

G 657 7157

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

- INSTRUCTION BOOK 3518

DD FORM

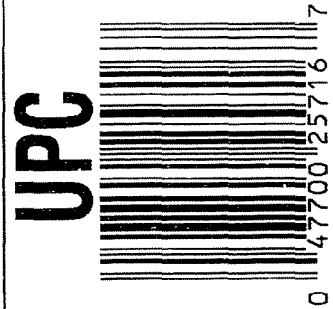


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6577157



ORDER 25716

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

UPC



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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6577157

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/23/06	RLC
420	ASSEMBLE ACTION		6/28/06	RLC
430	ASSEMBLE TO STOCK		6-29-06	R.P.
440	PROOF		6-29-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	6-29-06	TRW
470	DIS-ASSEMBLE ACTION	JUL 16 2006	7-5-06	RLC
480	MAGNAFLUX BBL ACTION		7/9/06	ced
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-7-06	CW
510	DRILL AND TAP SIGHT HOLES		7-6-06	TRW
520	GOFF BLAST BBL / REC		7-7-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		7/6	MS
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-12-06	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-12-06	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-12-06	RTL
	D) OIL FIRING PIN ASSEMBLY		7-12-06	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-22-06	nom

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	8-22-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>4.5</u>	8-22-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-22-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</u>	8-22-06	RA
	J) ASSEMBLE STOCK		7-12-06	RTL
	K) ASSEMBLE SWIVEL STUDS		8-22-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-12-06	BLG
	M) IRON SIGHT ALIGNMENT		7-12-06	BLC-
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-12-06	BLC-
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-10-06	TRL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-10-06	BD
670	FINAL INSPECTION A) HEADSPACE		8-22-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.68</u> <u>2.37</u> <u>2.57</u> <u>2.50</u>	8/22/06	RP
	C) FUNCTION		8-22-06	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 7-11-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.57	2.40		2.58	
PULL #2	2.56	2.73		2.48	
PULL #3	2.67	2.55		2.46	
PULL #4	2.30	2.53		2.57	
PULL #5	2.53	2.59		2.60	
TOTAL	12.63	12.80		12.69	
AVERAGE	2.52	2.56		2.53	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.99	3.25		
PULL #2	3.08	3.06		
PULL #3	3.06	3.09		
PULL #4	3.16	3.16		
PULL #5	3.14	3.06		
TOTAL	15.43	15.62		
AVERAGE	3.08	3.12		

	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	4.24	4.16		4.13
PULL #2	4.21	4.20		3.91
PULL #3	3.90	4.22		3.97
PULL #4	4.03	4.30		4.10
PULL #5	4.21	4.21		3.99
TOTAL	20.59	21.09		20.10
AVERAGE	4.11	4.21		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577157.__0
FILE DATE AND TIME: 08/10/2006 14:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.066
The Average Y Centroid of the Five Target Set:	-0.024
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.765
The Distance from POA to Centroid Target #1:	0.351
The Distance from Centroid Target #2 to Centroid Target #1:	0.187
The Distance from Centroid Target #3 to Centroid Target #1:	0.467
The Distance from Centroid Target #4 to Centroid Target #1:	0.238
The Distance from Centroid Target #5 to Centroid Target #1:	0.547

SERIAL NUMBER: G6577157.___0

TARGET NUMBER: 1

FILE DATE: 08/10/2006

FILE TIME: 14:16

X CENTROID: -0.351

Y CENTROID: -0.021

POA TO CENTROID: 0.351

HORZ SPREAD: 3.406

VERT SPREAD: 1.879

GROUP SPREAD: 3.502

MIN RADIUS: 0.118

MAX RADIUS: 1.931

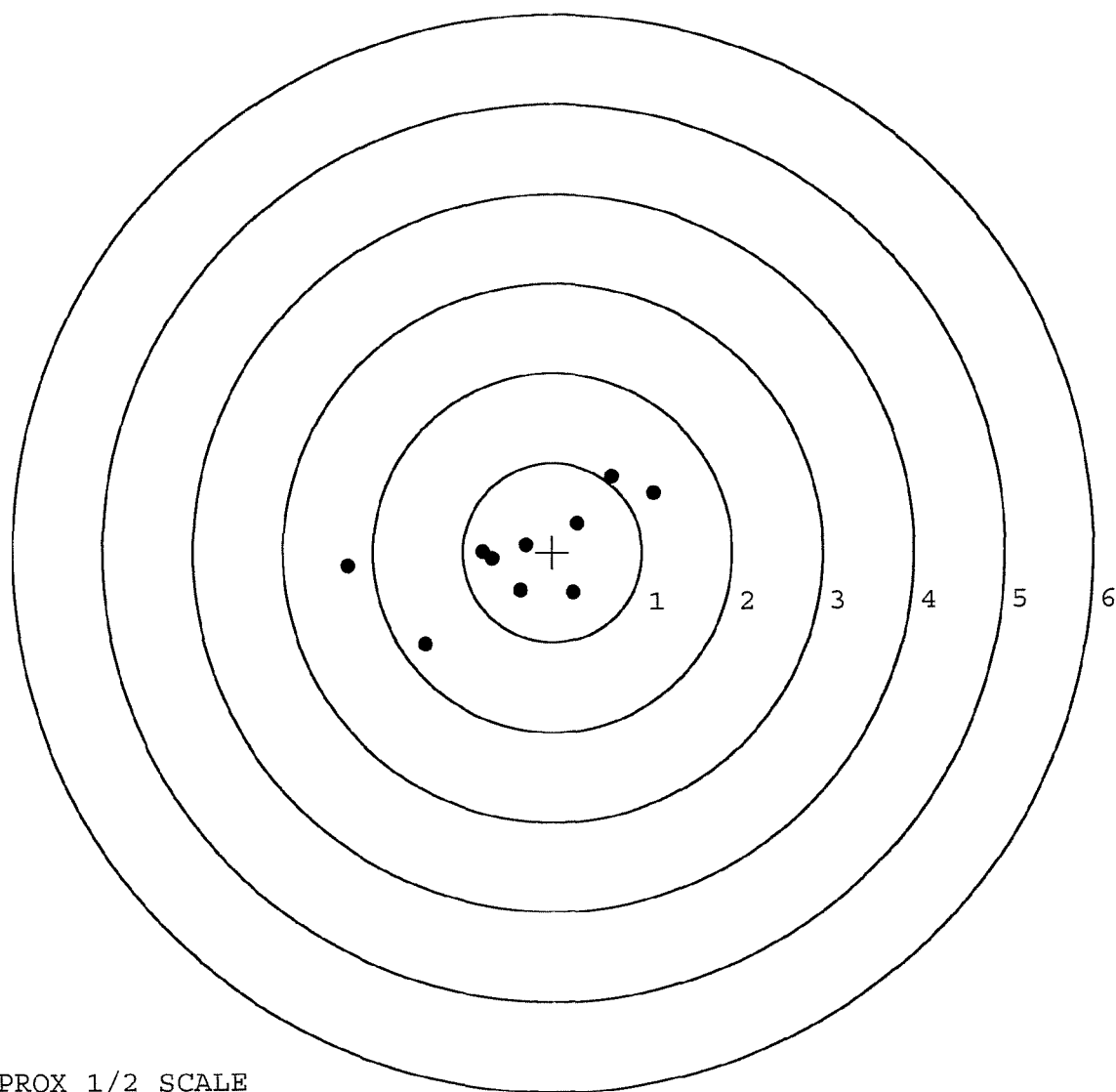
MEAN RADIUS: 0.909

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.664	0.851
2:	1.129	0.659
3:	0.276	0.326
4:	0.228	-0.455
5:	-0.360	-0.430
6:	-0.296	0.083
7:	-0.778	0.011
8:	-0.677	-0.073
9:	-1.417	-1.028
10:	-2.277	-0.157



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577157. __0

TARGET NUMBER: 2

FILE DATE: 08/10/2006

FILE TIME: 14:16

X CENTROID: -0.168

Y CENTROID: -0.060

POA TO CENTROID: 0.178

HORZ SPREAD: 1.792

VERT SPREAD: 2.367

GROUP SPREAD: 2.819

MIN RADIUS: 0.115

MAX RADIUS: 1.540

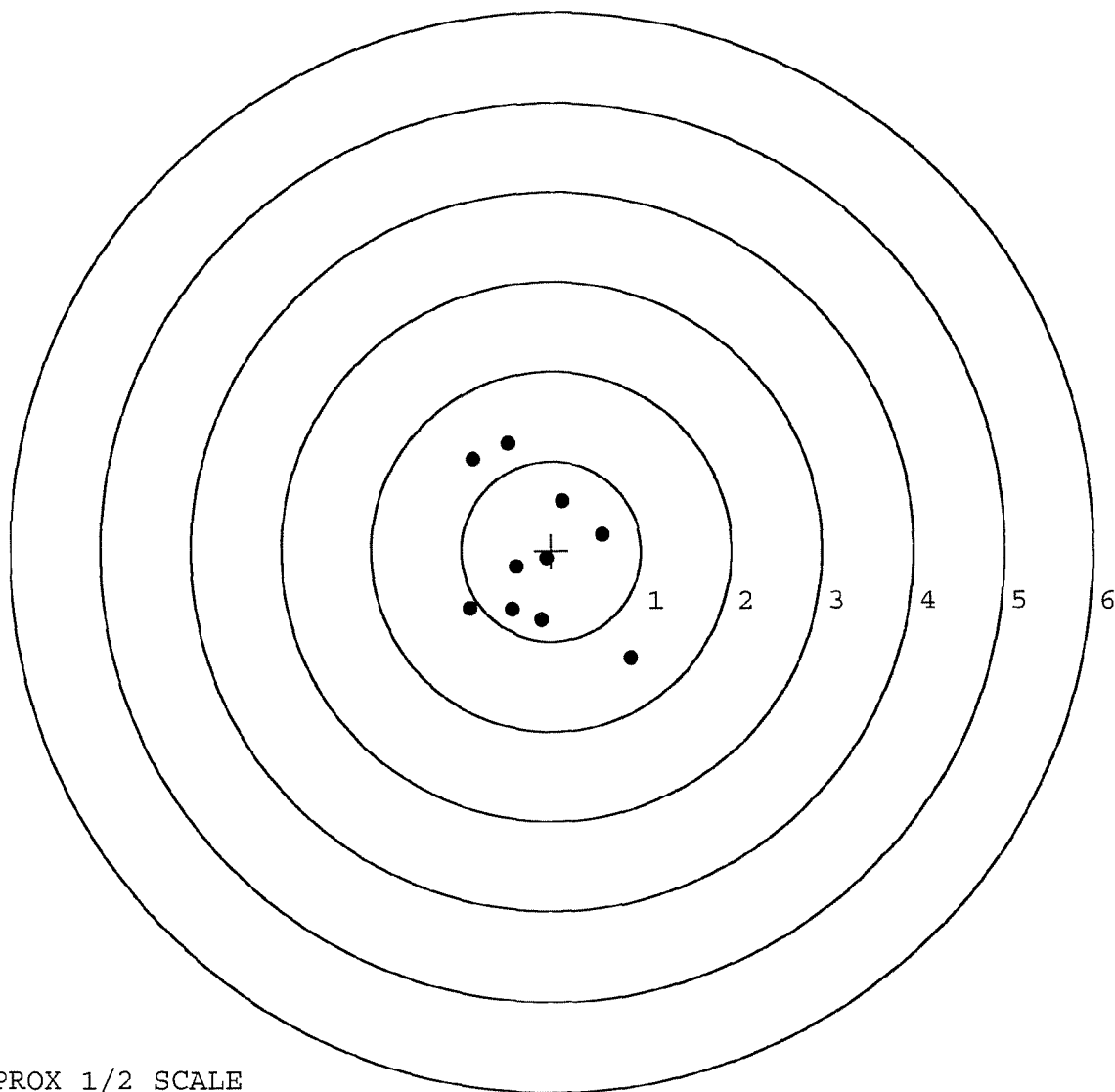
MEAN RADIUS: 0.827

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.489	1.187
2:	-0.876	1.018
3:	0.122	0.552
4:	0.573	0.185
5:	0.889	-1.180
6:	-0.107	-0.768
7:	-0.436	-0.665
8:	-0.903	-0.648
9:	-0.397	-0.191
10:	-0.057	-0.090

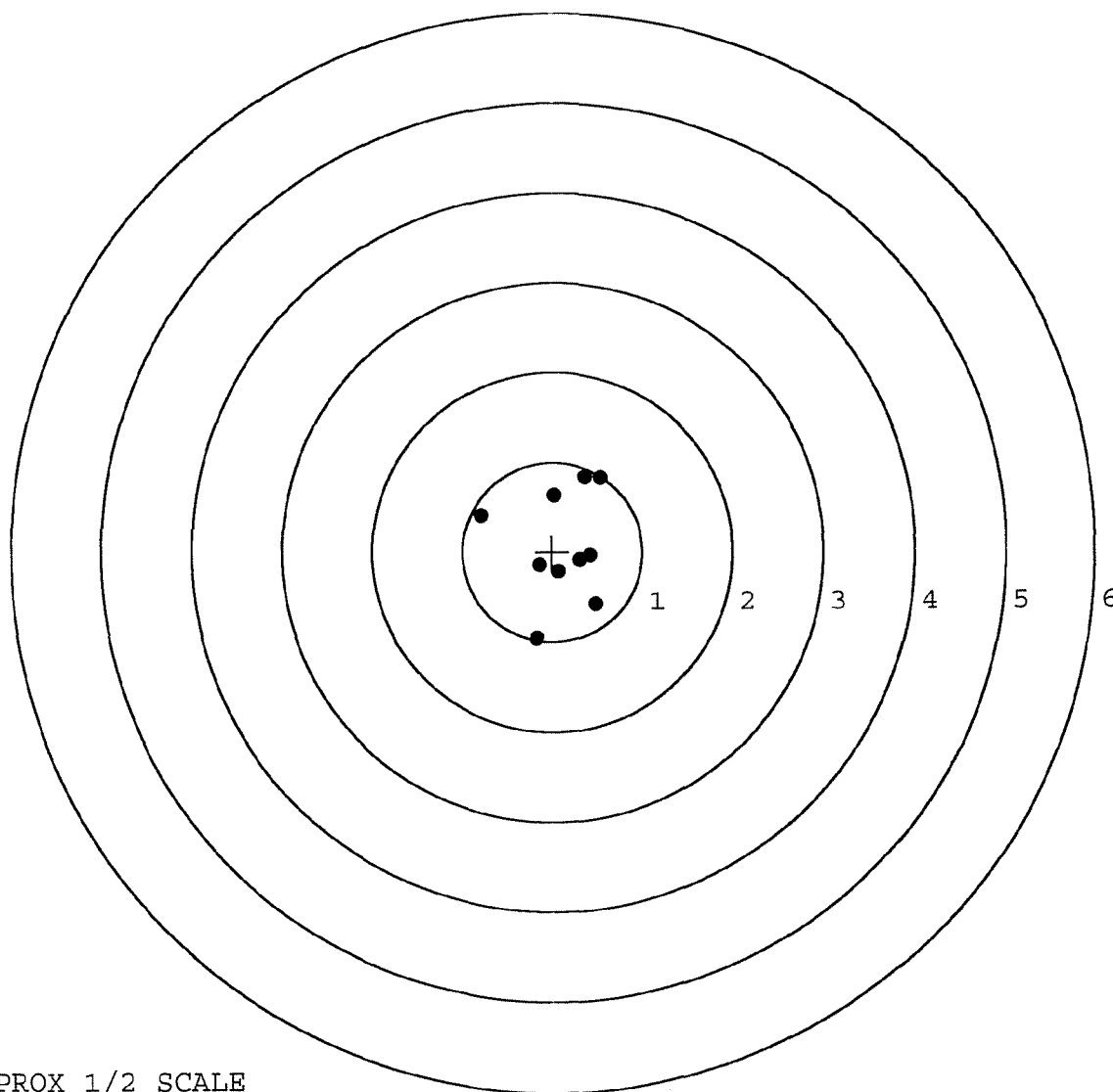


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577157. __0
TARGET NUMBER: 3
FILE DATE: 08/10/2006
FILE TIME: 14:16

POINT#	X	Y
1:	0.538	0.827
2:	0.360	0.837
3:	0.025	0.632
4:	-0.797	0.407
5:	0.483	-0.585
6:	-0.175	-0.971
7:	-0.145	-0.152
8:	0.067	-0.221
9:	0.310	-0.089
10:	0.420	-0.039

X CENTROID: 0.109
Y CENTROID: 0.065
POA TO CENTROID: 0.126
HORZ SPREAD: 1.335
VERT SPREAD: 1.808
GROUP SPREAD: 1.934
MIN RADIUS: 0.253
MAX RADIUS: 1.074
MEAN RADIUS: 0.626
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577157. __0

TARGET NUMBER: 4

FILE DATE: 08/10/2006

FILE TIME: 14:16

X CENTROID: -0.117

Y CENTROID: -0.062

POA TO CENTROID: 0.132

HORZ SPREAD: 1.592

VERT SPREAD: 1.740

GROUP SPREAD: 2.358

MIN RADIUS: 0.360

MAX RADIUS: 1.382

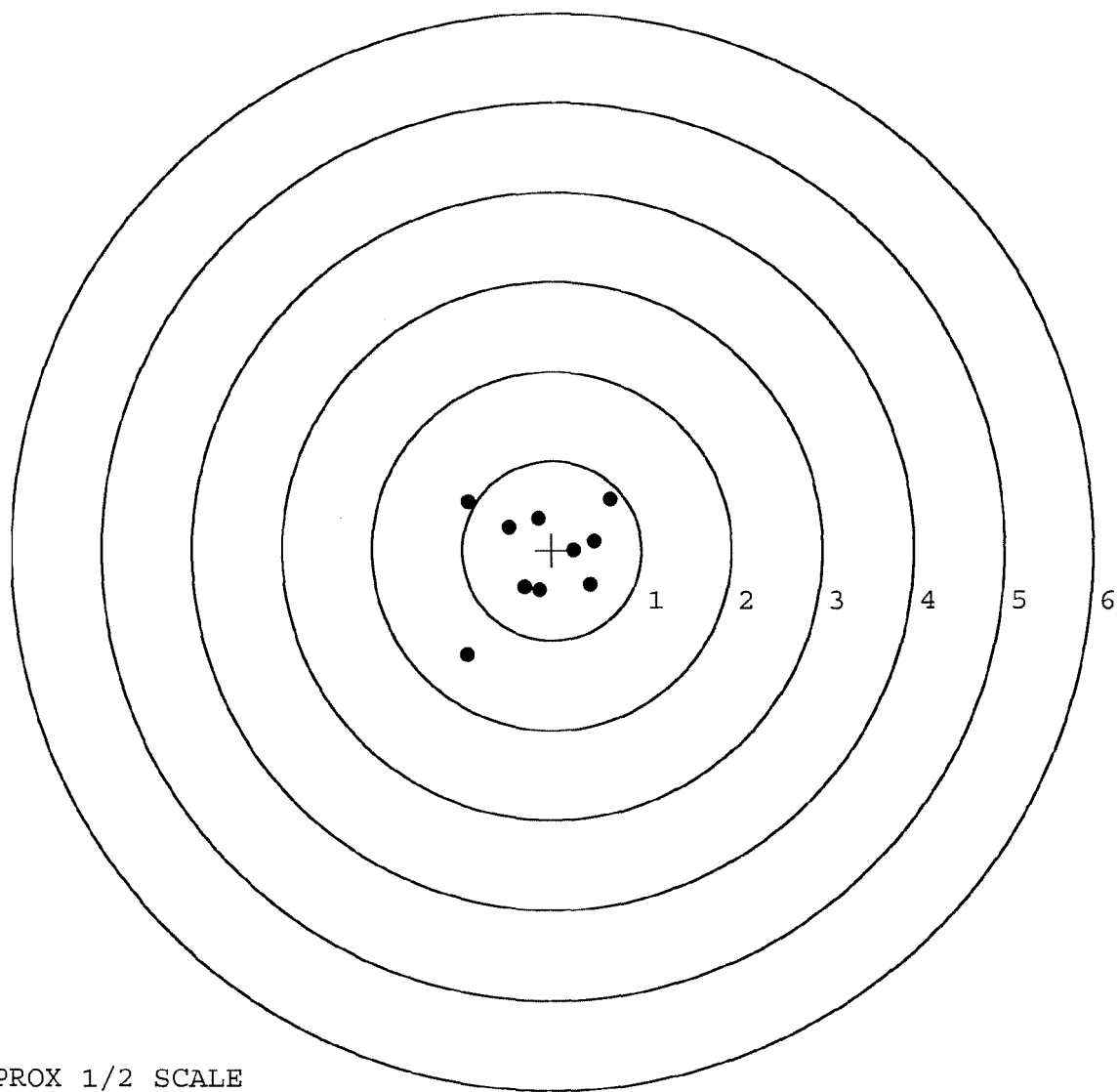
MEAN RADIUS: 0.668

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.653	0.568
2:	0.474	0.106
3:	0.240	-0.012
4:	0.427	-0.386
5:	-0.140	-0.448
6:	-0.303	-0.414
7:	-0.939	-1.172
8:	-0.938	0.540
9:	-0.486	0.252
10:	-0.155	0.348



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577157. 0

TARGET NUMBER: 5

FILE DATE: 08/10/2006

FILE TIME: 14:16

POINT#	X	Y
1:	-0.373	-0.155
2:	-0.477	-0.508
3:	-0.226	-0.886
4:	0.433	-0.189
5:	0.443	-0.414
6:	0.726	-1.021
7:	0.845	0.569
8:	0.149	1.130
9:	-0.354	0.882
10:	0.789	0.153

X CENTROID: 0.195

Y CENTROID: -0.044

POA TO CENTROID: 0.200

HORZ SPREAD: 1.322

VERT SPREAD: 2.151

GROUP SPREAD: 2.227

MIN RADIUS: 0.278

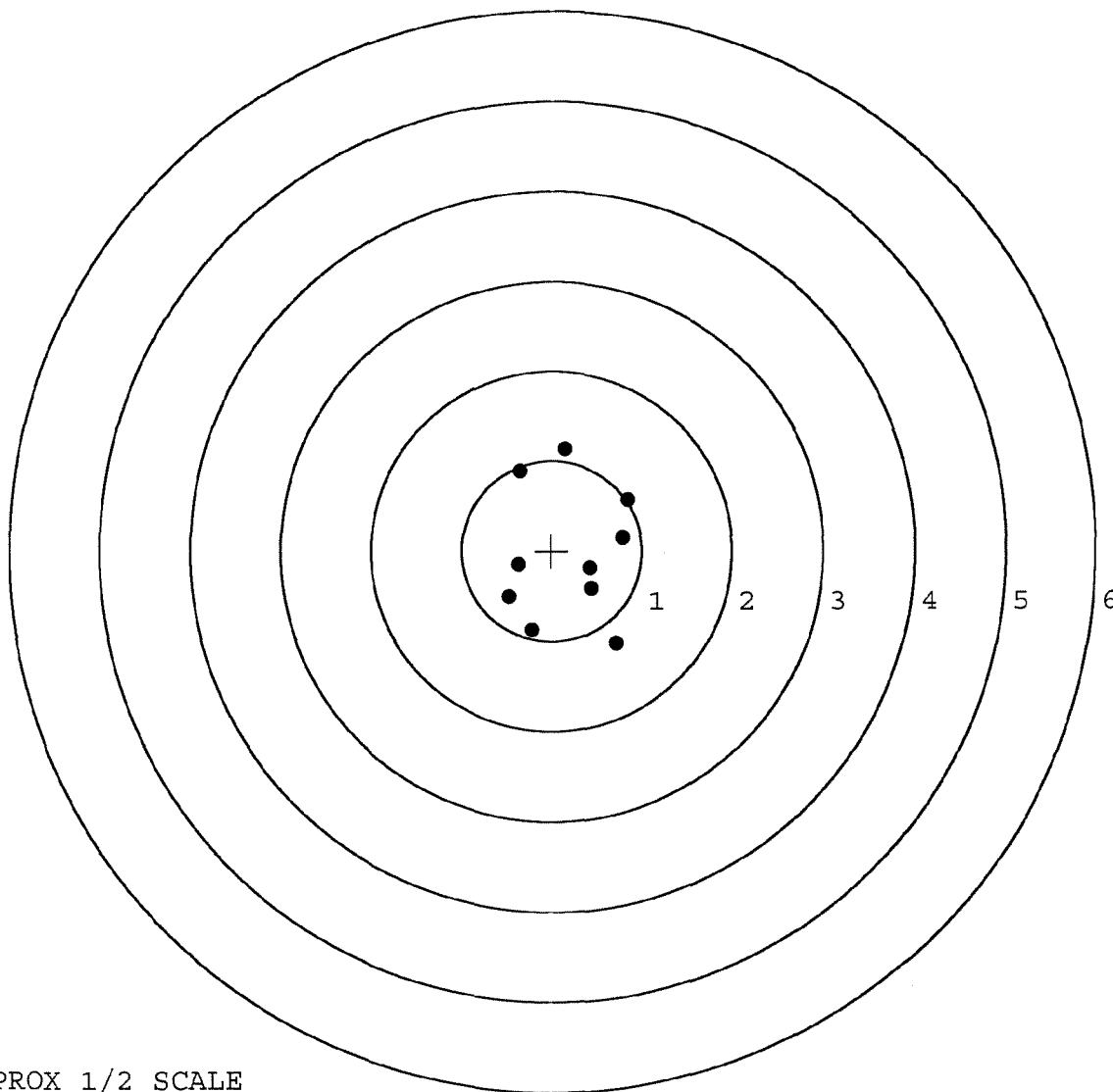
MAX RADIUS: 1.175

MEAN RADIUS: 0.794

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE