

G-6577289

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



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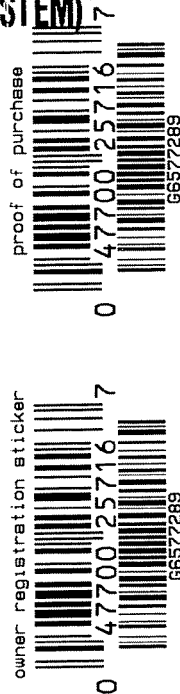
SERIAL NO.



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

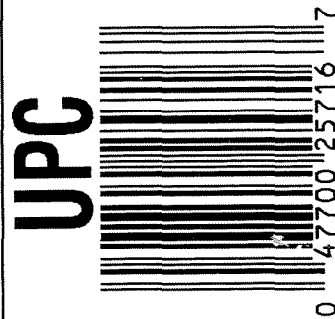
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6577289



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6577289

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-3-06	BLG
420	ASSEMBLE ACTION		8-3-06	BLG
430	ASSEMBLE TO STOCK		8-4-06	DK
440	PROOF	MAGNA-FLUX	8-4-06	BLG
460	CHECK HEADSPACE	INSPECTED	8-4-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 17 2006	8-4-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	8/17/06	<u>mm</u>
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)		8/21/06	RP
560	RE-ASSEMBLE ACTION		8/21/06	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8/21/06	RP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8/21/06	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8/21/06	RP
	D) OIL FIRING PIN ASSEMBLY		9-1-06	BLG
	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>6.0</u> <u>6.0</u> <u>6.0</u>	9/25/06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	9/25/06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.0245</u> <u>.025</u>	9/25/06	DA
	J) ASSEMBLE STOCK		9-1-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10-7-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-1-06	BLC
	M) IRON SIGHT ALIGNMENT		9-1-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-1-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-15-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-15-06	BD
670	FINAL INSPECTION A) HEADSPACE		10-7-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.71</u> <u>2.82</u> <u>2.70</u> <u>2.71</u>	9-16-06	DA
	C) FUNCTION		10-6-06	L.P.D.
690	PACK		10-28-06	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 8-31-06
TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.61		2.65	
PULL #2	2.47	2.58		2.64	
PULL #3	2.44	2.59		2.56	
PULL #4	2.46	2.55		2.54	
PULL #5	2.44	2.58		2.57	
TOTAL	12.29	12.91		12.96	
AVERAGE	2.45	2.58		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.07		
PULL #2	3.07	3.10		
PULL #3	3.06	3.07		
PULL #4	3.04	3.10		
PULL #5	3.06	3.09		
TOTAL	15.36	15.43		
AVERAGE	3.07	3.08		

	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	4.03	4.19		4.09
PULL #2	4.09	4.12		4.08
PULL #3	4.06	4.16		4.04
PULL #4	4.01	4.15		4.04
PULL #5	4.06	4.11		4.10
TOTAL	20.25	20.73		20.35
AVERAGE	4.05	4.14		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577289.___0
FILE DATE AND TIME: 09/16/2006 01:47

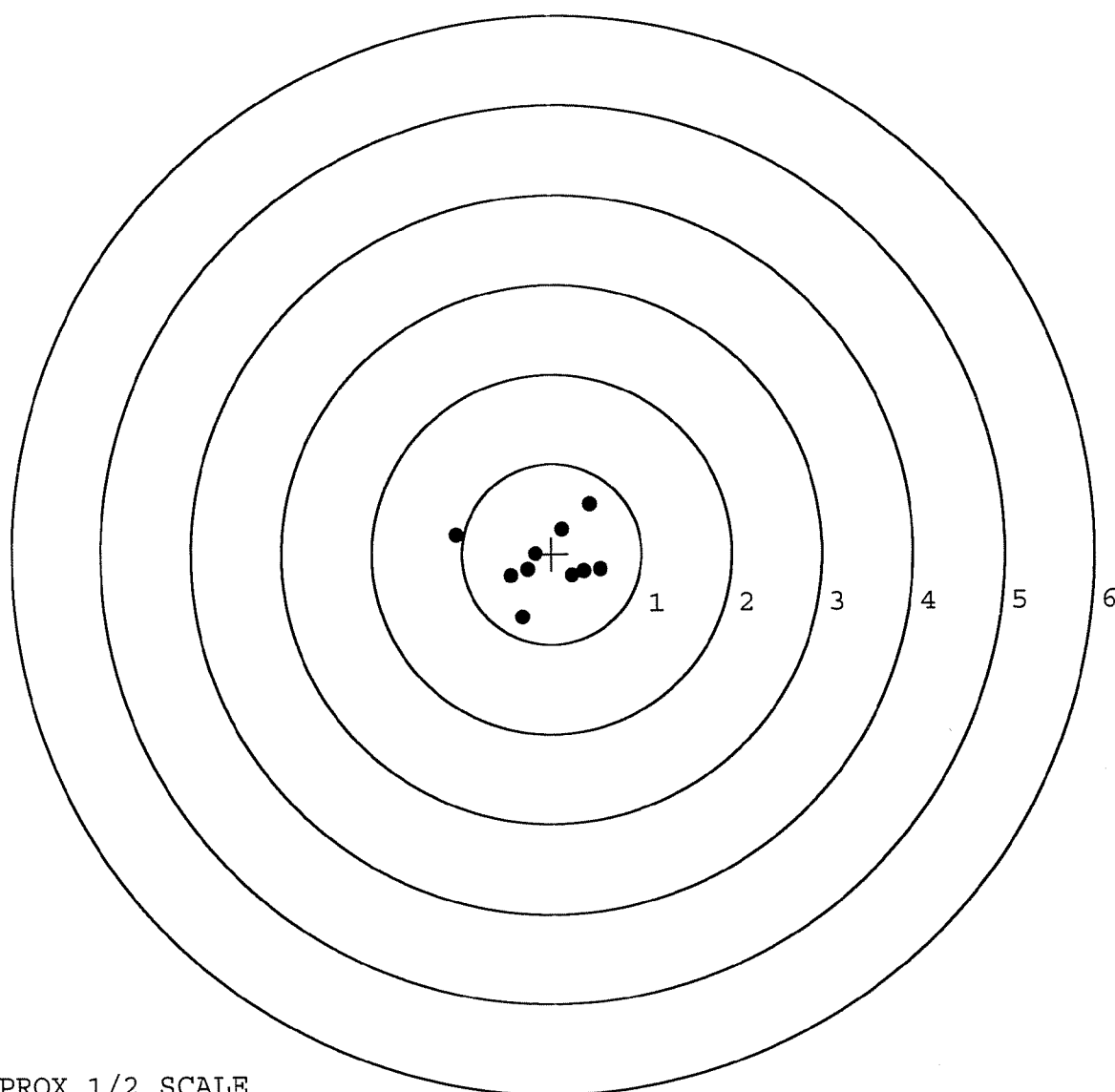
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.126
The Average Y Centroid of the Five Target Set:	0.046
The Average Point of Impact of the Five Target Set:	0.134
The Average Mean Radius of the Five Target Set:	0.739
The Distance from POA to Centroid Target #1:	0.094
The Distance from Centroid Target #2 to Centroid Target #1:	0.339
The Distance from Centroid Target #3 to Centroid Target #1:	0.291
The Distance from Centroid Target #4 to Centroid Target #1:	0.159
The Distance from Centroid Target #5 to Centroid Target #1:	0.078

SERIAL NUMBER: G6577289. __0
TARGET NUMBER: 1
FILE DATE: 09/16/2006
FILE TIME: 01:47

X CENTROID: -0.061
Y CENTROID: -0.071
POA TO CENTROID: 0.094
HORZ SPREAD: 1.605
VERT SPREAD: 1.259
GROUP SPREAD: 1.652
MIN RADIUS: 0.144
MAX RADIUS: 1.039
MEAN RADIUS: 0.512
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.061	0.214
2:	-0.329	-0.706
3:	-0.458	-0.242
4:	-0.185	0.003
5:	0.233	-0.244
6:	0.544	-0.178
7:	0.116	0.269
8:	0.433	0.553
9:	0.362	-0.195
10:	-0.270	-0.179

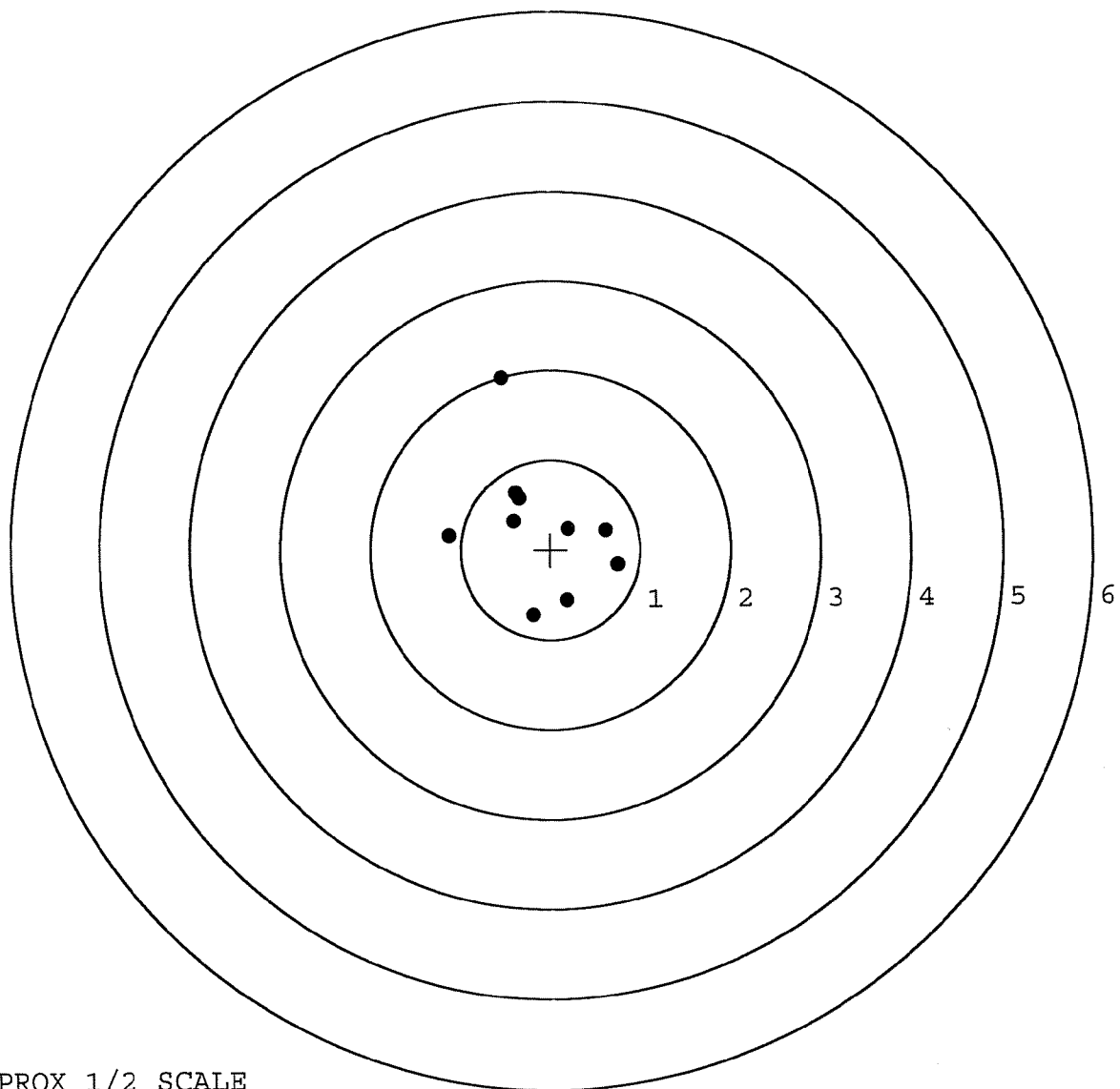


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577289. __0
TARGET NUMBER: 2
FILE DATE: 09/16/2006
FILE TIME: 01:47

X CENTROID: -0.128
Y CENTROID: 0.262
POA TO CENTROID: 0.291
HORZ SPREAD: 1.878
VERT SPREAD: 2.646
GROUP SPREAD: 2.669
MIN RADIUS: 0.286
MAX RADIUS: 1.708
MEAN RADIUS: 0.777
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.407	0.323
2:	-0.353	0.575
3:	-1.127	0.172
4:	-0.546	1.918
5:	0.196	0.234
6:	0.616	0.218
7:	0.751	-0.168
8:	0.181	-0.566
9:	-0.197	-0.728
10:	-0.392	0.639

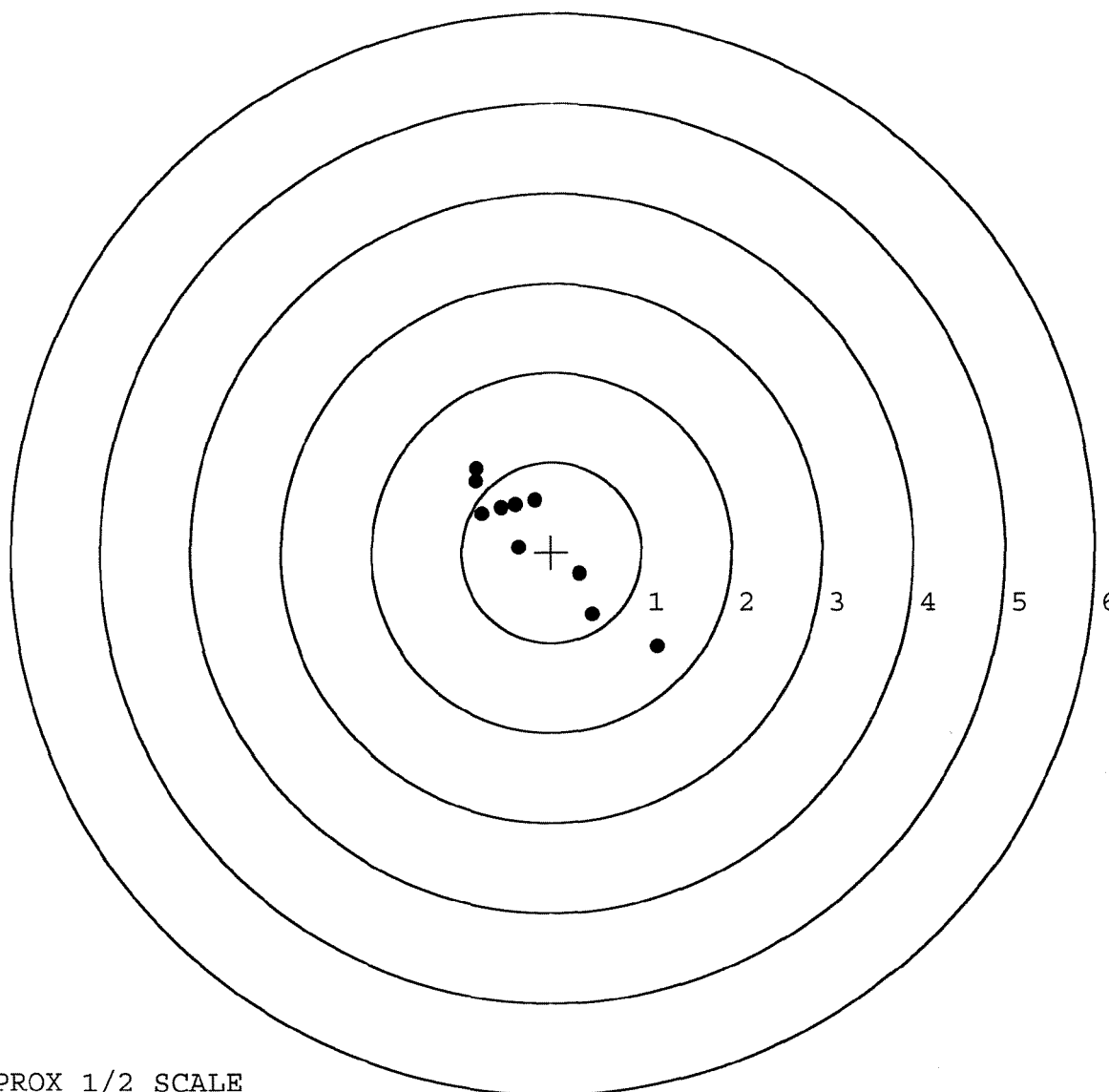


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577289. 0
TARGET NUMBER: 3
FILE DATE: 09/16/2006
FILE TIME: 01:47

POINT#	X	Y
1:	1.174	-1.051
2:	0.458	-0.688
3:	0.315	-0.235
4:	-0.369	0.059
5:	-0.843	0.787
6:	-0.839	0.933
7:	-0.776	0.428
8:	-0.564	0.500
9:	-0.404	0.532
10:	-0.190	0.574

X CENTROID: -0.204
Y CENTROID: 0.184
POA TO CENTROID: 0.275
HORZ SPREAD: 2.017
VERT SPREAD: 1.984
GROUP SPREAD: 2.826
MIN RADIUS: 0.207
MAX RADIUS: 1.850
MEAN RADIUS: 0.757
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

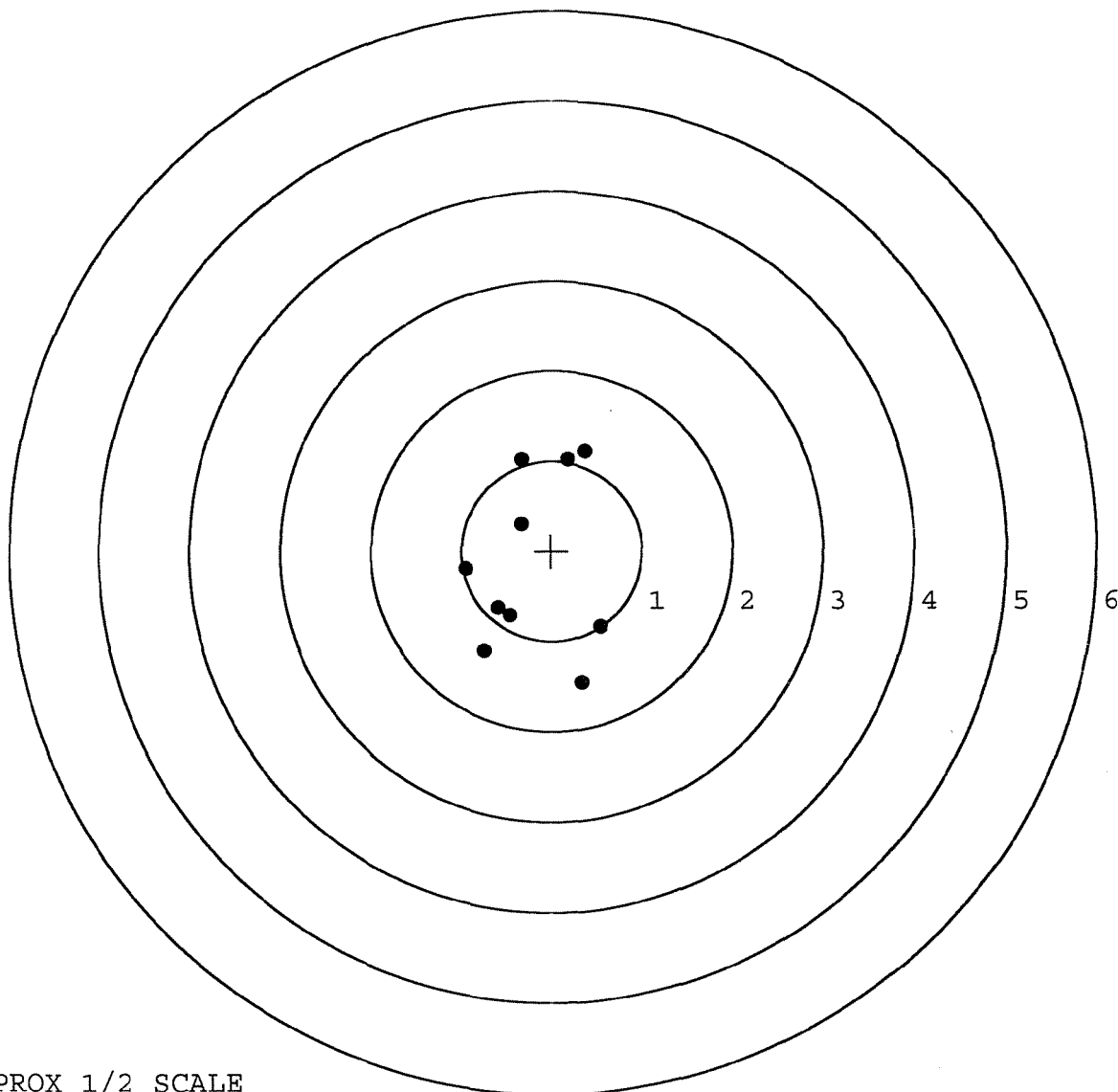


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577289. 0
TARGET NUMBER: 4
FILE DATE: 09/16/2006
FILE TIME: 01:47

POINT#	X	Y
1:	0.375	1.110
2:	0.182	1.019
3:	-0.330	1.014
4:	-0.335	0.302
5:	-0.951	-0.199
6:	-0.597	-0.633
7:	-0.464	-0.718
8:	-0.747	-1.112
9:	0.343	-1.463
10:	0.541	-0.843

X CENTROID: -0.198
Y CENTROID: -0.152
POA TO CENTROID: 0.250
HORZ SPREAD: 1.492
VERT SPREAD: 2.573
GROUP SPREAD: 2.573
MIN RADIUS: 0.474
MAX RADIUS: 1.418
MEAN RADIUS: 0.980
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 10

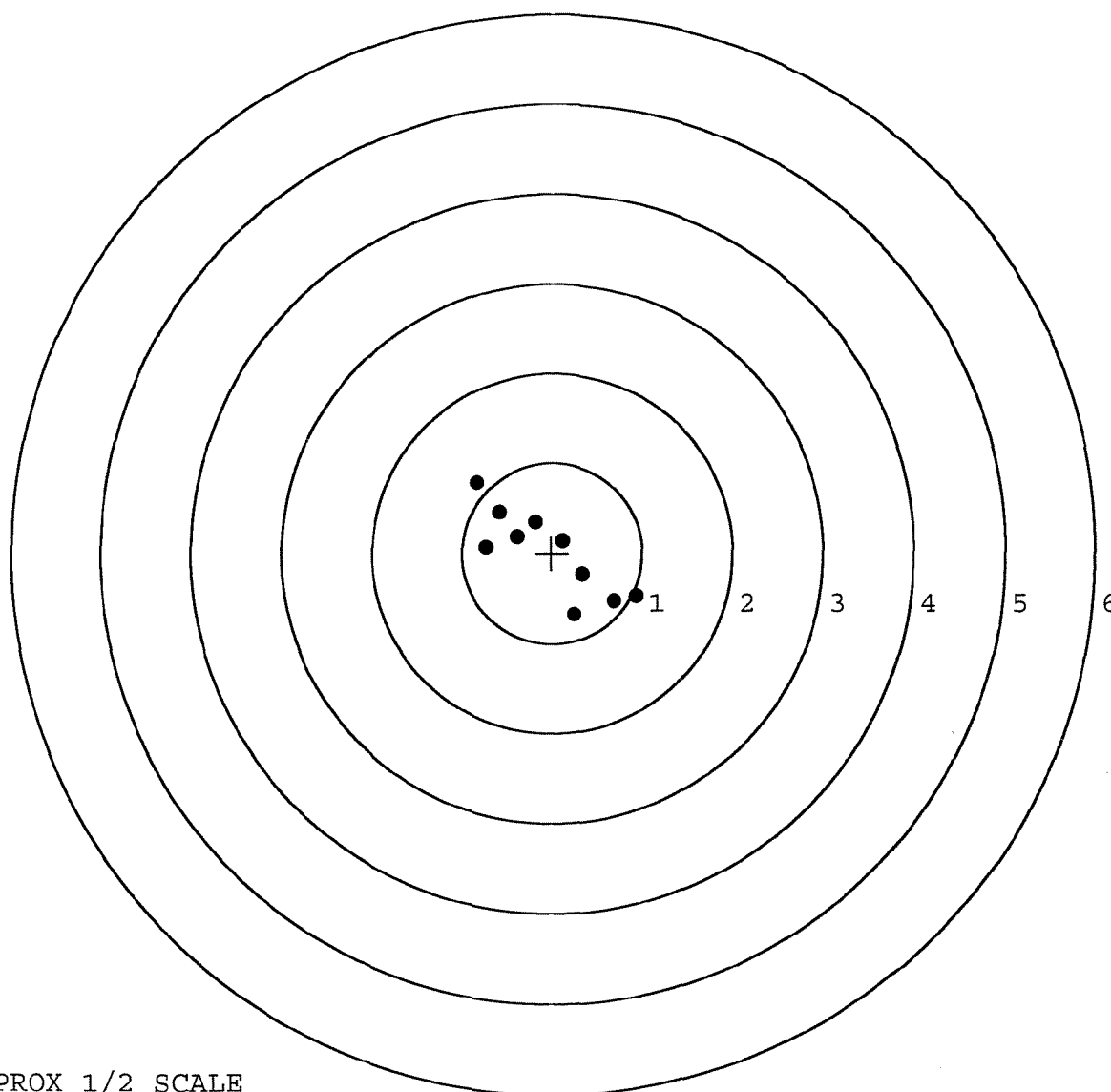


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577289. 0
TARGET NUMBER: 5
FILE DATE: 09/16/2006
FILE TIME: 01:47

POINT#	X	Y
1:	0.247	-0.680
2:	0.690	-0.532
3:	0.940	-0.479
4:	0.344	-0.229
5:	0.118	0.136
6:	-0.187	0.344
7:	-0.738	0.070
8:	-0.388	0.182
9:	-0.592	0.456
10:	-0.836	0.781

X CENTROID: -0.040
Y CENTROID: 0.005
POA TO CENTROID: 0.040
HORZ SPREAD: 1.776
VERT SPREAD: 1.461
GROUP SPREAD: 2.178
MIN RADIUS: 0.205
MAX RADIUS: 1.112
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE