

G-652 1268

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

UPC



0 47700 25716 7

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SERIAL NO.



66521268

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

- INSTRUCTION BOOK 3518

DD FORM

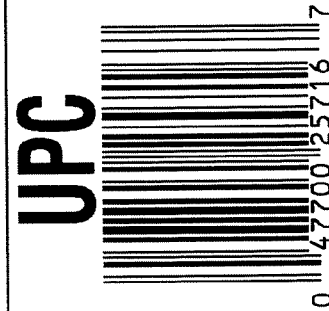


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521268



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521268

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-3-05	RTZ
440	PROOF		10-3-05	RTZ
460	CHECK HEADSPACE		10-3-05	RTZ
470	DIS-ASSEMBLE ACTION		10-4-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4180	10/7/05	undf
500	ROLLMARK CALIBER		10-7-05	CW
510	DRILL AND TAP SIGHT HOLES		10-6-05	RLW
520	GOFF BLAST BBL / REC		10/10/05	und
530 & 540	APPLY COATINGS (BARREL ACTION)		10/14/05	RB
	(BOLT)		10/14/05	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-17-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-05	DA
	D) OIL FIRING PIN ASSEMBLY		10-25-05	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>7 lb</u> <u>7 lb</u> <u>6 lb</u>	10-27-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lb</u> <u>3 lb</u> <u>3 lb</u>	10-27-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	10-27-05	BC
	J) ASSEMBLE STOCK		10-26-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-27-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-27-05	BC
	M) IRON SIGHT ALIGNMENT		10-27-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-27-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-26-05	TRU
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	10-26-05	R.P.
660	INSPECT FOR LIVE AMMO			
670	FINAL INSPECTION A) HEADSPACE		10-27-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.44</u> <u>2.40</u> <u>2.39</u> <u>2.28</u>	10-26-05	TRU
	C) FUNCTION		10-27-05	BC
690	PACK		10/29/05	CH

WEIGHT PULL TEST RESULTS

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 10-25-05

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	2.40		2.50	
PULL #2	2.51	2.52		2.41	
PULL #3	2.52	2.37		2.54	
PULL #4	2.38	2.49		2.35	
PULL #5	2.43	2.51		2.46	
TOTAL	12.35	12.29		12.26	
AVERAGE	2.47	2.45		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.08		
PULL #2	3.02	3.07		
PULL #3	2.98	2.99		
PULL #4	2.97	3.12		
PULL #5	2.83	3.11		
TOTAL	14.83	15.37		
AVERAGE	2.96	3.07		

	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	4.14	4.09		4.13
PULL #2	4.15	4.16		4.12
PULL #3	4.15	4.04		4.07
PULL #4	4.22	4.04		4.12
PULL #5	4.21	4.14		4.06
TOTAL	20.87	20.47		20.50
AVERAGE	4.17	4.09		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521268.__0
FILE DATE AND TIME: 10/26/2005 09:47

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:	-0.052
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.859
The Distance from POA to Centroid Target #1:	0.293
The Distance from Centroid Target #2 to Centroid Target #1:	0.663
The Distance from Centroid Target #3 to Centroid Target #1:	0.186
The Distance from Centroid Target #4 to Centroid Target #1:	0.362
The Distance from Centroid Target #5 to Centroid Target #1:	0.486

SERIAL NUMBER: G6521268. __0

TARGET NUMBER: 1

FILE DATE: 10/26/2005

FILE TIME: 09:47

POINT#	X	Y
1:	1.323	-0.320
2:	1.281	-0.006
3:	0.271	-0.529
4:	0.183	-0.240
5:	0.443	0.196
6:	-0.200	0.311
7:	-0.816	-0.628
8:	-1.180	0.013
9:	-1.770	-0.147
10:	-2.145	0.026

X CENTROID: -0.261

Y CENTROID: -0.132

POA TO CENTROID: 0.293

HORZ SPREAD: 3.468

VERT SPREAD: 0.939

GROUP SPREAD: 3.485

MIN RADIUS: 0.448

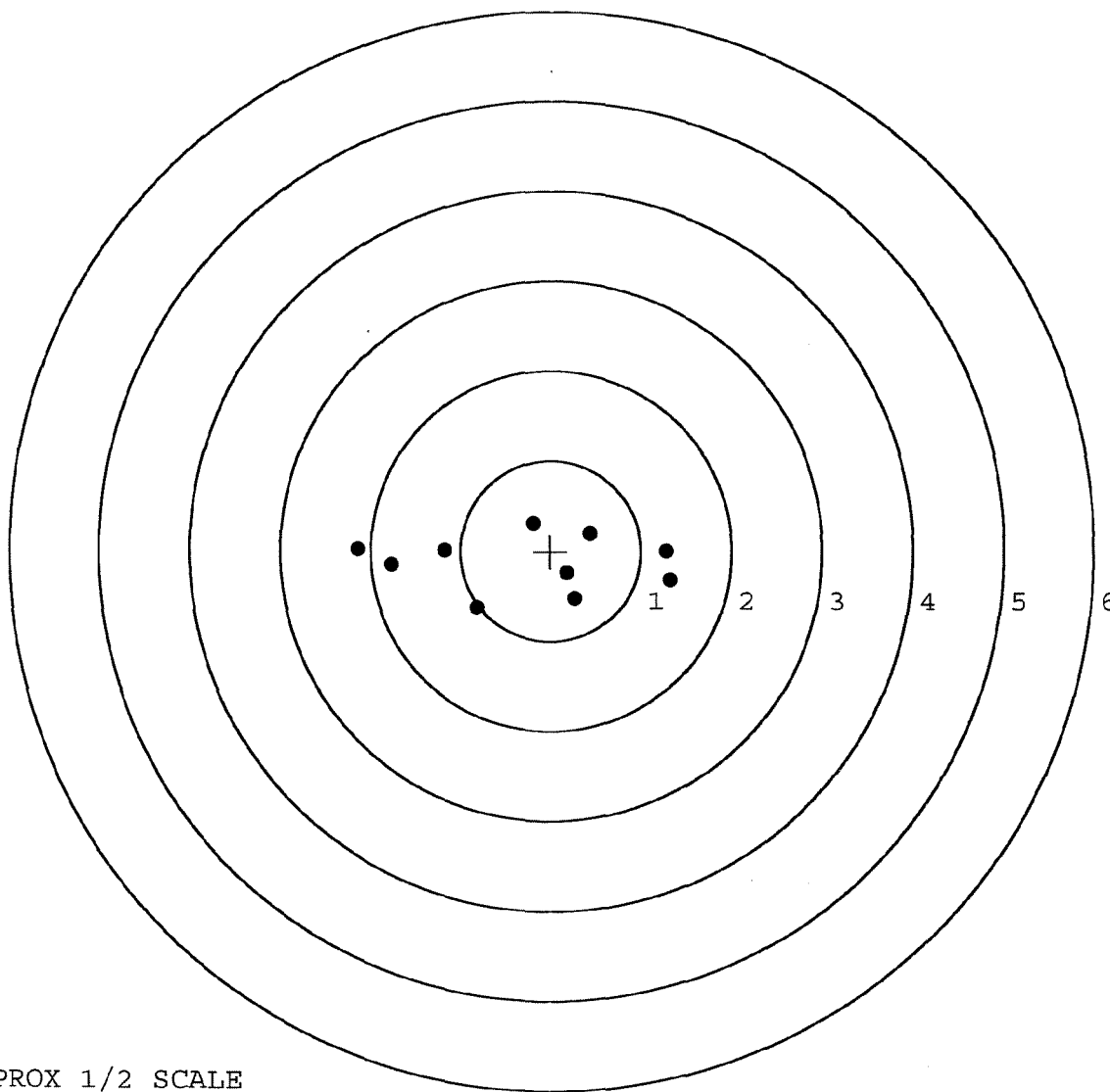
MAX RADIUS: 1.891

MEAN RADIUS: 1.056

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521268. __0

TARGET NUMBER: 2

FILE DATE: 10/26/2005

FILE TIME: 09:47

X CENTROID: 0.372

Y CENTROID: 0.064

POA TO CENTROID: 0.378

HORZ SPREAD: 2.246

VERT SPREAD: 1.256

GROUP SPREAD: 2.340

MIN RADIUS: 0.455

MAX RADIUS: 1.413

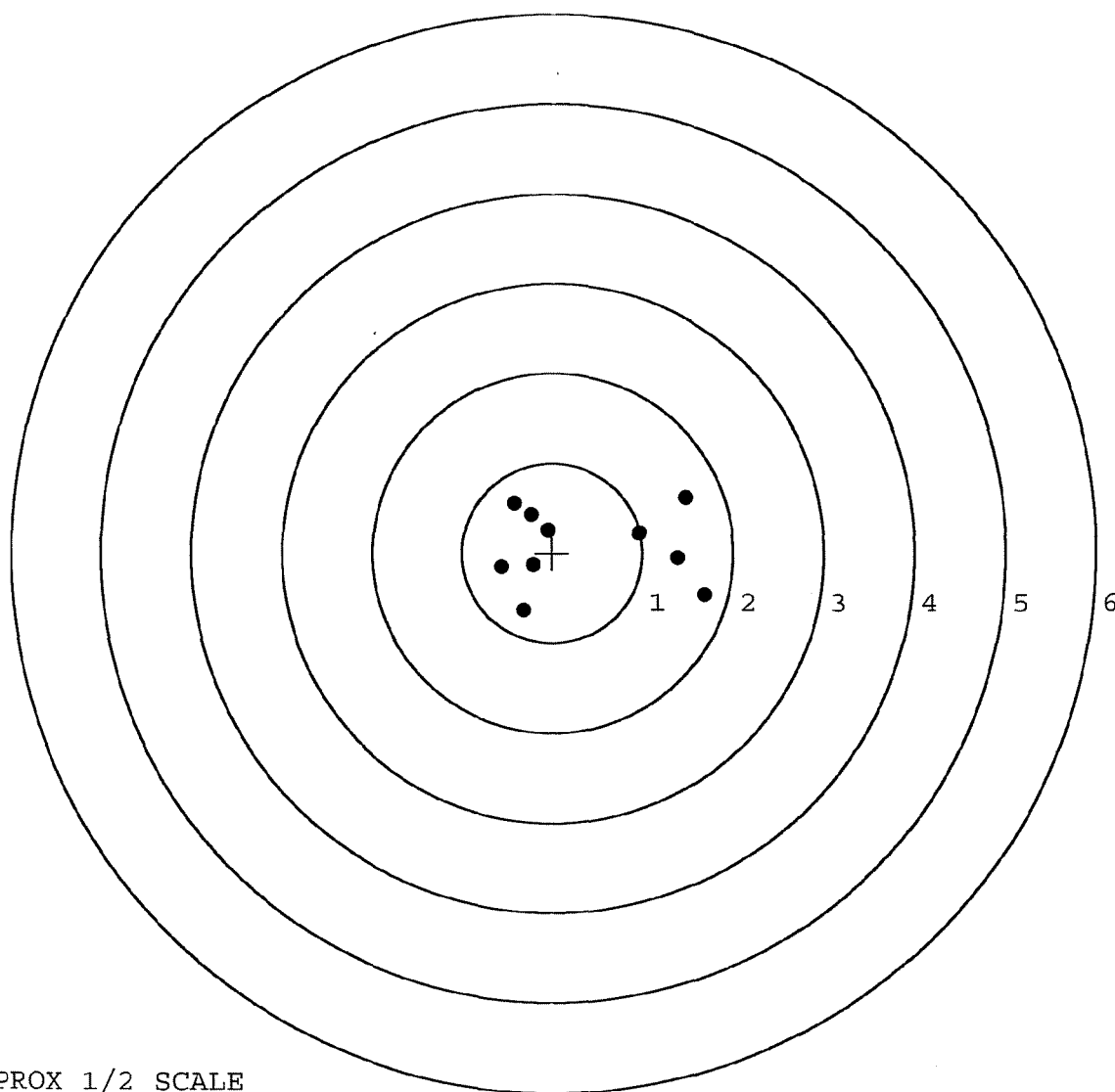
MEAN RADIUS: 0.895

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.684	-0.461
2:	1.390	-0.055
3:	0.966	0.225
4:	1.476	0.615
5:	-0.319	-0.641
6:	-0.212	-0.134
7:	-0.562	-0.155
8:	-0.041	0.255
9:	-0.237	0.430
10:	-0.422	0.558



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521268. 0

TARGET NUMBER: 3

FILE DATE: 10/26/2005

FILE TIME: 09:47

POINT#	X	Y
1:	0.615	-1.493
2:	-0.120	-1.467
3:	-0.451	-0.616
4:	-0.430	-0.179
5:	0.933	-0.152
6:	0.493	0.321
7:	0.177	1.032
8:	0.014	1.194
9:	-1.239	0.928
10:	-1.554	0.644

X CENTROID: -0.156

Y CENTROID: 0.021

POA TO CENTROID: 0.158

HORZ SPREAD: 2.487

VERT SPREAD: 2.687

GROUP SPREAD: 3.049

MIN RADIUS: 0.339

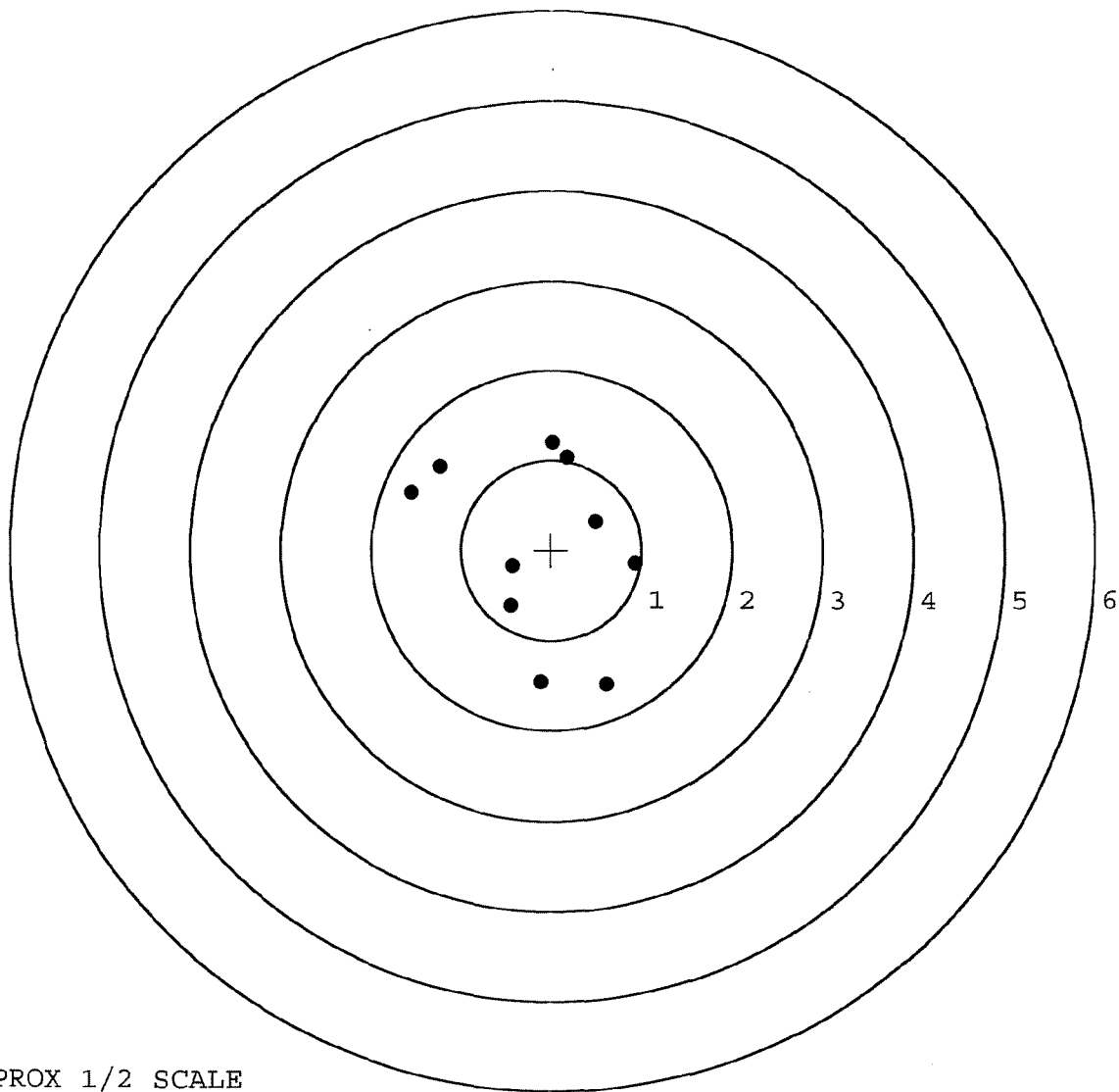
MAX RADIUS: 1.699

MEAN RADIUS: 1.124

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521268. 0

TARGET NUMBER: 4

FILE DATE: 10/26/2005

FILE TIME: 09:47

X CENTROID: 0.098

Y CENTROID: -0.085

POA TO CENTROID: 0.130

HORZ SPREAD: 1.880

VERT SPREAD: 1.465

GROUP SPREAD: 1.925

MIN RADIUS: 0.282

MAX RADIUS: 1.178

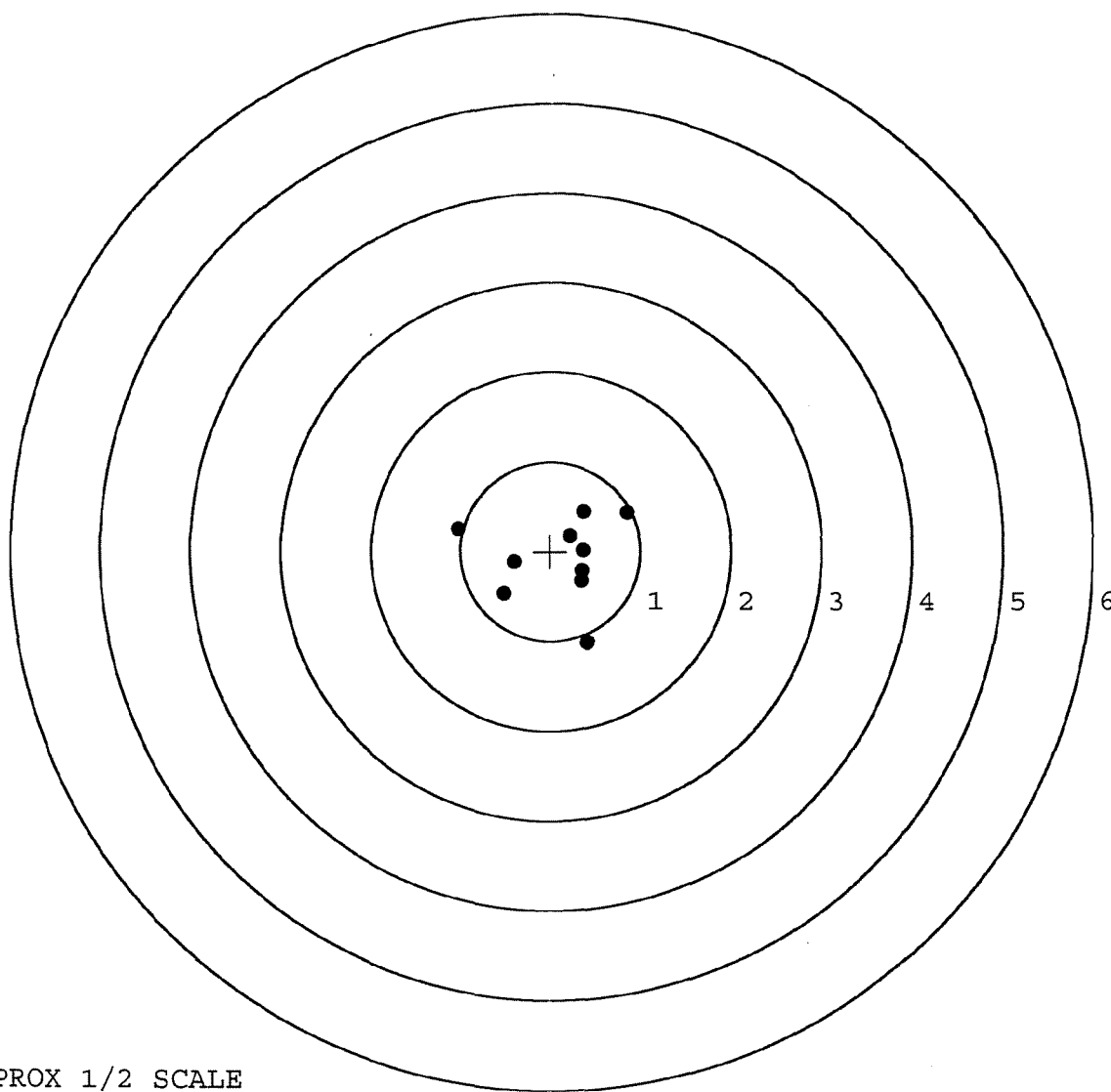
MEAN RADIUS: 0.612

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.419	-1.016
2:	0.349	-0.334
3:	0.849	0.436
4:	0.370	0.449
5:	0.224	0.167
6:	0.367	0.016
7:	0.355	-0.221
8:	-0.401	-0.122
9:	-0.519	-0.475
10:	-1.031	0.250



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521268. __0

TARGET NUMBER: 5

FILE DATE: 10/26/2005

FILE TIME: 09:47

X CENTROID: 0.225

Y CENTROID: -0.126

POA TO CENTROID: 0.258

HORZ SPREAD: 1.393

VERT SPREAD: 2.440

GROUP SPREAD: 2.563

MIN RADIUS: 0.061

MAX RADIUS: 1.364

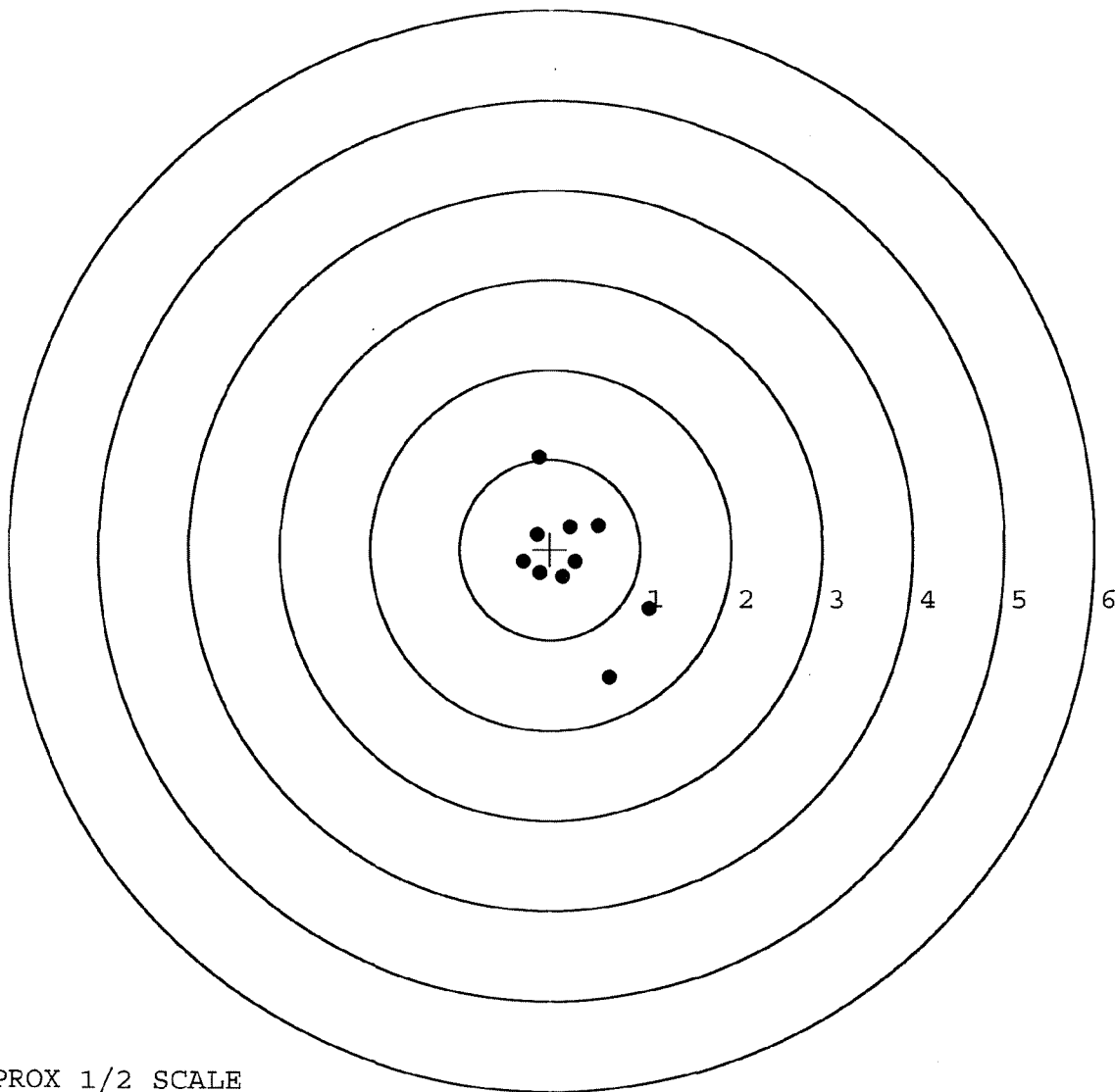
MEAN RADIUS: 0.608

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.660	-1.419
2:	1.095	-0.666
3:	0.529	0.261
4:	-0.126	1.021
5:	0.216	0.249
6:	-0.144	0.166
7:	0.283	-0.145
8:	0.146	-0.312
9:	-0.115	-0.269
10:	-0.298	-0.146



TARGET APPROX 1/2 SCALE