

G6535360

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

UPC



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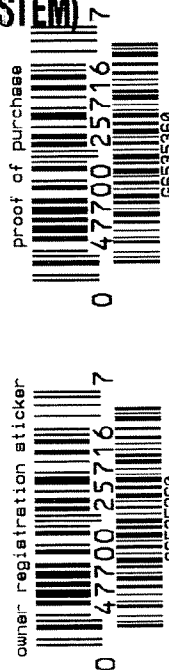
SERIAL NO.



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

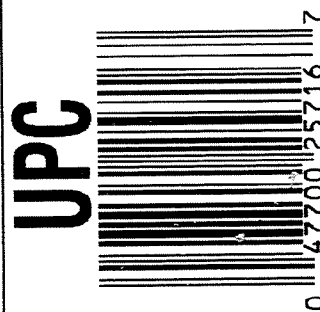
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6535360



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5360

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-2-06	RTZ
440	PROOF		2/2/06	MJD
460	CHECK HEADSPACE	MAGNA-FLUX TESTED	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		2-18	JJ
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/14	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		3/16/06	MJD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/16/06	MJD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3/16/06	MJD
	D) OIL FIRING PIN ASSEMBLY		3-16-06	Ac
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4-10-06	Ac

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>7.0</u> <u>6.5</u>	4-5-06	TRW
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.75</u> <u>2.5</u> <u>2.5</u>	4-5-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.021</u> <u>.022</u>	4-5-06	TRW
	J) ASSEMBLE STOCK		3-17-06	PZ
	K) ASSEMBLE SWIVEL STUDS		4-10-06	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-16-06	AC
	M) IRON SIGHT ALIGNMENT		3-16-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-16-06	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-17-06	MTJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-17-06	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		4-10-06	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.79</u> <u>2.81</u> <u>2.81</u> <u>2.81</u>	3-31-06	AC
	C) FUNCTION		4-10-06	AC
690	PACK		4-11-06	BA

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 3-16-06
TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.52	2.56		2.47	
PULL #2	2.53	2.57		2.48	
PULL #3	2.51	2.53		2.53	
PULL #4	2.56	2.57		2.57	
PULL #5	2.54	2.57		2.53	
TOTAL	12.66	12.80		12.58	
AVERAGE	2.53	2.56		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	2.91		
PULL #2	3.07	3.03		
PULL #3	3.10	2.99		
PULL #4	3.15	3.05		
PULL #5	3.12	3.03		
TOTAL	15.57	15.01		
AVERAGE	3.11	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	4.07	4.09		4.11
PULL #2	4.05	4.08		4.20
PULL #3	4.10	4.08		4.16
PULL #4	4.11	4.07		4.15
PULL #5	4.08	4.08		4.15
TOTAL	20.41	20.40		20.77
AVERAGE	4.08	4.08		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535360.__0
FILE DATE AND TIME: 03/17/2006 16:09

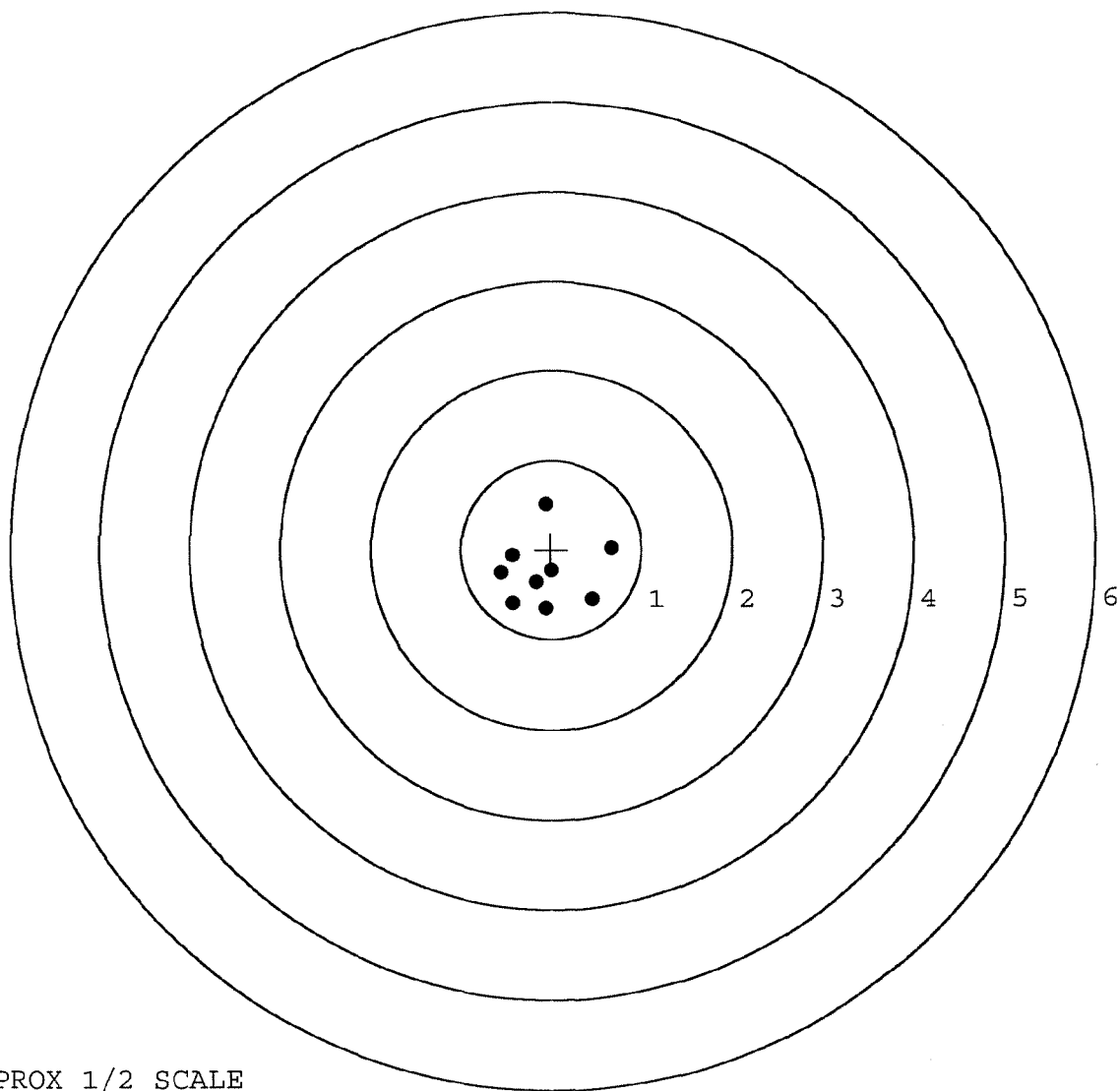
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.059
The Average Y Centroid of the Five Target Set:	-0.085
The Average Point of Impact of the Five Target Set:	0.103
The Average Mean Radius of the Five Target Set:	0.588
The Distance from POA to Centroid Target #1:	0.254
The Distance from Centroid Target #2 to Centroid Target #1:	0.387
The Distance from Centroid Target #3 to Centroid Target #1:	0.202
The Distance from Centroid Target #4 to Centroid Target #1:	0.289
The Distance from Centroid Target #5 to Centroid Target #1:	0.268

SERIAL NUMBER: G6535360. 0
TARGET NUMBER: 1
FILE DATE: 03/17/2006
FILE TIME: 16:09

X CENTROID: -0.064
Y CENTROID: -0.246
POA TO CENTROID: 0.254
HORZ SPREAD: 1.225
VERT SPREAD: 1.169
GROUP SPREAD: 1.266
MIN RADIUS: 0.066
MAX RADIUS: 0.782
MEAN RADIUS: 0.465
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.454	-0.551
2:	0.670	0.025
3:	-0.061	0.508
4:	0.002	-0.240
5:	-0.427	-0.064
6:	-0.555	-0.259
7:	-0.427	-0.606
8:	-0.063	-0.661
9:	-0.167	-0.368

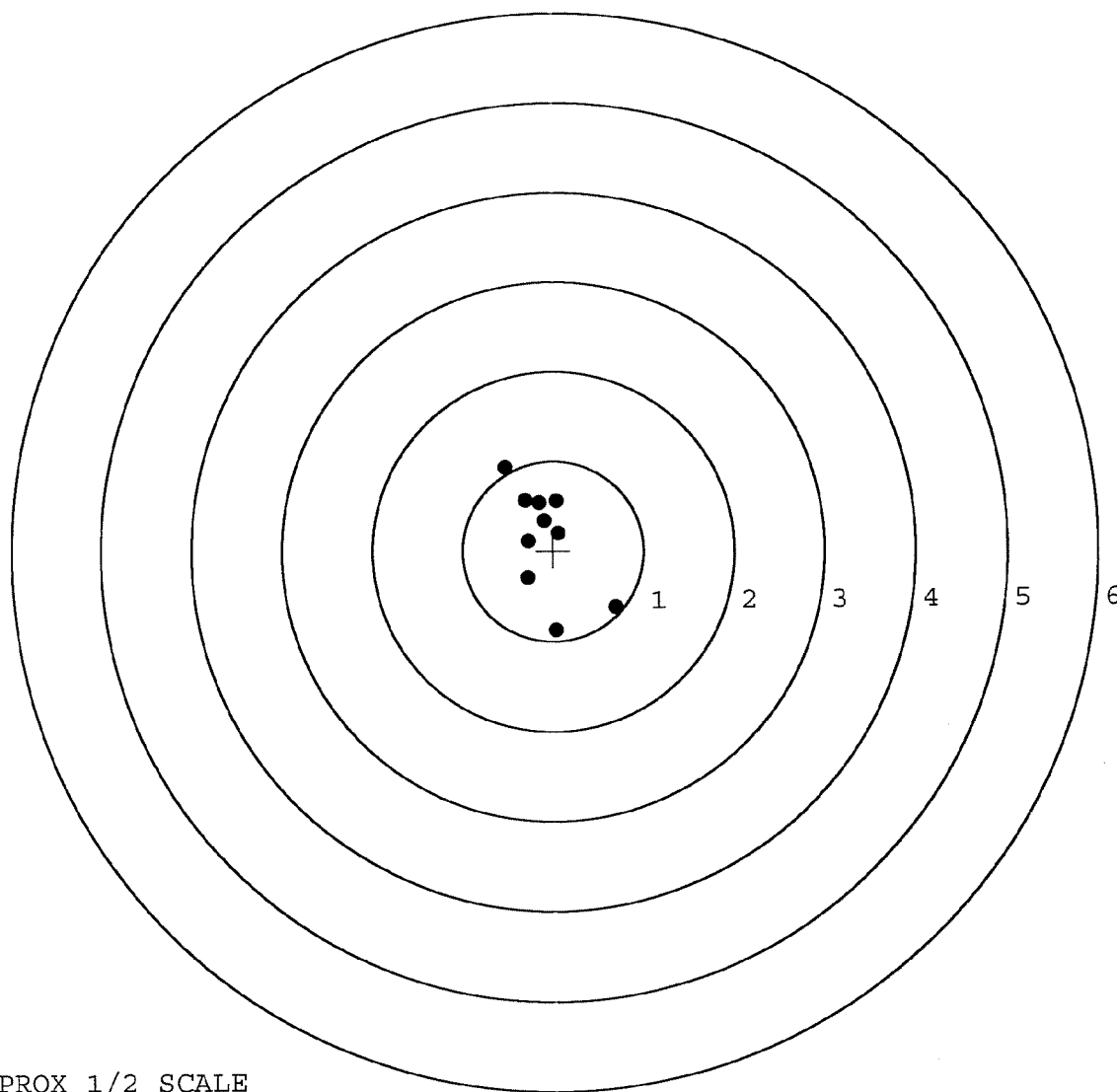


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535360. __0
TARGET NUMBER: 2
FILE DATE: 03/17/2006
FILE TIME: 16:09

X CENTROID: -0.085
Y CENTROID: 0.140
POA TO CENTROID: 0.164
HORZ SPREAD: 1.220
VERT SPREAD: 1.818
GROUP SPREAD: 1.984
MIN RADIUS: 0.152
MAX RADIUS: 1.095
MEAN RADIUS: 0.538
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.529	0.933
2:	-0.311	0.563
3:	0.039	0.555
4:	0.057	0.196
5:	-0.278	0.107
6:	-0.102	0.334
7:	-0.286	-0.306
8:	0.027	-0.885
9:	0.691	-0.632
10:	-0.154	0.539

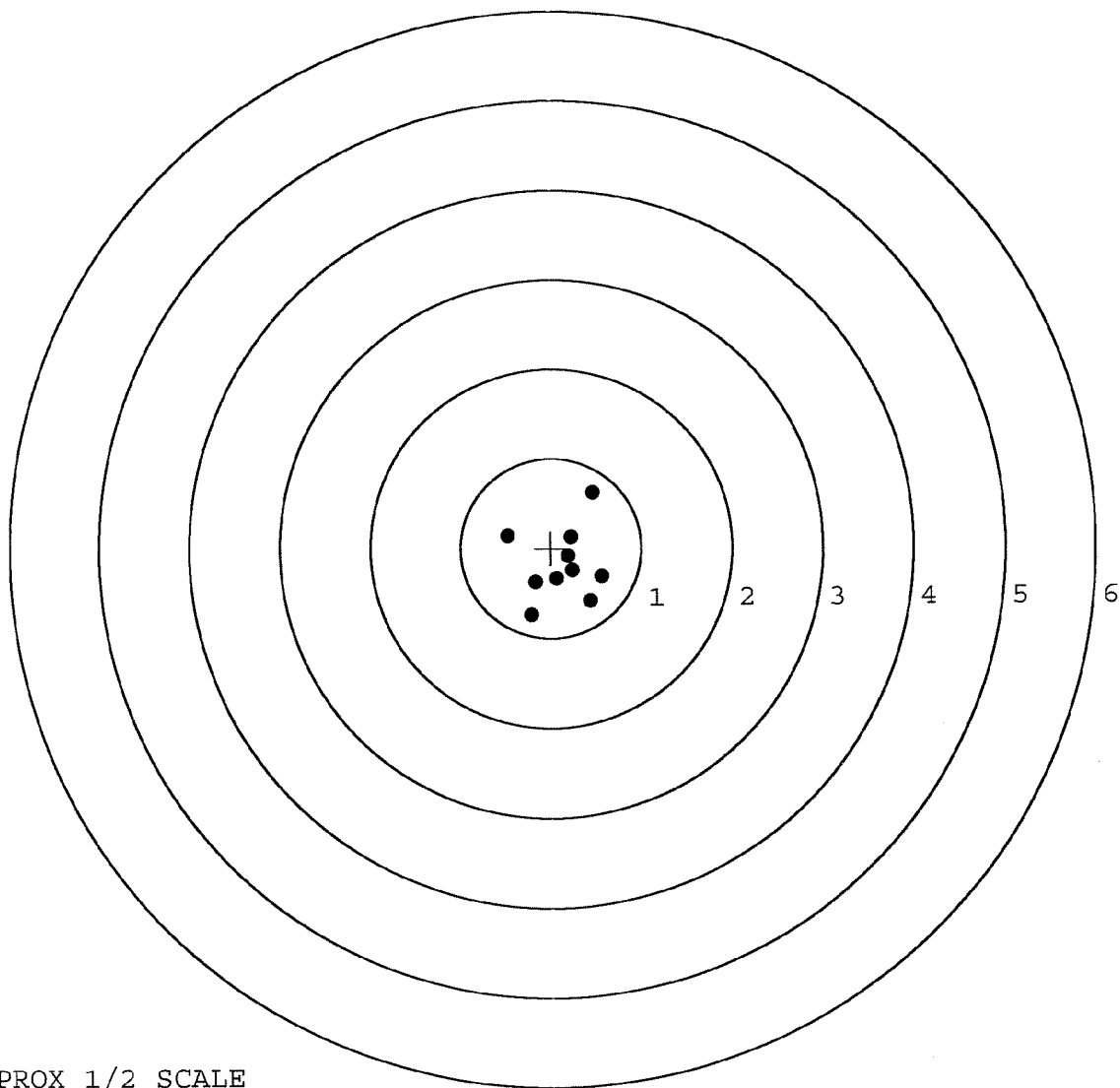


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535360. __0
TARGET NUMBER: 3
FILE DATE: 03/17/2006
FILE TIME: 16:09

X CENTROID: 0.129
Y CENTROID: -0.184
POA TO CENTROID: 0.225
HORZ SPREAD: 1.050
VERT SPREAD: 1.369
GROUP SPREAD: 1.532
MIN RADIUS: 0.113
MAX RADIUS: 0.868
MEAN RADIUS: 0.429
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.463	0.617
2:	-0.485	0.139
3:	-0.225	-0.752
4:	0.434	-0.588
5:	0.565	-0.314
6:	-0.177	-0.382
7:	0.061	-0.346
8:	0.238	-0.250
9:	0.192	-0.091
10:	0.223	0.123

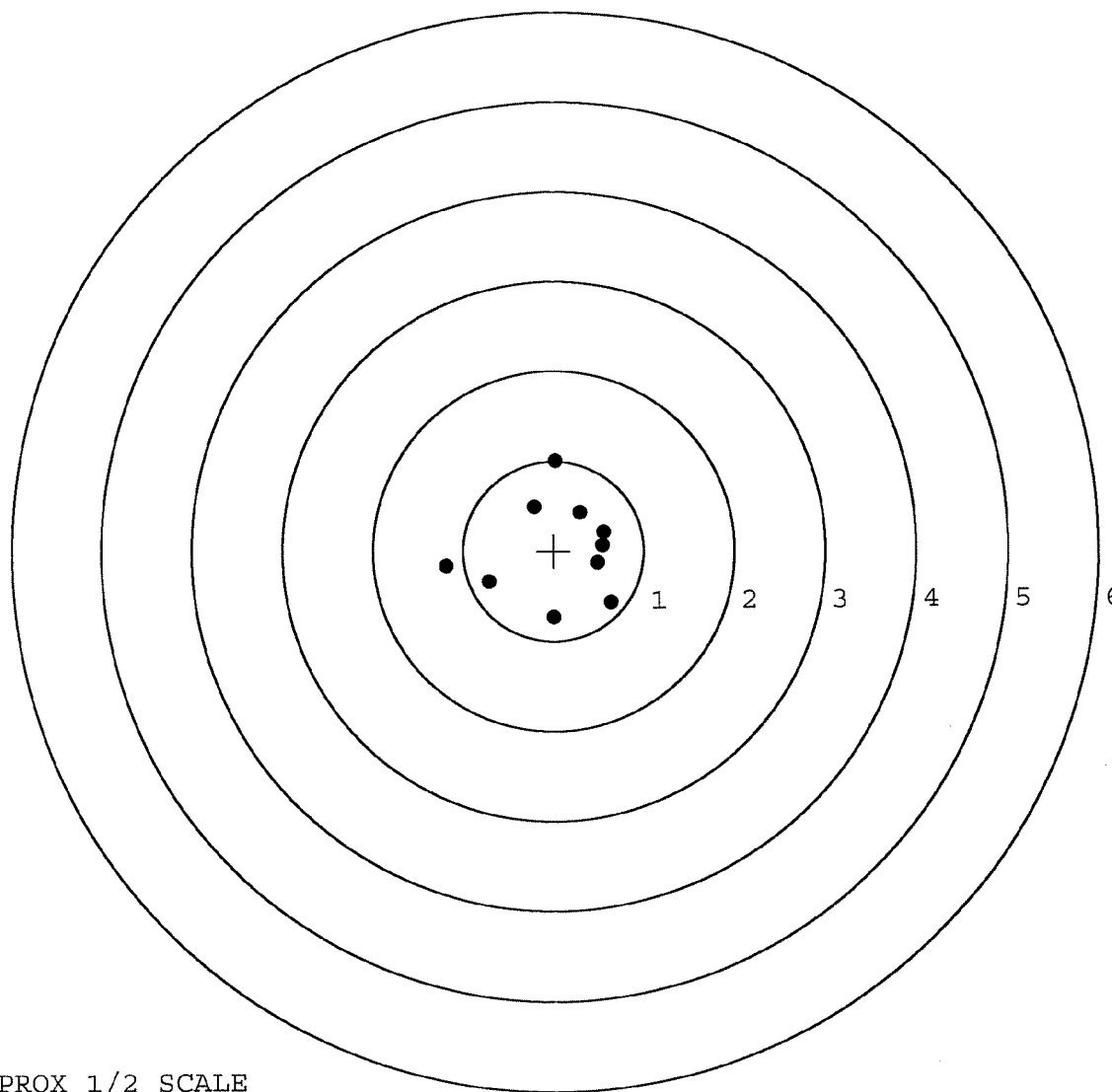


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535360. __0
TARGET NUMBER: 4
FILE DATE: 03/17/2006
FILE TIME: 16:09

X CENTROID: 0.043
Y CENTROID: 0.023
POA TO CENTROID: 0.048
HORZ SPREAD: 1.825
VERT SPREAD: 1.744
GROUP SPREAD: 1.869
MIN RADIUS: 0.473
MAX RADIUS: 1.248
MEAN RADIUS: 0.721
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

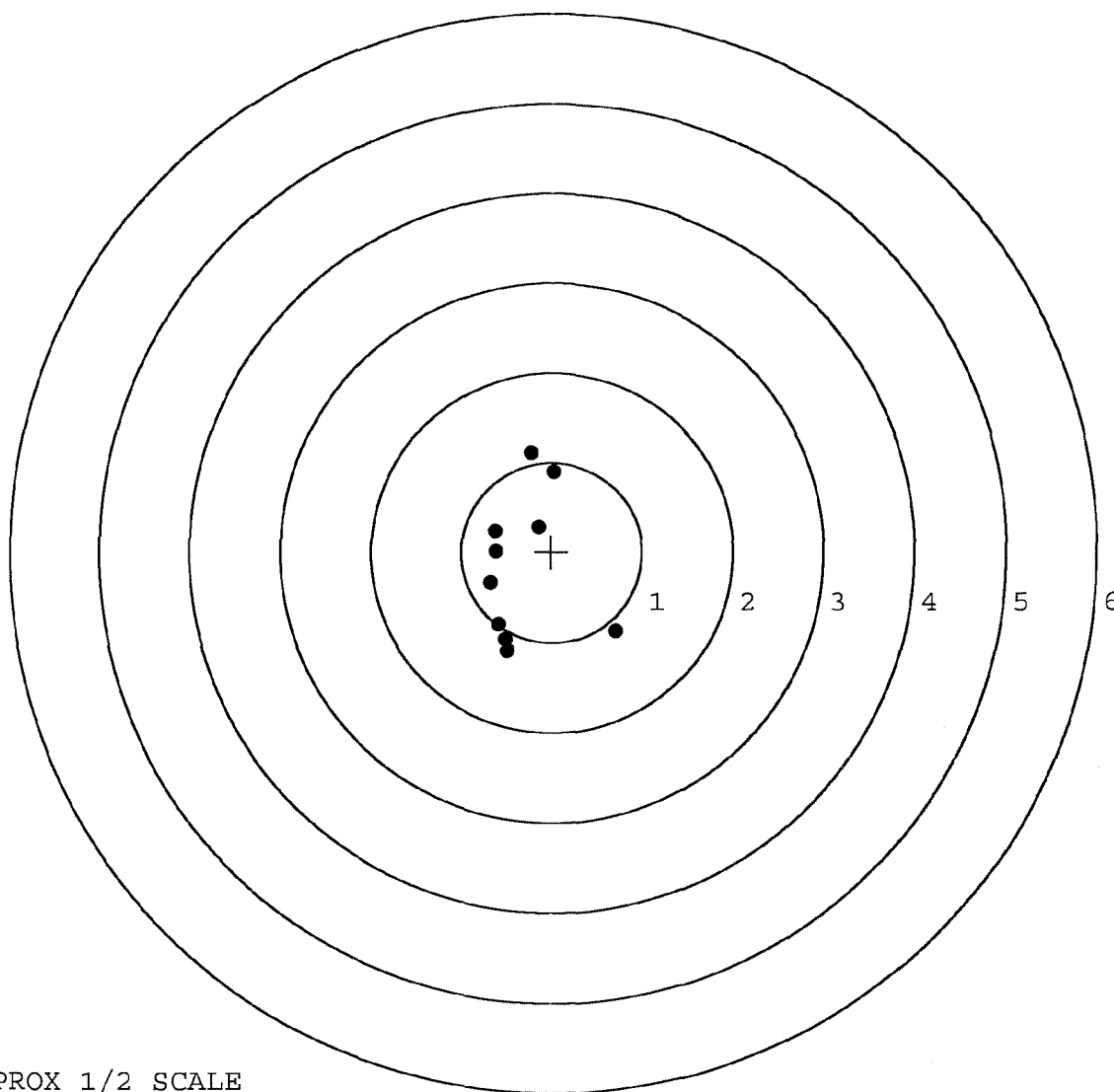
POINT#	X	Y
1:	0.025	1.004
2:	-0.214	0.491
3:	0.296	0.431
4:	0.559	0.211
5:	0.540	0.063
6:	0.487	-0.140
7:	0.635	-0.577
8:	0.004	-0.740
9:	-0.716	-0.341
10:	-1.190	-0.173



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535360. 0
TARGET NUMBER: 5
FILE DATE: 03/17/2006
FILE TIME: 16:09

	POINT#	X	Y
X CENTROID:	1:	0.708	-0.875
Y CENTROID:	2:	-0.487	-1.098
POA TO CENTROID:	3:	-0.519	-0.973
HORZ SPREAD:	4:	-0.590	-0.804
VERT SPREAD:	5:	-0.679	-0.341
GROUP SPREAD:	6:	-0.618	0.010
MIN RADIUS:	7:	-0.629	0.234
MAX RADIUS:	8:	-0.149	0.274
MEAN RADIUS:	9:	0.023	0.899
# IN 1 IN DIAMETER:	10:	-0.229	1.107
# IN 2 IN DIAMETER:			
# in 3 IN DIAMETER:			



TARGET APPROX 1/2 SCALE