

G-6577183

ORDER 25716

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

UPC



0 47700 25716 7

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SERIAL NO.

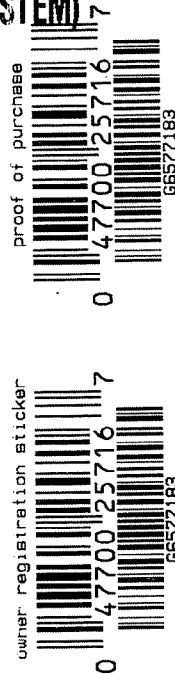


66577183

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

- INSTRUCTION BOOK 3518

DD FORM



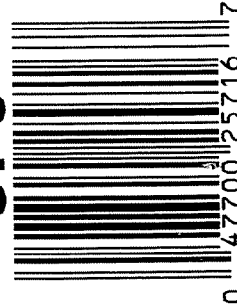
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6577183

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M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577183

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLC
420	ASSEMBLE ACTION		7-10-06	RTZ
430	ASSEMBLE TO STOCK		7-10-06	RTZ
440	PROOF	MAGNA-FLUX	7-11-06	TRLW
460	CHECK HEADSPACE	INSPECTED	7-11-06	TRLW
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		7-20-06	CW
510	DRILL AND TAP SIGHT HOLES		7-12-06	TRLW
520	GOFF BLAST BBL / REC		7-13-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		7/14	100
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-4-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-4-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-4-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-4-06	RTZ
	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>6.5</u> <u>7.0</u>	8-11-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.5</u> <u>5.5</u> <u>5.5</u>	8-11-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	0.23 0.23 0.23 RA	8-11-06	RA
	J) ASSEMBLE STOCK		8-4-06	RT
	K) ASSEMBLE SWIVEL STUDS		8-11-06	AK
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-4-06	RT
	M) IRON SIGHT ALIGNMENT		8-4-06	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-4-06	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-7-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-7-06	BD
670	FINAL INSPECTION A) HEADSPACE		8-11-06	AK
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.62</u> <u>2.60</u> <u>2.56</u> <u>2.56</u>	8-11-06	RA
	C) FUNCTION		8-11-06	AK
690	PACK		10-30-06	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 7-20-06

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	2.56		2.58	
PULL #2	2.51	2.61		2.59	
PULL #3	2.57	2.59		2.50	
PULL #4	2.55	2.42		2.44	
PULL #5	2.49	2.60		2.44	
TOTAL	12.69	12.78		12.55	
AVERAGE	2.53	2.55		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	2.97		
PULL #2	3.01	3.09		
PULL #3	3.00	2.97		
PULL #4	3.05	2.93		
PULL #5	3.05	3.07		
TOTAL	15.22	15.03		
AVERAGE	3.04	3.00		

	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	4.16	4.07		4.17
PULL #2	4.20	4.10		4.15
PULL #3	4.14	4.06		4.08
PULL #4	3.92	3.90		4.22
PULL #5	4.05	3.94		4.17
TOTAL	20.47	20.07		20.79
AVERAGE	4.09	4.01		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577183.__0

FILE DATE AND TIME: 08/07/2006 08:25

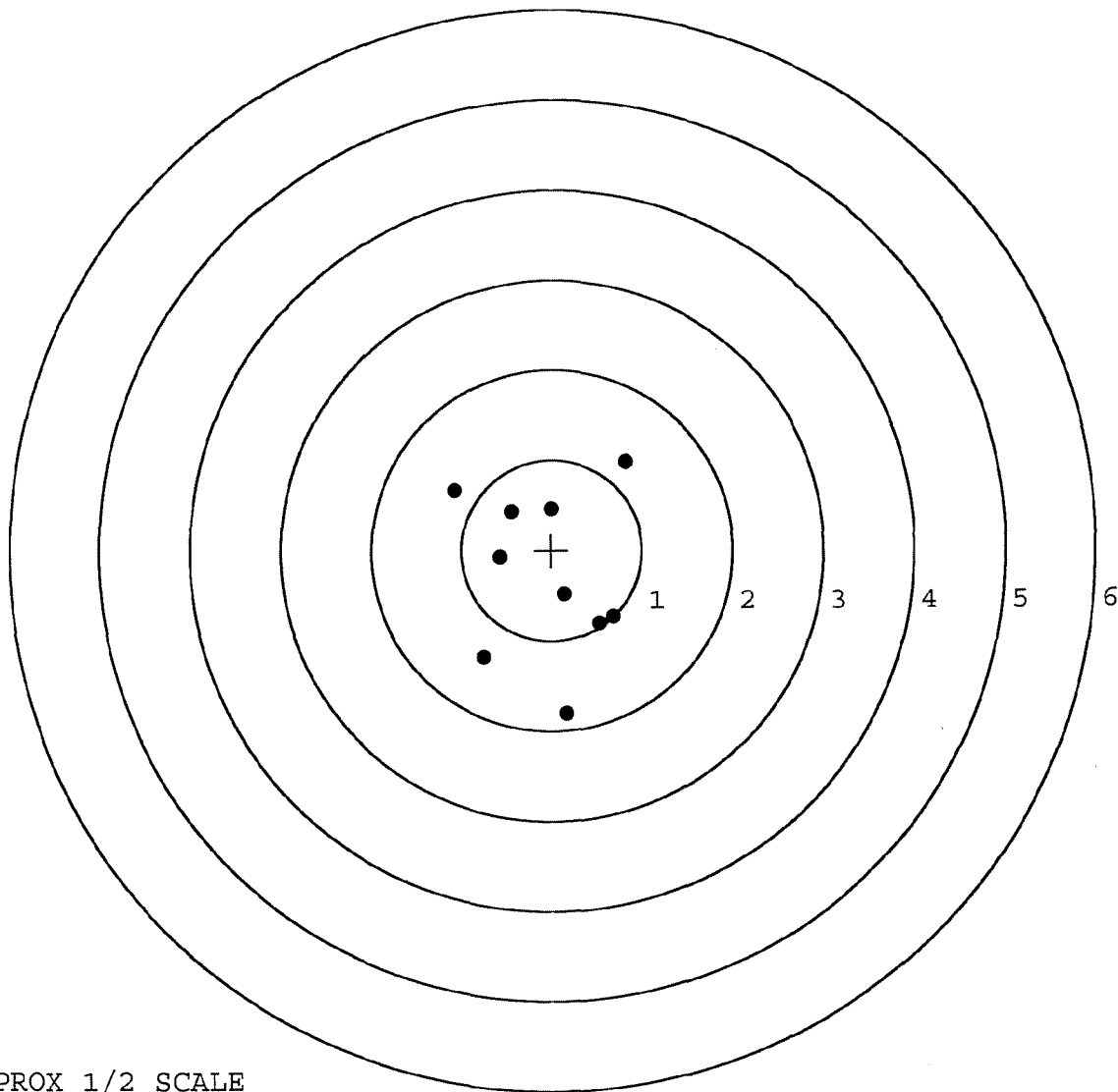
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.029
The Average Y Centroid of the Five Target Set:	-0.042
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.721
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.372
The Distance from Centroid Target #3 to Centroid Target #1:	0.259
The Distance from Centroid Target #4 to Centroid Target #1:	0.246
The Distance from Centroid Target #5 to Centroid Target #1:	0.316

SERIAL NUMBER: G6577183. __0
TARGET NUMBER: 1
FILE DATE: 08/07/2006
FILE TIME: 08:25

X CENTROID: -0.052
Y CENTROID: -0.259
POA TO CENTROID: 0.264
HORZ SPREAD: 1.901
VERT SPREAD: 2.797
GROUP SPREAD: 2.872
MIN RADIUS: 0.299
MAX RADIUS: 1.575
MEAN RADIUS: 0.967
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.824	0.978
2:	-0.010	0.458
3:	-0.451	0.429
4:	-1.077	0.666
5:	-0.572	-0.080
6:	0.141	-0.488
7:	0.528	-0.812
8:	0.170	-1.819
9:	-0.750	-1.186
10:	0.682	-0.740



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577183. __0

TARGET NUMBER: 2

FILE DATE: 08/07/2006

FILE TIME: 08:25

POINT#	X	Y
1:	1.002	0.045
2:	0.819	-0.534
3:	0.128	-0.173
4:	0.075	-0.650
5:	-0.424	-0.457
6:	-0.088	0.310
7:	0.220	0.687
8:	-0.086	0.707
9:	-0.363	0.685
10:	-0.870	0.389

X CENTROID: 0.041

Y CENTROID: 0.101

POA TO CENTROID: 0.109

HORZ SPREAD: 1.872

VERT SPREAD: 1.357

GROUP SPREAD: 1.925

MIN RADIUS: 0.246

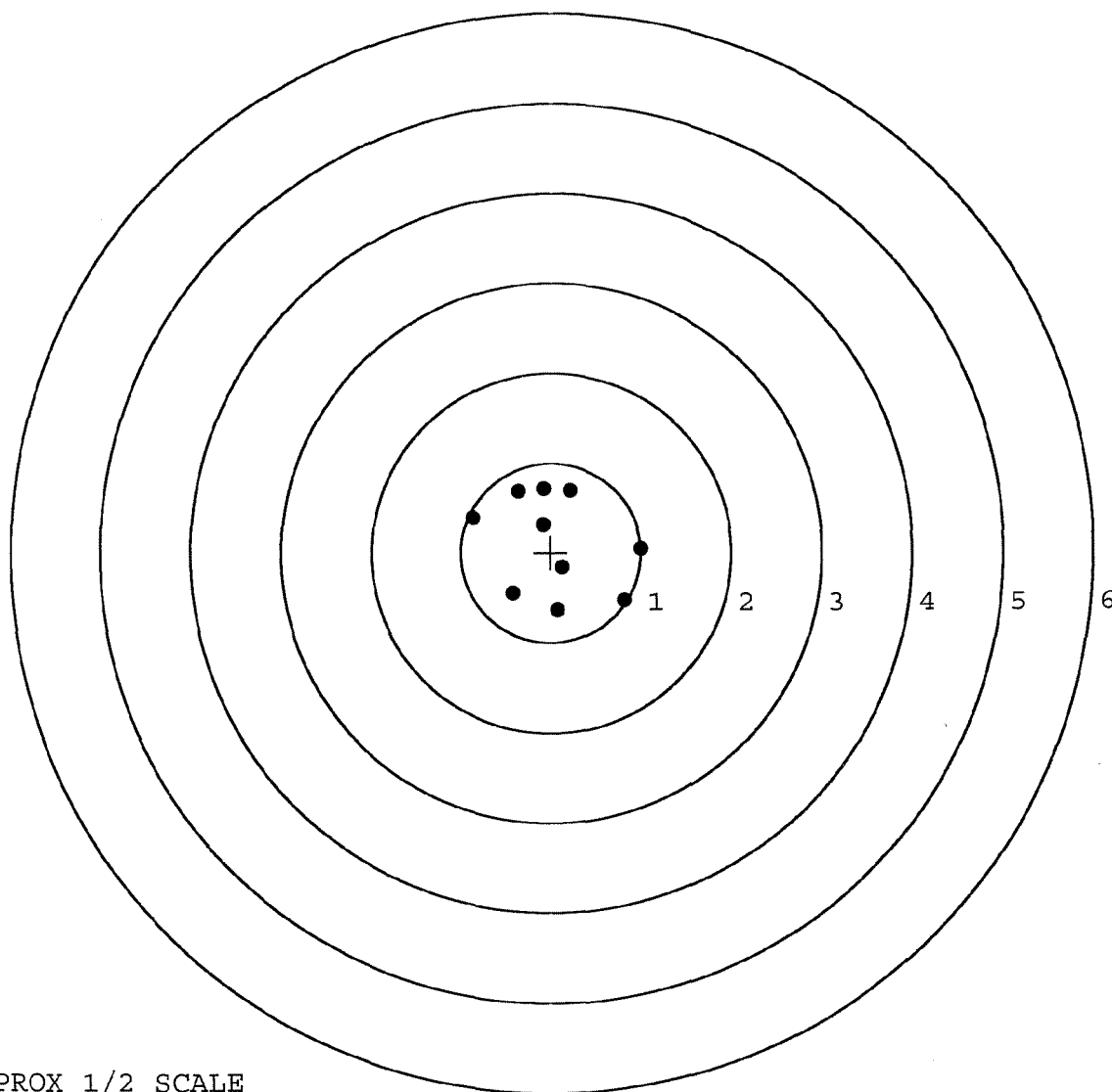
MAX RADIUS: 1.004

MEAN RADIUS: 0.688

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

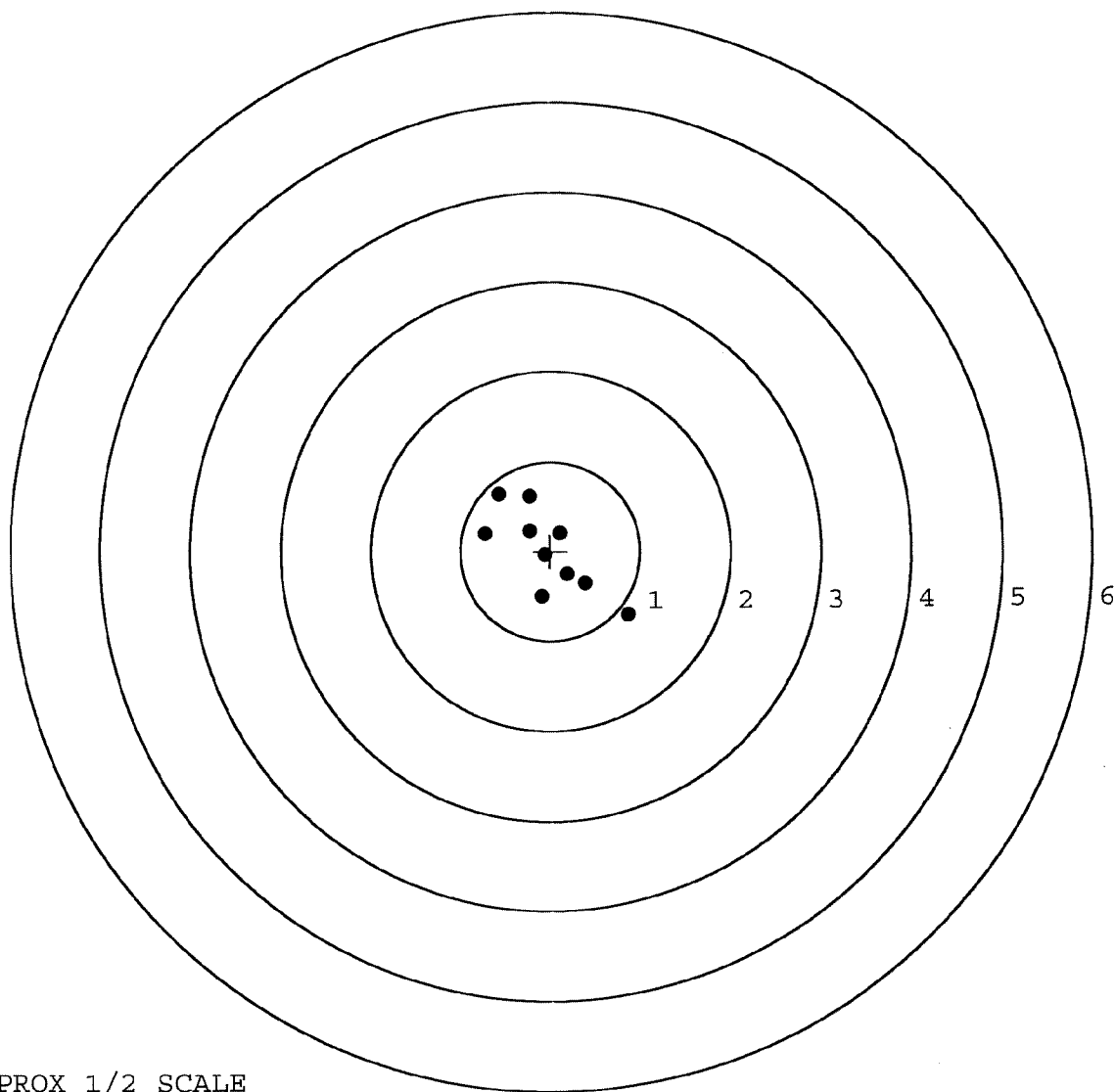


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577183. __0
TARGET NUMBER: 3
FILE DATE: 08/07/2006
FILE TIME: 08:25

X CENTROID: -0.036
Y CENTROID: 0.000
POA TO CENTROID: 0.036
HORZ SPREAD: 1.584
VERT SPREAD: 1.363
GROUP SPREAD: 1.977
MIN RADIUS: 0.053
MAX RADIUS: 1.149
MEAN RADIUS: 0.537
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.861	-0.719
2:	-0.094	-0.513
3:	-0.723	0.201
4:	-0.571	0.644
5:	-0.228	0.619
6:	0.110	0.204
7:	0.389	-0.362
8:	-0.227	0.231
9:	-0.064	-0.045
10:	0.187	-0.264



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577183. 0

TARGET NUMBER: 4

FILE DATE: 08/07/2006

FILE TIME: 08:25

POINT#	X	Y
1:	1.381	-0.311
2:	0.055	-0.560
3:	-0.322	-1.391
4:	-0.931	-0.894
5:	0.078	-0.108
6:	-0.021	0.161
7:	0.591	0.514
8:	0.241	0.817
9:	0.153	0.612
10:	-0.032	0.340

X CENTROID: 0.119

Y CENTROID: -0.082

POA TO CENTROID: 0.145

HORZ SPREAD: 2.312

VERT SPREAD: 2.208

GROUP SPREAD: 2.279

MIN RADIUS: 0.049

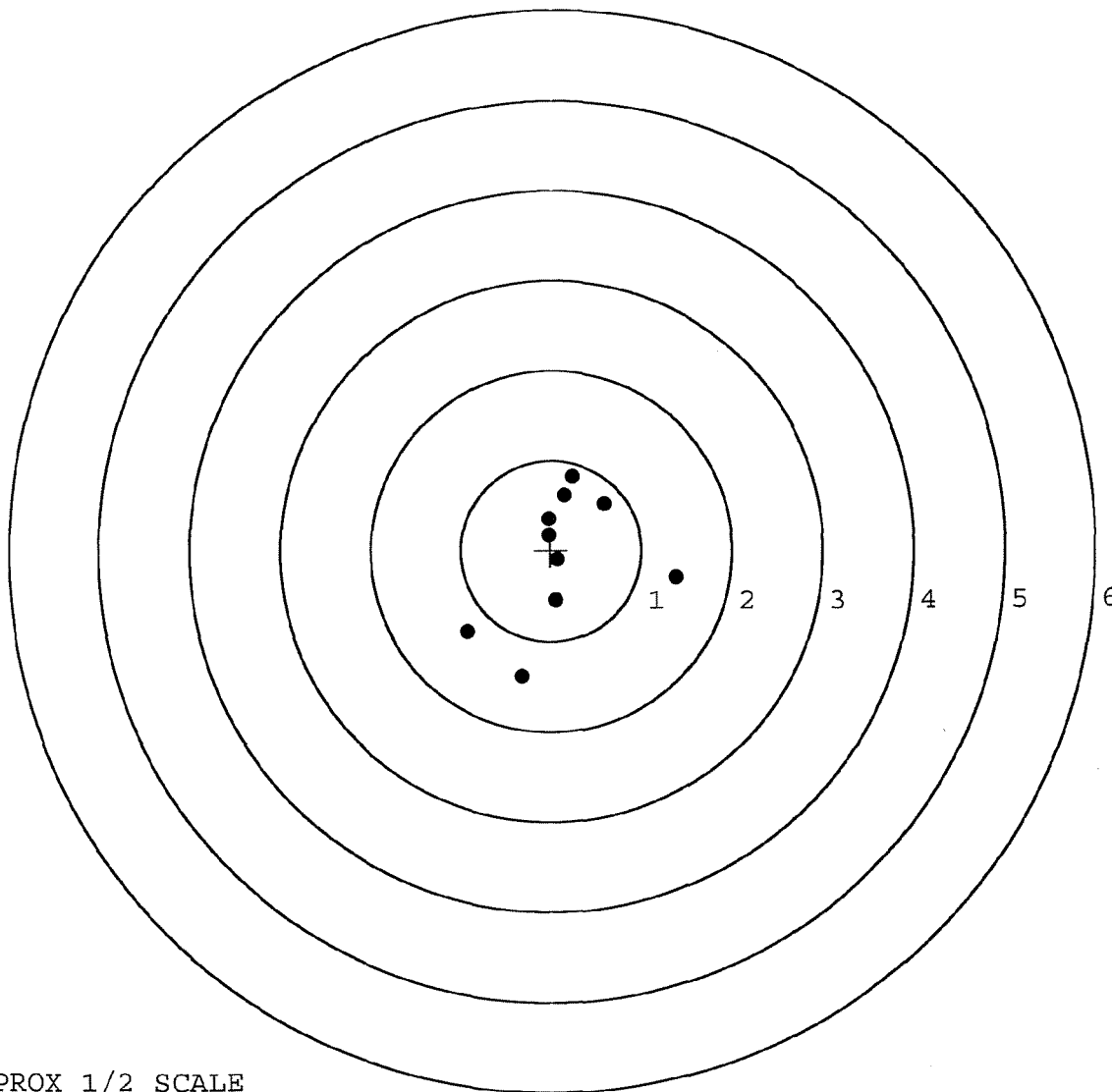
MAX RADIUS: 1.381

MEAN RADIUS: 0.761

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

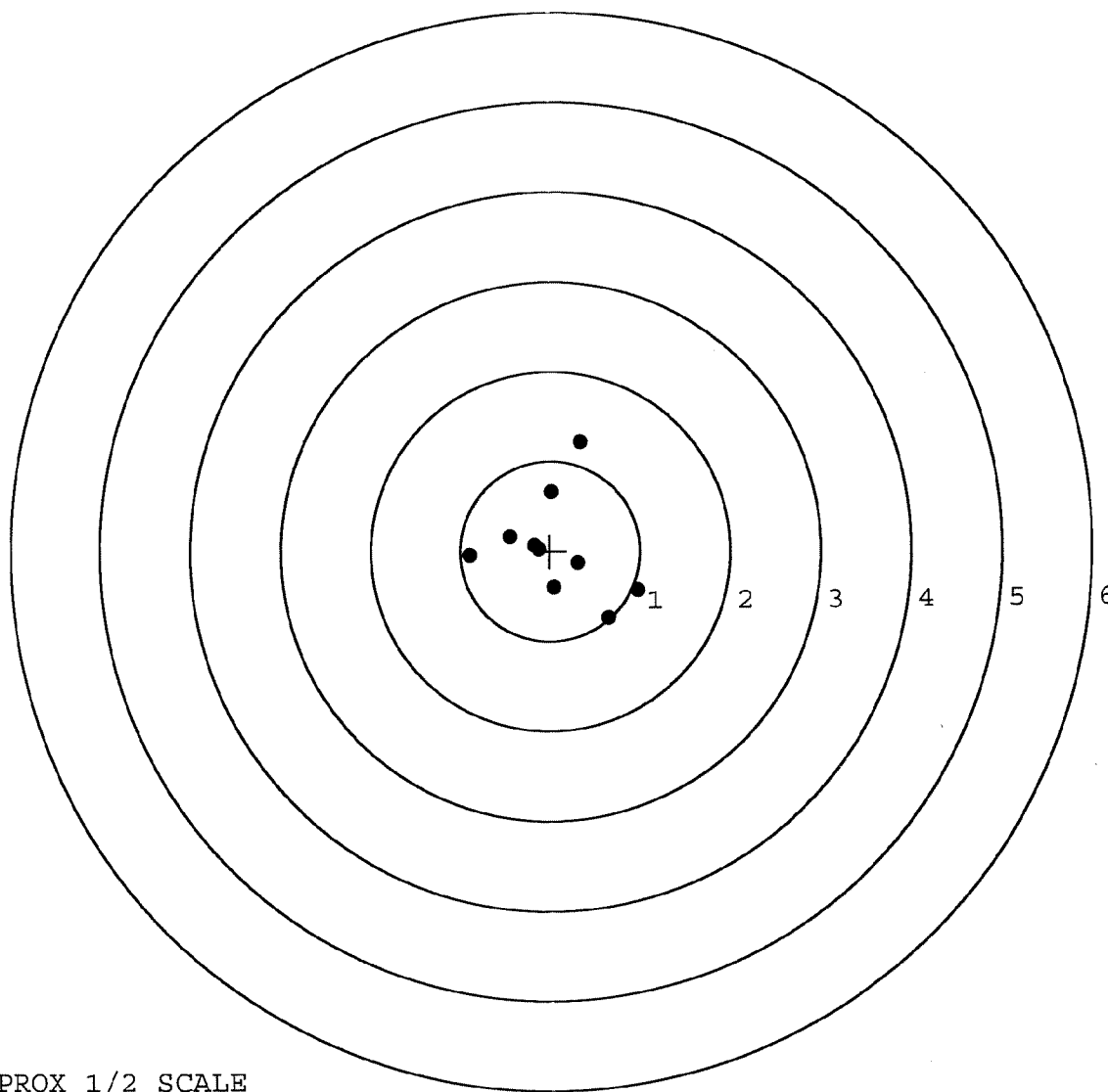


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577183. __0
TARGET NUMBER: 5
FILE DATE: 08/07/2006
FILE TIME: 08:25

X CENTROID: 0.070
Y CENTROID: 0.033
POA TO CENTROID: 0.077
HORZ SPREAD: 1.871
VERT SPREAD: 1.955
GROUP SPREAD: 1.979
MIN RADIUS: 0.201
MAX RADIUS: 1.207
MEAN RADIUS: 0.652
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.975	-0.446
2:	0.653	-0.747
3:	0.046	-0.411
4:	0.311	-0.138
5:	0.345	1.208
6:	0.019	0.659
7:	-0.131	0.022
8:	-0.447	0.161
9:	-0.896	-0.043
10:	-0.178	0.062



TARGET APPROX 1/2 SCALE