

G 6577074

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

UPC



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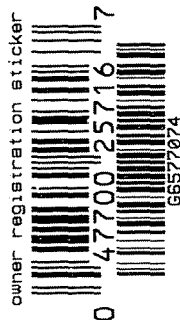
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM



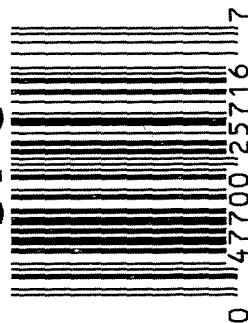
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6577074

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INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6577074

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-1-06	BLG
420	ASSEMBLE ACTION		8-2-06	BLG
430	ASSEMBLE TO STOCK		8-2-06	BLG
440	PROOF		8-2-06	BLG
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-2-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 09 2006	8-2-06	BLG
480	MAGNAFLUX BBL ACTION	QPD	8-2-09	APD
490	MAGNAFLUX BOLT	OPERATOR		
500	ROLLMARK CALIBER		8-9-06	CW
510	DRILL AND TAP SIGHT HOLES		8-8-06	TRW
520	GOFF BLAST BBL / REC		8-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/10/06	RTZ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-10-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-10-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-10-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-10-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	8-21-06	MM

F004 REV 5/2006

OP #	OPERATION NAME		READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>55</u> <u>5.5</u> <u>5.5</u>	8-21-06	RA
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	8-21-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			8-21-06	MTM
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	8-21-06	RA
	J) ASSEMBLE STOCK			8-10-06	RTL
	K) ASSEMBLE SWIVEL STUDS			8-21-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			8-10-06	BLC-
	M) IRON SIGHT ALIGNMENT			8-10-06	BLC-
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			8-10-06	BLC-
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	8-14-06	TRW
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			8-14-06	BD
670	FINAL INSPECTION A) HEADSPACE			8-21-06	MTM
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>274</u> <u>2.91</u> <u>2.95</u> <u>273</u> <u>273</u>	8-21-06	MTM
	C) FUNCTION			8-21-06	MTM
690	PACK			11/14/06	RA

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 8-9-06

TESTER MTM

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.66		2.37	
PULL #2	2.67	2.65		2.49	
PULL #3	2.51	2.33		2.54	
PULL #4	2.52	2.42		2.33	
PULL #5	2.66	2.57		2.69	
TOTAL	12.98	12.63		12.42	
AVERAGE	2.60	2.53		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.10		
PULL #2	3.23	3.22		
PULL #3	3.18	3.17		
PULL #4	3.15	2.91		
PULL #5	3.13	3.29		
TOTAL	15.75	15.69		
AVERAGE	3.15	3.14		

	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	4.13	4.15		4.12
PULL #2	4.26	4.27		4.07
PULL #3	4.25	4.18		4.24
PULL #4	4.06	4.21		4.29
PULL #5	4.29	4.13		4.19
TOTAL	20.99	20.94		20.91
AVERAGE	4.20	4.19		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577074.___0
FILE DATE AND TIME: 08/14/2006 13:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.028
The Average Y Centroid of the Five Target Set:	-0.110
The Average Point of Impact of the Five Target Set:	0.114
The Average Mean Radius of the Five Target Set:	0.760
The Distance from POA to Centroid Target #1:	0.219
The Distance from Centroid Target #2 to Centroid Target #1:	0.397
The Distance from Centroid Target #3 to Centroid Target #1:	0.155
The Distance from Centroid Target #4 to Centroid Target #1:	0.333
The Distance from Centroid Target #5 to Centroid Target #1:	0.330

SERIAL NUMBER: G6577074. __0

TARGET NUMBER: 1

FILE DATE: 08/14/2006

FILE TIME: 13:55

POINT#	X	Y
1:	-0.310	0.521
2:	0.567	1.267
3:	0.592	0.571
4:	0.722	0.350
5:	0.879	0.247
6:	0.971	-1.262
7:	0.007	-1.053
8:	-0.085	-0.899
9:	-0.283	-0.731
10:	-1.496	-0.546

X CENTROID: 0.156

Y CENTROID: -0.154

POA TO CENTROID: 0.219

HORZ SPREAD: 2.467

VERT SPREAD: 2.529

GROUP SPREAD: 2.746

MIN RADIUS: 0.726

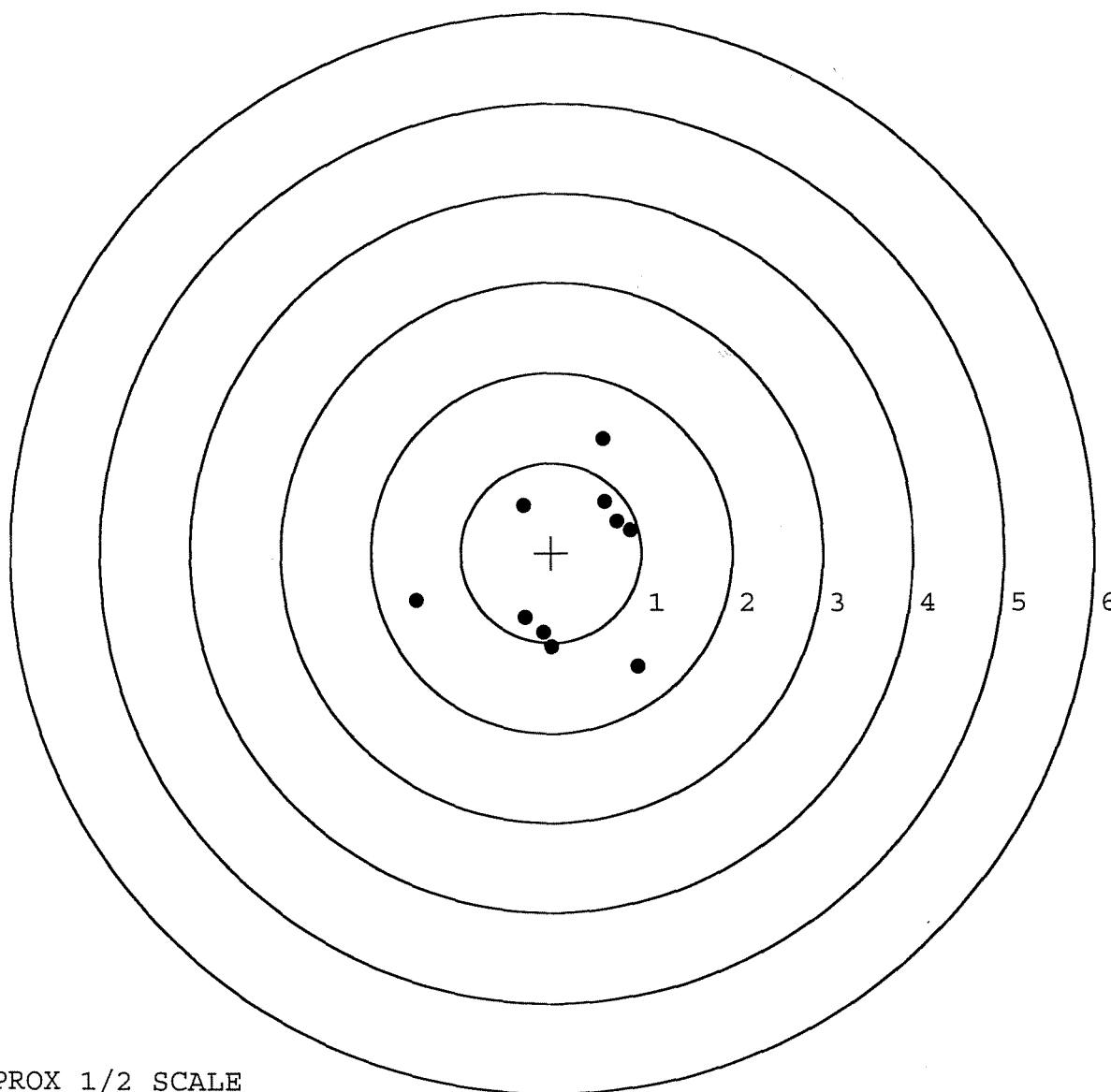
MAX RADIUS: 1.698

MEAN RADIUS: 1.022

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

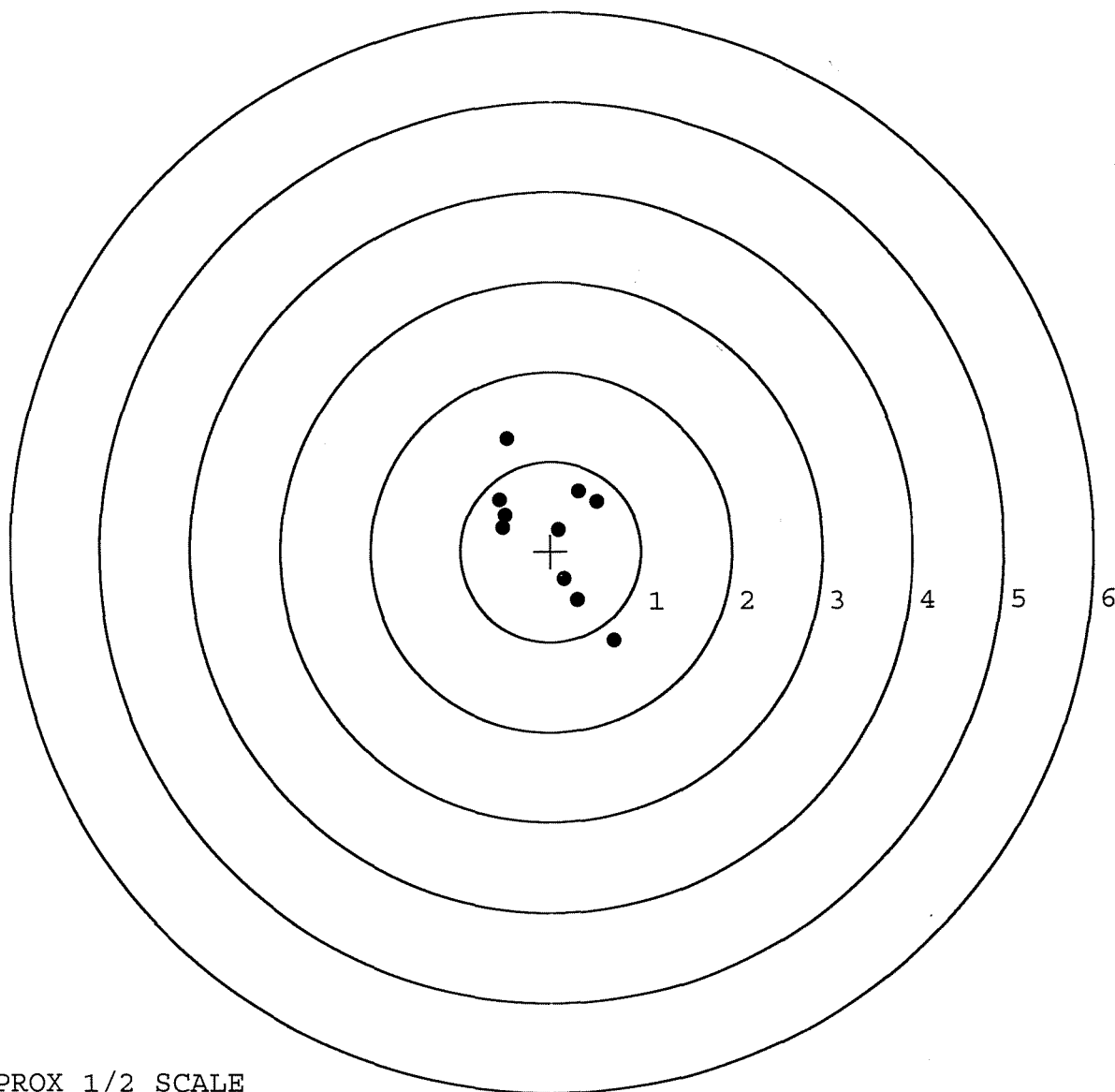


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577074. __0
TARGET NUMBER: 2
FILE DATE: 08/14/2006
FILE TIME: 13:55

	POINT#	X	Y
X CENTROID:		-0.003	
Y CENTROID:		0.211	
POA TO CENTROID:		0.211	
HORZ SPREAD:		1.271	
VERT SPREAD:		2.248	
GROUP SPREAD:		2.542	
MIN RADIUS:		0.094	
MAX RADIUS:		1.392	
MEAN RADIUS:		0.691	
# IN 1 IN DIAMETER:		1	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		10	

POINT#	X	Y
1:	-0.532	0.265
2:	-0.505	0.399
3:	-0.568	0.573
4:	0.087	0.240
5:	0.313	0.666
6:	0.513	0.549
7:	0.147	-0.311
8:	0.298	-0.545
9:	0.703	-0.989
10:	-0.483	1.259



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577074. __0

TARGET NUMBER: 3

FILE DATE: 08/14/2006

FILE TIME: 13:55

POINT#	X	Y
1:	-1.467	-0.952
2:	-0.773	-0.118
3:	-0.118	-0.349
4:	-0.024	0.257
5:	0.180	-0.107
6:	0.399	0.099
7:	0.770	-0.046
8:	0.495	-0.184
9:	0.504	-0.424
10:	0.452	-0.757

X CENTROID: 0.042

Y CENTROID: -0.258

POA TO CENTROID: 0.261

HORZ SPREAD: 2.237

VERT SPREAD: 1.209

GROUP SPREAD: 2.414

MIN RADIUS: 0.184

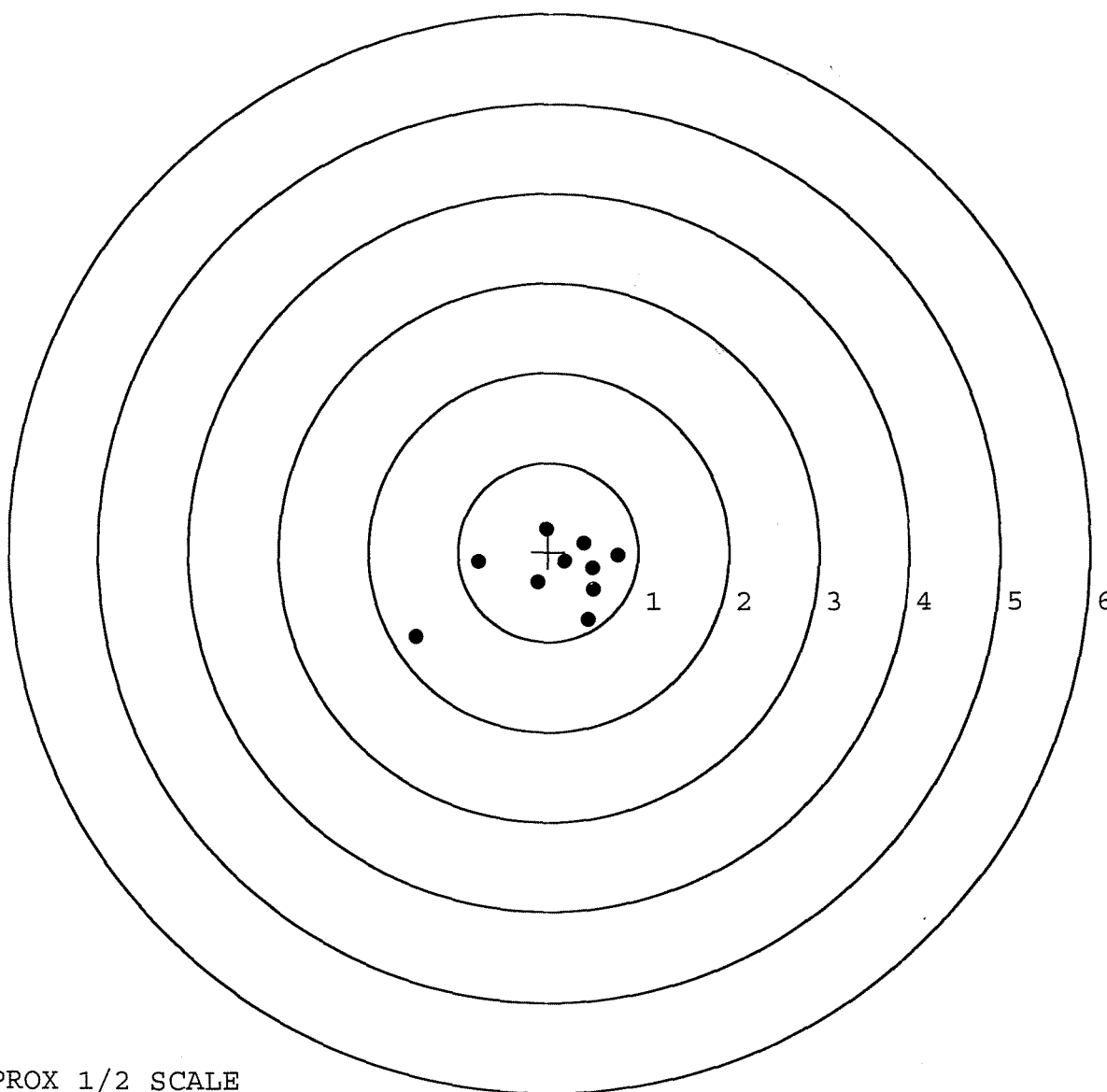
MAX RADIUS: 1.661

MEAN RADIUS: 0.626

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577074. __0

TARGET NUMBER: 4

FILE DATE: 08/14/2006

FILE TIME: 13:55

X CENTROID: -0.173

Y CENTROID: -0.103

POA TO CENTROID: 0.201

HORZ SPREAD: 1.990

VERT SPREAD: 2.137

GROUP SPREAD: 2.225

MIN RADIUS: 0.425

MAX RADIUS: 1.226

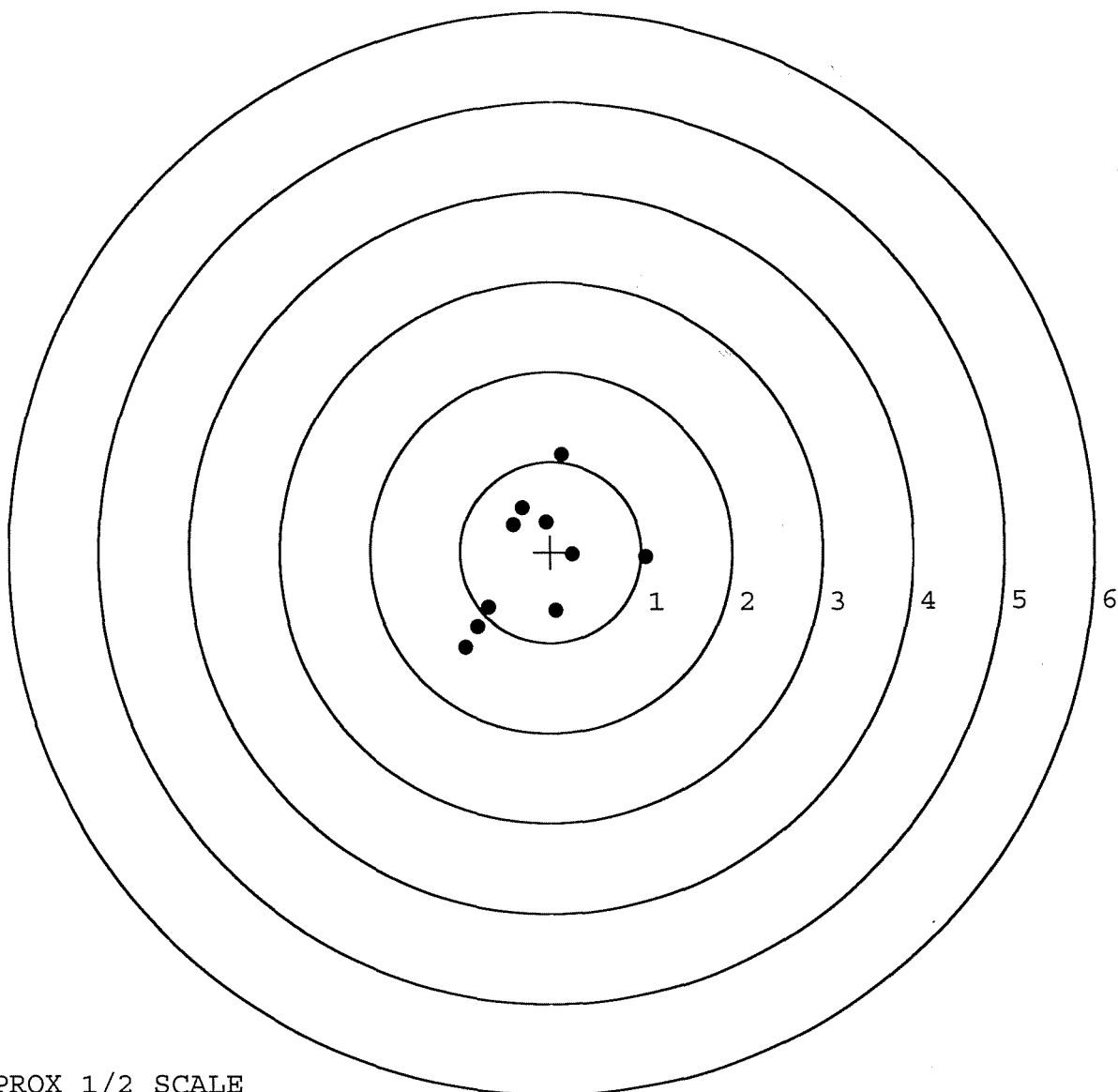
MEAN RADIUS: 0.791

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.125	1.077
2:	-0.409	0.306
3:	-0.320	0.490
4:	-0.051	0.333
5:	0.245	-0.027
6:	1.053	-0.065
7:	0.059	-0.648
8:	-0.688	-0.609
9:	-0.805	-0.832
10:	-0.937	-1.060



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577074. __0

TARGET NUMBER: 5

FILE DATE: 08/14/2006

FILE TIME: 13:55

X CENTROID: -0.161

Y CENTROID: -0.246

POA TO CENTROID: 0.294

HORZ SPREAD: 1.958

VERT SPREAD: 1.672

GROUP SPREAD: 2.090

MIN RADIUS: 0.120

MAX RADIUS: 1.218

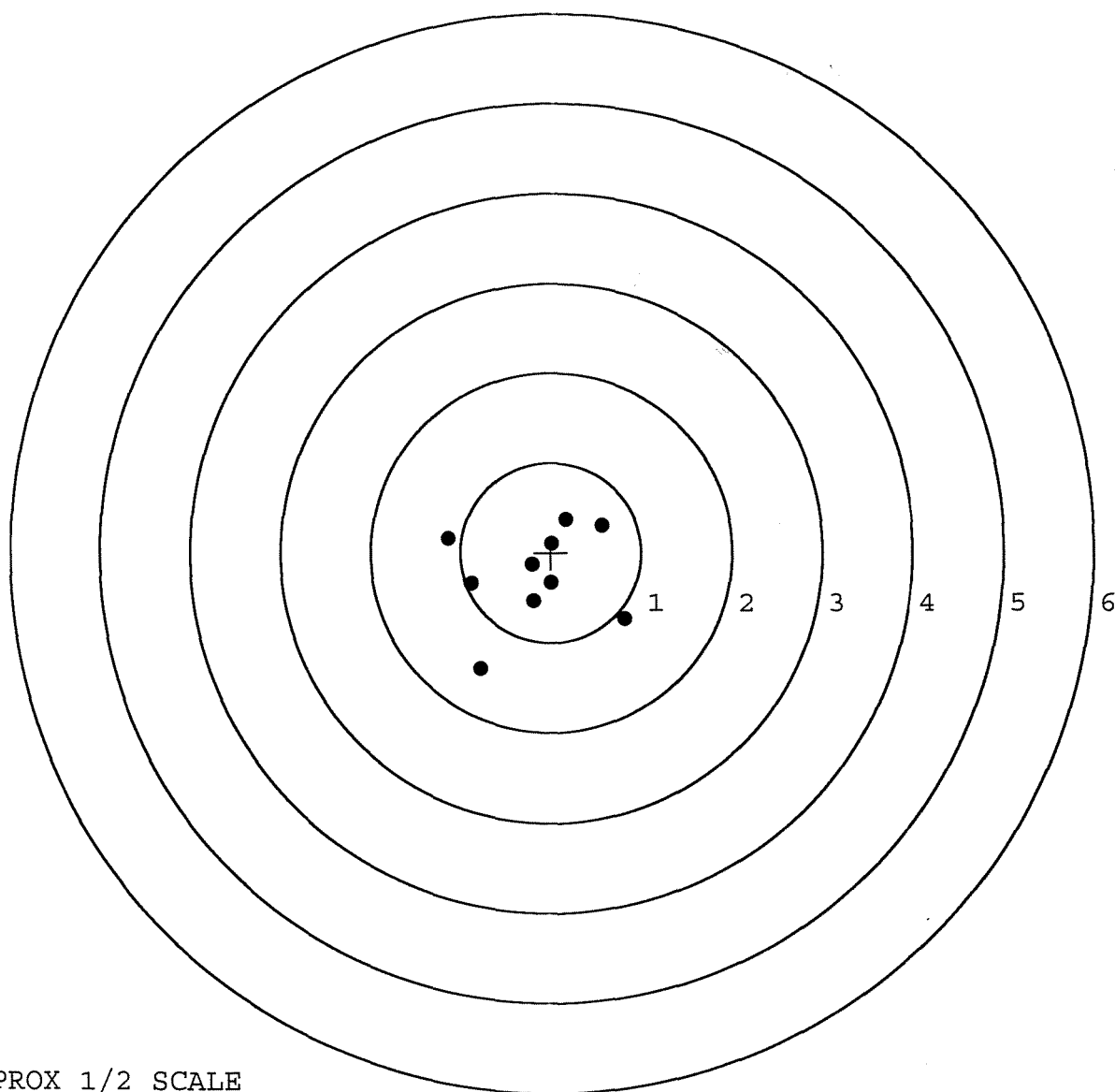
MEAN RADIUS: 0.671

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.135	0.159
2:	-0.880	-0.349
3:	-0.767	-1.302
4:	0.823	-0.735
5:	-0.193	-0.540
6:	0.008	-0.336
7:	-0.208	-0.136
8:	0.011	0.103
9:	0.167	0.370
10:	0.568	0.306



TARGET APPROX 1/2 SCALE