

G653 5292

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

- INSTRUCTION BOOK 3518

DD FORM

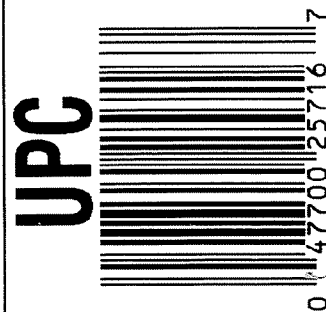


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6535292



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5292

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-2-06	RTZ
440	PROOF	MAGNA-FLUX INSPECTED	2/2/06	MJD
460	CHECK HEADSPACE		2/2/06	MJD
470	DIS-ASSEMBLE ACTION		2-3-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480	2-7-06	APD
500	ROLLMARK CALIBER		2-7-06	CW
510	DRILL AND TAP SIGHT HOLES		2-6-06	TRW
520	GOFF BLAST BBL / REC		2/8	
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/14	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3/20/06	MJD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/20/06	MJD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3/20/06	MJD
	D) OIL FIRING PIN ASSEMBLY		3-22-06	L
	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>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	4-24-06	<u>AC</u>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	4-24-06	<u>AC</u>
	H) TRIGGER PULL TEST AND RETAINABILITY		4-24-06	<u>AC</u>
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	4-24-06	<u>AC</u>
	J) ASSEMBLE STOCK		3-28-06	<u>RT</u>
	K) ASSEMBLE SWIVEL STUDS		4-24-06	<u>L.P.D.</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-22-06	<u>AC</u>
	M) IRON SIGHT ALIGNMENT		3-22-06	<u>AC</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-22-06	<u>AC</u>
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-29-06	<u>L.P.D.</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-29-06	<u>MM</u>
670	FINAL INSPECTION A) HEADSPACE		4-24-06	<u>AC</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.87</u> <u>2.75</u> <u>2.86</u> <u>2.87</u>	4-20-06	<u>AC</u>
	C) FUNCTION		4-24-06	<u>AC</u>
690	PACK		4-27-06	<u>DA</u>

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 3-14-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.45	2.49		2.41	
PULL #2	2.59	2.54		2.33	
PULL #3	2.66	2.54		2.51	
PULL #4	2.50	2.54		2.53	
PULL #5	2.33	2.62		2.57	
TOTAL	12.53	12.73		12.35	
AVERAGE	2.50	2.54		2.47	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.11		
PULL #2	3.10	3.05		
PULL #3	3.10	3.08		
PULL #4	3.09	3.06		
PULL #5	3.11	3.19		
TOTAL	15.47	15.49		
AVERAGE	3.09	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	4.16	4.04		4.06
PULL #2	4.13	4.02		4.01
PULL #3	4.04	4.01		4.01
PULL #4	4.14	4.03		4.15
PULL #5	4.10	4.01		4.10
TOTAL	20.57	20.11		20.33
AVERAGE	4.11	4.02		4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535292.___0
FILE DATE AND TIME: 03/29/2006 15:25

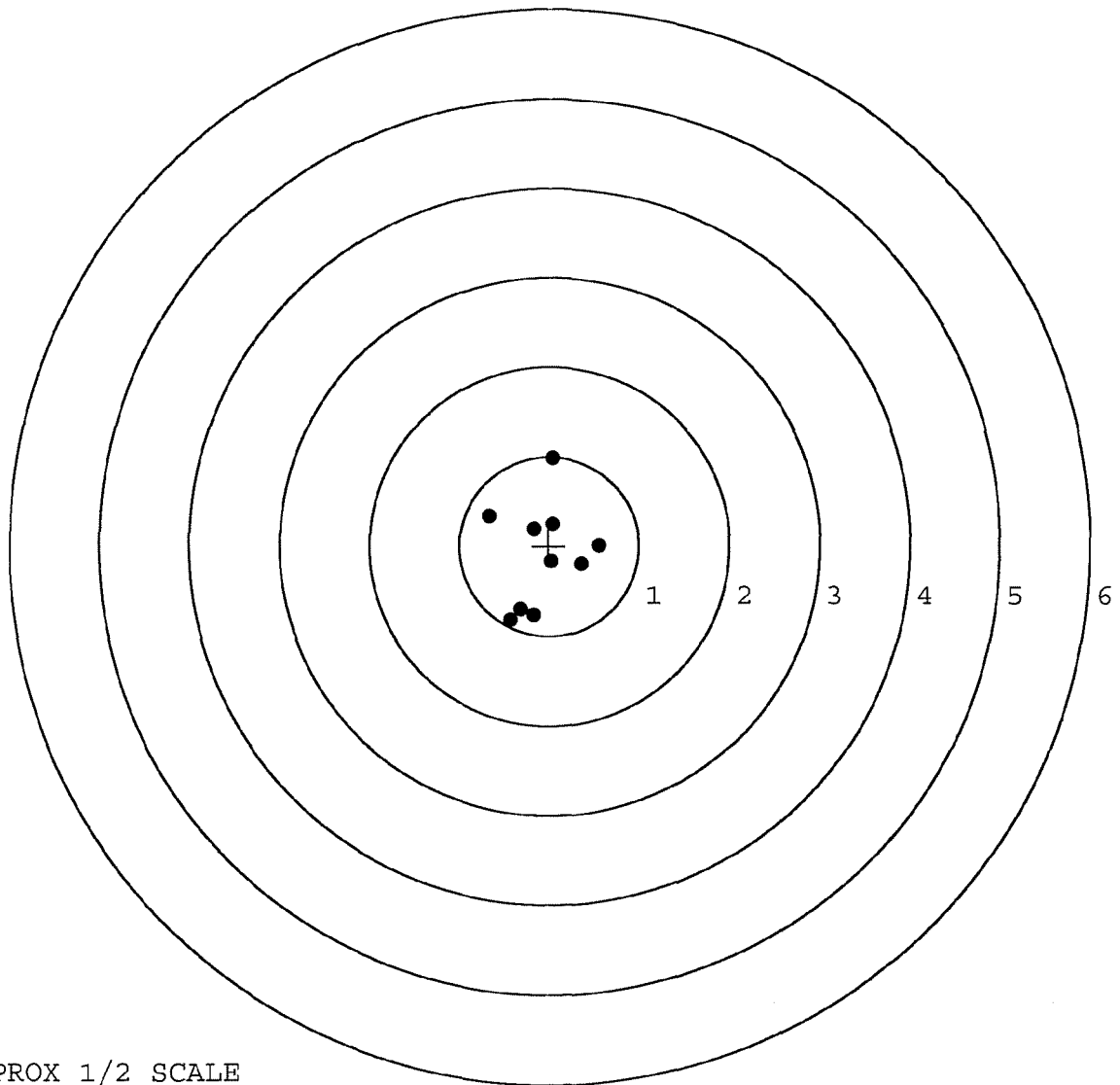
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.064
The Average Y Centroid of the Five Target Set:	0.006
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.583
The Distance from POA to Centroid Target #1:	0.117
The Distance from Centroid Target #2 to Centroid Target #1:	0.077
The Distance from Centroid Target #3 to Centroid Target #1:	0.207
The Distance from Centroid Target #4 to Centroid Target #1:	0.166
The Distance from Centroid Target #5 to Centroid Target #1:	0.248

SERIAL NUMBER: G6535292. 0
TARGET NUMBER: 1
FILE DATE: 03/29/2006
FILE TIME: 15:25

POINT#	X	Y
1:	0.049	0.245
2:	-0.172	0.191
3:	0.029	-0.177
4:	0.361	-0.205
5:	0.565	0.007
6:	-0.169	-0.776
7:	-0.315	-0.710
8:	-0.427	-0.828
9:	-0.671	0.334
10:	0.041	0.985

X CENTROID: -0.071
Y CENTROID: -0.093
POA TO CENTROID: 0.117
HORZ SPREAD: 1.236
VERT SPREAD: 1.813
GROUP SPREAD: 1.872
MIN RADIUS: 0.130
MAX RADIUS: 1.084
MEAN RADIUS: 0.587
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535292. 0

TARGET NUMBER: 2

FILE DATE: 03/29/2006

FILE TIME: 15:25

POINT#	X	Y
1:	0.061	0.469
2:	0.440	-0.047
3:	0.408	-0.213
4:	0.191	-0.635
5:	1.008	-1.110
6:	-0.103	-0.049
7:	-0.332	-0.228
8:	-0.361	-0.013
9:	-0.607	0.133
10:	-0.772	0.331

X CENTROID: -0.007

Y CENTROID: -0.136

POA TO CENTROID: 0.136

HORZ SPREAD: 1.780

VERT SPREAD: 1.579

GROUP SPREAD: 2.290

MIN RADIUS: 0.130

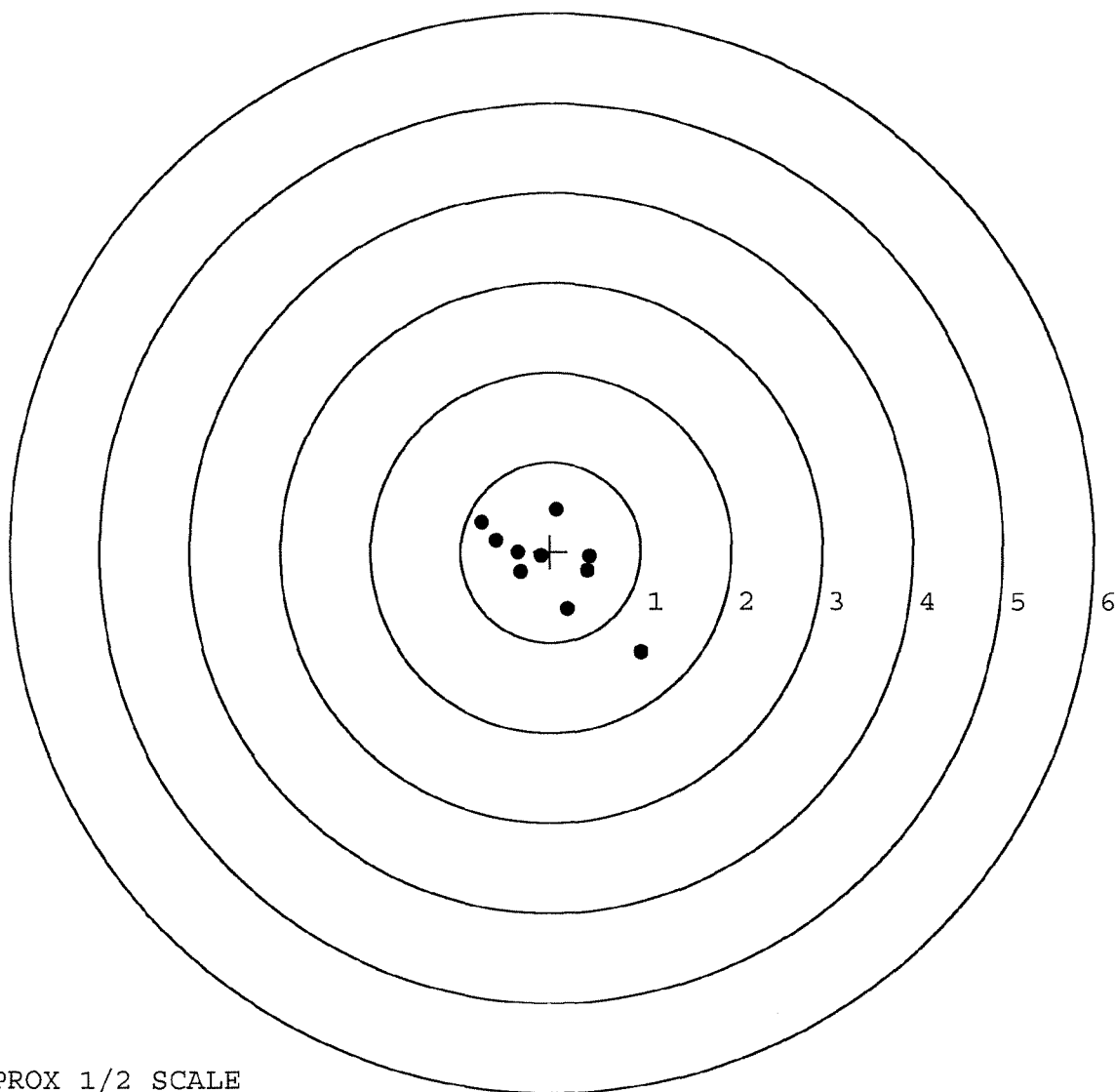
MAX RADIUS: 1.406

MEAN RADIUS: 0.583

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

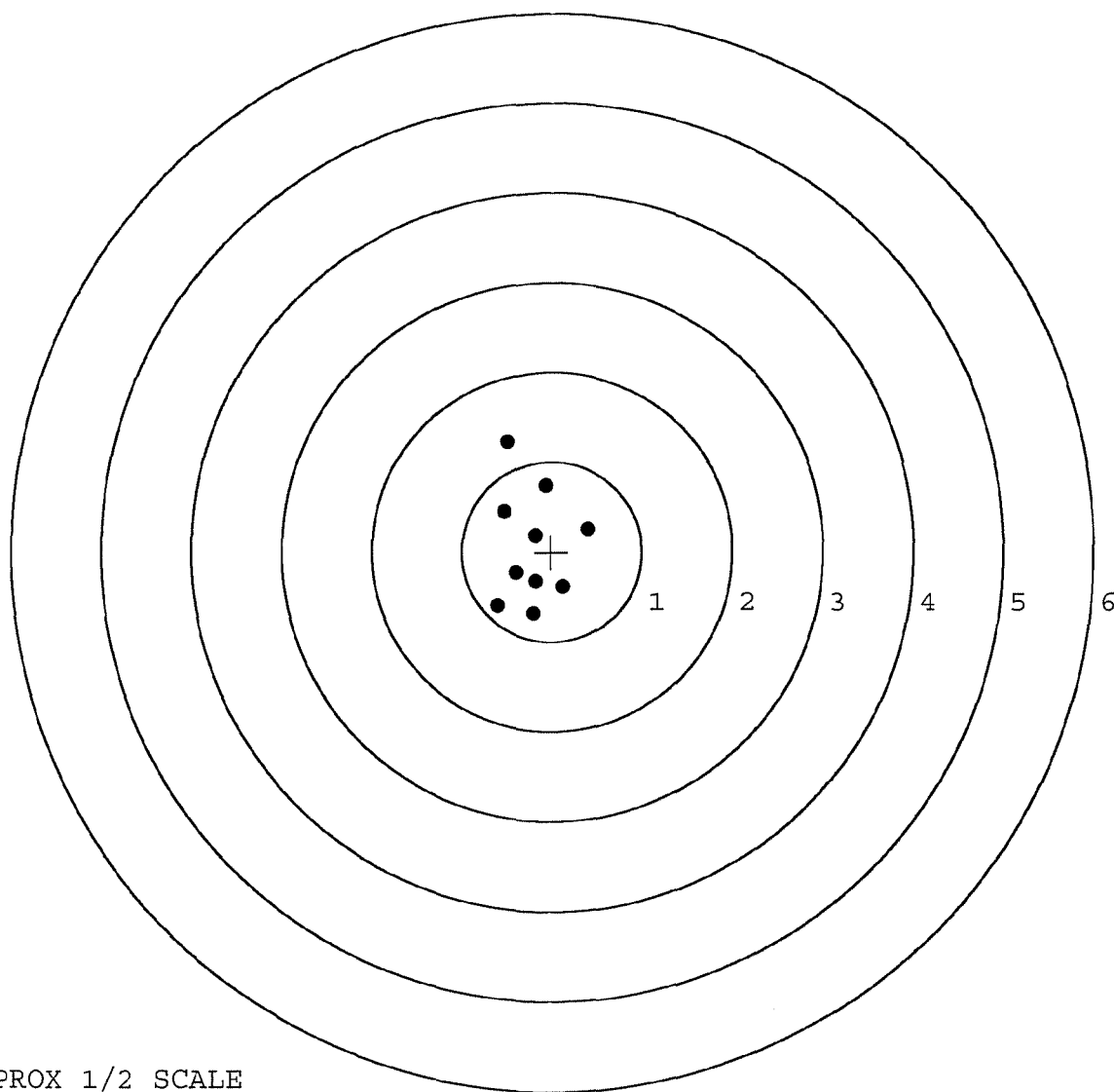


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535292. __0
TARGET NUMBER: 3
FILE DATE: 03/29/2006
FILE TIME: 15:25

POINT#	X	Y
1:	-0.499	1.218
2:	-0.060	0.730
3:	0.402	0.251
4:	-0.530	0.441
5:	-0.186	0.182
6:	-0.395	-0.230
7:	-0.177	-0.327
8:	0.127	-0.391
9:	-0.204	-0.689
10:	-0.604	-0.604

X CENTROID: -0.213
Y CENTROID: 0.058
POA TO CENTROID: 0.220
HORZ SPREAD: 1.006
VERT SPREAD: 1.907
GROUP SPREAD: 1.930
MIN RADIUS: 0.127
MAX RADIUS: 1.195
MEAN RADIUS: 0.596
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535292. 0

TARGET NUMBER: 4

FILE DATE: 03/29/2006

FILE TIME: 15:25

POINT#	X	Y
1:	0.260	0.383
2:	1.136	-0.235
3:	0.708	-0.298
4:	0.370	0.020
5:	0.078	-0.202
6:	-0.062	-0.048
7:	-0.238	-0.048
8:	-0.363	-0.420
9:	-0.595	0.288
10:	-1.077	1.008

X CENTROID: 0.022

Y CENTROID: 0.045

POA TO CENTROID: 0.050

HORZ SPREAD: 2.213

VERT SPREAD: 1.428

GROUP SPREAD: 2.538

MIN RADIUS: 0.125

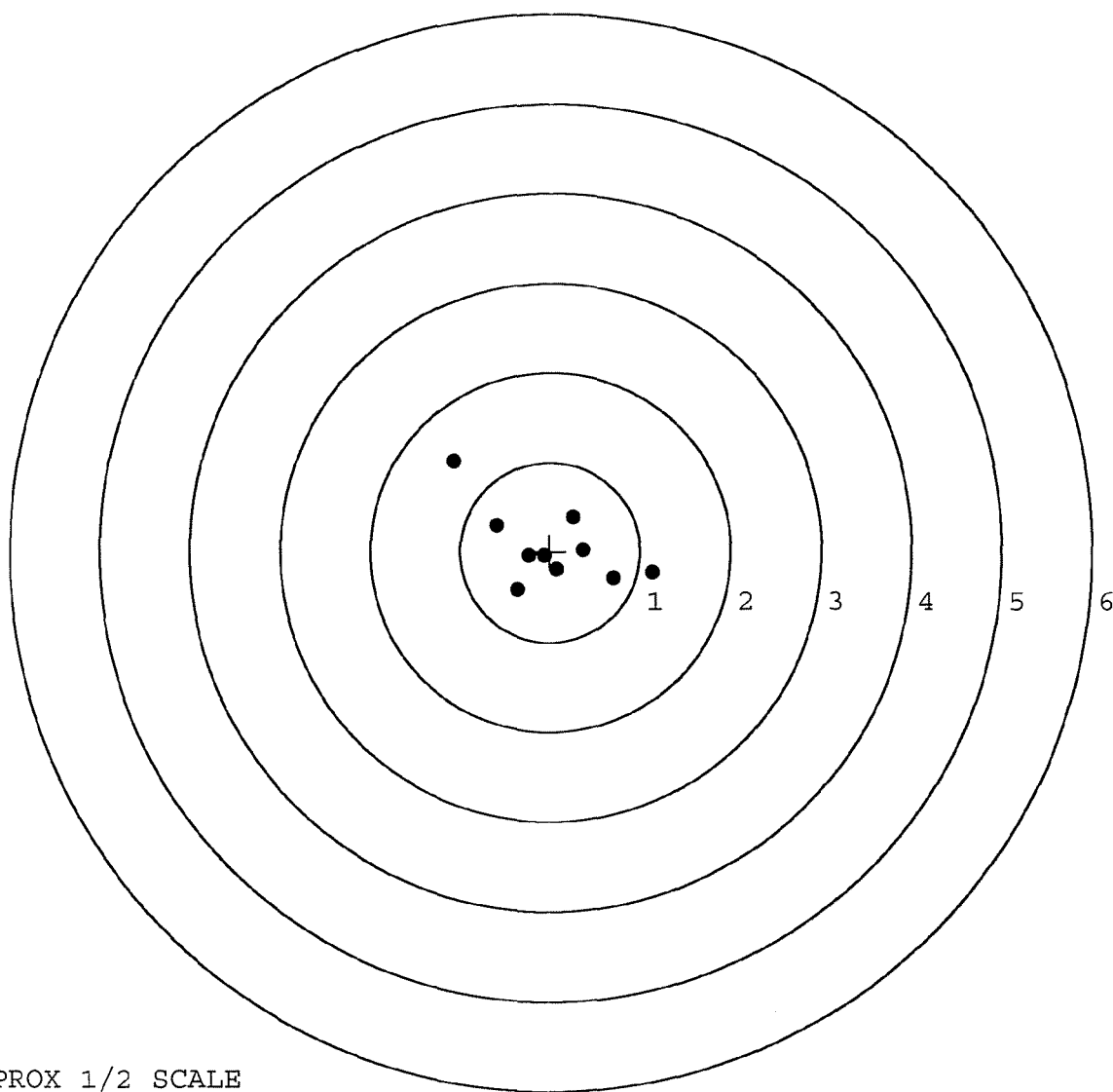
MAX RADIUS: 1.461

MEAN RADIUS: 0.606

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535292. __0

TARGET NUMBER: 5

FILE DATE: 03/29/2006

FILE TIME: 15:25

POINT#	X	Y
1:	-0.604	0.626
2:	-0.618	0.310
3:	-0.285	0.186
4:	0.043	0.477
5:	0.242	0.455
6:	0.573	0.395
7:	0.339	-0.124
8:	0.654	-0.261
9:	-0.290	-0.318
10:	-0.570	-0.203

X CENTROID: -0.052

Y CENTROID: 0.154

POA TO CENTROID: 0.163

HORZ SPREAD: 1.272

VERT SPREAD: 0.944

GROUP SPREAD: 1.539

MIN RADIUS: 0.236

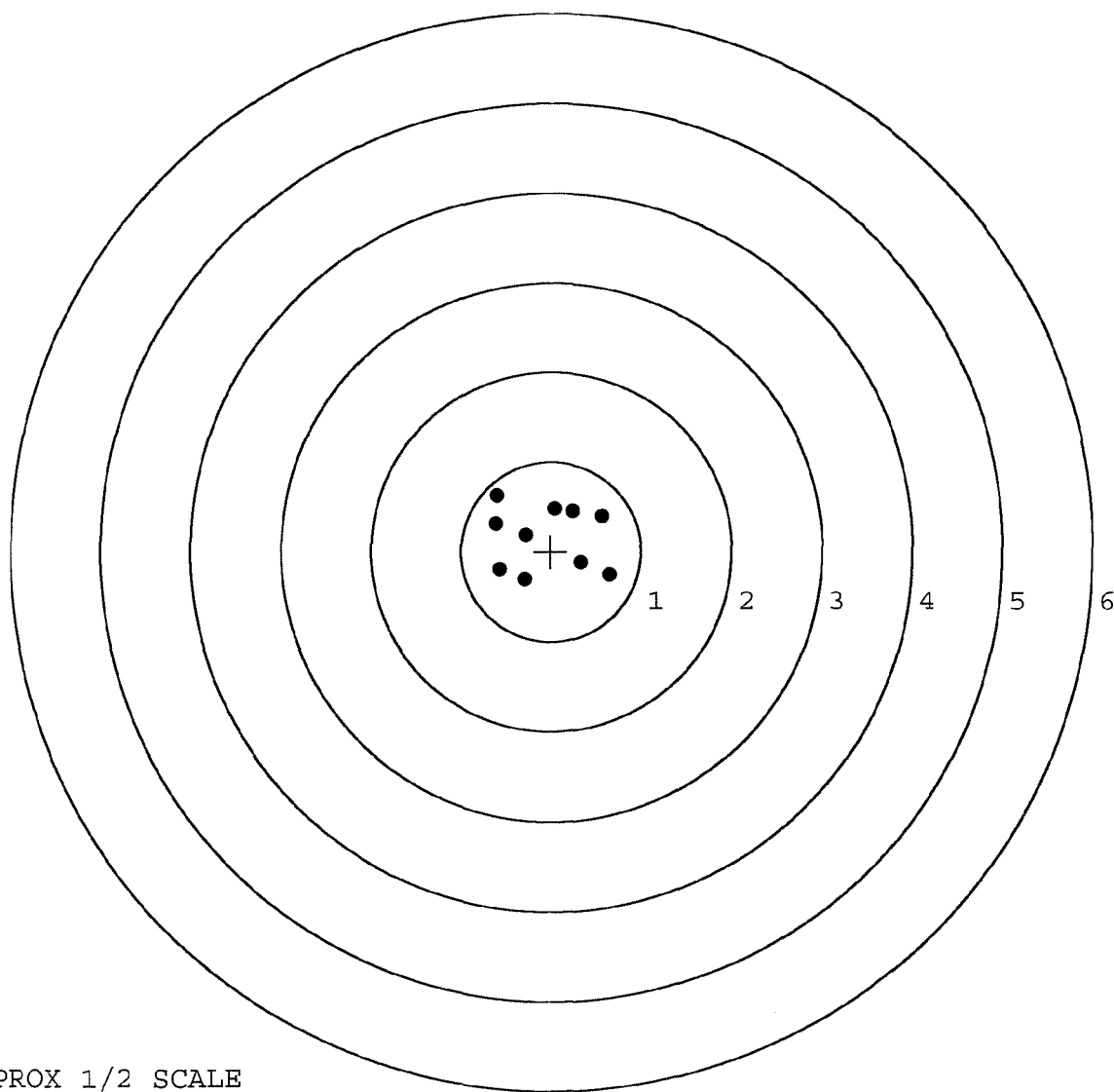
MAX RADIUS: 0.819

MEAN RADIUS: 0.543

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE