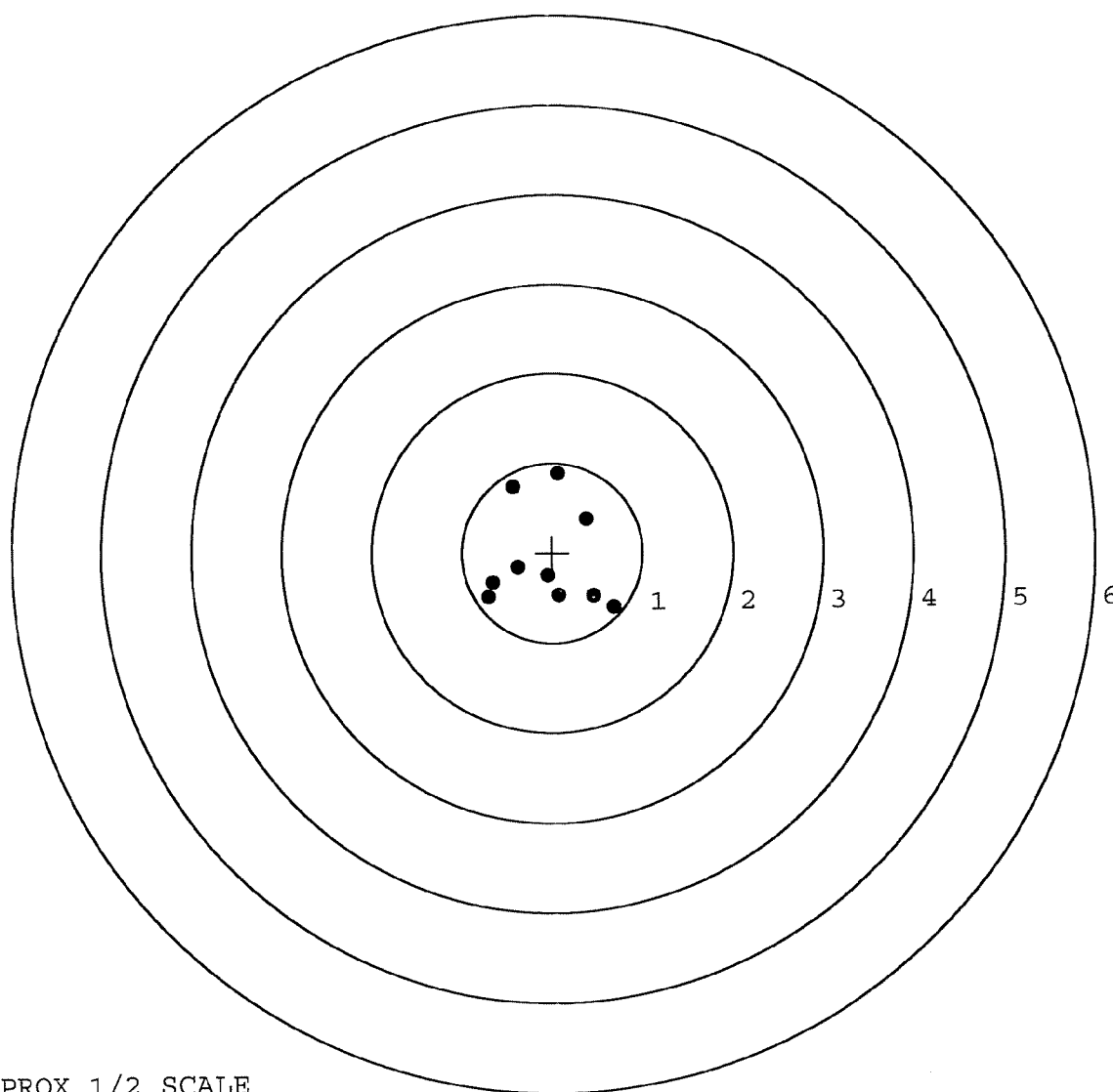


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591576. __0
 TARGET NUMBER: 2
 FILE DATE: 11/07/2006
 FILE TIME: 05:31

POINT#	X	Y
1:	-0.427	0.739
2:	0.067	0.886
3:	0.382	0.375
4:	0.678	-0.611
5:	0.459	-0.481
6:	0.070	-0.479
7:	-0.059	-0.258
8:	-0.384	-0.166
9:	-0.710	-0.490
10:	-0.660	-0.332

X CENTROID: -0.058
 Y CENTROID: -0.082
 POA TO CENTROID: 0.100
 HORZ SPREAD: 1.388
 VERT SPREAD: 1.497
 GROUP SPREAD: 1.617
 MIN RADIUS: 0.176
 MAX RADIUS: 0.976
 MEAN RADIUS: 0.642
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591576. __0

TARGET NUMBER: 3

FILE DATE: 11/07/2006

FILE TIME: 05:31

POINT#	X	Y
1:	-1.358	-0.169
2:	-0.645	-1.066
3:	0.900	-0.468
4:	0.988	-0.121
5:	0.308	1.025
6:	0.247	0.584
7:	-0.297	0.526
8:	-0.582	0.676
9:	-0.575	0.165
10:	-0.515	0.470

X CENTROID: -0.153

Y CENTROID: 0.162

POA TO CENTROID: 0.223

HORZ SPREAD: 2.346

VERT SPREAD: 2.091

GROUP SPREAD: 2.298

MIN RADIUS: 0.391

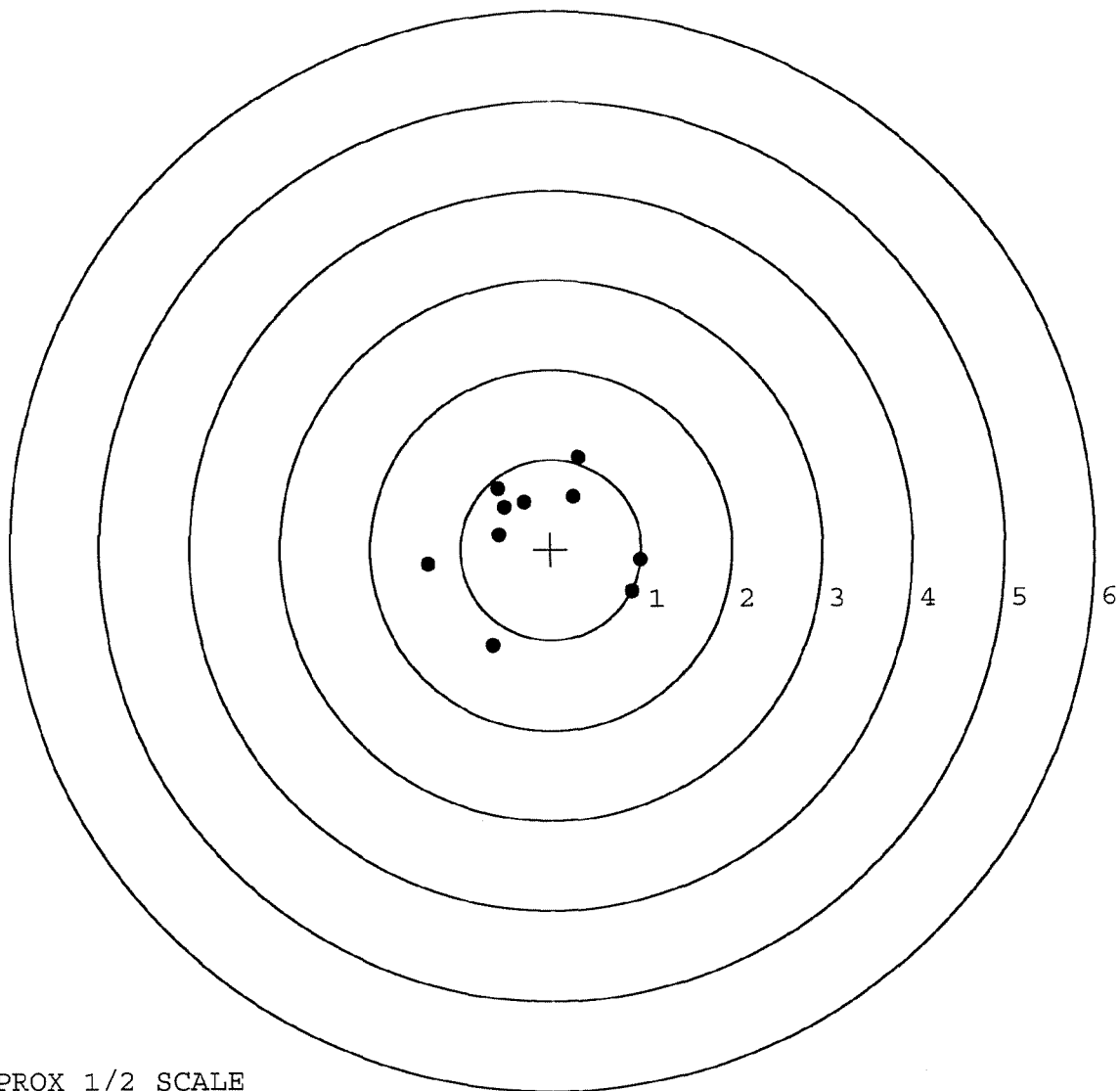
MAX RADIUS: 1.323

MEAN RADIUS: 0.849

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

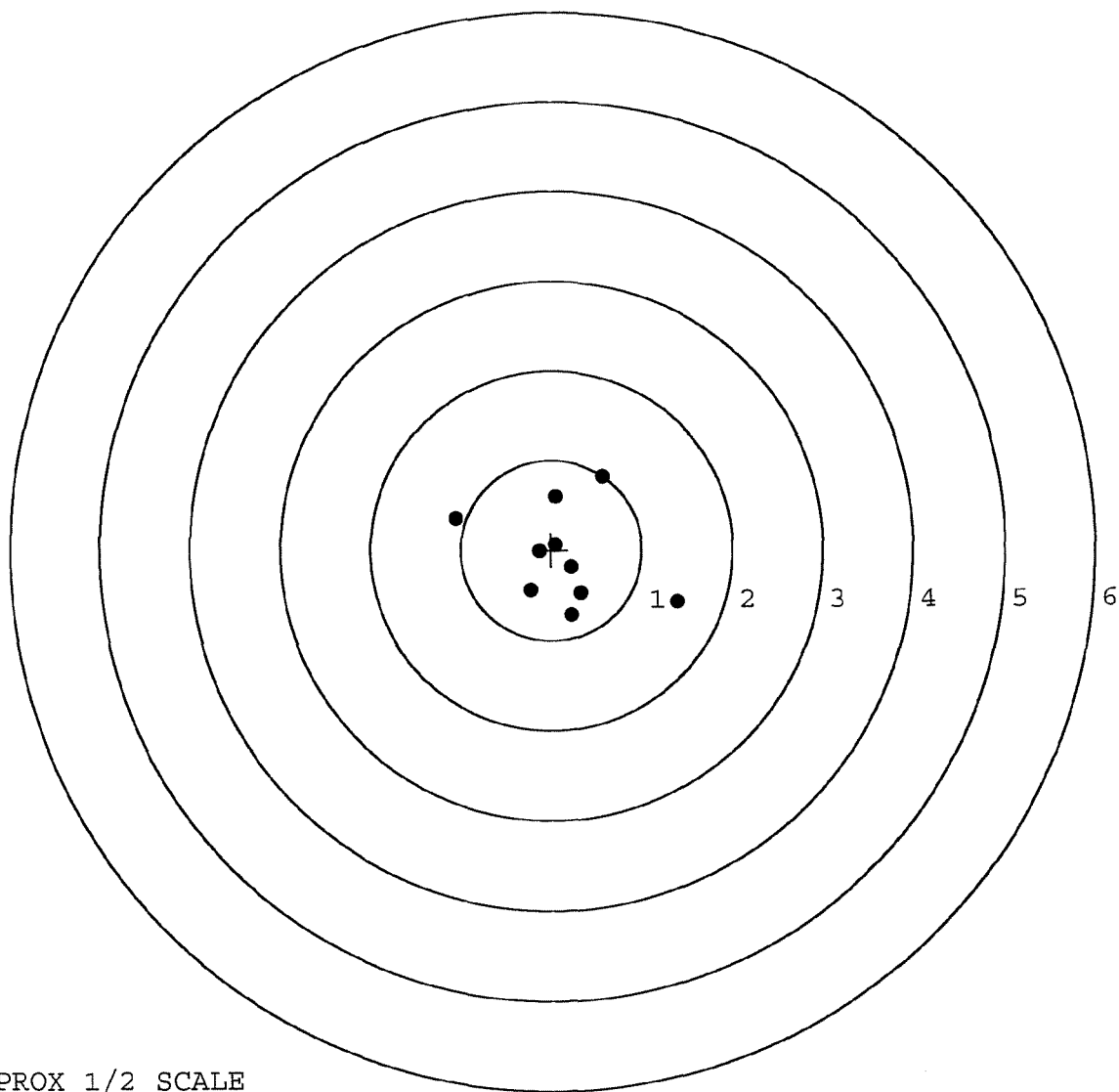


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591576. __0
 TARGET NUMBER: 4
 FILE DATE: 11/07/2006
 FILE TIME: 05:31

POINT#	X	Y
1:	1.393	-0.586
2:	0.567	0.814
3:	0.052	0.590
4:	-1.059	0.351
5:	0.221	-0.721
6:	0.330	-0.476
7:	-0.229	-0.448
8:	0.226	-0.199
9:	0.053	0.058
10:	-0.133	-0.014

X CENTROID: 0.142
 Y CENTROID: -0.063
 POA TO CENTROID: 0.155
 HORZ SPREAD: 2.452
 VERT SPREAD: 1.535
 GROUP SPREAD: 2.625
 MIN RADIUS: 0.150
 MAX RADIUS: 1.356
 MEAN RADIUS: 0.650
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



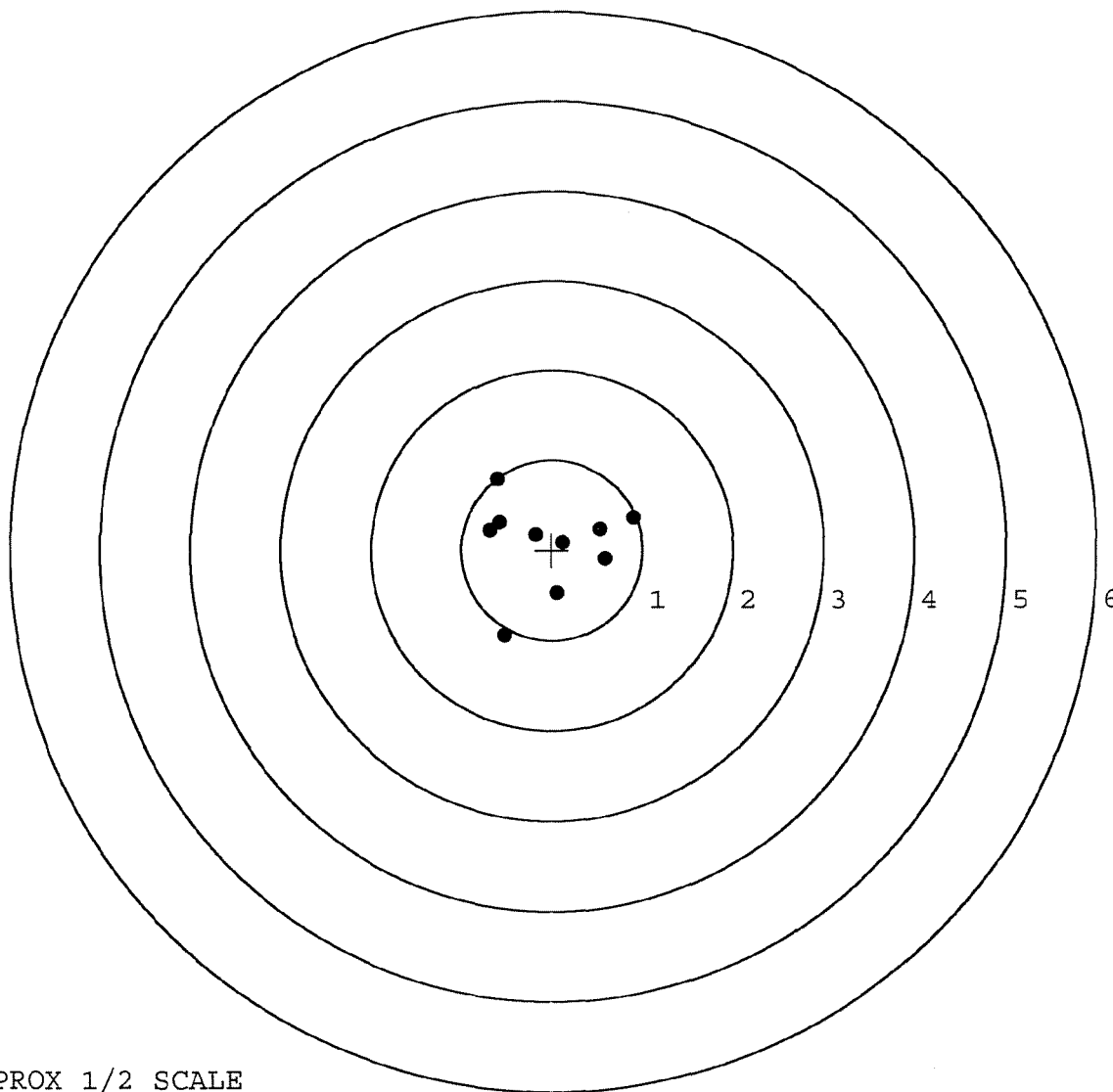
TARGET APPROX 1/2 SCALE

BARBER - M24 0168158

SERIAL NUMBER: G6591576. __0
 TARGET NUMBER: 5
 FILE DATE: 11/07/2006
 FILE TIME: 05:31

POINT#	X	Y
1:	-0.520	-0.951
2:	0.057	-0.480
3:	0.590	-0.096
4:	0.897	0.361
5:	0.528	0.235
6:	0.123	0.083
7:	-0.184	0.171
8:	-0.605	0.792
9:	-0.581	0.307
10:	-0.689	0.222

X CENTROID: -0.038
 Y CENTROID: 0.064
 POA TO CENTROID: 0.075
 HORZ SPREAD: 1.586
 VERT SPREAD: 1.743
 GROUP SPREAD: 1.931
 MIN RADIUS: 0.162
 MAX RADIUS: 1.124
 MEAN RADIUS: 0.643
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE