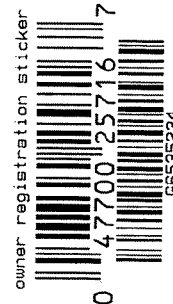


G 653 5234

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

- INSTRUCTION BOOK 3518

DD FORM



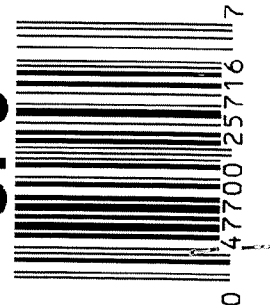
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6535234

UPC



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 # G653 5234

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		4-28-06	RTZ
440	PROOF		4-28-06	MTM
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-28-06	MTM
470	DIS-ASSEMBLE ACTION	MAY 1 2006	5-1-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 440 OPERATOR <u>CPD</u>	3-2-2006	CPD
500	ROLLMARK CALIBER		5-2-06	CW
510	DRILL AND TAP SIGHT HOLES		5-1-06	TRW
520	GOFF BLAST BBL / REC		5-3-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		5/9/06	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-19-06	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-19-06	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-19-06	RA
	D) OIL FIRING PIN ASSEMBLY		5-19-06	AK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		6-16-06	MTM

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>4.5</u>	6-7-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>3.5</u> <u>3.5</u>	6-7-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		6-11-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	6-7-06	DA
	J) ASSEMBLE STOCK		5-31-06	Ac
	K) ASSEMBLE SWIVEL STUDS		6-11-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-30-06	Ac
	M) IRON SIGHT ALIGNMENT		5-30-06	Ac
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-30-06	Ac
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	6-5-06	X.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-5-06	MTM
670	FINAL INSPECTION A) HEADSPACE		6-11-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.55</u> <u>2.30</u> <u>2.34</u> <u>2.65</u>	6-7-06	DA
	C) FUNCTION		6-11-06	MTM
690	PACK		7-7-06	DA

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 5-15-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	258	250		245	
PULL #2	251	240		246	
PULL #3	243	250		247	
PULL #4	258	253		247	
PULL #5	242	254		242	
TOTAL	1252	1247		1227	
AVERAGE	250	249		245	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	303	308		
PULL #2	304	308		
PULL #3	319	305		
PULL #4	320	302		
PULL #5	296	297		
TOTAL	1542	1520		
AVERAGE	308	304		

	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	415	410		411
PULL #2	416	406		411
PULL #3	415	407		414
PULL #4	412	410		416
PULL #5	409	411		412
TOTAL	2067	2044		2064
AVERAGE	413	408		412

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535234.___0
FILE DATE AND TIME: 06/05/2006 17:54

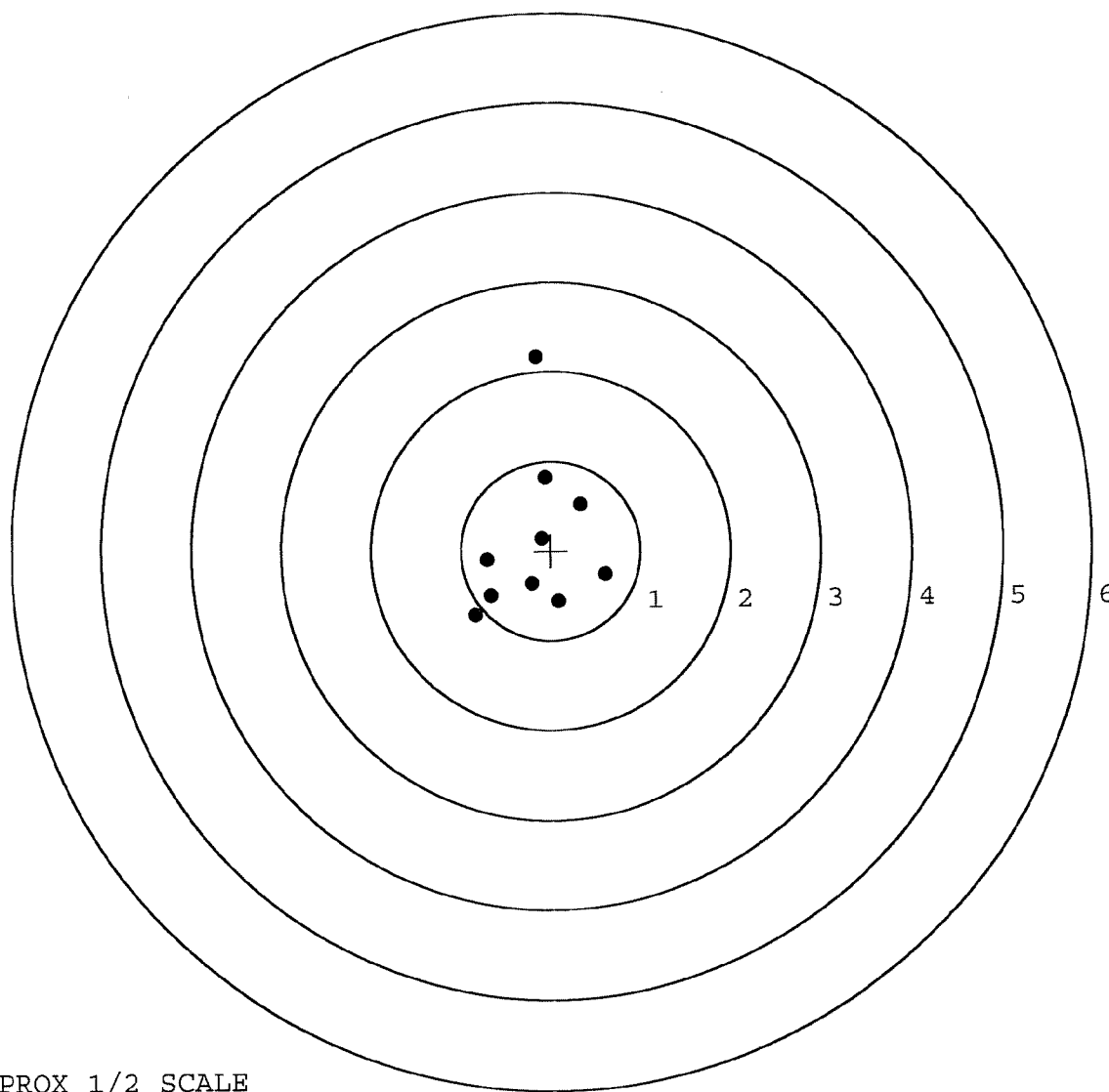
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.010
The Average Y Centroid of the Five Target Set:	0.057
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.720
The Distance from POA to Centroid Target #1:	0.204
The Distance from Centroid Target #2 to Centroid Target #1:	0.230
The Distance from Centroid Target #3 to Centroid Target #1:	0.185
The Distance from Centroid Target #4 to Centroid Target #1:	0.201
The Distance from Centroid Target #5 to Centroid Target #1:	0.384

SERIAL NUMBER: G6535234. __0
TARGET NUMBER: 1
FILE DATE: 06/05/2006
FILE TIME: 17:54

POINT#	X	Y
1:	-0.063	0.819
2:	0.337	0.514
3:	-0.103	0.134
4:	-0.217	-0.369
5:	0.082	-0.568
6:	0.607	-0.273
7:	-0.708	-0.102
8:	-0.672	-0.502
9:	-0.841	-0.723
10:	-0.154	2.155

X CENTROID: -0.173
Y CENTROID: 0.109
POA TO CENTROID: 0.204
HORZ SPREAD: 1.448
VERT SPREAD: 2.878
GROUP SPREAD: 2.959
MIN RADIUS: 0.075
MAX RADIUS: 2.047
MEAN RADIUS: 0.799
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



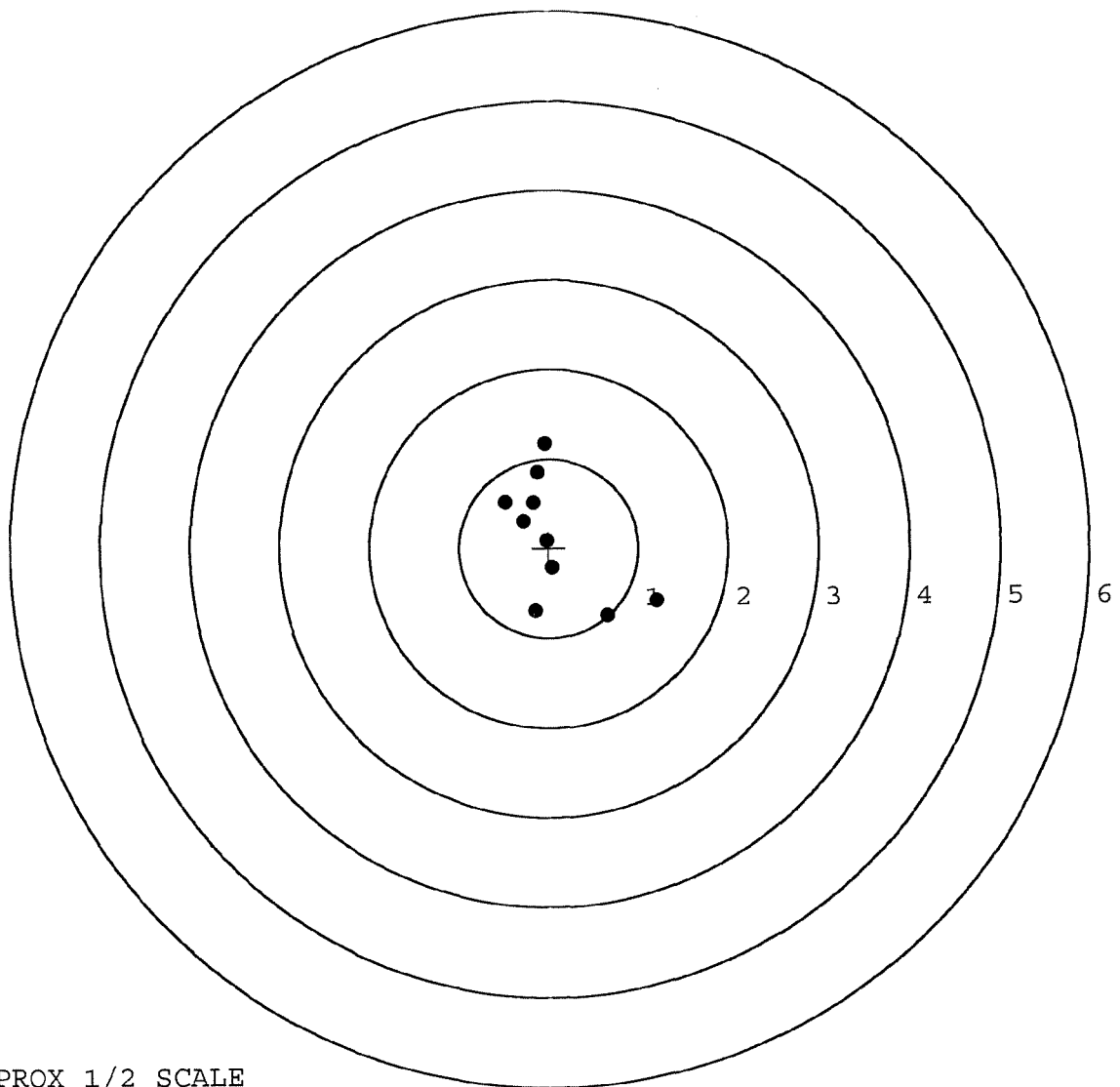
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535234. __0
TARGET NUMBER: 2
FILE DATE: 06/05/2006
FILE TIME: 17:54

X CENTROID: 0.057
Y CENTROID: 0.115
POA TO CENTROID: 0.128
HORZ SPREAD: 1.692
VERT SPREAD: 1.928
GROUP SPREAD: 2.160
MIN RADIUS: 0.087
MAX RADIUS: 1.347
MEAN RADIUS: 0.704

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.044	1.169
2:	-0.128	0.853
3:	-0.179	0.511
4:	-0.492	0.516
5:	-0.292	0.303
6:	0.035	-0.222
7:	-0.158	-0.713
8:	0.651	-0.759
9:	1.200	-0.597
10:	-0.025	0.084



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535234. 0

TARGET NUMBER: 3

FILE DATE: 06/05/2006

FILE TIME: 17:54

POINT#	X	Y
1:	-1.072	0.826
2:	-0.602	-0.935
3:	-0.307	-0.562
4:	-0.469	0.024
5:	-0.276	0.307
6:	0.245	0.185
7:	0.556	0.000
8:	0.243	-0.331
9:	0.985	-0.116
10:	0.067	0.198

X CENTROID: -0.063

Y CENTROID: -0.040

POA TO CENTROID: 0.075

HORZ SPREAD: 2.057

VERT SPREAD: 1.761

GROUP SPREAD: 2.262

MIN RADIUS: 0.272

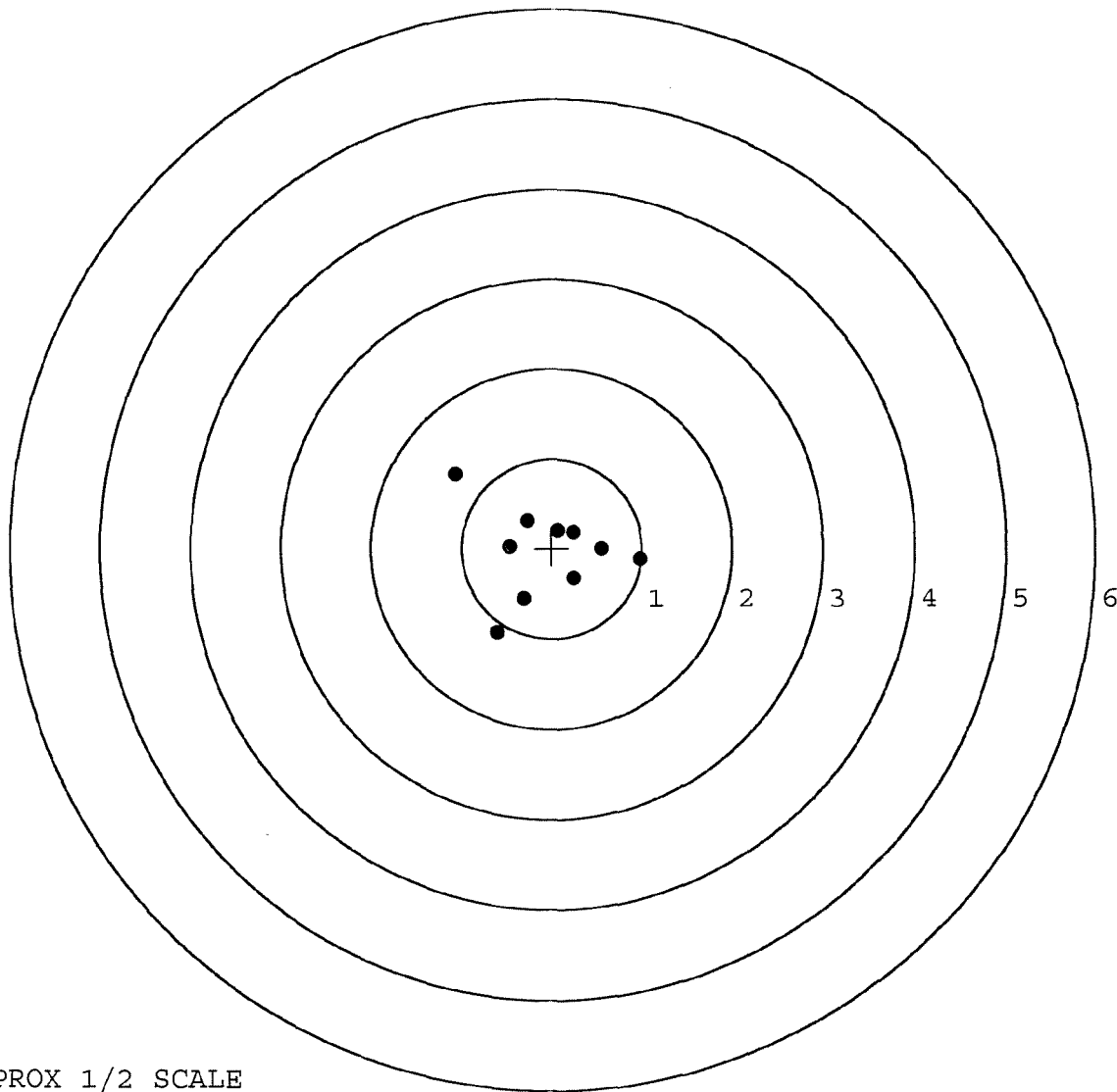
MAX RADIUS: 1.330

MEAN RADIUS: 0.652

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

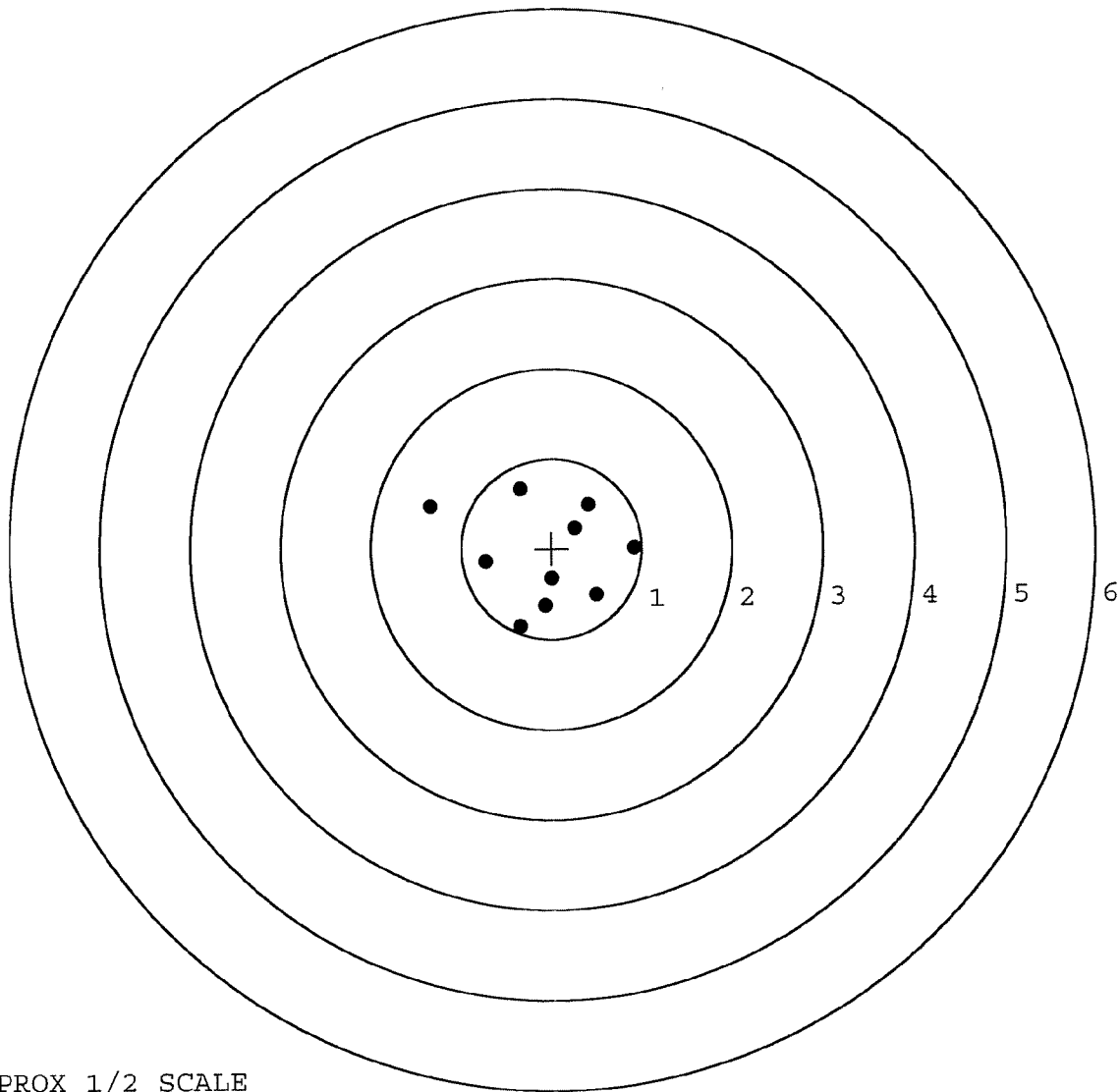


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535234. __0
TARGET NUMBER: 4
FILE DATE: 06/05/2006
FILE TIME: 17:54

X CENTROID: -0.077
Y CENTROID: -0.067
POA TO CENTROID: 0.102
HORZ SPREAD: 2.256
VERT SPREAD: 1.525
GROUP SPREAD: 2.305
MIN RADIUS: 0.282
MAX RADIUS: 1.369
MEAN RADIUS: 0.740
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.337	0.468
2:	-0.729	-0.153
3:	-0.355	-0.860
4:	-0.077	-0.637
5:	0.006	-0.337
6:	0.255	0.222
7:	0.409	0.483
8:	-0.351	0.665
9:	0.919	-0.006
10:	0.494	-0.517



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535234. __0

TARGET NUMBER: 5

FILE DATE: 06/05/2006

FILE TIME: 17:54

POINT#	X	Y
1:	-0.849	0.700
2:	-0.352	0.160
3:	-0.188	0.552
4:	0.015	0.721
5:	0.862	0.438
6:	0.851	0.304
7:	0.754	0.150
8:	0.465	0.051
9:	-0.225	-0.659
10:	0.728	-0.722

X CENTROID: 0.206

Y CENTROID: 0.170

POA TO CENTROID: 0.267

HORZ SPREAD: 1.711

VERT SPREAD: 1.443

GROUP SPREAD: 2.123

MIN RADIUS: 0.285

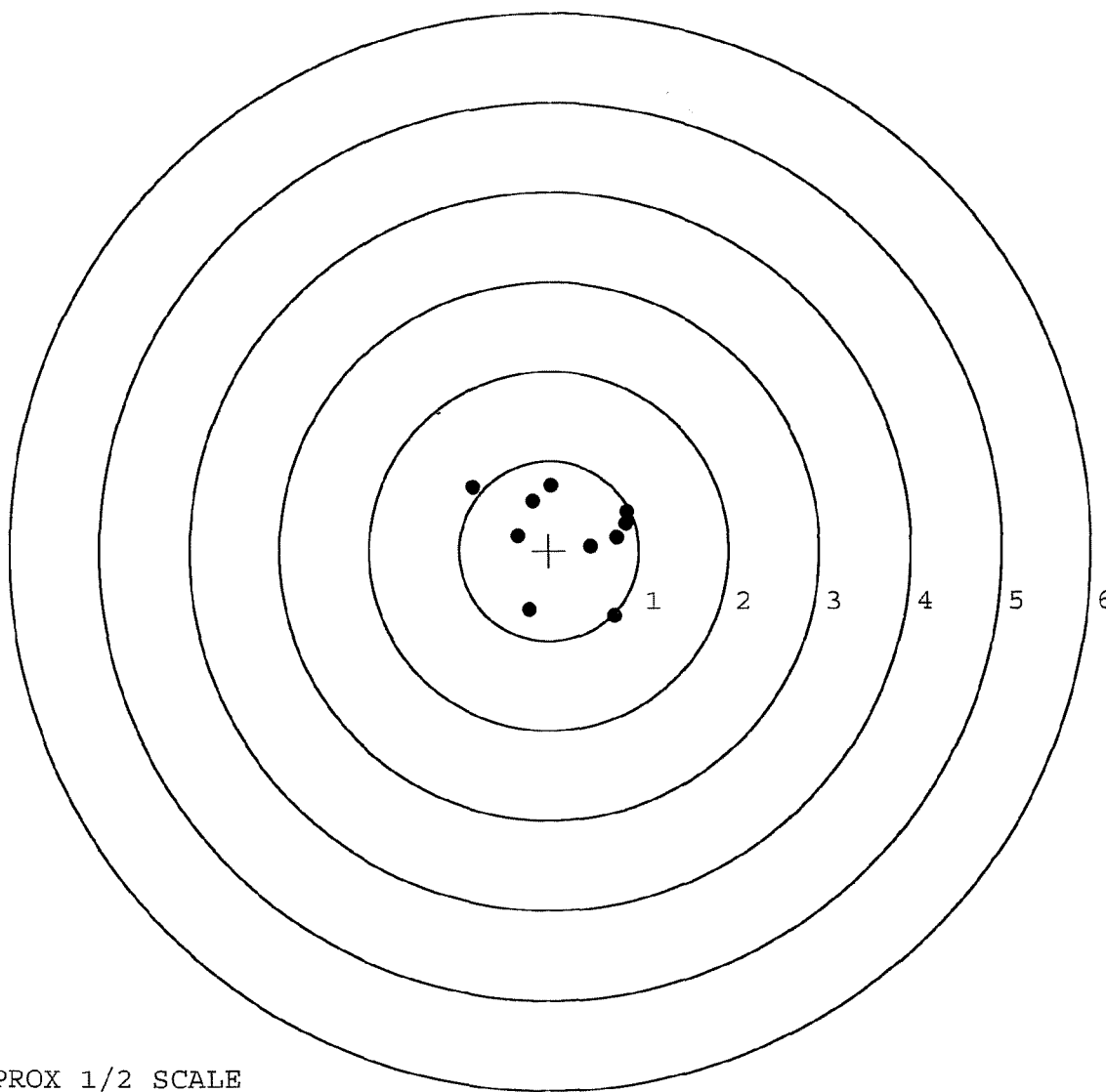
MAX RADIUS: 1.181

MEAN RADIUS: 0.704

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE