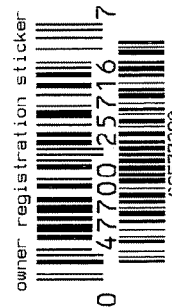


G-6577290

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

G6577290



1P FORM

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 # 06577290

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-12-06	RT
420	ASSEMBLE ACTION		10-12-06	RT
430	ASSEMBLE TO STOCK			
440	PROOF		10-13-06	TRW
460	CHECK HEADSPACE		10-13-06	TRW
470	DIS-ASSEMBLE ACTION		10-13-06	DL
480	MAGNAFLUX BBL ACTION		10-14-06	unus
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-13-06	AW
510	DRILL AND TAP SIGHT HOLES		10-13-06	TRW
520	GOFF BLAST BBL / REC		10-16-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/19/06	PS
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-8-06	BLG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-8-06	BLG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-8-06	BLG
	D) OIL FIRING PIN ASSEMBLY		11-8-06	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>2.0</u> <u>2.0</u> <u>2.0</u>	11-18-06	S.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	11-18-06	S.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0245</u> <u>.0245</u> <u>.0245</u>	11-18-06	S.P.D.
	J) ASSEMBLE STOCK		11-8-06	BLC
	K) ASSEMBLE SWIVEL STUDS		11-18-06	S.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-16-06	RTZ
	M) IRON SIGHT ALIGNMENT		11-16-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-16-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	11-8-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-8-06	S.P.D.
670	FINAL INSPECTION A) HEADSPACE		11-18-06	S.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.31</u> <u>2.45</u> <u>2.27</u> <u>2.59</u>	11/14/06	mon
	C) FUNCTION		11-18-06	S.P.D.
690	PACK		11-20-06	BLC

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

11-7-06

TESTER

SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.55	2.29		2.24	
PULL #2	2.57	2.23		2.24	
PULL #3	2.53	2.11		2.24	
PULL #4	2.40	2.11		2.27	
PULL #5	2.40	2.12		2.26	
TOTAL	1245	1086		1125	
AVERAGE	249	217		225	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.32		
PULL #2	3.20	3.12		
PULL #3	3.18	3.20		
PULL #4	3.19	3.24		
PULL #5	3.16	3.20		
TOTAL	1597	1608		
AVERAGE	319	321		

	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	4.11	4.13		4.01
PULL #2	4.06	4.09		4.13
PULL #3	4.15	4.07		4.00
PULL #4	4.17	4.13		4.01
PULL #5	4.12	4.11		4.01
TOTAL	2061	2053		2016
AVERAGE	412	410		403

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577290.___0

FILE DATE AND TIME: 11/08/2006 14:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.022
The Average Y Centroid of the Five Target Set:	-0.048
The Average Point of Impact of the Five Target Set:	0.052
The Average Mean Radius of the Five Target Set:	0.719
The Distance from POA to Centroid Target #1:	0.236
The Distance from Centroid Target #2 to Centroid Target #1:	0.174
The Distance from Centroid Target #3 to Centroid Target #1:	0.330
The Distance from Centroid Target #4 to Centroid Target #1:	0.237
The Distance from Centroid Target #5 to Centroid Target #1:	0.192

SERIAL NUMBER: G6577290. __ 0

TARGET NUMBER: 1

FILE DATE: 11/08/2006

FILE TIME: 14:50

POINT#	X	Y
1:	0.854	1.348
2:	0.147	0.857
3:	-0.133	0.223
4:	0.384	-0.018
5:	0.842	-0.484
6:	0.484	-0.651
7:	-1.572	-1.533
8:	-1.343	-0.289
9:	-0.332	-0.919
10:	-0.051	-0.783

X CENTROID: -0.072

Y CENTROID: -0.225

POA TO CENTROID: 0.236

HORZ SPREAD: 2.426

VERT SPREAD: 2.881

GROUP SPREAD: 3.766

MIN RADIUS: 0.452

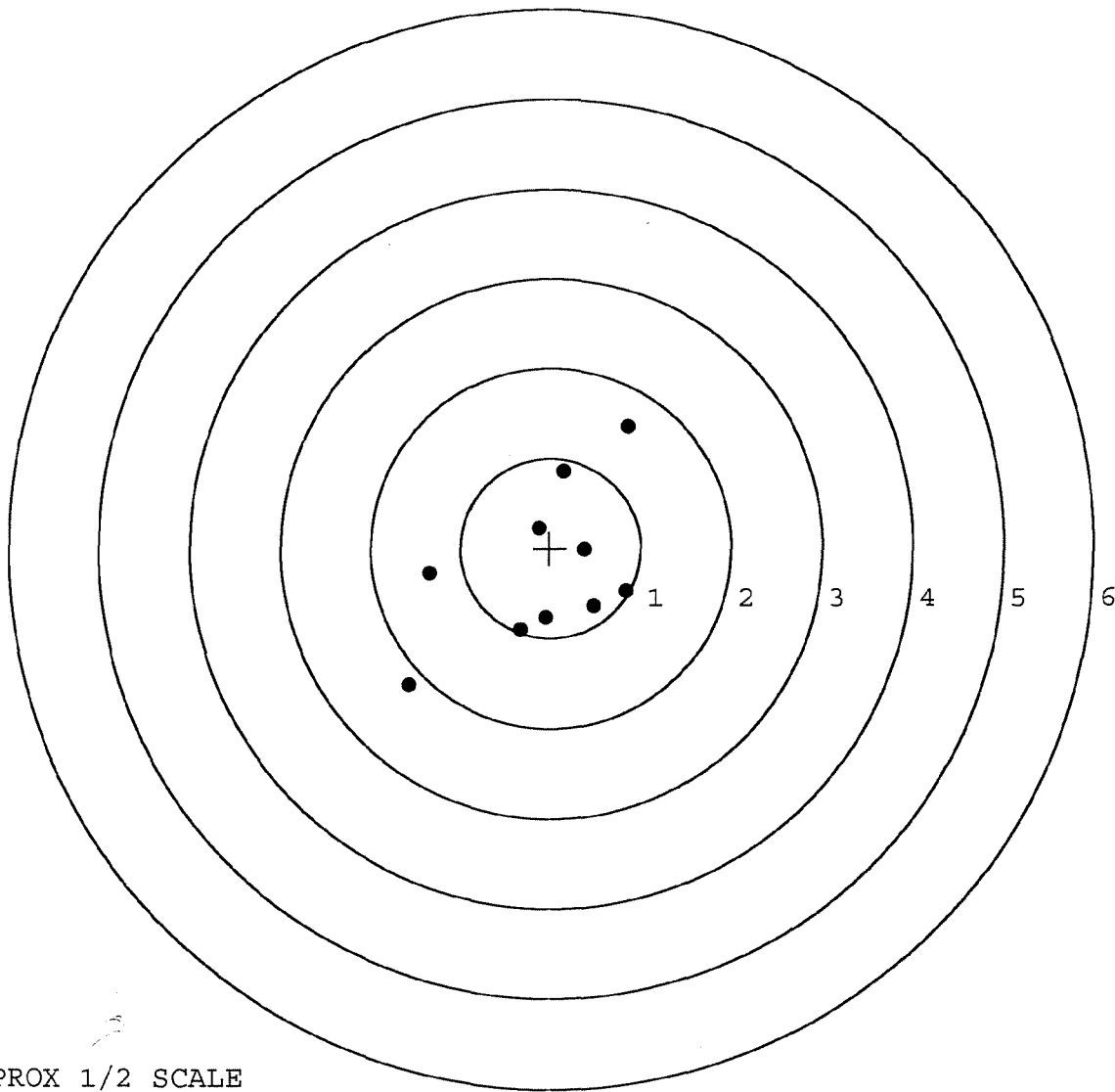
MAX RADIUS: 1.990

MEAN RADIUS: 1.009

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577290. __0

TARGET NUMBER: 2

FILE DATE: 11/08/2006

FILE TIME: 14:50

POINT#	X	Y
--------	---	---

1:	-0.565	-1.261
----	--------	--------

2:	0.097	-0.412
----	-------	--------

3:	0.608	0.284
----	-------	-------

4:	0.478	0.375
----	-------	-------

5:	0.296	0.459
----	-------	-------

6:	0.087	-0.045
----	-------	--------

7:	-0.154	0.039
----	--------	-------

8:	-0.071	0.210
----	--------	-------

9:	-0.325	-0.320
----	--------	--------

10:	-0.966	0.152
-----	--------	-------

X CENTROID: -0.051

Y CENTROID: -0.052

POA TO CENTROID: 0.073

HORZ SPREAD: 1.574

VERT SPREAD: 1.720

GROUP SPREAD: 1.940

MIN RADIUS: 0.137

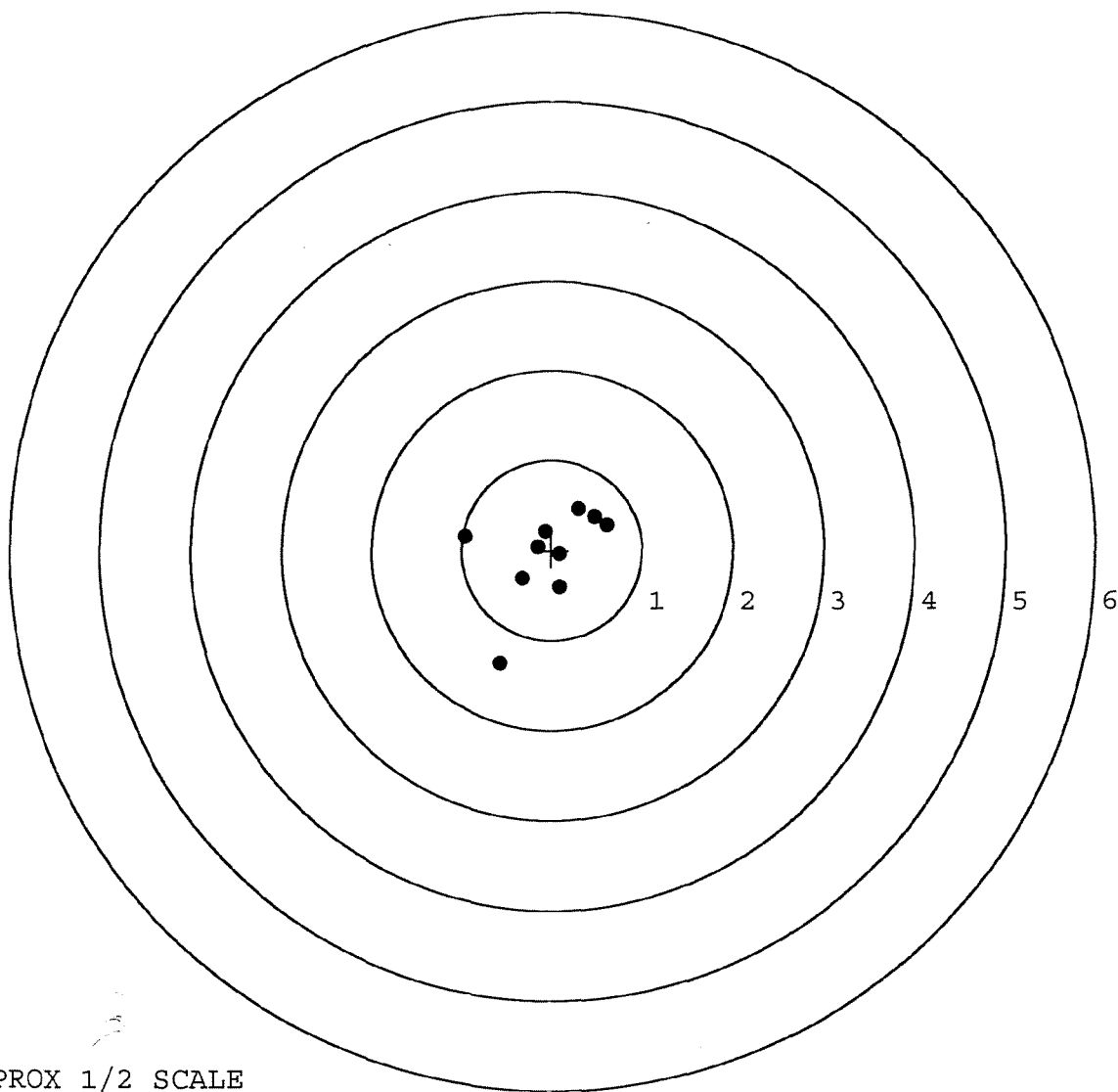
MAX RADIUS: 1.314

MEAN RADIUS: 0.560

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577290. __0

TARGET NUMBER: 3

FILE DATE: 11/08/2006

FILE TIME: 14:50

POINT#	X	Y
--------	---	---

1:	1.248	0.268
----	-------	-------

2:	0.538	-0.214
----	-------	--------

3:	-0.073	-0.783
----	--------	--------

4:	-0.416	-0.200
----	--------	--------

5:	0.095	0.024
----	-------	-------

6:	-0.796	0.569
----	--------	-------

7:	-0.231	0.534
----	--------	-------

8:	-0.127	0.346
----	--------	-------

9:	-0.364	0.289
----	--------	-------

10:	-0.149	0.189
-----	--------	-------

X CENTROID: -0.027

Y CENTROID: 0.102

POA TO CENTROID: 0.106

HORZ SPREAD: 2.044

VERT SPREAD: 1.352

GROUP SPREAD: 2.066

MIN RADIUS: 0.145

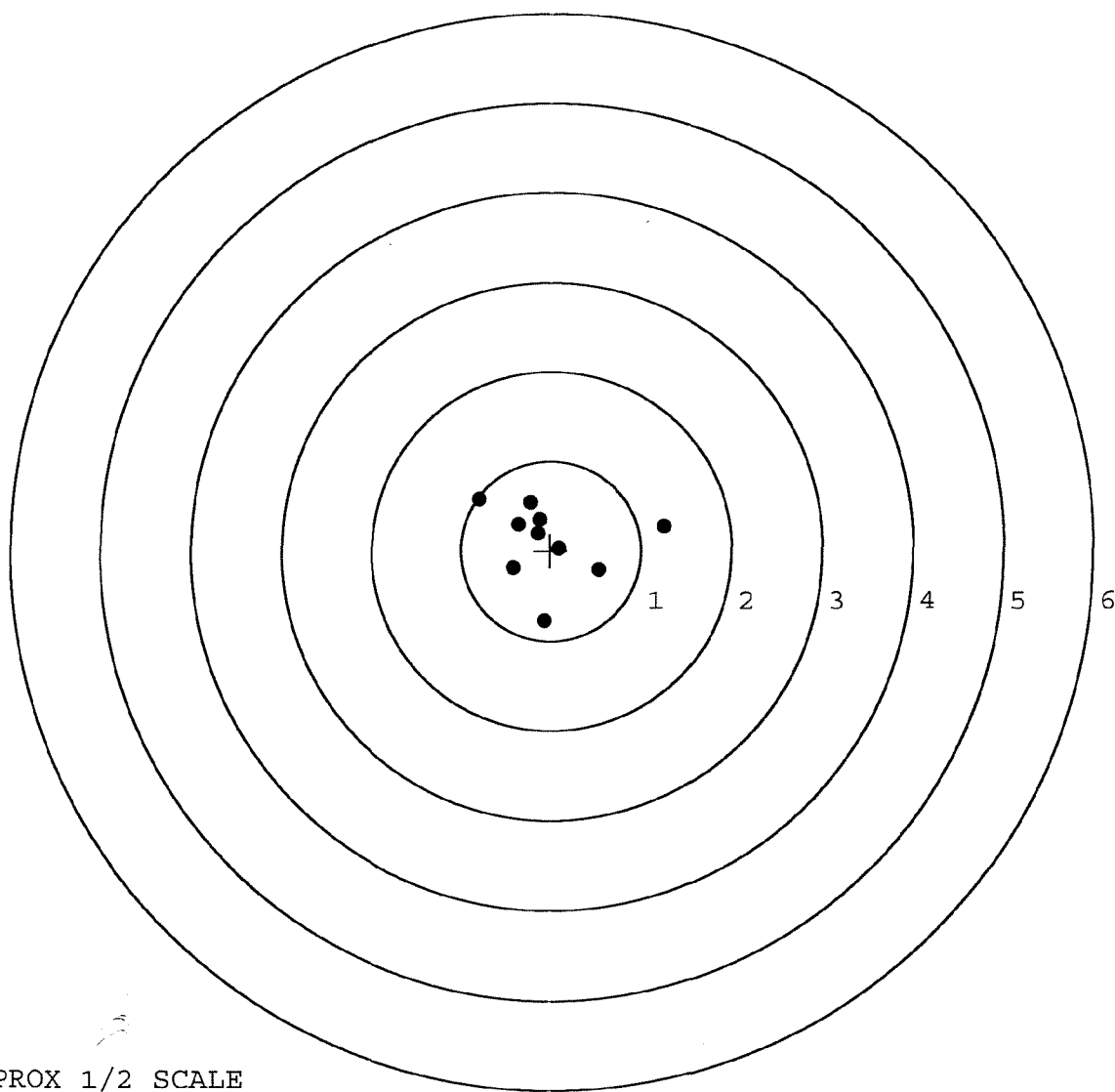
MAX RADIUS: 1.286

MEAN RADIUS: 0.563

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577290. __0

TARGET NUMBER: 4

FILE DATE: 11/08/2006

FILE TIME: 14:50

POINT#	X	Y
1:	0.889	-0.837
2:	0.355	-1.081
3:	0.328	-0.460
4:	0.255	-0.272
5:	0.944	0.856
6:	-0.859	0.597
7:	-0.262	0.552
8:	-0.429	0.419
9:	-0.378	0.114
10:	-0.480	-0.034

X CENTROID: 0.036

Y CENTROID: -0.015

POA TO CENTROID: 0.039

HORZ SPREAD: 1.803

VERT SPREAD: 1.937

GROUP SPREAD: 2.025

MIN RADIUS: 0.338

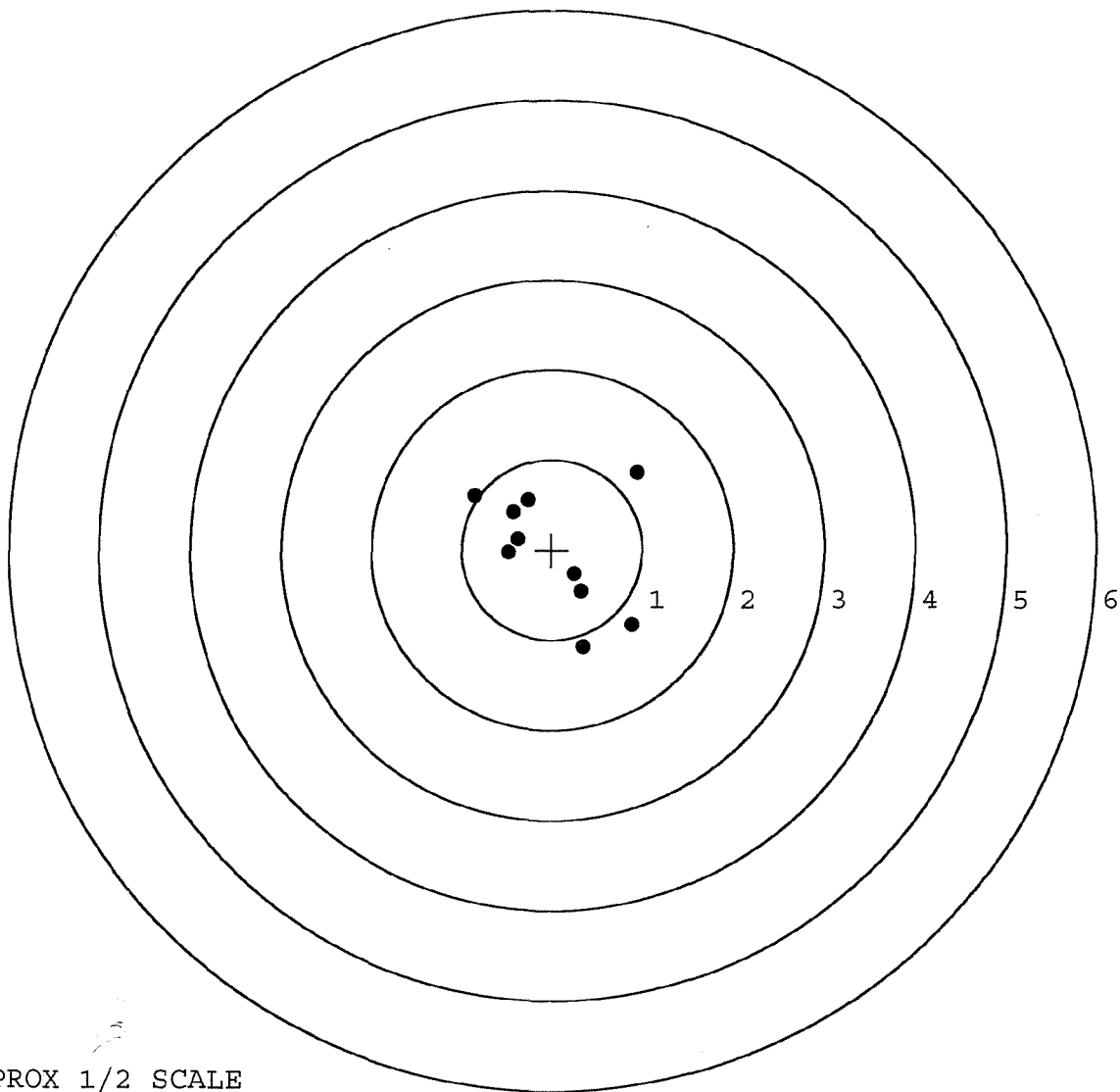
MAX RADIUS: 1.258

MEAN RADIUS: 0.774

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577290. __0

TARGET NUMBER: 5

FILE DATE: 11/08/2006

FILE TIME: 14:50

POINT#	X	Y
--------	---	---

1:	0.380	0.664
----	-------	-------

2:	0.027	-0.286
----	-------	--------

3:	-0.438	-0.116
----	--------	--------

4:	-0.918	-0.596
----	--------	--------

5:	-1.552	0.231
----	--------	-------

6:	0.226	0.227
----	-------	-------

7:	0.461	-0.007
----	-------	--------

8:	0.815	-0.146
----	-------	--------

9:	0.654	-0.204
----	-------	--------

10:	0.393	-0.258
-----	-------	--------

X CENTROID: 0.005

Y CENTROID: -0.049

POA TO CENTROID: 0.049

HORZ SPREAD: 2.367

VERT SPREAD: 1.260

GROUP SPREAD: 2.397

MIN RADIUS: 0.238

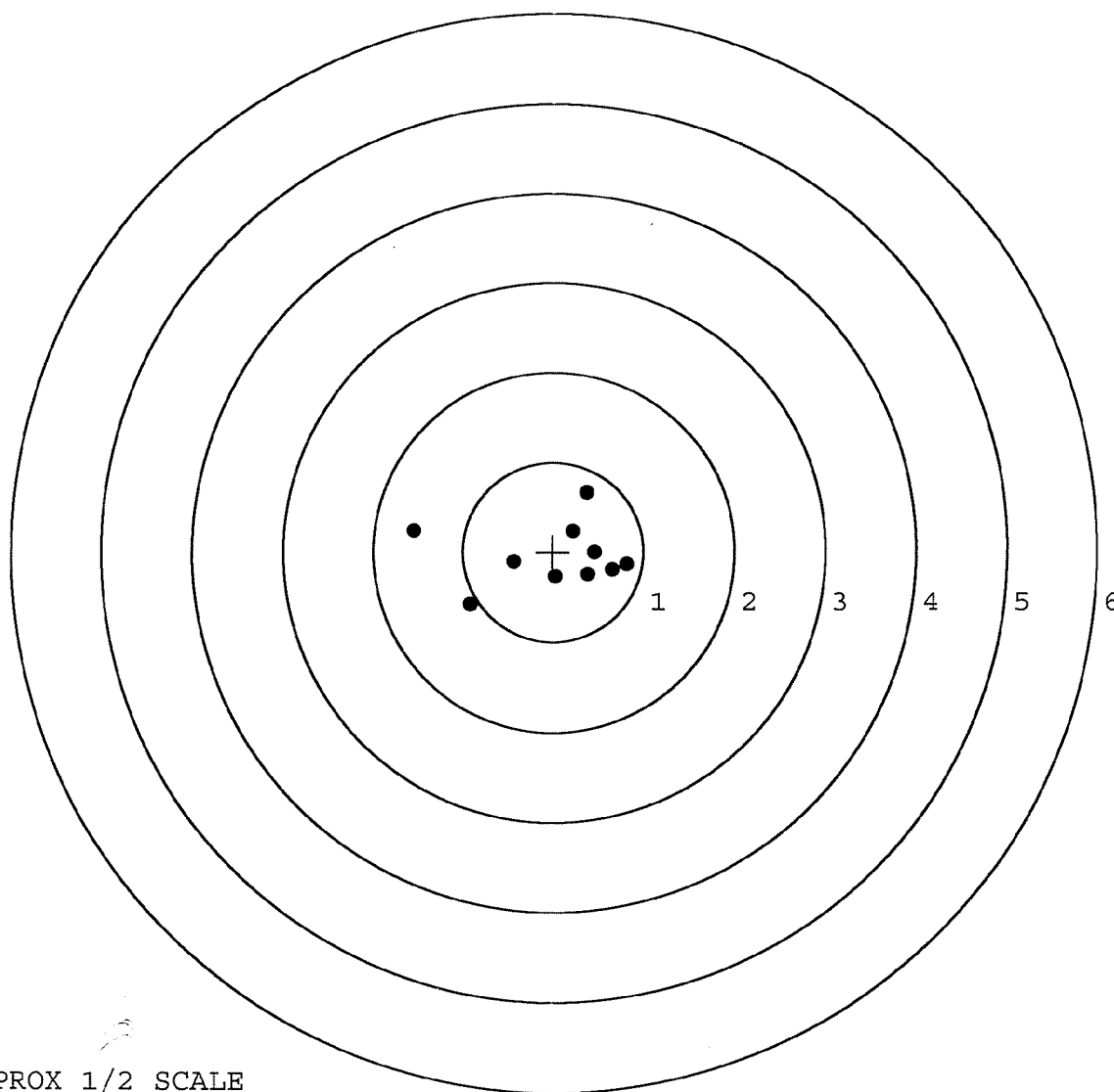
MAX RADIUS: 1.582

MEAN RADIUS: 0.688

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE