

G 653 5315

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

- INSTRUCTION BOOK 3518



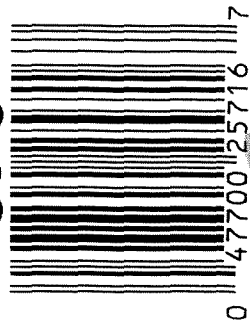
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6535315

UPC



DD FORM

ORDER 25716

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

UPC

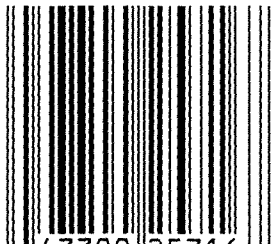


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ORDER 25716

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

UPC



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SERIAL NO.



66535315

SUBJECT TO PROTECTIVE ORDER

M2400090947

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5315

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-27-06	RTZ
440	PROOF		2/27/06	MPD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	2/27/06	MPD
470	DIS-ASSEMBLE ACTION	MAR 01 2006	2-28-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 OPERATOR <u>APD</u>	3-1-06	APD
500	ROLLMARK CALIBER		3-1-06	CW
510	DRILL AND TAP SIGHT HOLES		2-28-06	TRW
520	GOFF BLAST BBL / REC		3-2-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		3/0	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/17/06	MPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/17/06	MPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/17/06	MPD
	D) OIL FIRING PIN ASSEMBLY		4-21-06	A
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		5-10-06	A

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>10.0</u> <u>10.0</u> <u>10.0</u>	5-11-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	5-11-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		5-11-06	L.P.D.
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1022</u> <u>1022</u>	5-11-06	RA
	J) ASSEMBLE STOCK		4-24-06	AC
	K) ASSEMBLE SWIVEL STUDS		5-11-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-21-06	AC
	M) IRON SIGHT ALIGNMENT		4-21-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-21-06	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	5-3-06	L.P.D.
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-3-06	MM
670	FINAL INSPECTION A) HEADSPACE		5-11-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>243</u> <u>241</u> <u>2.60</u> <u>2.44</u>	5-10-06	AC
	C) FUNCTION		5-11-06	L.P.D.
690	PACK		5-3-06	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 4-7-06

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	2.51		2.62	
PULL #2	2.42	2.55		2.58	
PULL #3	2.67	2.61		2.52	
PULL #4	2.53	2.41		2.61	
PULL #5	2.72	2.54		2.57	
TOTAL	12.85	12.62		12.90	
AVERAGE	2.57	2.52		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.16		
PULL #2	3.21	3.05		
PULL #3	3.26	3.19		
PULL #4	2.96	3.09		
PULL #5	3.28	3.23		
TOTAL	15.80	15.72		
AVERAGE	3.16	3.14		

	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	4.17	4.20		4.26
PULL #2	4.17	3.95		4.05
PULL #3	4.20	4.20		4.28
PULL #4	4.18	4.06		4.29
PULL #5	4.05	4.28		4.27
TOTAL	20.77	20.69		21.15
AVERAGE	4.15	4.13		4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535315.___0

FILE DATE AND TIME: 05/03/2006 16:39

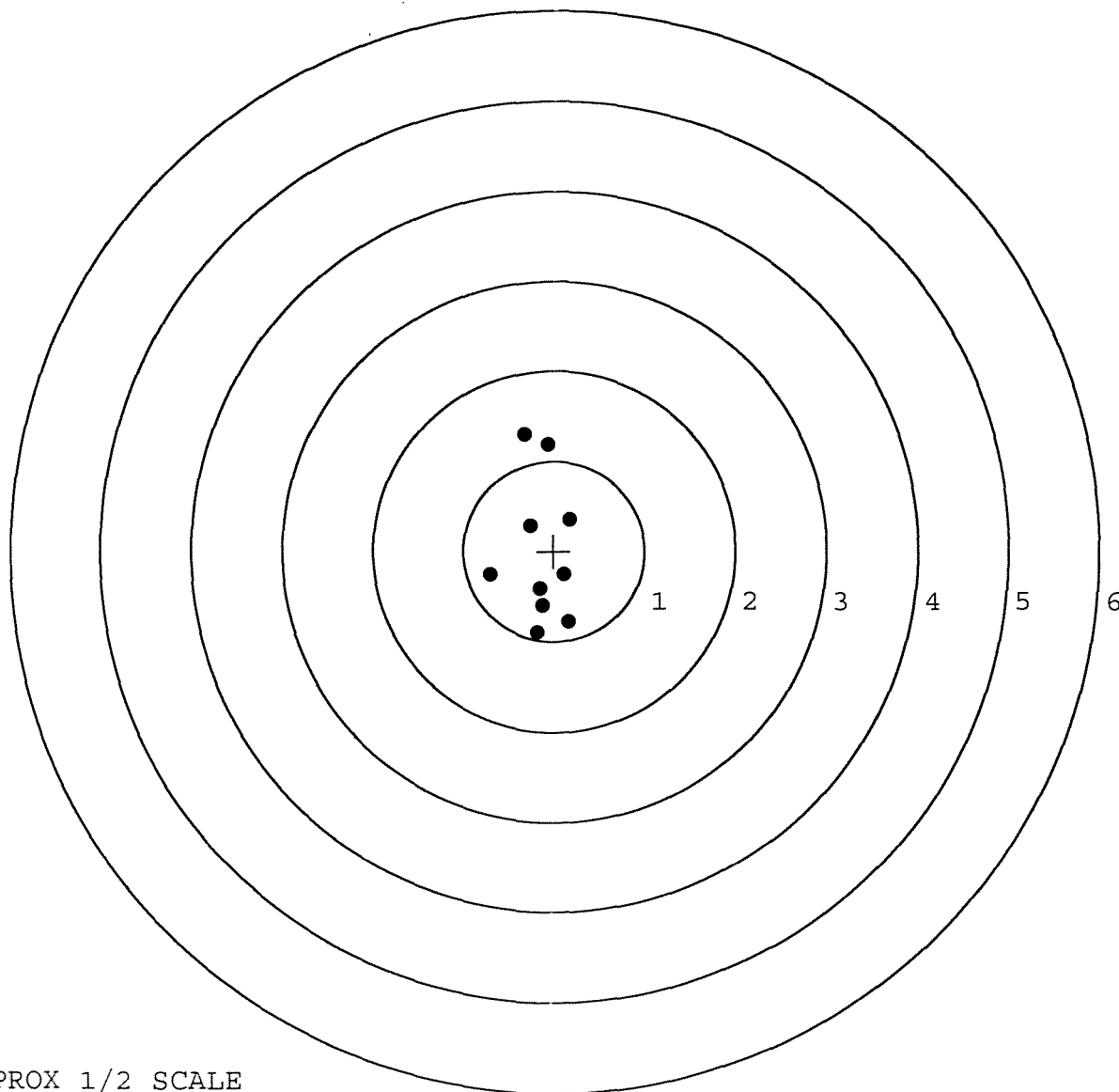
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.005
The Average Y Centroid of the Five Target Set:	0.046
The Average Point of Impact of the Five Target Set:	0.046
The Average Mean Radius of the Five Target Set:	0.658
The Distance from POA to Centroid Target #1:	0.136
The Distance from Centroid Target #2 to Centroid Target #1:	0.249
The Distance from Centroid Target #3 to Centroid Target #1:	0.288
The Distance from Centroid Target #4 to Centroid Target #1:	0.084
The Distance from Centroid Target #5 to Centroid Target #1:	0.197

SERIAL NUMBER: G6535315. __0
TARGET NUMBER: 1
FILE DATE: 05/03/2006
FILE TIME: 16:39

X CENTROID: -0.136
Y CENTROID: -0.014
POA TO CENTROID: 0.136
HORZ SPREAD: 0.877
VERT SPREAD: 2.211
GROUP SPREAD: 2.216
MIN RADIUS: 0.323
MAX RADIUS: 1.328
MEAN RADIUS: 0.704
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.333	1.299
2:	-0.073	1.183
3:	0.177	0.355
4:	-0.265	0.282
5:	-0.700	-0.267
6:	-0.150	-0.421
7:	0.120	-0.262
8:	-0.121	-0.613
9:	-0.182	-0.912
10:	0.171	-0.786

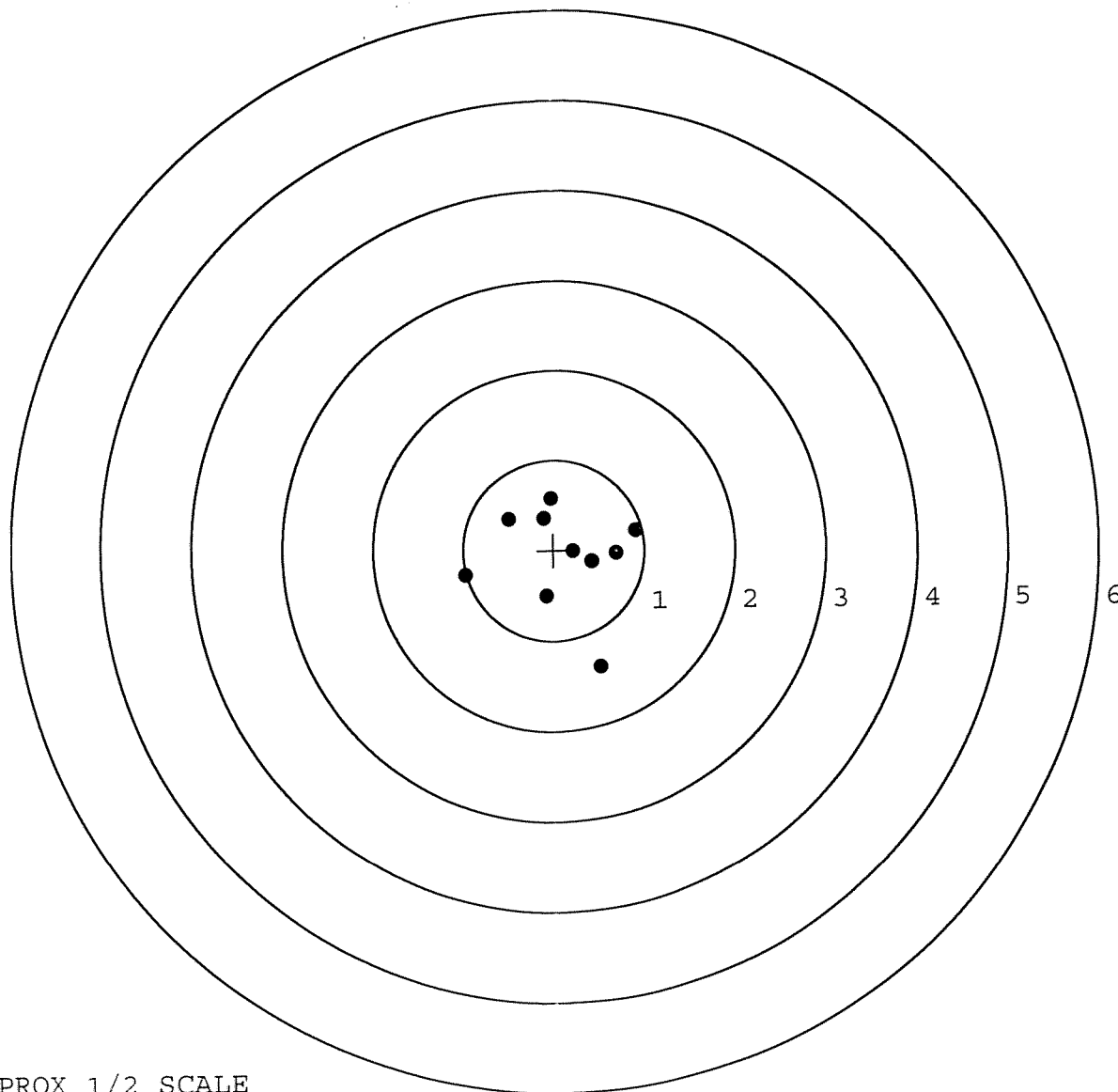


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535315. __0
TARGET NUMBER: 2
FILE DATE: 05/03/2006
FILE TIME: 16:39

X CENTROID: 0.105
Y CENTROID: -0.079
POA TO CENTROID: 0.131
HORZ SPREAD: 1.881
VERT SPREAD: 1.864
GROUP SPREAD: 1.943
MIN RADIUS: 0.128
MAX RADIUS: 1.283
MEAN RADIUS: 0.662
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.978	-0.275
2:	-0.086	-0.513
3:	0.518	-1.293
4:	-0.032	0.571
5:	-0.108	0.351
6:	-0.497	0.341
7:	0.217	-0.018
8:	0.421	-0.129
9:	0.688	-0.038
10:	0.903	0.214

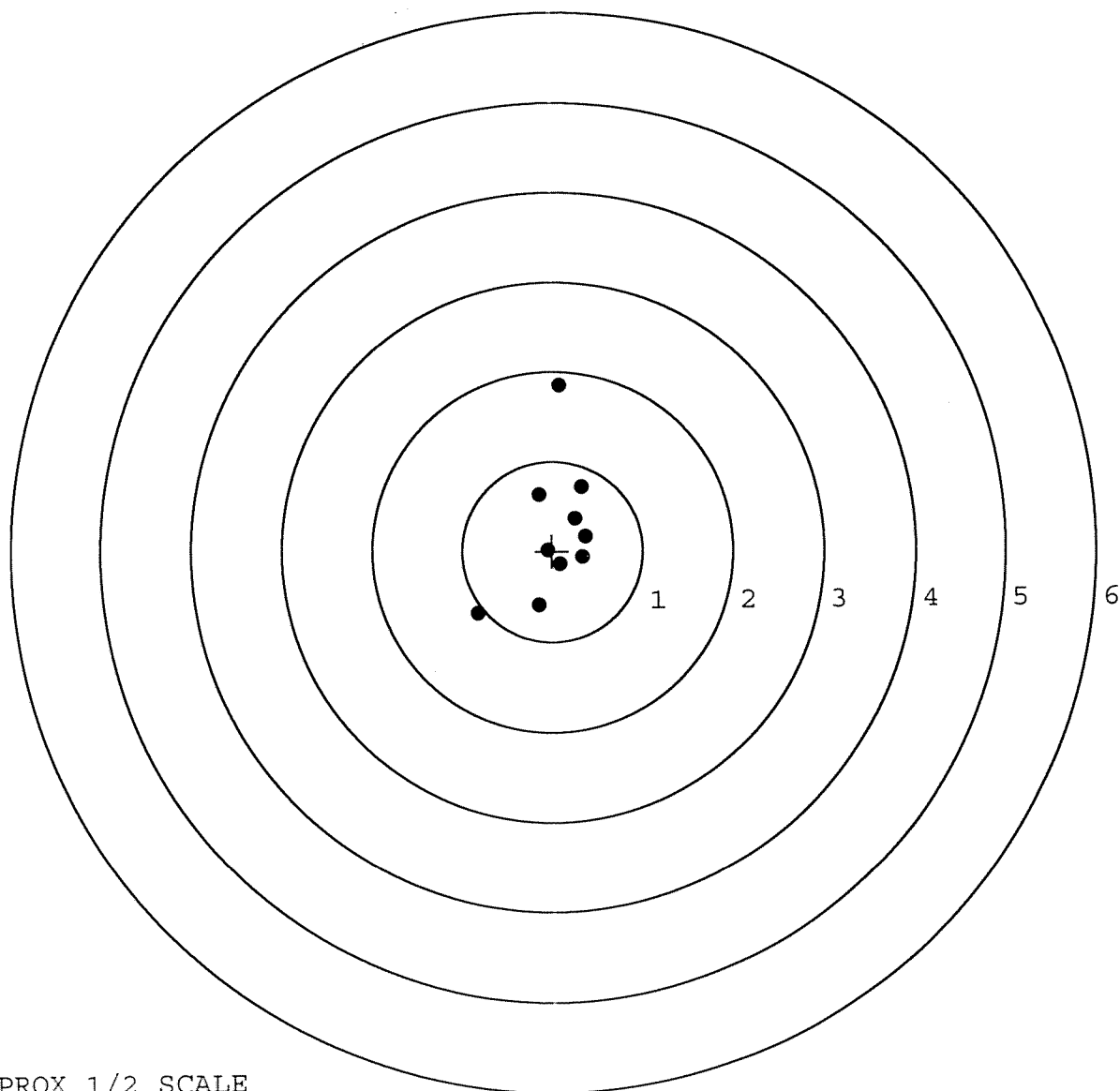


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535315. __0
TARGET NUMBER: 3
FILE DATE: 05/03/2006
FILE TIME: 16:39

X CENTROID: 0.030
Y CENTROID: 0.221
POA TO CENTROID: 0.223
HORZ SPREAD: 1.196
VERT SPREAD: 2.533
GROUP SPREAD: 2.694
MIN RADIUS: 0.225
MAX RADIUS: 1.622
MEAN RADIUS: 0.637
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.143	0.627
2:	0.332	0.714
3:	0.254	0.363
4:	0.369	0.162
5:	0.339	-0.069
6:	-0.053	0.012
7:	0.087	-0.147
8:	-0.147	-0.603
9:	-0.827	-0.691
10:	0.090	1.842

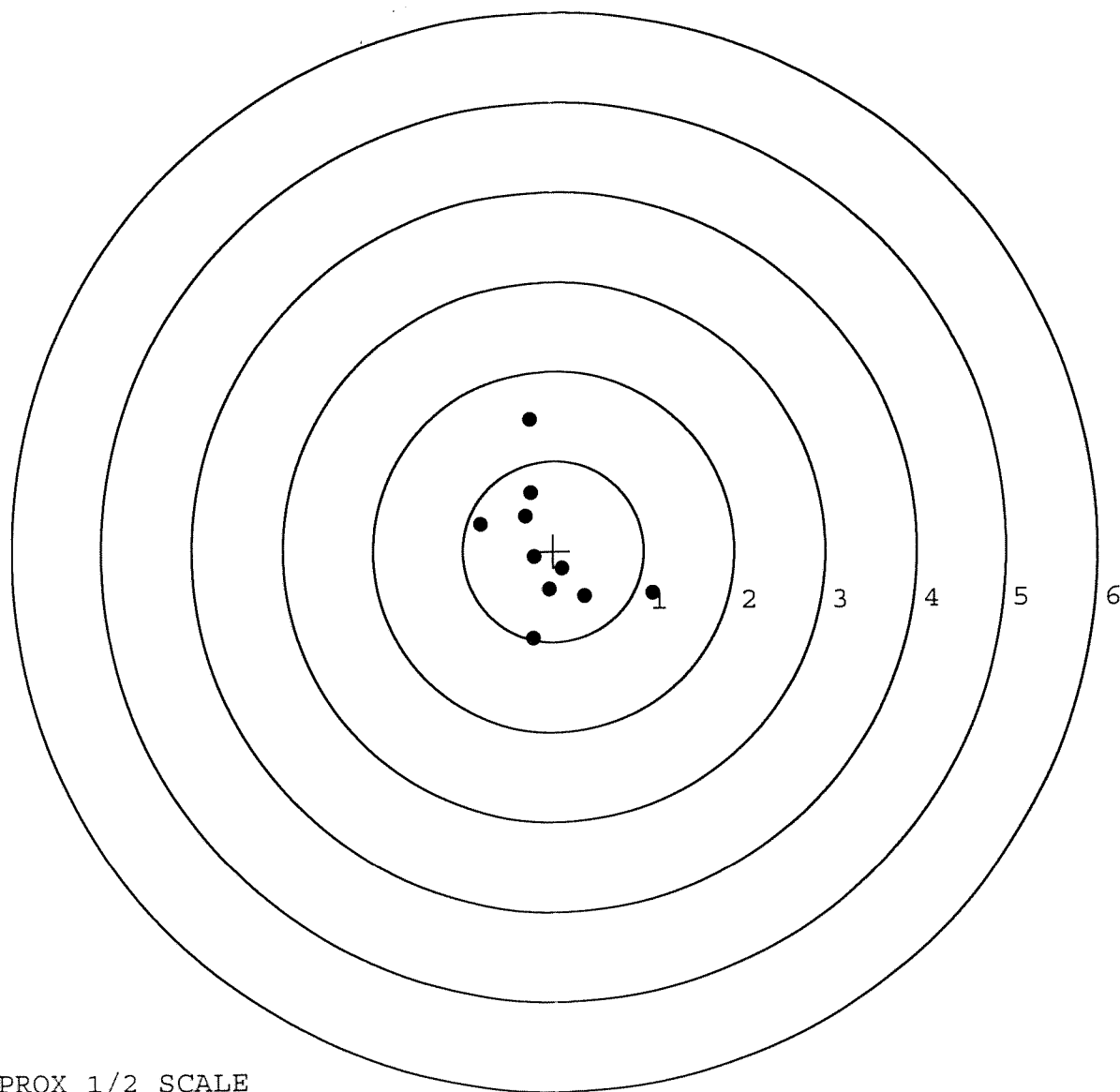


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535315. 0
TARGET NUMBER: 4
FILE DATE: 05/03/2006
FILE TIME: 16:39

X CENTROID: -0.058
Y CENTROID: 0.017
POA TO CENTROID: 0.061
HORZ SPREAD: 1.899
VERT SPREAD: 2.424
GROUP SPREAD: 2.424
MIN RADIUS: 0.177
MAX RADIUS: 1.457
MEAN RADIUS: 0.716
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.259	1.460
2:	-0.253	0.649
3:	-0.310	0.392
4:	-0.804	0.296
5:	-0.227	-0.964
6:	-0.216	-0.062
7:	-0.049	-0.426
8:	0.096	-0.200
9:	0.346	-0.501
10:	1.095	-0.472



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535315. __0

TARGET NUMBER: 5

FILE DATE: 05/03/2006

FILE TIME: 16:39

X CENTROID: 0.035

Y CENTROID: 0.085

POA TO CENTROID: 0.092

HORZ SPREAD: 1.351

VERT SPREAD: 1.450

GROUP SPREAD: 1.647

MIN RADIUS: 0.268

MAX RADIUS: 0.969

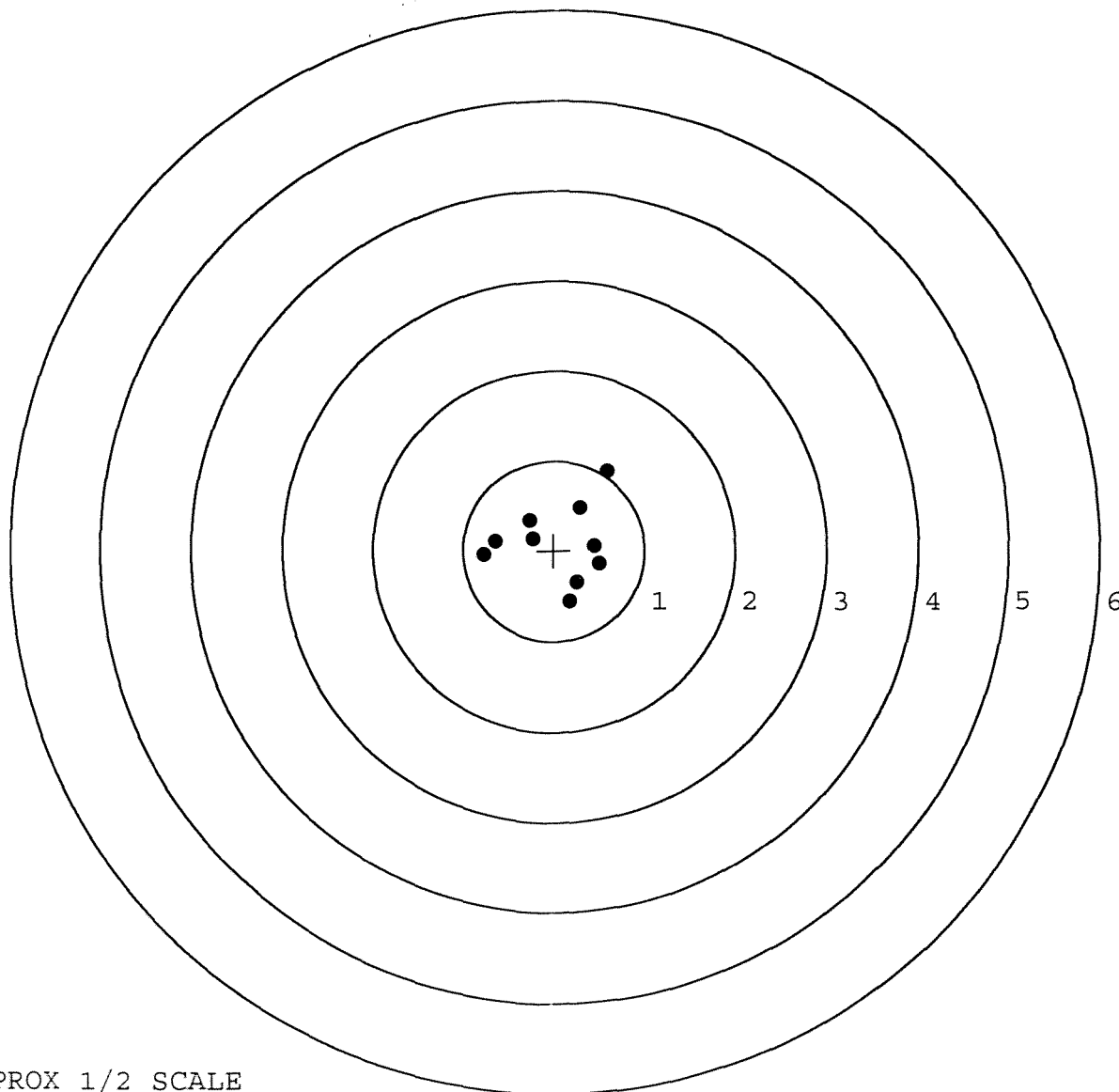
MEAN RADIUS: 0.570

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.291	0.480
2:	0.581	0.885
3:	-0.230	0.127
4:	-0.269	0.338
5:	-0.644	0.095
6:	-0.770	-0.057
7:	0.452	0.050
8:	0.503	-0.148
9:	0.256	-0.358
10:	0.180	-0.565



TARGET APPROX 1/2 SCALE