

G 652 1173

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

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



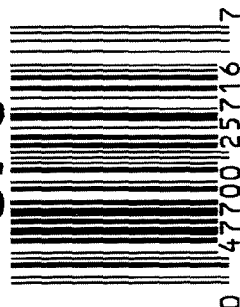
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521173

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521173

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/20/05	CO
440	PROOF		10/20/05	CO
460	CHECK HEADSPACE		10/20/05	CO
470	DIS-ASSEMBLE ACTION		10/20/05	CO
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	9/80 unus	10/20/05	unus
500	ROLLMARK CALIBER		10/20/05	CW
510	DRILL AND TAP SIGHT HOLES		10/26/05	BR
520	GOFF BLAST BBL / REC		10-28-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		11/3/05	RB
	(BOLT)		11/3/05	RB
560	RE-ASSEMBLE ACTION		11-11-05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/4/05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/4/05	MTM
	D) OIL FIRING PIN ASSEMBLY		11-17-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-20-05	AC

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6</u> lbs <u>6</u> lbs <u>6</u> lbs	12-7-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> lbs <u>4</u> lbs <u>4</u> lbs	12-7-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	12-7-05	AC
	J) ASSEMBLE STOCK		11-17-05	RTL
	K) ASSEMBLE SWIVEL STUDS		12-7-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-18-05	BG
	M) IRON SIGHT ALIGNMENT		11-18-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-18-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11/30/05	9R99
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/30/05	WOM
670	FINAL INSPECTION A) HEADSPACE		12-7-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.53</u> <u>2.66</u> <u>2.57</u> <u>2.64</u>	12-5-05	TRW
	C) FUNCTION		12-7-05	AC
690	PACK		2/13/06	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)

SERIAL NO. _____

DATE 11-17-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.55		2.54	
PULL #2	2.52	2.50		2.59	
PULL #3	2.55	2.49		2.60	
PULL #4	2.53	2.51		2.51	
PULL #5	2.58	2.54		2.63	
TOTAL	12.69	12.59		12.87	
AVERAGE	2.53	2.51		2.57	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.08		
PULL #2	3.10	3.10		
PULL #3	3.17	3.15		
PULL #4	3.06	3.08		
PULL #5	3.11	3.05		
TOTAL	15.53	15.46		
AVERAGE	3.10	3.09		

	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	4.00	3.97		3.97
PULL #2	4.06	4.00		3.98
PULL #3	4.02	4.08		4.02
PULL #4	3.99	4.05		4.02
PULL #5	4.05	4.06		3.99
TOTAL	20.12	20.16		19.98
AVERAGE	4.02	4.03		3.99

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521173.___0
FILE DATE AND TIME: 11/30/2005 23:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.149
The Average Y Centroid of the Five Target Set:	0.053
The Average Point of Impact of the Five Target Set:	0.158
The Average Mean Radius of the Five Target Set:	0.783
The Distance from POA to Centroid Target #1:	0.436
The Distance from Centroid Target #2 to Centroid Target #1:	0.596
The Distance from Centroid Target #3 to Centroid Target #1:	0.444
The Distance from Centroid Target #4 to Centroid Target #1:	0.138
The Distance from Centroid Target #5 to Centroid Target #1:	0.458

SERIAL NUMBER: G6521173. __0

TARGET NUMBER: 1

FILE DATE: 11/30/2005

FILE TIME: 23:13

X CENTROID: 0.353

Y CENTROID: 0.255

POA TO CENTROID: 0.436

HORZ SPREAD: 2.216

VERT SPREAD: 1.459

GROUP SPREAD: 2.227

MIN RADIUS: 0.086

MAX RADIUS: 1.374

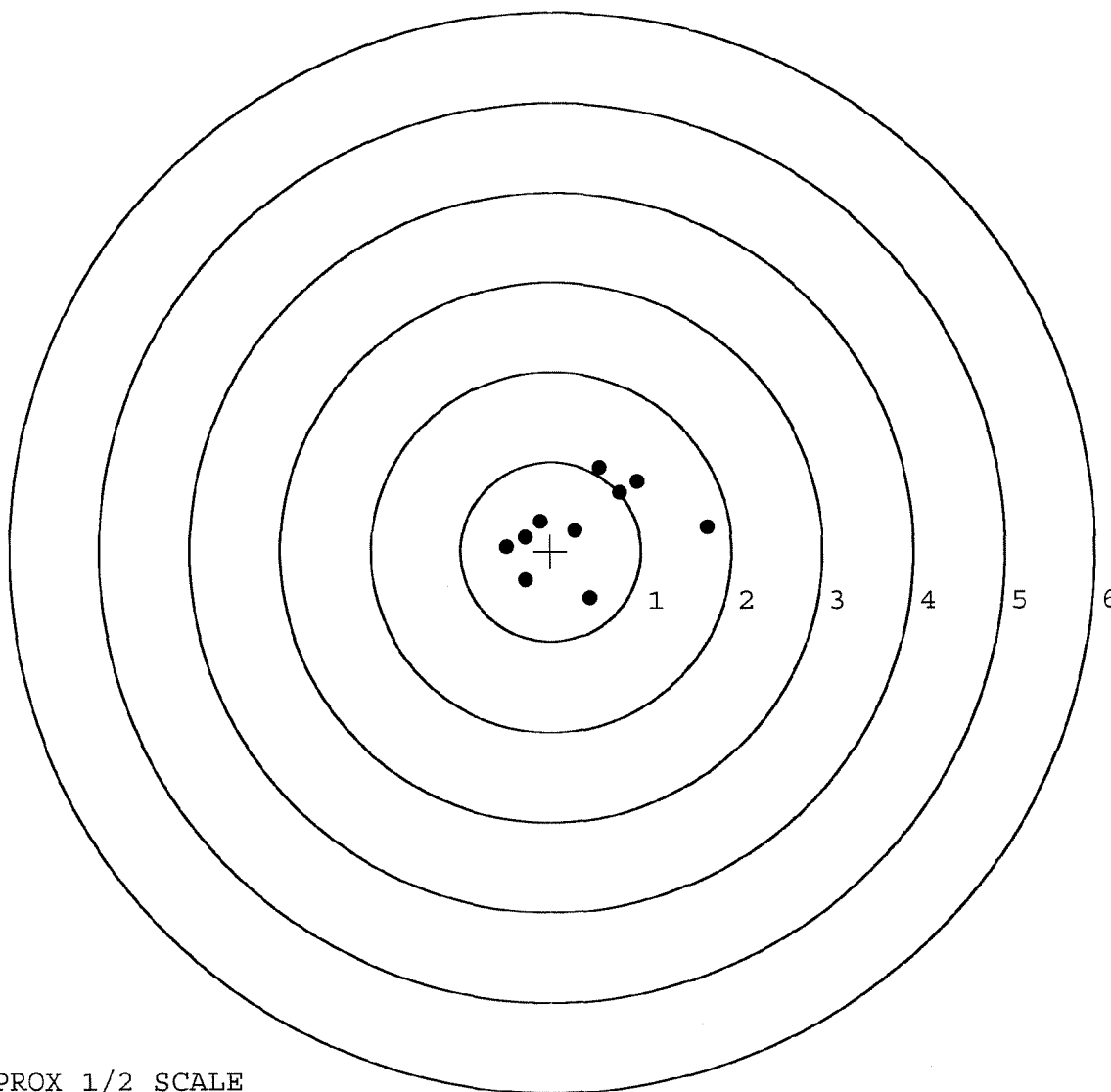
MEAN RADIUS: 0.718

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.286	-0.331
2:	-0.489	0.051
3:	-0.120	0.333
4:	0.271	0.228
5:	0.439	-0.524
6:	0.764	0.659
7:	0.958	0.777
8:	0.545	0.935
9:	1.727	0.270
10:	-0.280	0.154

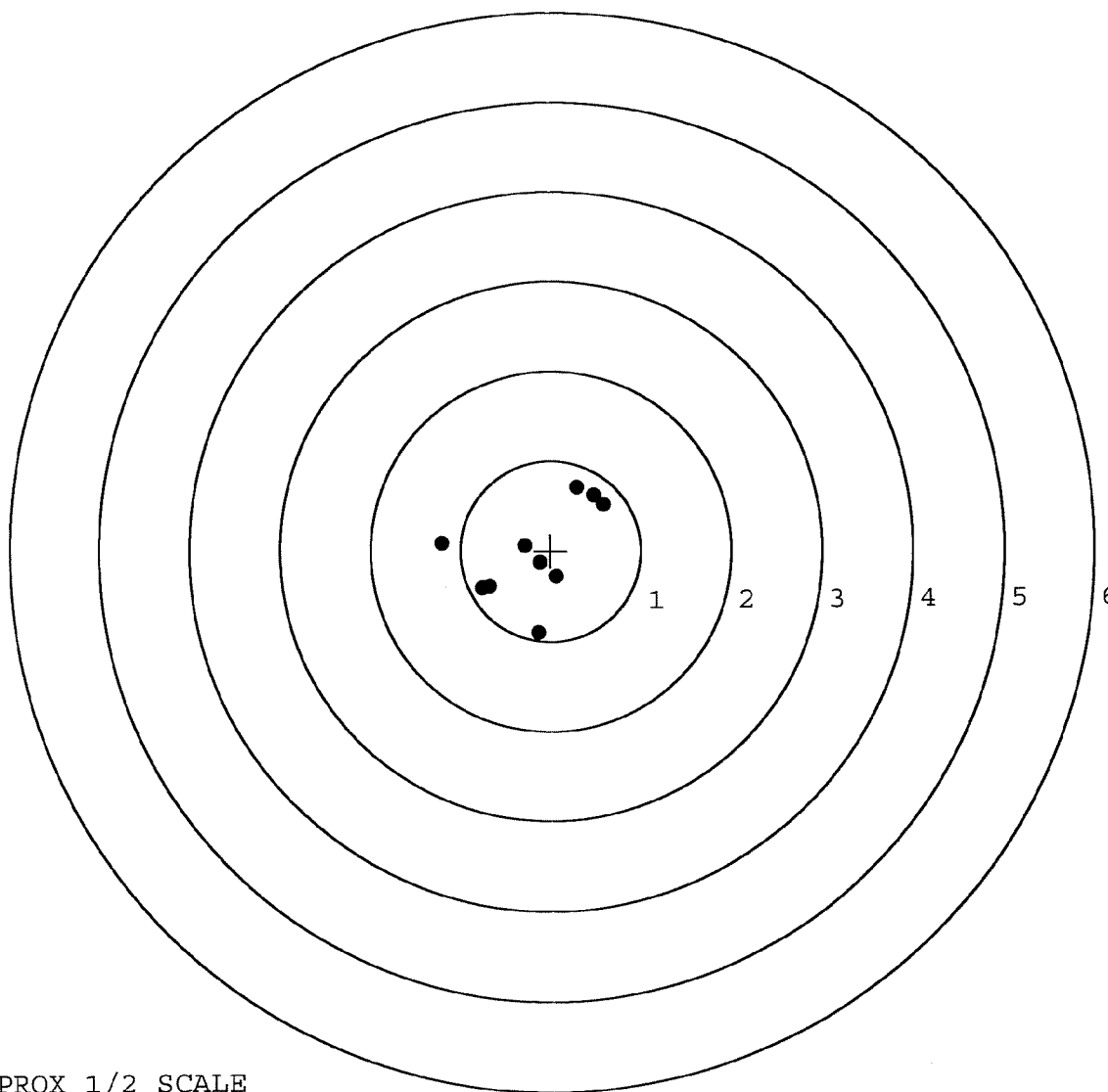


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521173.___0
TARGET NUMBER: 2
FILE DATE: 11/30/2005
FILE TIME: 23:13

X CENTROID: -0.178
Y CENTROID: -0.016
POA TO CENTROID: 0.179
HORZ SPREAD: 1.801
VERT SPREAD: 1.613
GROUP SPREAD: 1.850
MIN RADIUS: 0.132
MAX RADIUS: 1.038
MEAN RADIUS: 0.661
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.063	-0.289
2:	-0.122	-0.139
3:	-0.288	0.057
4:	-0.686	-0.389
5:	-0.143	-0.908
6:	-1.211	0.090
7:	0.299	0.705
8:	0.481	0.614
9:	0.590	0.512
10:	-0.765	-0.409



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521173. __0

TARGET NUMBER: 3

FILE DATE: 11/30/2005

FILE TIME: 23:13

POINT#	X	Y
1:	0.299	0.215
2:	-0.324	0.406
3:	-0.987	-0.081
4:	-0.956	-0.754
5:	-0.743	-1.179
6:	0.523	0.435
7:	0.709	0.206
8:	0.909	-0.060
9:	0.879	-0.805
10:	1.430	0.106

X CENTROID: 0.174

Y CENTROID: -0.151

POA TO CENTROID: 0.230

HORZ SPREAD: 2.417

VERT SPREAD: 1.614

GROUP SPREAD: 2.525

MIN RADIUS: 0.387

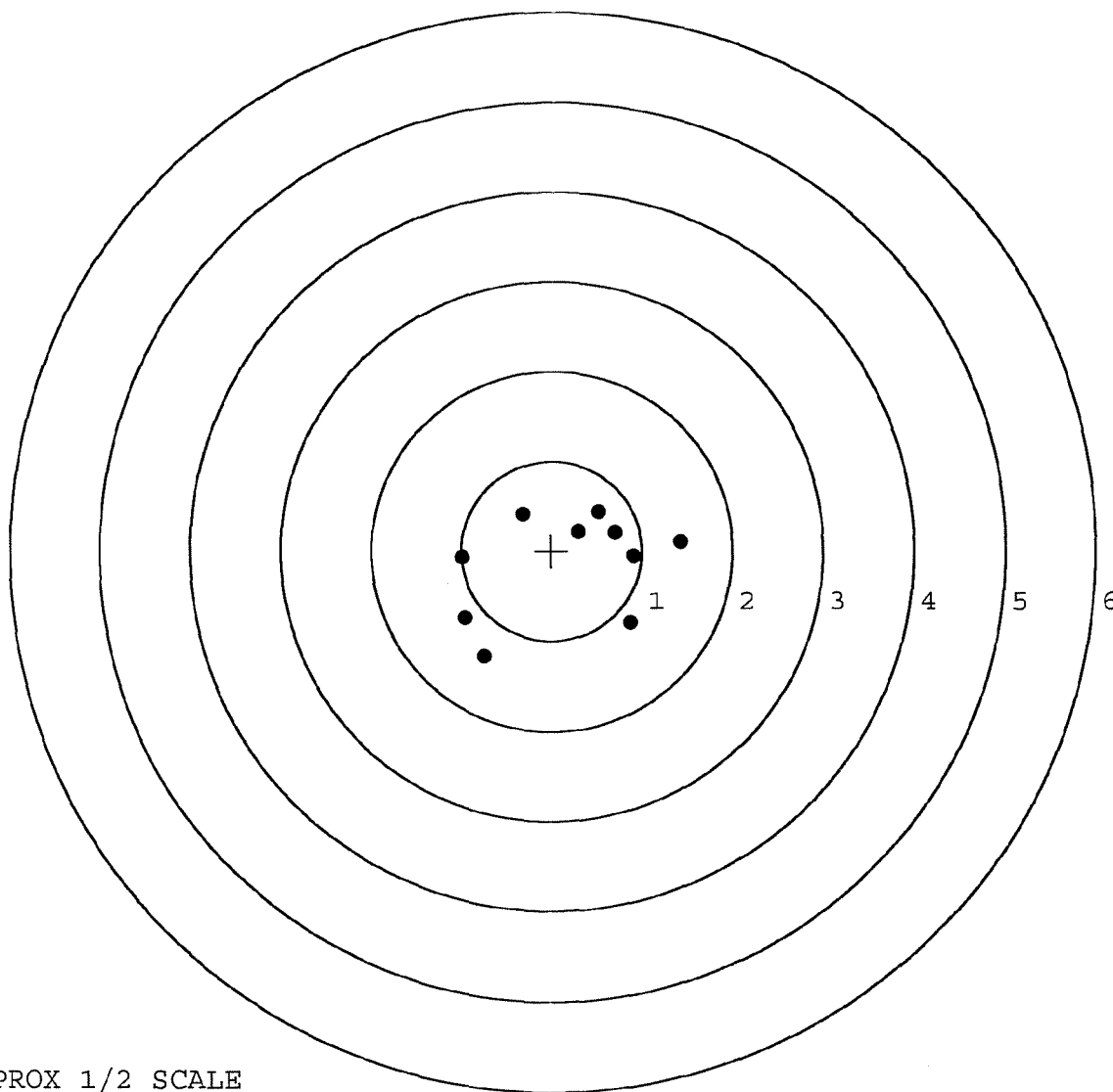
MAX RADIUS: 1.377

MEAN RADIUS: 0.927

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521173. __0

TARGET NUMBER: 4

FILE DATE: 11/30/2005

FILE TIME: 23:13

POINT#	X	Y
1:	0.384	-0.068
2:	0.501	-0.706
3:	0.126	-0.637
4:	-0.282	-0.301
5:	-0.358	0.425
6:	-0.028	0.427
7:	0.153	0.990
8:	0.101	1.300
9:	1.813	1.312
10:	-0.015	0.603

X CENTROID: 0.239

Y CENTROID: 0.335

POA TO CENTROID: 0.411

HORZ SPREAD: 2.171

VERT SPREAD: 2.018

GROUP SPREAD: 2.644

MIN RADIUS: 0.283

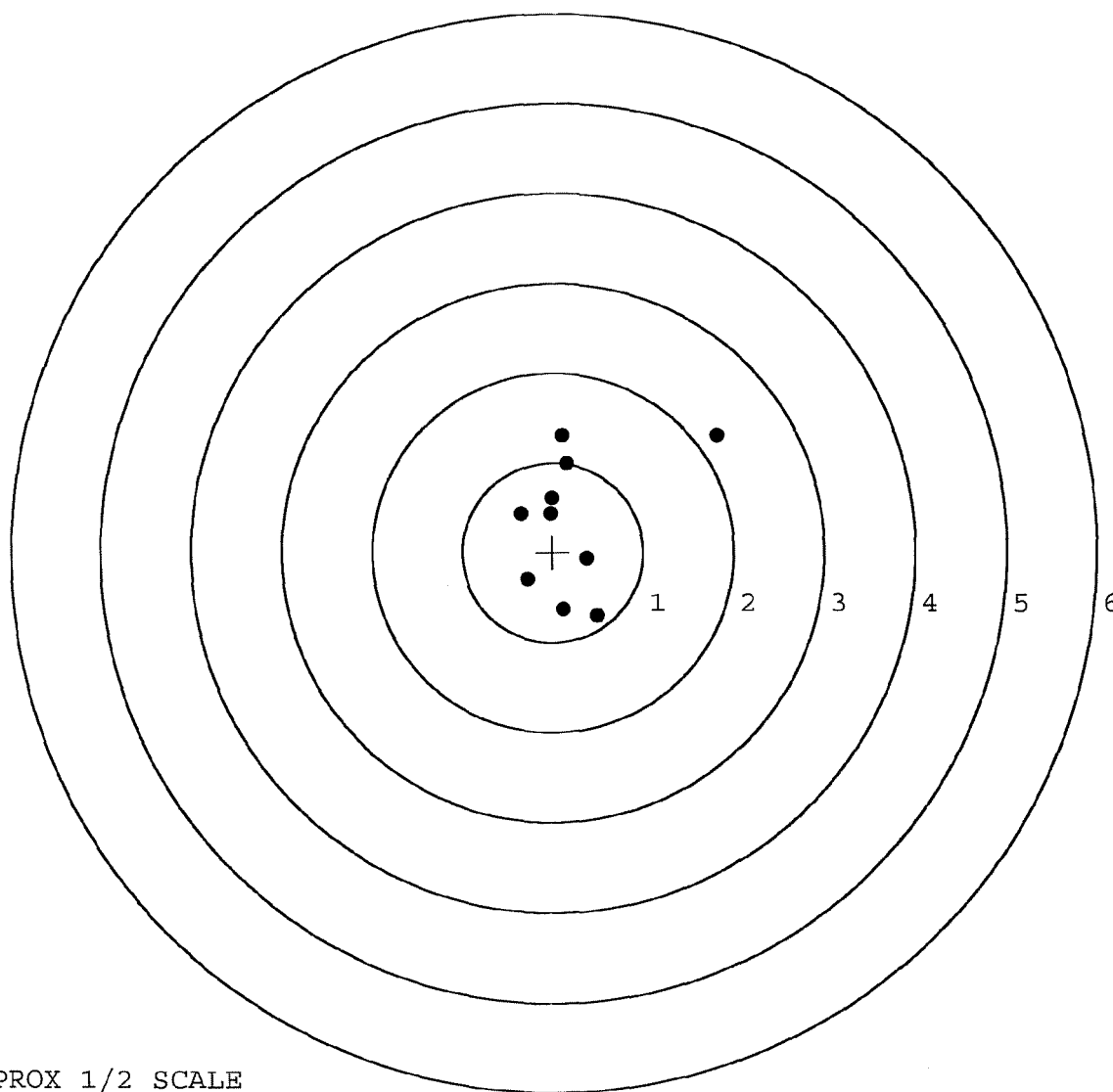
MAX RADIUS: 1.852

MEAN RADIUS: 0.805

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521173. __0

TARGET NUMBER: 5

FILE DATE: 11/30/2005

FILE TIME: 23:13

POINT#	X	Y
1:	-0.431	-0.022
2:	-0.908	0.105
3:	-0.223	-0.711
4:	0.590	-0.260
5:	0.503	0.392
6:	0.309	0.231
7:	0.102	0.208
8:	0.018	0.540
9:	0.154	0.332
10:	1.466	-2.408

X CENTROID: 0.158

Y CENTROID: -0.159

POA TO CENTROID: 0.224

HORZ SPREAD: 2.374

VERT SPREAD: 2.948

GROUP SPREAD: 3.457

MIN RADIUS: 0.372

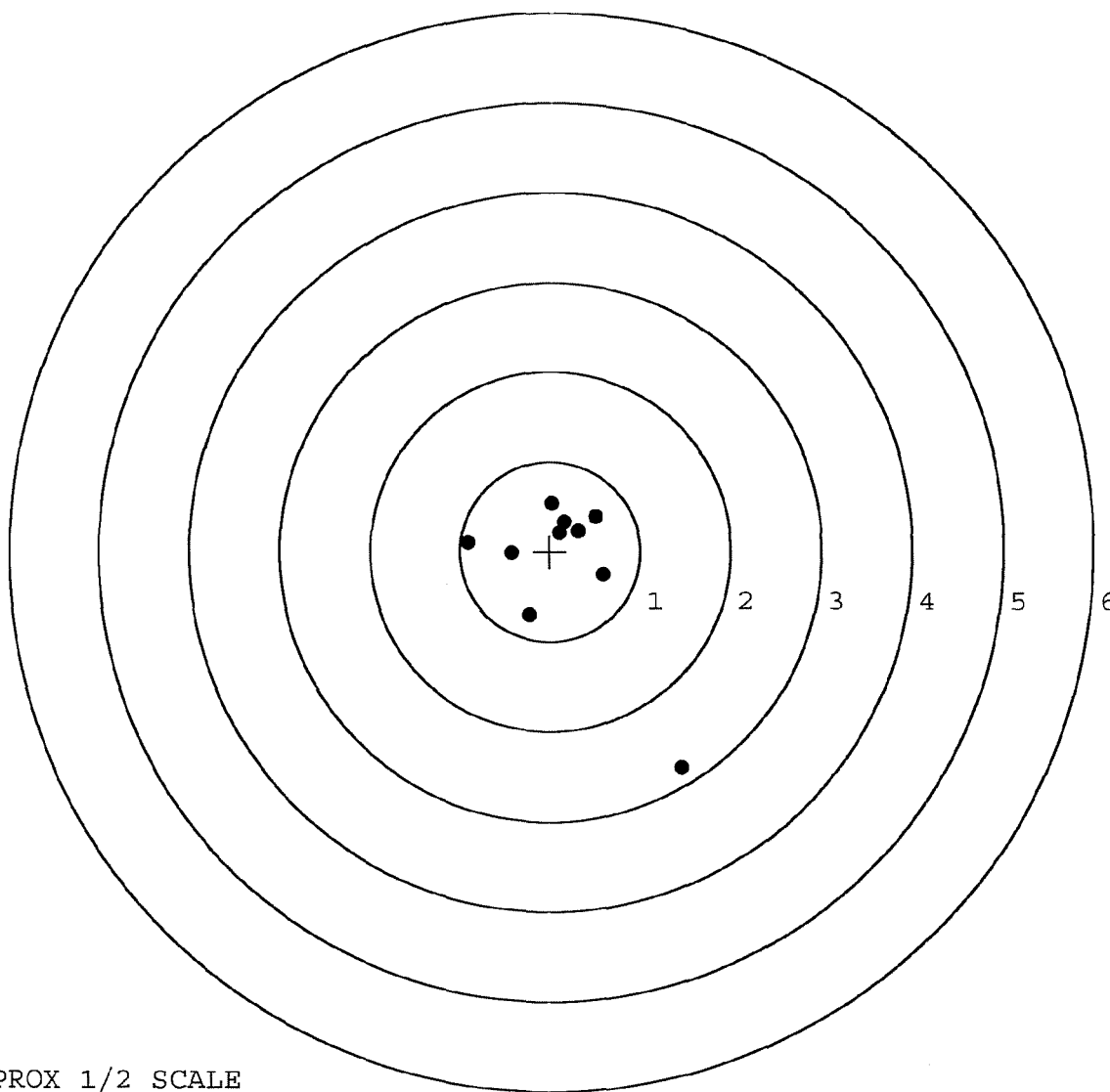
MAX RADIUS: 2.601

MEAN RADIUS: 0.806

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE