

G-653 5205

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

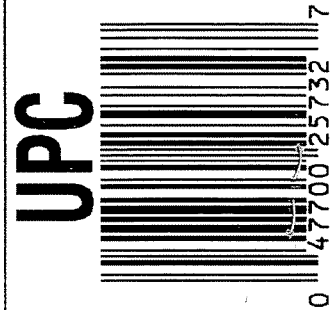
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

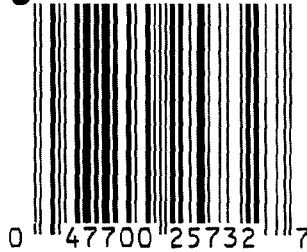
G6535205



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

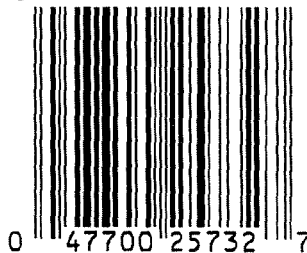


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ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



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SERIAL NO.



G6535205

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # ~~662~~ C6535205

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-31-06	RTZ
440	PROOF		1/31/06	MPD
460	CHECK HEADSPACE		1/31/06	MPD
470	DIS-ASSEMBLE ACTION		2-1-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	CP# 480 FEB 06 2006 CPD	2-6-06	APD
500	ROLLMARK CALIBER		2-6-06	CW
510	DRILL AND TAP SIGHT HOLES			
520	GOFF BLAST BBL / REC		2-6-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/9/06	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		2-23-06	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-23-06	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-23-06	MTM
	D) OIL FIRING PIN ASSEMBLY		3-13-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>65</u> <u>60</u> <u>60</u>	3-15-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>20</u> <u>20</u>	3-15-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1023</u> <u>1023</u>	3-15-06	RA
	J) ASSEMBLE STOCK		3-13-06	RTL
	K) ASSEMBLE SWIVEL STUDS			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-14-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-14-06	MTM
670	FINAL INSPECTION A) HEADSPACE		3-15-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u> <u>2.24</u> <u>2.50</u> <u>2.09</u> <u>2.19</u>	3-15-06	TRL
	C) FUNCTION		3-15-06	MTM
690	PACK		3-11-06	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 3-10-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.52	2.46		2.59	
PULL #2	2.48	2.43		2.58	
PULL #3	2.43	2.38		2.53	
PULL #4	2.54	2.56		2.57	
PULL #5	2.58	2.42		2.51	
TOTAL	12.55	12.25		12.78	
AVERAGE	2.51	2.45		2.55	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.08		
PULL #2	3.27	3.06		
PULL #3	3.29	3.05		
PULL #4	3.09	3.05		
PULL #5	3.02	3.02		
TOTAL	15.84	15.26		
AVERAGE	3.16	3.05		

	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	4.24	4.13		4.15
PULL #2	4.15	4.18		4.05
PULL #3	4.02	4.19		4.02
PULL #4	3.96	4.13		4.11
PULL #5	4.03	4.08		4.11
TOTAL	20.40	20.71		20.44
AVERAGE	4.08	4.14		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535205.__0

FILE DATE AND TIME: 03/14/2006 16:18

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.023
The Average Y Centroid of the Five Target Set:	0.053
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.678
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.167
The Distance from Centroid Target #3 to Centroid Target #1:	0.495
The Distance from Centroid Target #4 to Centroid Target #1:	0.285
The Distance from Centroid Target #5 to Centroid Target #1:	0.506

SERIAL NUMBER: G6535205. 0

TARGET NUMBER: 1

FILE DATE: 03/14/2006

FILE TIME: 16:18

POINT#	X	Y
1:	-0.747	0.986
2:	-0.515	0.716
3:	-0.297	0.743
4:	-0.376	0.295
5:	-1.381	0.189
6:	0.474	0.777
7:	0.108	-0.219
8:	0.577	-0.657
9:	0.150	-0.794
10:	-0.570	-1.454

X CENTROID: -0.258

Y CENTROID: 0.058

POA TO CENTROID: 0.264

HORZ SPREAD: 1.958

VERT SPREAD: 2.440

GROUP SPREAD: 2.463

MIN RADIUS: 0.265

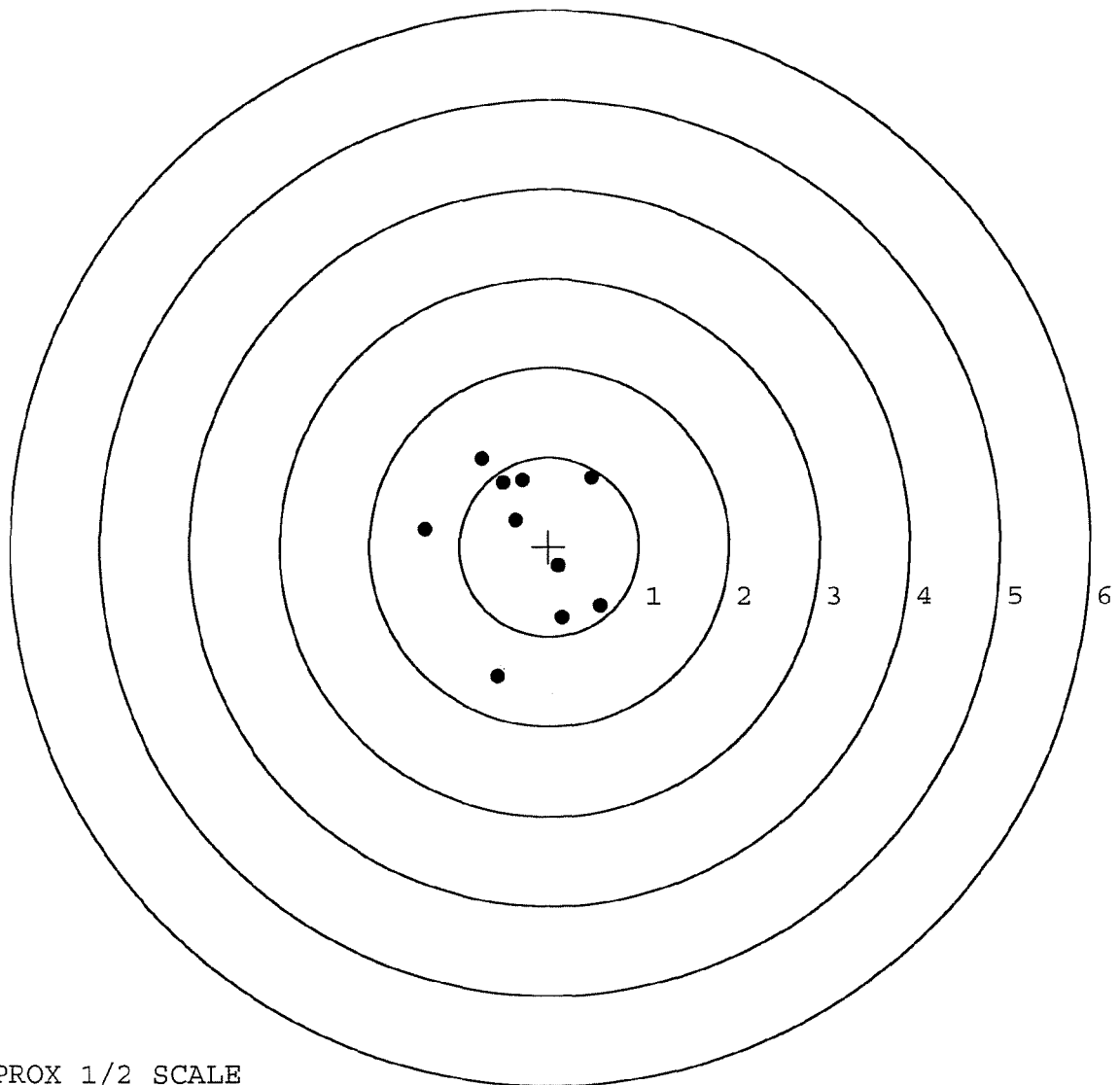
MAX RADIUS: 1.544

MEAN RADIUS: 0.891

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

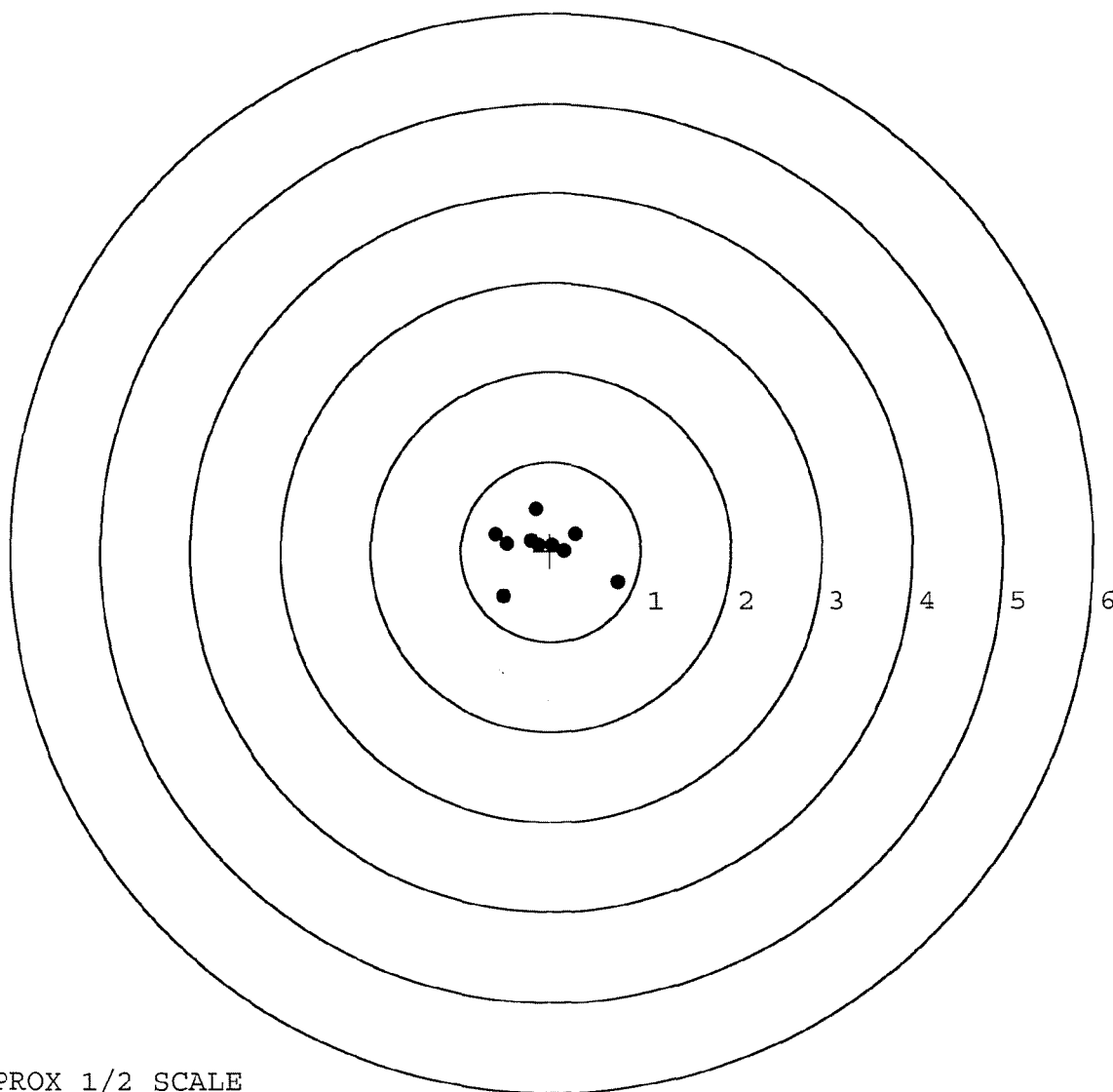


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535205. 0
TARGET NUMBER: 2
FILE DATE: 03/14/2006
FILE TIME: 16:18

X CENTROID: -0.092
Y CENTROID: 0.034
POA TO CENTROID: 0.098
HORZ SPREAD: 1.365
VERT SPREAD: 0.975
GROUP SPREAD: 1.465
MIN RADIUS: 0.050
MAX RADIUS: 0.920
MEAN RADIUS: 0.397
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.161	0.471
2:	0.160	-0.001
3:	-0.133	0.062
4:	-0.491	0.083
5:	-0.617	0.189
6:	0.279	0.198
7:	0.748	-0.342
8:	-0.520	-0.504
9:	-0.210	0.117
10:	0.023	0.065

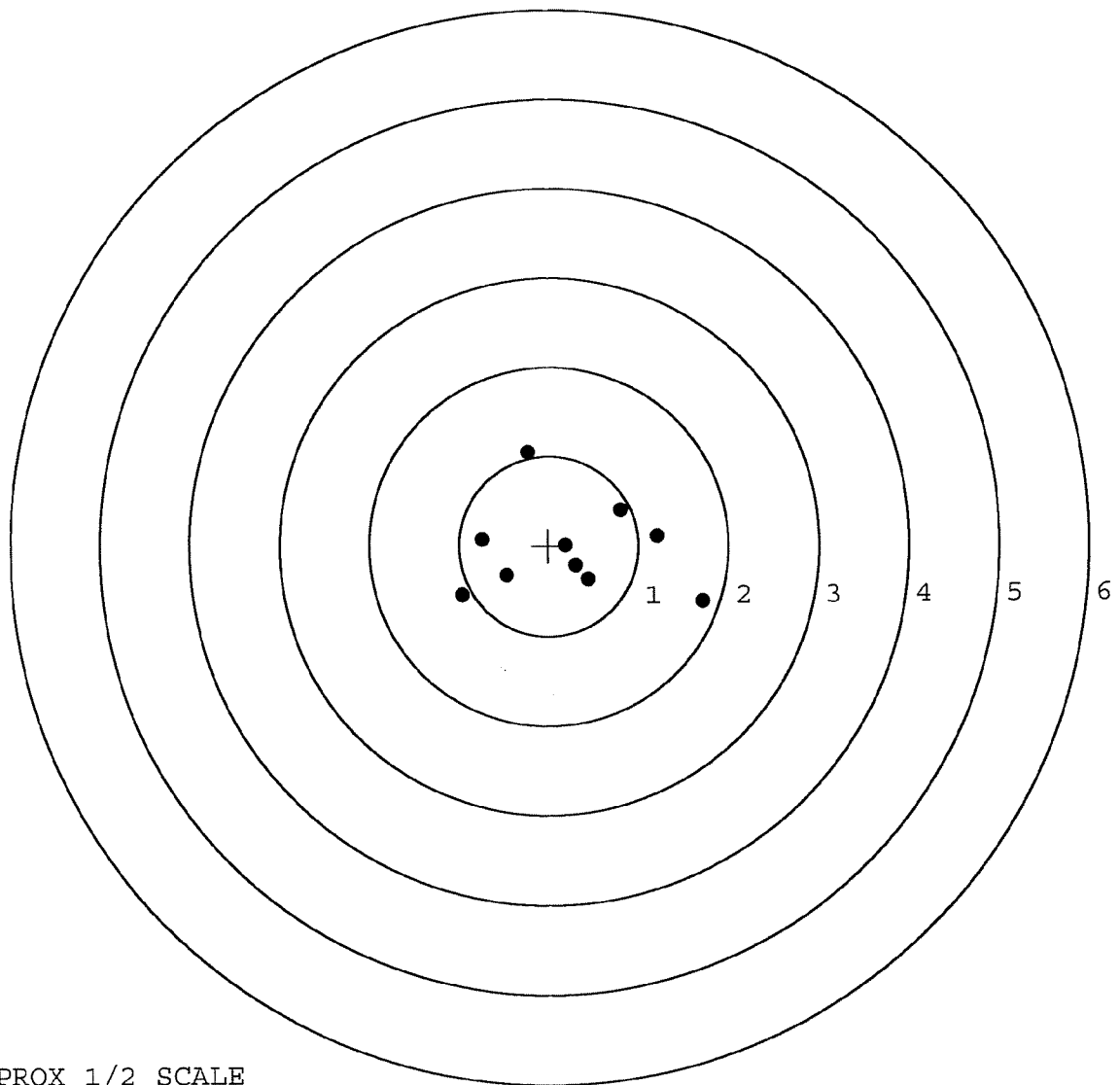


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535205. __0
TARGET NUMBER: 3
FILE DATE: 03/14/2006
FILE TIME: 16:18

POINT#	X	Y
1:	0.188	0.000
2:	0.305	-0.225
3:	0.444	-0.374
4:	-0.471	-0.330
5:	-0.741	0.072
6:	-0.967	-0.551
7:	-0.229	1.044
8:	0.803	0.395
9:	1.208	0.102
10:	1.710	-0.625

X CENTROID: 0.225
Y CENTROID: -0.049
POA TO CENTROID: 0.230
HORZ SPREAD: 2.677
VERT SPREAD: 1.669
GROUP SPREAD: 2.678
MIN RADIUS: 0.062
MAX RADIUS: 1.593
MEAN RADIUS: 0.816
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

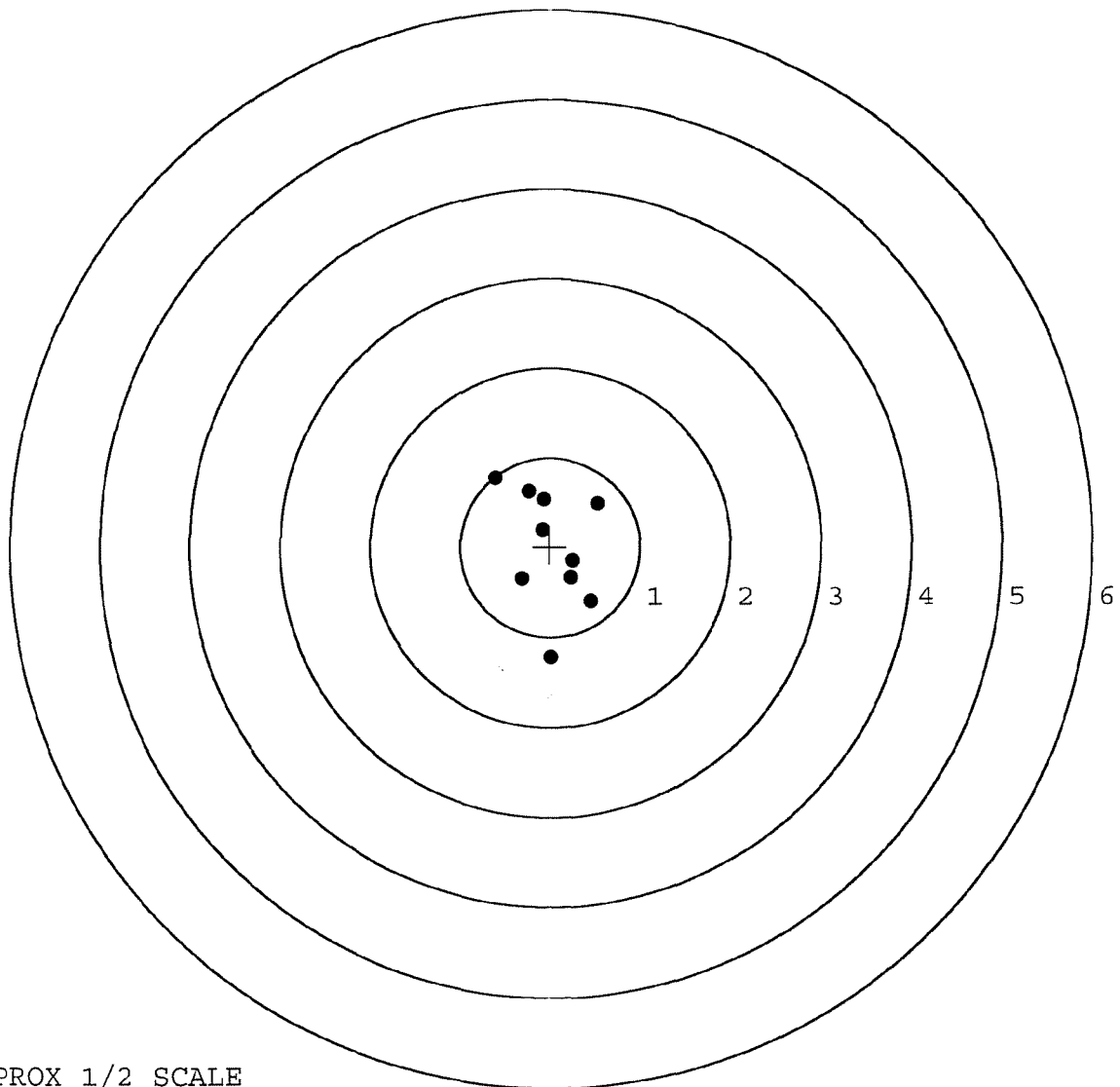


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535205. __0
TARGET NUMBER: 4
FILE DATE: 03/14/2006
FILE TIME: 16:18

POINT#	X	Y
1:	-0.607	0.778
2:	-0.236	0.620
3:	-0.067	0.532
4:	-0.078	0.192
5:	0.529	0.491
6:	0.258	-0.147
7:	0.458	-0.602
8:	-0.307	-0.359
9:	0.015	-1.231
10:	0.236	-0.335

X CENTROID: 0.020
Y CENTROID: -0.006
POA TO CENTROID: 0.021
HORZ SPREAD: 1.136
VERT SPREAD: 2.009
GROUP SPREAD: 2.103
MIN RADIUS: 0.221
MAX RADIUS: 1.225
MEAN RADIUS: 0.627
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

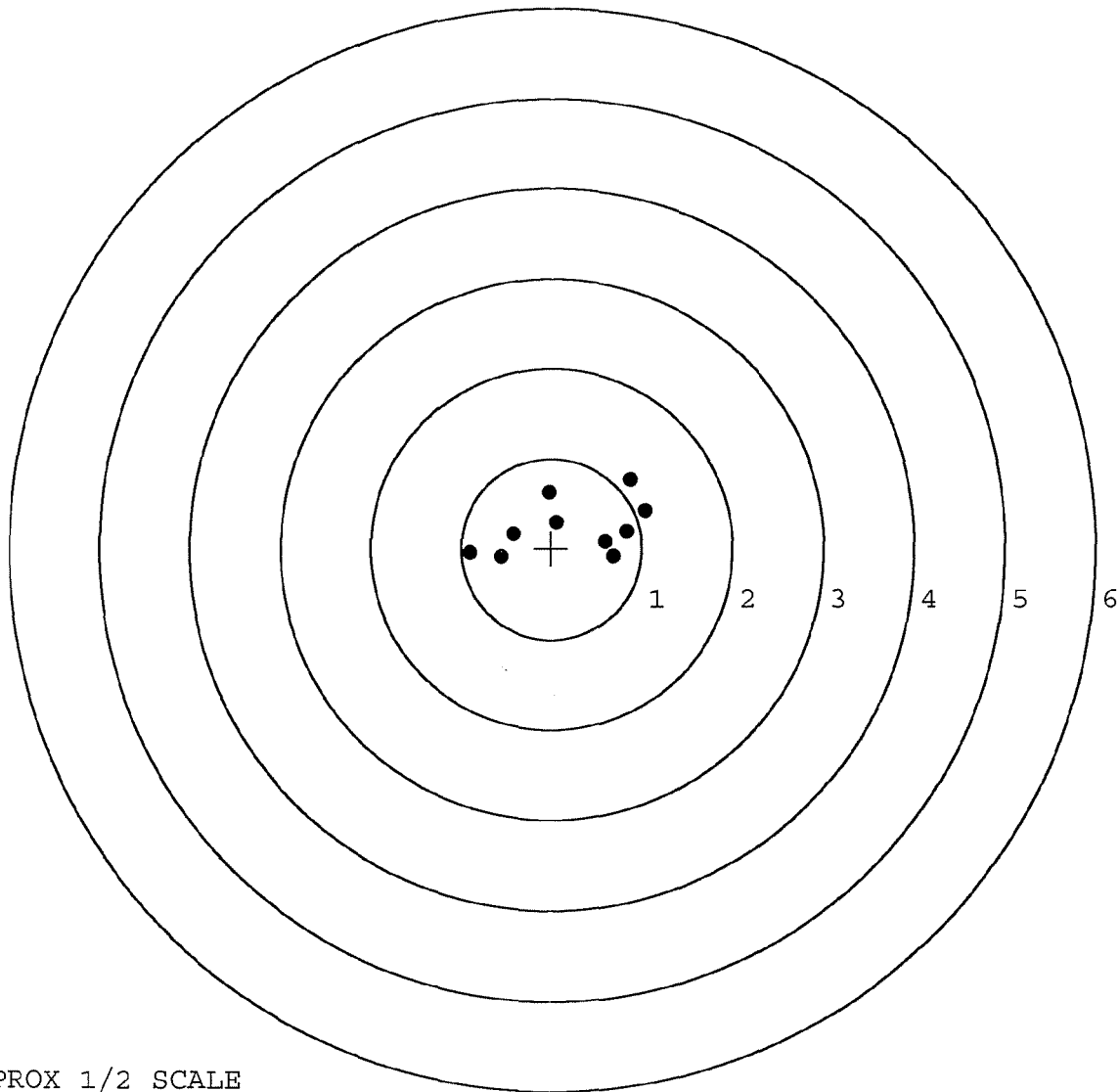


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535205. __0
TARGET NUMBER: 5
FILE DATE: 03/14/2006
FILE TIME: 16:18

X CENTROID: 0.219
Y CENTROID: 0.228
POA TO CENTROID: 0.316
HORZ SPREAD: 1.939
VERT SPREAD: 0.870
GROUP SPREAD: 1.998
MIN RADIUS: 0.173
MAX RADIUS: 1.158
MEAN RADIUS: 0.657
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.420	0.157
2:	-0.557	-0.101
3:	-0.903	-0.059
4:	-0.025	0.623
5:	0.059	0.292
6:	0.601	0.075
7:	0.832	0.190
8:	0.878	0.769
9:	1.036	0.424
10:	0.691	-0.092



TARGET APPROX 1/2 SCALE