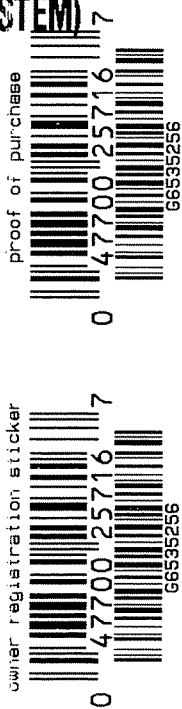


G6535256

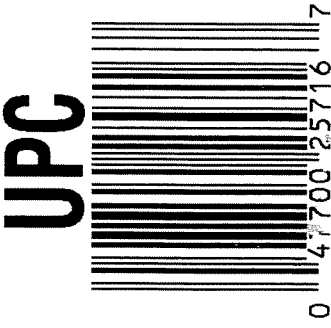
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6535256	



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 # G6535256

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		5-4-06	RTZ
440	PROOF		5-4-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	5-4-06	L.P.D.
470	DIS-ASSEMBLE ACTION		5-5-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	CD # 480 MAY 09 2006 OPERATOR CPD	2-9-06	APD
500	ROLLMARK CALIBER		5-8-06	CW
510	DRILL AND TAP SIGHT HOLES		5-8-06	TRJ
520	GOFF BLAST BBL / REC		5-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/12/06	TRJ
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		6-2-06	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-2-06	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-2-06	MTM
	D) OIL FIRING PIN ASSEMBLY		6-6-06	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-9-06	A
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.2</u> <u>6.2</u>	6-13-06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	6-13-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>.023</u> <u>.023</u>	6-13-06	DA
	J) ASSEMBLE STOCK		6-6-06	L.P.D.
	K) ASSEMBLE SWIVEL STUDS		8-9-06	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-6-06	L.P.D.
	M) IRON SIGHT ALIGNMENT		6-6-06	L.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-6-06	L.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	6-8-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-8-06	MTM
670	FINAL INSPECTION A) HEADSPACE		8-9-06	A
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.41</u> <u>2.42</u> <u>2.58</u> <u>2.49</u>	6-13-06	DA
	C) FUNCTION		8-9-06	A
690	PACK		10-30-06	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 5-31-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	254	258		249	
PULL #2	252	255		246	
PULL #3	230	247		244	
PULL #4	240	240		241	
PULL #5	263	245		246	
TOTAL	1239	1245		1226	
AVERAGE	247	249		245	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	304	300		
PULL #2	304	293		
PULL #3	316	300		
PULL #4	301	286		
PULL #5	296	295		
TOTAL	1521	1474		
AVERAGE	304	294		

	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	409	417		423
PULL #2	409	419		417
PULL #3	407	418		423
PULL #4	410	417		420
PULL #5	413	413		423
TOTAL	2048	2084		2106
AVERAGE	409	416		421

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535256.___0
FILE DATE AND TIME: 06/08/2006 16:32

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.008
The Average Y Centroid of the Five Target Set:	0.037
The Average Point of Impact of the Five Target Set:	0.038
The Average Mean Radius of the Five Target Set:	0.529
The Distance from POA to Centroid Target #1:	0.351
The Distance from Centroid Target #2 to Centroid Target #1:	0.435
The Distance from Centroid Target #3 to Centroid Target #1:	0.319
The Distance from Centroid Target #4 to Centroid Target #1:	0.534
The Distance from Centroid Target #5 to Centroid Target #1:	0.448

SERIAL NUMBER: G6535256. 0

TARGET NUMBER: 1

FILE DATE: 06/08/2006

FILE TIME: 16:32

X CENTROID: 0.012

Y CENTROID: 0.351

POA TO CENTROID: 0.351

HORZ SPREAD: 1.689

VERT SPREAD: 2.013

GROUP SPREAD: 2.227

MIN RADIUS: 0.163

MAX RADIUS: 1.407

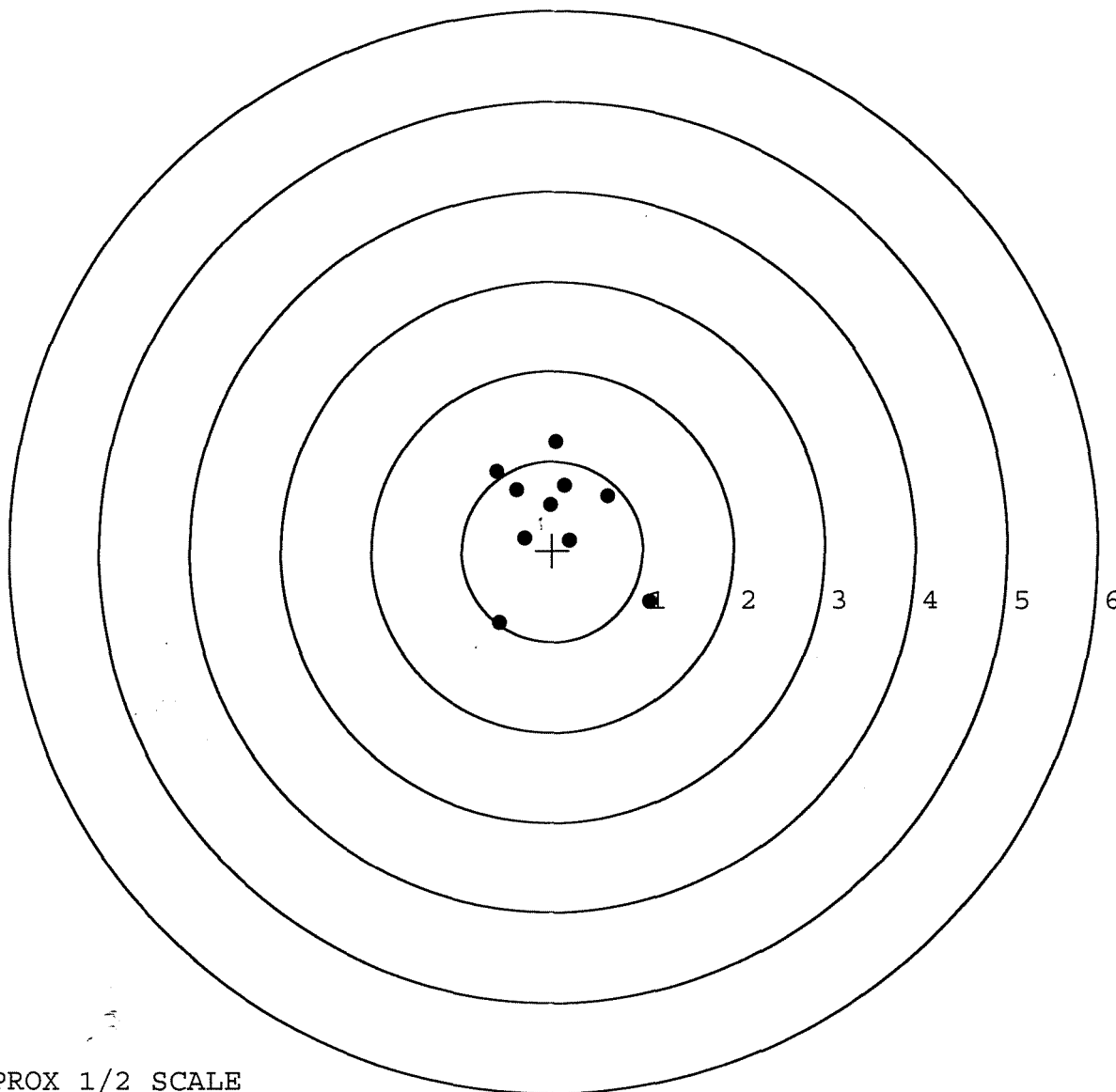
MEAN RADIUS: 0.680

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.614	0.881
2:	0.036	1.218
3:	-0.397	0.677
4:	-0.308	0.136
5:	0.134	0.729
6:	0.608	0.610
7:	0.187	0.114
8:	-0.023	0.510
9:	1.075	-0.570
10:	-0.581	-0.795



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535256. __0

TARGET NUMBER: 2

FILE DATE: 06/08/2006

FILE TIME: 16:32

X CENTROID: 0.168

Y CENTROID: -0.054

POA TO CENTROID: 0.176

HORZ SPREAD: 1.309

VERT SPREAD: 1.772

GROUP SPREAD: 1.849

MIN RADIUS: 0.126

MAX RADIUS: 1.038

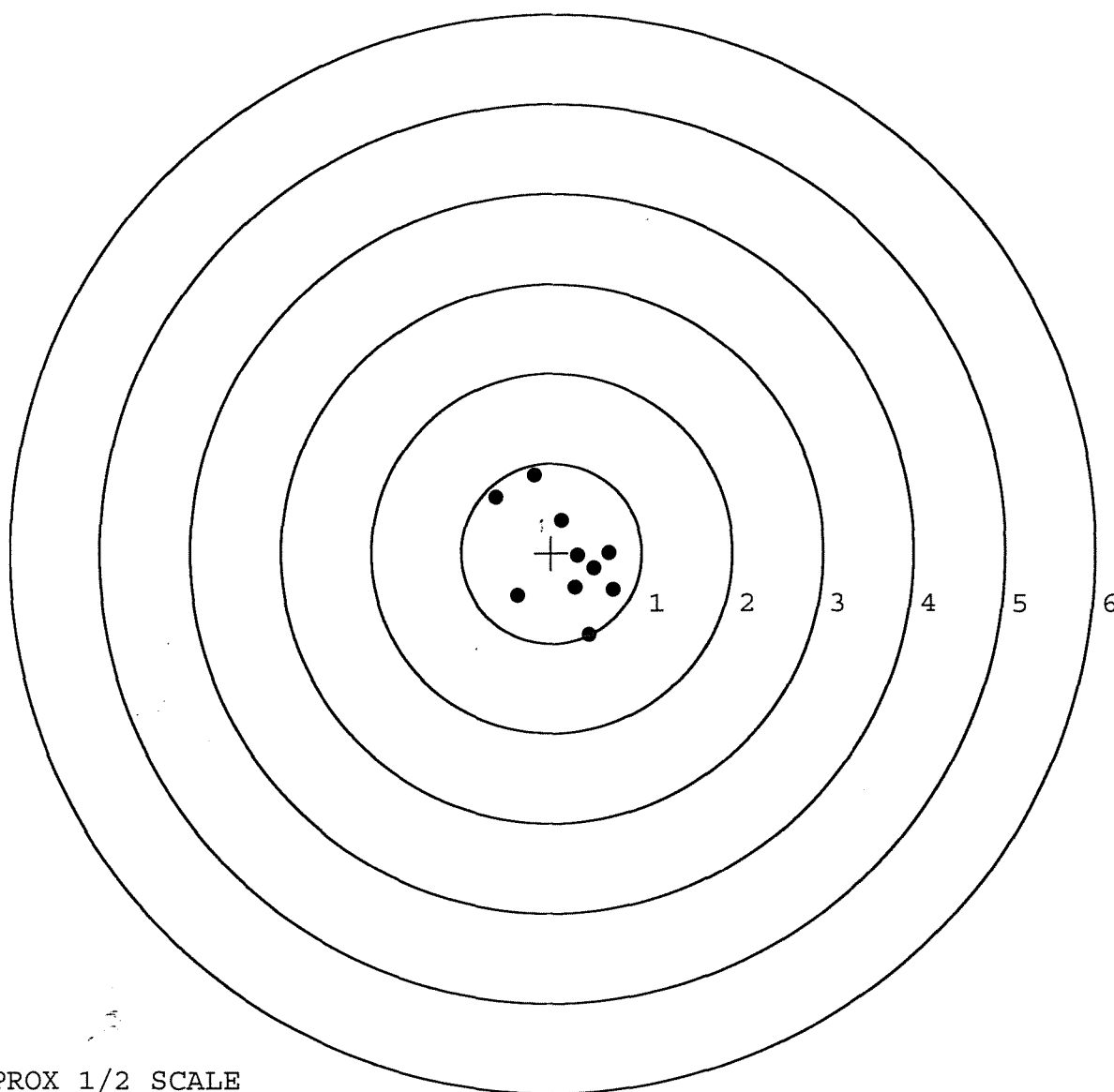
MEAN RADIUS: 0.592

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.424	-0.907
2:	-0.376	-0.475
3:	-0.626	0.615
4:	-0.196	0.865
5:	0.107	0.361
6:	0.637	-0.006
7:	0.683	-0.412
8:	0.260	-0.384
9:	0.292	-0.032
10:	0.473	-0.170



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535256. __0

TARGET NUMBER: 3

FILE DATE: 06/08/2006

FILE TIME: 16:32

X CENTROID: -0.234

Y CENTROID: 0.147

POA TO CENTROID: 0.277

HORZ SPREAD: 1.410

VERT SPREAD: 1.410

GROUP SPREAD: 1.643

MIN RADIUS: 0.071

MAX RADIUS: 1.098

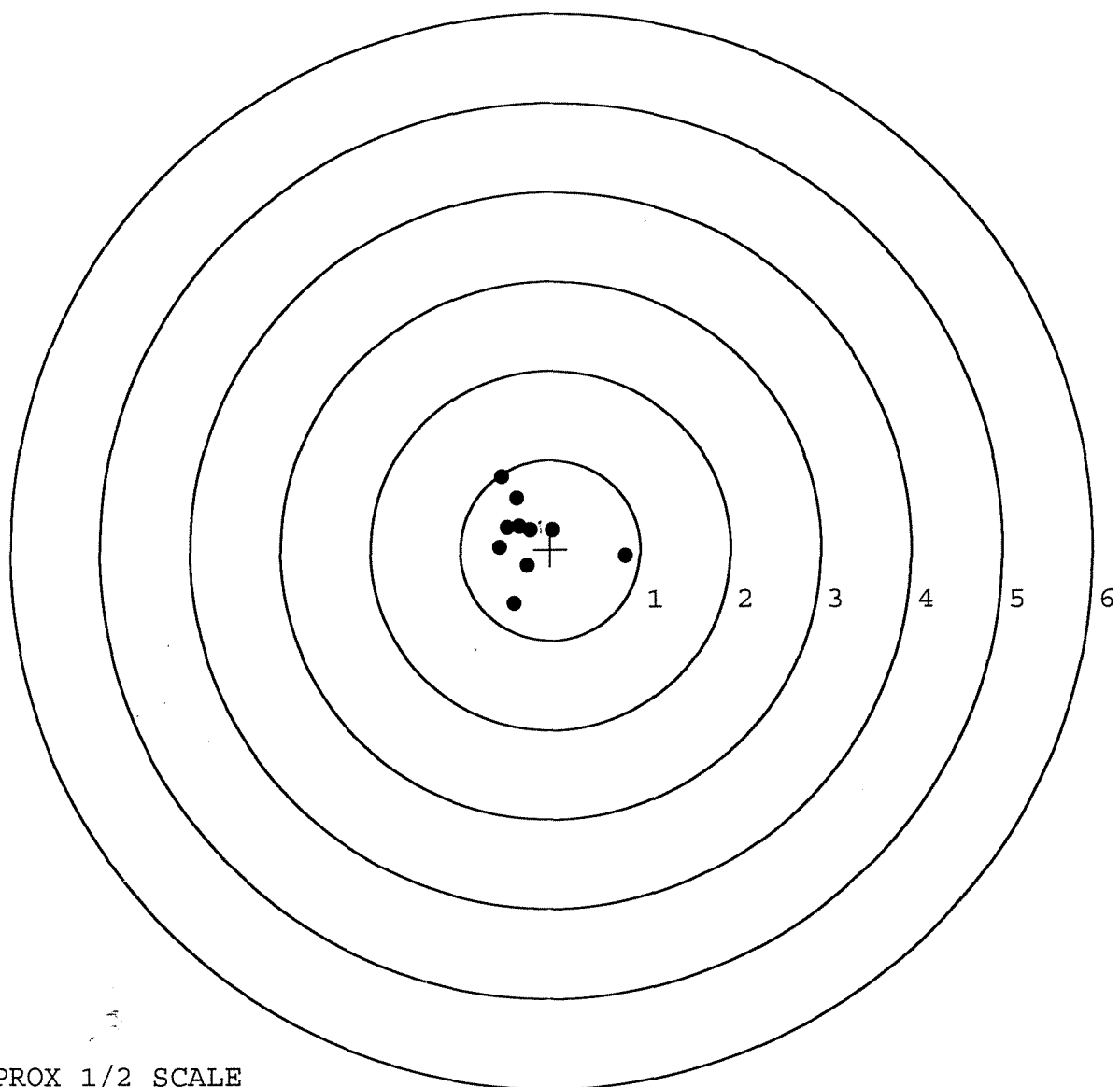
MEAN RADIUS: 0.449

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.401	-0.600
2:	0.840	-0.079
3:	-0.254	-0.183
4:	0.026	0.215
5:	-0.231	0.218
6:	-0.570	0.025
7:	-0.480	0.242
8:	-0.542	0.810
9:	-0.379	0.572
10:	-0.350	0.255



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535256. __0

TARGET NUMBER: 4

FILE DATE: 06/08/2006

FILE TIME: 16:32

X CENTROID: -0.043

Y CENTROID: -0.181

POA TO CENTROID: 0.186

HORZ SPREAD: 0.942

VERT SPREAD: 1.566

GROUP SPREAD: 1.613

MIN RADIUS: 0.085

MAX RADIUS: 0.933

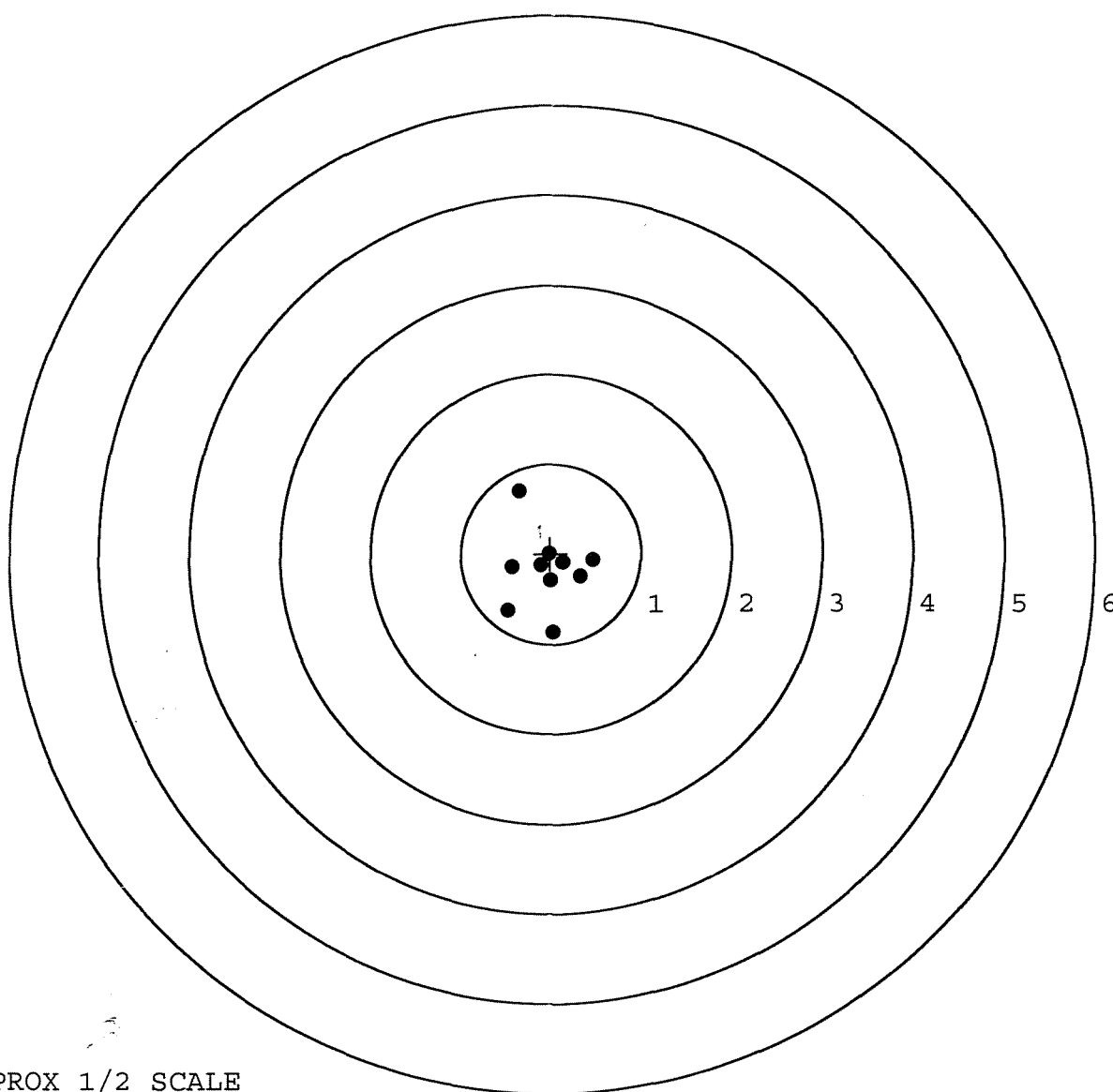
MEAN RADIUS: 0.412

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.030	-0.869
2:	-0.477	-0.633
3:	-0.358	0.697
4:	-0.430	-0.150
5:	-0.014	-0.004
6:	0.465	-0.068
7:	0.329	-0.248
8:	0.003	-0.297
9:	0.134	-0.106
10:	-0.110	-0.129

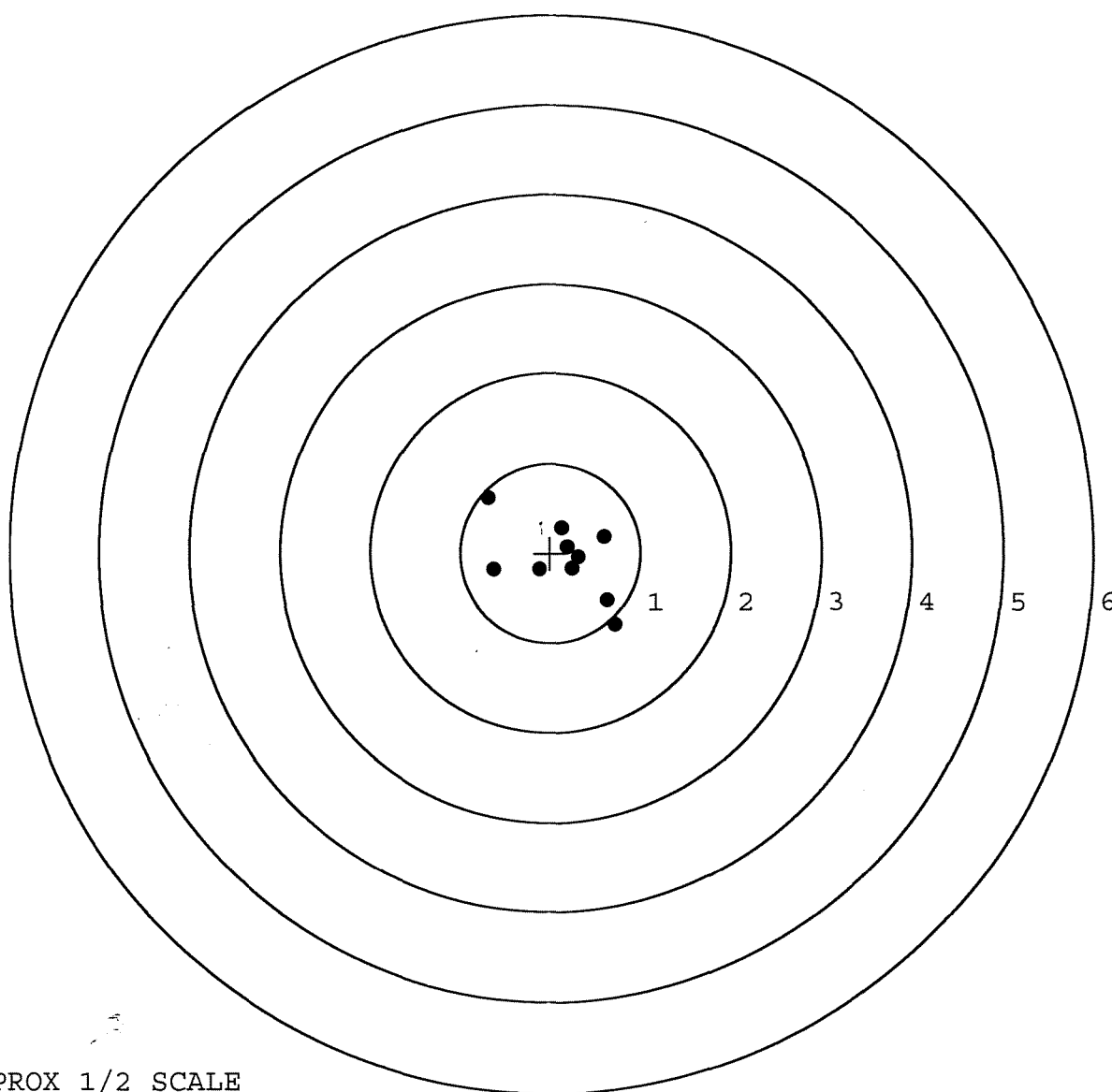


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535256. __ 0
TARGET NUMBER: 5
FILE DATE: 06/08/2006
FILE TIME: 16:32

X CENTROID: 0.137
Y CENTROID: -0.079
POA TO CENTROID: 0.158
HORZ SPREAD: 1.412
VERT SPREAD: 1.421
GROUP SPREAD: 2.003
MIN RADIUS: 0.144
MAX RADIUS: 1.084
MEAN RADIUS: 0.511
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.720	-0.802
2:	0.632	-0.529
3:	-0.628	-0.187
4:	-0.126	-0.193
5:	0.242	-0.177
6:	-0.692	0.619
7:	0.128	0.283
8:	0.597	0.183
9:	0.310	-0.053
10:	0.190	0.070



TARGET APPROX 1/2 SCALE