

G 652 1299

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

UPC



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UPC



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



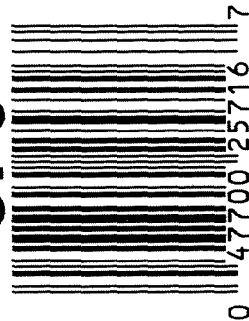
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521299

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521299

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 <i>unib</i>	10/18/05	<i>unib</i>
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 A) CLEAN INSIDE OF BOLT ASSEMBLY		10/31/05	MTM
	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		11-3-05	RTL
	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>7.0</u> <u>6.5</u> <u>7.0</u>	11/14/05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	11/14/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	11/14/05	DA
	J) ASSEMBLE STOCK		11-305	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-15-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-15-05	AC
	M) IRON SIGHT ALIGNMENT		11-15-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-15-05	AC
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	11/7/05	MTJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/7/05	MTJ
670	FINAL INSPECTION A) HEADSPACE		11-15-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.49</u> <u>2.52</u> <u>2.58</u> <u>2.78</u>	11/14/05	DA
	C) FUNCTION		11/15/05	AC
690	PACK		1-5-06	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 10-27-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.53	2.52		2.67	
PULL #2	2.52	2.43		2.57	
PULL #3	2.60	2.58		2.45	
PULL #4	2.52	2.63		2.50	
PULL #5	2.43	2.52		2.64	
TOTAL	12.60	12.68		12.83	
AVERAGE	2.52	2.53		2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.07		
PULL #2	3.16	3.03		
PULL #3	3.20	3.17		
PULL #4	3.17	3.19		
PULL #5	3.15	3.14		
TOTAL	15.81	15.60		
AVERAGE	3.16	3.12		

	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	4.10	4.09		4.13
PULL #2	4.14	4.09		3.97
PULL #3	4.18	3.94		4.22
PULL #4	4.14	4.03		4.03
PULL #5	4.18	4.04		4.00
TOTAL	20.74	20.19		20.35
AVERAGE	4.14	4.03		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

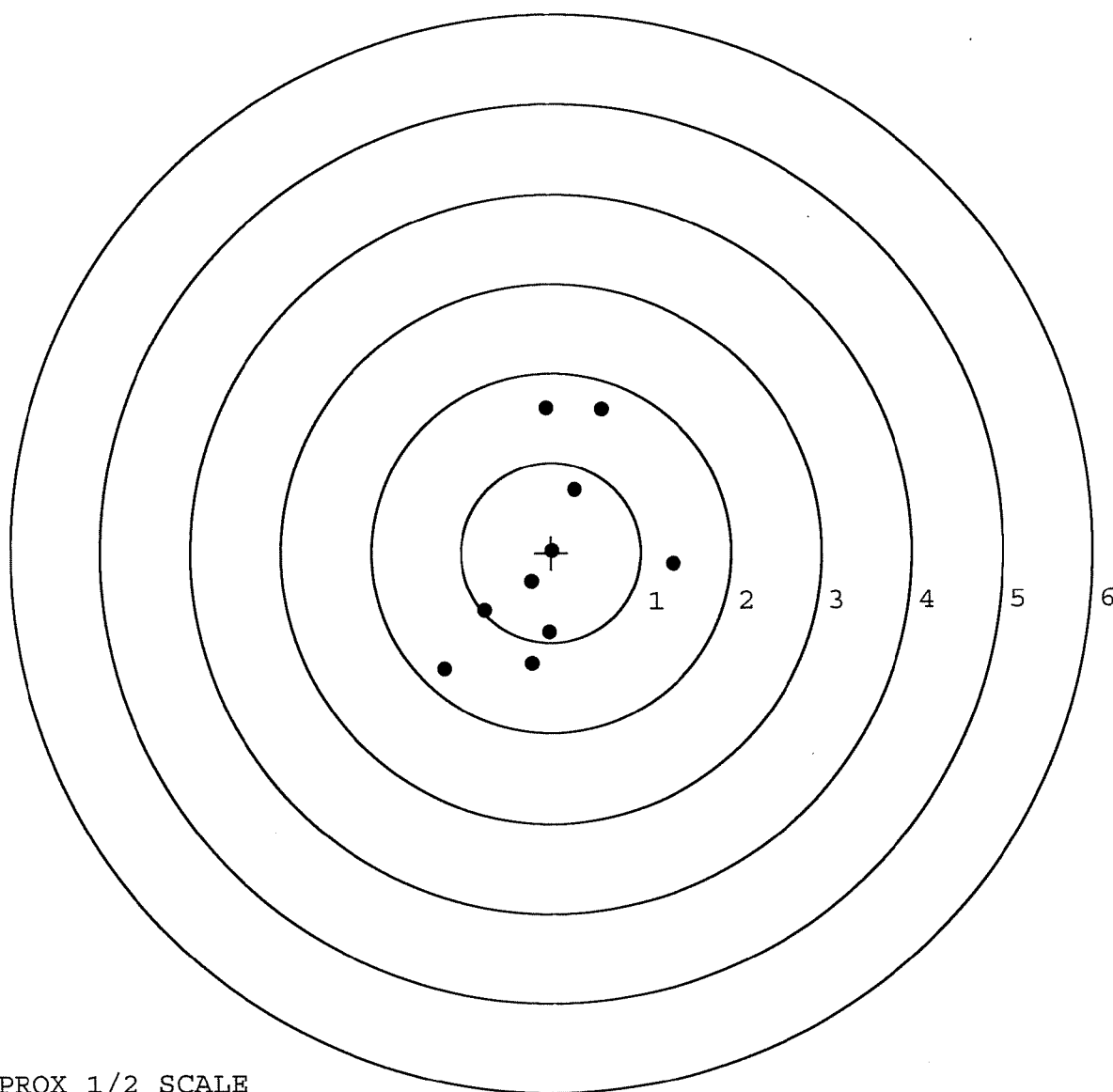
FIREARM SERIAL NUMBER / DATASET NAME: G6521299.___0
FILE DATE AND TIME: 11/07/2005 19:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES.

The Average X Centroid of the Five Target Set:	-0.042
The Average Y Centroid of the Five Target Set:	0.021
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.898
The Distance from POA to Centroid Target #1:	0.064
The Distance from Centroid Target #2 to Centroid Target #1:	0.301
The Distance from Centroid Target #3 to Centroid Target #1:	0.198
The Distance from Centroid Target #4 to Centroid Target #1:	0.325
The Distance from Centroid Target #5 to Centroid Target #1:	0.154

SERIAL NUMBER: G6521299. __0
TARGET NUMBER: 1
FILE DATE: 11/07/2005
FILE TIME: 19:09

	POINT#	X	Y
X CENTROID:	1:	0.009	0.022
Y CENTROID:	2:	-0.222	-0.326
POA TO CENTROID:	3:	-0.743	-0.642
HORZ SPREAD:	4:	-0.030	-0.889
VERT SPREAD:	5:	-0.220	-1.237
GROUP SPREAD:	6:	-1.197	-1.288
MIN RADIUS:	7:	1.356	-0.135
MAX RADIUS:	8:	0.271	0.698
MEAN RADIUS:	9:	0.578	1.590
# IN 1 IN DIAMETER:	10:	-0.048	1.611
# IN 2 IN DIAMETER:			
# in 3 IN DIAMETER:			



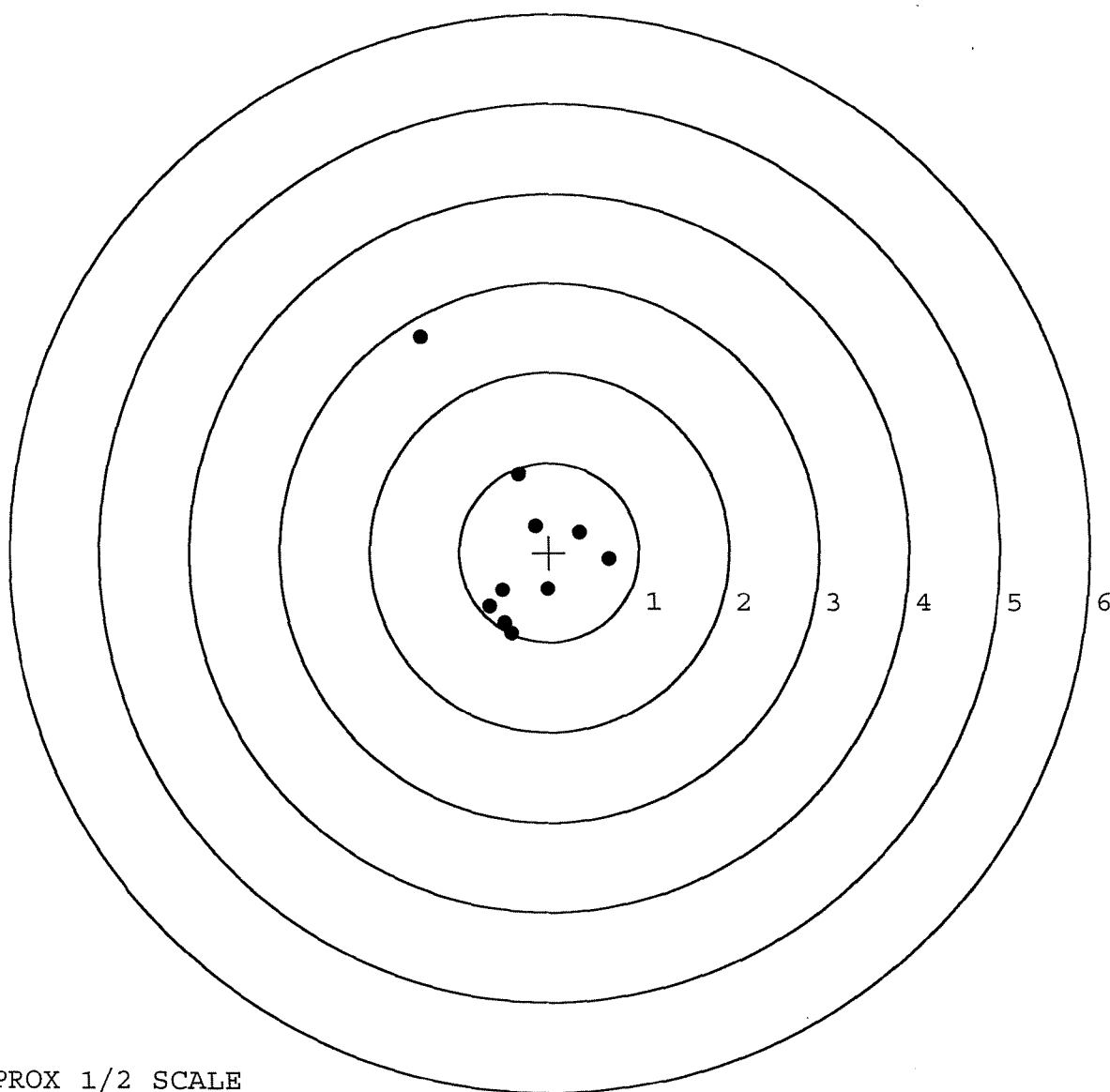
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521299. __0
TARGET NUMBER: 2
FILE DATE: 11/07/2005
FILE TIME: 19:09

X CENTROID: -0.304
Y CENTROID: 0.052
POA TO CENTROID: 0.309
HORZ SPREAD: 2.114
VERT SPREAD: 3.299
GROUP SPREAD: 3.454
MIN RADIUS: 0.278
MAX RADIUS: 2.599
MEAN RADIUS: 0.902

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.016	-0.419
2:	0.670	-0.080
3:	0.342	0.222
4:	-0.158	0.288
5:	-0.342	0.867
6:	-0.514	-0.432
7:	-0.664	-0.608
8:	-0.499	-0.799
9:	-0.420	-0.911
10:	-1.444	2.388

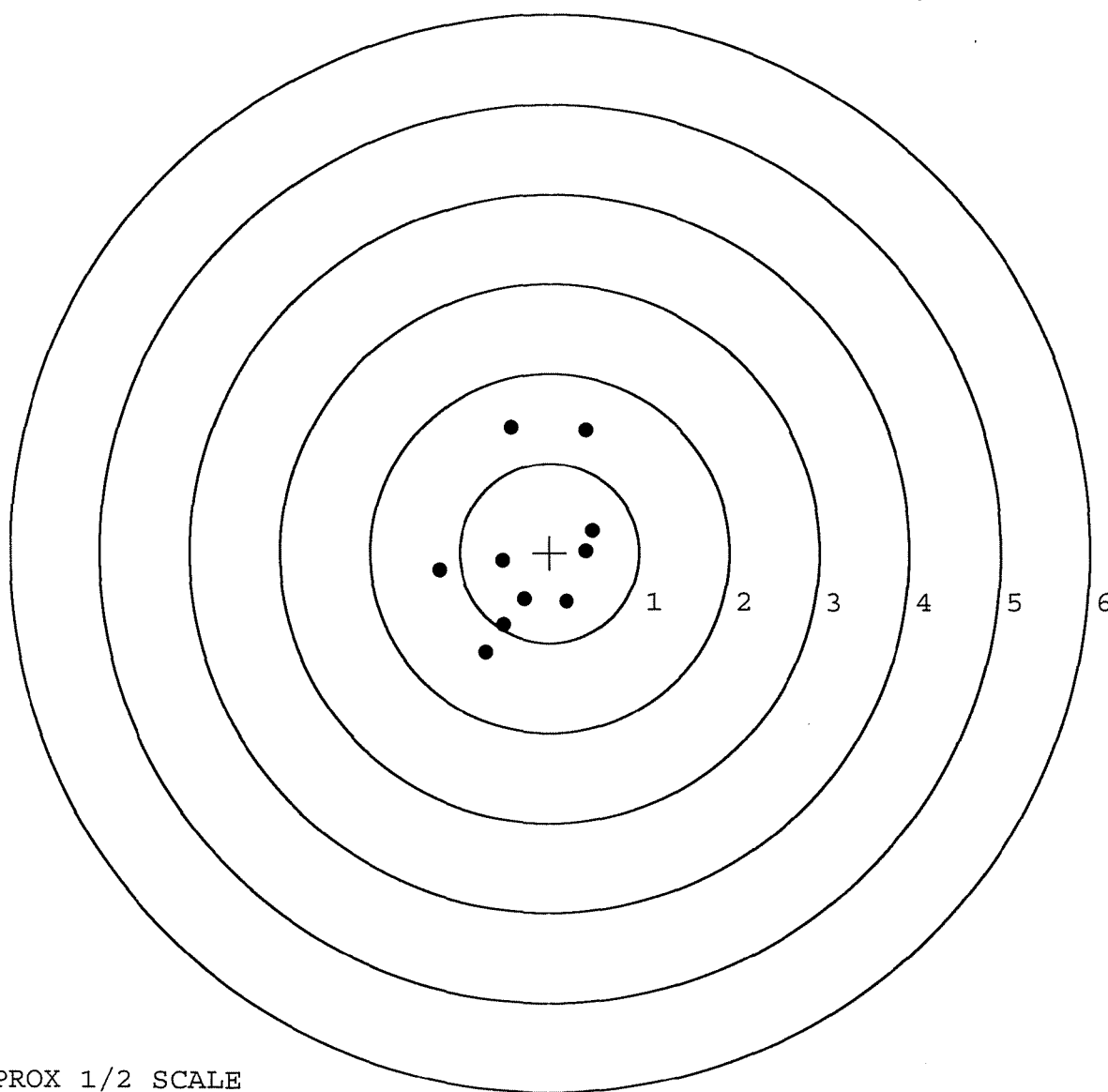


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521299. __0
TARGET NUMBER: 3
FILE DATE: 11/07/2005
FILE TIME: 19:09

X CENTROID: -0.220
Y CENTROID: -0.026
POA TO CENTROID: 0.221
HORZ SPREAD: 1.719
VERT SPREAD: 2.502
GROUP SPREAD: 2.716
MIN RADIUS: 0.313
MAX RADIUS: 1.529
MEAN RADIUS: 0.888
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.486	0.242
2:	0.408	0.015
3:	0.196	-0.551
4:	-0.275	-0.522
5:	-0.513	-0.808
6:	-0.709	-1.107
7:	-1.233	-0.200
8:	-0.525	-0.094
9:	-0.437	1.395
10:	0.405	1.370



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521299. 0

TARGET NUMBER: 4

FILE DATE: 11/07/2005

FILE TIME: 19:09

X CENTROID: 0.216

Y CENTROID: 0.159

POA TO CENTROID: 0.268

HORZ SPREAD: 2.363

VERT SPREAD: 1.264

GROUP SPREAD: 2.366

MIN RADIUS: 0.047

MAX RADIUS: 1.429

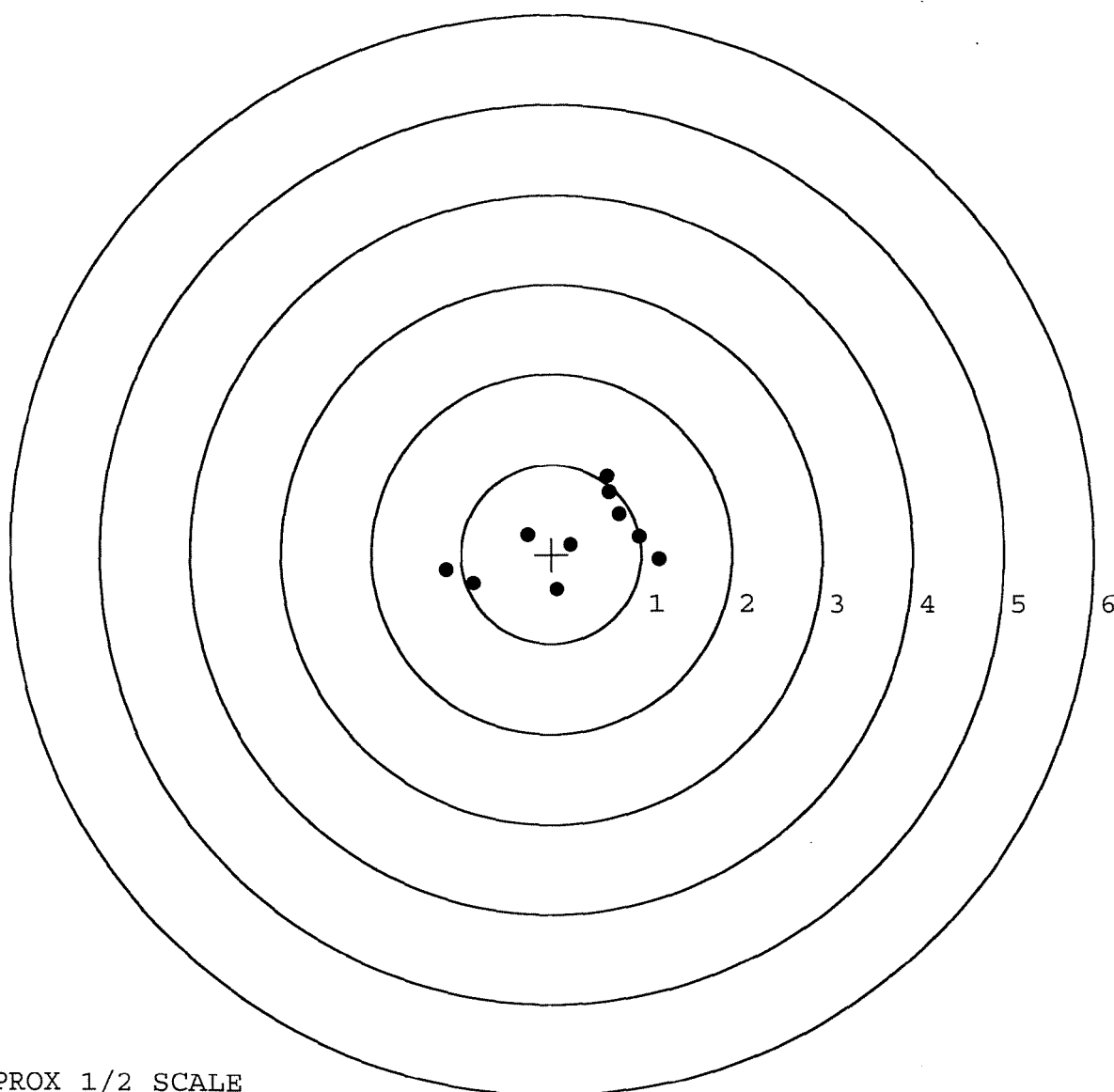
MEAN RADIUS: 0.759

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.214	0.112
2:	1.191	-0.056
3:	0.976	0.206
4:	0.642	0.694
5:	0.618	0.869
6:	-0.265	0.220
7:	0.065	-0.395
8:	-0.861	-0.330
9:	-1.172	-0.180
10:	0.753	0.452



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521299. __0

TARGET NUMBER: 5

FILE DATE: 11/07/2005

FILE TIME: 19:09

X CENTROID: 0.124

Y CENTROID: -0.020

POA TO CENTROID: 0.126

HORZ SPREAD: 1.733

VERT SPREAD: 2.187

GROUP SPREAD: 2.245

MIN RADIUS: 0.203

MAX RADIUS: 1.372

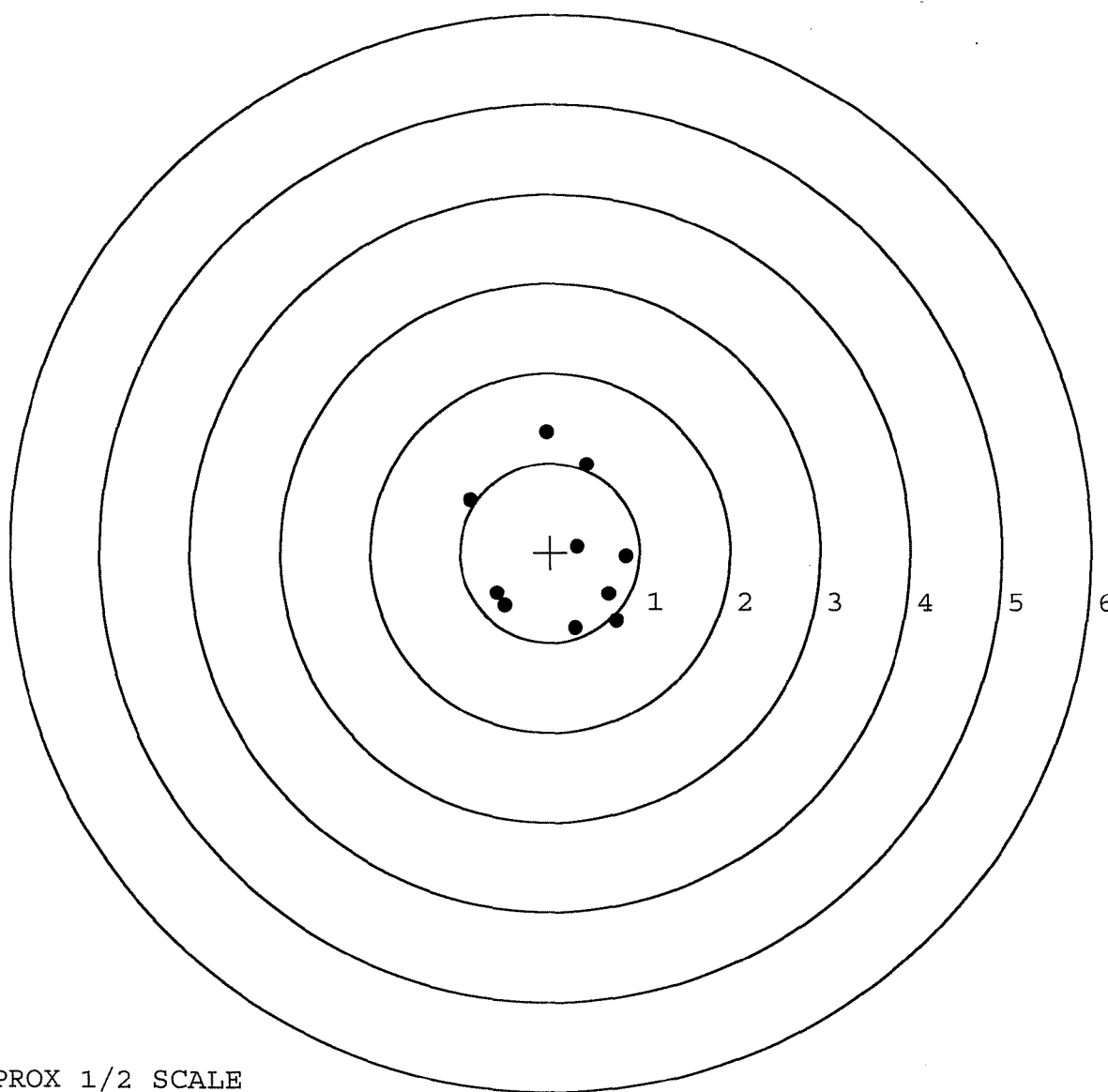
MEAN RADIUS: 0.872

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.305	0.073
2:	0.852	-0.046
3:	0.660	-0.469
4:	0.745	-0.761
5:	0.289	-0.845
6:	-0.505	-0.598
7:	-0.592	-0.456
8:	-0.881	0.581
9:	-0.040	1.342
10:	0.408	0.981



TARGET APPROX 1/2 SCALE