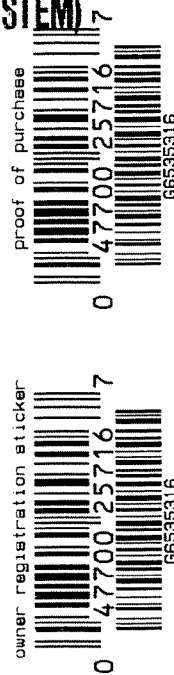


G 653 5316

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

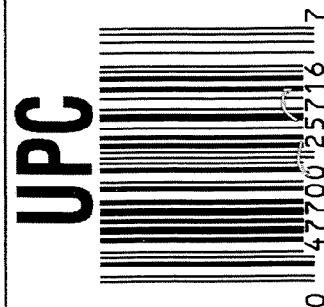
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6535316



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 5316

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-10-06	RTZ
440	PROOF		2-10-06	TRW
460	CHECK HEADSPACE		2-10-06	Ac
470	DIS-ASSEMBLE ACTION		2-10-06	Ac
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 FEB 14 2006 INSPECTED OPERATOR <i>APP</i>	2-14-06	APP
500	ROLLMARK CALIBER		2-14-06	CW
510	DRILL AND TAP SIGHT HOLES		2-13-06	TRW
520	GOFF BLAST BBL / REC		2-14-06	CB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/20/06	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		2/22/06	MPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/22/06	MPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/22/06	MPD
	D) OIL FIRING PIN ASSEMBLY		3-7-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/13/06	MPD

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.2</u> <u>5.5</u> <u>5.8</u>	3/13/06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	3/13/06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/13/06	MJD
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3/13/06	MJD
	J) ASSEMBLE STOCK		3-7-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		3/13/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-7-06	RTZ
	M) IRON SIGHT ALIGNMENT		3-7-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-7-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	3-7-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-7-06	MJM
670	FINAL INSPECTION A) HEADSPACE		3/13/06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.46</u> <u>2.52</u> <u>2.47</u> <u>2.49</u>	3/13/06	RA
	C) FUNCTION		3/13/06	MJD
690	PACK		3-27-06	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 3-6-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.56	2.44		2.52	
PULL #2	2.58	2.60		2.58	
PULL #3	2.57	2.37		2.41	
PULL #4	2.48	2.56		2.44	
PULL #5	2.41	2.37		2.58	
TOTAL	12.60	12.34		12.53	
AVERAGE	2.52	2.46		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.09		
PULL #2	3.25	3.15		
PULL #3	3.14	3.17		
PULL #4	3.19	3.22		
PULL #5	3.15	3.29		
TOTAL	15.87	15.92		
AVERAGE	3.17	3.18		

	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	4.15	3.92		4.04
PULL #2	4.17	4.04		4.10
PULL #3	4.19	4.25		4.01
PULL #4	3.98	4.22		3.97
PULL #5	4.07	4.18		4.03
TOTAL	20.56	20.61		20.15
AVERAGE	4.11	4.12		4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535316.___0

FILE DATE AND TIME: 03/07/2006 15:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.141
The Average Y Centroid of the Five Target Set:	0.049
The Average Point of Impact of the Five Target Set:	0.150
The Average Mean Radius of the Five Target Set:	0.701
The Distance from POA to Centroid Target #1:	0.190
The Distance from Centroid Target #2 to Centroid Target #1:	0.052
The Distance from Centroid Target #3 to Centroid Target #1:	0.060
The Distance from Centroid Target #4 to Centroid Target #1:	0.082
The Distance from Centroid Target #5 to Centroid Target #1:	0.361

SERIAL NUMBER: G6535316. __0

TARGET NUMBER: 1

FILE DATE: 03/07/2006

FILE TIME: 15:25

POINT#	X	Y
1:	-0.360	-0.017
2:	-0.737	-0.477
3:	-0.607	-0.930
4:	-0.182	-0.743
5:	0.400	0.155
6:	0.778	0.403
7:	0.891	0.047
8:	0.392	1.268
9:	-0.858	0.769
10:	-1.222	0.684

X CENTROID: -0.150

Y CENTROID: 0.116

POA TO CENTROID: 0.190

HORZ SPREAD: 2.113

VERT SPREAD: 2.198

GROUP SPREAD: 2.414

MIN RADIUS: 0.248

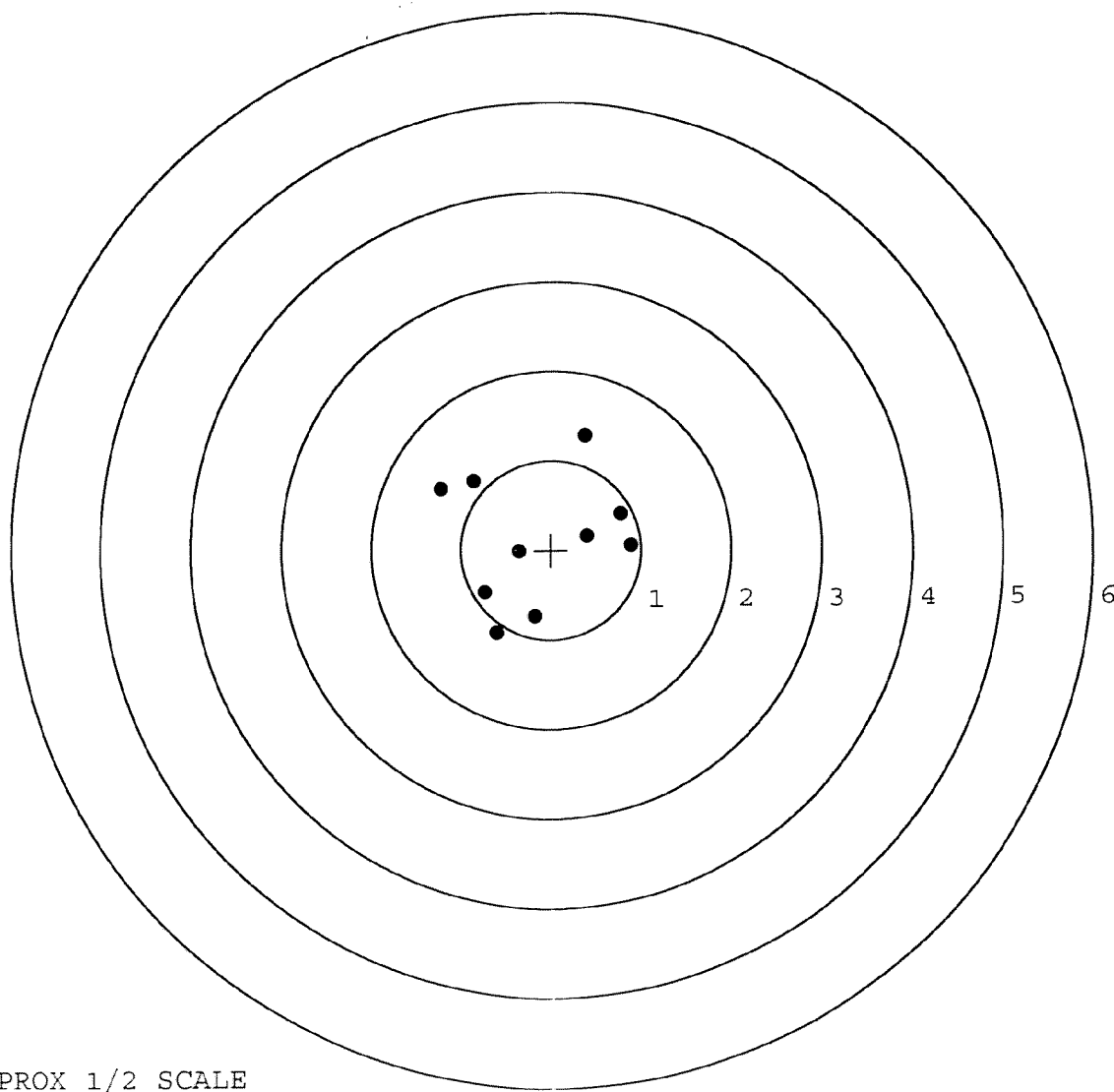
MAX RADIUS: 1.273

MEAN RADIUS: 0.910

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

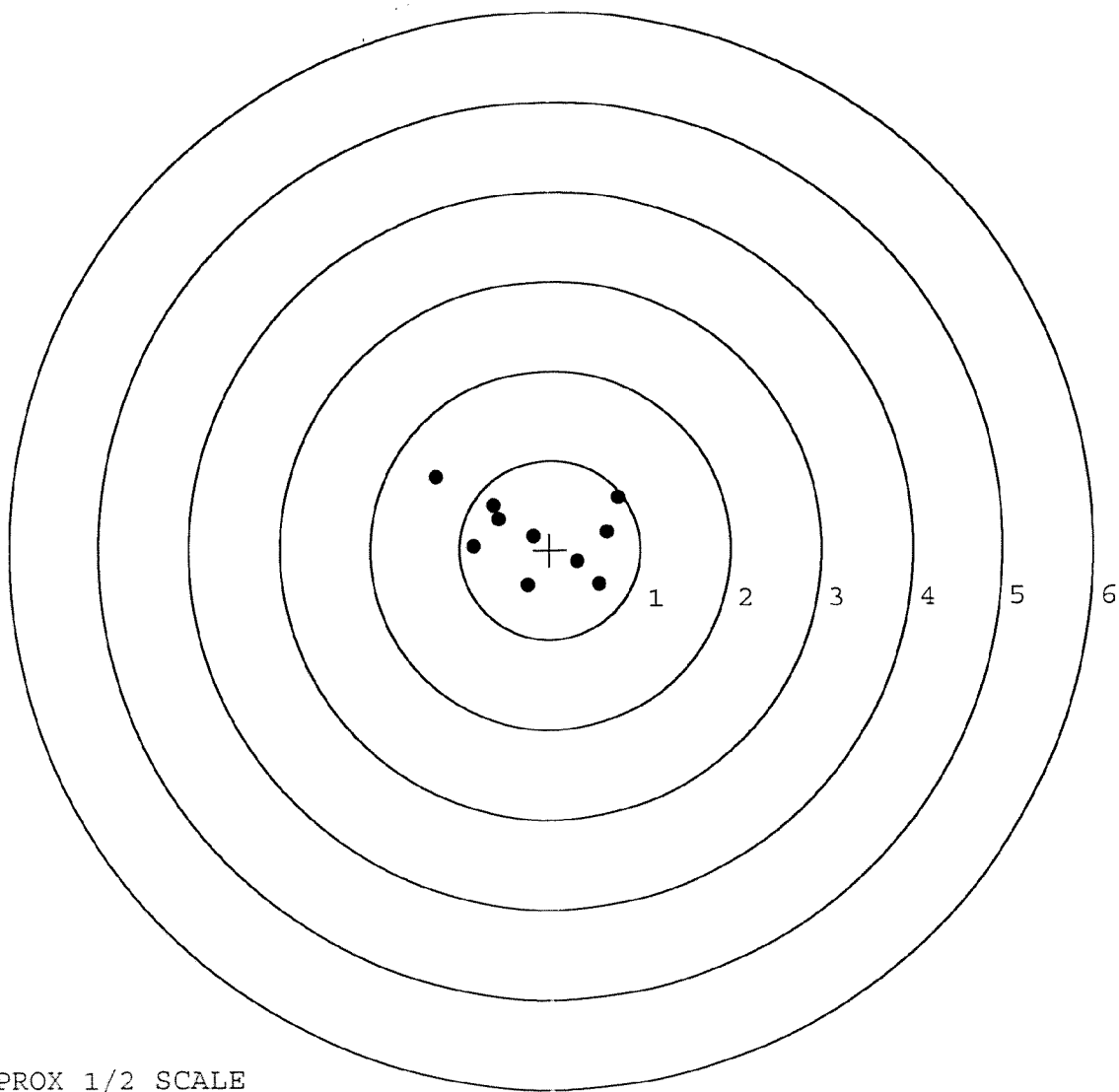


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535316. __0
TARGET NUMBER: 2
FILE DATE: 03/07/2006
FILE TIME: 15:25

X CENTROID: -0.149
Y CENTROID: 0.168
POA TO CENTROID: 0.224
HORZ SPREAD: 2.020
VERT SPREAD: 1.210
GROUP SPREAD: 2.172
MIN RADIUS: 0.035
MAX RADIUS: 1.286
MEAN RADIUS: 0.684
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.758	0.578
2:	0.627	0.189
3:	0.544	-0.394
4:	0.304	-0.134
5:	-0.247	-0.398
6:	-0.181	0.155
7:	-0.565	0.343
8:	-0.622	0.496
9:	-0.842	0.035
10:	-1.262	0.812



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535316. __0

TARGET NUMBER: 3

FILE DATE: 03/07/2006

FILE TIME: 15:25

X CENTROID: -0.110

Y CENTROID: 0.160

POA TO CENTROID: 0.194

HORZ SPREAD: 1.884

VERT SPREAD: 1.205

GROUP SPREAD: 2.069

MIN RADIUS: 0.235

MAX RADIUS: 1.092

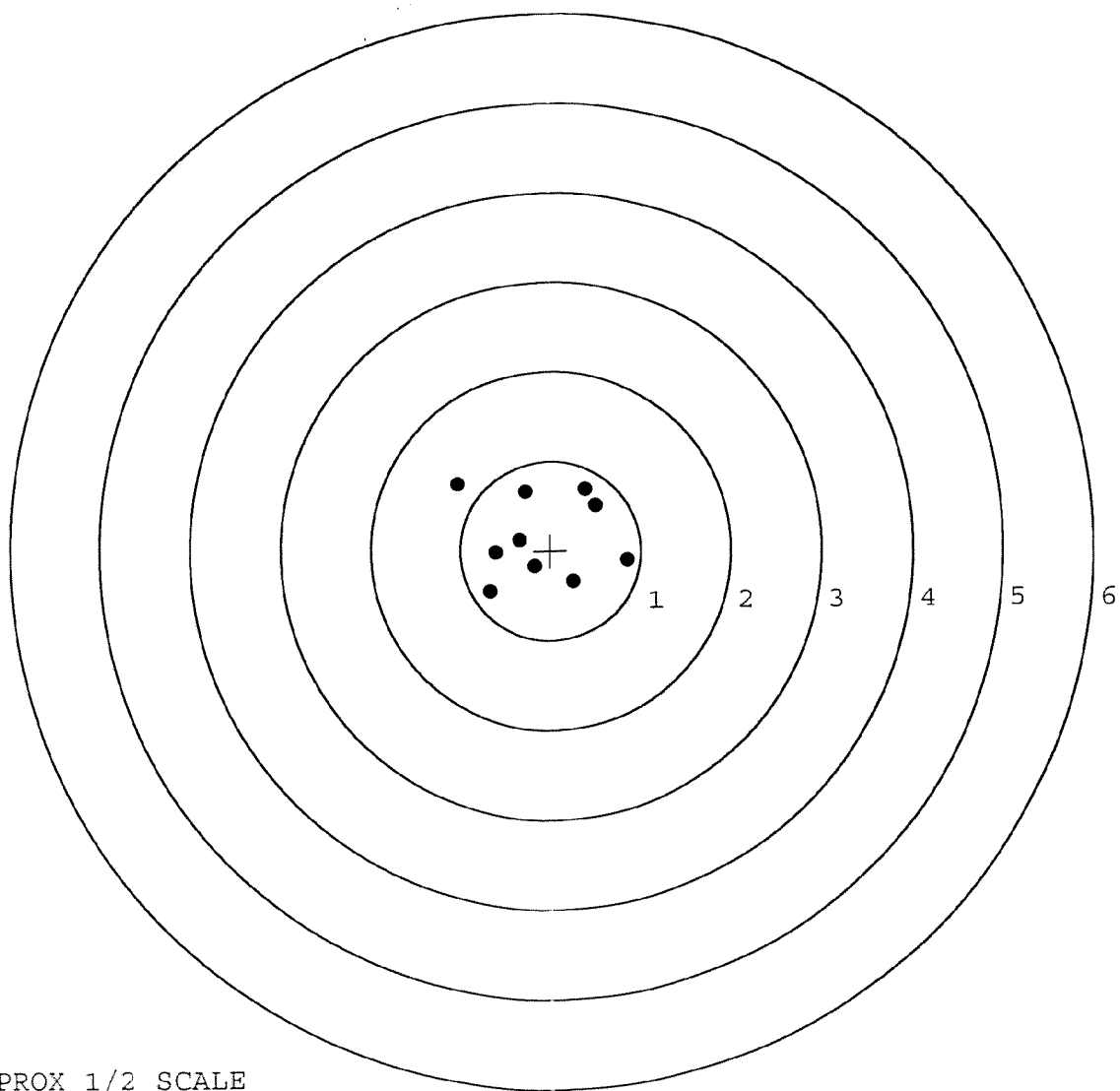
MEAN RADIUS: 0.662

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.031	0.746
2:	-0.277	0.666
3:	0.390	0.684
4:	0.506	0.500
5:	0.853	-0.109
6:	0.258	-0.349
7:	-0.341	0.121
8:	-0.179	-0.179
9:	-0.607	-0.022
10:	-0.669	-0.459

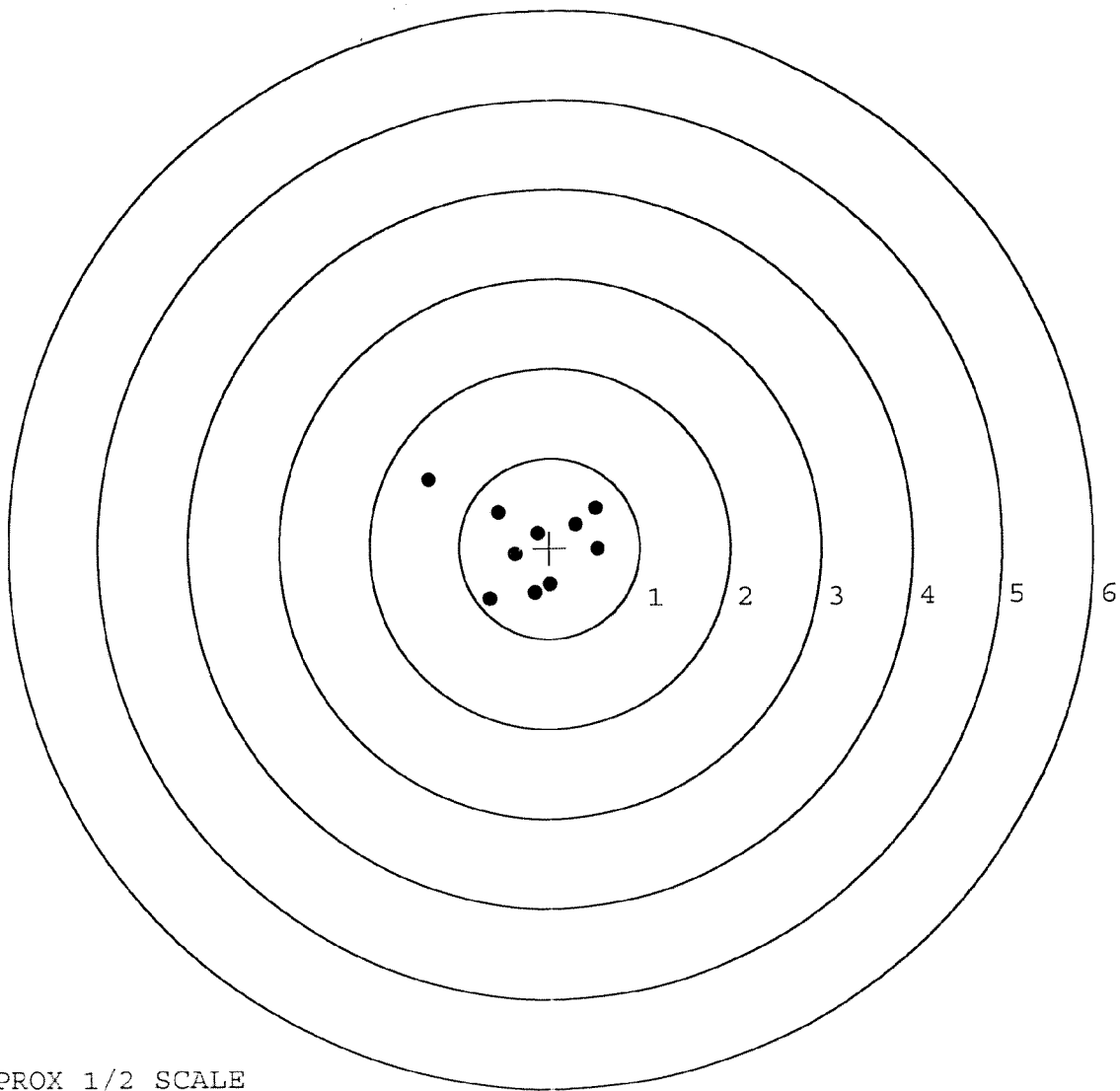


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535316. __0
TARGET NUMBER: 4
FILE DATE: 03/07/2006
FILE TIME: 15:25

X CENTROID: -0.192
Y CENTROID: 0.045
POA TO CENTROID: 0.197
HORZ SPREAD: 1.864
VERT SPREAD: 1.328
GROUP SPREAD: 2.023
MIN RADIUS: 0.132
MAX RADIUS: 1.349
MEAN RADIUS: 0.607
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.335	0.762
2:	-0.660	-0.566
3:	-0.563	0.397
4:	-0.135	0.164
5:	-0.386	-0.072
6:	-0.170	-0.495
7:	-0.003	-0.406
8:	0.529	-0.025
9:	0.290	0.257
10:	0.511	0.435

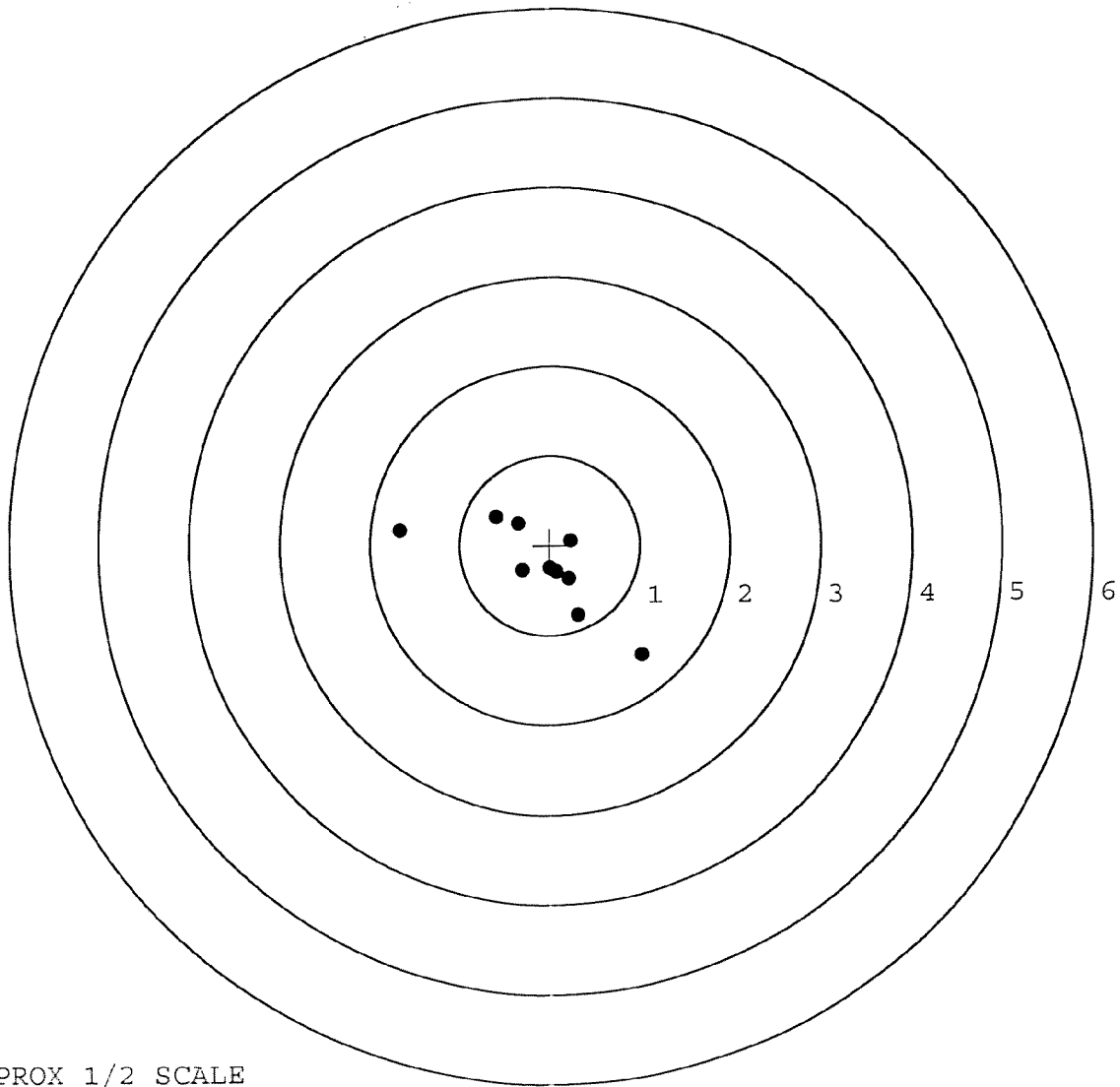


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535316.____0
TARGET NUMBER: 5
FILE DATE: 03/07/2006
FILE TIME: 15:25

X CENTROID: -0.105
Y CENTROID: -0.242
POA TO CENTROID: 0.264
HORZ SPREAD: 2.689
VERT SPREAD: 1.549
GROUP SPREAD: 3.029
MIN RADIUS: 0.111
MAX RADIUS: 1.619
MEAN RADIUS: 0.640
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.671	0.169
2:	-0.598	0.323
3:	-0.347	0.253
4:	0.234	0.052
5:	0.214	-0.374
6:	0.004	-0.260
7:	-0.302	-0.277
8:	0.319	-0.786
9:	1.018	-1.226
10:	0.076	-0.298



TARGET APPROX 1/2 SCALE