

G 6577184

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

UPC



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UPC



SERIAL NO.



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

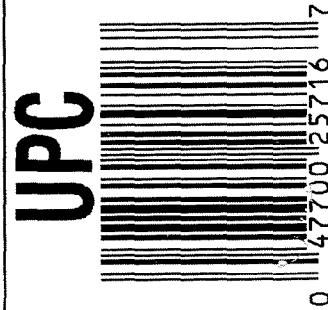
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6577184



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577184

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		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>APD</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		8-7-06	BLC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-7-06	BLC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-7-06	BLC
	D) OIL FIRING PIN ASSEMBLY		8-7-06	BLC
	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>7.5</u> <u>7.5</u>	8-11-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</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>1.023</u> <u>1.023</u>	8-11-06	DA
	J) ASSEMBLE STOCK		8-7-06	BLG
	K) ASSEMBLE SWIVEL STUDS		8-11-06	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-7-06	RLG
	M) IRON SIGHT ALIGNMENT		8-7-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-7-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-7-06	mjh
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-17-06	mjd
670	FINAL INSPECTION A) HEADSPACE		8-11-06	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.53</u> <u>2.85</u> <u>2.52</u> <u>2.71</u>	8-11-06	DA
	C) FUNCTION		8-11-06	AC
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

7-13-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	249	242		256	
PULL #2	234	250		251	
PULL #3	235	258		246	
PULL #4	258	258		259	
PULL #5	252	239		245	
TOTAL	1228	1247		1257	
AVERAGE	245	249		251	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	304	324		
PULL #2	317	328		
PULL #3	321	322		
PULL #4	317	323		
PULL #5	301	328		
TOTAL	1560	1625		
AVERAGE	312	325		

	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	405	403		424
PULL #2	411	413		419
PULL #3	408	407		417
PULL #4	399	403		419
PULL #5	404	406		418
TOTAL	2027	2032		2097
AVERAGE	405	406		419

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577184.__0
FILE DATE AND TIME: 08/07/2006 16:42

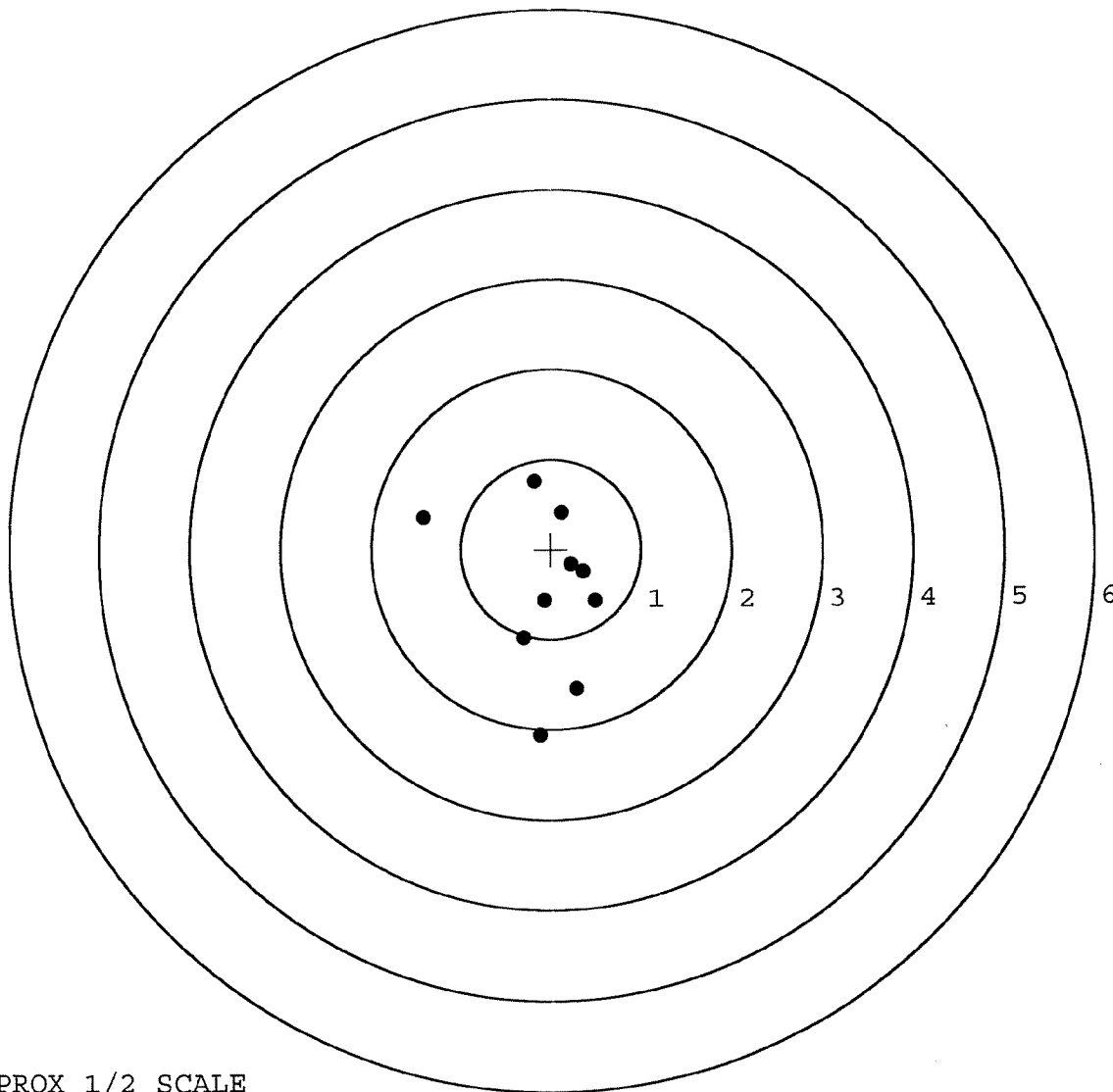
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.034
The Average Y Centroid of the Five Target Set:	-0.087
The Average Point of Impact of the Five Target Set:	0.094
The Average Mean Radius of the Five Target Set:	0.699
The Distance from POA to Centroid Target #1:	0.471
The Distance from Centroid Target #2 to Centroid Target #1:	0.697
The Distance from Centroid Target #3 to Centroid Target #1:	0.320
The Distance from Centroid Target #4 to Centroid Target #1:	0.452
The Distance from Centroid Target #5 to Centroid Target #1:	0.520

SERIAL NUMBER: G6577184. __0
TARGET NUMBER: 1
FILE DATE: 08/07/2006
FILE TIME: 16:42

X CENTROID: -0.064
Y CENTROID: -0.466
POA TO CENTROID: 0.471
HORZ SPREAD: 1.908
VERT SPREAD: 2.825
GROUP SPREAD: 2.825
MIN RADIUS: 0.112
MAX RADIUS: 1.606
MEAN RADIUS: 0.860
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.183	0.754
2:	0.125	0.410
3:	0.222	-0.168
4:	0.354	-0.249
5:	0.493	-0.578
6:	-0.076	-0.578
7:	-0.310	-0.990
8:	0.281	-1.559
9:	-0.132	-2.071
10:	-1.415	0.364

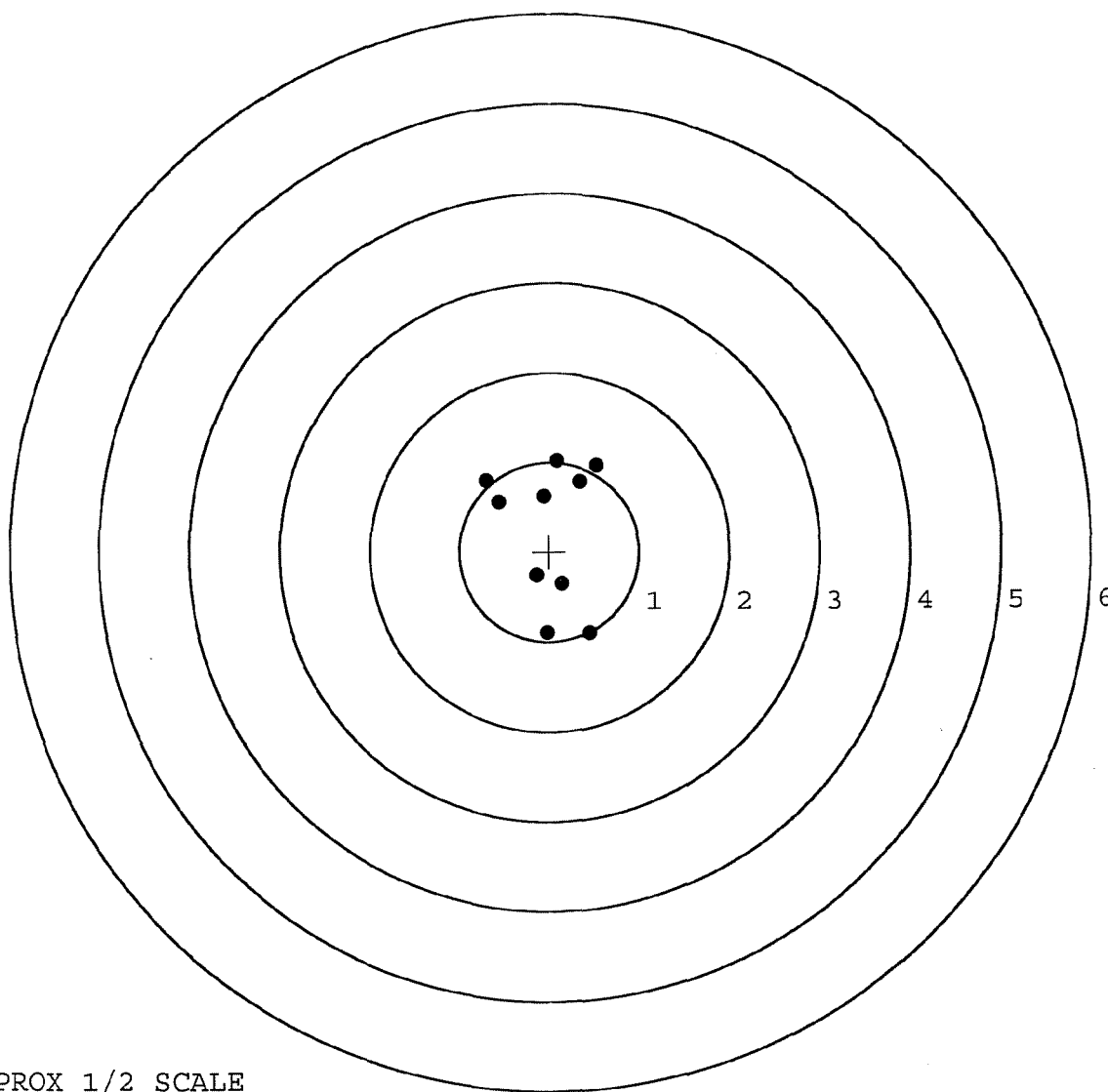


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577184. __0
TARGET NUMBER: 2
FILE DATE: 08/07/2006
FILE TIME: 16:42

X CENTROID: 0.005
Y CENTROID: 0.227
POA TO CENTROID: 0.227
HORZ SPREAD: 1.230
VERT SPREAD: 1.929
GROUP SPREAD: 2.062
MIN RADIUS: 0.395
MAX RADIUS: 1.224
MEAN RADIUS: 0.779
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.565	0.558
2:	-0.701	0.797
3:	-0.065	0.616
4:	0.092	1.016
5:	0.529	0.963
6:	0.341	0.779
7:	-0.142	-0.269
8:	0.143	-0.366
9:	0.451	-0.913
10:	-0.029	-0.909



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577184. __0

TARGET NUMBER: 3

FILE DATE: 08/07/2006

FILE TIME: 16:42

POINT#	X	Y
1:	-0.664	0.263
2:	-0.467	0.026
3:	-0.379	-0.289
4:	-0.047	-0.228
5:	0.069	-0.323
6:	0.405	-0.530
7:	0.350	-0.261
8:	0.169	0.216
9:	0.328	0.198
10:	1.270	-1.016

X CENTROID: 0.103

Y CENTROID: -0.194

POA TO CENTROID: 0.220

HORZ SPREAD: 1.934

VERT SPREAD: 1.279

GROUP SPREAD: 2.319

MIN RADIUS: 0.133

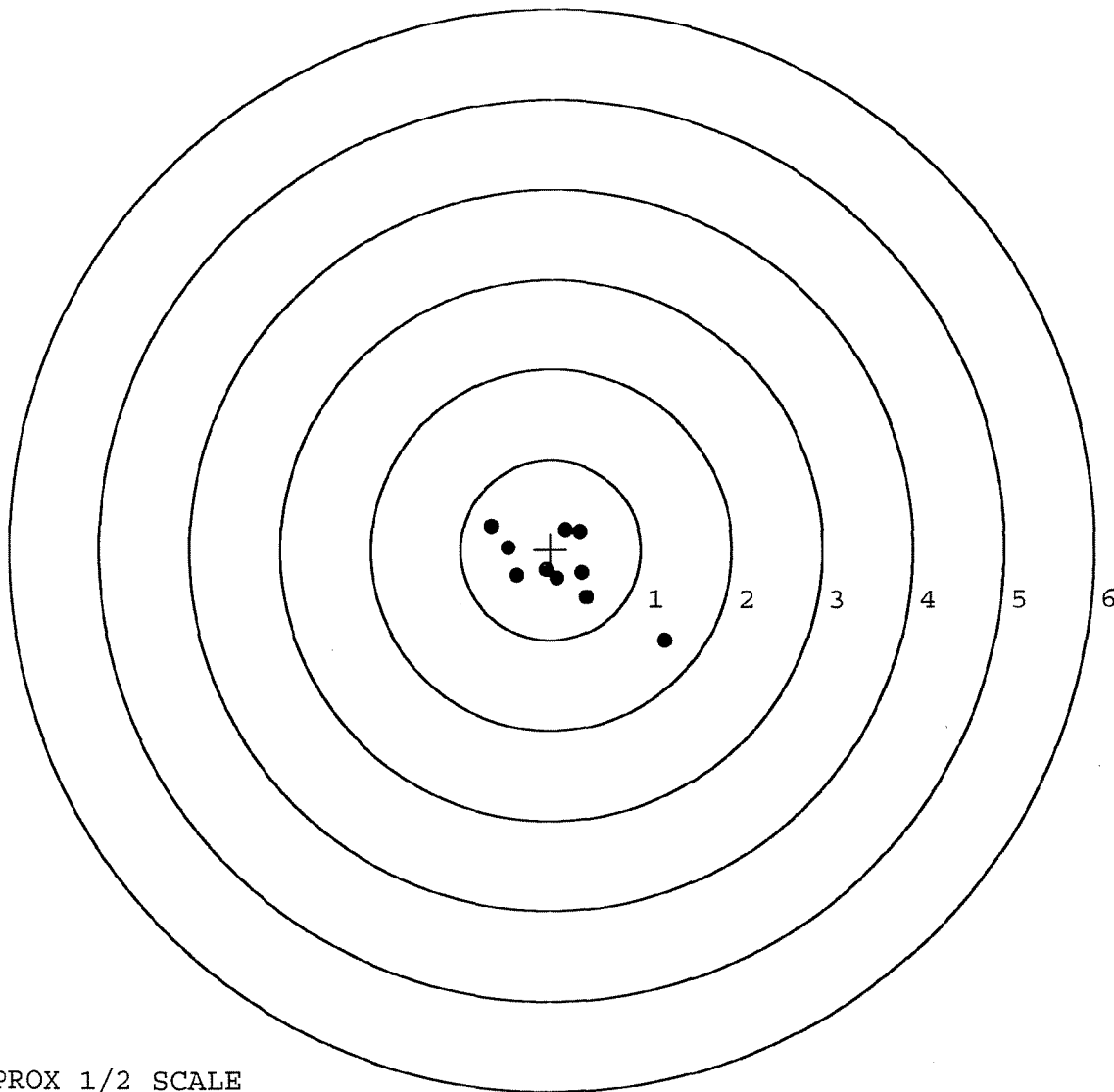
MAX RADIUS: 1.427

MEAN RADIUS: 0.528

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577184. 0

TARGET NUMBER: 4

FILE DATE: 08/07/2006

FILE TIME: 16:42

POINT#	X	Y
1:	-0.507	0.249
2:	-0.212	0.219
3:	-0.814	0.715
4:	-0.126	0.679
5:	0.990	0.047
6:	0.688	-0.224
7:	0.271	-0.425
8:	0.026	-0.242
9:	-0.119	-0.445
10:	-0.271	-0.757

X CENTROID: -0.007

Y CENTROID: -0.018

POA TO CENTROID: 0.020

HORZ SPREAD: 1.804

VERT SPREAD: 1.472

GROUP SPREAD: 1.924

MIN RADIUS: 0.226

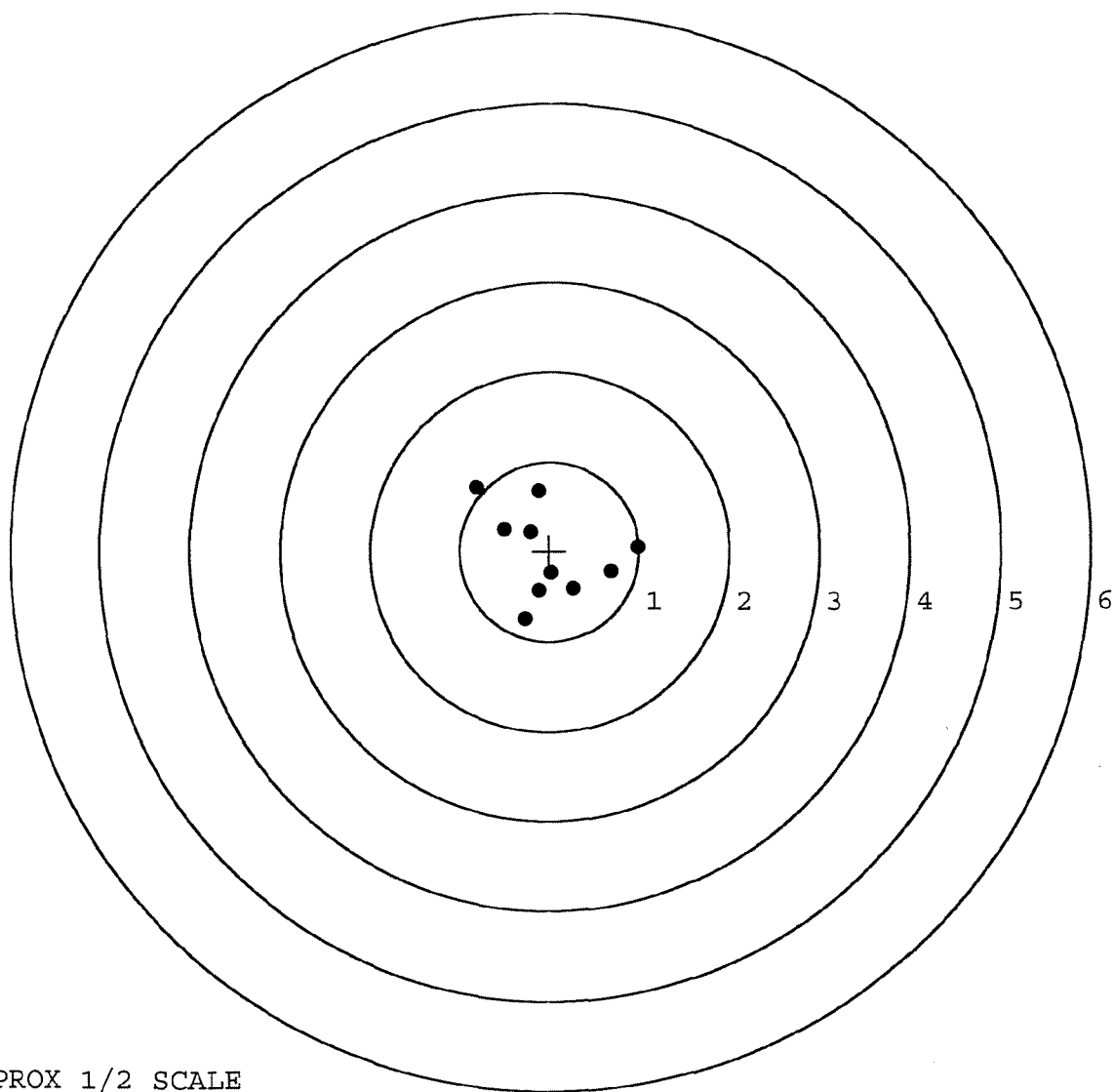
MAX RADIUS: 1.090

MEAN RADIUS: 0.635

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577184. __0

TARGET NUMBER: 5

FILE DATE: 08/07/2006

FILE TIME: 16:42

POINT#	X	Y
1:	-0.776	-0.071
2:	-0.214	1.597
3:	0.242	0.544
4:	1.251	-0.098
5:	0.647	-0.570
6:	0.399	-0.484
7:	0.081	-0.410
8:	-0.191	-0.365
9:	-0.195	-0.118
10:	0.078	0.128

X CENTROID: 0.132

Y CENTROID: 0.015

POA TO CENTROID: 0.133

HORZ SPREAD: 2.027

VERT SPREAD: 2.167

GROUP SPREAD: 2.332

MIN RADIUS: 0.125

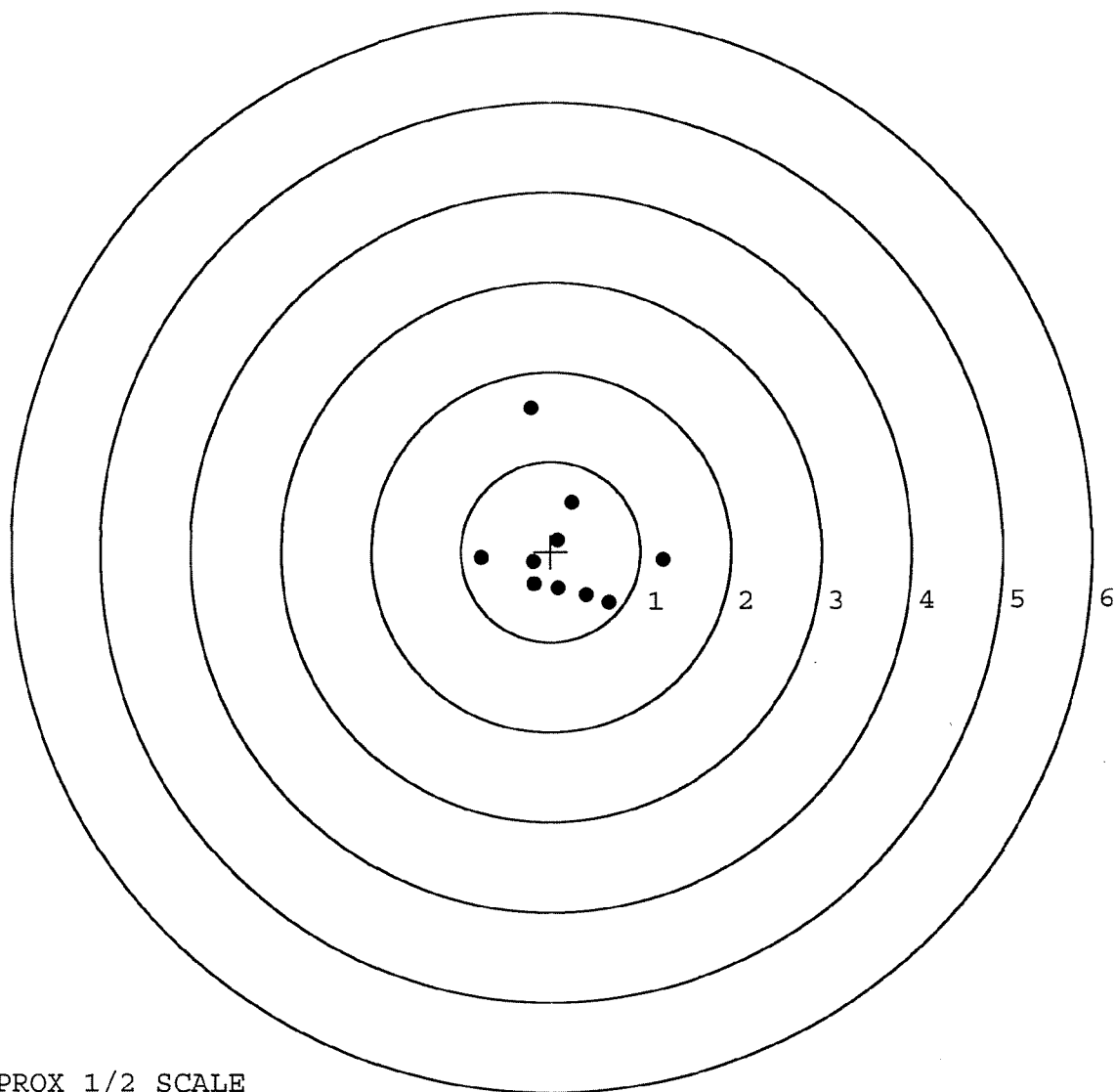
MAX RADIUS: 1.619

MEAN RADIUS: 0.695

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE