

G 659 1589

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



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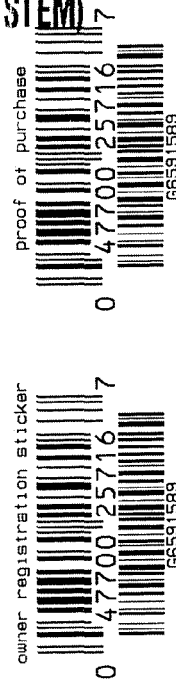
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

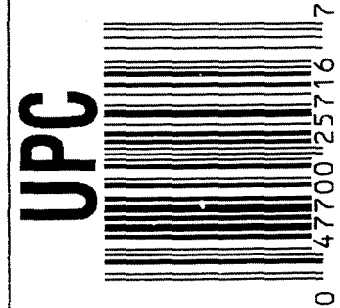


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6591589



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591589

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	BLC
420	ASSEMBLE ACTION		10-7-06	BLC
430	ASSEMBLE TO STOCK		10-7-06	WR
440	PROOF	MAGNA-FLUX INSPECTED	10-7-06	TRW
460	CHECK HEADSPACE	OCT 12 2006	10-7-06	TRW
470	DIS-ASSEMBLE ACTION	OPERATOR <i>unad</i>	10-9-06	RTZ
480	MAGNAFLUX BBL ACTION		10/12/06	<i>unad</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/10/06	CW
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-13-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/10	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		10-20-06	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-20-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-20-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-25-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP # OPERATION NAME			READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>8.0</u>	<u>8.0</u>	<u>8.0</u>	11-10-06	L.P.D.		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.0</u>	<u>2.0</u>	<u>2.0</u>	11-10-06	L.P.D.		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.026</u>	<u>.026</u>	<u>.026</u>	11-10-06	L.P.D.		
	J) ASSEMBLE STOCK					10-25-06	RT		
	K) ASSEMBLE SWIVEL STUDS					11-17-06	L.P.D.		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					10-25-06	RT		
	M) IRON SIGHT ALIGNMENT					10-25-06	RT		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					10-25-06	RT		
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u>	FAIL					
			<u>PASS</u>	FAIL		10/25/06	mm		
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					10-25-06	L.P.D.		
670	FINAL INSPECTION A) HEADSPACE					11-17-06	L.P.D.		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u>	<u>2.36</u>	<u>2.29</u>	<u>2.29</u>	<u>2.31</u>	11-10-06	RP
	C) FUNCTION							11-17-06	L.P.D.
690	PACK							25-07	DA

F004 REV 5/2006

BARBER - M24 0168348AVERAGE 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 9-14-06TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	251	230		242	
PULL #2	256	232		250	
PULL #3	259	231		258	
PULL #4	258	230		256	
PULL #5	259	225		263	
TOTAL	1283	1148		1269	
AVERAGE	256	229		253	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	316	294		
PULL #2	316	322		
PULL #3	315	300		
PULL #4	311	315		
PULL #5	294	295		
TOTAL	1552	1526		
AVERAGE	310	305		

	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	420	400		399
PULL #2	418	406		410
PULL #3	405	407		419
PULL #4	419	411		419
PULL #5	417	411		416
TOTAL	2079	2035		2063
AVERAGE	415	407		412

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591589.___0
FILE DATE AND TIME: 10/26/2006 05:46

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.041
The Average Y Centroid of the Five Target Set:	-0.036
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	0.657
The Distance from POA to Centroid Target #1:	0.169
The Distance from Centroid Target #2 to Centroid Target #1:	0.130
The Distance from Centroid Target #3 to Centroid Target #1:	0.225
The Distance from Centroid Target #4 to Centroid Target #1:	0.190
The Distance from Centroid Target #5 to Centroid Target #1:	0.108

BARBER - M24 0168350

SERIAL NUMBER: G6591589. __0

TARGET NUMBER: 1

FILE DATE: 10/26/2006

FILE TIME: 05:46

POINT#	X	Y
1:	0.280	-0.903
2:	0.369	-0.691
3:	0.130	-0.458
4:	0.687	-0.023
5:	0.369	-0.303
6:	-0.343	-0.396
7:	-0.238	-0.055
8:	0.255	0.520
9:	-0.071	0.681
10:	-0.216	0.460

X CENTROID: 0.122

Y CENTROID: -0.117

POA TO CENTROID: 0.169

HORZ SPREAD: 1.030

VERT SPREAD: 1.584

GROUP SPREAD: 1.622

MIN RADIUS: 0.309

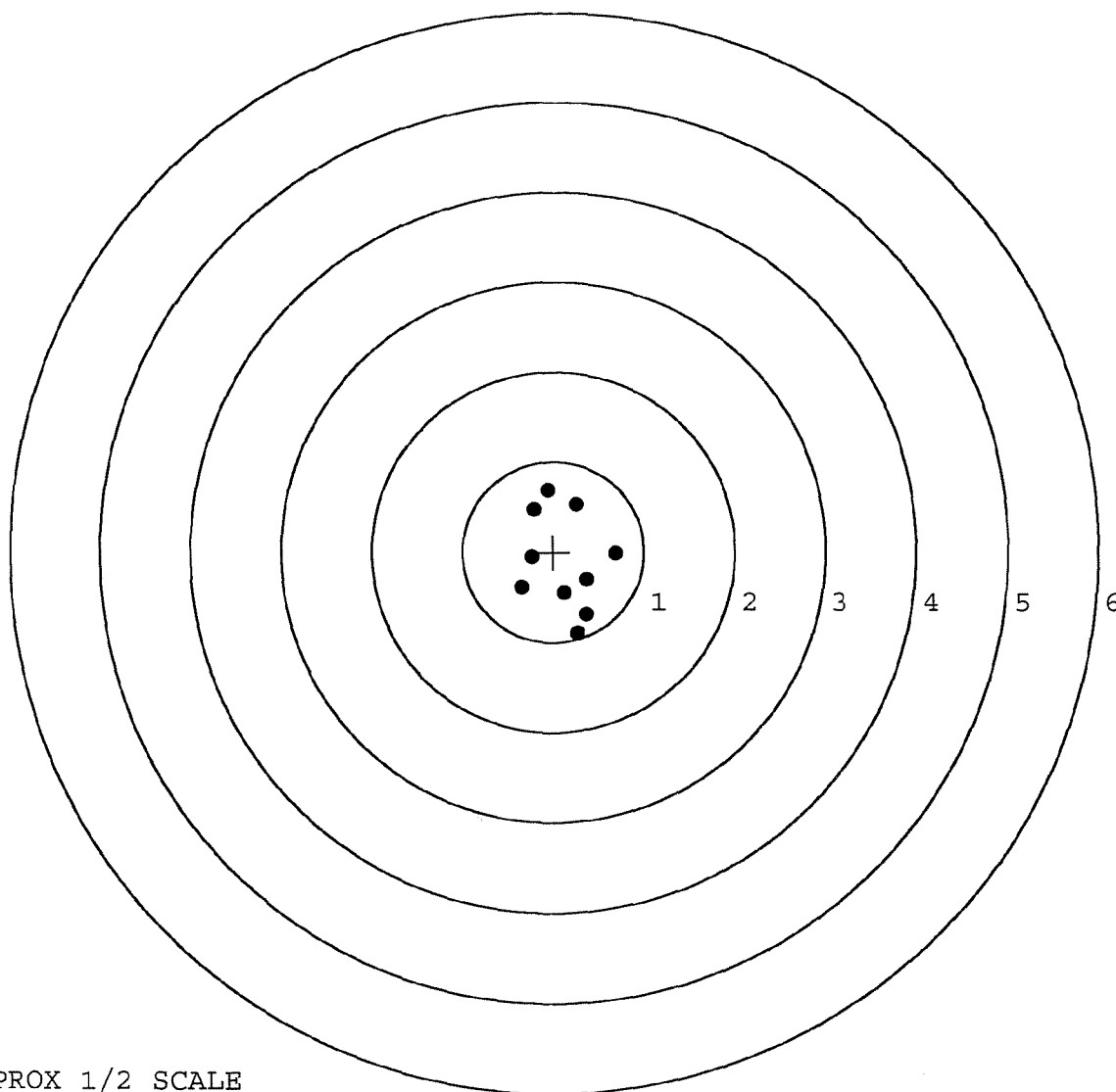
MAX RADIUS: 0.821

MEAN RADIUS: 0.570

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

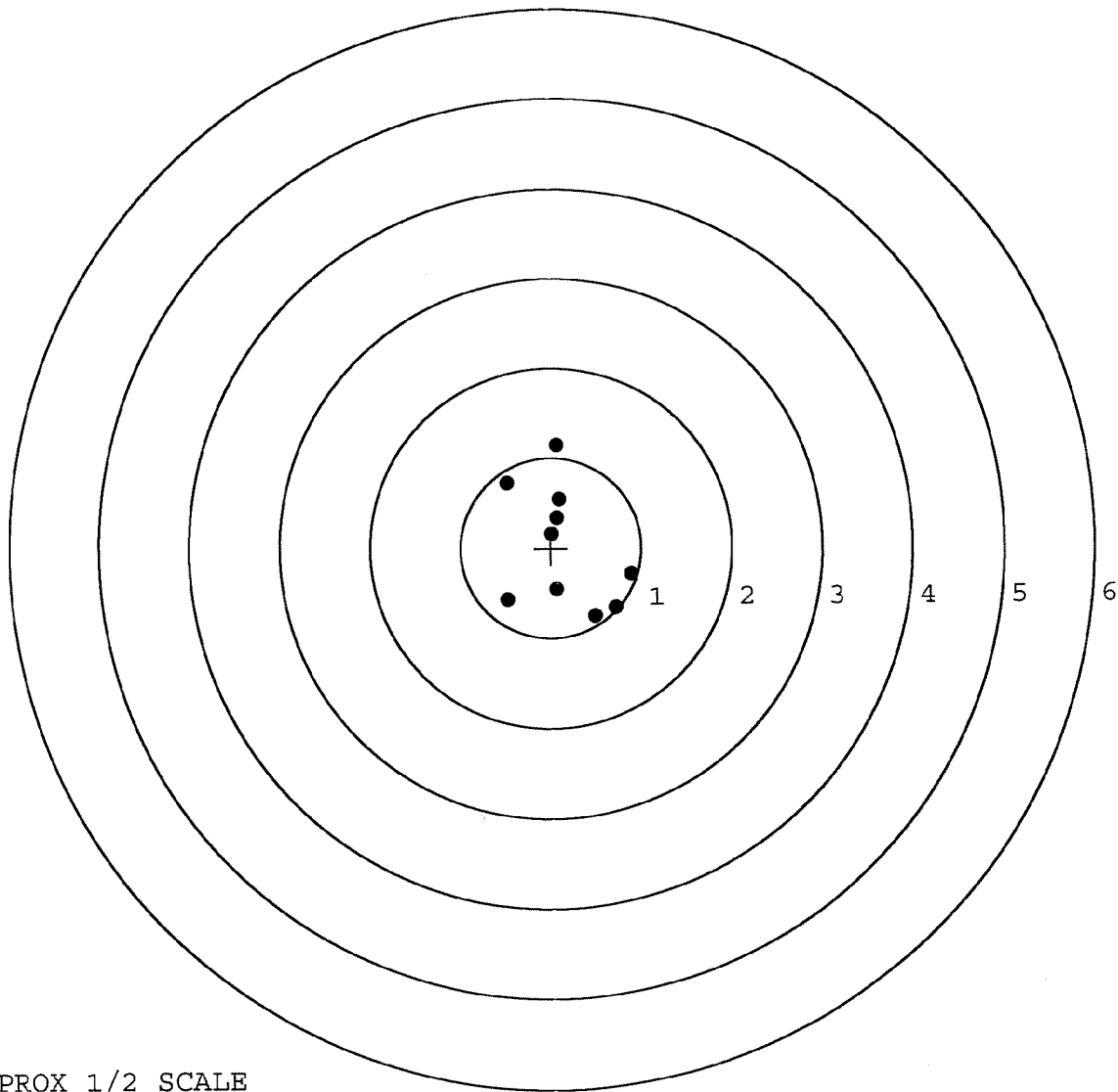


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591589. __0
 TARGET NUMBER: 2
 FILE DATE: 10/26/2006
 FILE TIME: 05:46

POINT#	X	Y
1:	-0.486	-0.577
2:	0.065	-0.464
3:	0.492	-0.766
4:	0.715	-0.673
5:	0.893	-0.298
6:	0.072	1.134
7:	-0.483	0.725
8:	0.094	0.540
9:	0.012	0.159
10:	0.071	0.336

X CENTROID: 0.145
 Y CENTROID: 0.012
 POA TO CENTROID: 0.145
 HORZ SPREAD: 1.379
 VERT SPREAD: 1.900
 GROUP SPREAD: 1.946
 MIN RADIUS: 0.198
 MAX RADIUS: 1.125
 MEAN RADIUS: 0.703
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591589. __0

TARGET NUMBER: 3

FILE DATE: 10/26/2006

FILE TIME: 05:46

POINT#	X	Y
1:	0.581	-0.515
2:	0.440	-0.367
3:	-0.455	-0.390
4:	0.696	0.521
5:	0.058	0.770
6:	-0.780	0.218
7:	-1.094	0.037
8:	0.016	0.253
9:	0.010	-0.036
10:	0.120	-0.112

X CENTROID: -0.041

Y CENTROID: 0.038

POA TO CENTROID: 0.056

HORZ SPREAD: 1.790

VERT SPREAD: 1.285

GROUP SPREAD: 1.854

MIN RADIUS: 0.090

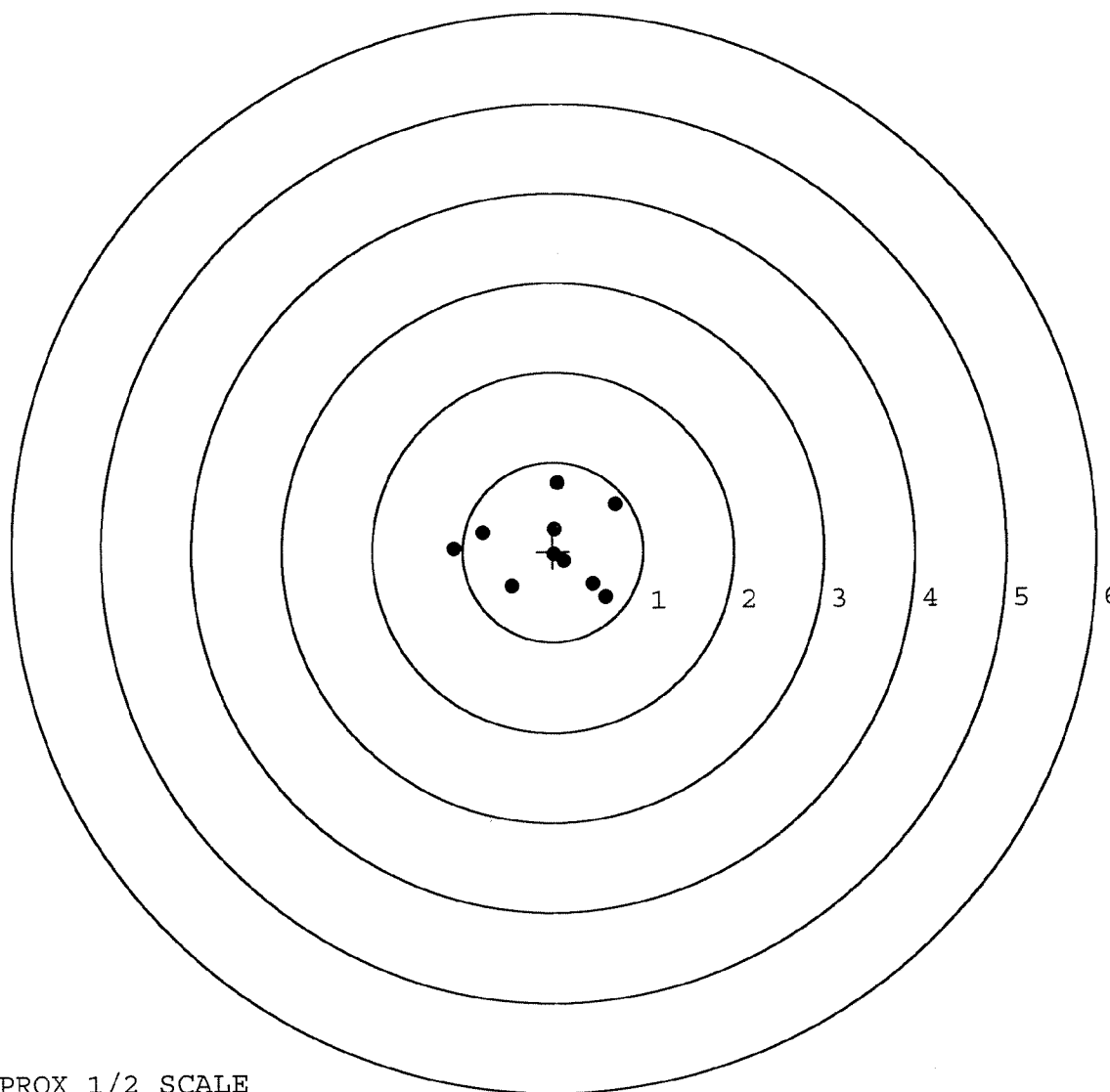
MAX RADIUS: 1.053

MEAN RADIUS: 0.602

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591589. 0

TARGET NUMBER: 4

FILE DATE: 10/26/2006

FILE TIME: 05:46

POINT#	X	Y
1:	0.515	-0.756
2:	0.273	-0.668
3:	-0.039	-0.686
4:	-0.037	-0.277
5:	0.355	0.121
6:	0.399	0.587
7:	0.014	0.887
8:	-0.318	0.146
9:	-0.483	-0.337
10:	-1.291	0.318

X CENTROID: -0.061

Y CENTROID: -0.066

POA TO CENTROID: 0.090

HORZ SPREAD: 1.806

VERT SPREAD: 1.643

GROUP SPREAD: 2.101

MIN RADIUS: 0.212

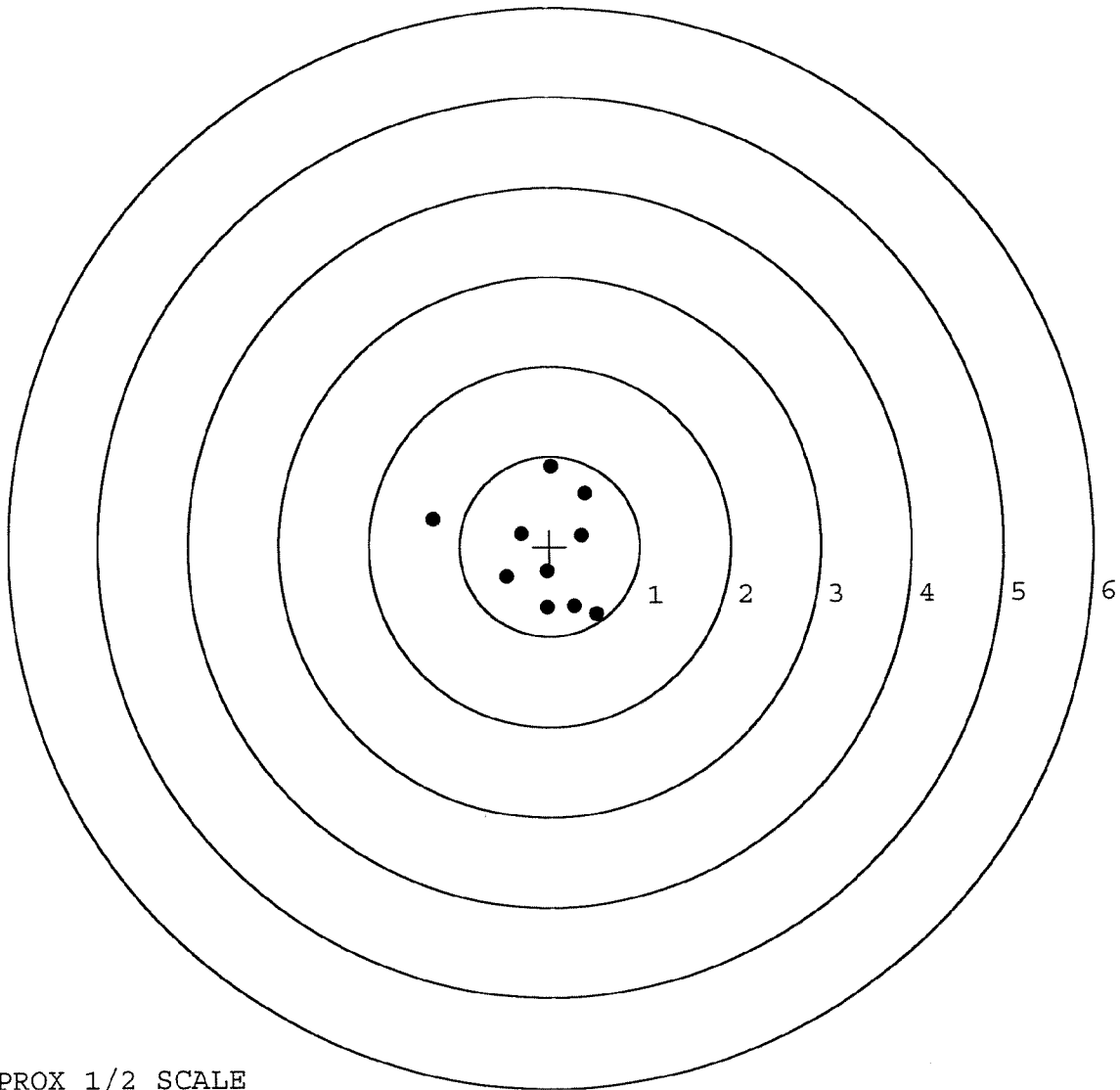
MAX RADIUS: 1.289

MEAN RADIUS: 0.675

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0168354

SERIAL NUMBER: G6591589. __0

TARGET NUMBER: 5

FILE DATE: 10/26/2006

FILE TIME: 05:46

POINT#	X	Y
1:	0.392	-0.858
2:	0.348	-0.382
3:	1.013	-0.114
4:	0.658	0.208
5:	0.195	0.621
6:	-0.080	-0.305
7:	-0.476	0.639
8:	-0.626	0.044
9:	-1.046	-0.259

X CENTROID: 0.042

Y CENTROID: -0.045

POA TO CENTROID: 0.062

HORZ SPREAD: 2.059

VERT SPREAD: 1.497

GROUP SPREAD: 2.064

MIN RADIUS: 0.287

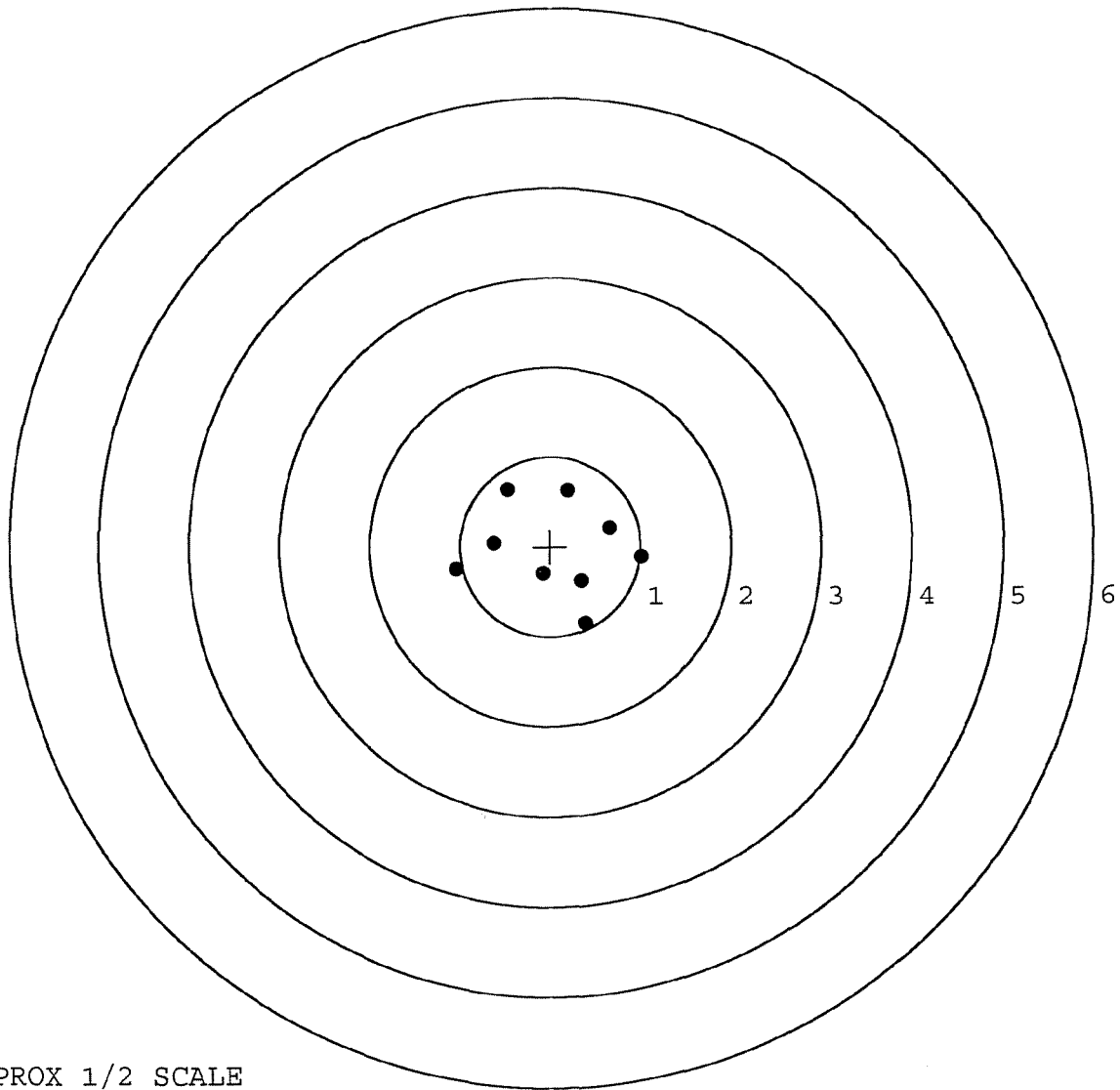
MAX RADIUS: 1.109

MEAN RADIUS: 0.732

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE