

G652132C

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTE
UPC



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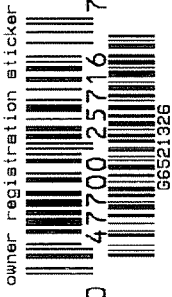
SERIAL NO.



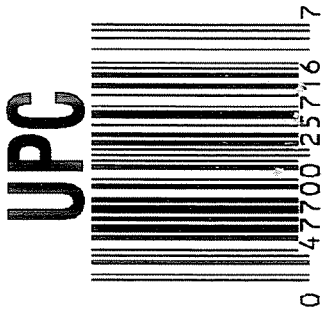
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6521326	



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66521326

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/8/05	CD
440	PROOF		11/8/05	CD
460	CHECK HEADSPACE	MAGNA-FLUX	11/8/05	CD
470	DIS-ASSEMBLE ACTION	INSPECTED	11/8/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	DEC 07 2005 490 OVERSTOP 40.00	12/7/05	mmf
500	ROLLMARK CALIBER		12-2-05	CW
510	DRILL AND TAP SIGHT HOLES		12-2-05	BR
520	GOFF BLAST BBL / REC		1212	SD
530 & 540	APPLY COATINGS (BARREL ACTION)		12/13	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		12/27/05	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12/27/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12/27/05	DA
	D) OIL FIRING PIN ASSEMBLY		3/8/06	mmf
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/8/06	mmf
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>4.5</u> <u>5.5</u>	1-29-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.5</u> <u>2.5</u>	1-29-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/8/06	MJD
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	3/8/06	MJD
	J) ASSEMBLE STOCK		1-4-06	BG
	K) ASSEMBLE SWIVEL STUDS		3/8/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-4-06	BG
	M) IRON SIGHT ALIGNMENT		1-4-06	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-4-06	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1/5/06	MJD
	MALFUNCTION <i>Shells eject hard</i>	CORRECTION OK	1-24-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-5-06	MJD
670	FINAL INSPECTION A) HEADSPACE		3/8/06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.30</u> <u>2.52</u> <u>2.44</u> <u>2.55</u>	1-29-06	RA
	C) FUNCTION		3/8/06	MJD
690	PACK		3-24-06	RA

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 11-10-05

TESTER S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.39	2.62		2.62	
PULL #2	2.48	2.60		2.60	
PULL #3	2.47	2.50		2.63	
PULL #4	2.49	2.68		2.37	
PULL #5	2.53	2.62		2.55	
TOTAL	12.36	13.02		12.77	
AVERAGE	2.47	2.60		2.55	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.94	2.85		
PULL #2	2.91	2.93		
PULL #3	2.93	3.06		
PULL #4	2.92	3.20		
PULL #5	3.05	3.13		
TOTAL	14.75	15.17		
AVERAGE	2.95	3.03		

	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	3.92		4.00
PULL #2	3.97	3.92		4.08
PULL #3	3.96	3.91		4.05
PULL #4	4.03	4.00		3.95
PULL #5	3.98	4.02		4.18
TOTAL	19.94	19.77		20.26
AVERAGE	3.99	3.95		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

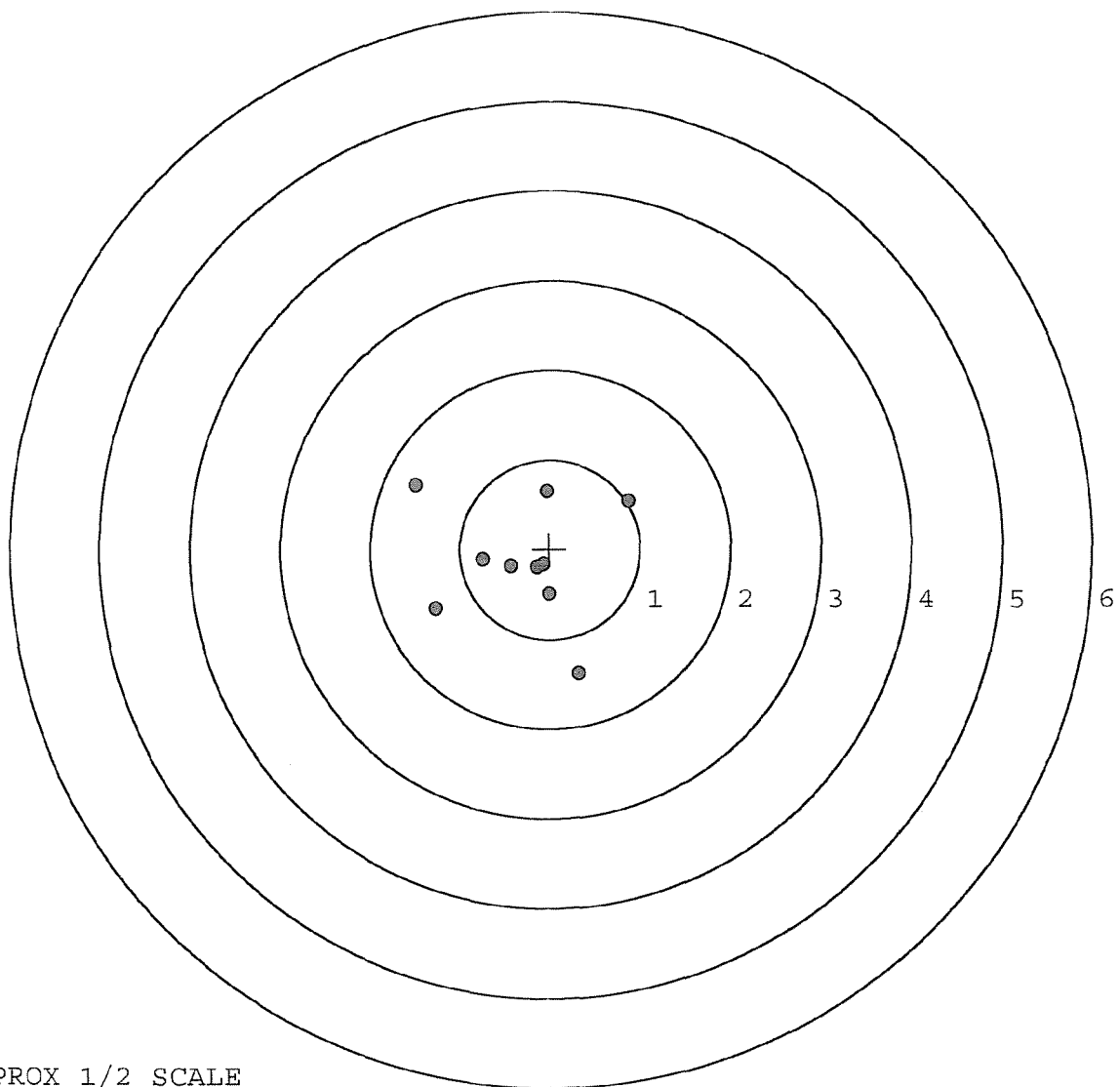
FIREARM SERIAL NUMBER / DATASET NAME: G6521326.___0

FILE DATE AND TIME: 01/05/2006 23:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.054
The Average Y Centroid of the Five Target Set:	-0.070
The Average Point of Impact of the Five Target Set:	0.089
The Average Mean Radius of the Five Target Set:	0.755
The Distance from POA to Centroid Target #1:	0.328
The Distance from Centroid Target #2 to Centroid Target #1:	0.322
The Distance from Centroid Target #3 to Centroid Target #1:	0.215
The Distance from Centroid Target #4 to Centroid Target #1:	0.372
The Distance from Centroid Target #5 to Centroid Target #1:	0.502

SERIAL NUMBER: G6521326. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	-0.037	0.648
FILE DATE: 01/05/2006	2:	0.868	0.544
FILE TIME: 23:10	3:	-1.499	0.716
	4:	-1.273	-0.661
X CENTROID: -0.301	5:	-0.741	-0.118
Y CENTROID: -0.131	6:	-0.430	-0.188
POA TO CENTROID: 0.328	7:	-0.071	-0.169
HORZ SPREAD: 2.367	8:	-0.013	-0.499
VERT SPREAD: 2.096	9:	0.328	-1.380
GROUP SPREAD: 2.780	10:	-0.145	-0.201
MIN RADIUS: 0.141			
MAX RADIUS: 1.467			
MEAN RADIUS: 0.760			
# IN 1 IN DIAMETER: 5			
# IN 2 IN DIAMETER: 6			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521326. 0

TARGET NUMBER: 2

FILE DATE: 01/05/2006

FILE TIME: 23:10

POINT#	X	Y
1:	0.205	1.065
2:	-0.383	0.740
3:	-1.638	0.365
4:	-0.583	0.298
5:	-0.007	0.301
6:	0.630	0.385
7:	-0.421	-0.420
8:	0.296	-0.385
9:	0.951	-0.326
10:	0.323	-1.172

X CENTROID: -0.063

Y CENTROID: 0.085

POA TO CENTROID: 0.106

HORZ SPREAD: 2.589

VERT SPREAD: 2.237

GROUP SPREAD: 2.680

MIN RADIUS: 0.223

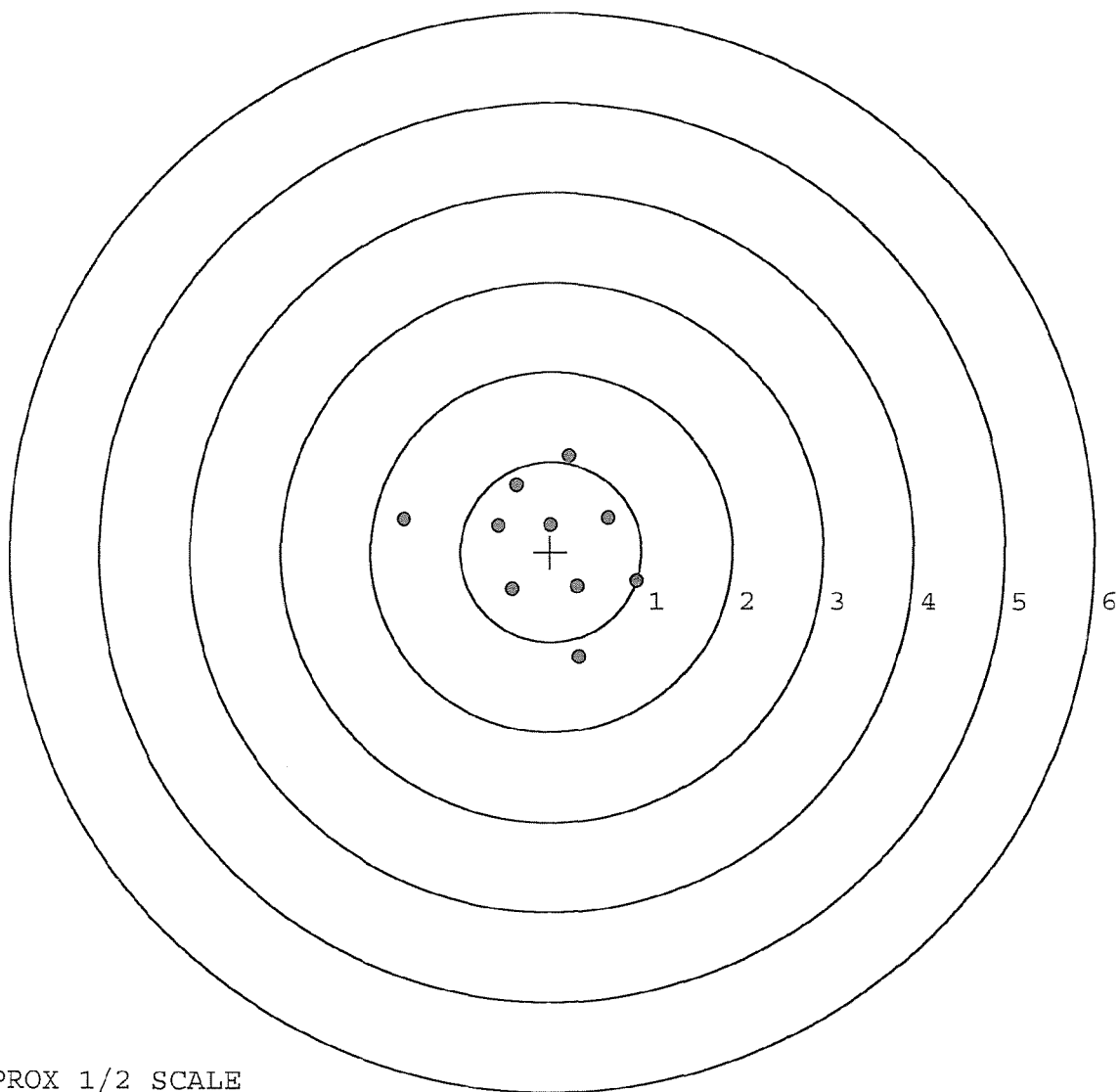
MAX RADIUS: 1.600

MEAN RADIUS: 0.850

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

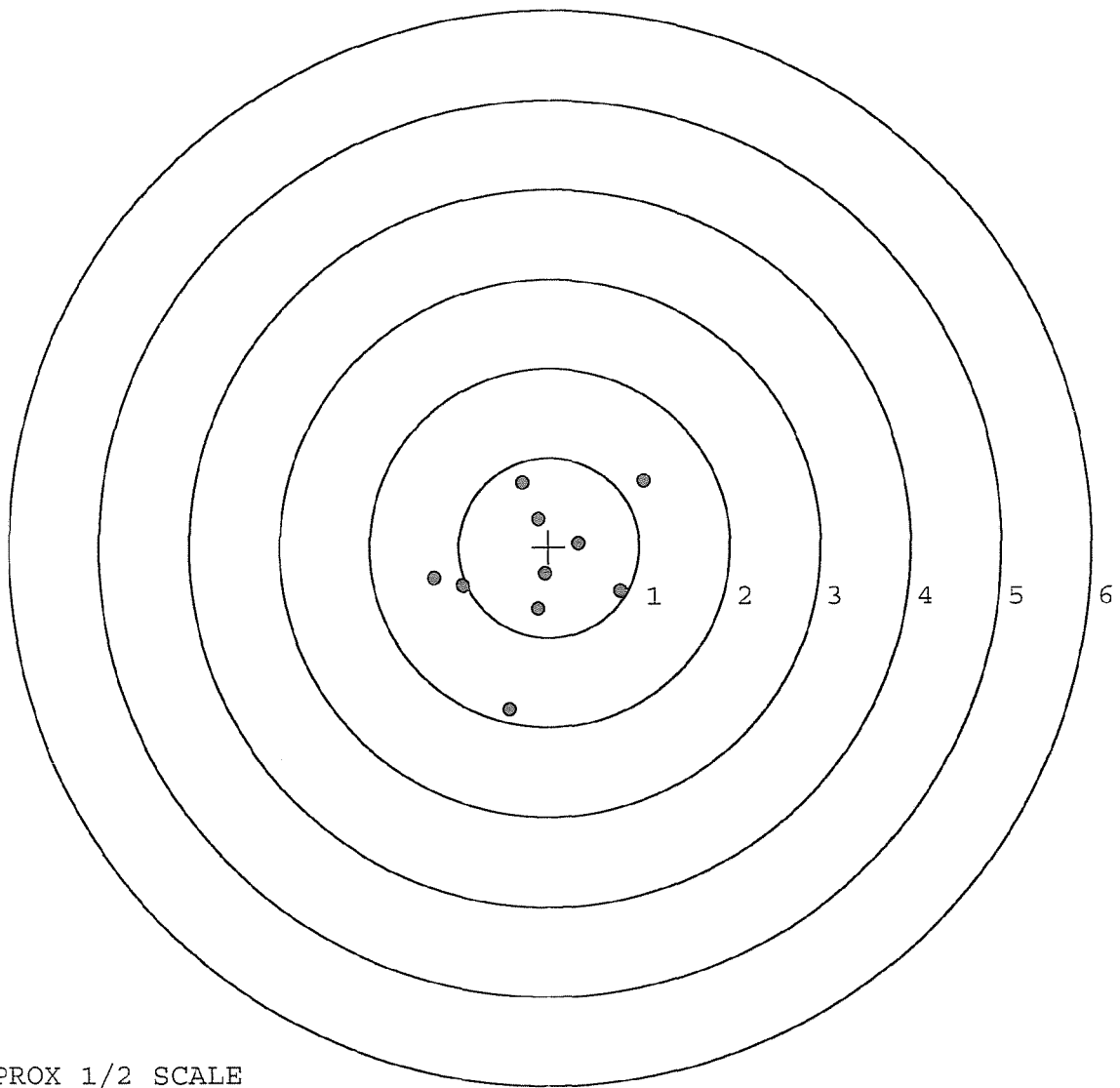


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521326. __0
TARGET NUMBER: 3
FILE DATE: 01/05/2006
FILE TIME: 23:10

X CENTROID: -0.109
Y CENTROID: -0.227
POA TO CENTROID: 0.252
HORZ SPREAD: 2.328
VERT SPREAD: 2.551
GROUP SPREAD: 2.952
MIN RADIUS: 0.098
MAX RADIUS: 1.619
MEAN RADIUS: 0.868
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.297	0.714
2:	-0.124	0.308
3:	1.049	0.738
4:	0.329	0.042
5:	0.788	-0.490
6:	-0.126	-0.690
7:	-0.955	-0.429
8:	-1.279	-0.350
9:	-0.436	-1.813
10:	-0.042	-0.298



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521326.___0

TARGET NUMBER: 4

FILE DATE: 01/05/2006

FILE TIME: 23:10

POINT#	X	Y
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1:	-0.080	0.398
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2:	0.275	0.458
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3:	0.352	-0.113
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4:	-0.190	-0.290
----	--------	--------

5:	-0.294	-0.065
----	--------	--------

6:	-0.898	0.192
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7:	1.232	-0.065
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8:	0.805	-0.640
----	-------	--------

9:	0.339	-0.913
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10:	-0.885	-0.884
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X CENTROID: 0.066

Y CENTROID: -0.192

POA TO CENTROID: 0.203

HORZ SPREAD: 2.130

VERT SPREAD: 1.371

GROUP SPREAD: 2.270

MIN RADIUS: 0.274

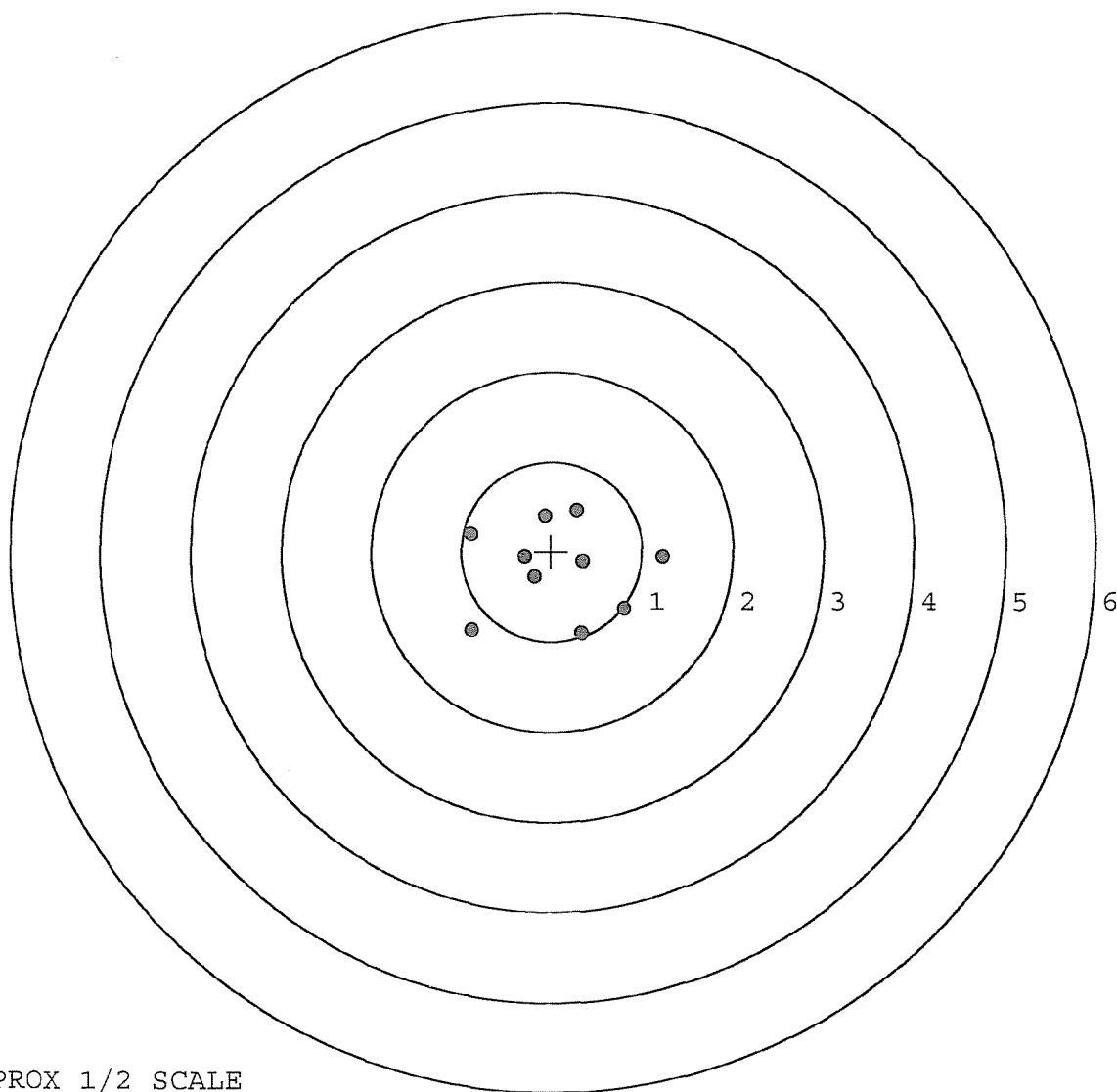
MAX RADIUS: 1.176

MEAN RADIUS: 0.726

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

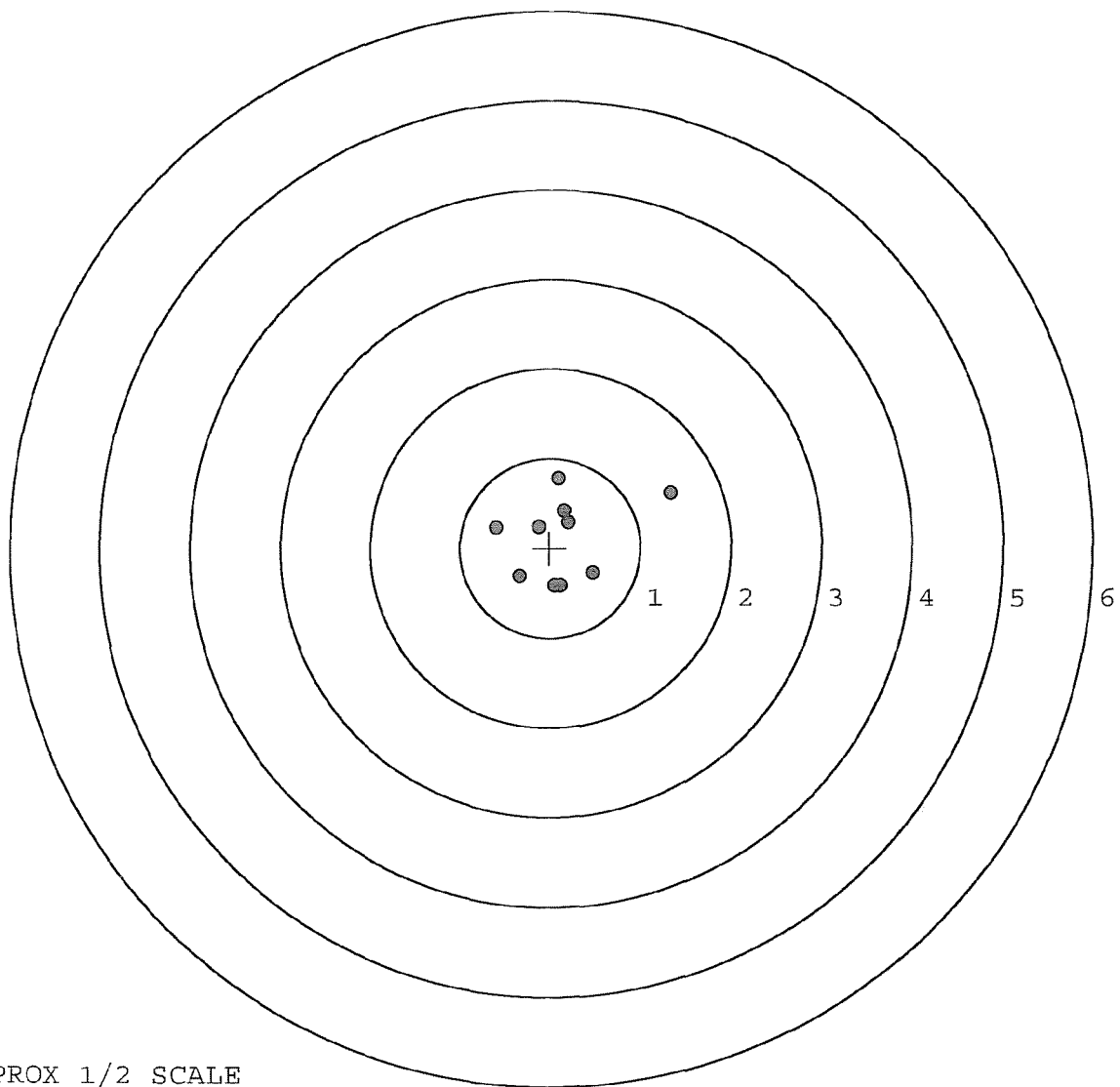


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521326. 0
TARGET NUMBER: 5
FILE DATE: 01/05/2006
FILE TIME: 23:10

POINT#	X	Y
1:	-0.337	-0.314
2:	0.057	-0.420
3:	0.126	-0.424
4:	0.478	-0.277
5:	1.331	0.615
6:	0.094	0.777
7:	0.156	0.419
8:	0.200	0.289
9:	-0.128	0.237
10:	-0.604	0.229

X CENTROID: 0.137
Y CENTROID: 0.113
POA TO CENTROID: 0.178
HORZ SPREAD: 1.935
VERT SPREAD: 1.201
GROUP SPREAD: 1.973
MIN RADIUS: 0.187
MAX RADIUS: 1.295
MEAN RADIUS: 0.573
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE