

G653 4980

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



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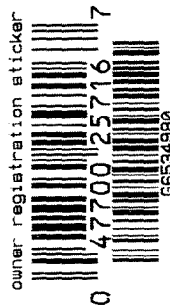
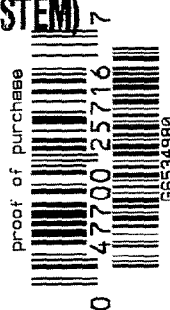
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

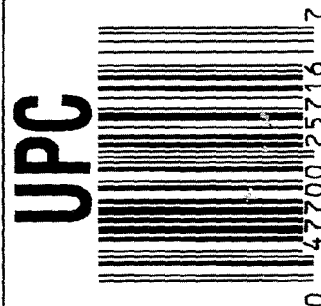


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6534980



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66534980

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/3/05	CD
440	PROOF		11/3/05	CD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED JAN 02 2006	11/3/05	CD
470	DIS-ASSEMBLE ACTION		11/3/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>CPD</u>	1/9/06	CPD
500	ROLLMARK CALIBER		1/9/06	CW
510	DRILL AND TAP SIGHT HOLES		1-6-06	TRW
520	GOFF BLAST BBL / REC		1-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1/11	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		1-18-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-18-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-18-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-18-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	3/6/06	MPJ
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.5</u> <u>5.5</u>	2-1-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	2-1-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/6/06	MJD
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3/6/06	MJD
	J) ASSEMBLE STOCK		1-18-06	RTL
	K) ASSEMBLE SWIVEL STUDS		3/6/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-6-06	A
	M) IRON SIGHT ALIGNMENT		3-6-06	A
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-6-06	A
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-23-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-23-06	KH
670	FINAL INSPECTION A) HEADSPACE		3/6/06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.58</u> <u>2.61</u> <u>2.63</u> <u>2.75</u>	2-1-06	RA
	C) FUNCTION		3/6/06	MJD
690	PACK		3-28-06	RA

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 1-18-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.39		2.49	
PULL #2	2.49	2.48		2.49	
PULL #3	2.60	2.45		2.47	
PULL #4	2.55	2.45		2.45	
PULL #5	2.61	2.44		2.45	
TOTAL	12.76	12.21		12.35	
AVERAGE	2.55	2.44		2.47	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.06		
PULL #2	3.08	3.11		
PULL #3	3.12	3.09		
PULL #4	3.06	3.09		
PULL #5	3.06	3.10		
TOTAL	15.40	15.45		
AVERAGE	3.08	3.09		

	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	4.20	4.01		4.16
PULL #2	4.09	3.97		4.11
PULL #3	4.11	4.01		4.18
PULL #4	4.09	3.91		4.17
PULL #5	4.17	4.04		4.13
TOTAL	20.66	19.94		20.75
AVERAGE	4.13	3.98		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6534980.__0
FILE DATE AND TIME: 01/23/2006 14:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.001
The Average Y Centroid of the Five Target Set:	-0.064
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.661
The Distance from POA to Centroid Target #1:	0.170
The Distance from Centroid Target #2 to Centroid Target #1:	0.302
The Distance from Centroid Target #3 to Centroid Target #1:	0.236
The Distance from Centroid Target #4 to Centroid Target #1:	0.262
The Distance from Centroid Target #5 to Centroid Target #1:	0.374

SERIAL NUMBER: G6534980. __0

TARGET NUMBER: 1

FILE DATE: 01/23/2006

FILE TIME: 14:31

X CENTROID: 0.042

Y CENTROID: 0.165

POA TO CENTROID: 0.170

HORZ SPREAD: 1.607

VERT SPREAD: 2.345

GROUP SPREAD: 2.419

MIN RADIUS: 0.172

MAX RADIUS: 1.251

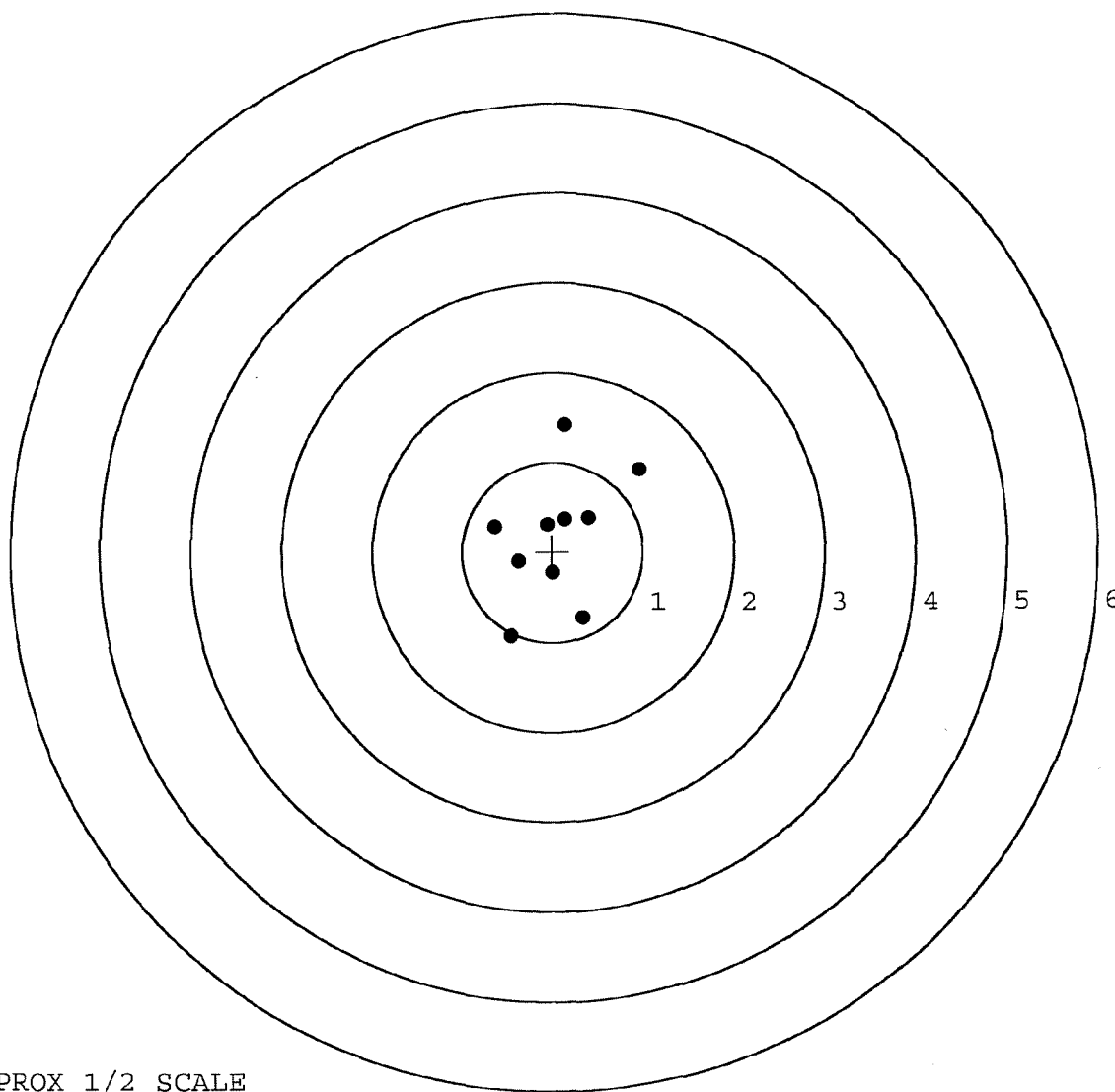
MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.336	-0.727
2:	-0.461	-0.933
3:	-0.644	0.280
4:	0.397	0.381
5:	0.134	0.366
6:	0.963	0.915
7:	0.134	1.412
8:	-0.060	0.303
9:	0.001	-0.238
10:	-0.377	-0.113

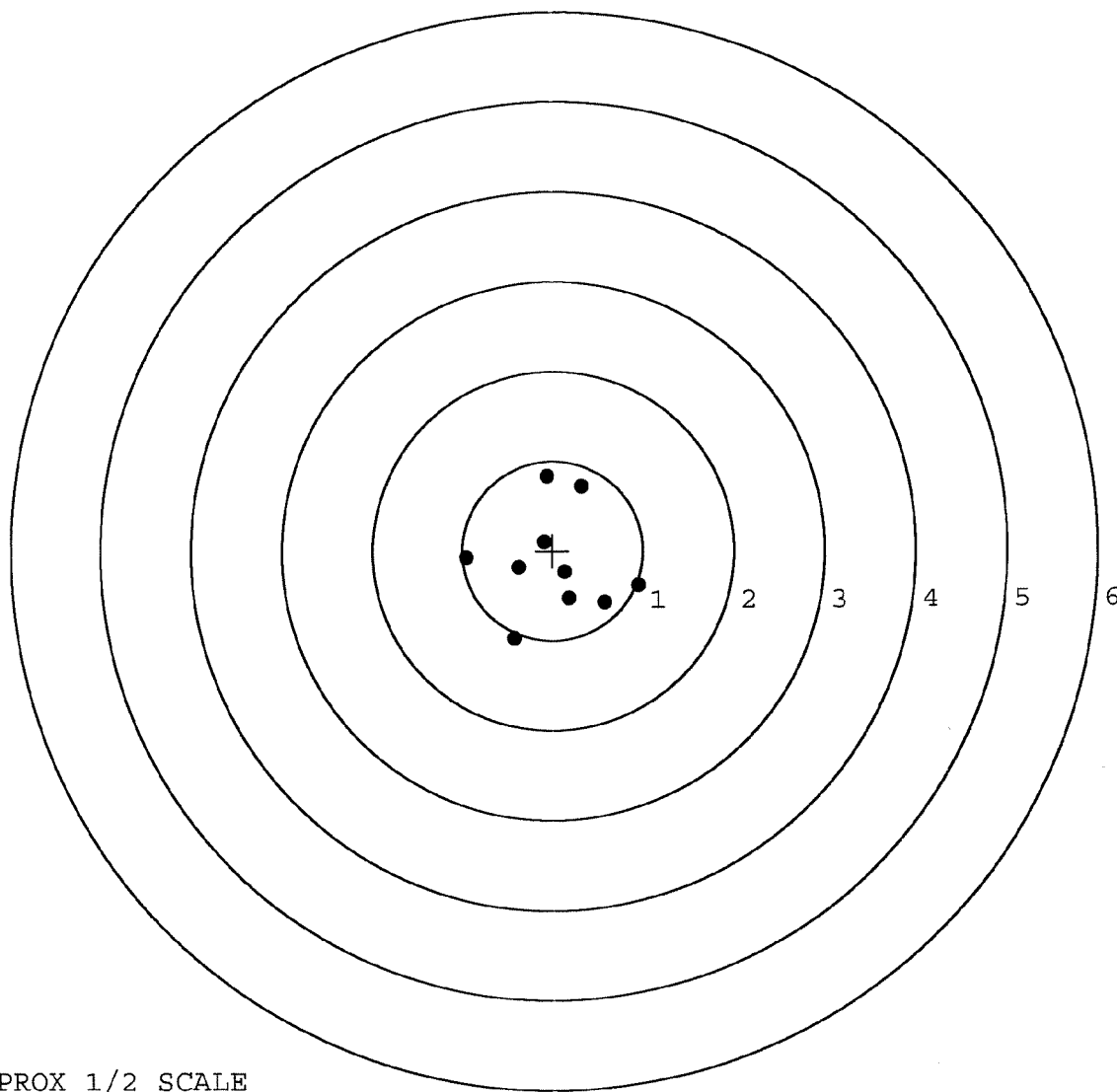


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534980. __0
TARGET NUMBER: 2
FILE DATE: 01/23/2006
FILE TIME: 14:31

X CENTROID: 0.025
Y CENTROID: -0.136
POA TO CENTROID: 0.139
HORZ SPREAD: 1.905
VERT SPREAD: 1.814
GROUP SPREAD: 1.932
MIN RADIUS: 0.155
MAX RADIUS: 0.985
MEAN RADIUS: 0.674
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.947	-0.397
2:	0.576	-0.581
3:	0.185	-0.534
4:	0.135	-0.246
5:	-0.422	-0.984
6:	-0.379	-0.191
7:	-0.096	0.099
8:	-0.958	-0.074
9:	0.324	0.714
10:	-0.064	0.830

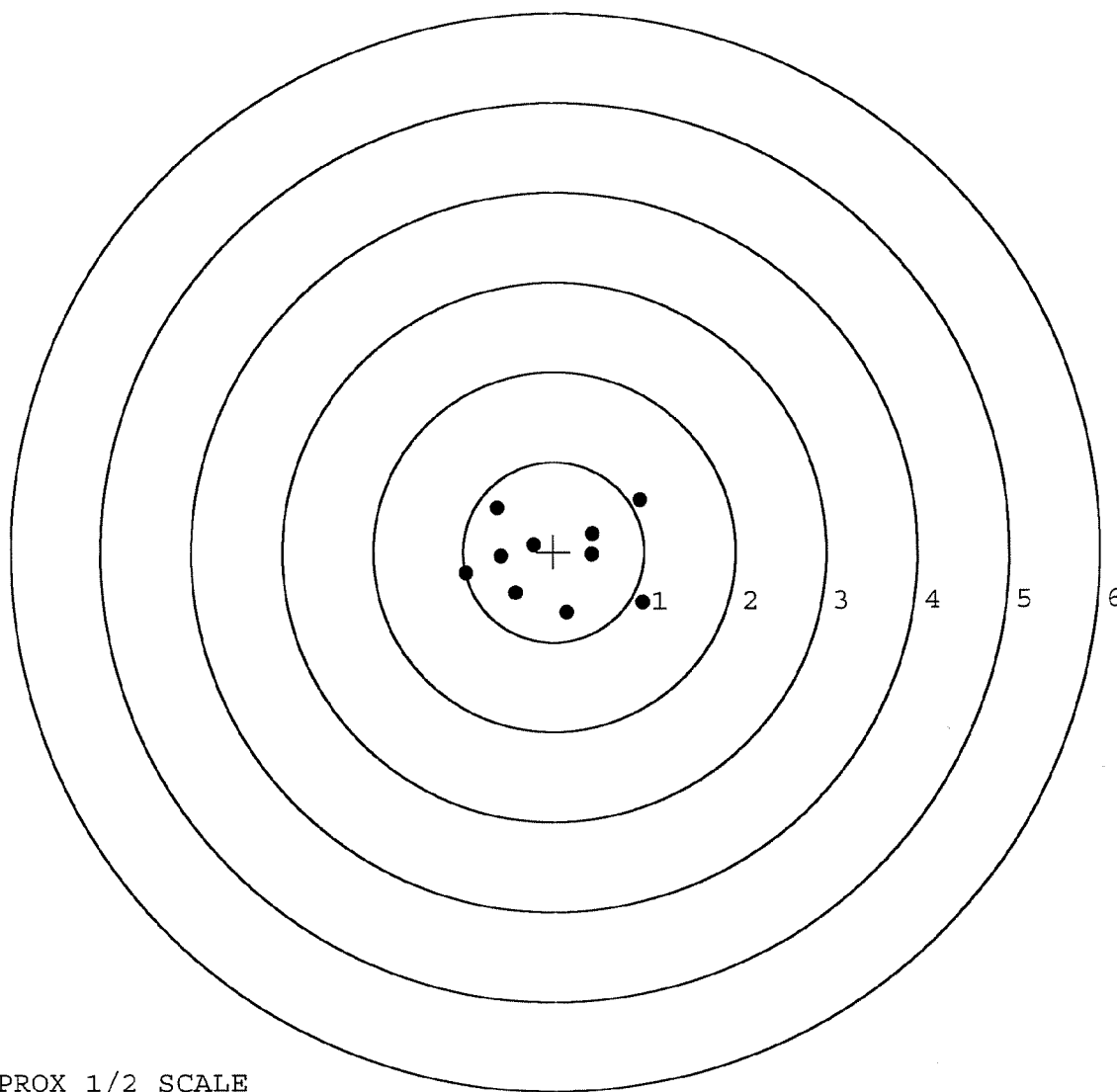


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534980. __0
TARGET NUMBER: 3
FILE DATE: 01/23/2006
FILE TIME: 14:31

X CENTROID: 0.011
Y CENTROID: -0.069
POA TO CENTROID: 0.070
HORZ SPREAD: 1.955
VERT SPREAD: 1.246
GROUP SPREAD: 2.092
MIN RADIUS: 0.280
MAX RADIUS: 1.142
MEAN RADIUS: 0.706
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.984	-0.569
2:	0.958	0.570
3:	0.423	-0.036
4:	0.428	0.199
5:	0.146	-0.676
6:	-0.423	-0.457
7:	-0.226	0.079
8:	-0.582	-0.051
9:	-0.971	-0.239
10:	-0.623	0.490



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534980. __0

TARGET NUMBER: 4

FILE DATE: 01/23/2006

FILE TIME: 14:31

POINT#	X	Y
1:	0.512	-0.677
2:	0.036	-0.871
3:	0.224	-0.371
4:	0.243	0.855
5:	0.300	0.521
6:	-0.886	-0.179
7:	-0.454	-0.079
8:	-0.100	0.286
9:	0.210	0.109
10:	-0.726	-0.346

X CENTROID: -0.064

Y CENTROID: -0.075

POA TO CENTROID: 0.099

HORZ SPREAD: 1.398

VERT SPREAD: 1.726

GROUP SPREAD: 1.738

MIN RADIUS: 0.330

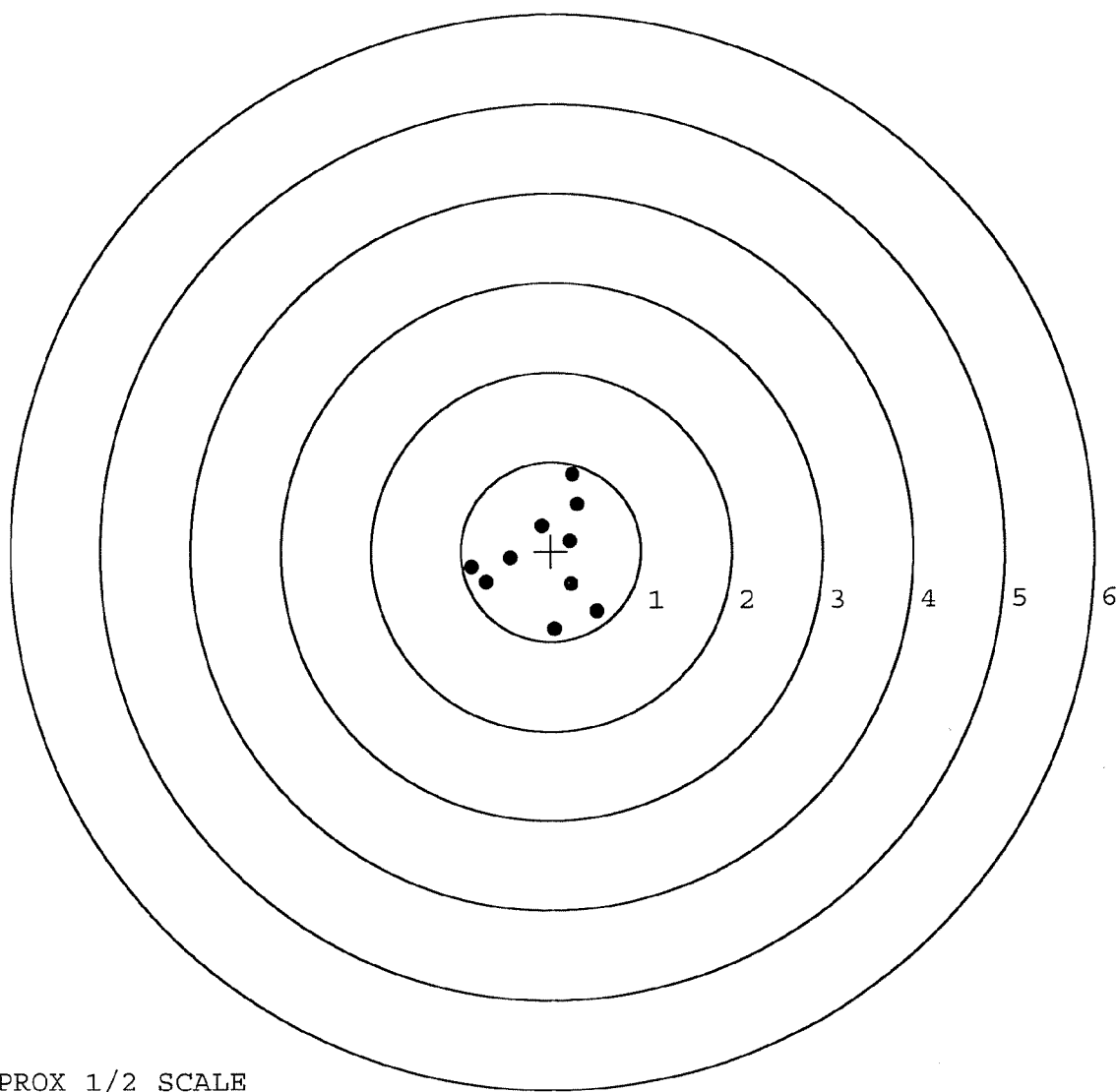
MAX RADIUS: 0.980

MEAN RADIUS: 0.635

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

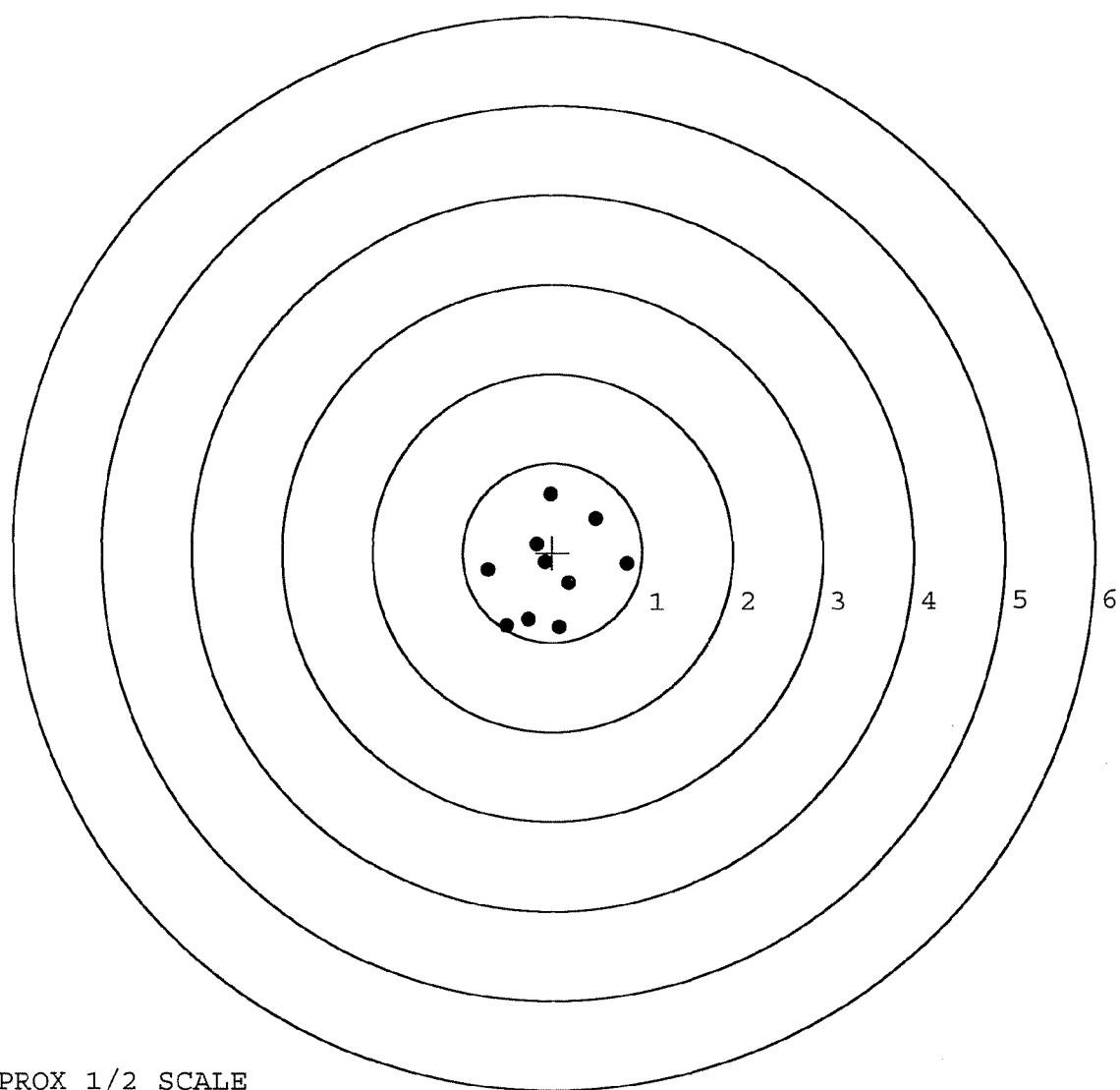


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534980.___0
TARGET NUMBER: 5
FILE DATE: 01/23/2006
FILE TIME: 14:31

POINT#	X	Y
1:	0.829	-0.128
2:	0.493	0.379
3:	-0.014	0.649
4:	0.074	-0.837
5:	-0.268	-0.747
6:	-0.507	-0.818
7:	-0.717	-0.191
8:	0.181	-0.345
9:	-0.080	-0.110
10:	-0.177	0.100

X CENTROID: -0.019
Y CENTROID: -0.205
POA TO CENTROID: 0.206
HORZ SPREAD: 1.546
VERT SPREAD: 1.486
GROUP SPREAD: 1.548
MIN RADIUS: 0.113
MAX RADIUS: 0.854
MEAN RADIUS: 0.590
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE