

G-652 1289

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



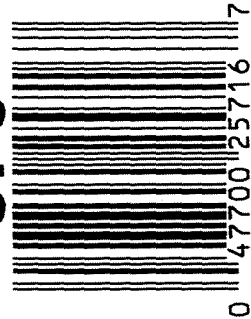
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521289

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M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521289

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/12/05	CD
440	PROOF		10/12/05	CD
460	CHECK HEADSPACE		10/12/05	CD
470	DIS-ASSEMBLE ACTION		10/12/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	10/18/05	unsub
500	ROLLMARK CALIBER		10/18/05	CW
510	DRILL AND TAP SIGHT HOLES		10/14/05	BR
520	GOFF BLAST BBL / REC		10/15/05	DG
530 & 540	APPLY COATINGS (BARREL ACTION)		10/24/05	RB
	(BOLT)		10/24/05	RB
560	RE-ASSEMBLE ACTION		10/31/05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/31/05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/31/05	MTM
	D) OIL FIRING PIN ASSEMBLY		11-4-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-5-05	BA

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.5</u> <u>5.5</u>	11/15/05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	11/15/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>024</u> <u>.023</u>	11/15/05	DA
	J) ASSEMBLE STOCK		11-4-05	RT
	K) ASSEMBLE SWIVEL STUDS		12-5-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-5-05	BG
	M) IRON SIGHT ALIGNMENT		12-5-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-5-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11-7-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/7/05	SH
670	FINAL INSPECTION A) HEADSPACE		12-5-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.50</u> <u>2.09</u> <u>2.24</u> <u>2.22</u> <u>2.32</u>	11-8-05	BG
	C) FUNCTION		12-5-05	BG
690	PACK		12/6/05	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 11-4-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.70	2.48		2.63	
PULL #2	2.56	2.44		2.58	
PULL #3	2.56	2.41		2.62	
PULL #4	2.53	2.52		2.60	
PULL #5	2.42	2.53		2.55	
TOTAL	12.77	12.38		12.98	
AVERAGE	2.55	2.47		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.01		
PULL #2	3.19	3.05		
PULL #3	3.04	3.00		
PULL #4	3.10	3.07		
PULL #5	3.10	3.07		
TOTAL	15.59	15.20		
AVERAGE	3.11	3.04		

	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	4.08		4.03
PULL #2	4.02	4.02		4.07
PULL #3	4.07	4.13		4.16
PULL #4	4.08	4.15		4.13
PULL #5	4.06	4.13		4.18
TOTAL	20.27	20.51		20.57
AVERAGE	4.05	4.10		4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521289.___0
FILE DATE AND TIME: 11/07/2005 10:45

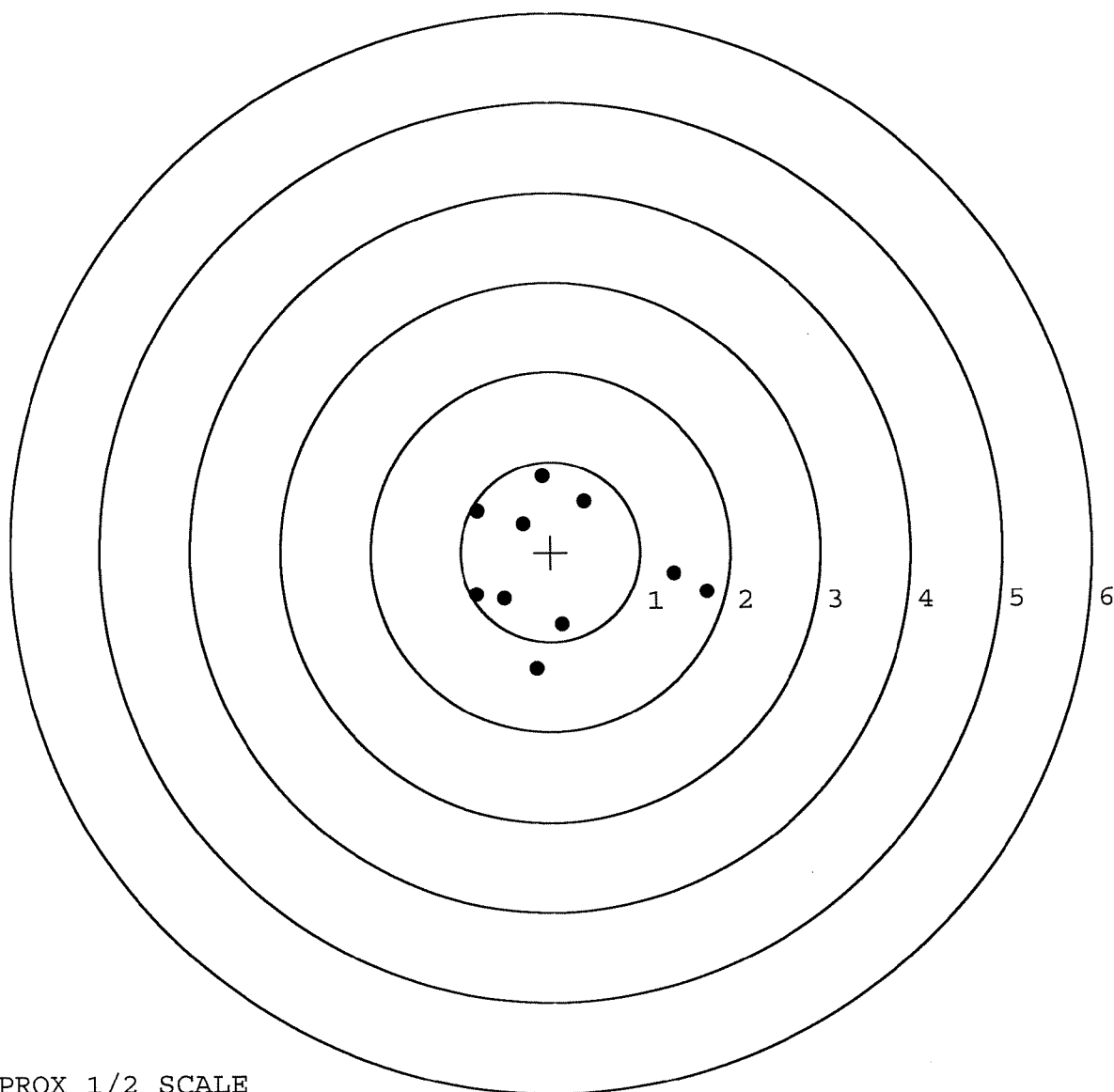
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.059
The Average Y Centroid of the Five Target Set:	-0.048
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.793
The Distance from POA to Centroid Target #1:	0.186
The Distance from Centroid Target #2 to Centroid Target #1:	0.184
The Distance from Centroid Target #3 to Centroid Target #1:	0.168
The Distance from Centroid Target #4 to Centroid Target #1:	0.129
The Distance from Centroid Target #5 to Centroid Target #1:	0.154

SERIAL NUMBER: G6521289. __0
TARGET NUMBER: 1
FILE DATE: 11/07/2005
FILE TIME: 10:45

X CENTROID: 0.090
Y CENTROID: -0.162
POA TO CENTROID: 0.186
HORZ SPREAD: 2.557
VERT SPREAD: 2.147
GROUP SPREAD: 2.707
MIN RADIUS: 0.619
MAX RADIUS: 1.670
MEAN RADIUS: 0.996
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.734	-0.458
2:	1.367	-0.250
3:	0.121	-0.813
4:	-0.161	-1.305
5:	-0.520	-0.517
6:	-0.823	-0.467
7:	-0.301	0.318
8:	0.386	0.565
9:	-0.091	0.842
10:	-0.812	0.462

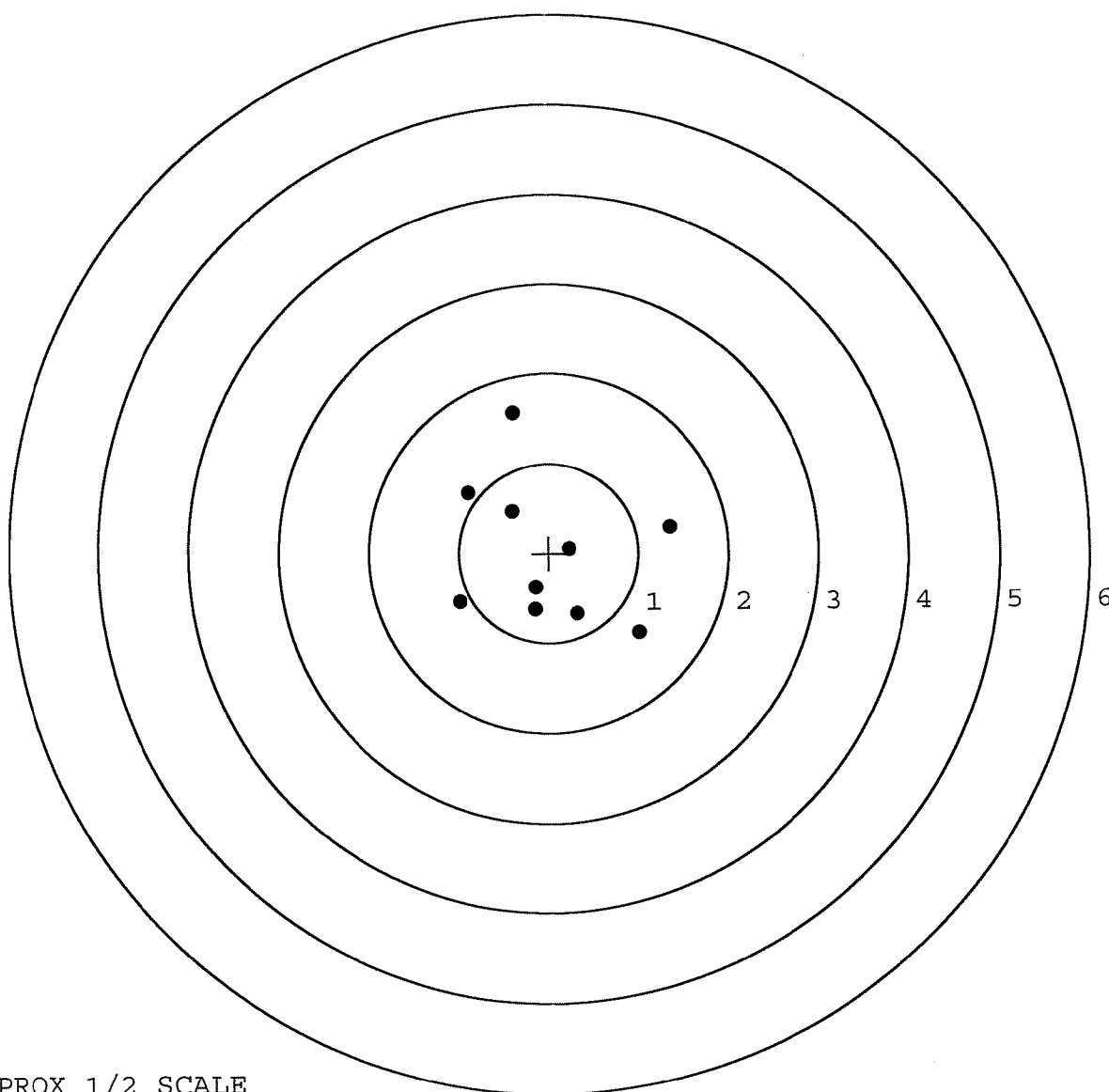


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521289. __0
TARGET NUMBER: 2
FILE DATE: 11/07/2005
FILE TIME: 10:45

X CENTROID: -0.007
Y CENTROID: -0.006
POA TO CENTROID: 0.009
HORZ SPREAD: 2.336
VERT SPREAD: 2.462
GROUP SPREAD: 2.829
MIN RADIUS: 0.244
MAX RADIUS: 1.618
MEAN RADIUS: 0.924
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.005	-0.896
2:	1.349	0.284
3:	0.230	0.050
4:	0.320	-0.675
5:	-0.157	-0.630
6:	-0.148	-0.380
7:	-0.987	-0.538
8:	-0.404	0.472
9:	-0.889	0.685
10:	-0.389	1.566

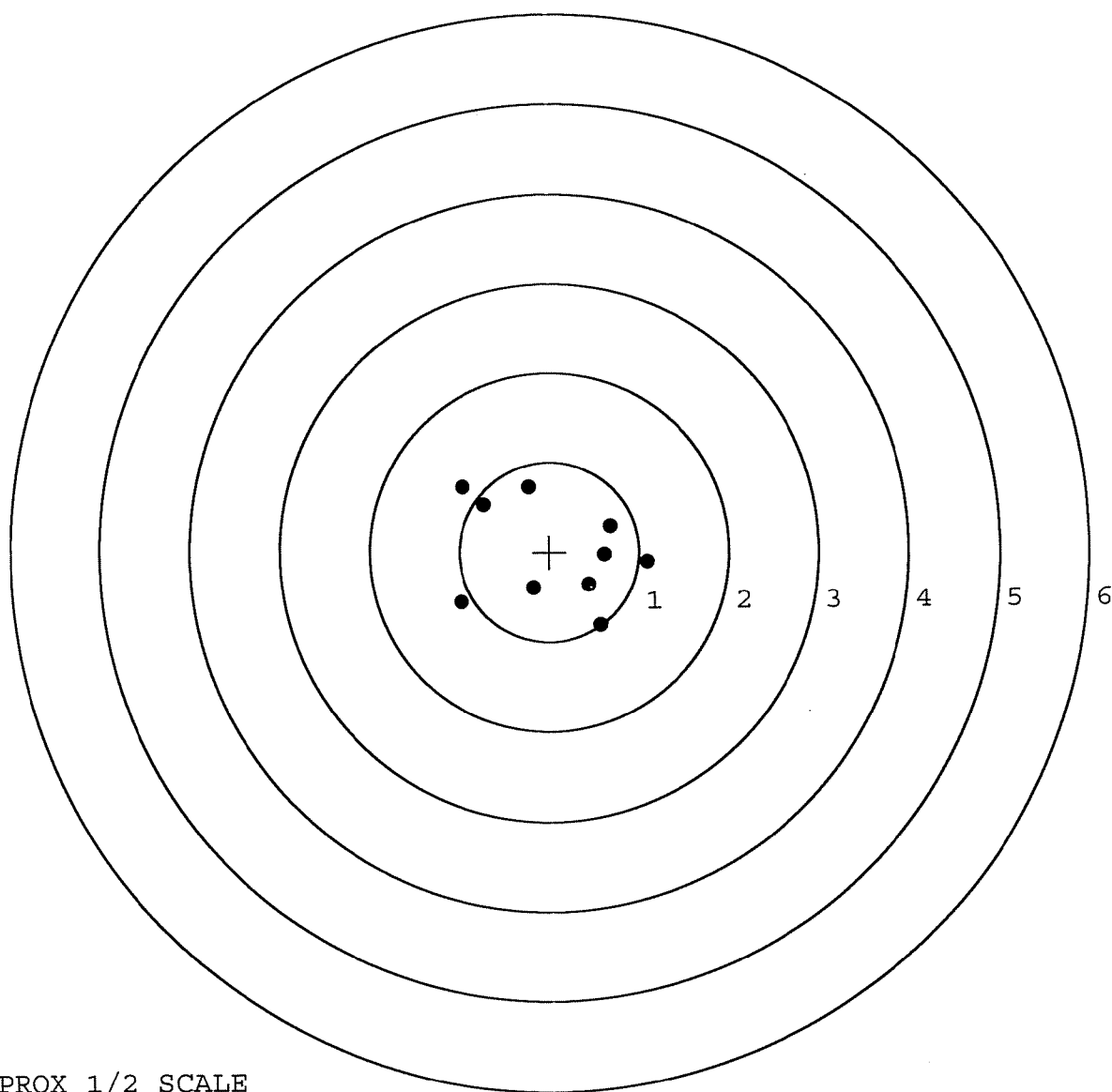


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521289. __0
TARGET NUMBER: 3
FILE DATE: 11/07/2005
FILE TIME: 10:45

X CENTROID: 0.032
Y CENTROID: -0.005
POA TO CENTROID: 0.032
HORZ SPREAD: 2.077
VERT SPREAD: 1.558
GROUP SPREAD: 2.227
MIN RADIUS: 0.454
MAX RADIUS: 1.240
MEAN RADIUS: 0.846
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.573	-0.825
2:	1.091	-0.124
3:	0.685	0.284
4:	0.616	-0.037
5:	0.443	-0.370
6:	-0.181	-0.406
7:	-0.986	-0.559
8:	-0.227	0.722
9:	-0.732	0.533
10:	-0.965	0.733

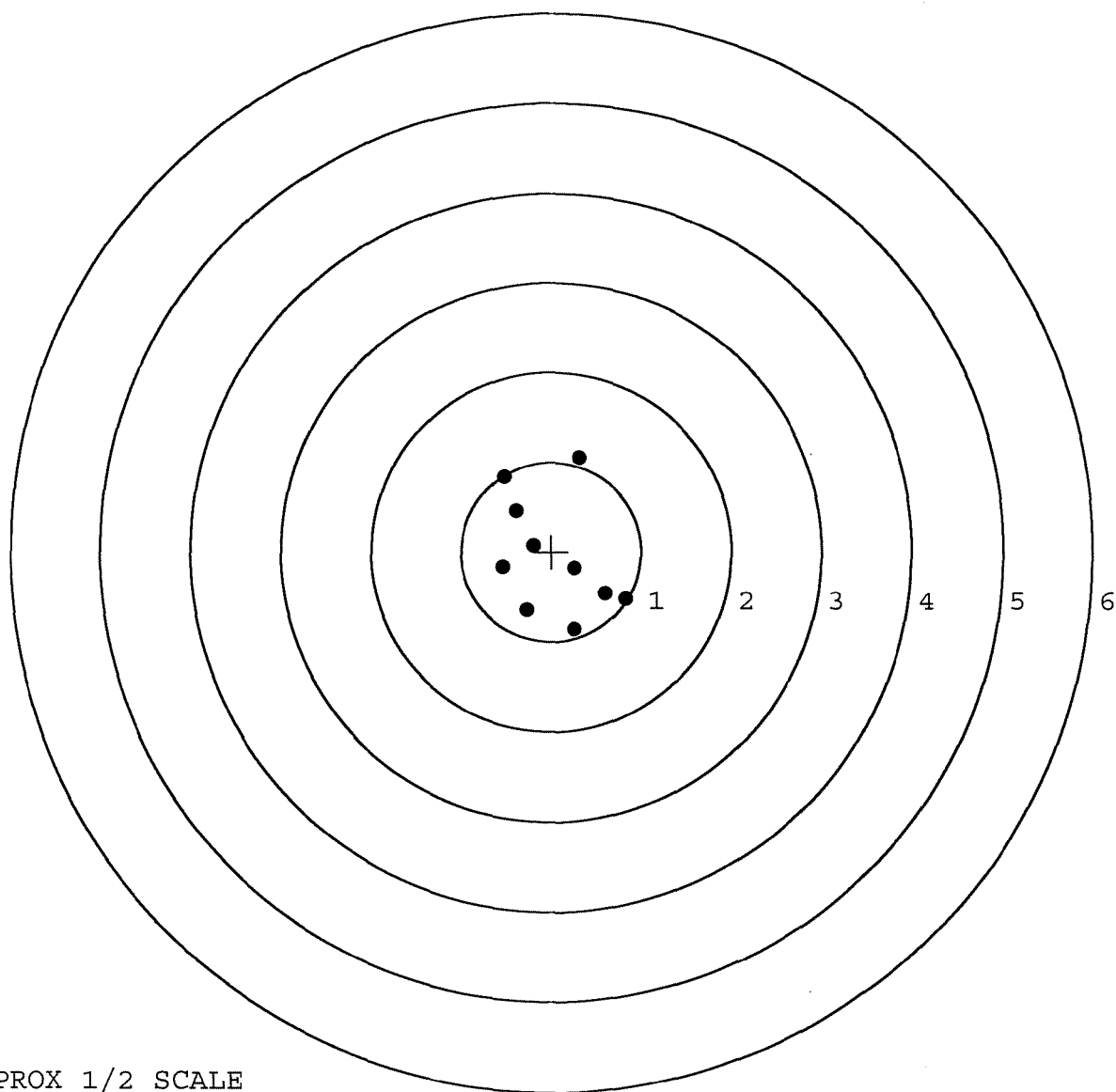


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521289. __0
TARGET NUMBER: 4
FILE DATE: 11/07/2005
FILE TIME: 10:45

X CENTROID: 0.035
Y CENTROID: -0.046
POA TO CENTROID: 0.058
HORZ SPREAD: 1.364
VERT SPREAD: 1.922
GROUP SPREAD: 1.923
MIN RADIUS: 0.263
MAX RADIUS: 1.134
MEAN RADIUS: 0.713
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.830	-0.533
2:	0.604	-0.469
3:	0.261	-0.870
4:	0.265	-0.181
5:	-0.275	-0.655
6:	-0.534	-0.169
7:	-0.202	0.067
8:	-0.392	0.459
9:	-0.524	0.840
10:	0.320	1.052

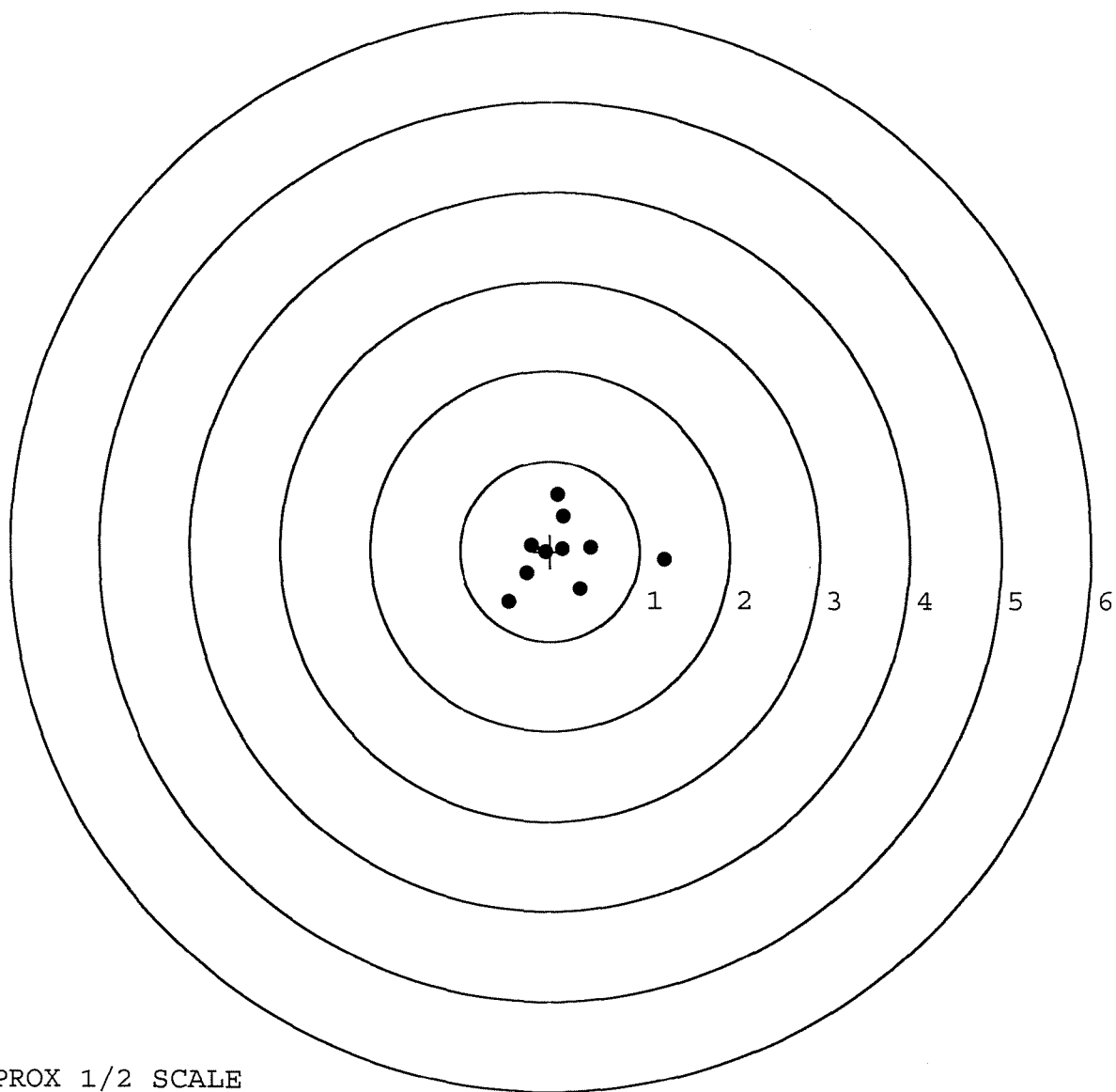


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521289. __0
TARGET NUMBER: 5
FILE DATE: 11/07/2005
FILE TIME: 10:45

X CENTROID: 0.146
Y CENTROID: -0.019
POA TO CENTROID: 0.147
HORZ SPREAD: 1.726
VERT SPREAD: 1.203
GROUP SPREAD: 1.790
MIN RADIUS: 0.049
MAX RADIUS: 1.127
MEAN RADIUS: 0.485
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.270	-0.098
2:	0.345	-0.422
3:	0.457	0.043
4:	0.151	0.387
5:	0.082	0.631
6:	0.139	0.030
7:	-0.212	0.070
8:	-0.054	-0.013
9:	-0.262	-0.244
10:	-0.456	-0.572



TARGET APPROX 1/2 SCALE