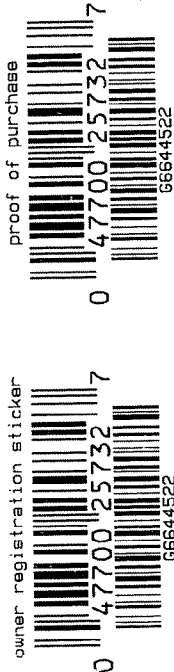


G 664 4522

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5
G6644522	
UPC	

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



GUN SERIAL # 66644522

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		5-7-07	RTL
420	ASSEMBLE ACTION		5-4-07	SP.D.
430	ASSEMBLE TO STOCK		5-7-07	TRW
440	PROOF	MAGNA - FLUX	5-7-07	FM
460	CHECK HEADSPACE	MAY 10 2000	5-7-07	FM
470	DIS-ASSEMBLE ACTION			
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mmms</u>	5/10/07	mmms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		5-9-07	CW
510	DRILL AND TAP SIGHT HOLES		5-9-07	TRW
520	GOFF BLAST BBL / REC		5-10-07	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5-12-07	WJ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-07	SP.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-07	SP.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-07	SP.D.
	D) OIL FIRING PIN ASSEMBLY		5-25-07	SP.D.
	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>7.0</u> <u>7.0</u> <u>7.0</u>	6-7-07	Fm
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	6-7-07	Fm
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	6-7-07	Fm
	J) ASSEMBLE STOCK		5-25-07	APD
	K) ASSEMBLE SWIVEL STUDS		6-7-07	APD
	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	5/29/07	SD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-29-07	SD
670	FINAL INSPECTION A) HEADSPACE		6-7-07	APD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.90</u> <u>2.89</u> <u>2.84</u> <u>2.79</u>	6-7-07	Fm
	C) FUNCTION		6-7-07	APD
690	PACK		6-12-07	APD

F004 REV 5/2006

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 5-25-07TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS.		COMMENTS
PULL #1	2.60	2.28		2.29	
PULL #2	2.68	2.52		2.60	
PULL #3	2.60	2.40		2.69	
PULL #4	2.53	2.41		2.78	
PULL #5	2.59	2.57		2.09	
TOTAL	13.00	12.18		12.45	
AVERAGE	2.60	2.43		2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.33		
PULL #2	3.24	3.38		
PULL #3	3.18	3.47		
PULL #4	3.48	3.43		
PULL #5	3.39	3.38		
TOTAL	16.51	16.99		
AVERAGE	3.30	3.39		

	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	4.28		4.27
PULL #2	4.19	4.19		4.56
PULL #3	4.22	4.42		4.09
PULL #4	4.11	4.56		4.39
PULL #5	4.45	4.04		4.12
TOTAL	21.08	21.49		21.43
AVERAGE	4.21	4.29		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6644522.___0
FILE DATE AND TIME: 05/30/2007 05:07

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.030
The Average Y Centroid of the Five Target Set:	-0.150
The Average Point of Impact of the Five Target Set:	0.153
The Average Mean Radius of the Five Target Set:	0.744
The Distance from POA to Centroid Target #1:	0.171
The Distance from Centroid Target #2 to Centroid Target #1:	0.298
The Distance from Centroid Target #3 to Centroid Target #1:	0.045
The Distance from Centroid Target #4 to Centroid Target #1:	0.121
The Distance from Centroid Target #5 to Centroid Target #1:	0.175

BARBER - M24 0170526

SERIAL NUMBER: G6644522. __ 0

TARGET NUMBER: 1

FILE DATE: 05/30/2007

FILE TIME: 05:07

POINT#	X	Y
1:	0.734	-1.054
2:	0.368	-1.331
3:	0.230	-0.778
4:	-0.336	-1.141
5:	-0.599	-0.270
6:	0.312	0.302
7:	0.138	0.992
8:	-0.621	0.767
9:	-0.466	0.533
10:	-0.778	0.601

X CENTROID: -0.102

Y CENTROID: -0.138

POA TO CENTROID: 0.171

HORZ SPREAD: 1.512

VERT SPREAD: 2.323

GROUP SPREAD: 2.334

MIN RADIUS: 0.514

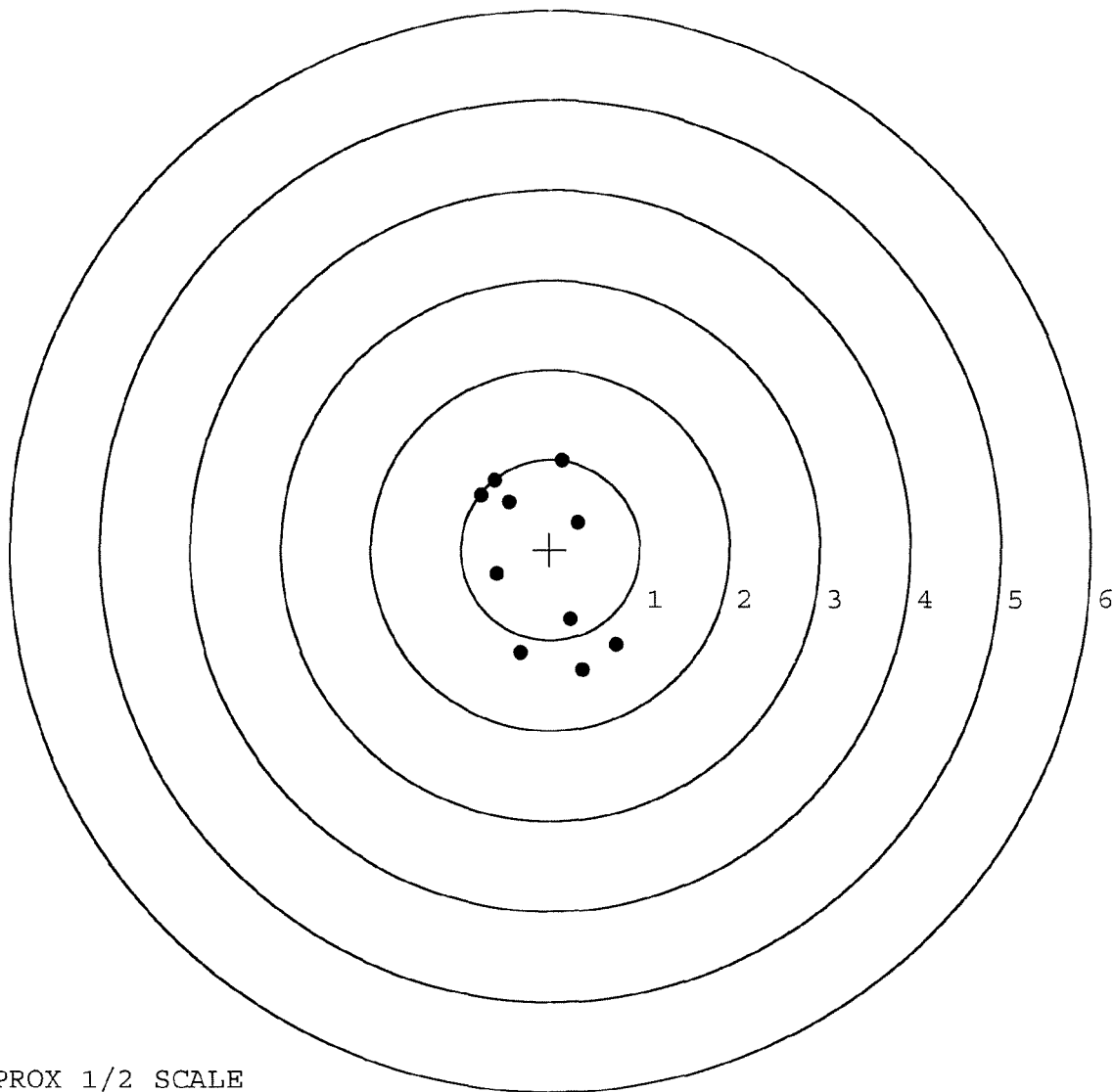
MAX RADIUS: 1.282

MEAN RADIUS: 0.936

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0170527

SERIAL NUMBER: G6644522. 0

TARGET NUMBER: 2

FILE DATE: 05/30/2007

FILE TIME: 05:07

POINT#	X	Y
1:	1.261	-1.360
2:	0.895	-1.342
3:	0.158	0.381
4:	-0.125	0.288
5:	-0.540	0.700
6:	-0.606	0.453
7:	0.046	-0.605
8:	0.088	-0.816
9:	-0.355	-0.789
10:	-0.053	-0.679

X CENTROID: 0.077

Y CENTROID: -0.377

POA TO CENTROID: 0.385

HORZ SPREAD: 1.867

VERT SPREAD: 2.060

GROUP SPREAD: 2.736

MIN RADIUS: 0.230

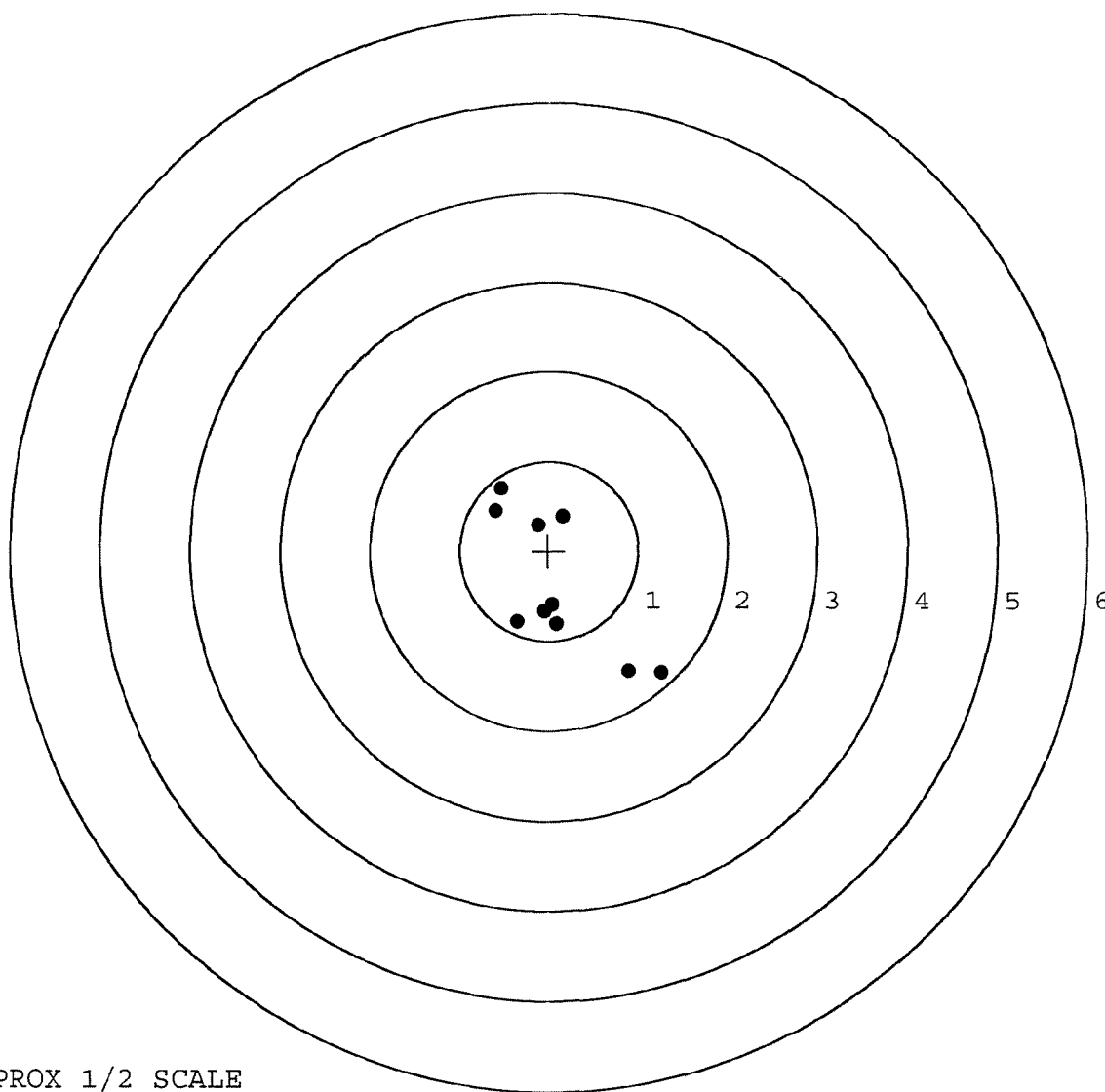
MAX RADIUS: 1.539

MEAN RADIUS: 0.817

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0170528

SERIAL NUMBER: G6644522. __ 0

TARGET NUMBER: 3

FILE DATE: 05/30/2007

FILE TIME: 05:07

POINT#	X	Y
1:	0.677	0.089
2:	0.554	-0.328
3:	0.197	-0.021
4:	0.112	-0.489
5:	-0.078	-0.708
6:	-0.231	-0.122
7:	-0.026	0.391
8:	-0.298	0.591
9:	-1.730	0.115
10:	-0.264	-1.346

X CENTROID: -0.109

Y CENTROID: -0.183

POA TO CENTROID: 0.213

HORZ SPREAD: 2.407

VERT SPREAD: 1.937

GROUP SPREAD: 2.407

MIN RADIUS: 0.137

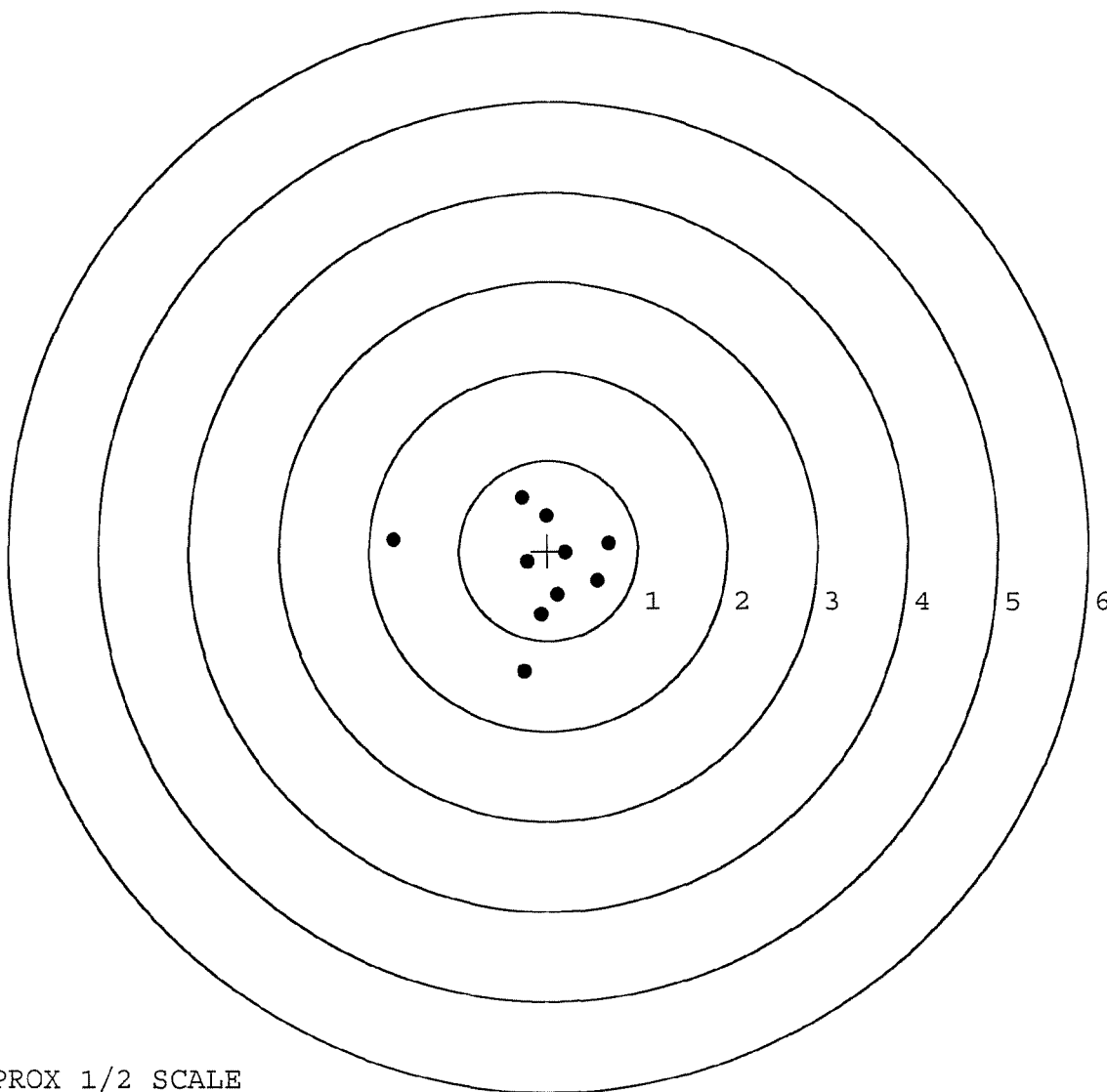
MAX RADIUS: 1.648

MEAN RADIUS: 0.709

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0170529

SERIAL NUMBER: G6644522. __0

TARGET NUMBER: 4

FILE DATE: 05/30/2007

FILE TIME: 05:07

POINT#	X	Y
1:	0.271	0.630
2:	-0.114	0.737
3:	0.319	0.181
4:	0.358	-0.211
5:	-0.033	0.280
6:	-0.221	0.147
7:	0.010	-0.626
8:	-0.203	-0.446
9:	-0.341	-0.621
10:	-0.513	-0.376

X CENTROID: -0.047

Y CENTROID: -0.030

POA TO CENTROID: 0.056

HORZ SPREAD: 0.871

VERT SPREAD: 1.363

GROUP SPREAD: 1.377

MIN RADIUS: 0.249

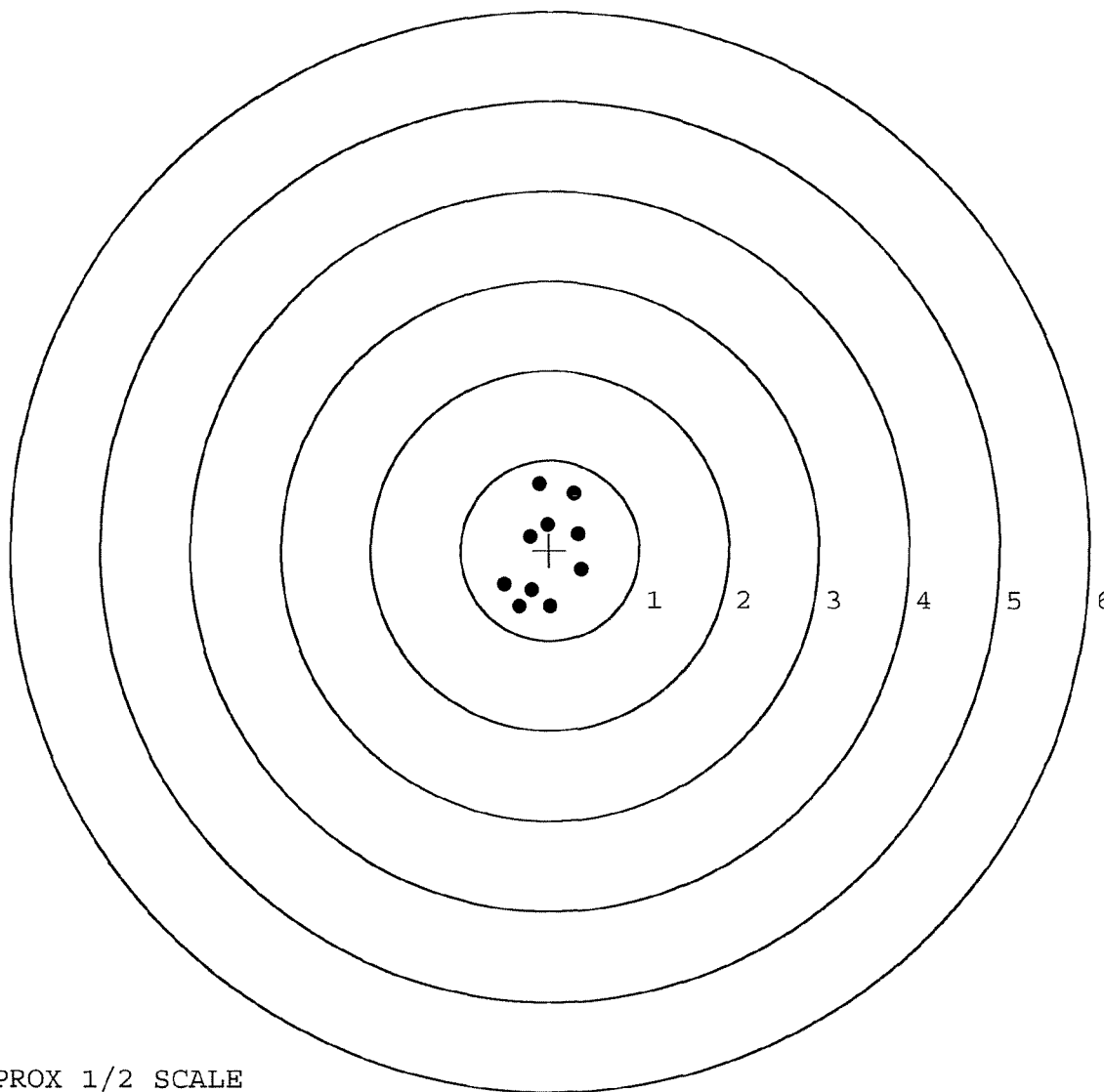
MAX RADIUS: 0.770

MEAN RADIUS: 0.521

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0170530

SERIAL NUMBER: G6644522. __0

TARGET NUMBER: 5

FILE DATE: 05/30/2007

FILE TIME: 05:07

POINT#	X	Y
1:	0.804	-1.040
2:	-0.542	0.548
3:	-0.225	1.032
4:	0.054	1.278
5:	0.347	-0.149
6:	0.514	-0.201
7:	0.146	-0.377
8:	0.031	-0.412
9:	-0.356	-0.555
10:	-0.485	-0.341

X CENTROID: 0.029

Y CENTROID: -0.022

POA TO CENTROID: 0.036

HORZ SPREAD: 1.346

VERT SPREAD: 2.318

GROUP SPREAD: 2.436

MIN RADIUS: 0.343

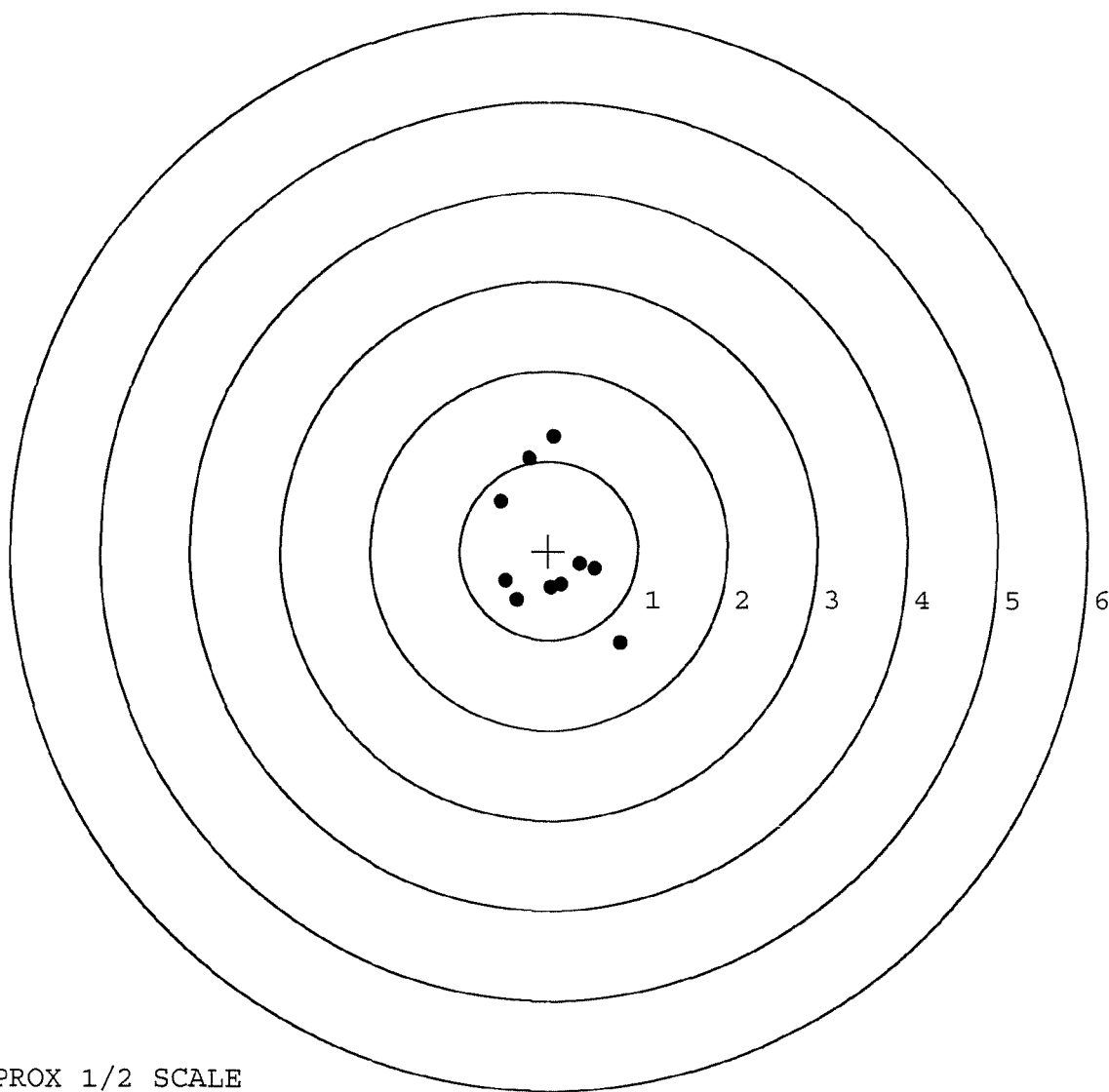
MAX RADIUS: 1.300

MEAN RADIUS: 0.736

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE