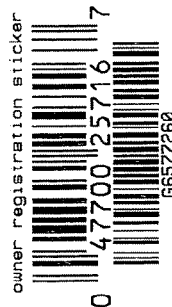


GCS77260

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

- INSTRUCTION BOOK 3518

DD FORM

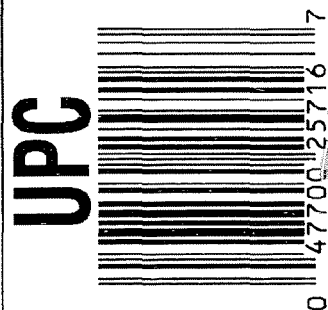


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6577260



ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G657 7260

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		5-9-06	RTZ
440	PROOF		5-9-06	TRW
460	CHECK HEADSPACE		5-9-06	TRW
470	DIS-ASSEMBLE ACTION		5-10-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	5/10/06	uncl
500	ROLLMARK CALIBER		5-10-06	CW
510	DRILL AND TAP SIGHT HOLES		5-10-06	TRW
520	GOFF BLAST BBL / REC		5-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		5/15	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-6-06	OP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-6-06	OP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-6-06	OP
	D) OIL FIRING PIN ASSEMBLY		6-23-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	7-18-06	uncl

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.0</u> <u>7.0</u> <u>7.5</u>	7-11-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.0</u> <u>5.0</u> <u>5.0</u>	7-11-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		7-18-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.023</u> <u>.022</u>	7-11-06	RA
	J) ASSEMBLE STOCK		6-23-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		7-18-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-23-06	RTZ
	M) IRON SIGHT ALIGNMENT		6-23-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-23-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	6-23-06	L.P.R.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-23-06	MTM
670	FINAL INSPECTION A) HEADSPACE		7-18-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.10</u> <u>2.25</u> <u>2.08</u> <u>2.19</u>	7-17-06	A
	C) FUNCTION		7-18-06	MTM
690	PACK		11-16-06	BLC

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 6-22-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	246	254		246	
PULL #2	228	248		242	
PULL #3	260	250		237	
PULL #4	262	260		239	
PULL #5	268	259		246	
TOTAL	1264	1271		1210	
AVERAGE	252	254		242	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	307	304		
PULL #2	298	289		
PULL #3	310	318		
PULL #4	310	326		
PULL #5	293	297		
TOTAL	1518	1534		
AVERAGE	303	306		

	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	404		406
PULL #2	422	391		394
PULL #3	420	394		399
PULL #4	408	396		406
PULL #5	416	416		410
TOTAL	2071	2001		2015
AVERAGE	414	400		403

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577260.___0
FILE DATE AND TIME: 06/23/2006 17:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.030
The Average Y Centroid of the Five Target Set:	-0.054
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.764
The Distance from POA to Centroid Target #1:	0.039
The Distance from Centroid Target #2 to Centroid Target #1:	0.197
The Distance from Centroid Target #3 to Centroid Target #1:	0.146
The Distance from Centroid Target #4 to Centroid Target #1:	0.042
The Distance from Centroid Target #5 to Centroid Target #1:	0.284

SERIAL NUMBER: G6577260. __0

TARGET NUMBER: 1

FILE DATE: 06/23/2006

FILE TIME: 17:20

X CENTROID: -0.020

Y CENTROID: -0.034

POA TO CENTROID: 0.039

HORZ SPREAD: 1.540

VERT SPREAD: 2.094

GROUP SPREAD: 2.444

MIN RADIUS: 0.286

MAX RADIUS: 1.228

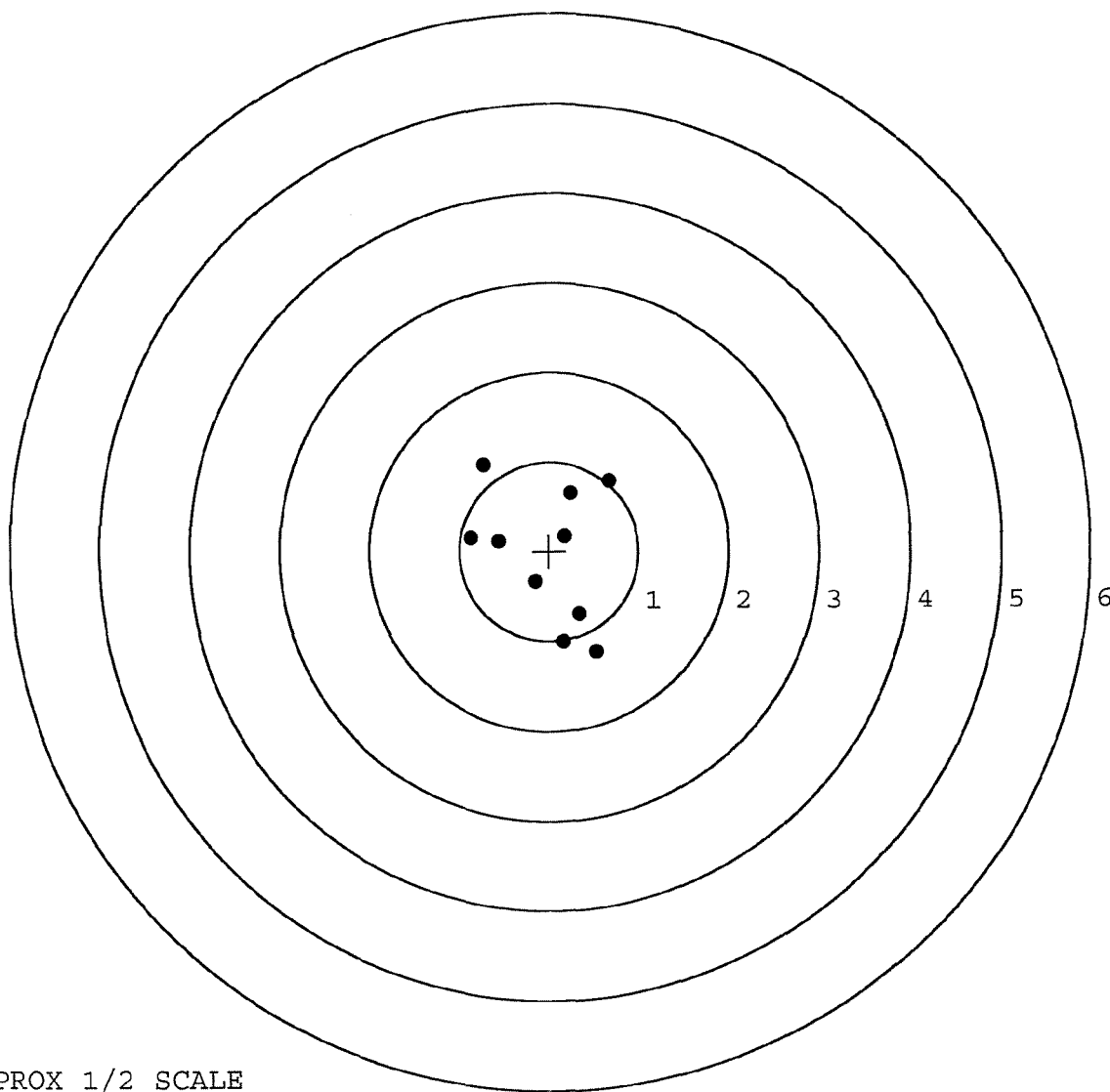
MEAN RADIUS: 0.807

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.727	0.970
2:	-0.868	0.154
3:	-0.566	0.116
4:	0.234	0.648
5:	0.672	0.791
6:	0.177	0.173
7:	-0.157	-0.341
8:	0.163	-1.020
9:	0.338	-0.704
10:	0.533	-1.124



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577260. __0

TARGET NUMBER: 2

FILE DATE: 06/23/2006

FILE TIME: 17:20

X CENTROID: 0.088

Y CENTROID: -0.198

POA TO CENTROID: 0.217

HORZ SPREAD: 1.600

VERT SPREAD: 2.255

GROUP SPREAD: 2.730

MIN RADIUS: 0.196

MAX RADIUS: 1.651

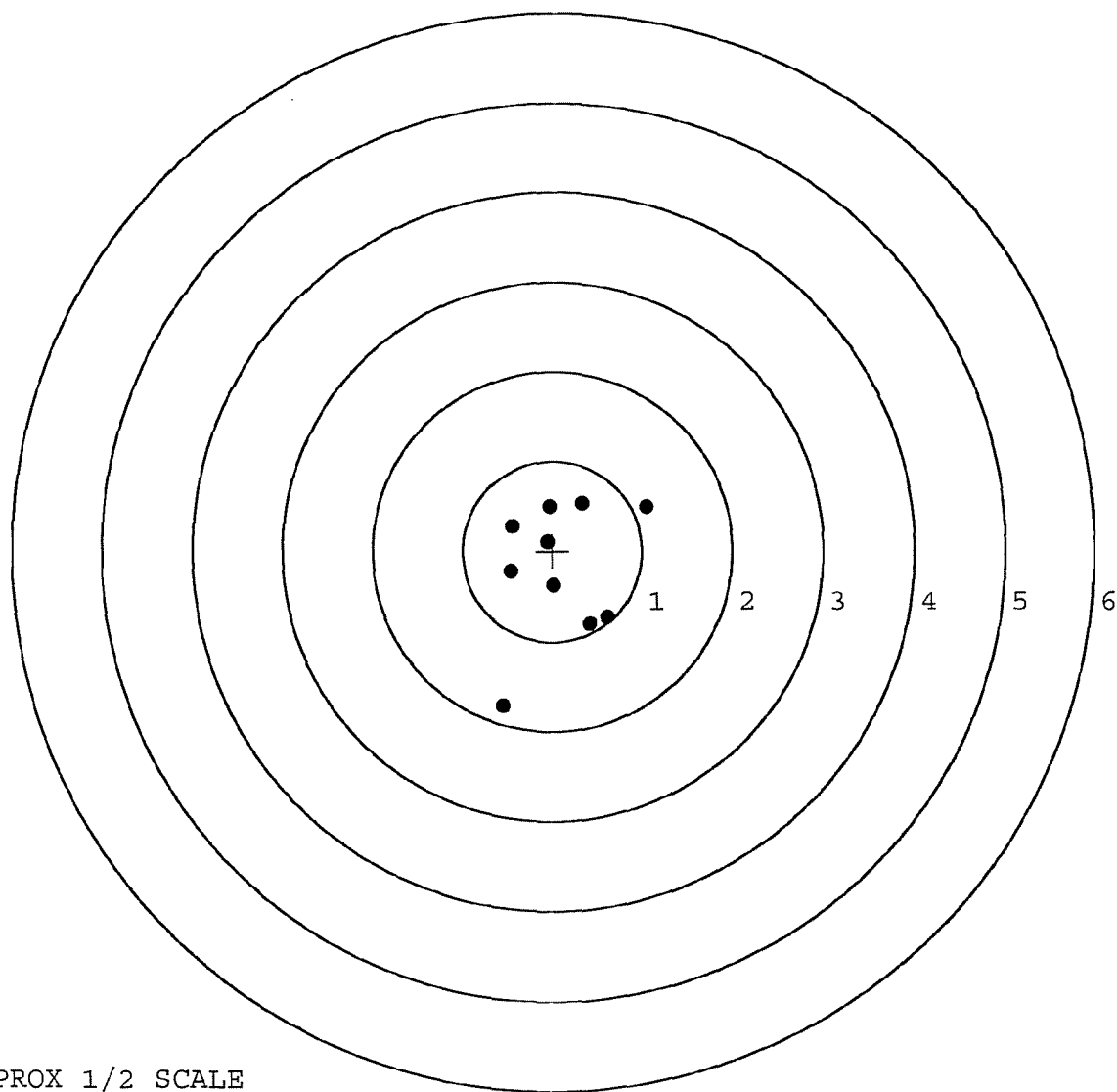
MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.547	-1.722
2:	0.619	-0.729
3:	1.053	0.490
4:	0.333	0.533
5:	-0.055	0.099
6:	-0.039	0.492
7:	-0.456	0.272
8:	-0.470	-0.233
9:	0.019	-0.381
10:	0.424	-0.801



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577260. __0

TARGET NUMBER: 3

FILE DATE: 06/23/2006

FILE TIME: 17:20

X CENTROID: -0.156

Y CENTROID: -0.086

POA TO CENTROID: 0.178

HORZ SPREAD: 1.593

VERT SPREAD: 1.976

GROUP SPREAD: 2.092

MIN RADIUS: 0.244

MAX RADIUS: 1.444

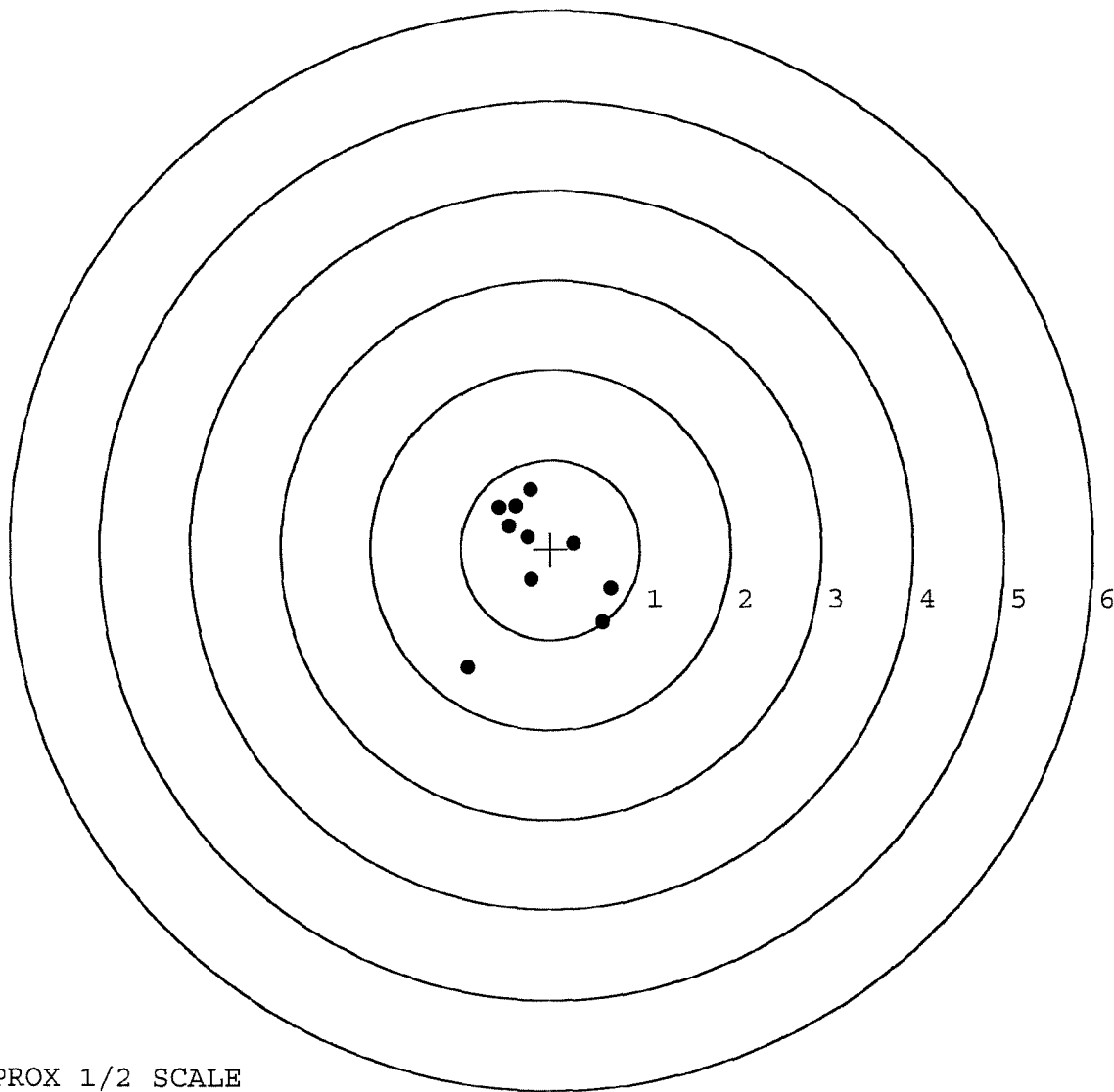
MEAN RADIUS: 0.686

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.919	-1.312
2:	0.586	-0.809
3:	0.674	-0.442
4:	0.258	0.057
5:	-0.226	-0.346
6:	-0.254	0.138
7:	-0.469	0.258
8:	-0.580	0.460
9:	-0.399	0.474
10:	-0.231	0.664



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577260. __0

TARGET NUMBER: 4

FILE DATE: 06/23/2006

FILE TIME: 17:20

X CENTROID: 0.012

Y CENTROID: -0.060

POA TO CENTROID: 0.062

HORZ SPREAD: 1.615

VERT SPREAD: 1.992

GROUP SPREAD: 2.079

MIN RADIUS: 0.151

MAX RADIUS: 1.292

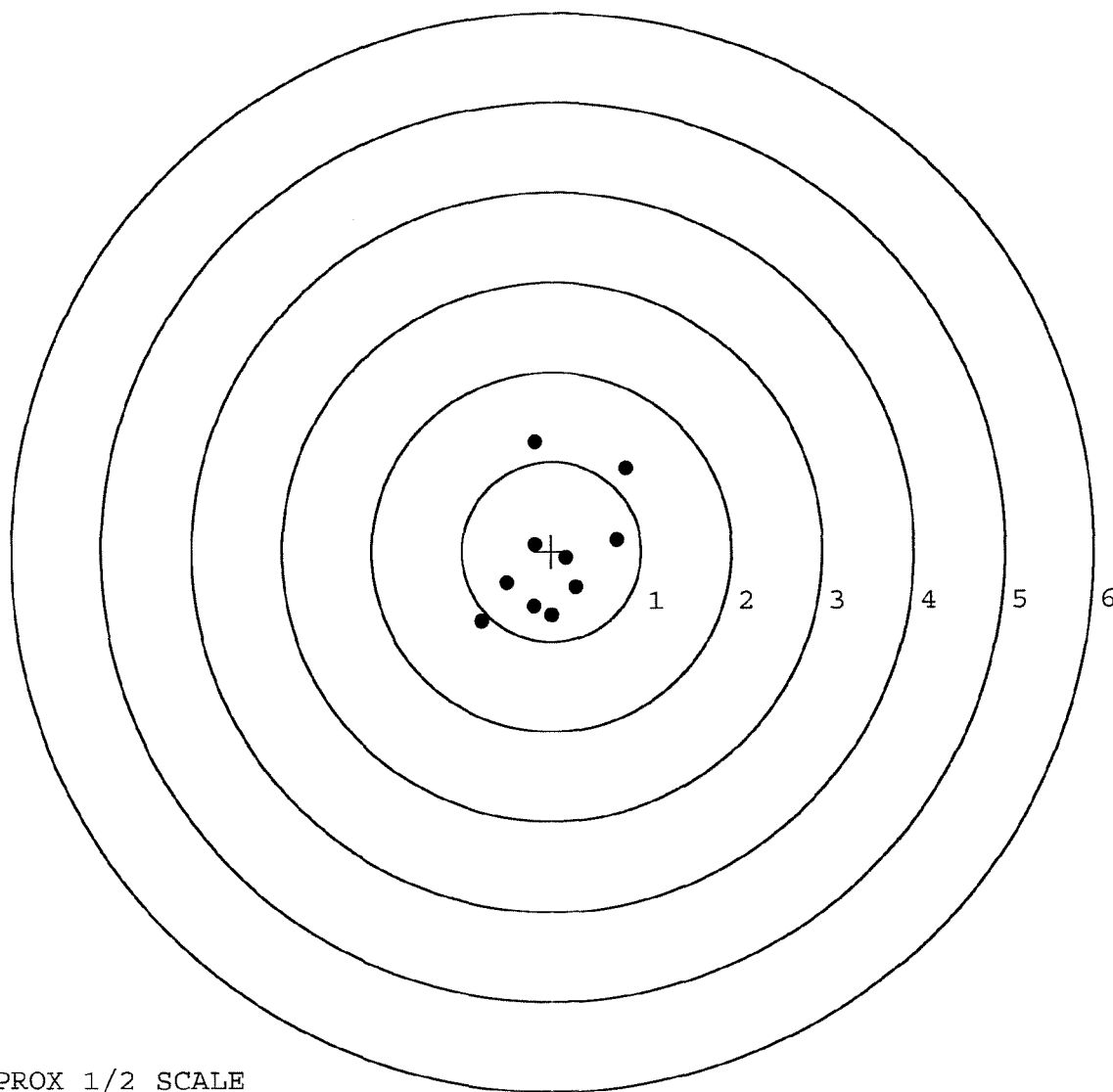
MEAN RADIUS: 0.707

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.188	1.216
2:	0.831	0.924
3:	-0.191	0.076
4:	0.731	0.129
5:	-0.503	-0.351
6:	0.273	-0.405
7:	-0.005	-0.719
8:	-0.206	-0.620
9:	-0.784	-0.776
10:	0.162	-0.078



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577260.___0

TARGET NUMBER: 5

FILE DATE: 06/23/2006

FILE TIME: 17:20

X CENTROID: 0.228

Y CENTROID: 0.106

POA TO CENTROID: 0.251

HORZ SPREAD: 2.433

VERT SPREAD: 1.983

GROUP SPREAD: 3.139

MIN RADIUS: 0.057

MAX RADIUS: 1.813

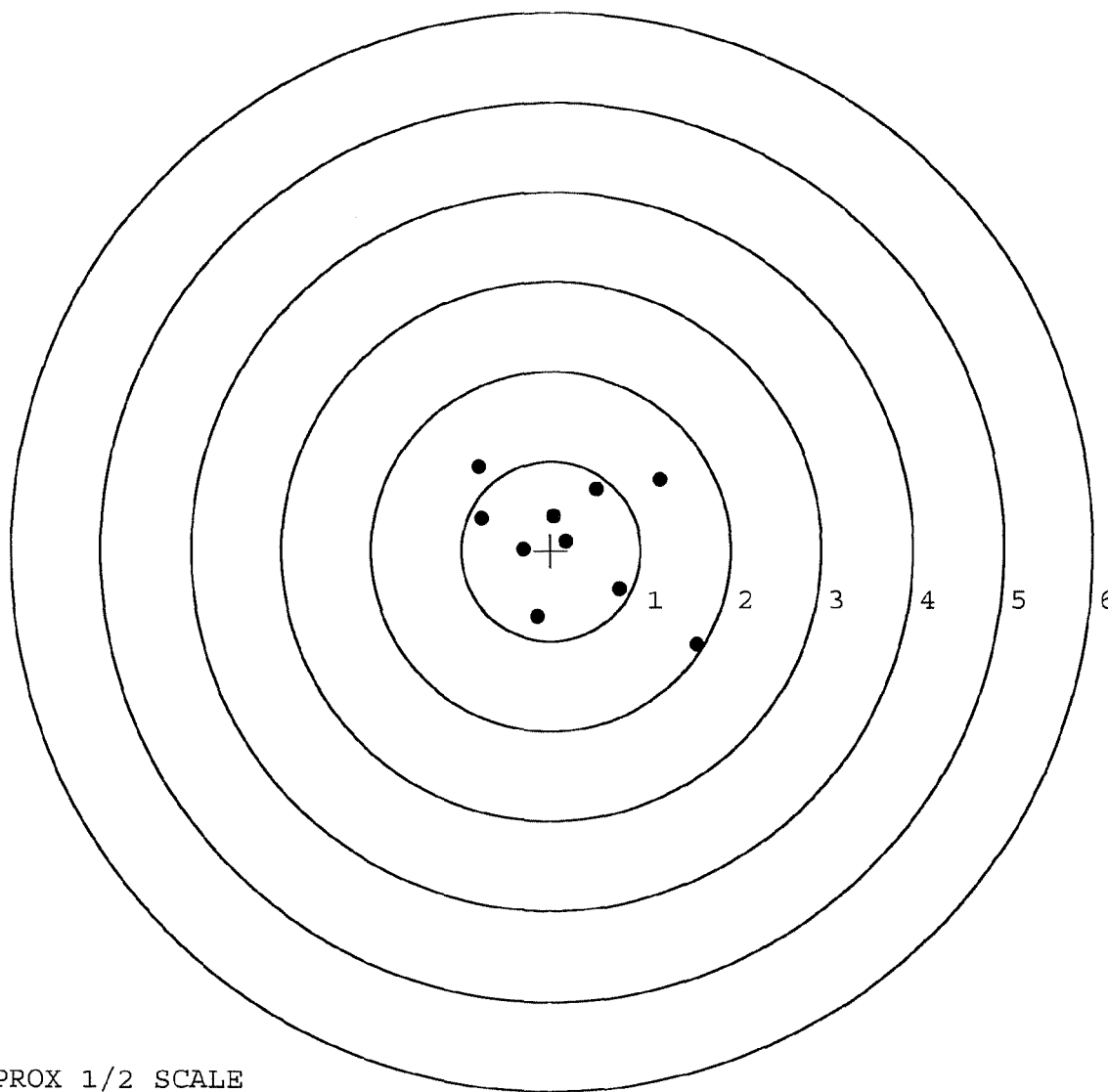
MEAN RADIUS: 0.865

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.803	0.940
2:	-0.779	0.355
3:	-0.310	0.011
4:	0.030	0.385
5:	0.171	0.106
6:	0.512	0.682
7:	1.216	0.793
8:	-0.153	-0.737
9:	0.761	-0.430
10:	1.630	-1.043



TARGET APPROX 1/2 SCALE