

G 653 5406

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

UPC



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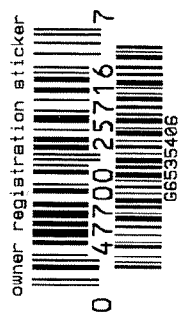
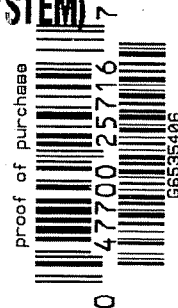
SERIAL NO.



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

G6535406



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C6535406

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	MAGNA-FLUX INSPECTED	2-10-06	AC
470	DIS-ASSEMBLE ACTION	FEB 14 2006	2-10-06	AC
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 OPERATOR CPD	2-11-06	APD
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	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/20/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2/21/06	MM99
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/21/06	MM99
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/21/06	MM99
	D) OIL FIRING PIN ASSEMBLY		2-28-06	AC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4-17-06	mm

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7 lbs.</u> <u>7 lbs.</u> <u>7 lbs.</u>	4-13-06	mm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	4-13-06	mm
	H) TRIGGER PULL TEST AND RETAINABILITY		4-17-06	mm
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	4-13-06	mm
	J) ASSEMBLE STOCK		3-1-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		4-17-06	R.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	PASS FAIL PASS FAIL	3-1-06	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>NA</i>		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3/1/06	mm
670	FINAL INSPECTION A) HEADSPACE		4-17-06	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.27</u> <u>2.64</u> <u>2.36</u> <u>2.66</u> <u>2.88</u>	3-3-06	mm
	C) FUNCTION		4-17-06	mm
690	PACK		4-20-06	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 2-22-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.49	2.57		2.63	
PULL #2	2.48	2.57		2.61	
PULL #3	2.56	2.56		2.57	
PULL #4	2.57	2.54		2.57	
PULL #5	2.53	2.59		2.57	
TOTAL	12.63	12.83		12.95	
AVERAGE	2.52	2.56		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.28		
PULL #2	2.99	3.15		
PULL #3	3.19	3.01		
PULL #4	3.28	3.00		
PULL #5	3.05	2.98		
TOTAL	15.56	15.42		
AVERAGE	3.11	3.08		

	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	4.13	4.13		4.00
PULL #2	4.08	3.99		4.12
PULL #3	4.05	4.10		4.06
PULL #4	4.11	4.00		4.08
PULL #5	4.16	4.08		4.14
TOTAL	20.53	20.30		20.40
AVERAGE	4.10	4.06		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535406.___0

FILE DATE AND TIME: 03/01/2006 15:05

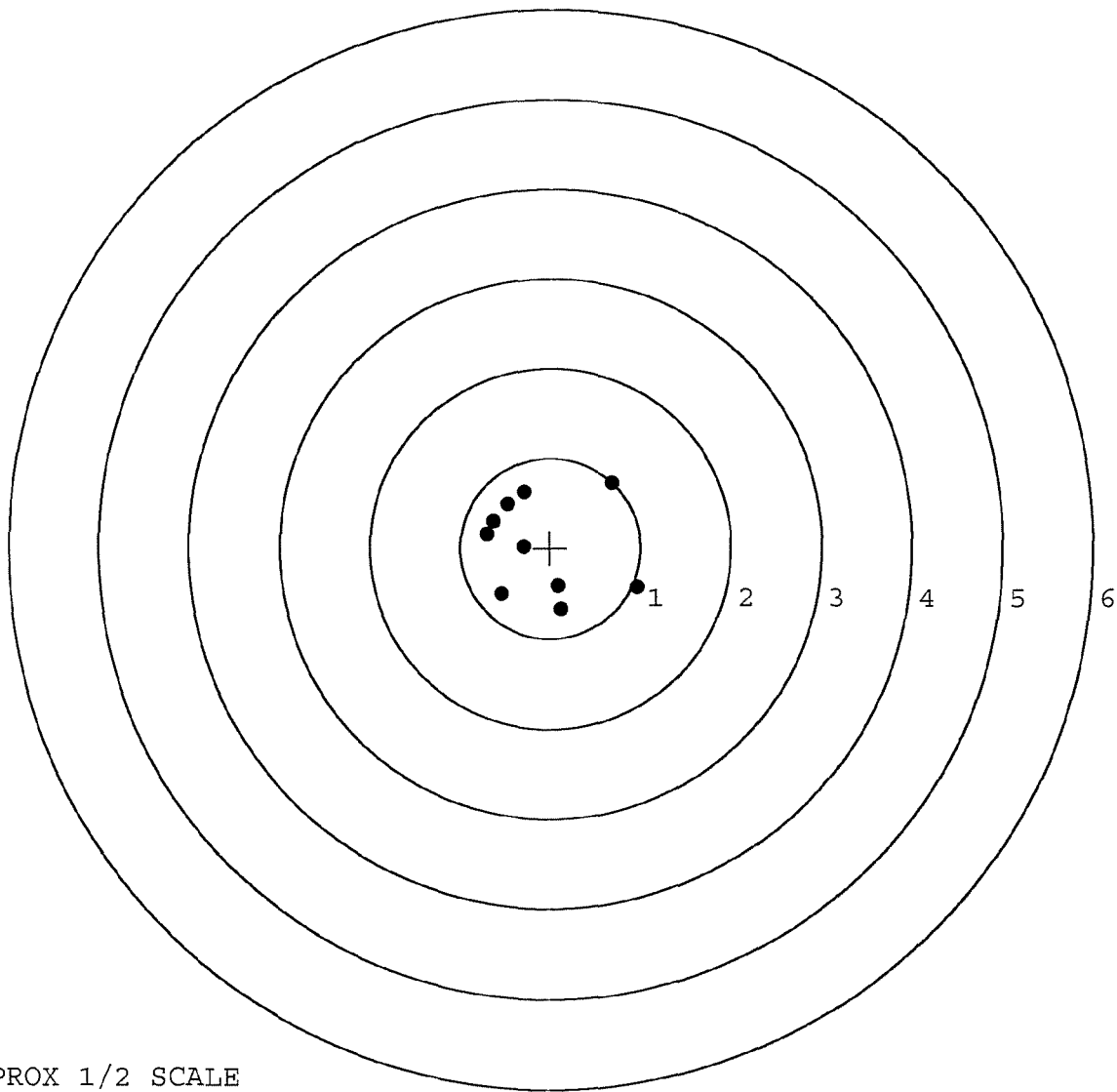
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.199
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.210
The Average Mean Radius of the Five Target Set:	0.599
The Distance from POA to Centroid Target #1:	0.111
The Distance from Centroid Target #2 to Centroid Target #1:	0.128
The Distance from Centroid Target #3 to Centroid Target #1:	0.405
The Distance from Centroid Target #4 to Centroid Target #1:	0.181
The Distance from Centroid Target #5 to Centroid Target #1:	0.235

SERIAL NUMBER: G6535406. 0
TARGET NUMBER: 1
FILE DATE: 03/01/2006
FILE TIME: 15:05

POINT#	X	Y
1:	0.088	-0.421
2:	0.122	-0.682
3:	-0.540	-0.514
4:	-0.290	0.017
5:	-0.709	0.149
6:	-0.635	0.291
7:	-0.479	0.480
8:	-0.289	0.625
9:	0.684	0.726
10:	0.961	-0.436

X CENTROID: -0.109
Y CENTROID: 0.024
POA TO CENTROID: 0.111
HORZ SPREAD: 1.670
VERT SPREAD: 1.408
GROUP SPREAD: 1.769
MIN RADIUS: 0.181
MAX RADIUS: 1.164
MEAN RADIUS: 0.674
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535406. __0

TARGET NUMBER: 2

FILE DATE: 03/01/2006

FILE TIME: 15:05

POINT#	X	Y
1:	0.000	0.000
2:	-0.047	0.201
3:	-0.205	-0.049
4:	-0.036	-0.568
5:	0.528	-0.375
6:	-0.677	-0.546
7:	-0.865	-0.528
8:	0.297	0.930
9:	-0.299	0.559
10:	-1.031	0.905

X CENTROID: -0.233

Y CENTROID: 0.053

POA TO CENTROID: 0.239

HORZ SPREAD: 1.559

VERT SPREAD: 1.498

GROUP SPREAD: 2.017

MIN RADIUS: 0.106

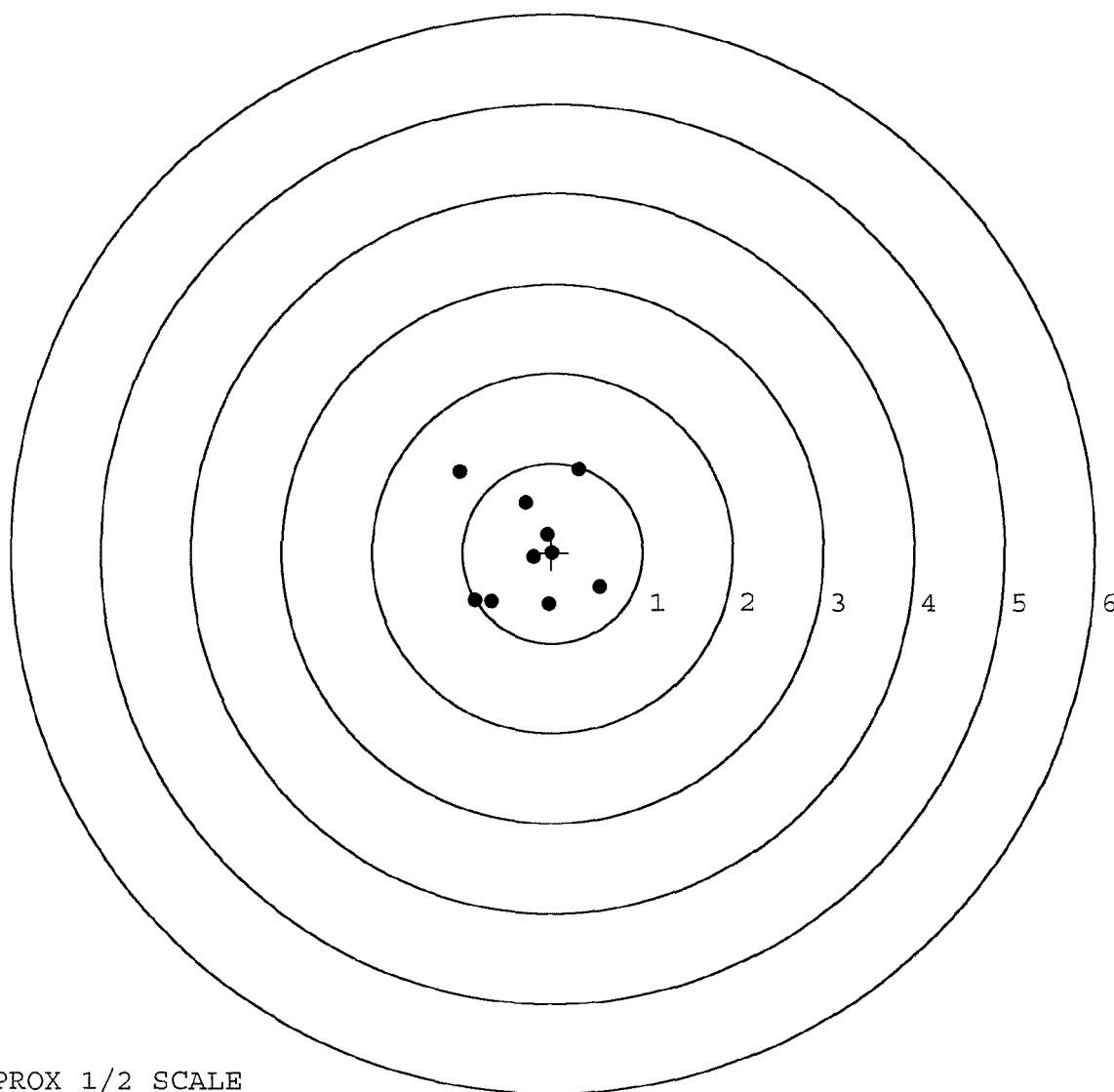
MAX RADIUS: 1.167

MEAN RADIUS: 0.641

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535406. 0

TARGET NUMBER: 3

FILE DATE: 03/01/2006

FILE TIME: 15:05

POINT#	X	Y
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1:	0.000	0.000
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2:	-0.335	-0.158
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3:	-0.227	-0.403
----	--------	--------

4:	-0.157	-0.594
----	--------	--------

5:	0.274	-0.875
----	-------	--------

6:	0.391	-0.288
----	-------	--------

7:	0.187	0.003
----	-------	-------

8:	-0.498	0.272
----	--------	-------

9:	-0.636	-0.784
----	--------	--------

10:	-0.413	-0.979
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X CENTROID: -0.141

Y CENTROID: -0.381

POA TO CENTROID: 0.406

HORZ SPREAD: 1.027

VERT SPREAD: 1.251

GROUP SPREAD: 1.383

MIN RADIUS: 0.088

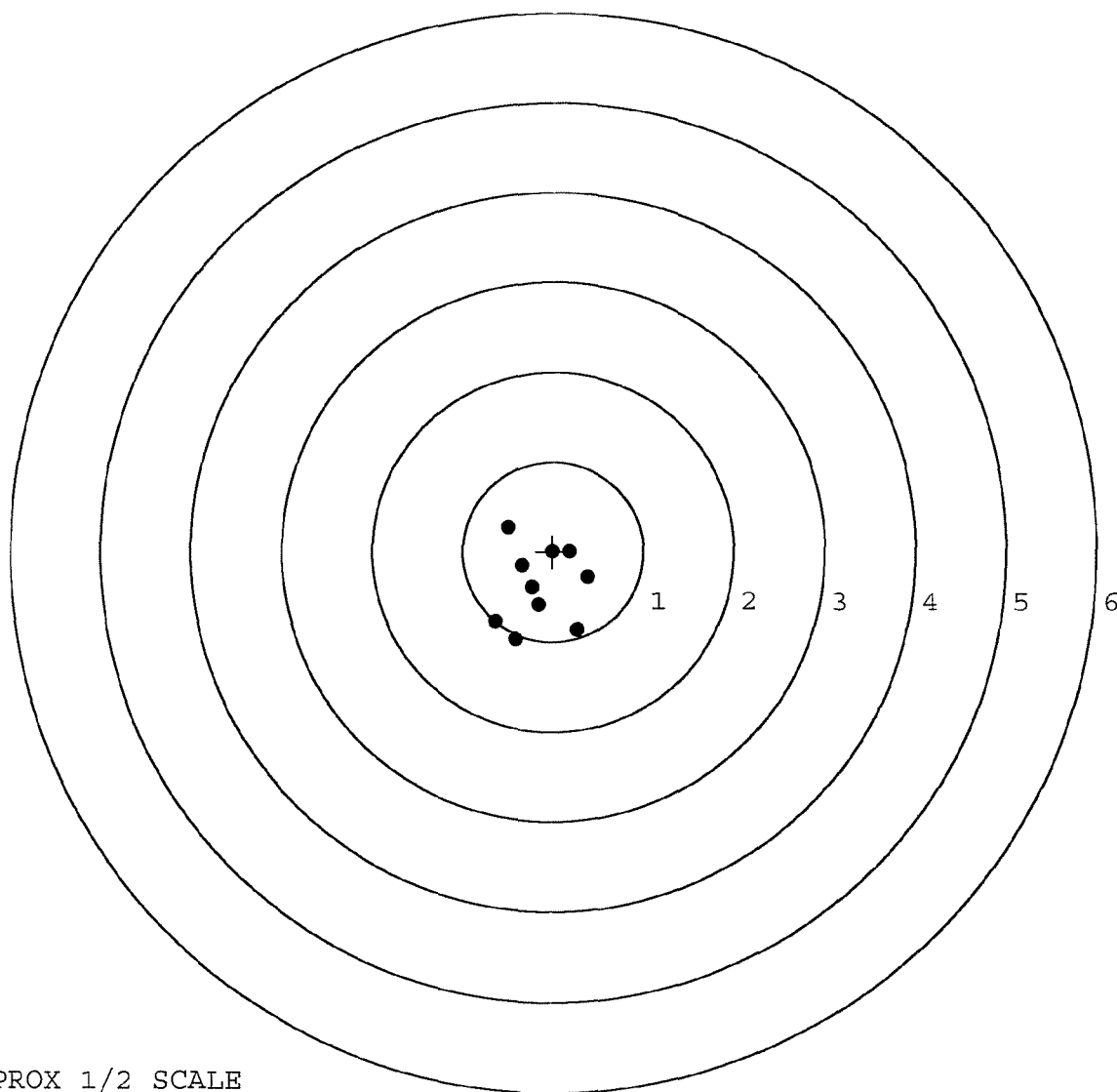
MAX RADIUS: 0.744

MEAN RADIUS: 0.473

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535406. 0

TARGET NUMBER: 4

FILE DATE: 03/01/2006

FILE TIME: 15:05

POINT#	X	Y
1:	-0.833	-0.228
2:	-0.200	-0.775
3:	0.658	-0.985
4:	0.268	-0.332
5:	-0.907	0.651
6:	-0.170	0.478
7:	-0.274	0.235
8:	-0.272	0.013
9:	-0.150	-0.168
10:	0.081	-0.314

X CENTROID: -0.180

Y CENTROID: -0.143

POA TO CENTROID: 0.229

HORZ SPREAD: 1.565

VERT SPREAD: 1.636

GROUP SPREAD: 2.264

MIN RADIUS: 0.039

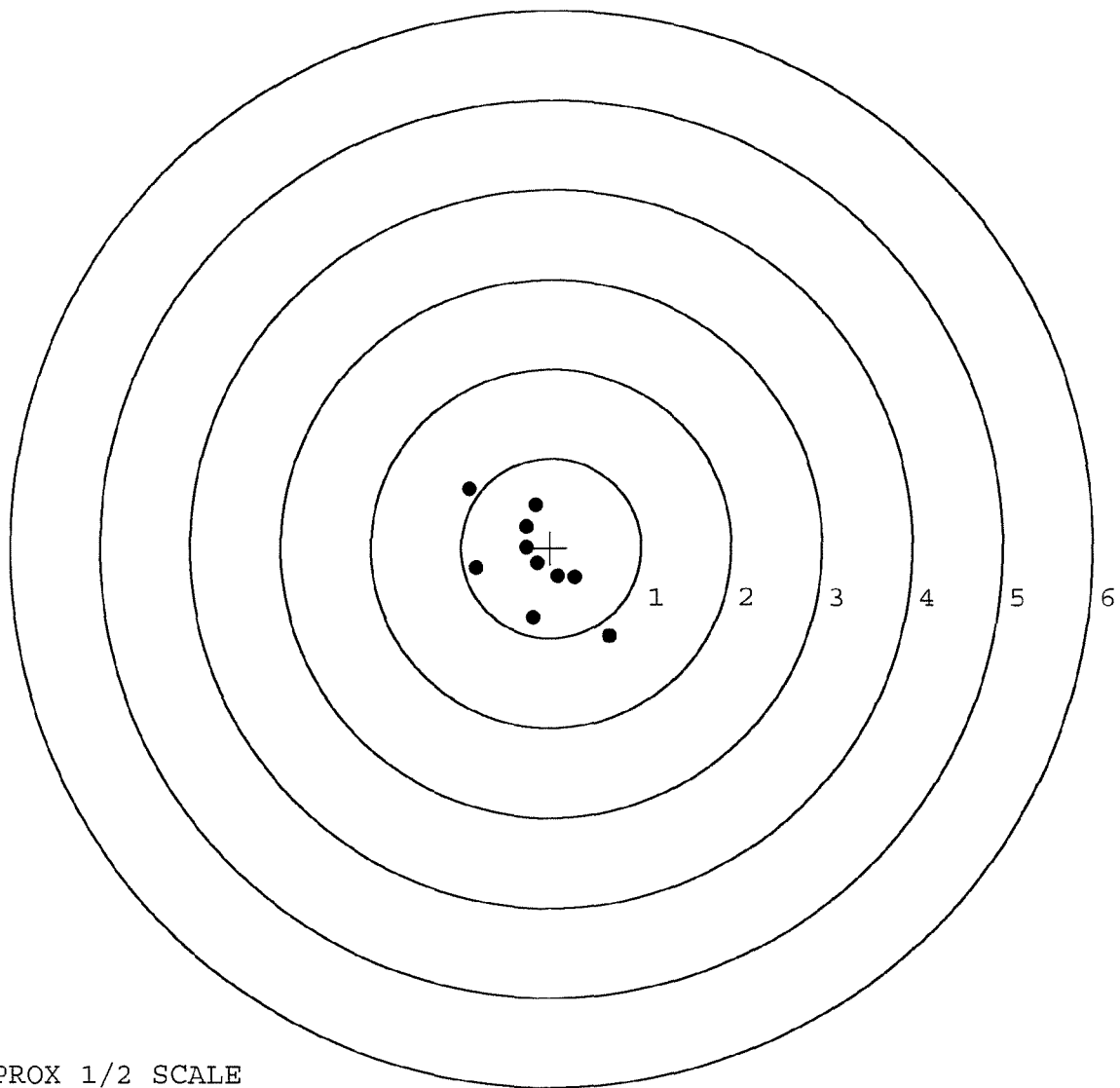
MAX RADIUS: 1.188

MEAN RADIUS: 0.558

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

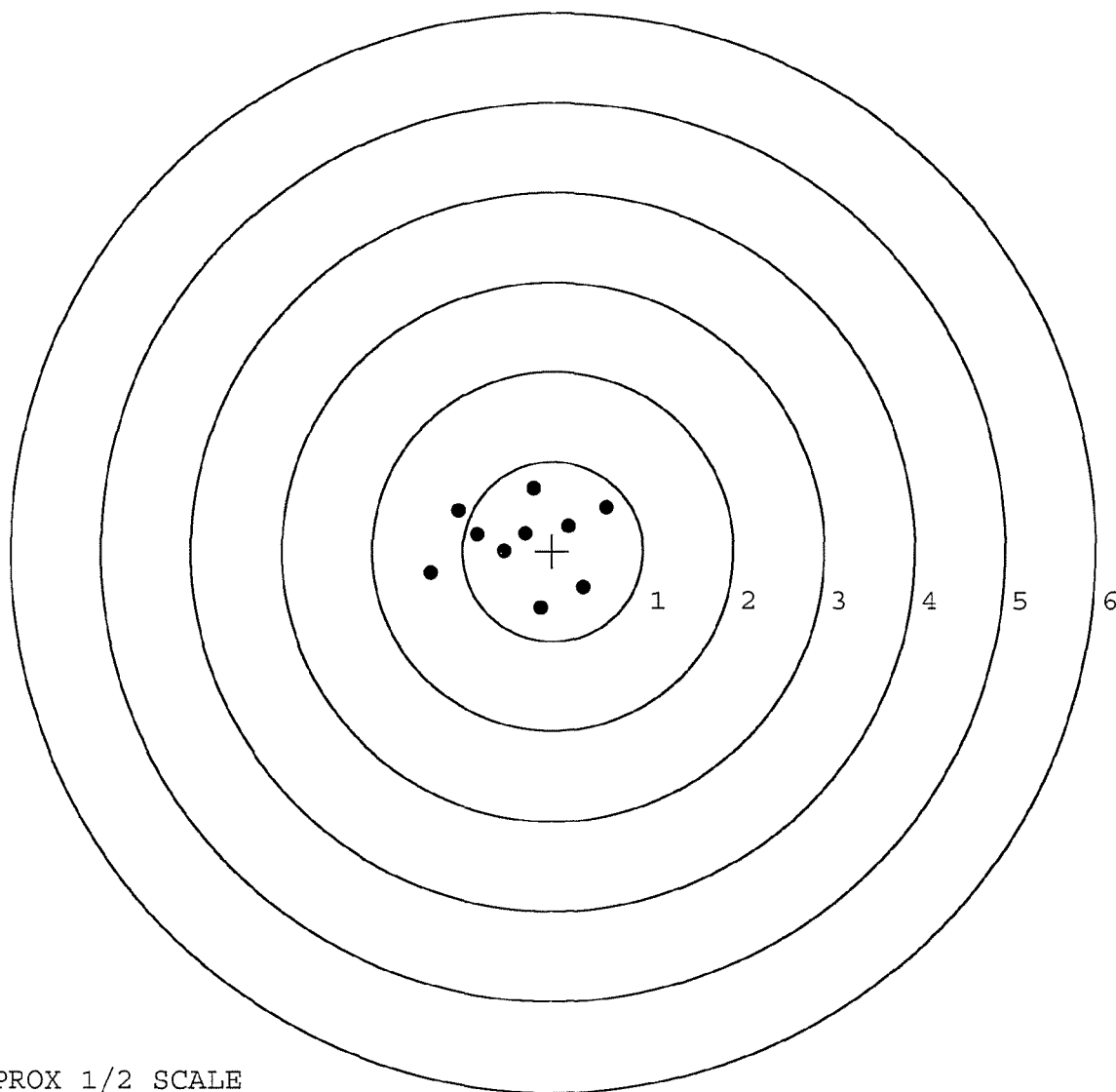


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535406. 0
TARGET NUMBER: 5
FILE DATE: 03/01/2006
FILE TIME: 15:05

POINT#	X	Y
1:	-0.300	0.196
2:	-0.210	0.695
3:	-1.048	0.448
4:	-0.846	0.192
5:	-0.537	0.003
6:	0.177	0.278
7:	0.600	0.491
8:	0.341	-0.401
9:	-0.127	-0.639
10:	-1.349	-0.249

X CENTROID: -0.330
Y CENTROID: 0.101
POA TO CENTROID: 0.345
HORZ SPREAD: 1.949
VERT SPREAD: 1.334
GROUP SPREAD: 2.085
MIN RADIUS: 0.099
MAX RADIUS: 1.078
MEAN RADIUS: 0.648
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE