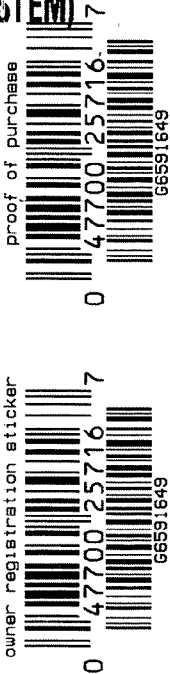


G659 1649

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

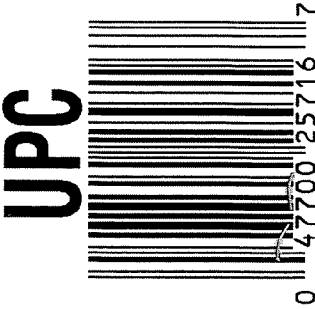
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591649



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



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



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591649

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-12-06	RTZ
420	ASSEMBLE ACTION		9-20-06	RTZ
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	RTZ
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	MR
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/26/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/26/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/26/06	DA
	D) OIL FIRING PIN ASSEMBLY		9-26-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/16/06	MR

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7°</u> <u>6°</u> <u>7°</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6°</u> <u>6°</u> <u>5°</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/06	NOTM
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.027</u> <u>.027</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-26-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10/16/06	NOTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-26-06	BLC
	M) IRON SIGHT ALIGNMENT		9-26-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-26-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-26-06	R.P.D.
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/26/06	MPD
670	FINAL INSPECTION A) HEADSPACE		10/16/06	NOTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.25</u> <u>2.33</u> <u>2.43</u> <u>2.43</u>	9/28/06	DA
	C) FUNCTION		10/16/06	NOTM
690	PACK		11/7/06	DA

F004 REV 5/2006

BARBER - M24 0169121
**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 9-26-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	251	240		260	
PULL #2	257	232		259	
PULL #3	260	230		251	
PULL #4	263	234		252	
PULL #5	262	233		256	
TOTAL	1293	1169		1278	
AVERAGE	258	233		255	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	318	316		
PULL #2	313	309		
PULL #3	321	307		
PULL #4	314	312		
PULL #5	319	313		
TOTAL	1585	1557		
AVERAGE	317	311		

	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	415	408		412
PULL #2	408	405		413
PULL #3	405	404		414
PULL #4	408	402		413
PULL #5	407	403		413
TOTAL	2043	2022		2065
AVERAGE	408	404		413

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591649.__0
FILE DATE AND TIME: 09/27/2006 05:40

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.081
The Average Y Centroid of the Five Target Set:	-0.109
The Average Point of Impact of the Five Target Set:	0.136
The Average Mean Radius of the Five Target Set:	0.872
The Distance from POA to Centroid Target #1:	0.149
The Distance from Centroid Target #2 to Centroid Target #1:	0.163
The Distance from Centroid Target #3 to Centroid Target #1:	0.076
The Distance from Centroid Target #4 to Centroid Target #1:	0.129
The Distance from Centroid Target #5 to Centroid Target #1:	0.116

SERIAL NUMBER: G6591649. 0

TARGET NUMBER: 1

FILE DATE: 09/27/2006

FILE TIME: 05:40

X CENTROID: -0.082

Y CENTROID: -0.124

POA TO CENTROID: 0.149

HORZ SPREAD: 3.272

VERT SPREAD: 2.132

GROUP SPREAD: 3.476

MIN RADIUS: 0.405

MAX RADIUS: 1.885

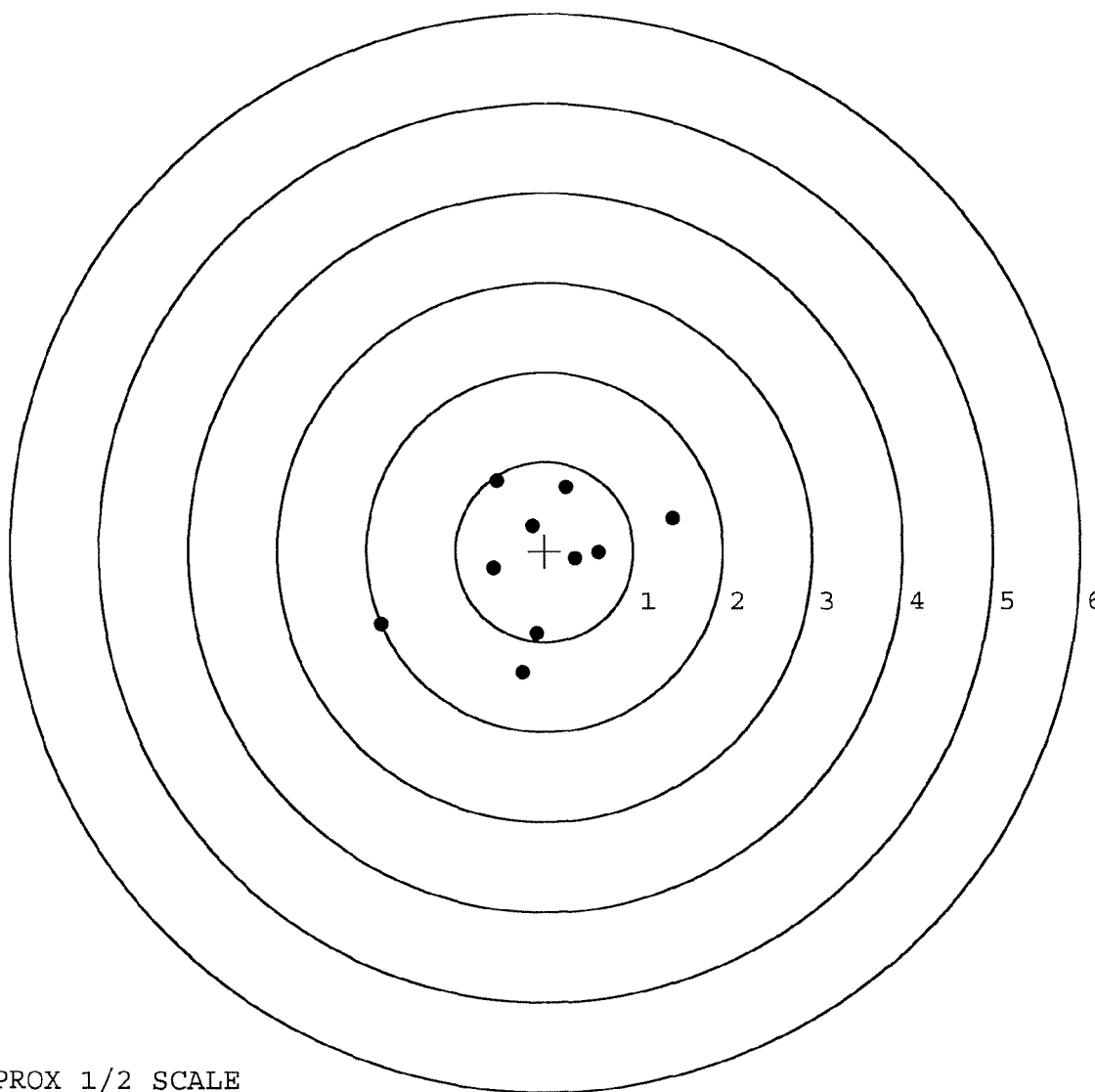
MEAN RADIUS: 0.945

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-1.837	-0.813
2:	-0.252	-1.350
3:	-0.096	-0.916
4:	1.435	0.360
5:	-0.576	-0.191
6:	-0.146	0.276
7:	0.239	0.710
8:	-0.545	0.782
9:	0.610	-0.018
10:	0.344	-0.083



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591649. 0

TARGET NUMBER: 2

FILE DATE: 09/27/2006

FILE TIME: 05:40

POINT#	X	Y
1:	-1.544	-1.318
2:	-0.655	-0.612
3:	-0.785	-0.198
4:	-0.454	0.238
5:	0.287	-0.019
6:	0.519	0.198
7:	0.067	0.382
8:	1.415	0.597
9:	0.183	1.037
10:	0.415	0.055

X CENTROID: -0.055

Y CENTROID: 0.036

POA TO CENTROID: 0.066

HORZ SPREAD: 2.959

VERT SPREAD: 2.355

GROUP SPREAD: 3.525

MIN RADIUS: 0.347

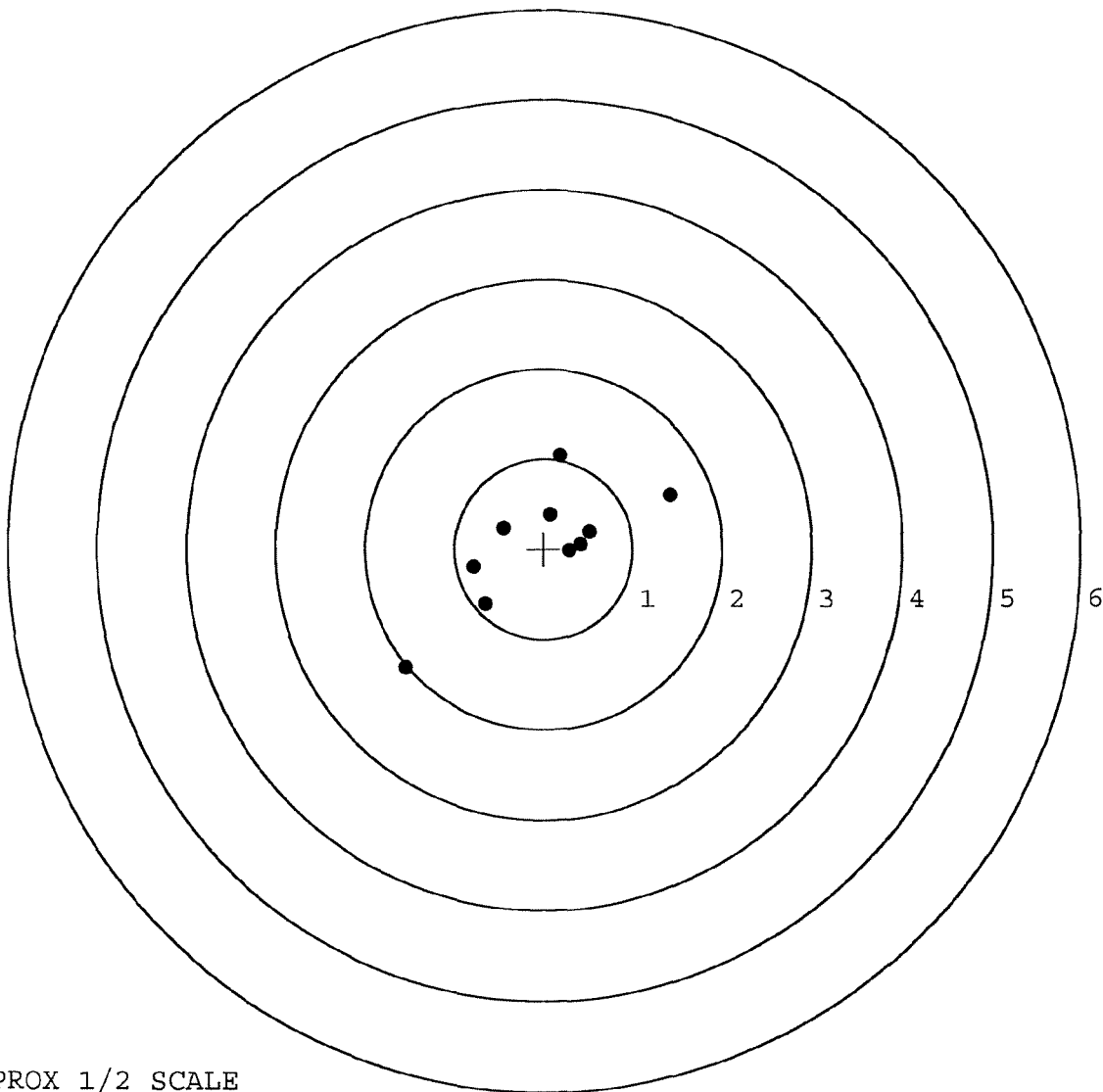
MAX RADIUS: 2.012

MEAN RADIUS: 0.849

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591649. 0

TARGET NUMBER: 3

FILE DATE: 09/27/2006

FILE TIME: 05:40

POINT#	X	Y
1:	-0.728	-1.438
2:	0.302	-1.166
3:	0.296	-0.691
4:	0.521	-0.519
5:	1.469	0.204
6:	-0.039	-0.001
7:	-0.497	-0.050
8:	-0.092	0.593
9:	-0.831	0.570
10:	-1.347	0.507

X CENTROID: -0.095

Y CENTROID: -0.199

POA TO CENTROID: 0.220

HORZ SPREAD: 2.816

VERT SPREAD: 2.031

GROUP SPREAD: 2.832

MIN RADIUS: 0.206

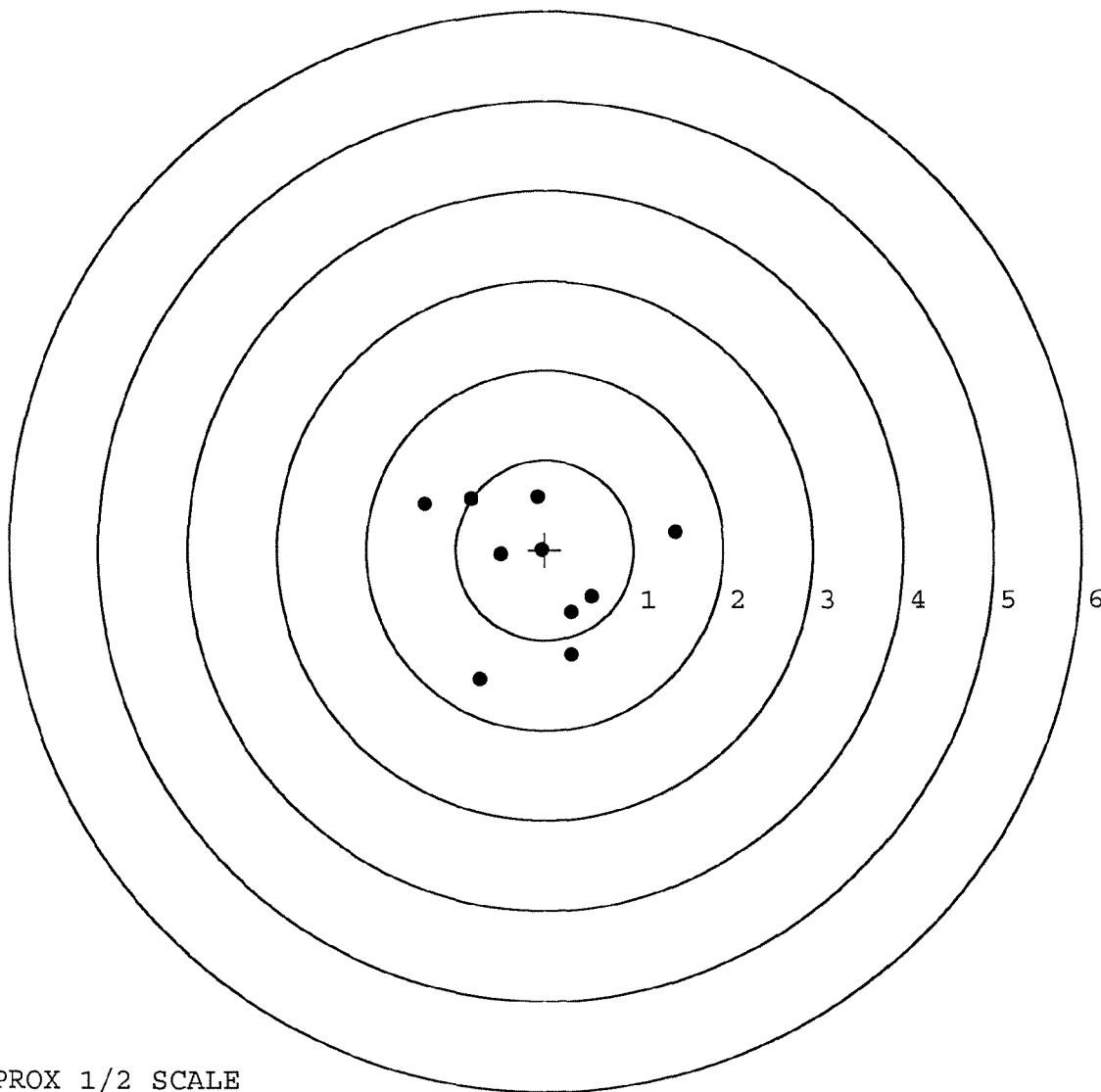
MAX RADIUS: 1.615

MEAN RADIUS: 0.930

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591649. 0

TARGET NUMBER: 4

FILE DATE: 09/27/2006

FILE TIME: 05:40

X CENTROID: -0.181

Y CENTROID: -0.207

POA TO CENTROID: 0.275

HORZ SPREAD: 1.882

VERT SPREAD: 2.184

GROUP SPREAD: 2.300

MIN RADIUS: 0.172

MAX RADIUS: 1.537

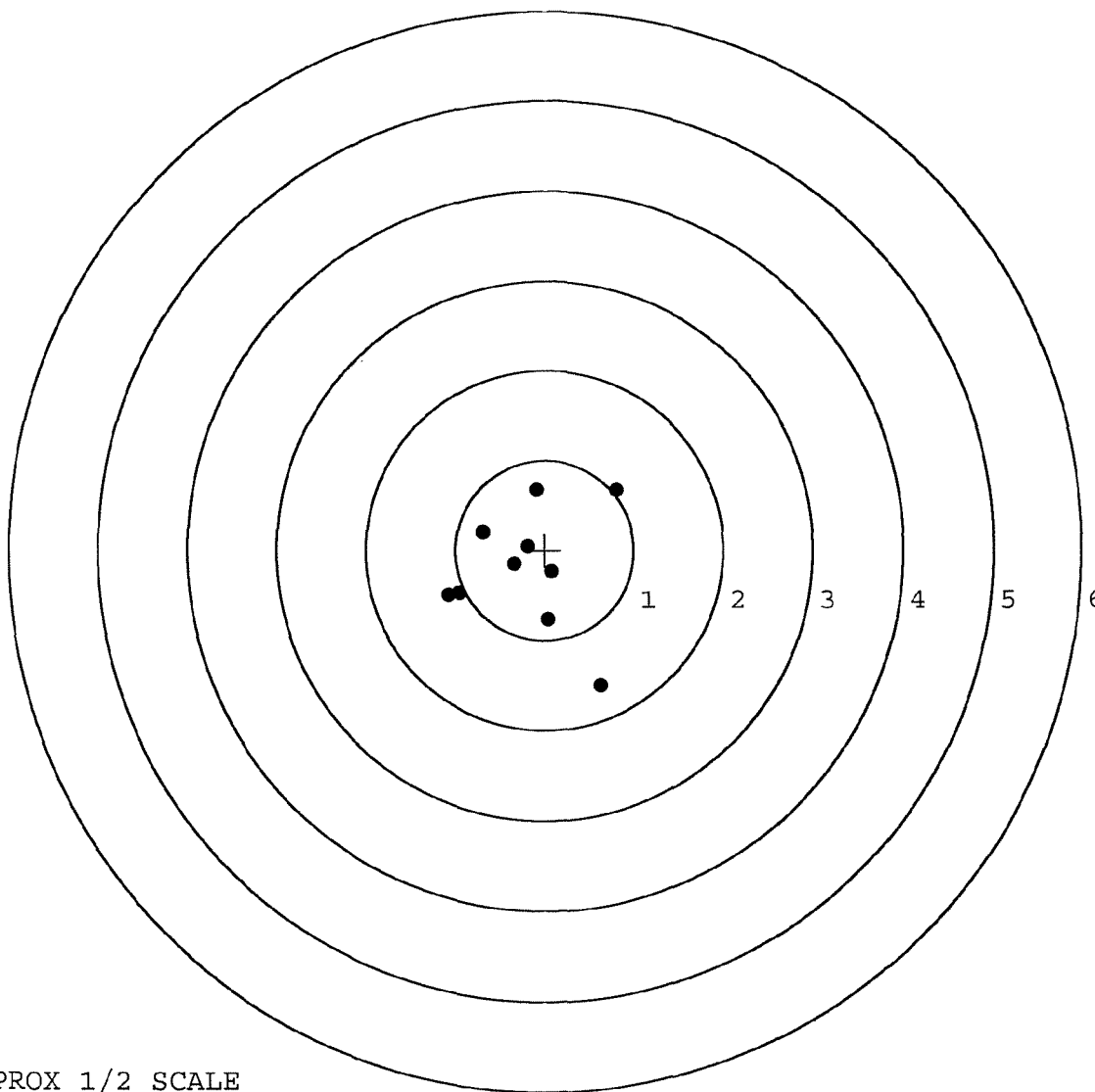
MEAN RADIUS: 0.744

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.631	-1.512
2:	0.039	-0.774
3:	-1.078	-0.501
4:	0.076	-0.243
5:	-0.344	-0.154
6:	-0.192	0.043
7:	-0.691	0.202
8:	-0.096	0.670
9:	0.804	0.672
10:	-0.955	-0.475



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591649. __0

TARGET NUMBER: 5

FILE DATE: 09/27/2006

FILE TIME: 05:40

X CENTROID: 0.007

Y CENTROID: -0.050

POA TO CENTROID: 0.050

HORZ SPREAD: 3.370

VERT SPREAD: 1.538

GROUP SPREAD: 3.448

MIN RADIUS: 0.270

MAX RADIUS: 1.730

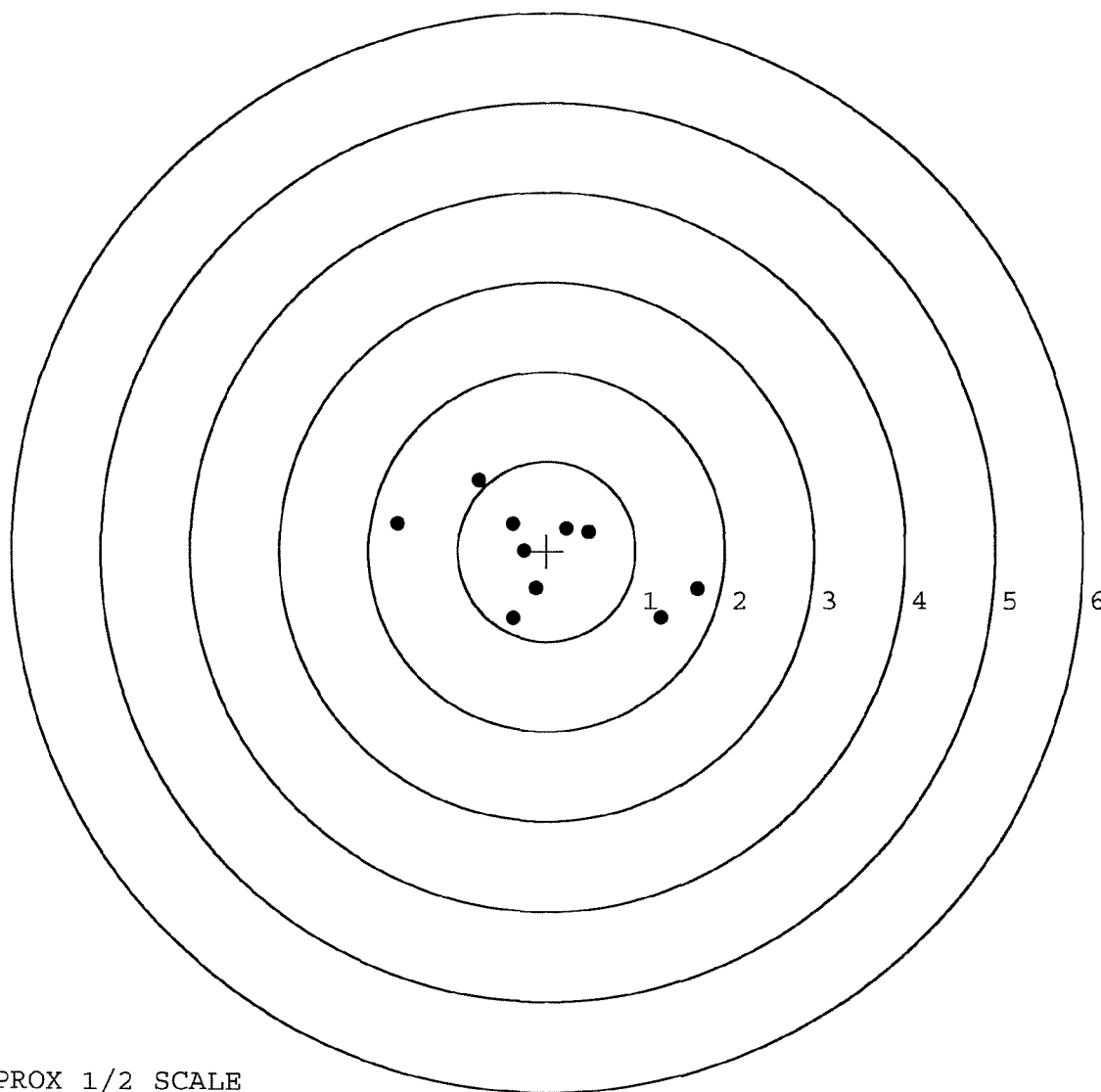
MEAN RADIUS: 0.892

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.696	-0.423
2:	1.281	-0.742
3:	-0.385	-0.753
4:	-1.674	0.306
5:	-0.766	0.785
6:	-0.122	-0.419
7:	0.467	0.210
8:	0.218	0.249
9:	-0.259	-0.005
10:	-0.387	0.296



TARGET APPROX 1/2 SCALE