

G 653 5333

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

- INSTRUCTION BOOK 3518



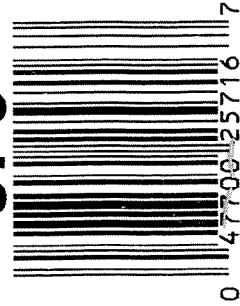
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6535333

UPC

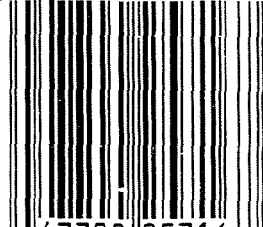


DD FORM

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

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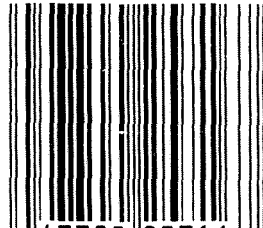


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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



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SERIAL NO.



66535333

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66535333

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		5-4-06	RTZ
440	PROOF		5-4-06	J.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	5-4-06	J.P.D.
470	DIS-ASSEMBLE ACTION		5-5-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	CP # 480 MAY 12 2006 OPERATOR JPD	5-9-06	APD
500	ROLLMARK CALIBER		5-8-06	CW
510	DRILL AND TAP SIGHT HOLES		5-8-06	TRW
520	GOFF BLAST BBL / REC		5-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		5/12/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-24-06	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-24-06	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-24-06	MTM
	D) OIL FIRING PIN ASSEMBLY		5-31-06	AC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		6-6-06	MTM
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.2</u> <u>5.5</u>	6-5-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>3.0</u>	6-5-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		6-6-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>1021</u> <u>1023</u> <u>1022</u>	6-5-06	RA
	J) ASSEMBLE STOCK		5-31-06	AC
	K) ASSEMBLE SWIVEL STUDS		6-6-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-31-06	AC
	M) IRON SIGHT ALIGNMENT		5-31-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-31-06	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	6-1-06	MTM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		6-1-06	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		6-6-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.85</u> <u>2.54</u> <u>2.93</u> <u>2.62</u>	6-2-06	AC
	C) FUNCTION		6-6-06	MTM
690	PACK		11/14/06	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 4-5-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.61	2.44		2.47	
PULL #2	2.60	2.45		2.41	
PULL #3	2.60	2.48		2.40	
PULL #4	2.59	2.45		2.50	
PULL #5	2.56	2.44		2.51	
TOTAL	12.96	12.26		12.29	
AVERAGE	2.59	2.45		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.06		
PULL #2	3.17	3.05		
PULL #3	3.15	3.03		
PULL #4	3.01	3.05		
PULL #5	3.17	3.04		
TOTAL	15.63	15.23		
AVERAGE	3.12	3.04		

	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	4.01	4.24		4.15
PULL #2	4.10	4.20		4.12
PULL #3	4.13	4.01		4.14
PULL #4	4.13	4.18		4.09
PULL #5	4.17	4.20		4.02
TOTAL	20.54	20.83		20.52
AVERAGE	4.10	4.16		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535333.__0

FILE DATE AND TIME: 06/01/2006 16:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.052
The Average Y Centroid of the Five Target Set:	-0.049
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.581
The Distance from POA to Centroid Target #1:	0.021
The Distance from Centroid Target #2 to Centroid Target #1:	0.106
The Distance from Centroid Target #3 to Centroid Target #1:	0.349
The Distance from Centroid Target #4 to Centroid Target #1:	0.104
The Distance from Centroid Target #5 to Centroid Target #1:	0.159

SERIAL NUMBER: G6535333. __0

TARGET NUMBER: 1

FILE DATE: 06/01/2006

FILE TIME: 16:23

POINT#	X	Y
1:	-0.495	0.784
2:	-0.127	0.633
3:	-0.102	1.025
4:	-0.562	0.298
5:	-0.142	-0.134
6:	0.284	-0.569
7:	0.143	-0.491
8:	-0.043	-0.997
9:	1.195	-0.719
10:	-0.028	0.341

X CENTROID: 0.012

Y CENTROID: 0.017

POA TO CENTROID: 0.021

HORZ SPREAD: 1.757

VERT SPREAD: 2.022

GROUP SPREAD: 2.262

MIN RADIUS: 0.216

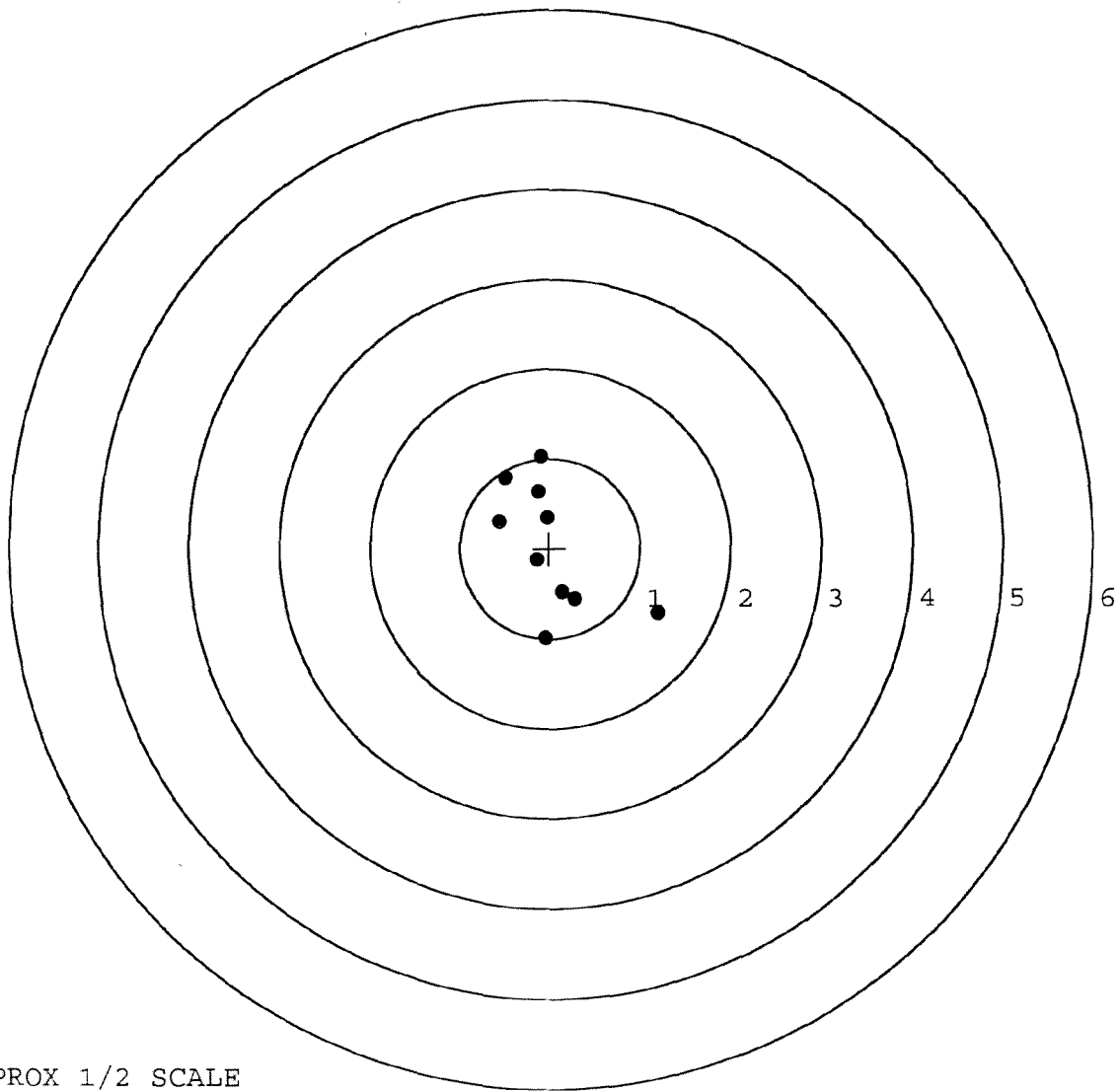
MAX RADIUS: 1.393

MEAN RADIUS: 0.733

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

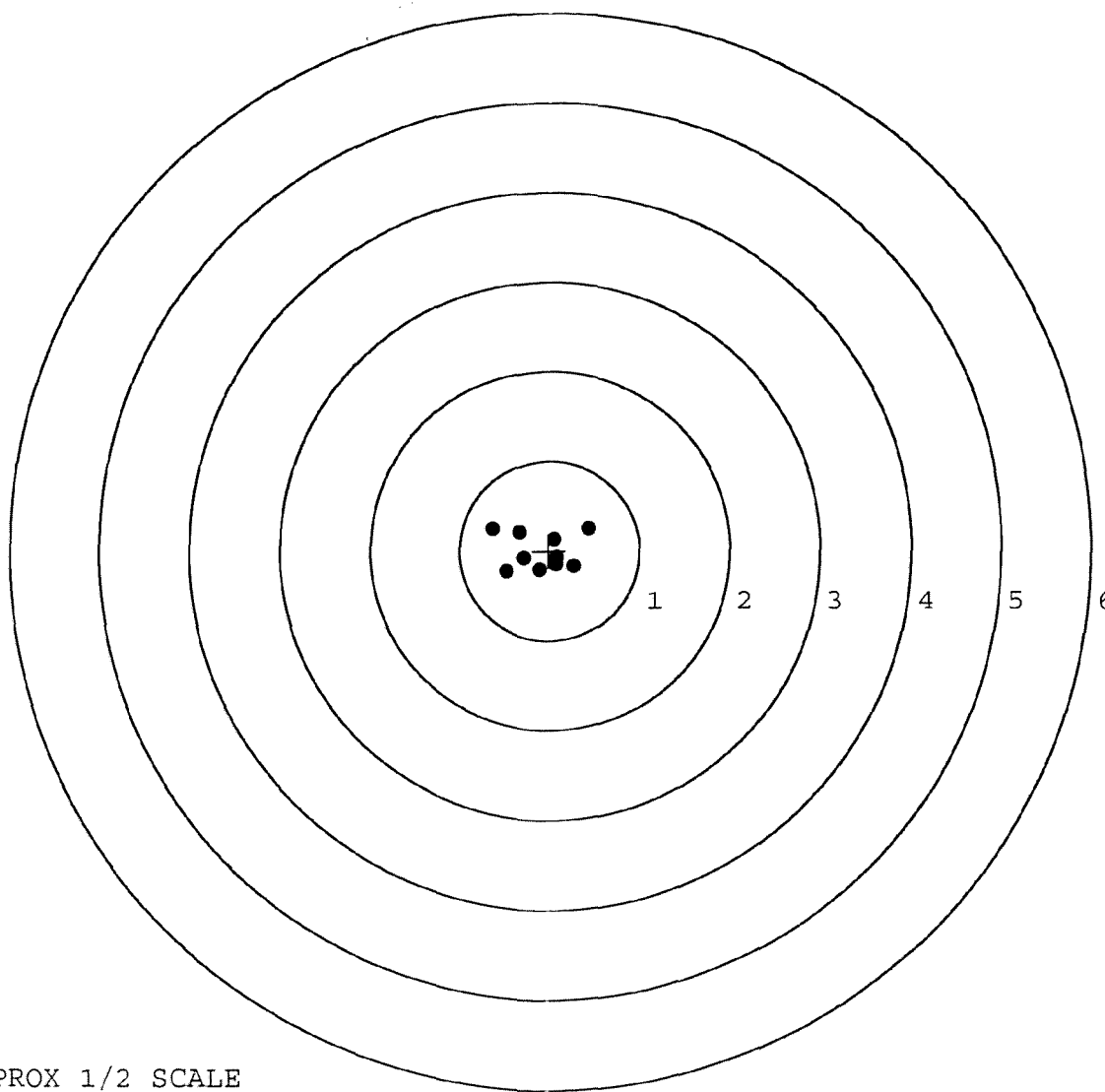


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535333. __0
TARGET NUMBER: 2
FILE DATE: 06/01/2006
FILE TIME: 16:23

POINT#	X	Y
1:	-0.634	0.241
2:	-0.336	0.209
3:	0.063	0.131
4:	0.434	0.249
5:	0.280	-0.180
6:	0.081	-0.160
7:	-0.113	-0.219
8:	-0.475	-0.235
9:	-0.284	-0.081
10:	0.089	-0.079

X CENTROID: -0.090
Y CENTROID: -0.012
POA TO CENTROID: 0.090
HORZ SPREAD: 1.068
VERT SPREAD: 0.484
GROUP SPREAD: 1.068
MIN RADIUS: 0.191
MAX RADIUS: 0.601
MEAN RADIUS: 0.341
IN 1 IN DIAMETER: 8
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535333. __0

TARGET NUMBER: 3

FILE DATE: 06/01/2006

FILE TIME: 16:23

POINT#	X	Y
1:	0.139	0.480
2:	0.328	-0.112
3:	0.243	-0.694
4:	-0.540	-0.298
5:	-0.300	-0.106
6:	-0.660	-0.074
7:	-0.365	0.156
8:	-0.625	0.294
9:	-1.109	-0.145
10:	-0.418	0.000

X CENTROID: -0.331

Y CENTROID: -0.050

POA TO CENTROID: 0.334

HORZ SPREAD: 1.437

VERT SPREAD: 1.174

GROUP SPREAD: 1.459

MIN RADIUS: 0.064

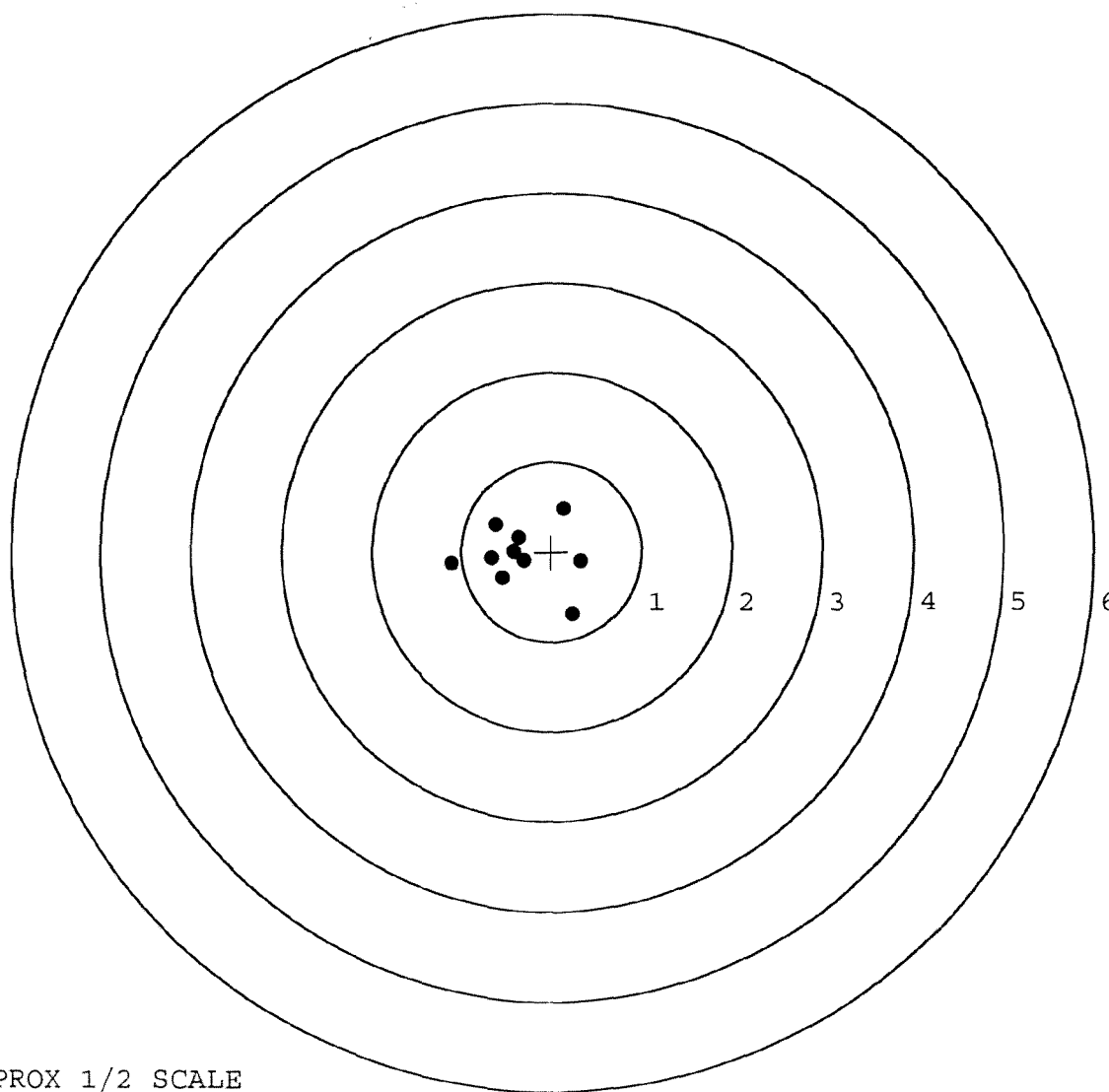
MAX RADIUS: 0.863

MEAN RADIUS: 0.450

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

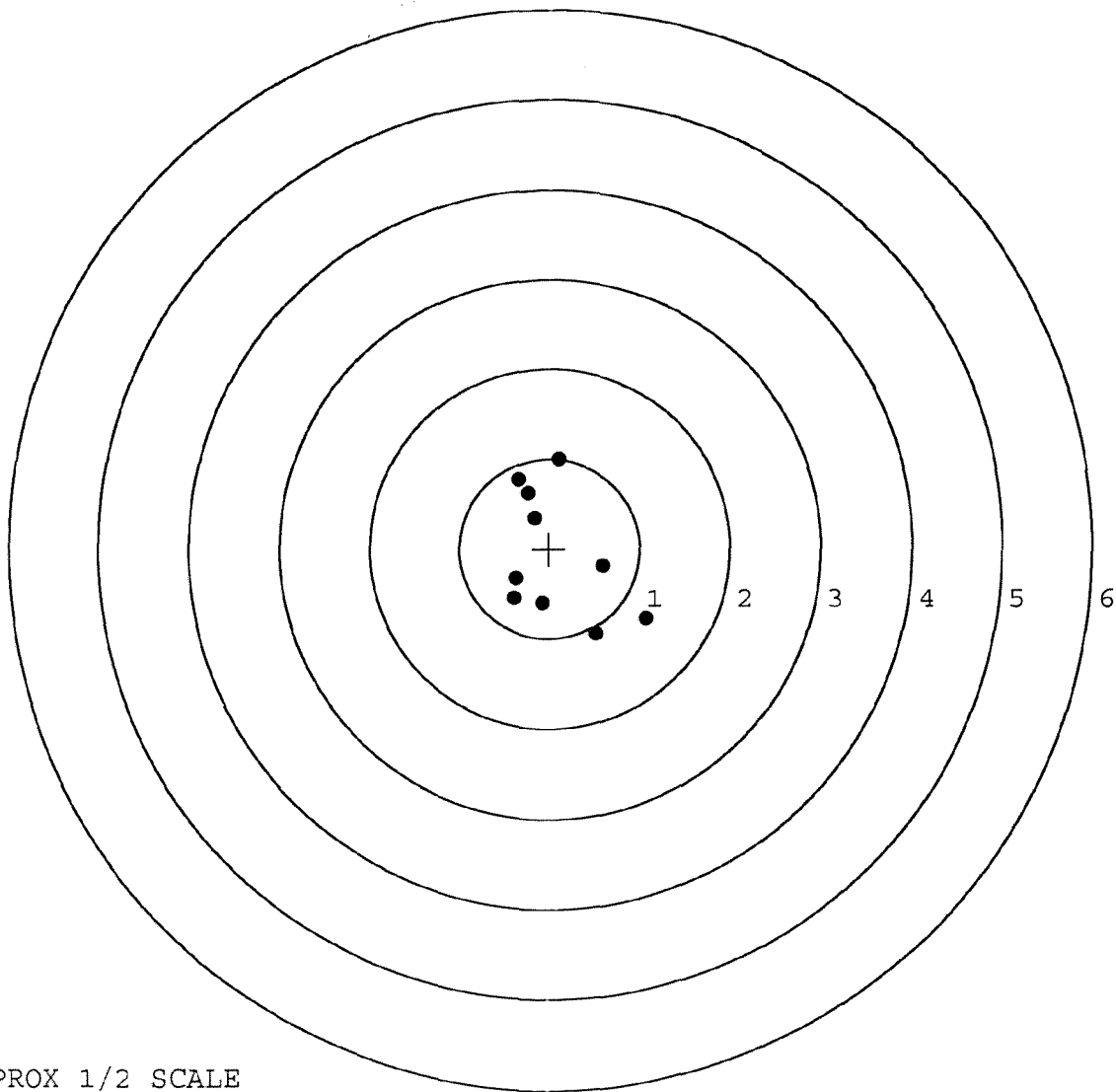


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535333. __0
TARGET NUMBER: 4
FILE DATE: 06/01/2006
FILE TIME: 16:23

POINT#	X	Y
1:	-0.341	0.779
2:	-0.237	0.623
3:	-0.162	0.343
4:	0.108	0.997
5:	-0.372	-0.337
6:	-0.388	-0.559
7:	-0.078	-0.613
8:	0.520	-0.953
9:	1.067	-0.777
10:	0.597	-0.187

X CENTROID: 0.071
Y CENTROID: -0.068
POA TO CENTROID: 0.099
HORZ SPREAD: 1.455
VERT SPREAD: 1.950
GROUP SPREAD: 2.098
MIN RADIUS: 0.473
MAX RADIUS: 1.222
MEAN RADIUS: 0.775
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

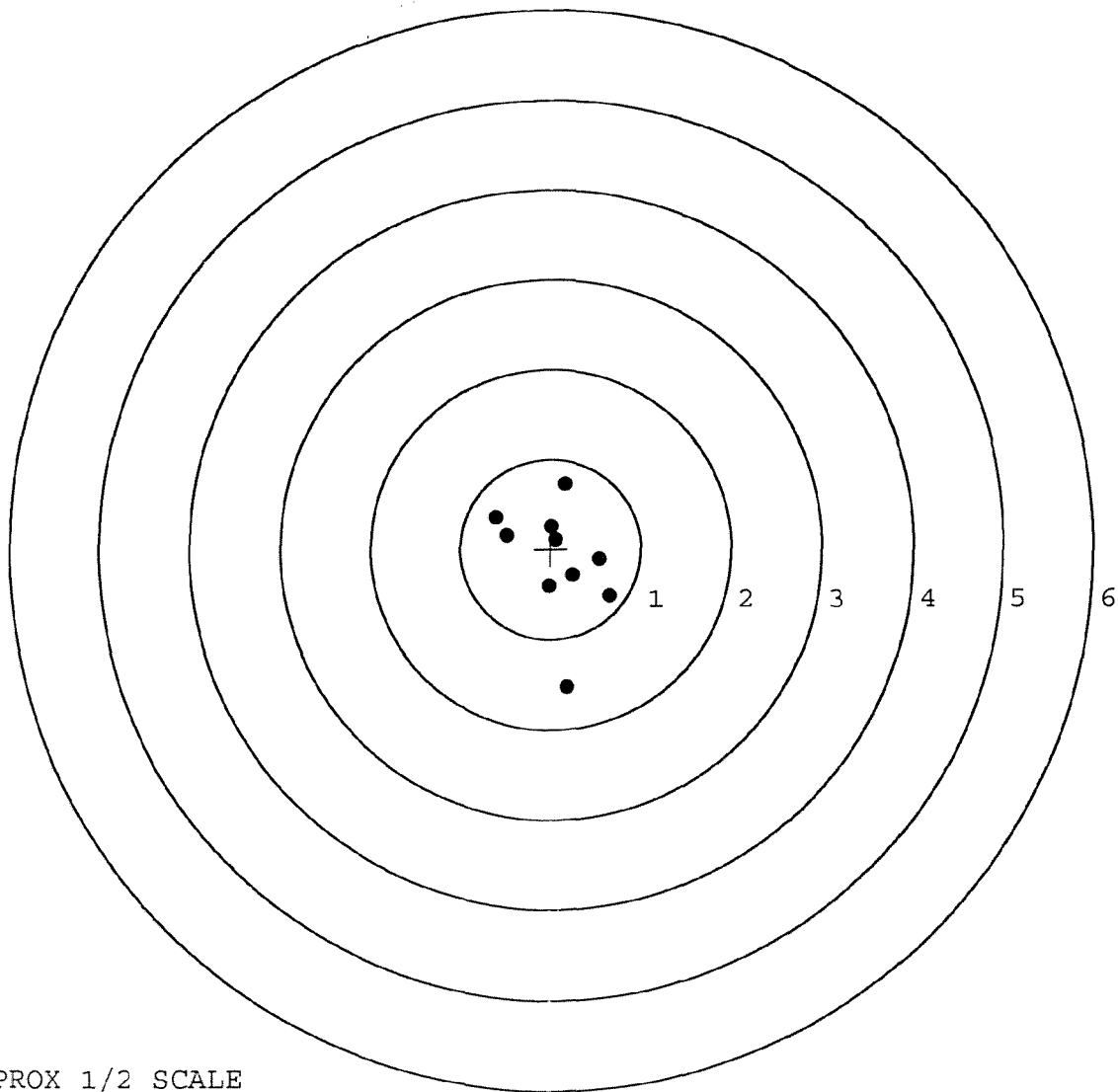


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535333. __0
TARGET NUMBER: 5
FILE DATE: 06/01/2006
FILE TIME: 16:23

POINT#	X	Y
1:	-0.609	0.351
2:	-0.492	0.153
3:	0.011	0.252
4:	0.161	0.726
5:	0.543	-0.114
6:	-0.014	-0.414
7:	0.658	-0.524
8:	0.187	-1.527
9:	0.248	-0.296
10:	0.057	0.103

X CENTROID: 0.075
Y CENTROID: -0.129
POA TO CENTROID: 0.149
HORZ SPREAD: 1.267
VERT SPREAD: 2.253
GROUP SPREAD: 2.253
MIN RADIUS: 0.233
MAX RADIUS: 1.402
MEAN RADIUS: 0.606
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE