

G 653 5420

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

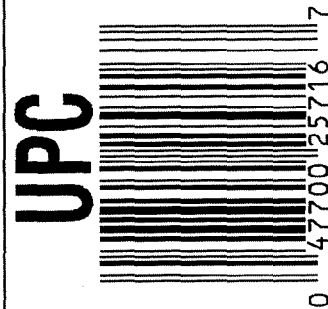
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6535420



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6535420

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		4-13-06	RTZ
440	PROOF		4-13-06	TRW
460	CHECK HEADSPACE		4-13-06	TRW
470	DIS-ASSEMBLE ACTION	INSPECTED	4-13-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 17 2006 unb	4/17/06	unb
500	ROLLMARK CALIBER		4-18-06	CW
510	DRILL AND TAP SIGHT HOLES		4-17-06	TRW
520	GOFF BLAST BBL / REC		4-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		4/19/06	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		4-27-06	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-27-06	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-27-06	MTM
	D) OIL FIRING PIN ASSEMBLY		4-27-06	Ac
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		5-10-06	MTM

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>5.5</u>	5-11-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>3.5</u> <u>4.2</u>	5-11-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		5-11-06	R.P.D.
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	5-11-06	RA
	J) ASSEMBLE STOCK		5-2-06	Ac
	K) ASSEMBLE SWIVEL STUDS		5-11-06	R.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-2-06	Ac
	M) IRON SIGHT ALIGNMENT		5-2-06	Ac
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-2-06	Ac
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	5-4-06	mtm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5-4-06	R.P.D.
670	FINAL INSPECTION A) HEADSPACE		5-11-06	R.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.61</u> <u>2.59</u> <u>2.62</u> <u>2.61</u>	5-10-06	mtm
	C) FUNCTION		5-11-06	R.P.D.
690	PACK		6-27-06	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 4/11/06

TESTER mgd

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	263	263		254	
PULL #2	264	248		248	
PULL #3	259	248		248	
PULL #4	252	264		248	
PULL #5	251	253		252	
TOTAL	1289	1276		1250	
AVERAGE	257	255		250	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	308	315		
PULL #2	301	315		
PULL #3	312	311		
PULL #4	310	307		
PULL #5	311	312		
TOTAL	1542	1560		
AVERAGE	308	312		

	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	422	409		412
PULL #2	405	402		408
PULL #3	418	409		403
PULL #4	419	406		410
PULL #5	406	399		408
TOTAL	2070	2025		2041
AVERAGE	414	405		408

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535420.__0
FILE DATE AND TIME: 05/04/2006 16:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.037
The Average Y Centroid of the Five Target Set:	0.047
The Average Point of Impact of the Five Target Set:	0.060
The Average Mean Radius of the Five Target Set:	0.763
The Distance from POA to Centroid Target #1:	0.086
The Distance from Centroid Target #2 to Centroid Target #1:	0.241
The Distance from Centroid Target #3 to Centroid Target #1:	0.207
The Distance from Centroid Target #4 to Centroid Target #1:	0.079
The Distance from Centroid Target #5 to Centroid Target #1:	0.194

SERIAL NUMBER: G6535420. 0

TARGET NUMBER: 1

FILE DATE: 05/04/2006

FILE TIME: 16:30

POINT#	X	Y
1:	0.062	1.054
2:	0.132	0.684
3:	0.896	0.621
4:	0.345	-0.214
5:	0.485	-0.394
6:	0.566	-0.853
7:	-0.895	0.058
8:	-0.423	-0.405
9:	-0.329	-0.186
10:	-0.143	0.142

X CENTROID: 0.070

Y CENTROID: 0.051

POA TO CENTROID: 0.086

HORZ SPREAD: 1.791

VERT SPREAD: 1.907

GROUP SPREAD: 1.972

MIN RADIUS: 0.231

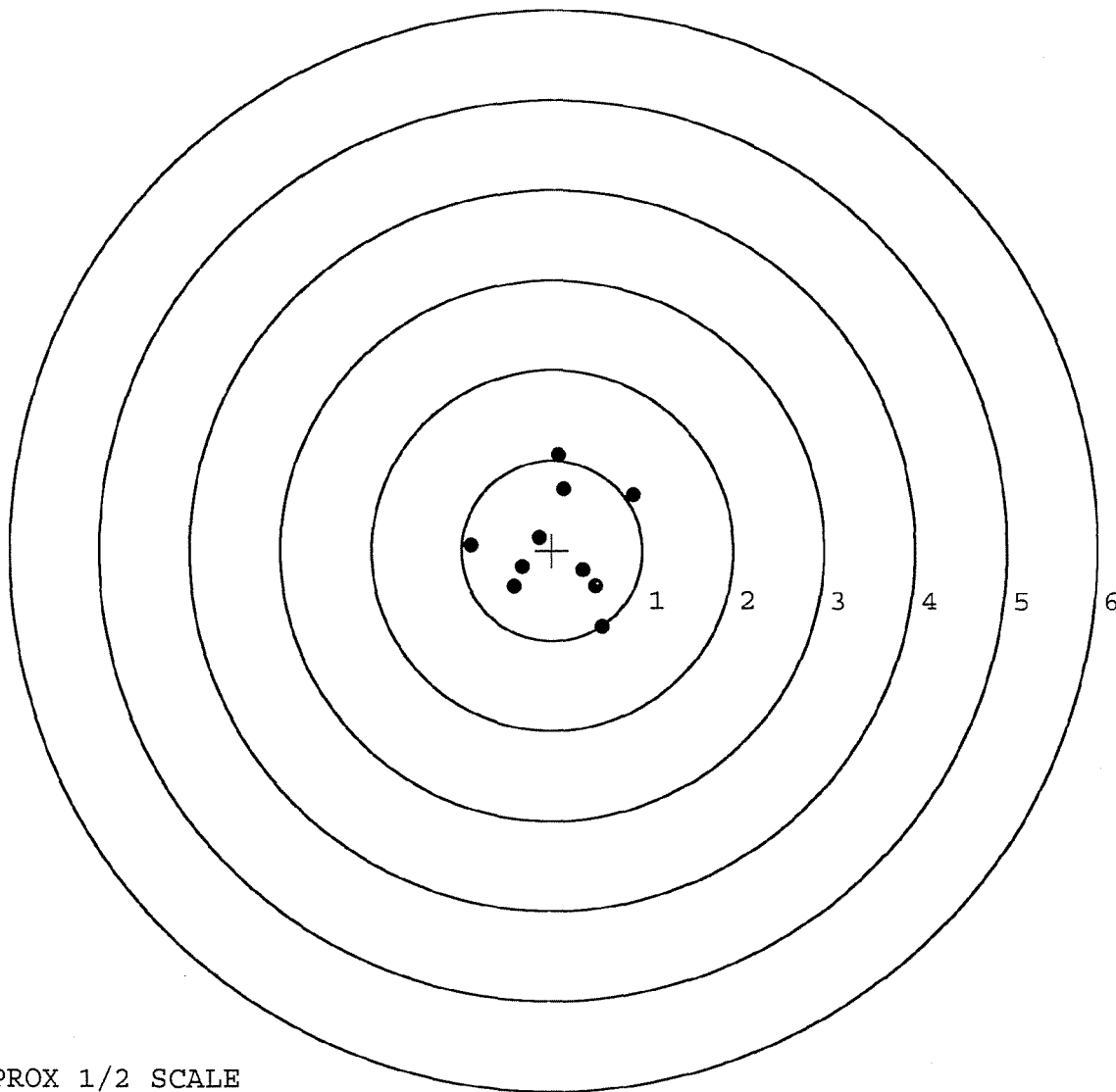
MAX RADIUS: 1.031

MEAN RADIUS: 0.700

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535420. 0

TARGET NUMBER: 2

FILE DATE: 05/04/2006

FILE TIME: 16:30

X CENTROID: -0.161

Y CENTROID: 0.120

POA TO CENTROID: 0.201

HORZ SPREAD: 2.022

VERT SPREAD: 2.616

GROUP SPREAD: 3.120

MIN RADIUS: 0.320

MAX RADIUS: 1.923

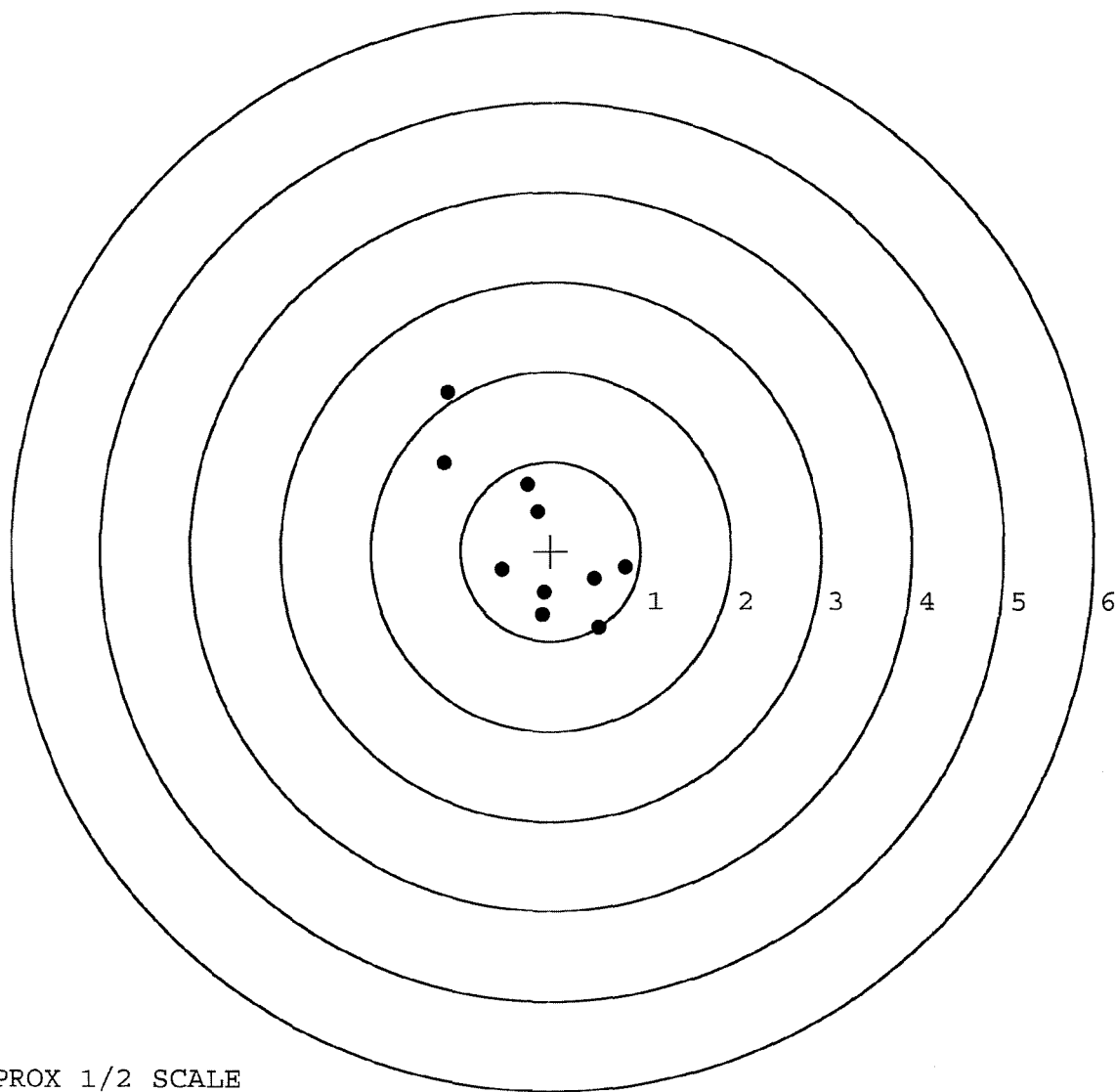
MEAN RADIUS: 0.916

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.075	-0.466
2:	-0.091	-0.712
3:	-0.546	-0.207
4:	0.546	-0.850
5:	0.487	-0.310
6:	0.831	-0.180
7:	-0.152	0.440
8:	-0.260	0.745
9:	-1.191	0.978
10:	-1.155	1.766

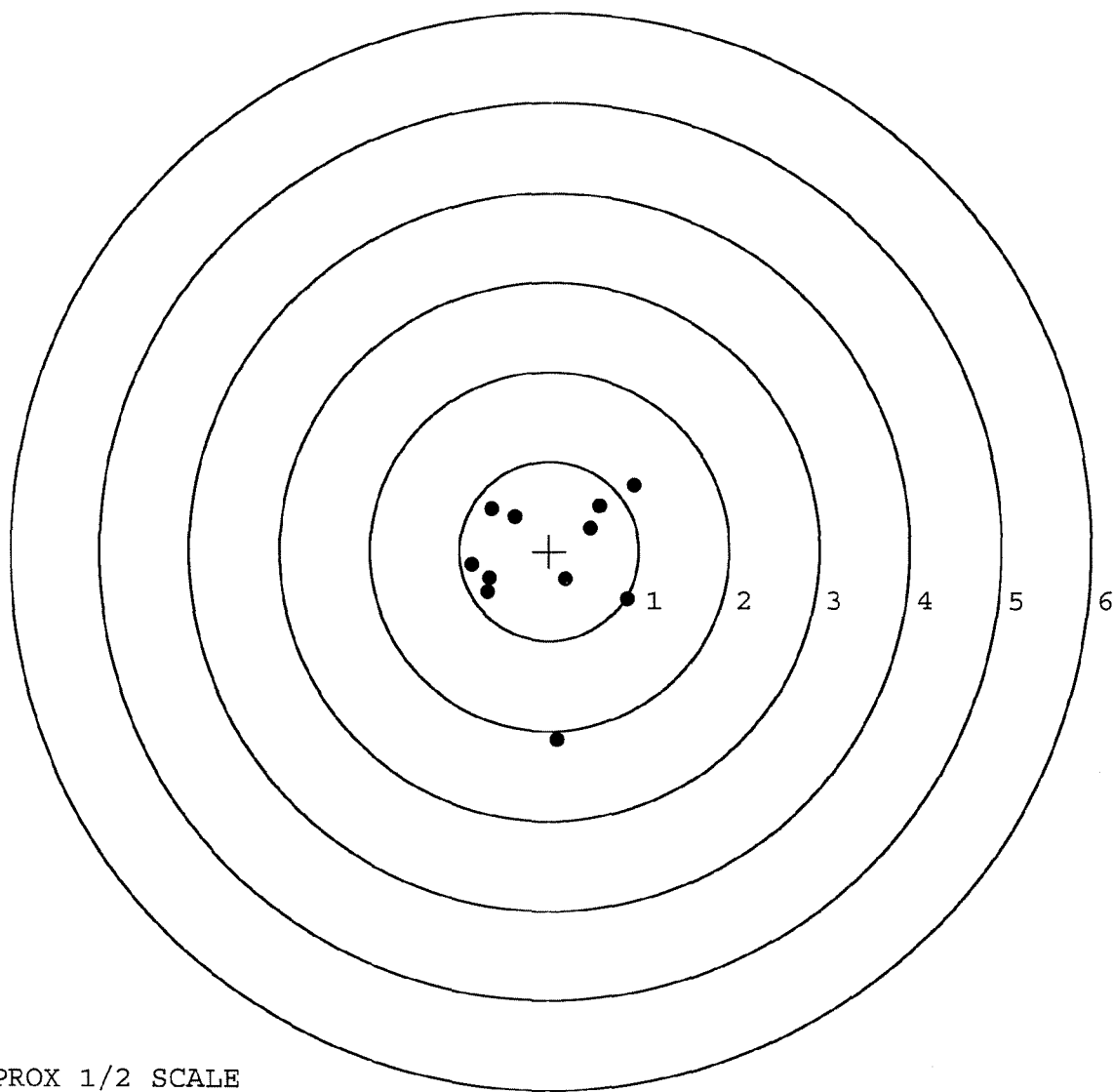


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535420. __0
TARGET NUMBER: 3
FILE DATE: 05/04/2006
FILE TIME: 16:30

X CENTROID: -0.014
Y CENTROID: -0.139
POA TO CENTROID: 0.140
HORZ SPREAD: 1.812
VERT SPREAD: 2.846
GROUP SPREAD: 2.970
MIN RADIUS: 0.266
MAX RADIUS: 1.970
MEAN RADIUS: 0.890
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.098	-2.106
2:	0.872	-0.535
3:	0.185	-0.315
4:	-0.689	-0.465
5:	-0.866	-0.155
6:	-0.653	0.468
7:	0.459	0.255
8:	0.554	0.505
9:	0.946	0.740
10:	-0.393	0.385
11:	-0.667	-0.308



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535420. 0

TARGET NUMBER: 4

FILE DATE: 05/04/2006

FILE TIME: 16:30

POINT#	X	Y
1:	0.243	-0.866
2:	-0.029	-0.994
3:	0.487	-0.202
4:	0.287	-0.057
5:	0.665	0.375
6:	-0.109	0.227
7:	-0.056	0.524
8:	-0.558	0.505
9:	-0.895	0.338
10:	-0.082	0.380

X CENTROID: -0.005

Y CENTROID: 0.023

POA TO CENTROID: 0.023

HORZ SPREAD: 1.560

VERT SPREAD: 1.518

GROUP SPREAD: 1.590

MIN RADIUS: 0.229

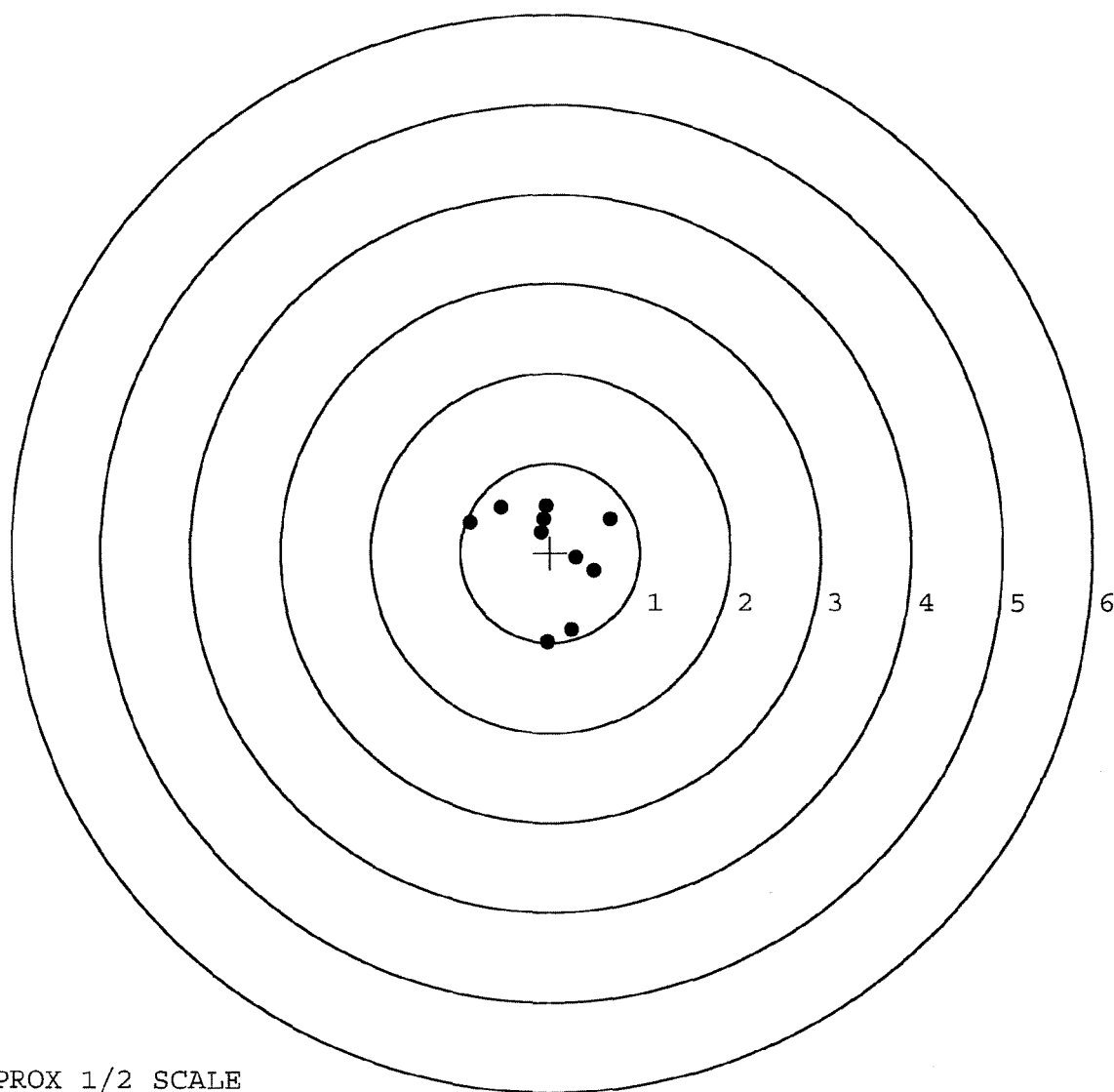
MAX RADIUS: 1.017

MEAN RADIUS: 0.632

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535420. 0

TARGET NUMBER: 5

FILE DATE: 05/04/2006

FILE TIME: 16:30

POINT#	X	Y
1:	0.579	1.000
2:	-0.157	1.347
3:	0.467	-0.712
4:	-0.024	-1.100
5:	-0.397	-0.111
6:	-0.657	0.166
7:	-0.231	0.570
8:	-0.017	0.217
9:	0.150	0.384
10:	-0.480	0.027

X CENTROID: -0.077

Y CENTROID: 0.179

POA TO CENTROID: 0.195

HORZ SPREAD: 1.236

VERT SPREAD: 2.447

GROUP SPREAD: 2.451

MIN RADIUS: 0.071

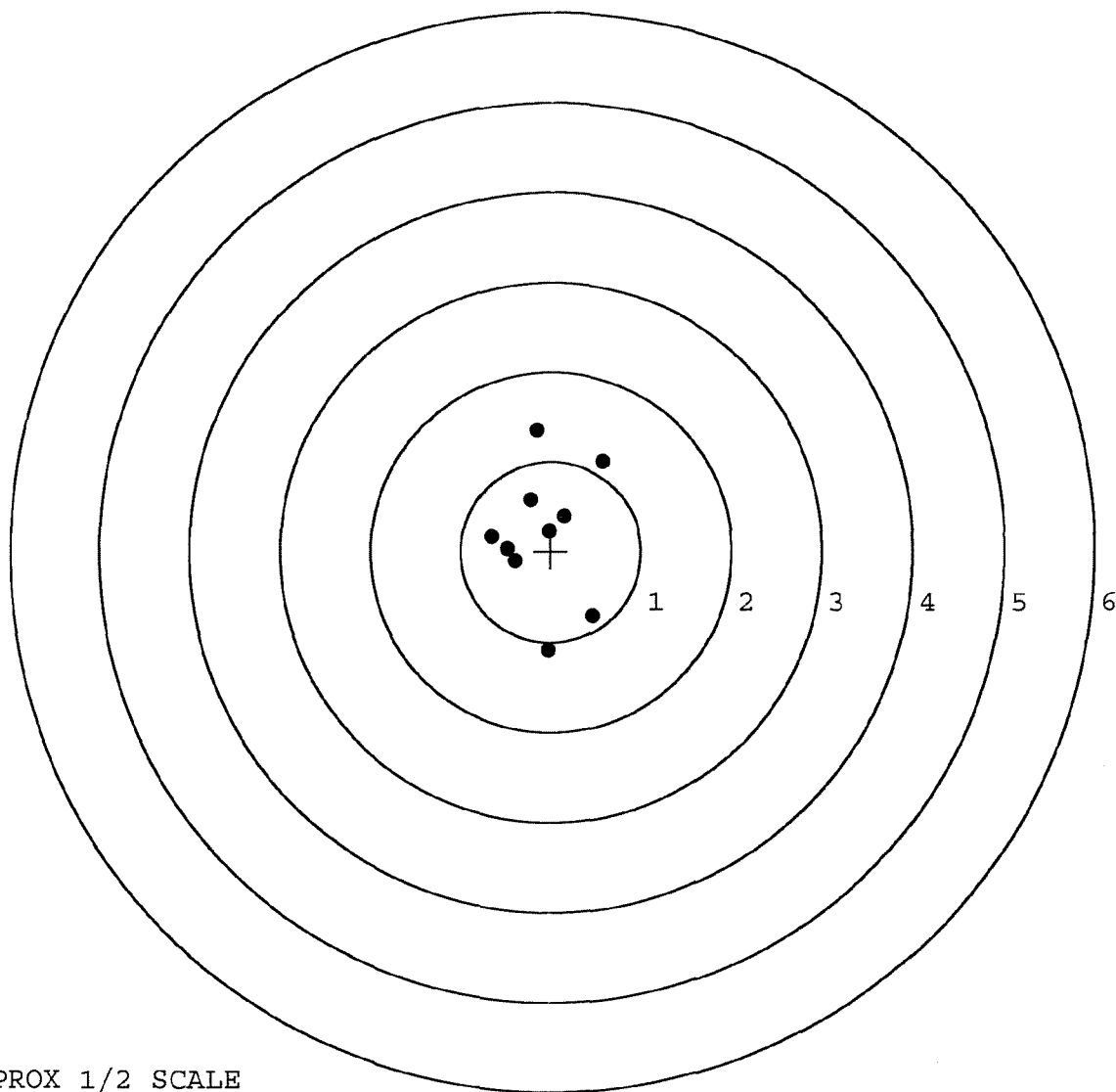
MAX RADIUS: 1.280

MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE