

G-6591585

ORDER 25716

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

UPC



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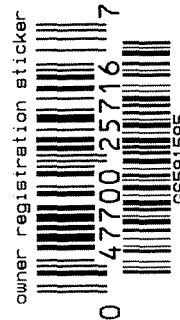
SERIAL NO.



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

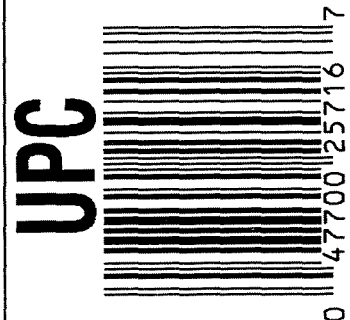
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591585



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591585

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-12-06	RTL
420	ASSEMBLE ACTION		9-20-06	RTL
430	ASSEMBLE TO STOCK		9-21-06	RP
440	PROOF		9-21-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-21-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 22 2006	9-21-06	RTL
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	9-22-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-22-06	CW
510	DRILL AND TAP SIGHT HOLES		9-21-06	TRW
520	GOFF BLAST BBL / REC		9-22-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/25	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/27	DK
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/27	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/27	DK
	D) OIL FIRING PIN ASSEMBLY		9-28-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

UP BARBER M240168312		READINGS			DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	10 ⁰	9 ⁰	8 ⁵	10-3-06 SD
CONT.						
	G) SAFETY OFF FORCE	2 LBS MIN	4 ⁵	6 ⁰	6 ⁰	10-3-06 SD
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	.020 MIN	.024	.024	.024	10-3-06 SD
	J) ASSEMBLE STOCK					9-28-06 BLC
	K) ASSEMBLE SWIVEL STUDS					11-8-06 RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					9-28-06 BLC
	M) IRON SIGHT ALIGNMENT					9-28-06 BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					9-28-06 BLC
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		
			PASS	FAIL	9-28-06	L.P.D.
	MALFUNCTION		CORRECTION			
	MALFUNCTION					
	MALFUNCTION					
	MALFUNCTION					
660	INSPECT FOR LIVE AMMO					9/28/06 M.G.D.
670	FINAL INSPECTION A) HEADSPACE					11-8-06 RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.21	2.22	2.33 2.26 2.22	9/29/06 RA
	C) FUNCTION					11-8-06 RTZ
690	PACK					11/9/06 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 9.27.06

TESTER mjm

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.65	2.54		2.33	
PULL #2	2.62	2.51		2.37	
PULL #3	2.71	2.61		2.34	
PULL #4	2.64	2.57		2.42	
PULL #5	2.79	2.59		2.39	
TOTAL	13.41	12.82		11.85	
AVERAGE	2.68	2.56		2.37	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.91		
PULL #2	3.02	2.89		
PULL #3	3.09	2.92		
PULL #4	3.05	2.94		
PULL #5	3.01	2.93		
TOTAL	15.17	14.59		
AVERAGE	3.03	2.92		

	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	4.19		4.08
PULL #2	4.07	4.18		4.16
PULL #3	3.88	4.01		4.13
PULL #4	3.93	4.21		4.10
PULL #5	3.75	4.06		4.15
TOTAL	19.66	20.65		20.62
AVERAGE	3.93	4.13		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591585.__0

FILE DATE AND TIME: 09/29/2006 01:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.245
The Average Y Centroid of the Five Target Set:	-0.108
The Average Point of Impact of the Five Target Set:	0.268
The Average Mean Radius of the Five Target Set:	0.862
The Distance from POA to Centroid Target #1:	0.116
The Distance from Centroid Target #2 to Centroid Target #1:	0.149
The Distance from Centroid Target #3 to Centroid Target #1:	0.611
The Distance from Centroid Target #4 to Centroid Target #1:	0.198
The Distance from Centroid Target #5 to Centroid Target #1:	0.346

SERIAL NUMBER: G6591585. __0

TARGET NUMBER: 1

FILE DATE: 09/29/2006

FILE TIME: 01:22

X CENTROID: -0.113

Y CENTROID: 0.025

POA TO CENTROID: 0.116

HORZ SPREAD: 2.045

VERT SPREAD: 2.161

GROUP SPREAD: 2.332

MIN RADIUS: 0.168

MAX RADIUS: 1.290

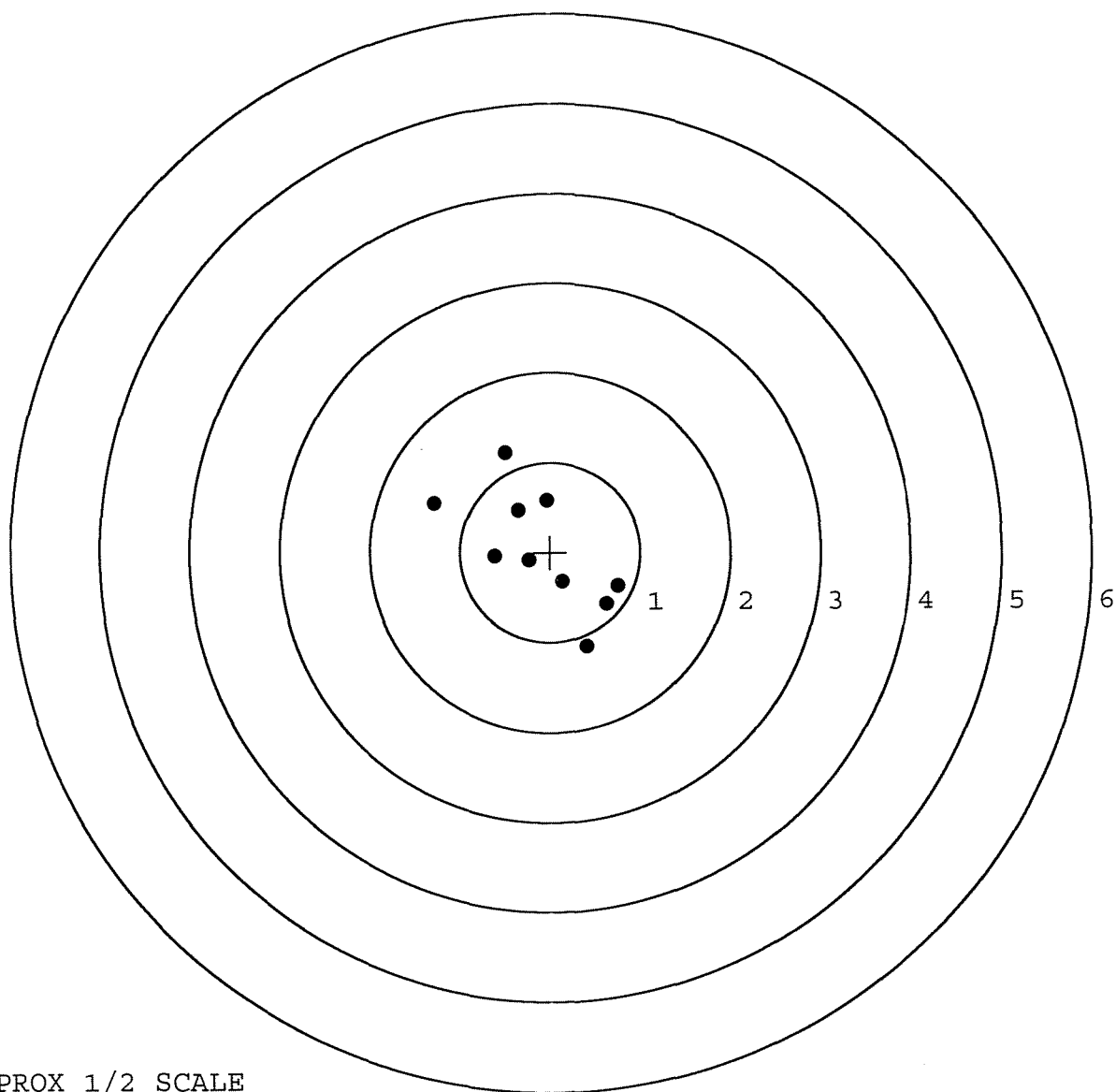
MEAN RADIUS: 0.772

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.499	1.112
2:	-0.045	0.579
3:	-0.360	0.471
4:	-1.292	0.549
5:	-0.620	-0.041
6:	-0.236	-0.090
7:	0.139	-0.330
8:	0.753	-0.378
9:	0.622	-0.575
10:	0.407	-1.049

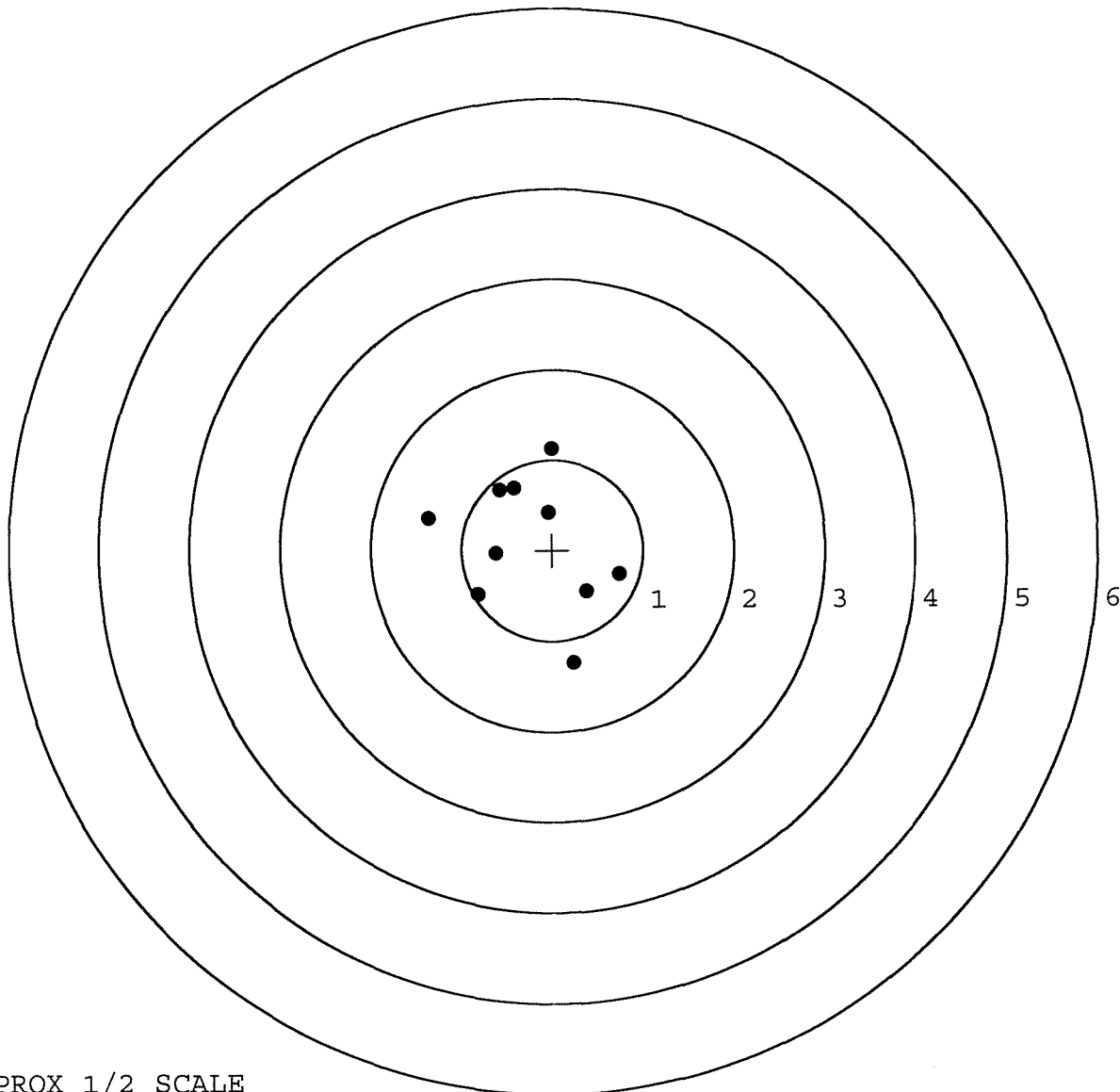


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591585. __0
 TARGET NUMBER: 2
 FILE DATE: 09/29/2006
 FILE TIME: 01:22

X CENTROID: -0.253
 Y CENTROID: 0.076
 POA TO CENTROID: 0.264
 HORZ SPREAD: 2.101
 VERT SPREAD: 2.368
 GROUP SPREAD: 2.381
 MIN RADIUS: 0.386
 MAX RADIUS: 1.407
 MEAN RADIUS: 0.840
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.824	-0.487
2:	-0.622	-0.037
3:	-0.050	0.417
4:	-0.010	1.124
5:	-0.421	0.689
6:	-0.585	0.673
7:	-1.365	0.354
8:	0.736	-0.267
9:	0.376	-0.459
10:	0.234	-1.244



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591585. __0

TARGET NUMBER: 3

FILE DATE: 09/29/2006

FILE TIME: 01:22

POINT#	X	Y
1:	1.093	-0.750
2:	0.436	-0.935
3:	0.086	-0.632
4:	-1.154	-1.196
5:	-1.704	-0.872
6:	-0.792	-0.491
7:	-0.809	-0.294
8:	-0.902	-0.073
9:	-0.286	-0.046
10:	-0.415	0.405

X CENTROID: -0.445

Y CENTROID: -0.488

POA TO CENTROID: 0.661

HORZ SPREAD: 2.797

VERT SPREAD: 1.601

GROUP SPREAD: 2.800

MIN RADIUS: 0.347

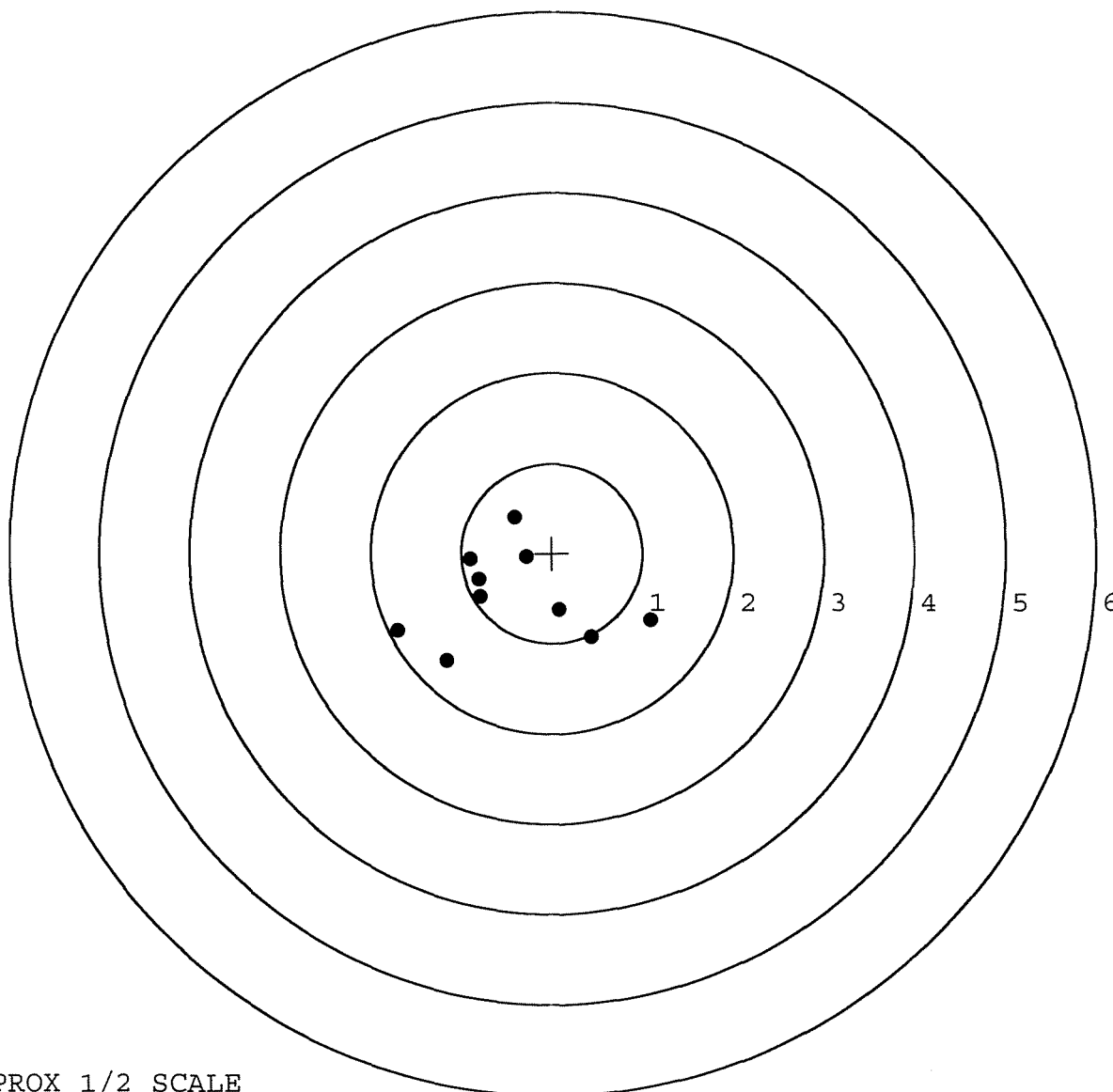
MAX RADIUS: 1.560

MEAN RADIUS: 0.816

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591585. __0

TARGET NUMBER: 4

FILE DATE: 09/29/2006

FILE TIME: 01:22

POINT#	X	Y
1:	0.846	-0.581
2:	1.080	-0.241
3:	0.591	-0.162
4:	0.125	-0.855
5:	0.146	-0.547
6:	-0.258	-0.459
7:	-0.730	-0.255
8:	-0.759	0.378
9:	-0.024	0.419
10:	-0.656	1.252

X CENTROID: 0.036

Y CENTROID: -0.105

POA TO CENTROID: 0.111

HORZ SPREAD: 1.839

VERT SPREAD: 2.107

GROUP SPREAD: 2.370

MIN RADIUS: 0.455

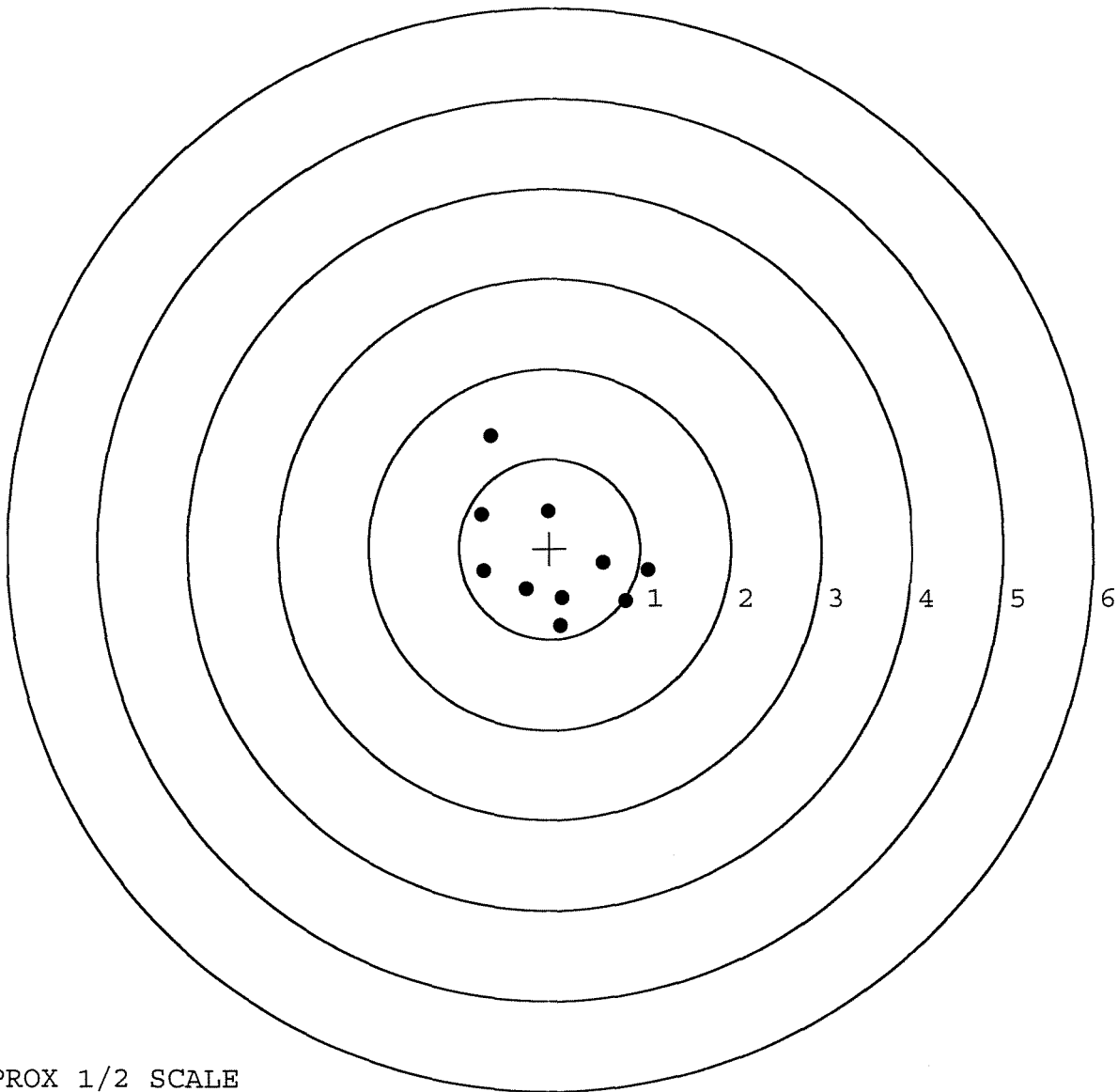
MAX RADIUS: 1.523

MEAN RADIUS: 0.798

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591585. __0

TARGET NUMBER: 5

FILE DATE: 09/29/2006

FILE TIME: 01:22

X CENTROID: -0.452

Y CENTROID: -0.045

POA TO CENTROID: 0.454

HORZ SPREAD: 3.120

VERT SPREAD: 2.426

GROUP SPREAD: 3.404

MIN RADIUS: 0.275

MAX RADIUS: 1.971

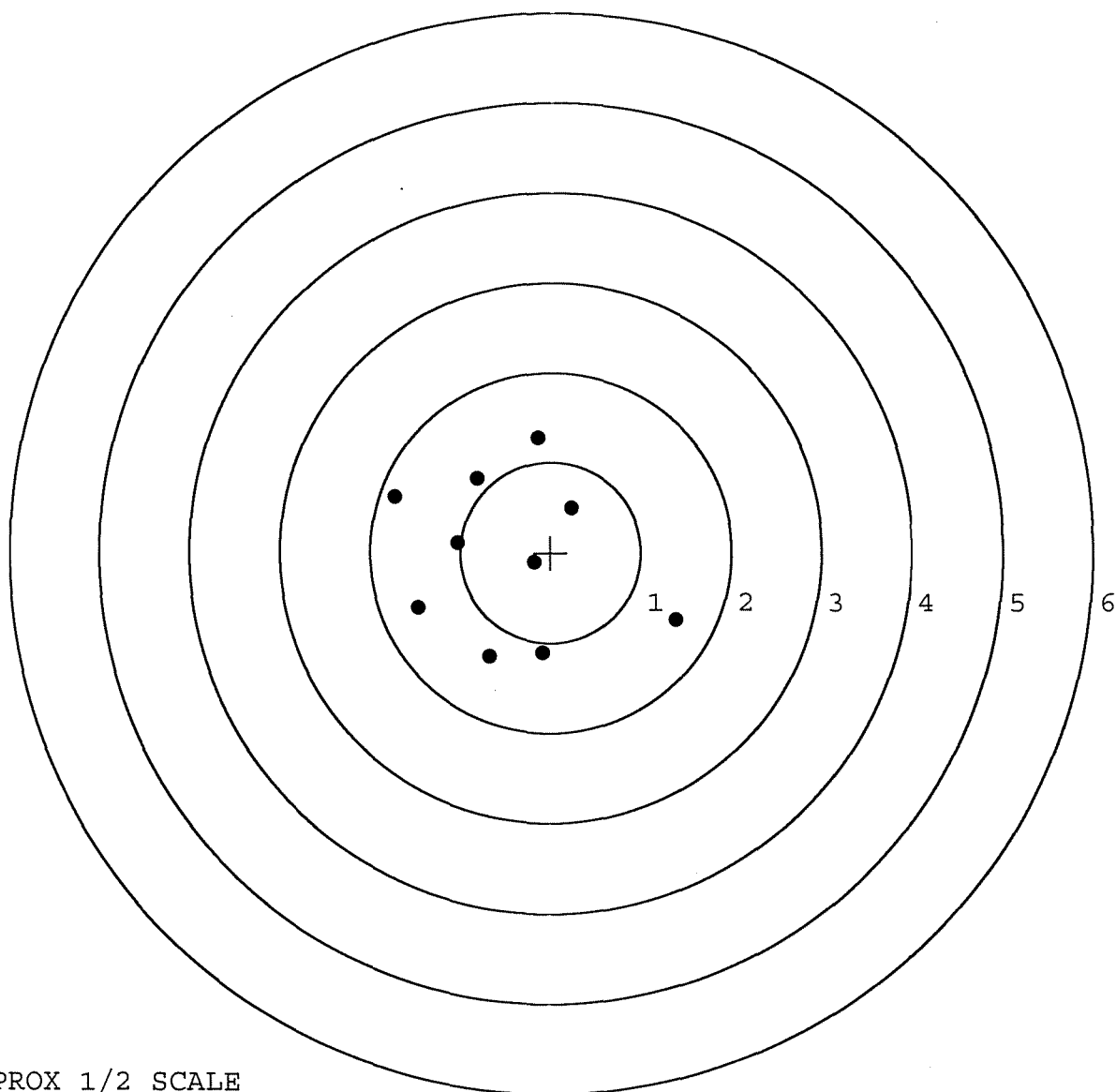
MEAN RADIUS: 1.086

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.389	-0.750
2:	-0.091	-1.115
3:	-0.678	-1.155
4:	-0.185	-0.111
5:	0.231	0.488
6:	-0.148	1.271
7:	-0.816	0.817
8:	-1.030	0.107
9:	-1.731	0.610
10:	-1.462	-0.616



TARGET APPROX 1/2 SCALE