

G 657-2197

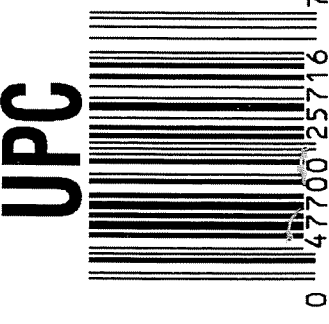
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6577197



DD FORM

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

UPC



0 47700 25716 7

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

UPC



0 47700 25716 7

SERIAL NO.



66577197

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6577197

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-1-06	BLG
420	ASSEMBLE ACTION		8-1-06	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 17 2006	8-2-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	8/17/06	mm
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-16-06	TRW
520	GOFF BLAST BBL / REC		8-17-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/23/06	LB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-21-06	mm
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-21-06	mm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-21-06	mm
	D) OIL FIRING PIN ASSEMBLY		8-30-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8/30/06	mm

F004 REV 5/2006

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M2400086687

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.2</u> <u>7.0</u> <u>7.2</u>	8-31-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>5.2</u>	8-31-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/13/06	WTH
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	8-31-06	DA
	J) ASSEMBLE STOCK		8-30-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10/13/06	WTH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-30-06	BLC
	M) IRON SIGHT ALIGNMENT		8-30-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-30-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-30-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-30-06	MTM
670	FINAL INSPECTION A) HEADSPACE		10/13/06	WTH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.53</u> <u>2.54</u> <u>2.52</u> <u>2.57</u>	8-31-06	DA
	C) FUNCTION		10/13/06	WTH
690	PACK		11/4/06	DA

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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 8-29-06
TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.43		2.49	
PULL #2	2.48	2.54		2.55	
PULL #3	2.43	2.53		2.59	
PULL #4	2.46	2.54		2.47	
PULL #5	2.43	2.59		2.52	
TOTAL	12.42	12.63		12.62	
AVERAGE	2.48	2.52		2.52	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.06		
PULL #2	3.08	3.00		
PULL #3	3.17	2.90		
PULL #4	3.18	3.00		
PULL #5	3.12	3.01		
TOTAL	15.67	14.97		
AVERAGE	3.13	2.99		

	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	4.04	3.92		4.17
PULL #2	3.98	3.92		3.96
PULL #3	3.99	3.93		4.05
PULL #4	4.01	3.97		4.04
PULL #5	3.98	3.99		4.03
TOTAL	20.00	19.73		20.25
AVERAGE	4.00	3.94		4.05

EVALUATION RECORD - M-24 TRIGGER ASSEMBLY

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M2400086689

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577197.___0
FILE DATE AND TIME: 08/30/2006 20:15

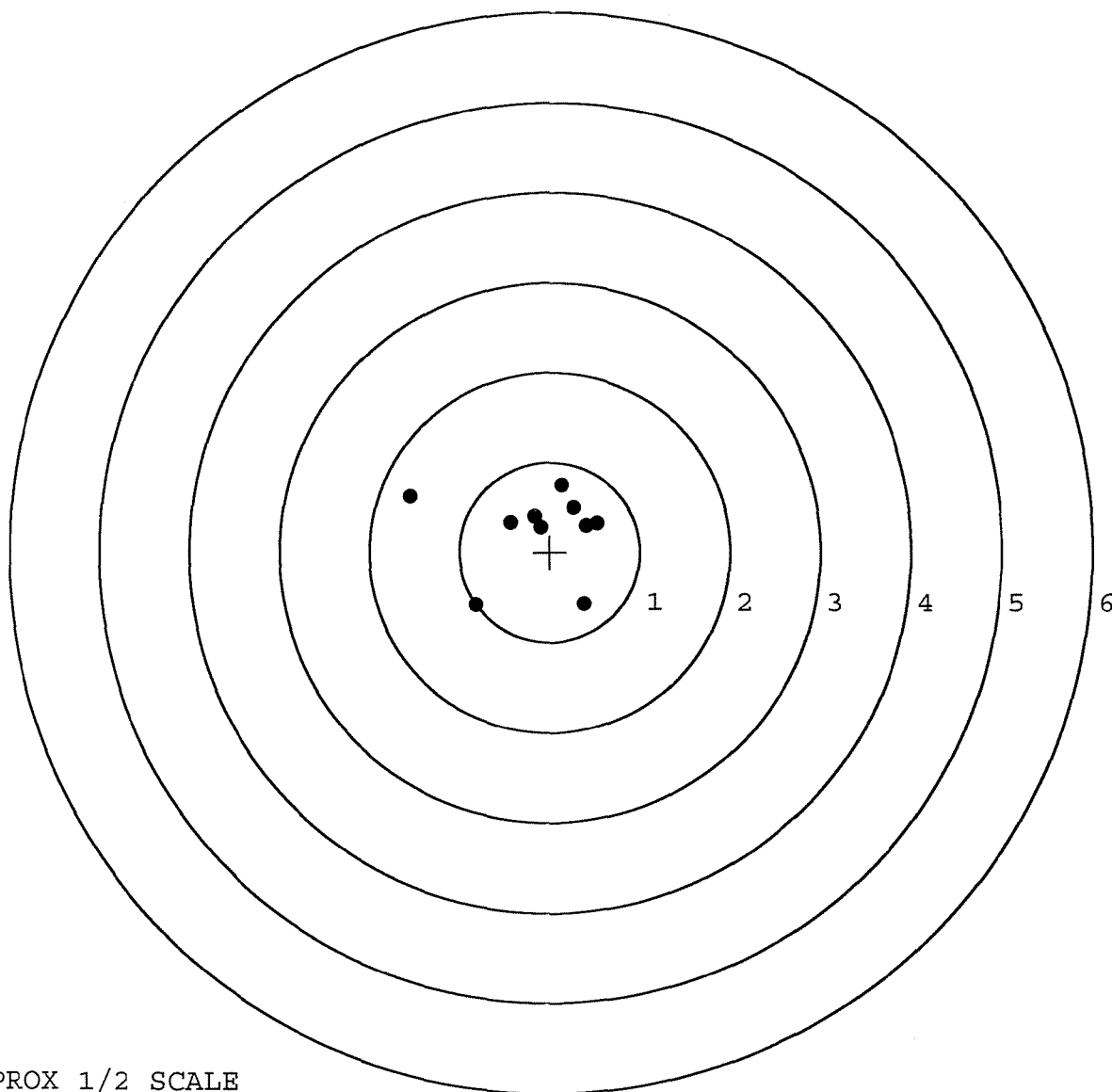
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.048
The Average Y Centroid of the Five Target Set:	0.050
The Average Point of Impact of the Five Target Set:	0.069
The Average Mean Radius of the Five Target Set:	0.750
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.250
The Distance from Centroid Target #3 to Centroid Target #1:	0.227
The Distance from Centroid Target #4 to Centroid Target #1:	0.420
The Distance from Centroid Target #5 to Centroid Target #1:	0.386

SERIAL NUMBER: G6577197. __0
TARGET NUMBER: 1
FILE DATE: 08/30/2006
FILE TIME: 20:15

POINT#	X	Y
1:	-0.815	-0.596
2:	0.390	-0.580
3:	-1.559	0.613
4:	0.527	0.318
5:	0.413	0.288
6:	0.260	0.492
7:	0.129	0.743
8:	-0.438	0.324
9:	-0.101	0.272
10:	-0.168	0.393

X CENTROID: -0.136
Y CENTROID: 0.227
POA TO CENTROID: 0.264
HORZ SPREAD: 2.086
VERT SPREAD: 1.339
GROUP SPREAD: 2.285
MIN RADIUS: 0.057
MAX RADIUS: 1.474
MEAN RADIUS: 0.633
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

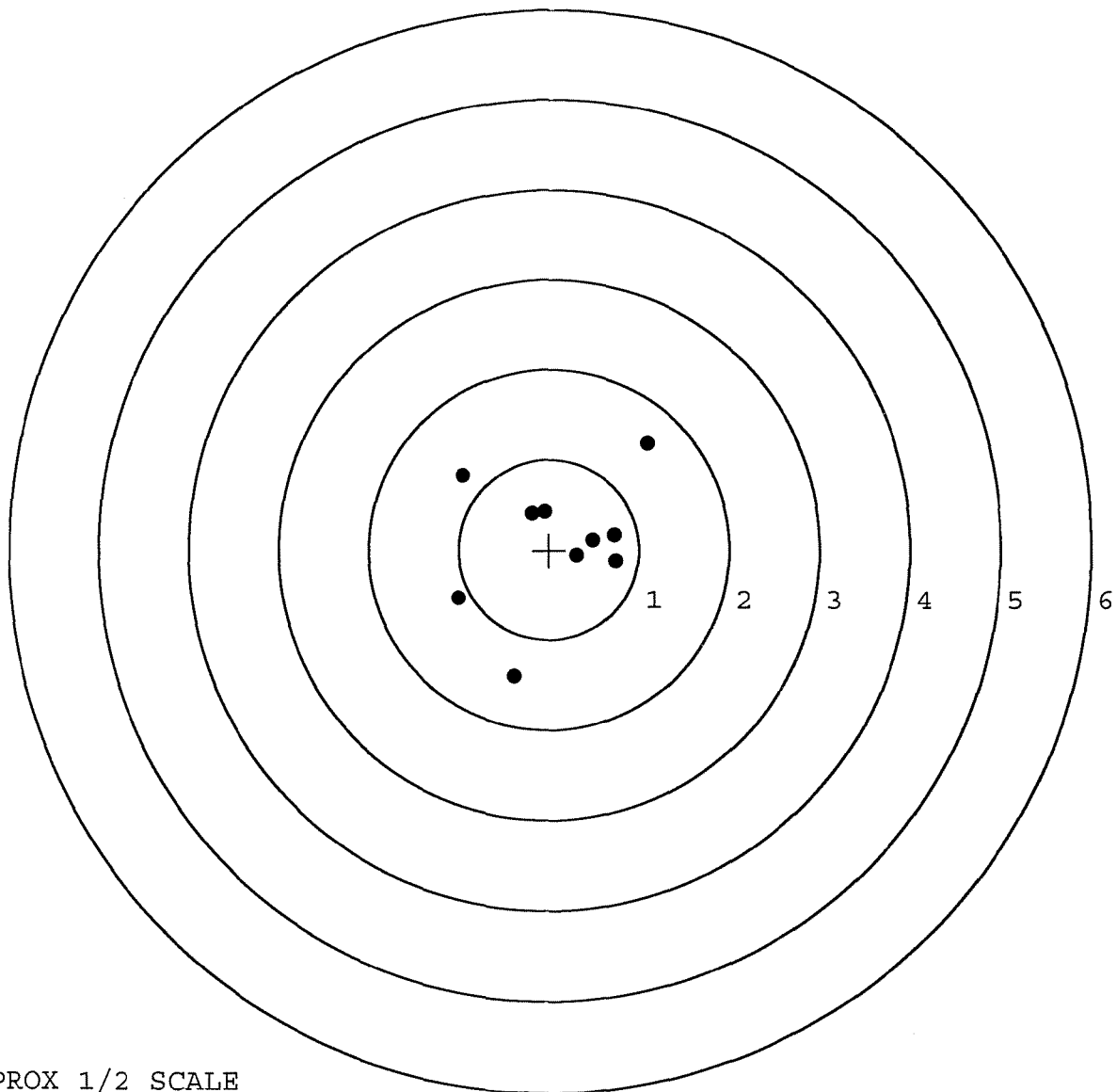


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577197. __0
TARGET NUMBER: 2
FILE DATE: 08/30/2006
FILE TIME: 20:15

POINT#	X	Y
1:	-0.383	-1.407
2:	-1.006	-0.541
3:	-0.965	0.814
4:	1.091	1.175
5:	-0.192	0.401
6:	-0.052	0.421
7:	0.740	-0.122
8:	0.733	0.171
9:	0.492	0.109
10:	0.311	-0.060

X CENTROID: 0.077
Y CENTROID: 0.096
POA TO CENTROID: 0.123
HORZ SPREAD: 2.097
VERT SPREAD: 2.582
GROUP SPREAD: 2.973
MIN RADIUS: 0.281
MAX RADIUS: 1.572
MEAN RADIUS: 0.839
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

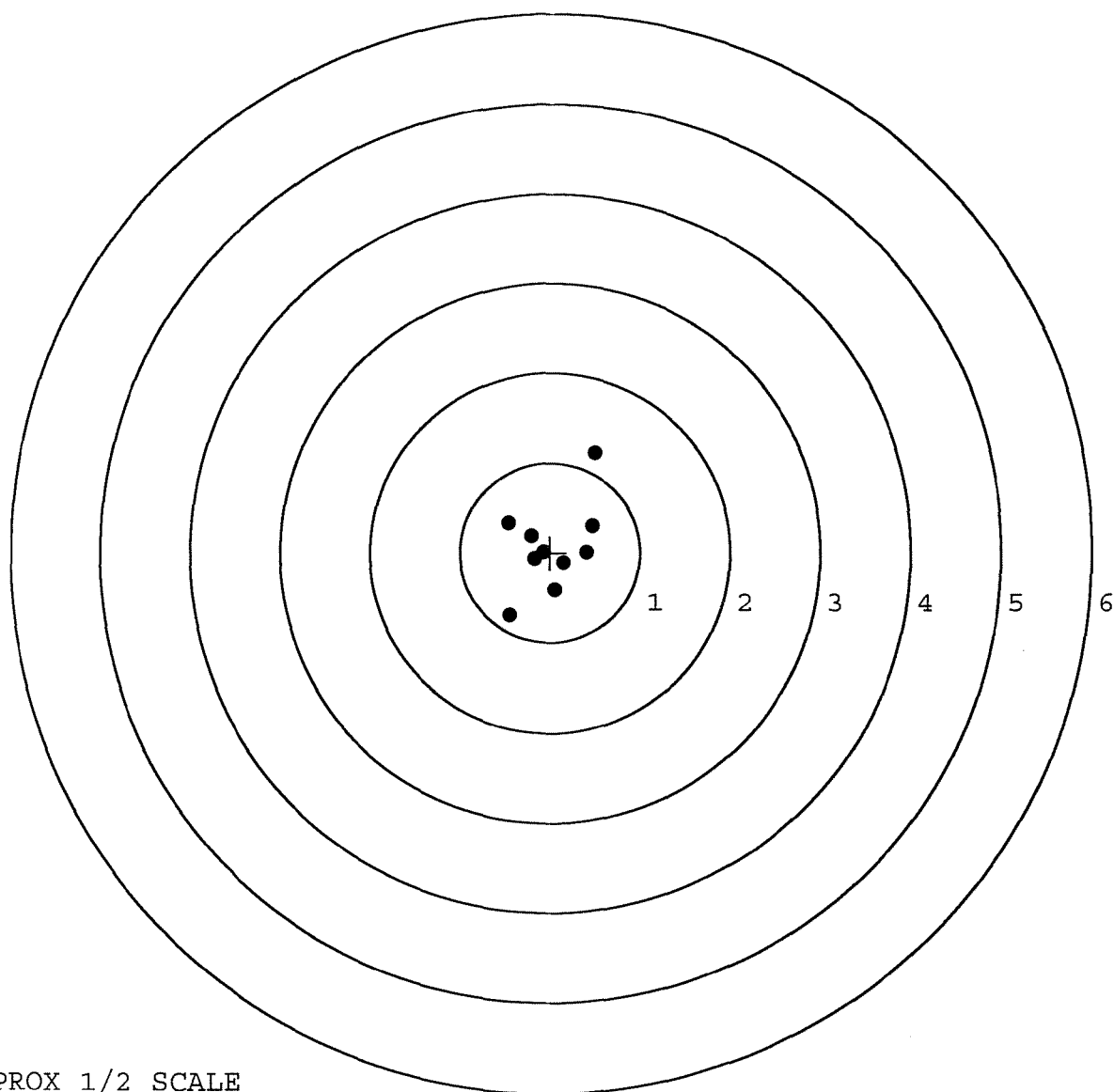


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577197. __0
TARGET NUMBER: 3
FILE DATE: 08/30/2006
FILE TIME: 20:15

POINT#	X	Y
1:	0.501	1.113
2:	0.476	0.297
3:	-0.449	-0.701
4:	-0.462	0.332
5:	-0.178	-0.073
6:	0.055	-0.416
7:	0.410	0.005
8:	0.147	-0.116
9:	-0.074	0.011
10:	-0.212	0.181

X CENTROID: 0.021
Y CENTROID: 0.063
POA TO CENTROID: 0.067
HORZ SPREAD: 0.963
VERT SPREAD: 1.814
GROUP SPREAD: 2.048
MIN RADIUS: 0.109
MAX RADIUS: 1.154
MEAN RADIUS: 0.482
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

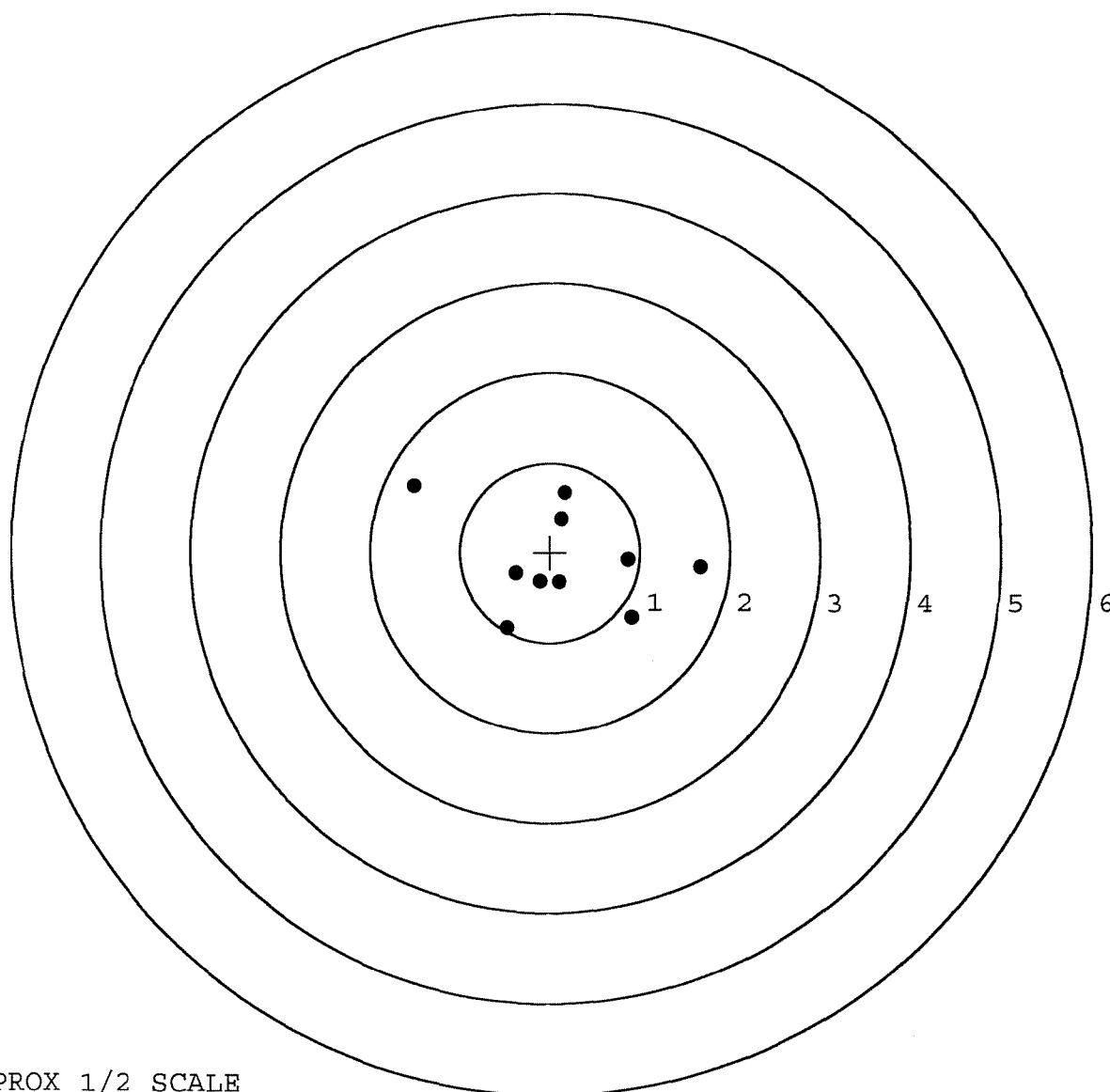


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577197. __0
TARGET NUMBER: 4
FILE DATE: 08/30/2006
FILE TIME: 20:15

POINT#	X	Y
1:	1.668	-0.165
2:	0.917	-0.722
3:	0.872	-0.083
4:	-1.515	0.735
5:	-0.474	-0.845
6:	-0.385	-0.236
7:	0.101	-0.331
8:	0.166	0.663
9:	0.122	0.370
10:	-0.120	-0.323

X CENTROID: 0.135
Y CENTROID: -0.094
POA TO CENTROID: 0.164
HORZ SPREAD: 3.183
VERT SPREAD: 1.580
GROUP SPREAD: 3.308
MIN RADIUS: 0.240
MAX RADIUS: 1.847
MEAN RADIUS: 0.843
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

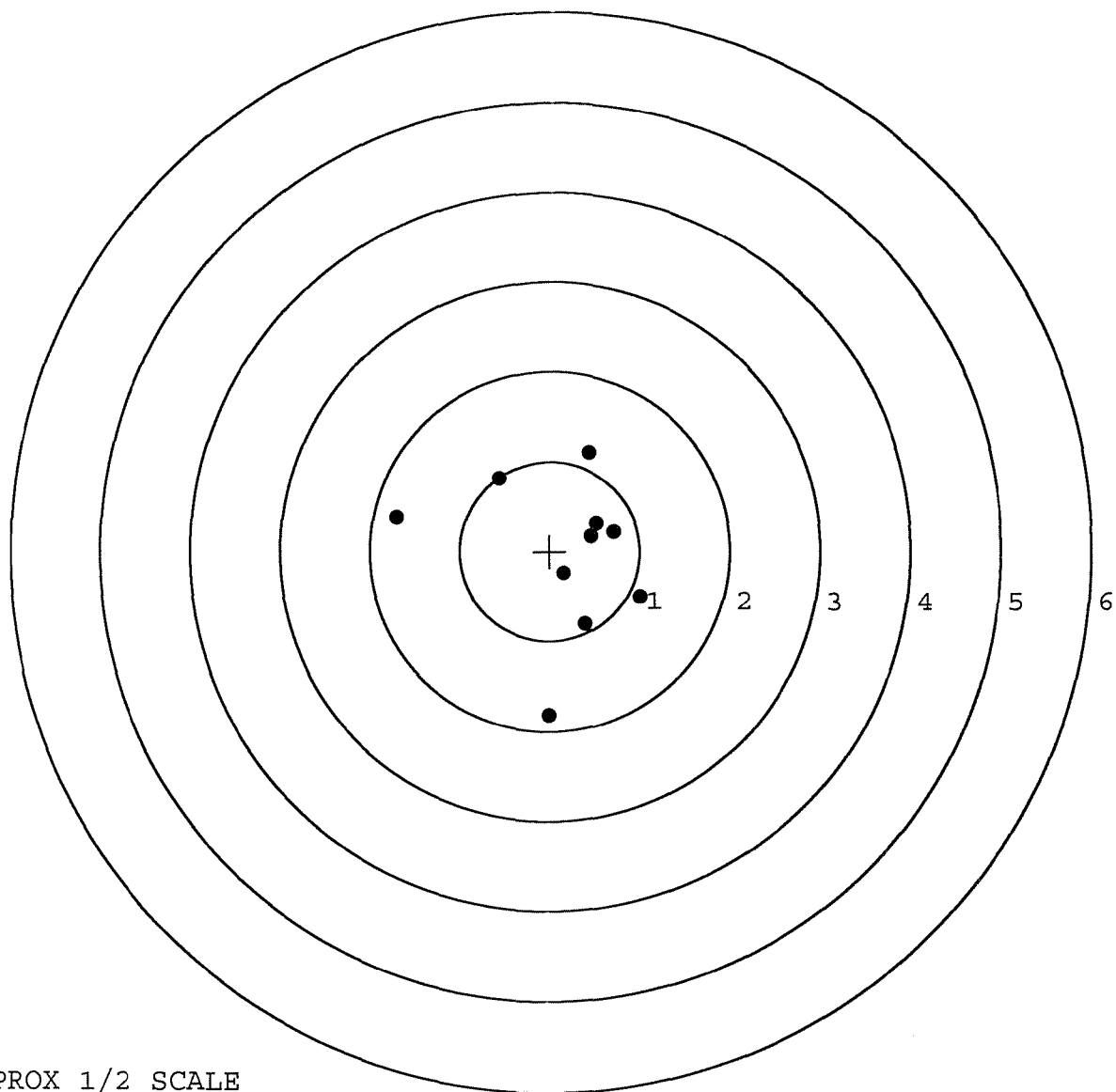


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577197. __0
TARGET NUMBER: 5
FILE DATE: 08/30/2006
FILE TIME: 20:15

POINT#	X	Y
1:	-0.004	-1.833
2:	-1.711	0.378
3:	-0.572	0.810
4:	0.434	1.095
5:	1.002	-0.507
6:	0.402	-0.819
7:	0.160	-0.247
8:	0.719	0.222
9:	0.526	0.319
10:	0.462	0.174

X CENTROID: 0.142
Y CENTROID: -0.041
POA TO CENTROID: 0.148
HORZ SPREAD: 2.713
VERT SPREAD: 2.928
GROUP SPREAD: 2.854
MIN RADIUS: 0.207
MAX RADIUS: 1.900
MEAN RADIUS: 0.953
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE