

G 652 1181

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



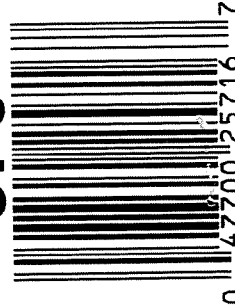
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6521181

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C 6521181

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/19/05	CD
440	PROOF		10/19/05	CD
460	CHECK HEADSPACE		10/19/05	CD
470	DIS-ASSEMBLE ACTION		10/19/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/88 <i>und</i>	10/27/05	<i>und</i>
500	ROLLMARK CALIBER		10/27/05	CW
510	DRILL AND TAP SIGHT HOLES		10/25/05	BR
520	GOFF BLAST BBL / REC		10-31-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		11/2/05	RB
	(BOLT)		11/2/05	RB
560	RE-ASSEMBLE ACTION		11/3/05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/3/05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/3/05	MTM
	D) OIL FIRING PIN ASSEMBLY		11/30/05	DA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		11/30/05	DA
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5 16</u> <u>55 16</u> <u>6 16</u>	11-28-05	BG
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 16</u> <u>3 16</u> <u>3 16</u>	11-28-05	BG
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.023</u>	11-28-05	BC
	J) ASSEMBLE STOCK		11-16-05	AC
	K) ASSEMBLE SWIVEL STUDS		11-28-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-28-05	BG
	M) IRON SIGHT ALIGNMENT		11-28-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-28-05	BG
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	11/17/05	MTM
	MALFUNCTION <i>Bolt Closes Hard</i>	CORRECTION	11-18-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/17/05	mgd
670	FINAL INSPECTION A) HEADSPACE		11-28-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.46</u> <u>2.33</u> <u>2.49</u> <u>2.44</u> <u>2.34</u>	11-28-05	BG
	C) FUNCTION		11-28-05	BC
690	PACK		12-7-05	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 11-15-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.58	2.61		2.54	
PULL #2	2.54	2.49		2.44	
PULL #3	2.49	2.63		2.53	
PULL #4	2.59	2.56		2.50	
PULL #5	2.58	2.52		2.52	
TOTAL	12.78	12.81		12.53	
AVERAGE	2.55	2.56		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.01		
PULL #2	3.14	3.18		
PULL #3	3.17	3.16		
PULL #4	3.10	3.16		
PULL #5	3.06	3.04		
TOTAL	15.62	15.55		
AVERAGE	3.12	3.11		

	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	4.04	4.21		4.04
PULL #2	4.01	4.16		4.07
PULL #3	4.20	4.12		4.12
PULL #4	4.21	4.22		4.15
PULL #5	4.10	4.25		4.08
TOTAL	20.56	20.96		20.46
AVERAGE	4.11	4.19		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521181.__0
FILE DATE AND TIME: 11/17/2005 22:57

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.047
The Average Y Centroid of the Five Target Set:	0.022
The Average Point of Impact of the Five Target Set:	0.052
The Average Mean Radius of the Five Target Set:	0.786
The Distance from POA to Centroid Target #1:	0.167
The Distance from Centroid Target #2 to Centroid Target #1:	0.267
The Distance from Centroid Target #3 to Centroid Target #1:	0.236
The Distance from Centroid Target #4 to Centroid Target #1:	0.412
The Distance from Centroid Target #5 to Centroid Target #1:	0.386

SERIAL NUMBER: G6521181. __0

TARGET NUMBER: 1

FILE DATE: 11/17/2005

FILE TIME: 22:57

X CENTROID: 0.124

Y CENTROID: 0.112

POA TO CENTROID: 0.167

HORZ SPREAD: 2.035

VERT SPREAD: 2.095

GROUP SPREAD: 2.157

MIN RADIUS: 0.214

MAX RADIUS: 1.548

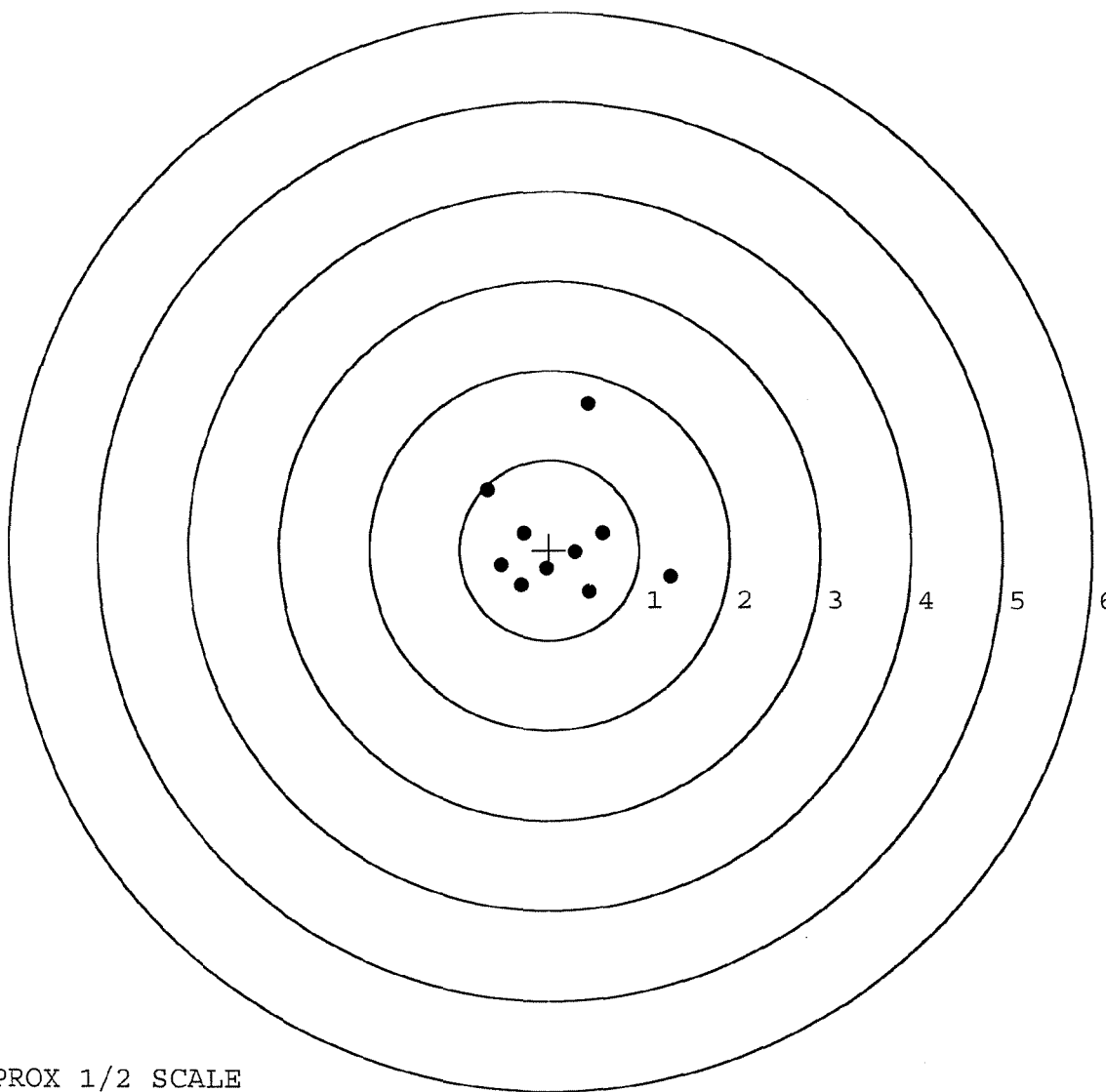
MEAN RADIUS: 0.733

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.036	-0.206
2:	-0.316	-0.395
3:	-0.537	-0.169
4:	-0.285	0.190
5:	-0.693	0.663
6:	0.597	0.188
7:	0.290	-0.023
8:	0.445	-0.466
9:	1.342	-0.295
10:	0.430	1.629



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521181. __0

TARGET NUMBER: 2

FILE DATE: 11/17/2005

FILE TIME: 22:57

X CENTROID: -0.091

Y CENTROID: 0.270

POA TO CENTROID: 0.285

HORZ SPREAD: 1.757

VERT SPREAD: 1.096

GROUP SPREAD: 1.837

MIN RADIUS: 0.245

MAX RADIUS: 0.975

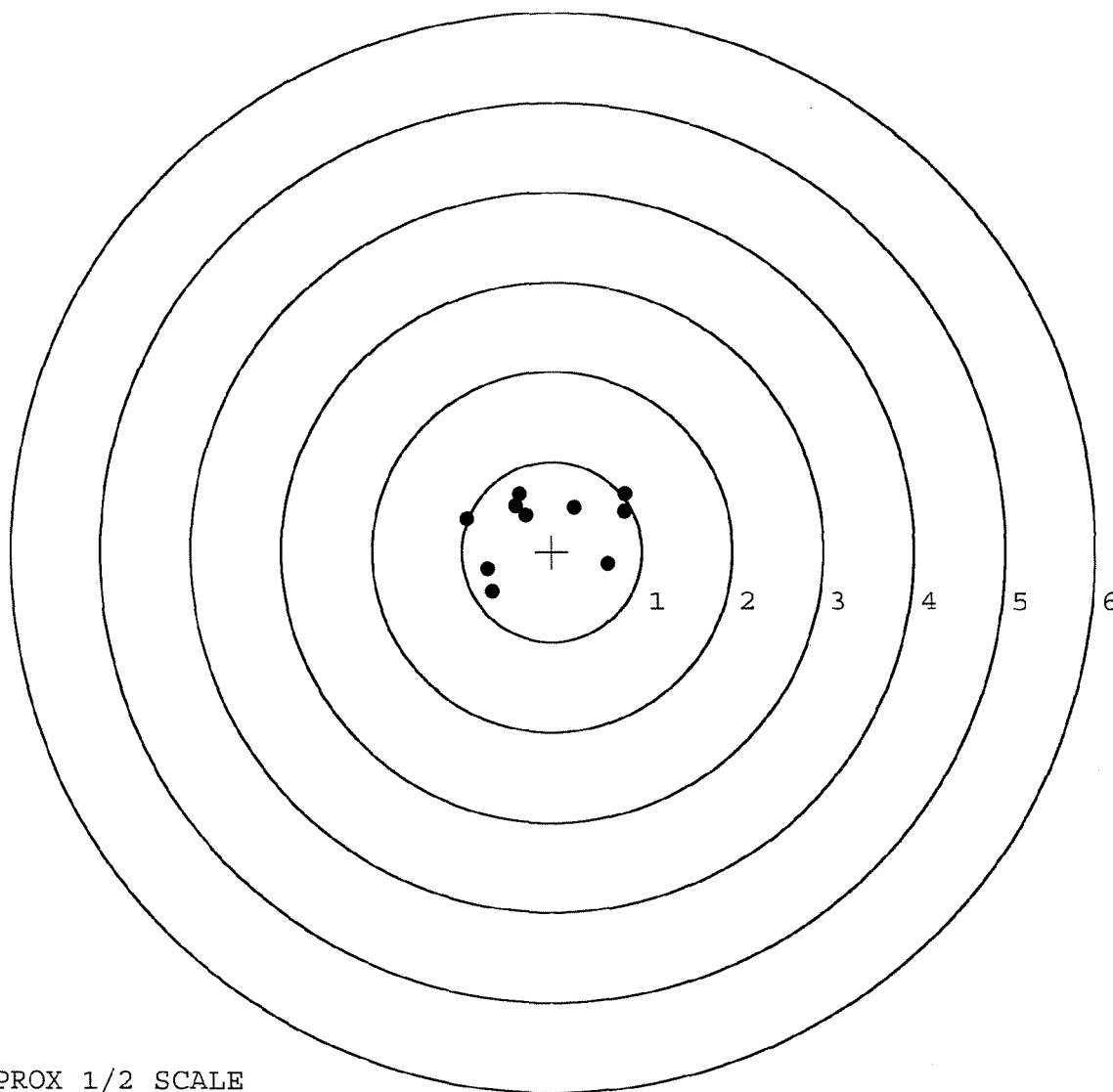
MEAN RADIUS: 0.678

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.251	0.487
2:	0.810	0.644
3:	0.803	0.452
4:	0.624	-0.143
5:	-0.295	0.405
6:	-0.365	0.635
7:	-0.947	0.364
8:	-0.714	-0.195
9:	-0.664	-0.452
10:	-0.412	0.502



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521181. __0

TARGET NUMBER: 3

FILE DATE: 11/17/2005

FILE TIME: 22:57

POINT#	X	Y
1:	0.209	-0.609
2:	0.367	-0.821
3:	0.742	-1.107
4:	0.556	0.128
5:	0.552	0.716
6:	-0.263	0.933
7:	-0.318	1.149
8:	-0.075	1.202
9:	-1.226	0.371
10:	2.850	0.104

X CENTROID: 0.339

Y CENTROID: 0.207

POA TO CENTROID: 0.397

HORZ SPREAD: 4.076

VERT SPREAD: 2.309

GROUP SPREAD: 4.085

MIN RADIUS: 0.230

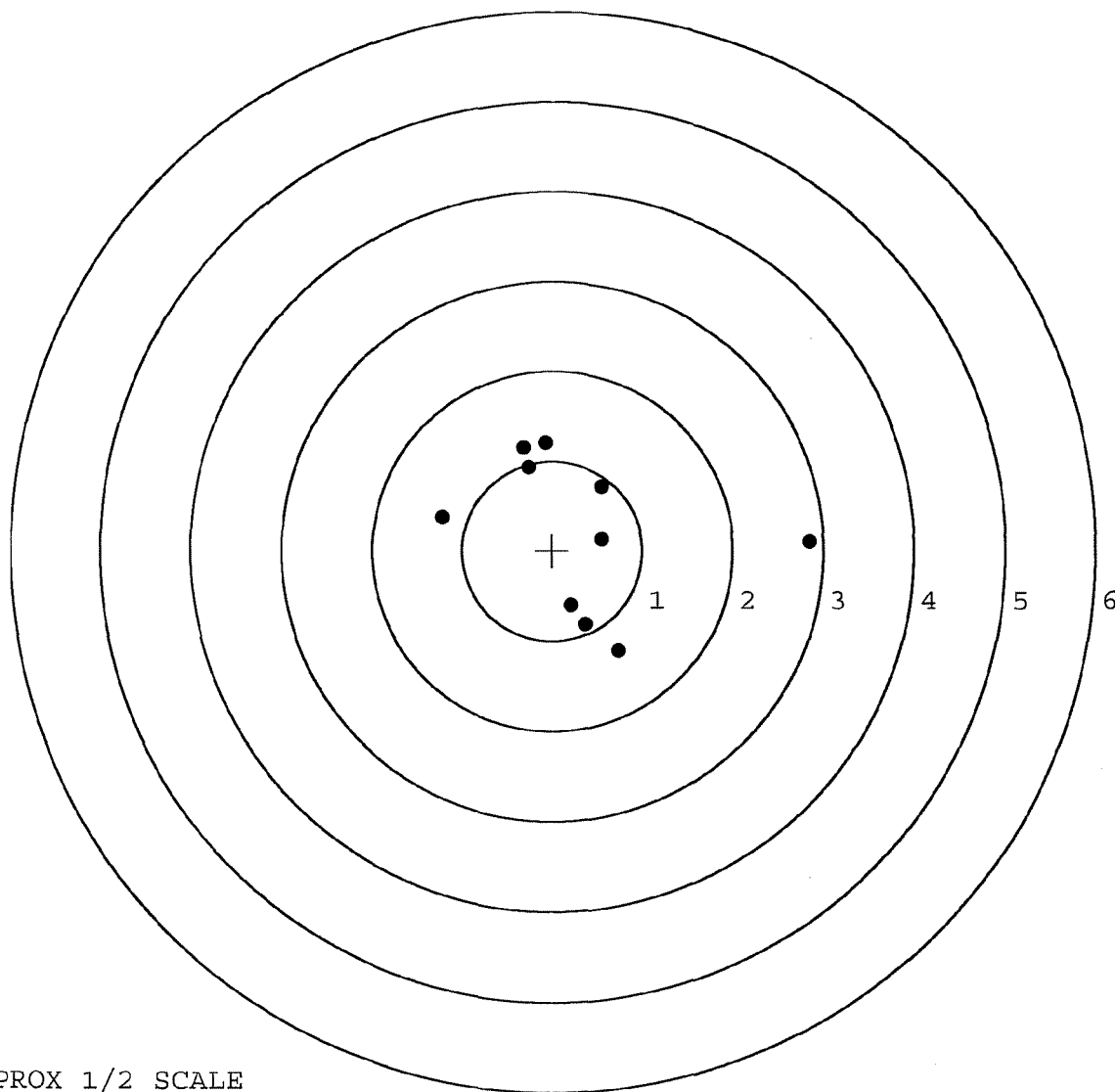
MAX RADIUS: 2.513

MEAN RADIUS: 1.127

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521181. 0

TARGET NUMBER: 4

FILE DATE: 11/17/2005

FILE TIME: 22:57

X CENTROID: -0.089

Y CENTROID: -0.241

POA TO CENTROID: 0.257

HORZ SPREAD: 2.165

VERT SPREAD: 1.964

GROUP SPREAD: 2.426

MIN RADIUS: 0.332

MAX RADIUS: 1.290

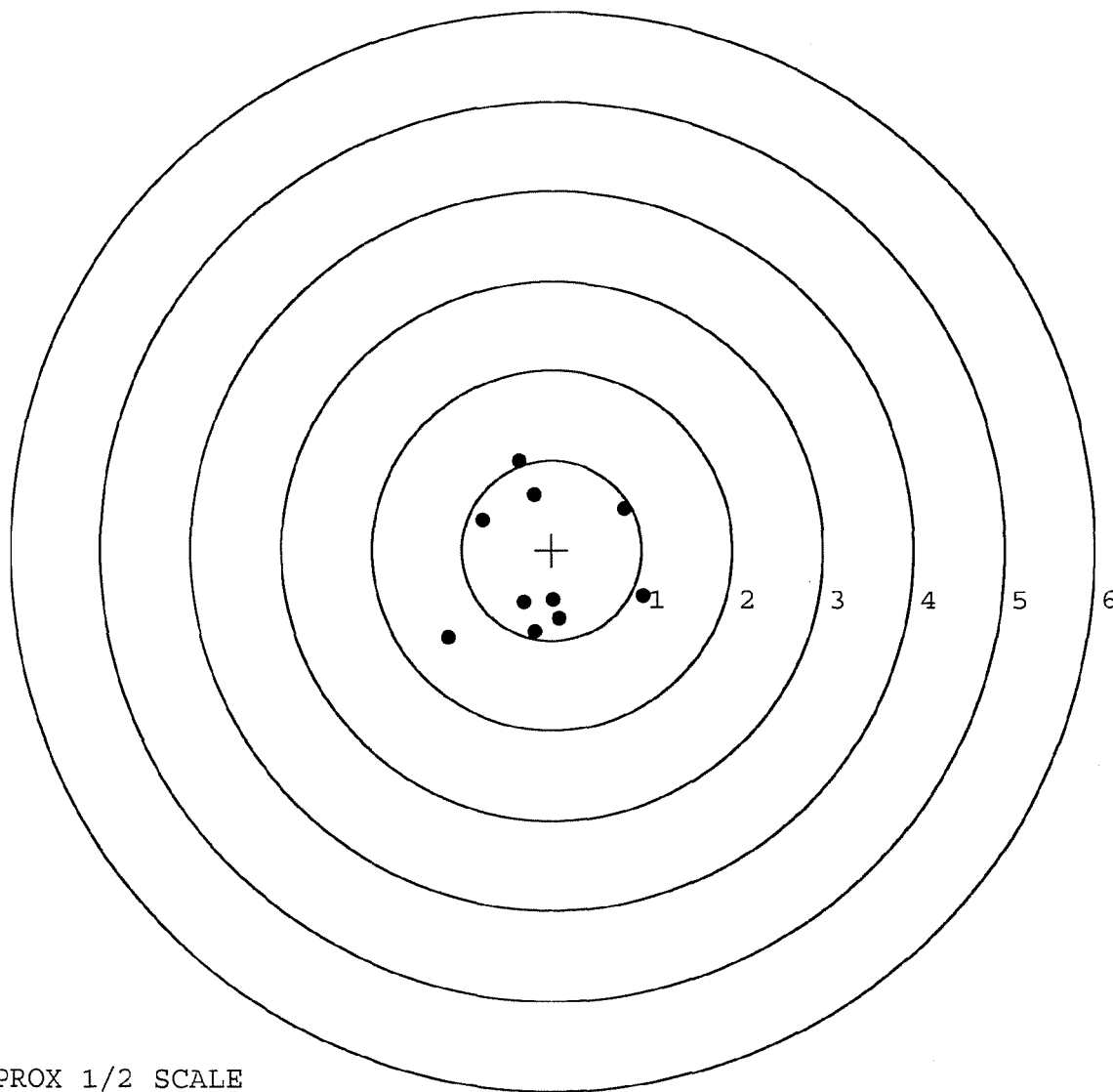
MEAN RADIUS: 0.827

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 11

POINT#	X	Y
1:	0.018	-0.555
2:	-0.309	-0.581
3:	0.086	-0.765
4:	0.083	-0.765
5:	-0.193	-0.910
6:	1.014	-0.509
7:	0.802	0.464
8:	-0.364	0.989
9:	-0.199	0.616
10:	-0.771	0.336
11:	-1.151	-0.975

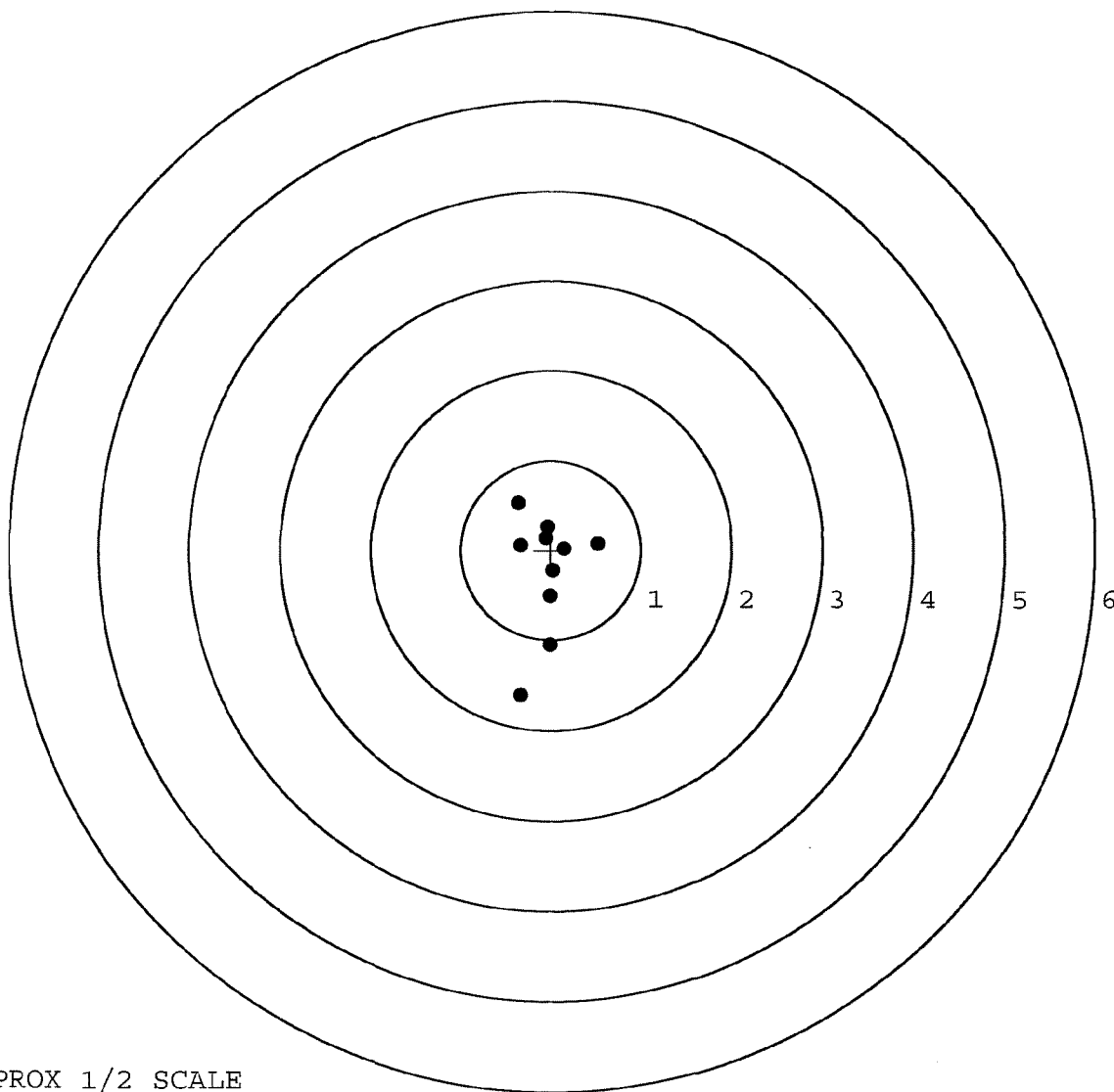


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521181. __ 0
TARGET NUMBER: 5
FILE DATE: 11/17/2005
FILE TIME: 22:57

X CENTROID: -0.046
Y CENTROID: -0.235
POA TO CENTROID: 0.240
HORZ SPREAD: 0.892
VERT SPREAD: 2.145
GROUP SPREAD: 2.145
MIN RADIUS: 0.068
MAX RADIUS: 1.411
MEAN RADIUS: 0.567
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.012	-0.520
2:	-0.009	-1.065
3:	-0.335	-1.616
4:	0.521	0.077
5:	0.148	0.019
6:	0.021	-0.229
7:	-0.335	0.057
8:	-0.371	0.529
9:	-0.035	0.262
10:	-0.056	0.135



TARGET APPROX 1/2 SCALE