

G-6591600

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



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UPC



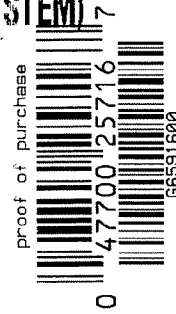
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

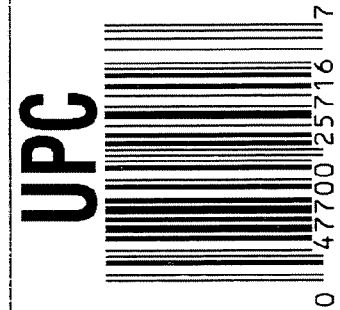


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6591600



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591600

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	RJC
420	ASSEMBLE ACTION		10-6-06	BLC
430	ASSEMBLE TO STOCK		10-7-06	WK
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	RJC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CIPD</u>	10-10-06	APD
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		10-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/18/06	FB
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	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-25-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-3-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP # 660 PERM 0150176			READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>49</u>	<u>45</u>	<u>45</u>	11-4-06	SD		
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>75</u>	<u>75</u>	<u>75</u>	11-4-06	SD		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u>	<u>.025</u>	<u>.025</u>	11-4-06	SD		
	J) ASSEMBLE STOCK					11-3-06	BLG		
	K) ASSEMBLE SWIVEL STUDS					11-17-06	LRD		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					11-17-06	RR		
	M) IRON SIGHT ALIGNMENT					11-17-06	RR		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					11-17-06	RR		
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u>	FAIL		11-6-06	mm		
			<u>PASS</u>	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					11-6-06	SD		
670	FINAL INSPECTION A) HEADSPACE					11-17-06	LRD		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u>	<u>2.27</u>	<u>2.30</u>	<u>2.30</u>	<u>2.30</u>	11-13-06	SD
	C) FUNCTION					11-17-06	LRD		
690	PACK					2-5-07	RA		

F004 REV 5/2006

BARBER - M24 0168477AVERAGE 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 10-31-06TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.32		2.55	
PULL #2	2.58	2.18		2.48	
PULL #3	2.52	2.18		2.40	
PULL #4	2.21	2.19		2.48	
PULL #5	2.62	2.02		2.57	
TOTAL	1241	1089		1248	
AVERAGE	248	217		249	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.23		
PULL #2	3.24 ^{SD}	3.04		
PULL #3	3.23	2.94		
PULL #4	3.19	2.95		
PULL #5	3.16	2.92		
TOTAL	1600	1508		
AVERAGE	320	301		

	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	4.11	4.08		4.28
PULL #2	4.00	3.95		4.23
PULL #3	3.95	3.91		4.19
PULL #4	3.99	3.97		4.20
PULL #5	3.97	3.92		4.24
TOTAL	2002	1983		2114
AVERAGE	400	396		422

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591600.___0
FILE DATE AND TIME: 11/07/2006 06:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.040
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.679
The Distance from POA to Centroid Target #1:	0.083
The Distance from Centroid Target #2 to Centroid Target #1:	0.081
The Distance from Centroid Target #3 to Centroid Target #1:	0.072
The Distance from Centroid Target #4 to Centroid Target #1:	0.119
The Distance from Centroid Target #5 to Centroid Target #1:	0.168

SERIAL NUMBER: G6591600. __ 0

TARGET NUMBER: 1

FILE DATE: 11/07/2006

FILE TIME: 06:04

POINT#	X	Y
1:	-1.184	0.466
2:	-0.263	-1.360
3:	1.006	-0.213
4:	0.541	0.146
5:	0.355	-0.050
6:	-0.080	-0.480
7:	-0.189	-0.202
8:	0.101	0.475
9:	-0.249	0.317
10:	0.254	0.123

X CENTROID: 0.029

Y CENTROID: -0.078

POA TO CENTROID: 0.083

HORZ SPREAD: 2.190

VERT SPREAD: 1.835

GROUP SPREAD: 2.293

MIN RADIUS: 0.251

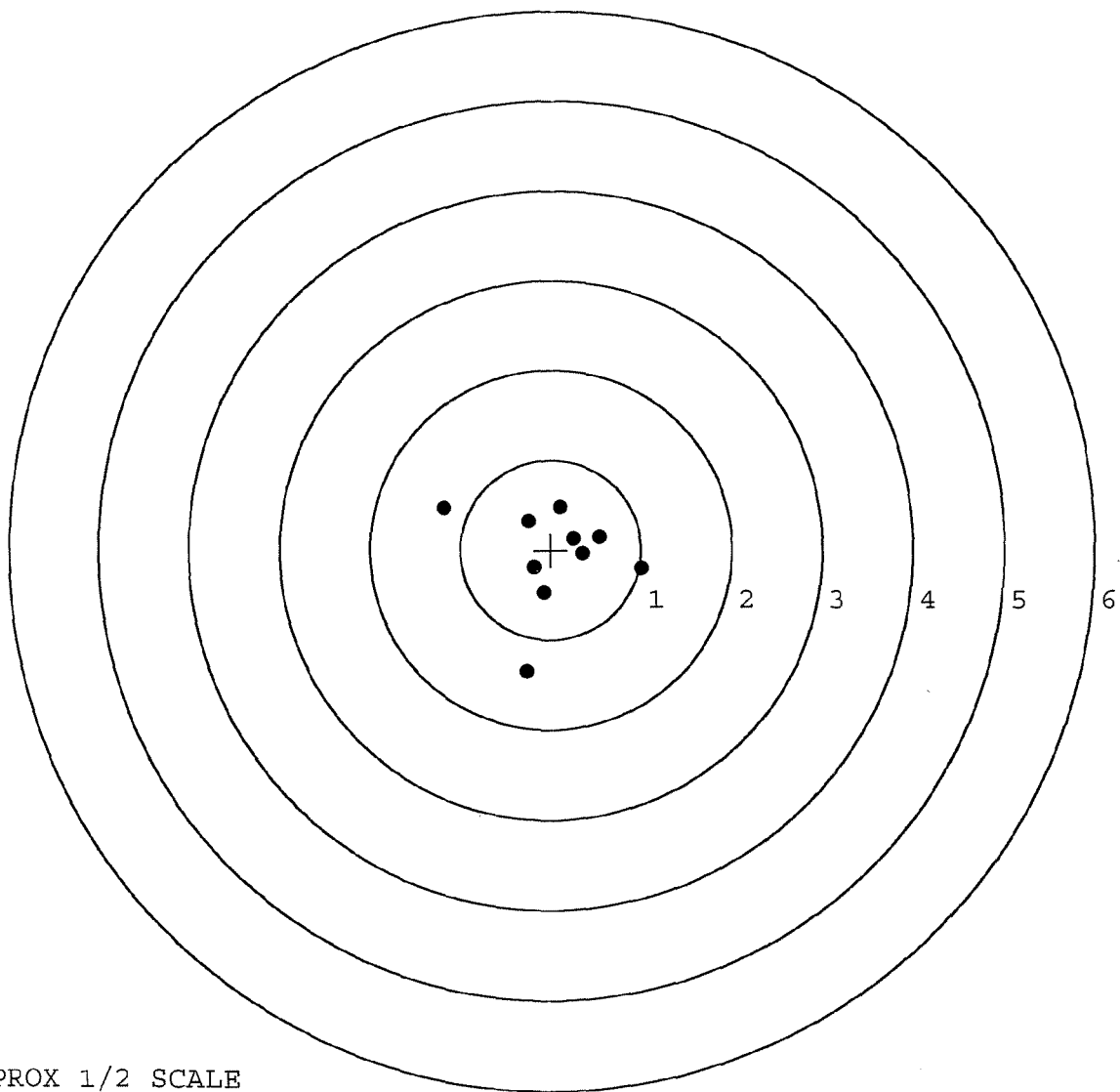
MAX RADIUS: 1.330

MEAN RADIUS: 0.653

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0168480

SERIAL NUMBER: G6591600. __0

TARGET NUMBER: 2

FILE DATE: 11/07/2006

FILE TIME: 06:04

POINT#	X	Y
1:	0.966	-1.035
2:	0.558	-1.021
3:	-0.344	-0.989
4:	-1.310	0.273
5:	0.470	0.078
6:	-0.008	-0.044
7:	-0.550	0.096
8:	0.096	0.352
9:	-0.260	0.382
10:	0.003	0.673

X CENTROID: -0.038

Y CENTROID: -0.124

POA TO CENTROID: 0.129

HORZ SPREAD: 2.276

VERT SPREAD: 1.708

GROUP SPREAD: 2.625

MIN RADIUS: 0.085

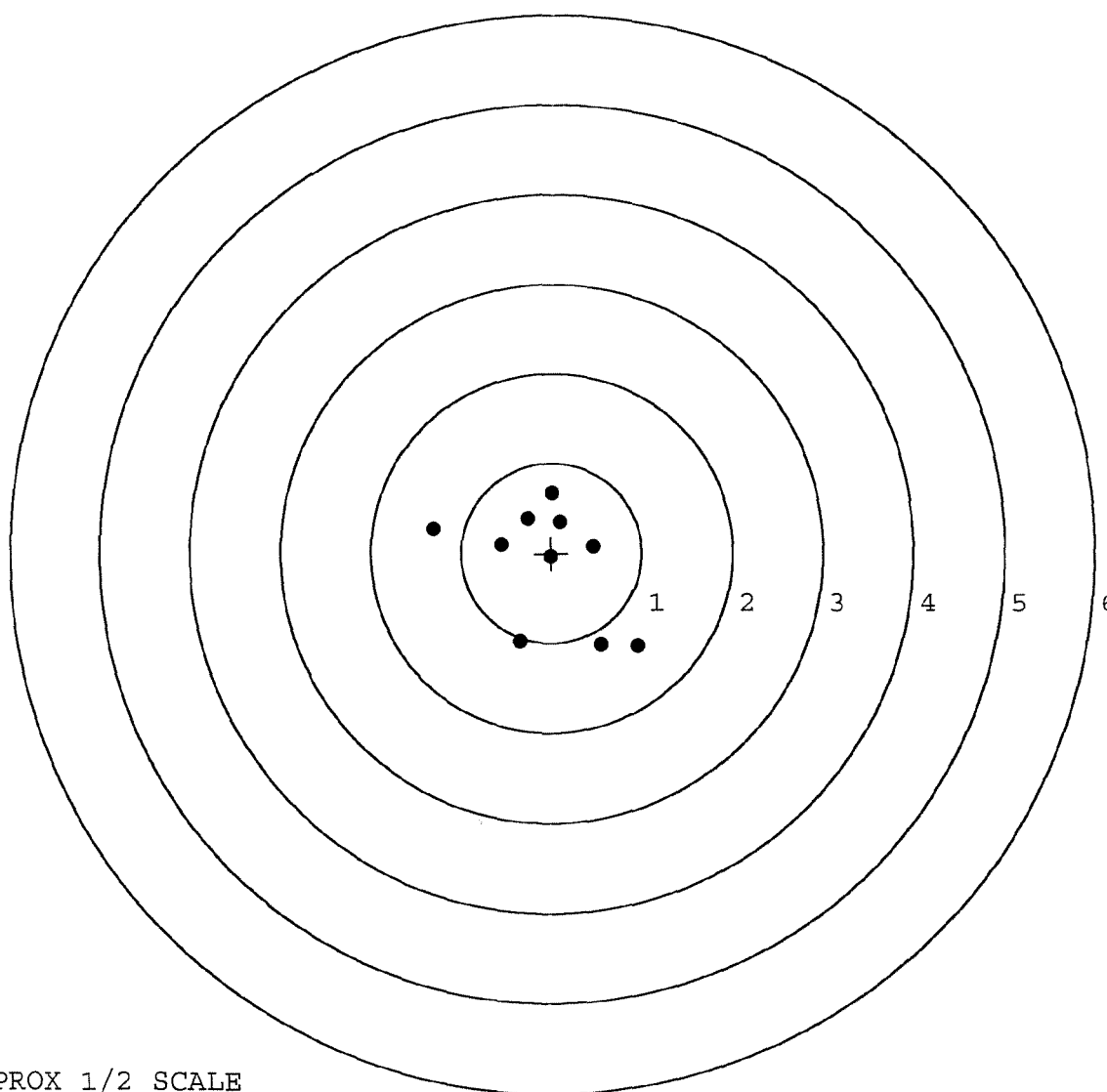
MAX RADIUS: 1.356

MEAN RADIUS: 0.772

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591600. __0

TARGET NUMBER: 3

FILE DATE: 11/07/2006

FILE TIME: 06:04

POINT#	X	Y
1:	0.988	-0.339
2:	0.683	-0.267
3:	-0.171	-0.468
4:	-0.376	-0.683
5:	-1.204	-0.532
6:	-0.707	0.659
7:	-0.007	0.584
8:	0.097	0.366
9:	0.385	0.252
10:	0.082	0.139

X CENTROID: -0.023

Y CENTROID: -0.029

POA TO CENTROID: 0.037

HORZ SPREAD: 2.192

VERT SPREAD: 1.342

GROUP SPREAD: 2.200

MIN RADIUS: 0.198

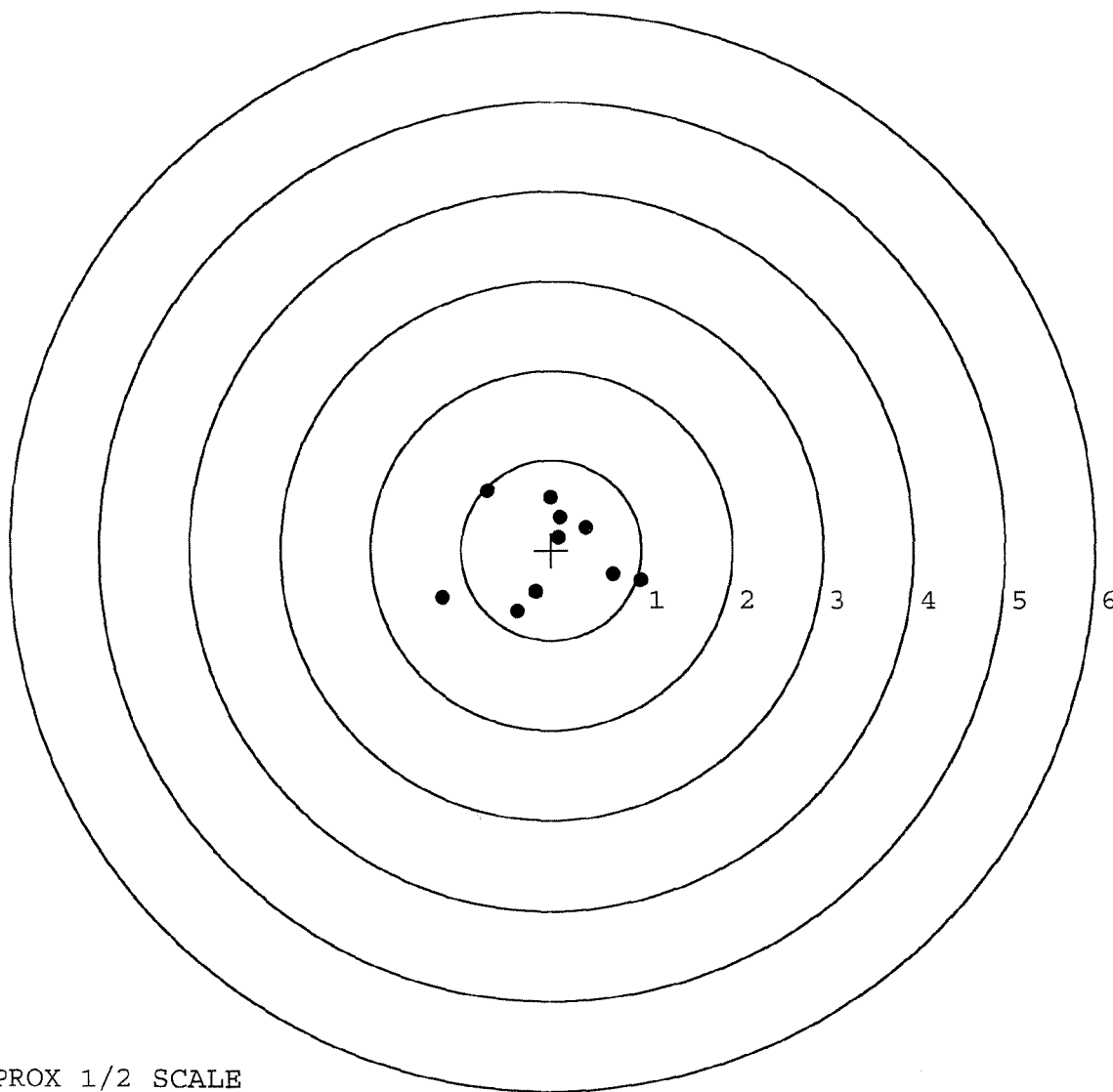
MAX RADIUS: 1.284

MEAN RADIUS: 0.698

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591600. __0

TARGET NUMBER: 4

FILE DATE: 11/07/2006

FILE TIME: 06:04

POINT#	X	Y
1:	-0.665	-0.830
2:	-0.886	-0.554
3:	0.796	-0.297
4:	0.559	-0.238
5:	-0.270	-0.099
6:	-0.289	0.225
7:	0.206	0.042
8:	0.206	0.370
9:	0.427	0.613
10:	-0.490	0.950

X CENTROID: -0.041

Y CENTROID: 0.018

POA TO CENTROID: 0.044

HORZ SPREAD: 1.682

VERT SPREAD: 1.780

GROUP SPREAD: 1.810

MIN RADIUS: 0.248

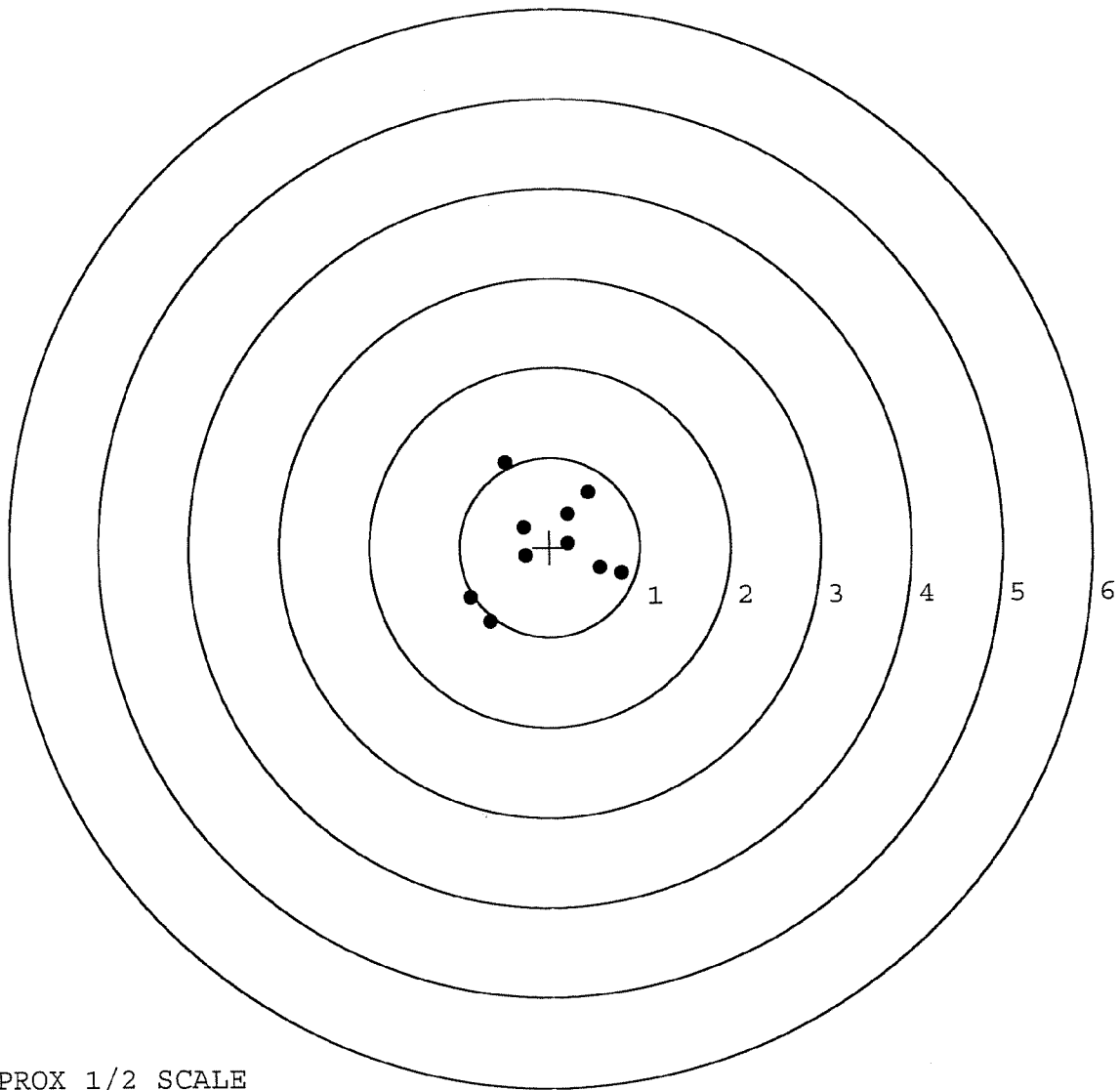
MAX RADIUS: 1.053

MEAN RADIUS: 0.667

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591600. __0

TARGET NUMBER: 5

FILE DATE: 11/07/2006

FILE TIME: 06:04

POINT#	X	Y
1:	-1.167	-0.908
2:	0.480	-0.494
3:	0.817	0.193
4:	-0.343	-0.389
5:	0.391	-0.067
6:	0.083	-0.016
7:	-0.015	0.285
8:	-0.354	0.186
9:	-0.769	0.271
10:	-0.419	-0.374

X CENTROID: -0.130

Y CENTROID: -0.131

POA TO CENTROID: 0.184

HORZ SPREAD: 1.984

VERT SPREAD: 1.193

GROUP SPREAD: 2.269

MIN RADIUS: 0.242

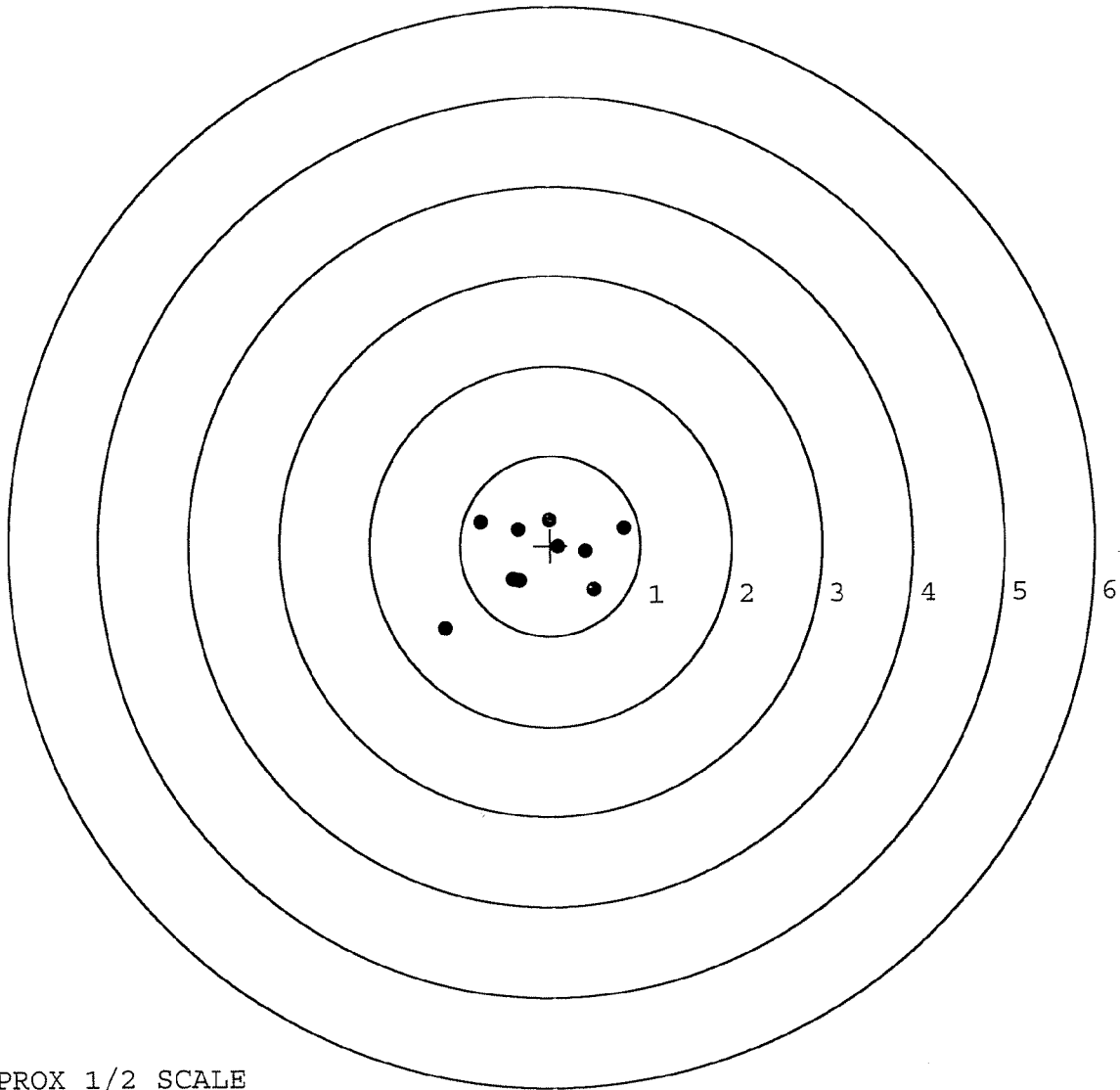
MAX RADIUS: 1.296

MEAN RADIUS: 0.606

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE