

G652 1146

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



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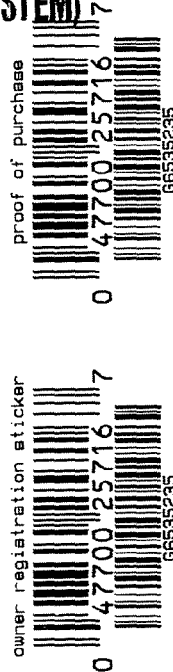
SERIAL NO.



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

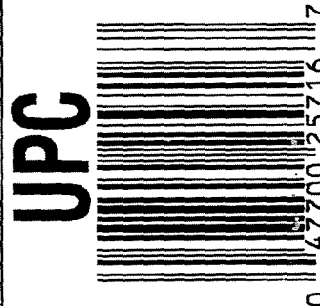
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6535235



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521166

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-27-06	RTZ
440	PROOF		1-27-06	AE
460	CHECK HEADSPACE	MAGNA-FLUX	1-27-06	AE
470	DIS-ASSEMBLE ACTION	INSPECTED	1-28-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 JAN 31 2006 OPERATOR <u>CPD</u>	1-31-06	APJ
500	ROLLMARK CALIBER		1-31-06	CW
510	DRILL AND TAP SIGHT HOLES		1-30-06	TRW
520	GOFF BLAST BBL / REC		2/1/06	JS
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		2/10/06	EB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2/20/06	MPJ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2/20/06	MPJ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2/20/06	MPJ
	D) OIL FIRING PIN ASSEMBLY		3-10-06	AE
	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>5.5</u> <u>5.5</u> <u>6.0</u>	3-14-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	3-14-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.023</u> <u>1.022</u> <u>1.022</u>	3-14-06	DA
	J) ASSEMBLE STOCK		3-10-06	AC
	K) ASSEMBLE SWIVEL STUDS		3/29/06	MMJ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-10-06	AC
	M) IRON SIGHT ALIGNMENT		3-10-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-10-06	AC
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	3-13-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-13-06	MMJ
670	FINAL INSPECTION A) HEADSPACE		3/29/06	MMJ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u> <u>2.18</u> <u>2.28</u> <u>2.25</u> <u>2.32</u>	3-14-06	DA
	C) FUNCTION		3/29/06	MMJ
690	PACK		3-30-06	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 3-9-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.34		2.52	
PULL #2	2.52	2.54		2.50	
PULL #3	2.66	2.59		2.52	
PULL #4	2.66	2.44		2.46	
PULL #5	2.67	2.57		2.50	
TOTAL	12.99	12.48		12.50	
AVERAGE	2.59	2.49		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.04		
PULL #2	3.03	2.91		
PULL #3	3.15	2.94		
PULL #4	3.00	2.97		
PULL #5	3.06	2.97		
TOTAL	15.29	14.83		
AVERAGE	3.05	2.96		

	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	3.90 4.10	3.98		4.16
PULL #2	4.04	4.09		4.13
PULL #3	4.04	4.01		4.10
PULL #4	4.01	3.92		4.19
PULL #5	4.06	3.95		4.06
TOTAL	20.25	19.95		20.64
AVERAGE	4.05	3.99		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521166.__0
FILE DATE AND TIME: 03/13/2006 15:57

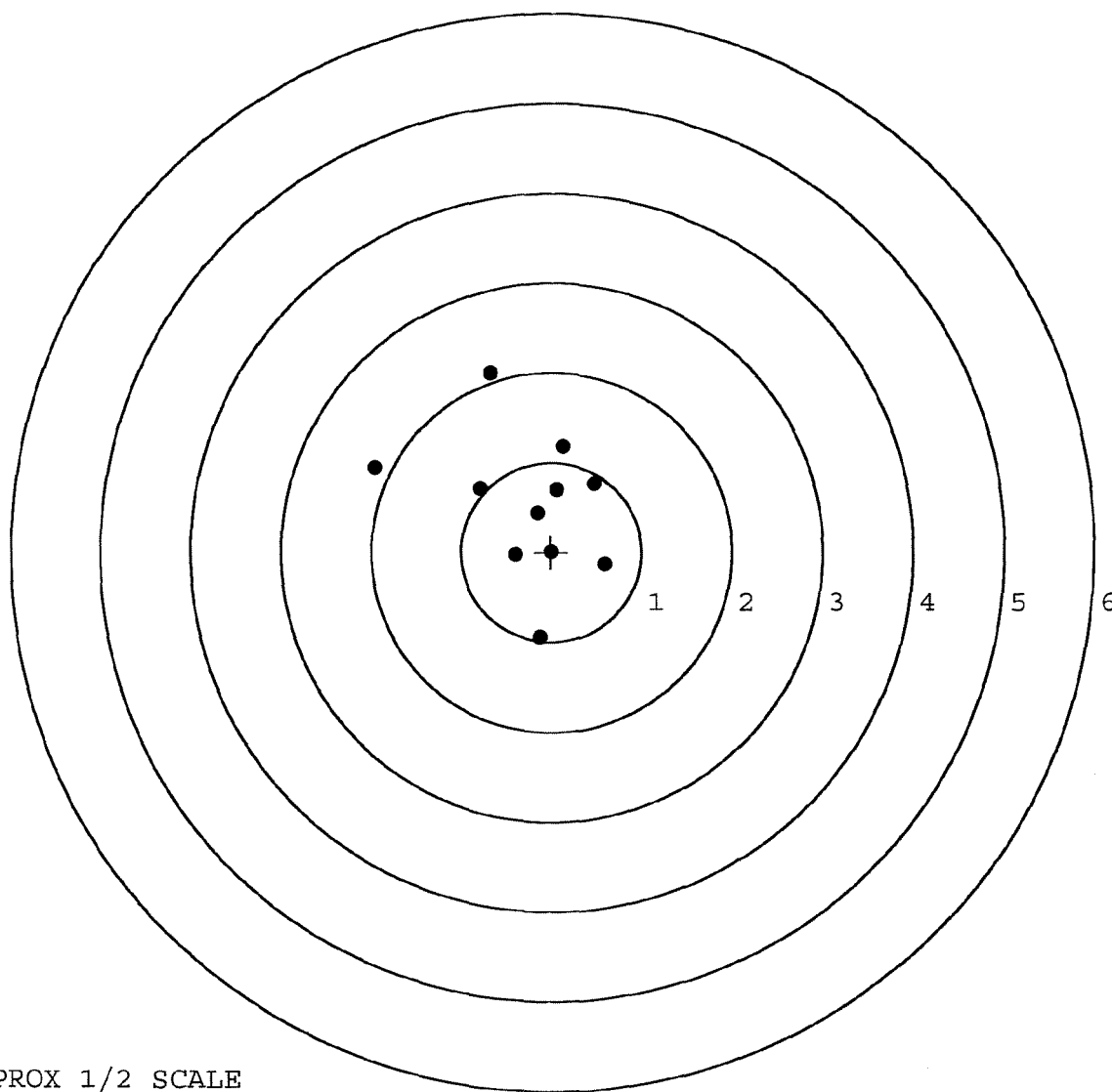
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.203
The Average Y Centroid of the Five Target Set:	-0.020
The Average Point of Impact of the Five Target Set:	0.204
The Average Mean Radius of the Five Target Set:	0.747
The Distance from POA to Centroid Target #1:	0.571
The Distance from Centroid Target #2 to Centroid Target #1:	0.867
The Distance from Centroid Target #3 to Centroid Target #1:	0.540
The Distance from Centroid Target #4 to Centroid Target #1:	0.685
The Distance from Centroid Target #5 to Centroid Target #1:	0.589

SERIAL NUMBER: G6521166. __0
TARGET NUMBER: 1
FILE DATE: 03/13/2006
FILE TIME: 15:57

POINT#	X	Y
1:	0.003	0.002
2:	-0.123	-0.955
3:	0.599	-0.135
4:	-0.394	-0.040
5:	0.476	0.773
6:	-0.157	0.434
7:	0.129	1.175
8:	-0.788	0.712
9:	-1.969	0.938
10:	-0.689	1.992
11:	0.064	0.699

X CENTROID: -0.259
Y CENTROID: 0.509
POA TO CENTROID: 0.571
HORZ SPREAD: 2.568
VERT SPREAD: 2.947
GROUP SPREAD: 2.783
MIN RADIUS: 0.126
MAX RADIUS: 1.763
MEAN RADIUS: 0.873
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521166. 0

TARGET NUMBER: 2

FILE DATE: 03/13/2006

FILE TIME: 15:57

POINT#	X	Y
1:	0.847	-2.185
2:	-0.044	-1.080
3:	0.091	-0.765
4:	0.400	-0.565
5:	0.209	-0.158
6:	-0.369	-0.012
7:	-0.795	-0.038
8:	-1.096	-0.136
9:	-1.683	-0.124
10:	-0.254	1.482

X CENTROID: -0.269

Y CENTROID: -0.358

POA TO CENTROID: 0.448

HORZ SPREAD: 2.530

VERT SPREAD: 3.667

GROUP SPREAD: 3.829

MIN RADIUS: 0.360

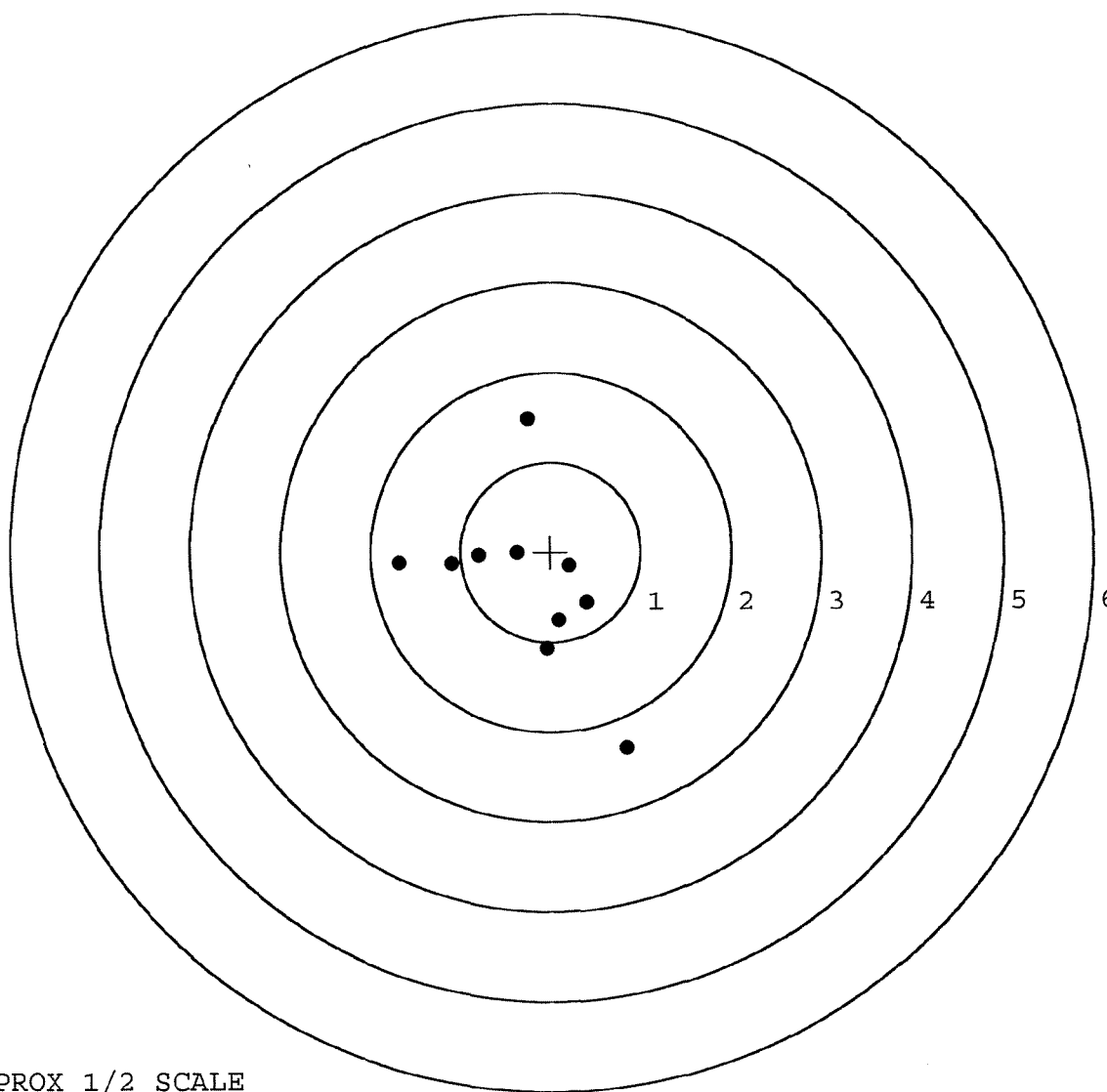
MAX RADIUS: 2.141

MEAN RADIUS: 0.976

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

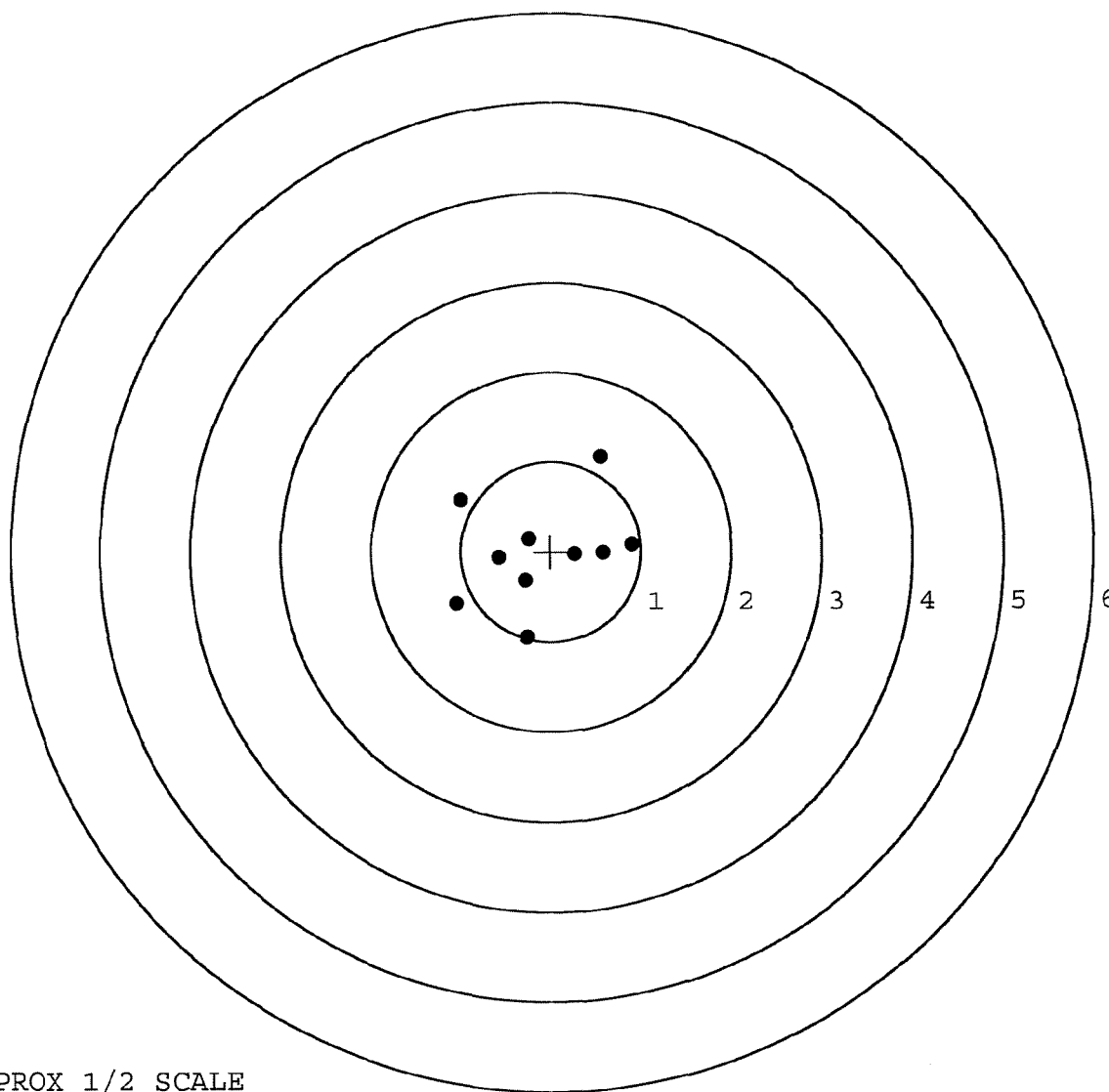


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521166.___0
TARGET NUMBER: 3
FILE DATE: 03/13/2006
FILE TIME: 15:57

X CENTROID: -0.111
Y CENTROID: -0.010
POA TO CENTROID: 0.112
HORZ SPREAD: 1.952
VERT SPREAD: 2.010
GROUP SPREAD: 2.297
MIN RADIUS: 0.204
MAX RADIUS: 1.258
MEAN RADIUS: 0.751
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.262	-0.954
2:	-0.283	-0.320
3:	-1.052	-0.584
4:	-0.576	-0.065
5:	-0.244	0.144
6:	0.270	-0.031
7:	0.585	-0.011
8:	0.900	0.085
9:	0.557	1.056
10:	-1.006	0.577



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521166. __0

TARGET NUMBER: 4

FILE DATE: 03/13/2006

FILE TIME: 15:57

POINT#	X	Y
1:	0.455	-0.802
2:	0.618	-0.134
3:	0.621	0.158
4:	-0.207	-0.588
5:	-0.137	-0.293
6:	-0.809	-0.501
7:	-0.707	-0.225
8:	-0.267	0.170
9:	-0.540	0.980
10:	-0.214	-0.385

X CENTROID: -0.119

Y CENTROID: -0.162

POA TO CENTROID: 0.201

HORZ SPREAD: 1.430

VERT SPREAD: 1.782

GROUP SPREAD: 2.041

MIN RADIUS: 0.132

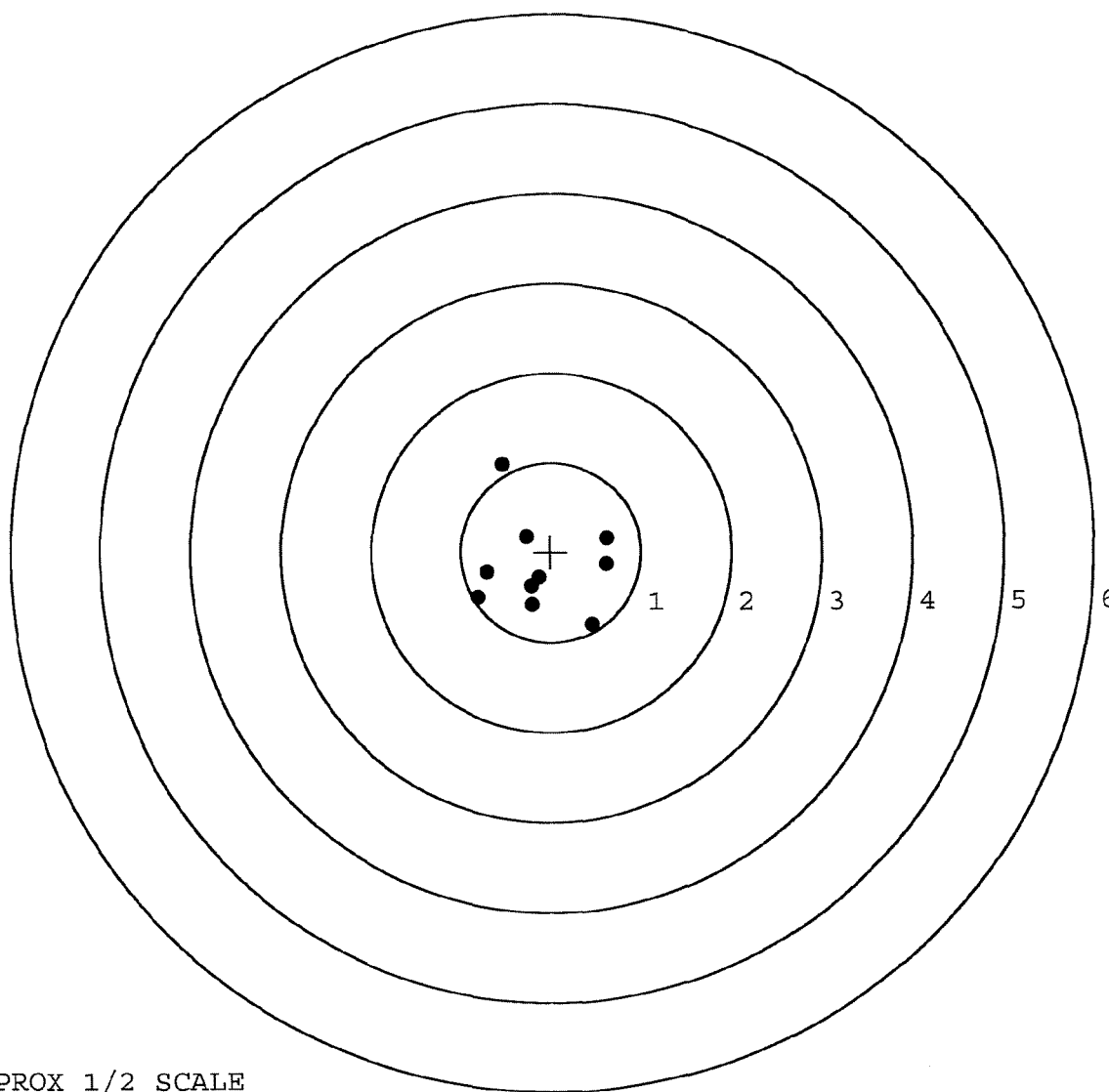
MAX RADIUS: 1.217

MEAN RADIUS: 0.615

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521166. 0

TARGET NUMBER: 5

FILE DATE: 03/13/2006

FILE TIME: 15:57

POINT#	X	Y
1:	-0.322	0.297
2:	-0.801	0.292
3:	-0.801	0.172
4:	-0.897	-0.066
5:	-0.561	-0.146
6:	-0.314	-0.165
7:	-0.184	-0.324
8:	0.096	-0.348
9:	0.332	-0.394
10:	0.877	-0.125

X CENTROID: -0.257

Y CENTROID: -0.081

POA TO CENTROID: 0.270

HORZ SPREAD: 1.774

VERT SPREAD: 0.691

GROUP SPREAD: 1.775

MIN RADIUS: 0.101

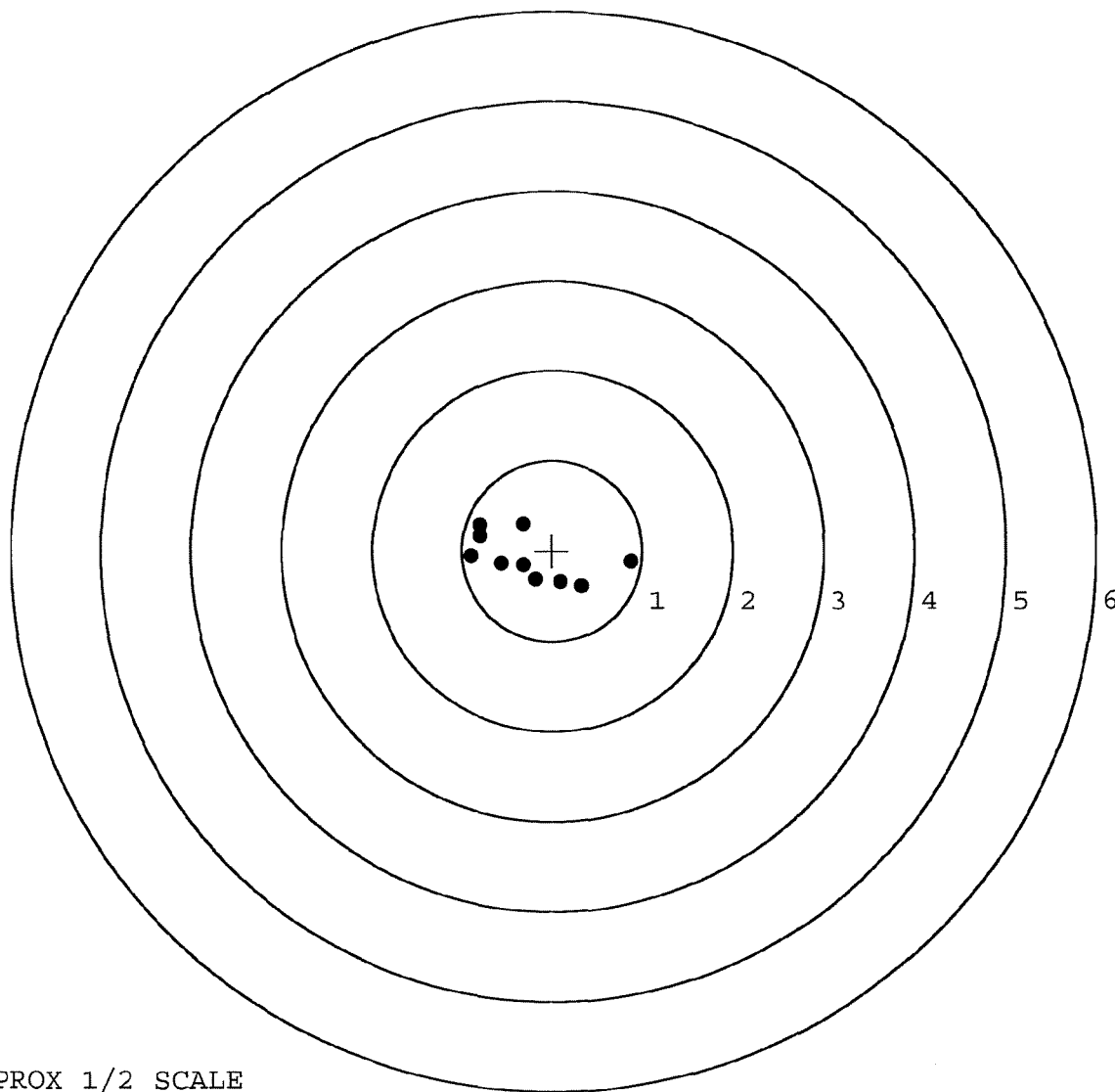
MAX RADIUS: 1.135

MEAN RADIUS: 0.519

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE