

6653 5350

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

UPC



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UPC



SERIAL NO.



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

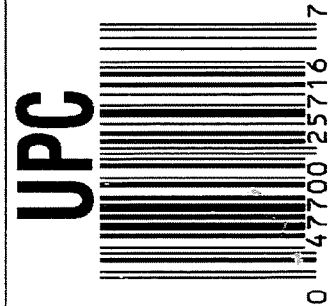
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6535350



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C653 53 50

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	mgg
460	CHECK HEADSPACE	FEB 07 2006	2/2/06	mgg
470	DIS-ASSEMBLE ACTION		2-3-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 OPERATOR <u>CAD</u>	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	SW
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/14	TRB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		2/27/06	mgg
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/27/06	mgg
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/27/06	mgg
	D) OIL FIRING PIN ASSEMBLY		3-1-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4-10-06	H.T.D.

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.0</u> <u>8.0</u> <u>8.0</u>	4-4-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	4-4-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0225</u> <u>.022</u> <u>.0245</u>	4-4-06	TRW
	J) ASSEMBLE STOCK		3-1-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		4-10-06	X.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-1-06	RTZ
	M) IRON SIGHT ALIGNMENT		3-1-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-1-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-3-06	TRW
	MALFUNCTION Bolt + pulls out hard	CORRECTION OK	3-3-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
660	INSPECT FOR LIVE AMMO		3/3/06	SH
670	FINAL INSPECTION A) HEADSPACE		4-10-06	X.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.63</u> <u>2.53</u> <u>2.49</u> <u>2.56</u>	3-3-06	TRW
	C) FUNCTION		4-10-06	X.P.D.
690	PACK		4-1-06	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 2-28-06

TESTER R.P

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.54		2.42	
PULL #2	2.47	2.57		2.48	
PULL #3	2.50	2.44		2.39	
PULL #4	2.56	2.42		2.42	
PULL #5	2.51	2.43		2.53	
TOTAL	12.54	12.40		12.24	
AVERAGE	2.50	2.48		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.04		
PULL #2	3.13	2.96		
PULL #3	3.10	3.00		
PULL #4	2.99	2.99		
PULL #5	3.06	3.05		
TOTAL	15.35	15.04		
AVERAGE	3.07	3.00		

	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	4.23	4.12		4.19
PULL #2	4.19	4.12		4.06
PULL #3	4.23	4.07		4.14
PULL #4	4.24	4.08		4.17
PULL #5	4.23	4.09		4.01
TOTAL	21.12	20.48		20.57
AVERAGE	4.22	4.09		4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535350.__0
FILE DATE AND TIME: 03/03/2006 07:53

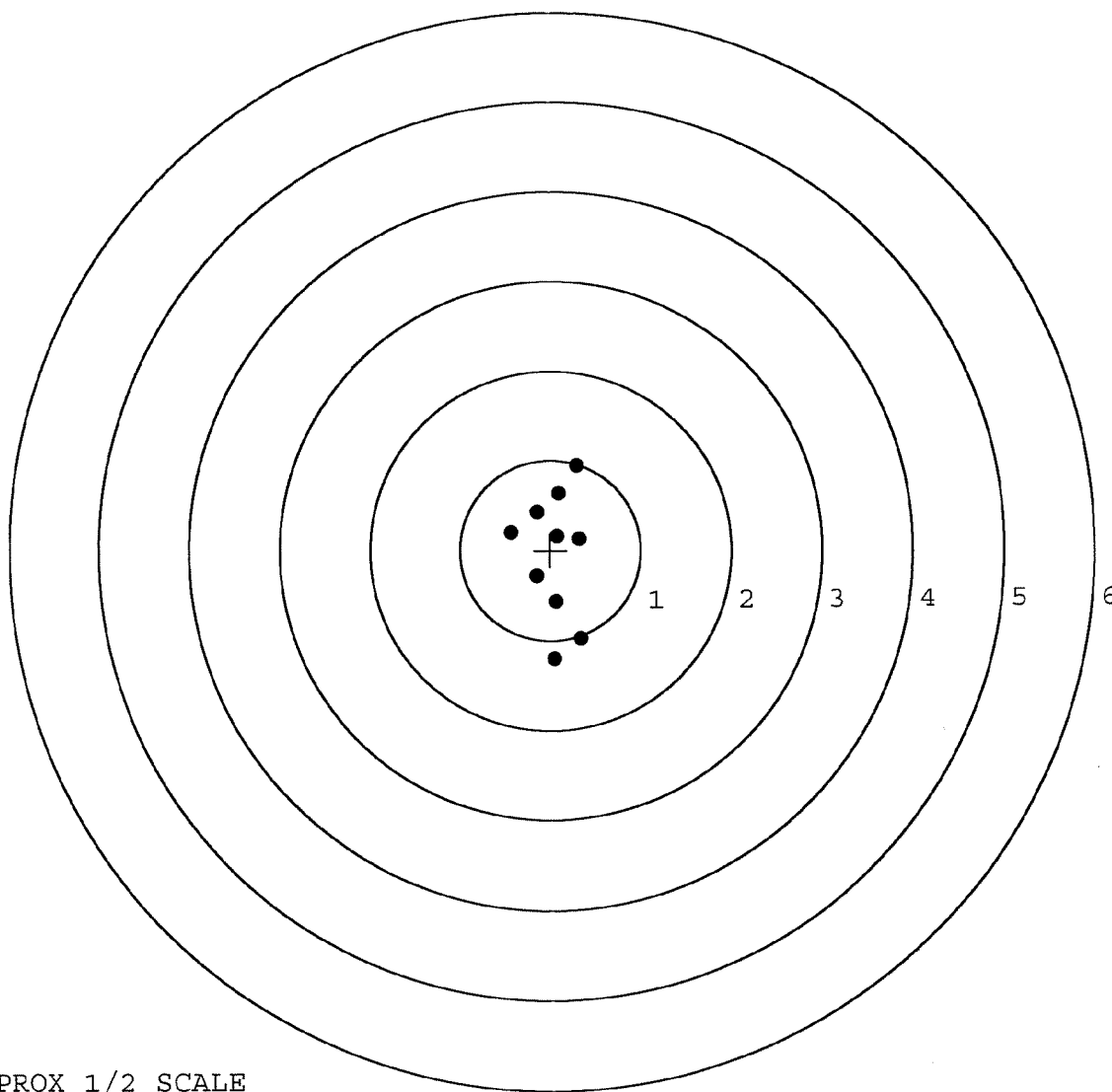
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.001
The Average Y Centroid of the Five Target Set:	-0.055
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	0.580
The Distance from POA to Centroid Target #1:	0.076
The Distance from Centroid Target #2 to Centroid Target #1:	0.219
The Distance from Centroid Target #3 to Centroid Target #1:	0.148
The Distance from Centroid Target #4 to Centroid Target #1:	0.111
The Distance from Centroid Target #5 to Centroid Target #1:	0.177

SERIAL NUMBER: G6535350. __0
TARGET NUMBER: 1
FILE DATE: 03/03/2006
FILE TIME: 07:53

X CENTROID: 0.049
Y CENTROID: -0.059
POA TO CENTROID: 0.076
HORZ SPREAD: 0.779
VERT SPREAD: 2.147
GROUP SPREAD: 2.162
MIN RADIUS: 0.217
MAX RADIUS: 1.152
MEAN RADIUS: 0.627
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.041	-1.211
2:	0.339	-0.981
3:	0.061	-0.572
4:	-0.156	-0.287
5:	-0.440	0.195
6:	0.321	0.120
7:	0.074	0.157
8:	0.098	0.633
9:	0.294	0.936
10:	-0.147	0.423



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535350. __0

TARGET NUMBER: 2

FILE DATE: 03/03/2006

FILE TIME: 07:53

X CENTROID: -0.104

Y CENTROID: 0.098

POA TO CENTROID: 0.143

HORZ SPREAD: 1.602

VERT SPREAD: 0.805

GROUP SPREAD: 1.778

MIN RADIUS: 0.173

MAX RADIUS: 1.015

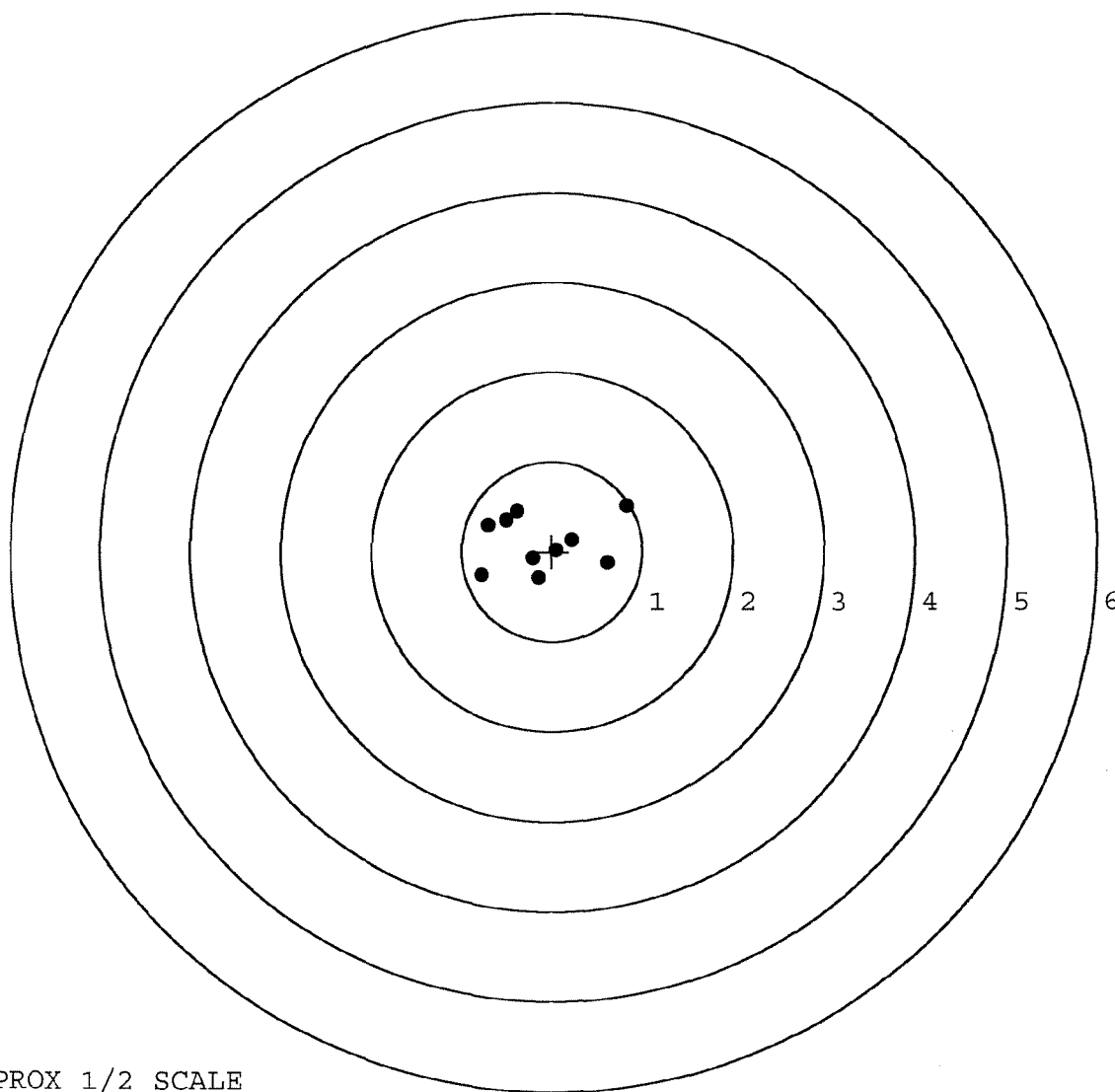
MEAN RADIUS: 0.520

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.618	-0.123
2:	0.825	0.507
3:	-0.711	0.298
4:	-0.392	0.450
5:	-0.777	-0.265
6:	-0.148	-0.298
7:	-0.207	-0.077
8:	0.216	0.129
9:	0.049	0.017
10:	-0.512	0.347



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535350.___0

TARGET NUMBER: 3

FILE DATE: 03/03/2006

FILE TIME: 07:53

X CENTROID: 0.039

Y CENTROID: -0.206

POA TO CENTROID: 0.210

HORZ SPREAD: 1.313

VERT SPREAD: 2.192

GROUP SPREAD: 2.246

MIN RADIUS: 0.211

MAX RADIUS: 1.233

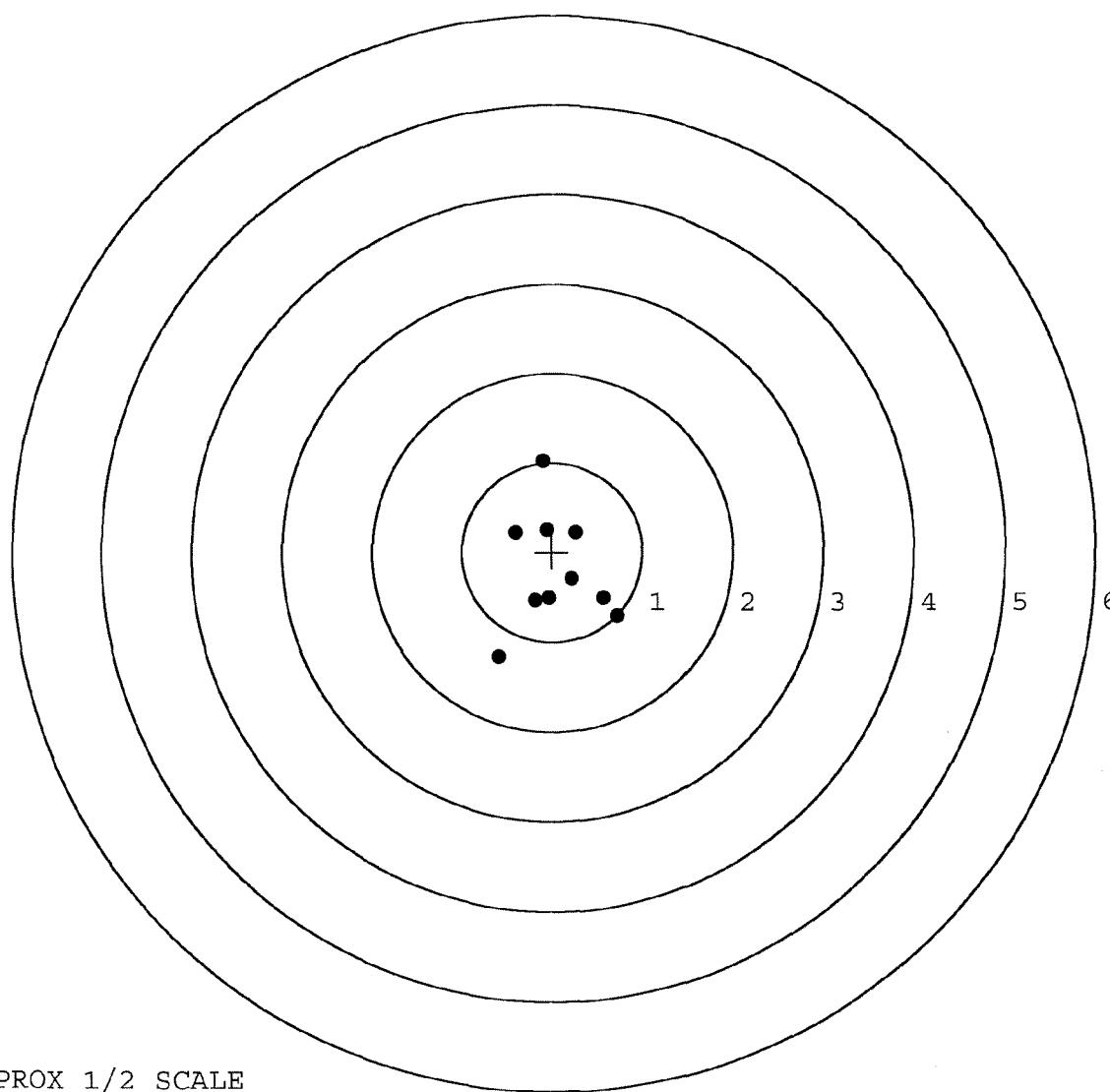
MEAN RADIUS: 0.634

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.721	-0.707
2:	0.571	-0.512
3:	-0.592	-1.173
4:	-0.188	-0.541
5:	-0.040	-0.517
6:	0.226	-0.303
7:	0.261	0.218
8:	-0.059	0.243
9:	-0.410	0.214
10:	-0.103	1.019



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535350. __0

TARGET NUMBER: 4

FILE DATE: 03/03/2006

FILE TIME: 07:53

X CENTROID: 0.148

Y CENTROID: -0.011

POA TO CENTROID: 0.148

HORZ SPREAD: 1.795

VERT SPREAD: 1.549

GROUP SPREAD: 1.893

MIN RADIUS: 0.208

MAX RADIUS: 1.205

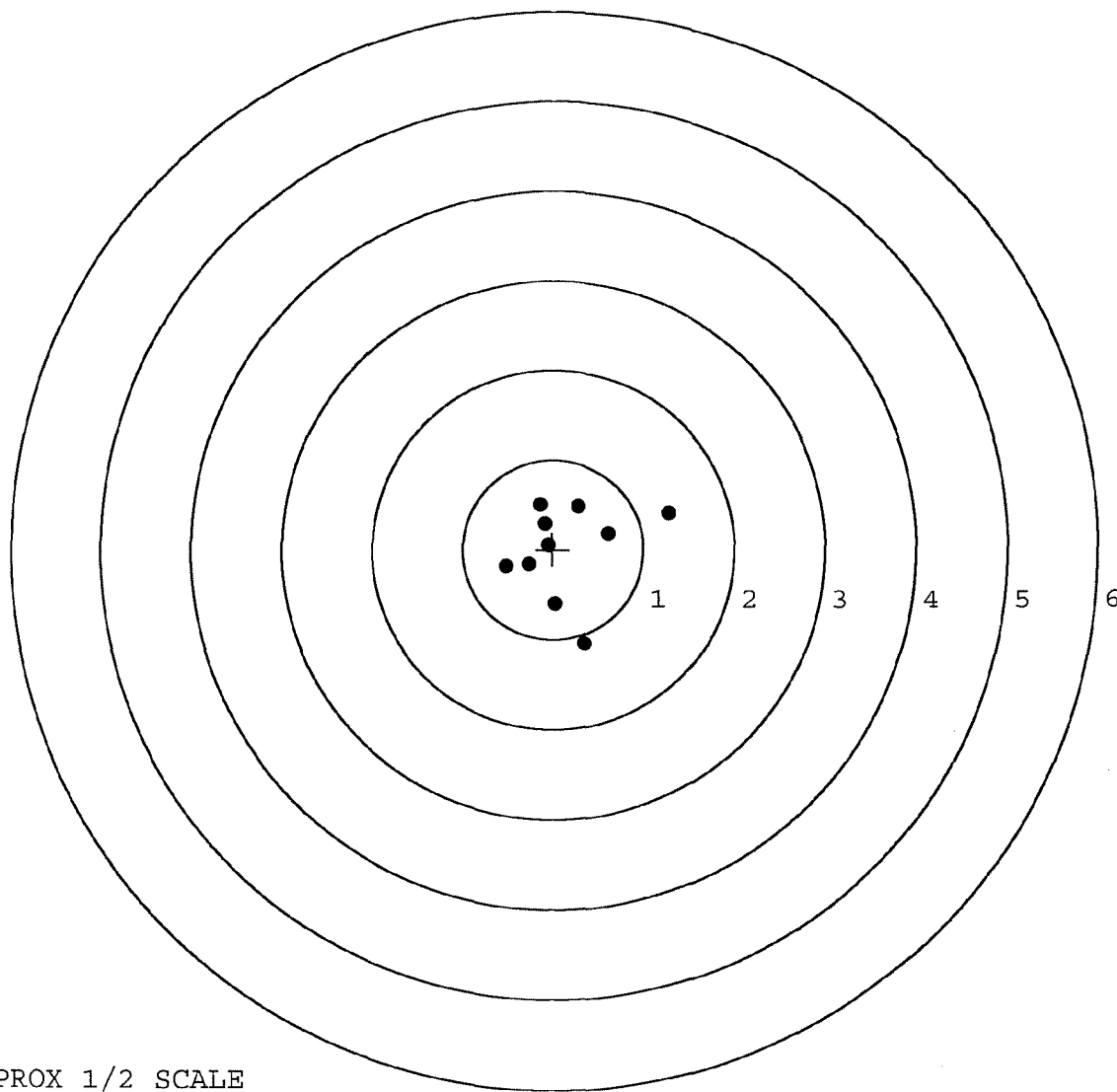
MEAN RADIUS: 0.620

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.353	-1.049
2:	0.027	-0.610
3:	1.278	0.408
4:	0.607	0.184
5:	0.284	0.486
6:	-0.146	0.500
7:	-0.092	0.291
8:	-0.051	0.049
9:	-0.262	-0.172
10:	-0.517	-0.193



TARGET APPROX 1/2 SCALE

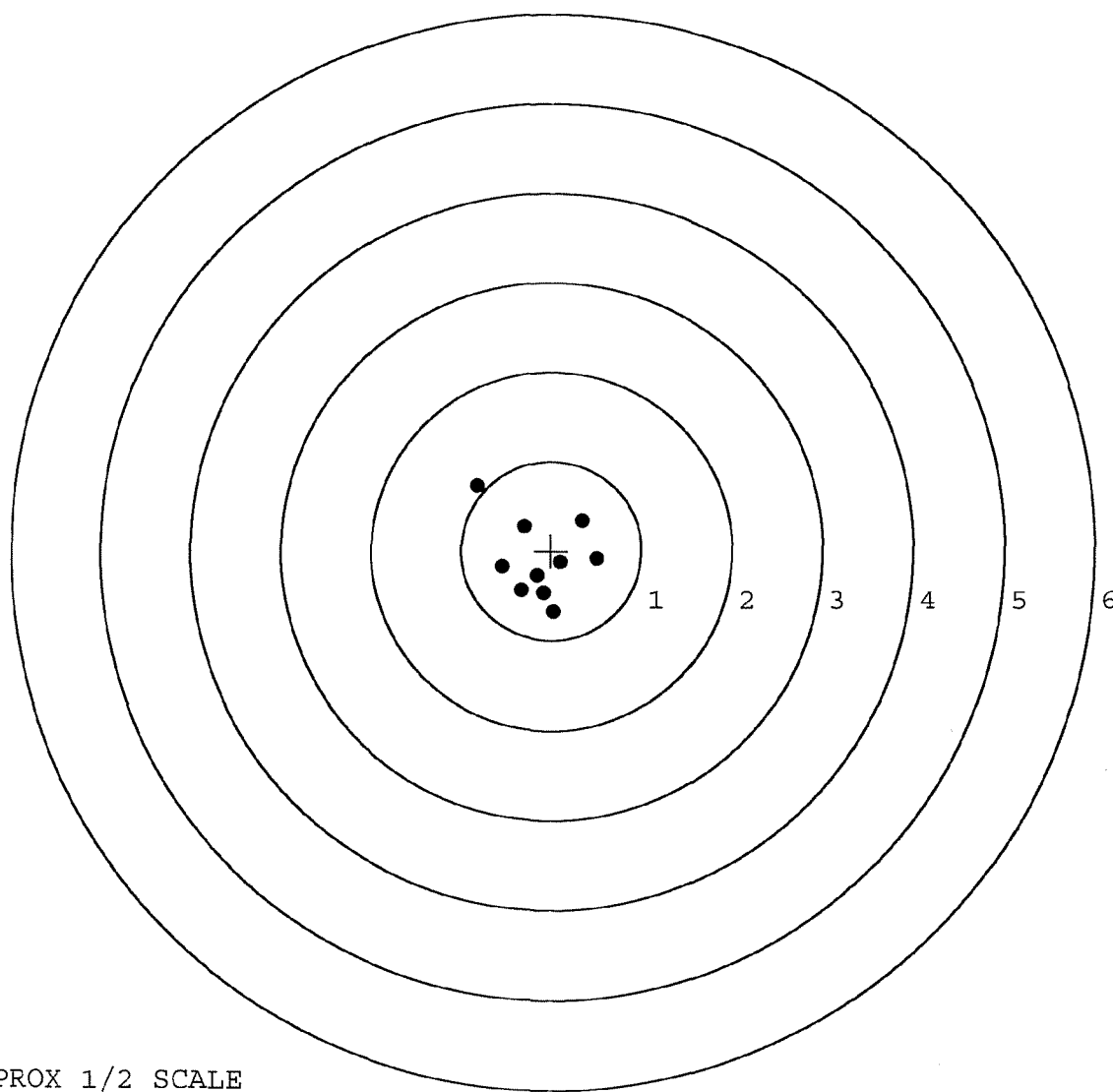
SERIAL NUMBER: G6535350. __ 0

TARGET NUMBER: 5

FILE DATE: 03/03/2006

FILE TIME: 07:53

	POINT#	X	Y
	1:	0.511	-0.091
	2:	0.343	0.339
	3:	0.103	-0.127
	4:	-0.300	0.269
	5:	-0.823	0.725
	6:	-0.544	-0.183
	7:	-0.154	-0.285
	8:	-0.330	-0.450
	9:	-0.085	-0.476
	10:	0.031	-0.687
X CENTROID:		-0.125	
Y CENTROID:		-0.097	
POA TO CENTROID:		0.158	
HORZ SPREAD:		1.334	
VERT SPREAD:		1.412	
GROUP SPREAD:		1.650	
MIN RADIUS:		0.191	
MAX RADIUS:		1.078	
MEAN RADIUS:		0.501	
# IN 1 IN DIAMETER:		6	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE