

G-6535434

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



0 47700 25732 7

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SERIAL NO.



G6535434

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 200348



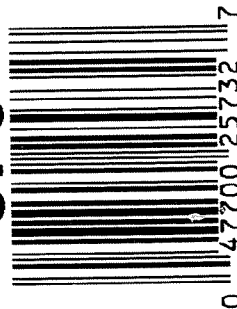
ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6535434

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5434

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-27-06	RTZ
440	PROOF		2/27/06	MPA
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	2/27/06	MPA
470	DIS-ASSEMBLE ACTION		2-28-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 OPERATOR APD	3-1-06	APD
500	ROLLMARK CALIBER		3-1-06	CW
510	DRILL AND TAP SIGHT HOLES		2-28-06	TRC
520	GOFF BLAST BBL / REC		3-2-06	WB
530 & 540	APPLY COATINGS (BARREL ACTION)		3/10	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/17/06	MPA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/17/06	MPA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/17/06	MPA
	D) OIL FIRING PIN ASSEMBLY		4-20-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

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>6-0</u>	4-21-06	RTL
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2-0</u>	4-21-06	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY		4-21-06	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	4-21-06	TKW
	J) ASSEMBLE STOCK		4-20-06	RTL
	K) ASSEMBLE SWIVEL STUDS		4-21-06	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	N/A		
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	4-20-06	TKW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4/20/06	R.P.
670	FINAL INSPECTION A) HEADSPACE		4-21-06	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>268</u> <u>272</u> <u>270</u> <u>268</u> <u>276</u>	4-21-06	RTL
	C) FUNCTION		4-21-06	RTL
690	PACK		4-21-06	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 4-20-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.56	2.40		2.60	
PULL #2	2.43	2.40		2.50	
PULL #3	2.40	2.39		2.56	
PULL #4	2.47	2.40		2.61	
PULL #5	2.46	2.46		2.57	
TOTAL	12.32	12.05		12.84	
AVERAGE	2.46	2.41		2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.18		
PULL #2	3.10	3.13		
PULL #3	3.08	2.92		
PULL #4	3.00	3.10		
PULL #5	3.10	3.11		
TOTAL	15.34	15.44		
AVERAGE	3.06	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	4.12	4.17		4.17
PULL #2	4.13	4.13		4.07
PULL #3	4.19	3.90		4.14
PULL #4	4.19	4.14		4.13
PULL #5	4.14	4.15		4.10
TOTAL	20.77	20.49		20.61
AVERAGE	4.15	4.09		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535434.__0
FILE DATE AND TIME: 04/20/2006 08:35

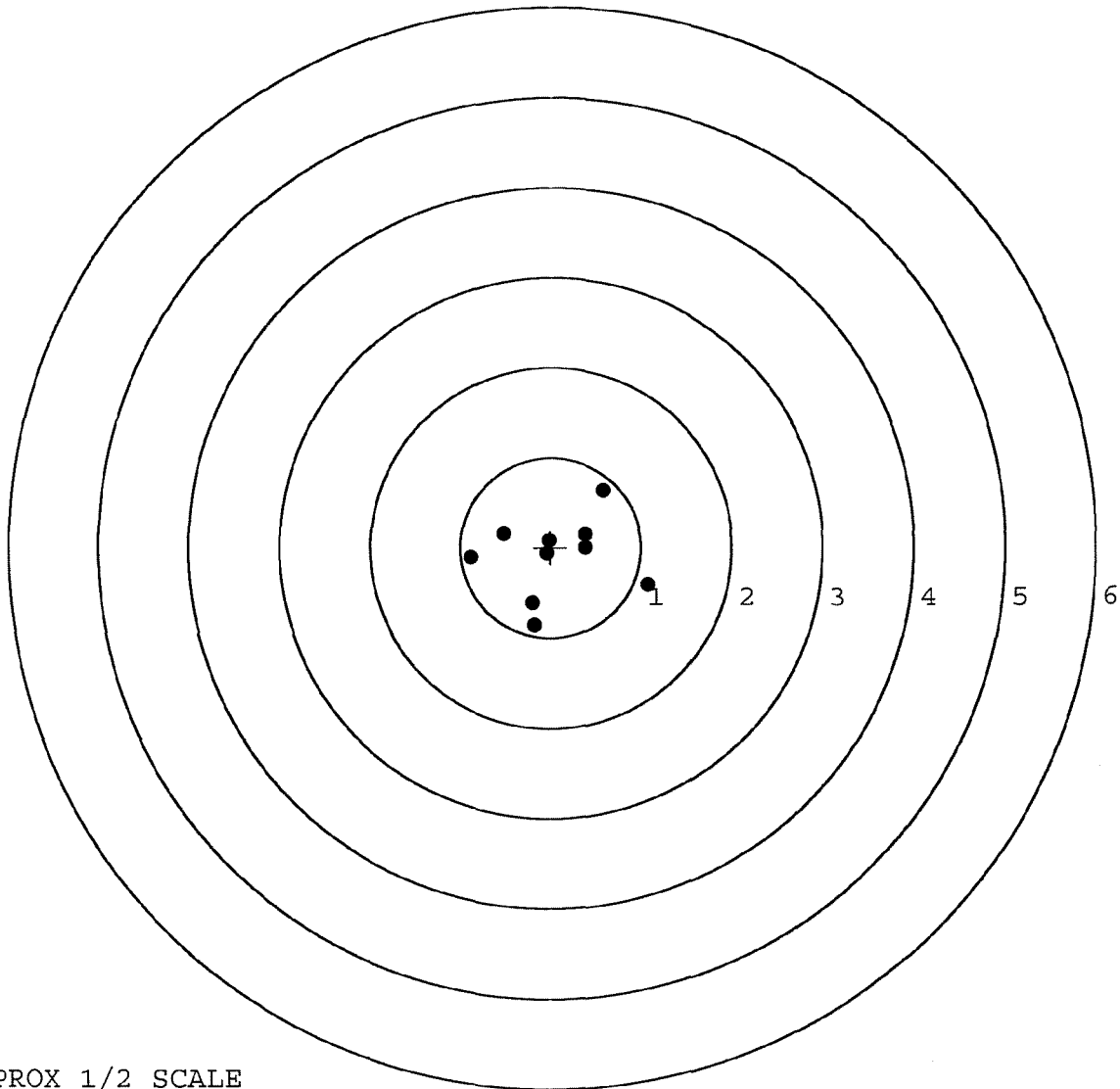
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.056
The Average Y Centroid of the Five Target Set:	0.023
The Average Point of Impact of the Five Target Set:	0.060
The Average Mean Radius of the Five Target Set:	0.681
The Distance from POA to Centroid Target #1:	0.123
The Distance from Centroid Target #2 to Centroid Target #1:	0.138
The Distance from Centroid Target #3 to Centroid Target #1:	0.359
The Distance from Centroid Target #4 to Centroid Target #1:	0.127
The Distance from Centroid Target #5 to Centroid Target #1:	0.054

SERIAL NUMBER: G6535434. __0
TARGET NUMBER: 1
FILE DATE: 04/20/2006
FILE TIME: 08:35

X CENTROID: 0.059
Y CENTROID: -0.108
POA TO CENTROID: 0.123
HORZ SPREAD: 1.960
VERT SPREAD: 1.506
GROUP SPREAD: 1.984
MIN RADIUS: 0.112
MAX RADIUS: 1.063
MEAN RADIUS: 0.601
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.074	-0.424
2:	-0.181	-0.872
3:	-0.204	-0.624
4:	0.388	0.153
5:	0.391	-0.002
6:	-0.016	0.079
7:	-0.045	-0.067
8:	0.585	0.634
9:	-0.518	0.158
10:	-0.886	-0.116



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535434. __ 0

TARGET NUMBER: 2

FILE DATE: 04/20/2006

FILE TIME: 08:35

POINT#	X	Y
1:	0.632	-0.564
2:	0.225	-0.761
3:	0.110	-0.317
4:	-0.582	-0.218
5:	-0.362	0.273
6:	-0.146	1.293
7:	0.147	0.510
8:	0.321	0.311
9:	0.402	0.125
10:	0.375	-0.459

X CENTROID: 0.112

Y CENTROID: 0.019

POA TO CENTROID: 0.114

HORZ SPREAD: 1.214

VERT SPREAD: 2.054

GROUP SPREAD: 2.087

MIN RADIUS: 0.308

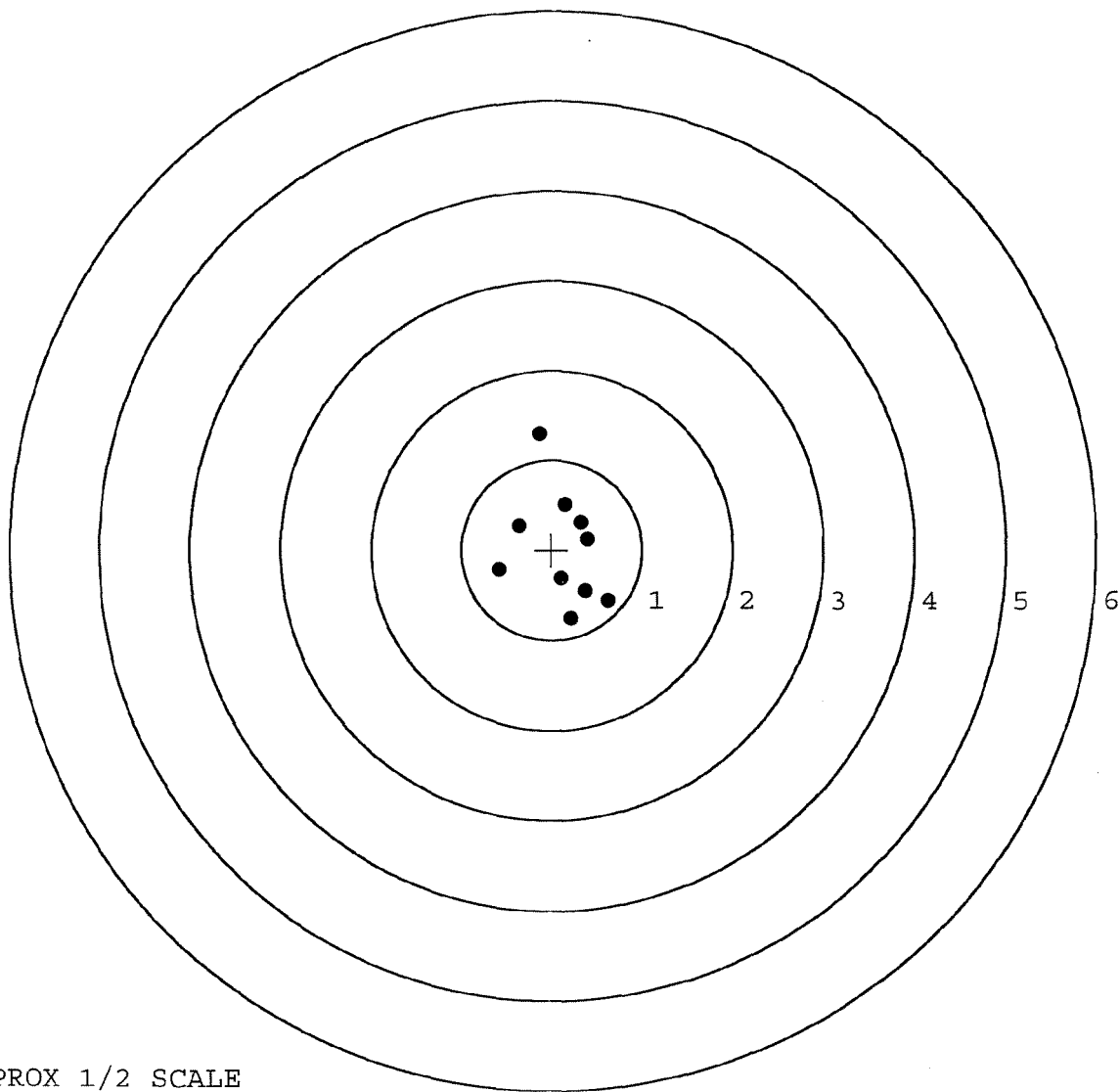
MAX RADIUS: 1.300

MEAN RADIUS: 0.618

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

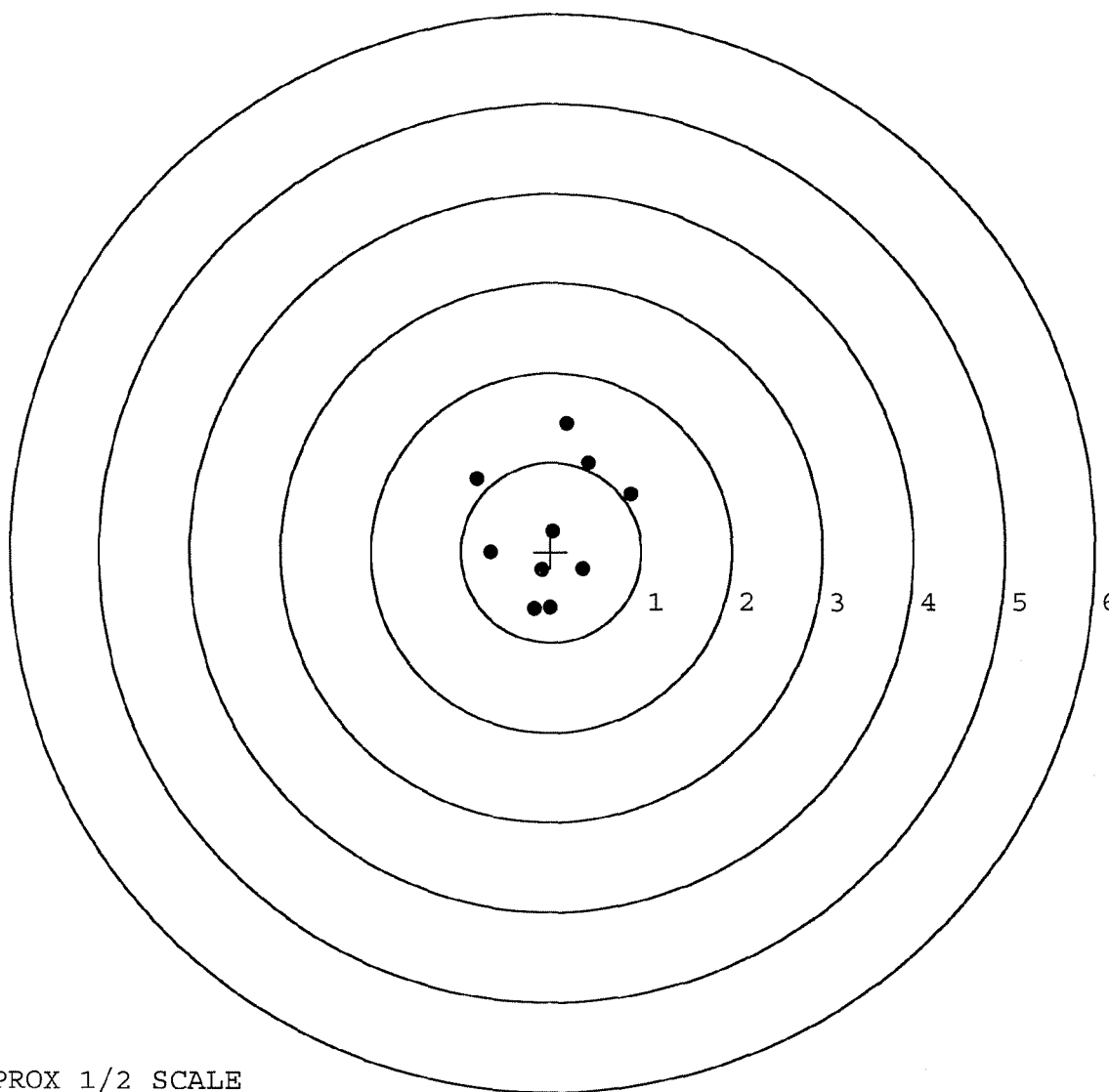


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535434. __0
TARGET NUMBER: 3
FILE DATE: 04/20/2006
FILE TIME: 08:35

POINT#	X	Y
1:	0.884	0.651
2:	0.409	0.994
3:	0.171	1.437
4:	-0.826	0.815
5:	-0.671	-0.009
6:	0.022	0.232
7:	0.356	-0.191
8:	-0.105	-0.204
9:	-0.186	-0.634
10:	-0.013	-0.623

X CENTROID: 0.004
Y CENTROID: 0.247
POA TO CENTROID: 0.247
HORZ SPREAD: 1.710
VERT SPREAD: 2.071
GROUP SPREAD: 2.102
MIN RADIUS: 0.023
MAX RADIUS: 1.202
MEAN RADIUS: 0.757
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535434. __ 0

TARGET NUMBER: 4

FILE DATE: 04/20/2006

FILE TIME: 08:35

POINT#	X	Y
1:	1.381	0.139
2:	0.672	-0.205
3:	0.277	-0.741
4:	0.140	-0.962
5:	0.182	0.432
6:	-0.013	0.875
7:	-0.311	0.542
8:	-0.377	0.149
9:	-0.275	-0.061
10:	-0.991	0.017

X CENTROID: 0.068

Y CENTROID: 0.018

POA TO CENTROID: 0.071

HORZ SPREAD: 2.372

VERT SPREAD: 1.837

GROUP SPREAD: 2.375

MIN RADIUS: 0.353

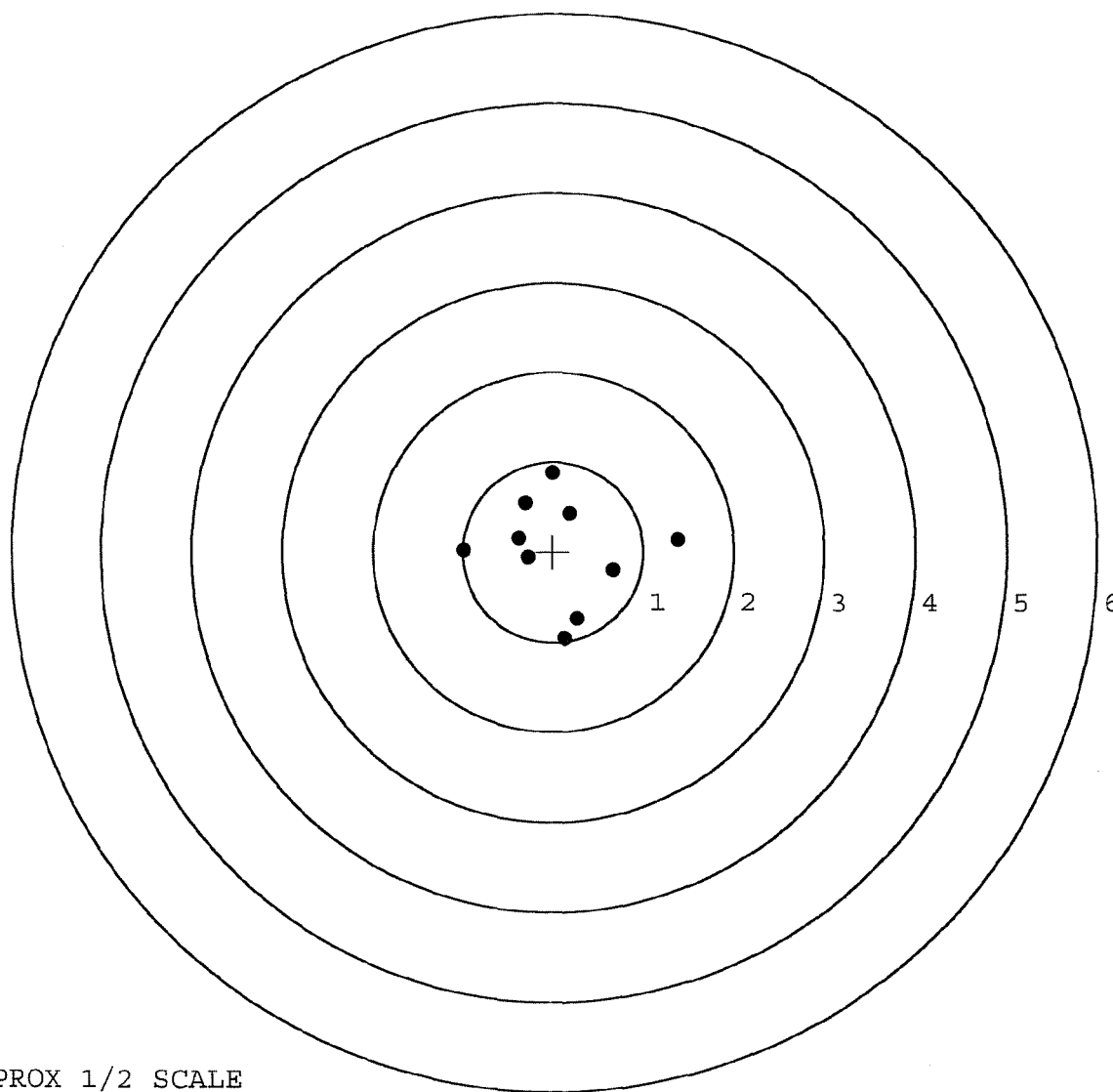
MAX RADIUS: 1.318

MEAN RADIUS: 0.754

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535434. __0

TARGET NUMBER: 5

FILE DATE: 04/20/2006

FILE TIME: 08:35

POINT#	X	Y
1:	-0.299	0.520
2:	-0.696	0.514
3:	-1.065	0.589
4:	0.303	0.306
5:	0.464	-0.177
6:	0.736	-0.255
7:	0.023	-0.368
8:	0.064	-0.924
9:	0.612	-0.375
10:	0.198	-0.434

X CENTROID: 0.034

Y CENTROID: -0.060

POA TO CENTROID: 0.069

HORZ SPREAD: 1.801

VERT SPREAD: 1.513

GROUP SPREAD: 1.989

MIN RADIUS: 0.308

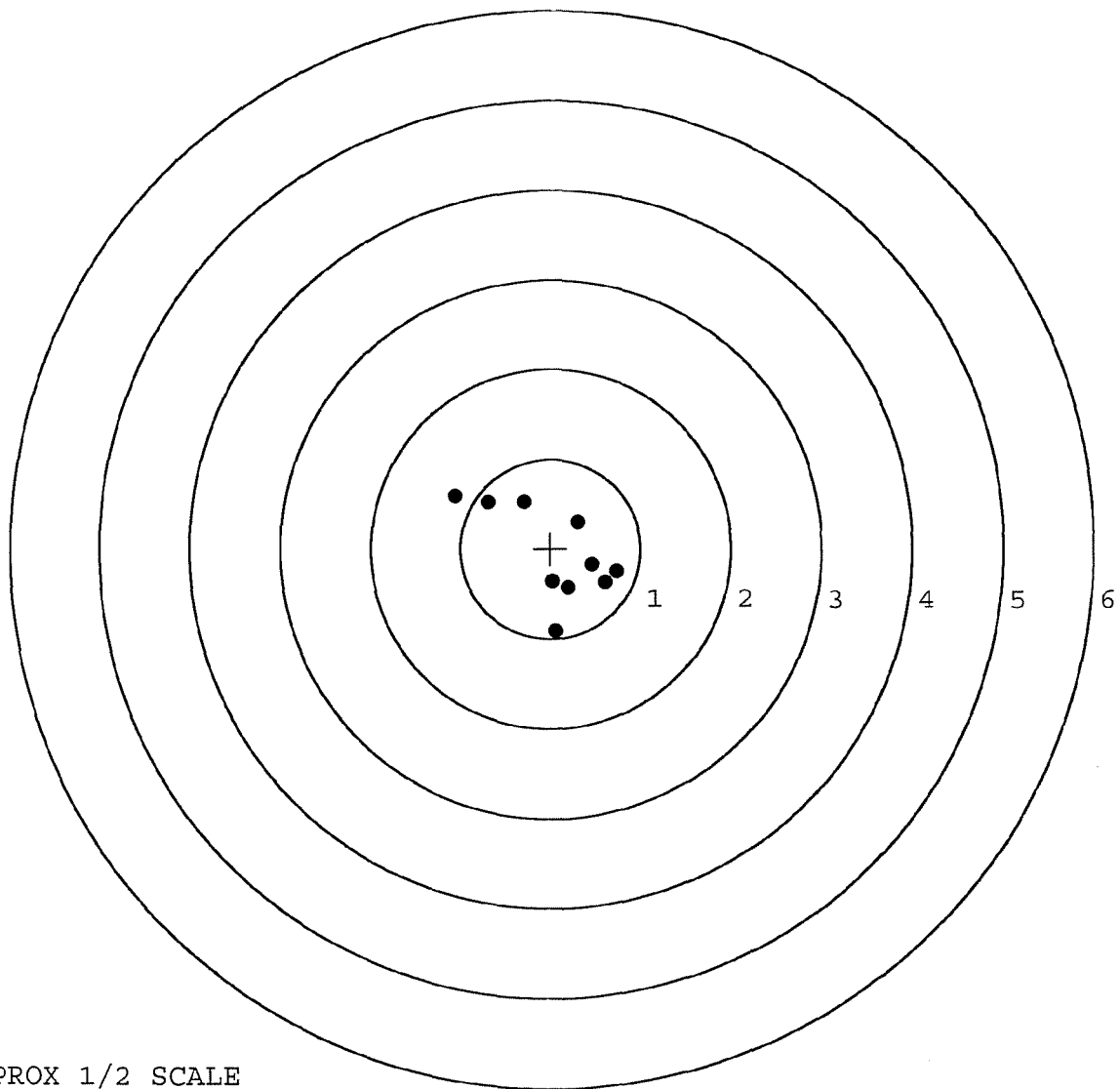
MAX RADIUS: 1.277

MEAN RADIUS: 0.674

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE