

G-657 714c

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

G6577146



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

UPC



0 47700 25716 7

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

UPC



0 47700 25716 7

SERIAL NO.



66577146

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577146

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLC
420	ASSEMBLE ACTION		7-10-06	RTL
430	ASSEMBLE TO STOCK		7-10-06	RTL
440	PROOF		7-11-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	7-11-06	TRW
470	DIS-ASSEMBLE ACTION	JUL 13 2006	7-11-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	7-13-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-12-06	CW
510	DRILL AND TAP SIGHT HOLES		7-12-06	TRW
520	GOFF BLAST BBL / REC		7-13-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		7/14	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-4-06	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-4-06	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-4-06	RTL
	D) OIL FIRING PIN ASSEMBLY		8-4-06	RTL
	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>7.5</u> <u>7.2</u> <u>7.2</u>	8-11-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>4.5</u>	8-11-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.023</u> <u>0.24</u> <u>1.023</u>	8-11-06	DA
	J) ASSEMBLE STOCK		8-4-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-11-06	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-4-06	RTZ
	M) IRON SIGHT ALIGNMENT		8-4-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-4-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-7-06	TRW
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-7-06	BD
670	FINAL INSPECTION A) HEADSPACE		8-11-06	A
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.89</u> <u>2.87</u> <u>2.83</u> <u>2.75</u> <u>2.91</u>	8-11-06	DA
	C) FUNCTION		8-11-06	A
690	PACK		10-30-06	DA

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 7-21-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.47	2.47		2.36	
PULL #2	2.47	2.41		2.49	
PULL #3	2.49	2.30		2.61	
PULL #4	2.42	2.53		2.57	
PULL #5	2.49	2.44		2.59	
TOTAL	12.34	12.15		12.62	
AVERAGE	2.46	2.43		2.52	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.06		
PULL #2	3.08	3.16		
PULL #3	3.15	3.24		
PULL #4	3.18	3.27		
PULL #5	3.24	3.25		
TOTAL	15.87	15.98		
AVERAGE	3.17	3.19		

	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	4.21	4.25		4.01
PULL #2	4.24	4.33		3.99
PULL #3	4.23	4.18		4.15
PULL #4	4.27	4.06		4.11
PULL #5	4.26	4.34		4.12
TOTAL	21.21	21.16		20.38
AVERAGE	4.24	4.23		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577146.__0
FILE DATE AND TIME: 08/07/2006 08:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.010
The Average Y Centroid of the Five Target Set:	-0.151
The Average Point of Impact of the Five Target Set:	0.151
The Average Mean Radius of the Five Target Set:	0.763
The Distance from POA to Centroid Target #1:	0.232
The Distance from Centroid Target #2 to Centroid Target #1:	0.310
The Distance from Centroid Target #3 to Centroid Target #1:	0.165
The Distance from Centroid Target #4 to Centroid Target #1:	0.208
The Distance from Centroid Target #5 to Centroid Target #1:	0.080

SERIAL NUMBER: G6577146. __0

TARGET NUMBER: 1

FILE DATE: 08/07/2006

FILE TIME: 08:30

X CENTROID: -0.019

Y CENTROID: -0.231

POA TO CENTROID: 0.232

HORZ SPREAD: 1.134

VERT SPREAD: 1.546

GROUP SPREAD: 1.577

MIN RADIUS: 0.240

MAX RADIUS: 0.968

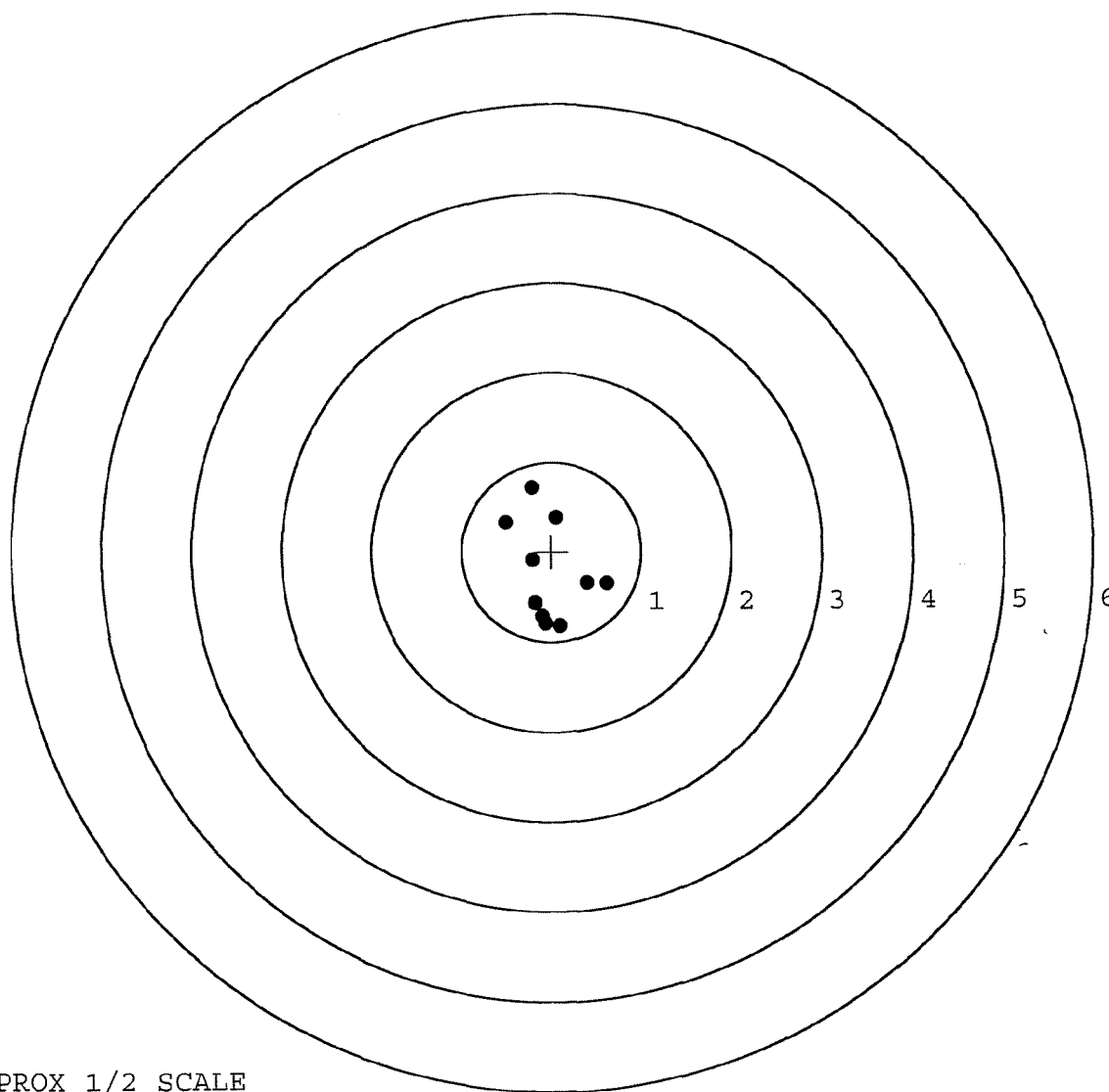
MEAN RADIUS: 0.573

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.615	-0.355
2:	0.394	-0.350
3:	0.090	-0.831
4:	-0.078	-0.806
5:	-0.191	-0.576
6:	-0.218	-0.097
7:	0.052	0.386
8:	-0.519	0.327
9:	-0.223	0.715
10:	-0.109	-0.721

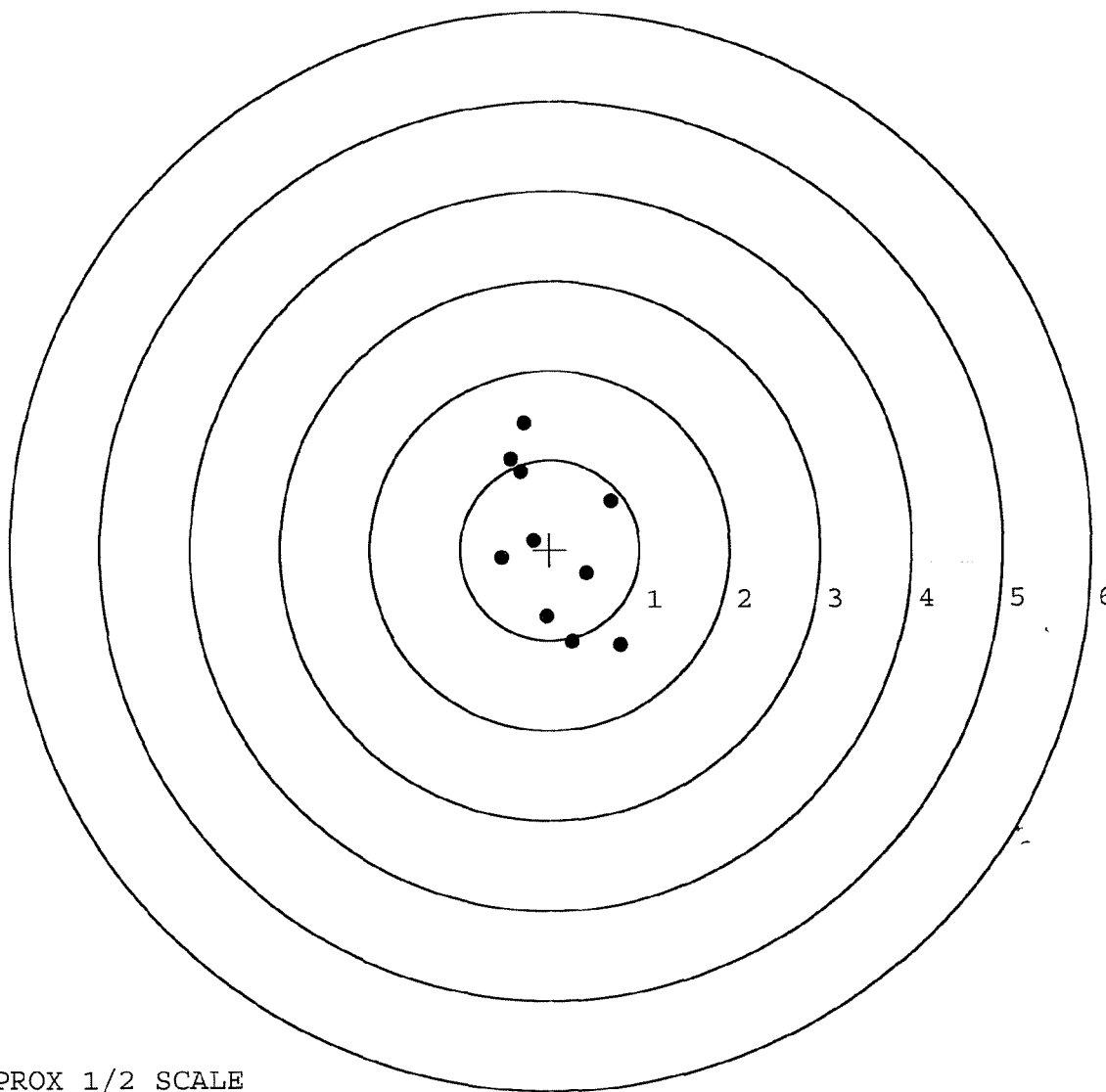


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577146. __0
TARGET NUMBER: 2
FILE DATE: 08/07/2006
FILE TIME: 08:30

X CENTROID: 0.031
Y CENTROID: 0.075
POA TO CENTROID: 0.081
HORZ SPREAD: 1.325
VERT SPREAD: 2.471
GROUP SPREAD: 2.700
MIN RADIUS: 0.216
MAX RADIUS: 1.377
MEAN RADIUS: 0.872
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.789	-1.059
2:	0.252	-1.024
3:	-0.046	-0.742
4:	0.411	-0.266
5:	0.683	0.540
6:	-0.184	0.100
7:	-0.536	-0.091
8:	-0.434	1.011
9:	-0.329	0.867
10:	-0.298	1.412

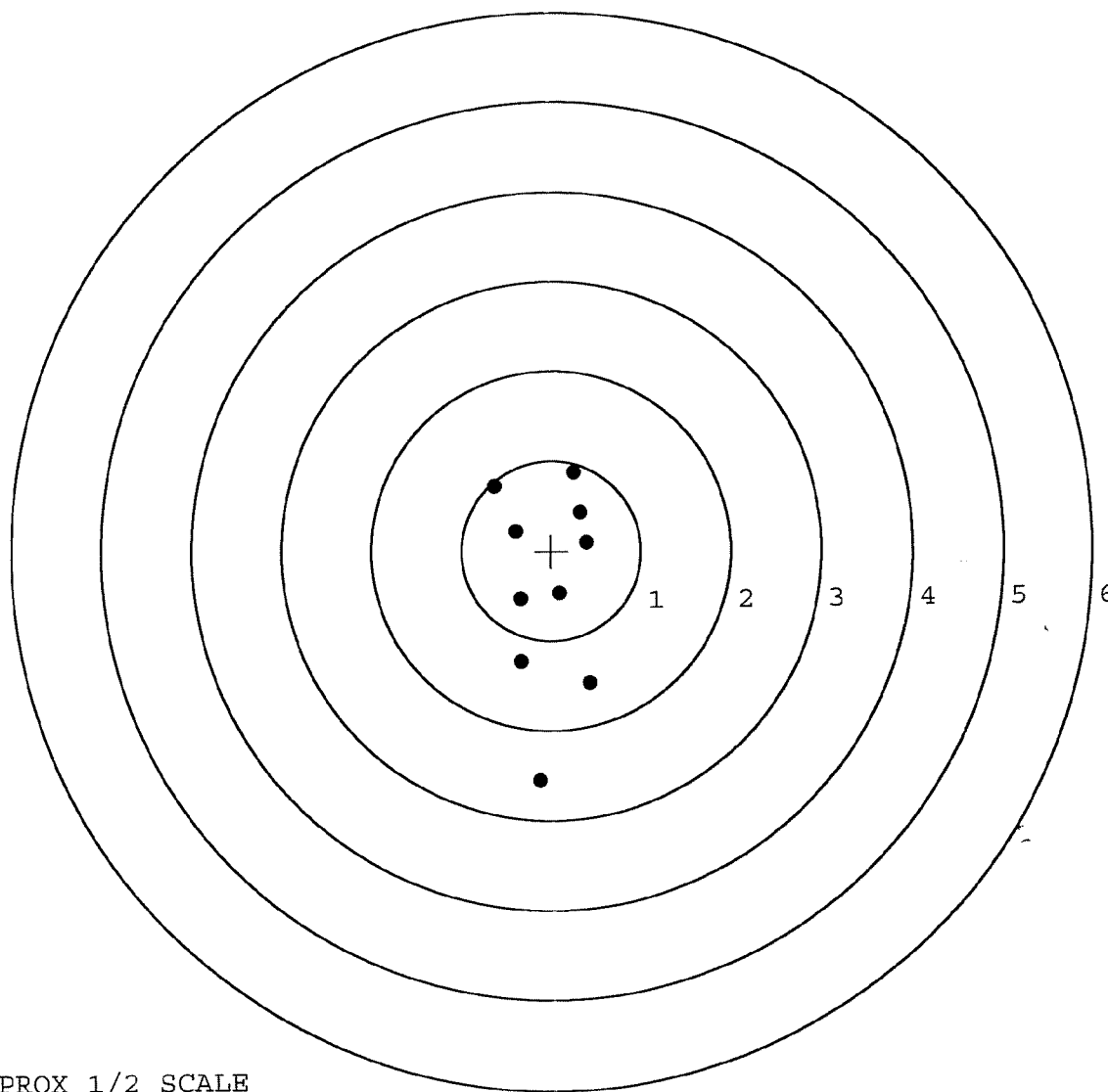


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577146. __0
TARGET NUMBER: 3
FILE DATE: 08/07/2006
FILE TIME: 08:30

POINT#	X	Y
1:	-0.140	-2.563
2:	0.421	-1.474
3:	-0.350	-1.239
4:	0.093	-0.474
5:	-0.349	-0.539
6:	0.400	0.095
7:	0.333	0.431
8:	0.255	0.868
9:	-0.397	0.220
10:	-0.632	0.726

X CENTROID: -0.037
Y CENTROID: -0.395
POA TO CENTROID: 0.397
HORZ SPREAD: 1.053
VERT SPREAD: 3.431
GROUP SPREAD: 3.454
MIN RADIUS: 0.152
MAX RADIUS: 2.171
MEAN RADIUS: 0.958
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577146. __0

TARGET NUMBER: 4

FILE DATE: 08/07/2006

FILE TIME: 08:30

X CENTROID: 0.089

Y CENTROID: -0.052

POA TO CENTROID: 0.103

HORZ SPREAD: 1.490

VERT SPREAD: 1.841

GROUP SPREAD: 1.892

MIN RADIUS: 0.387

MAX RADIUS: 1.256

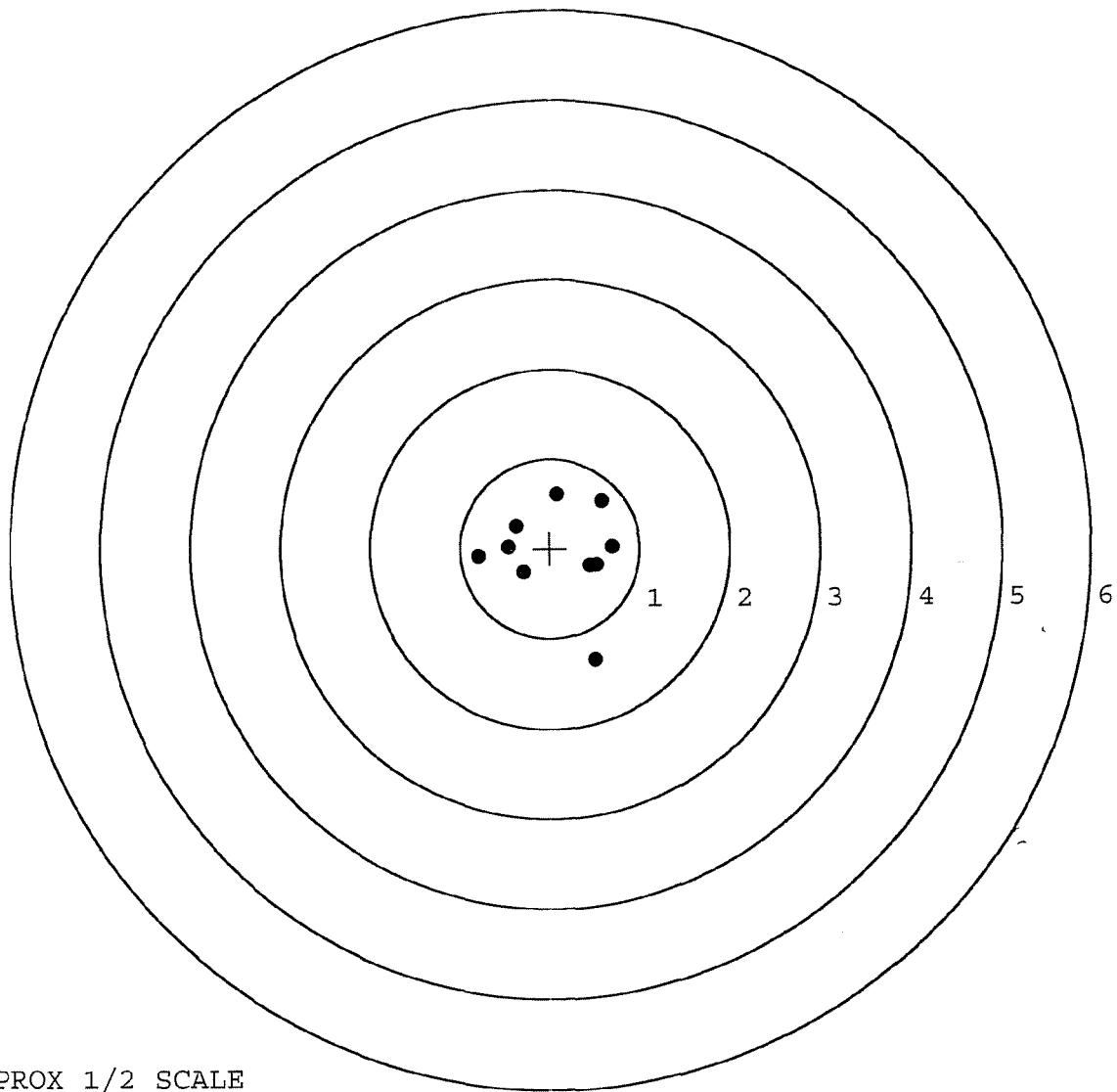
MEAN RADIUS: 0.658

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.510	-1.235
2:	0.450	-0.192
3:	0.521	-0.180
4:	0.695	0.026
5:	0.578	0.540
6:	0.075	0.606
7:	-0.385	0.253
8:	-0.466	0.015
9:	-0.795	-0.087
10:	-0.296	-0.267



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577146. __ 0

TARGET NUMBER: 5

FILE DATE: 08/07/2006

FILE TIME: 08:30

POINT#	X	Y
1:	-0.320	-1.044
2:	-0.728	-1.007
3:	-0.558	-0.575
4:	-0.504	0.201
5:	-0.101	0.537
6:	-0.023	1.085
7:	0.792	-0.072
8:	0.708	-0.445
9:	0.511	-0.143
10:	0.079	-0.050

X CENTROID: -0.014

Y CENTROID: -0.151

POA TO CENTROID: 0.152

HORZ SPREAD: 1.520

VERT SPREAD: 2.129

GROUP SPREAD: 2.208

MIN RADIUS: 0.138

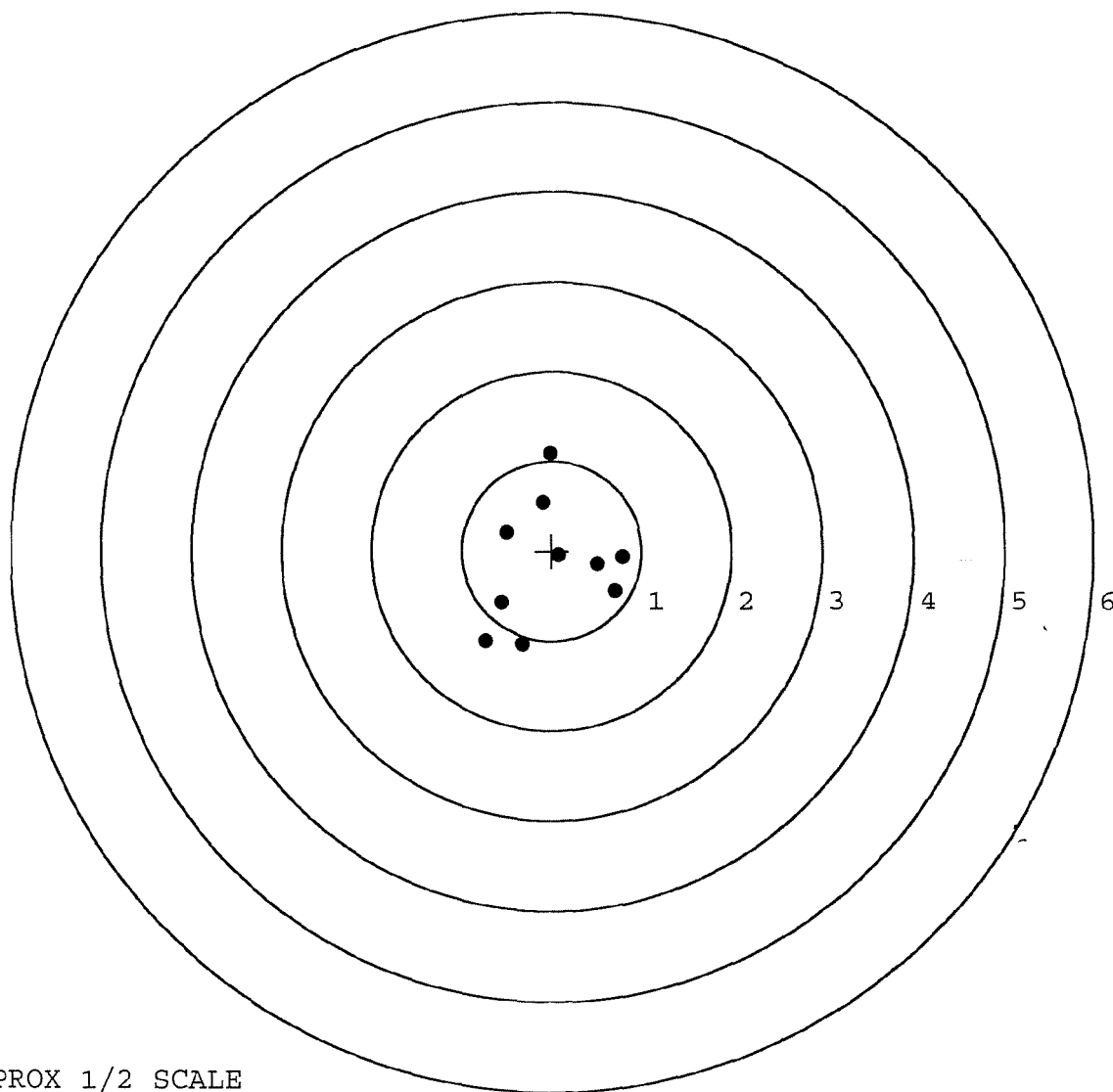
MAX RADIUS: 1.236

MEAN RADIUS: 0.753

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE