

G652 1387

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



0 47700 25716 7

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M/24 7.62 NATO S.W.S. (COMPLETE SYST

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SERIAL NO.



66521387

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

G6521387



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521387

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-12-06	RTZ
440	PROOF		1-12-06	AC
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-12-06	AC
470	DIS-ASSEMBLE ACTION		1-13-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 13 2006 480 OPERATOR <i>unus</i>	1/18/06	<i>unus</i>
500	ROLLMARK CALIBER		1-18-06	CW
510	DRILL AND TAP SIGHT HOLES		1-16-06	TRW
520	GOFF BLAST BBL / REC		1-18-06	DS
530 & 540	APPLY COATINGS (BARREL ACTION)		1/19	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-8-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-8-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-8-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-8-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	3/7/06	MPD

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.5</u> <u>6.5</u>	2-15-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.75</u> <u>2.25</u> <u>2.25</u>	2-15-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		3/7/06	MJD
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>		
	J) ASSEMBLE STOCK		2-8-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		3/7/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-8-06	RTZ
	M) IRON SIGHT ALIGNMENT		2-8-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-8-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	2-9-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-9-06	SH
670	FINAL INSPECTION A) HEADSPACE		3/7/06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.74</u> <u>2.79</u> <u>2.73</u> <u>2.21</u>	2-15-06	TRW
	C) FUNCTION		3/7/06	MJD
690	PACK		3-24-06	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)

DATE 2-8-06

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	2.67		2.59	
PULL #2	2.47	2.60		2.56	
PULL #3	2.61	2.58		2.55	
PULL #4	2.60	2.62		2.58	
PULL #5	2.63	2.36		2.54	
TOTAL	12.82	12.83		12.82	
AVERAGE	2.56	2.56		2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.28		
PULL #2	3.11	3.18		
PULL #3	3.06	3.22		
PULL #4	3.18	3.21		
PULL #5	3.17	3.22		
TOTAL	15.63	16.11		
AVERAGE	3.12	3.22		

	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	4.15	4.33		4.18
PULL #2	4.14	4.19		4.29
PULL #3	4.16	4.27		4.20
PULL #4	4.31	4.02		4.17
PULL #5	4.19	4.18		4.15
TOTAL	20.95	20.99		20.99
AVERAGE	4.19	4.19		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521387.___0

FILE DATE AND TIME: 02/09/2006 07:41

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.026
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.026
The Average Mean Radius of the Five Target Set:	0.777
The Distance from POA to Centroid Target #1:	0.121
The Distance from Centroid Target #2 to Centroid Target #1:	0.137
The Distance from Centroid Target #3 to Centroid Target #1:	0.172
The Distance from Centroid Target #4 to Centroid Target #1:	0.201
The Distance from Centroid Target #5 to Centroid Target #1:	0.129

SERIAL NUMBER: G6521387. __0

TARGET NUMBER: 1

FILE DATE: 02/09/2006

FILE TIME: 07:41

POINT#	X	Y
--------	---	---

1:	0.806	-0.786
----	-------	--------

2:	0.582	-0.694
----	-------	--------

3:	0.772	-0.057
----	-------	--------

4:	0.061	-0.044
----	-------	--------

5:	0.102	0.605
----	-------	-------

6:	-0.400	-0.060
----	--------	--------

7:	-0.649	0.364
----	--------	-------

8:	-0.569	1.114
----	--------	-------

9:	-0.506	-0.765
----	--------	--------

10:	-0.286	-0.886
-----	--------	--------

X CENTROID: -0.009

Y CENTROID: -0.121

POA TO CENTROID: 0.121

HORZ SPREAD: 1.455

VERT SPREAD: 2.000

GROUP SPREAD: 2.345

MIN RADIUS: 0.104

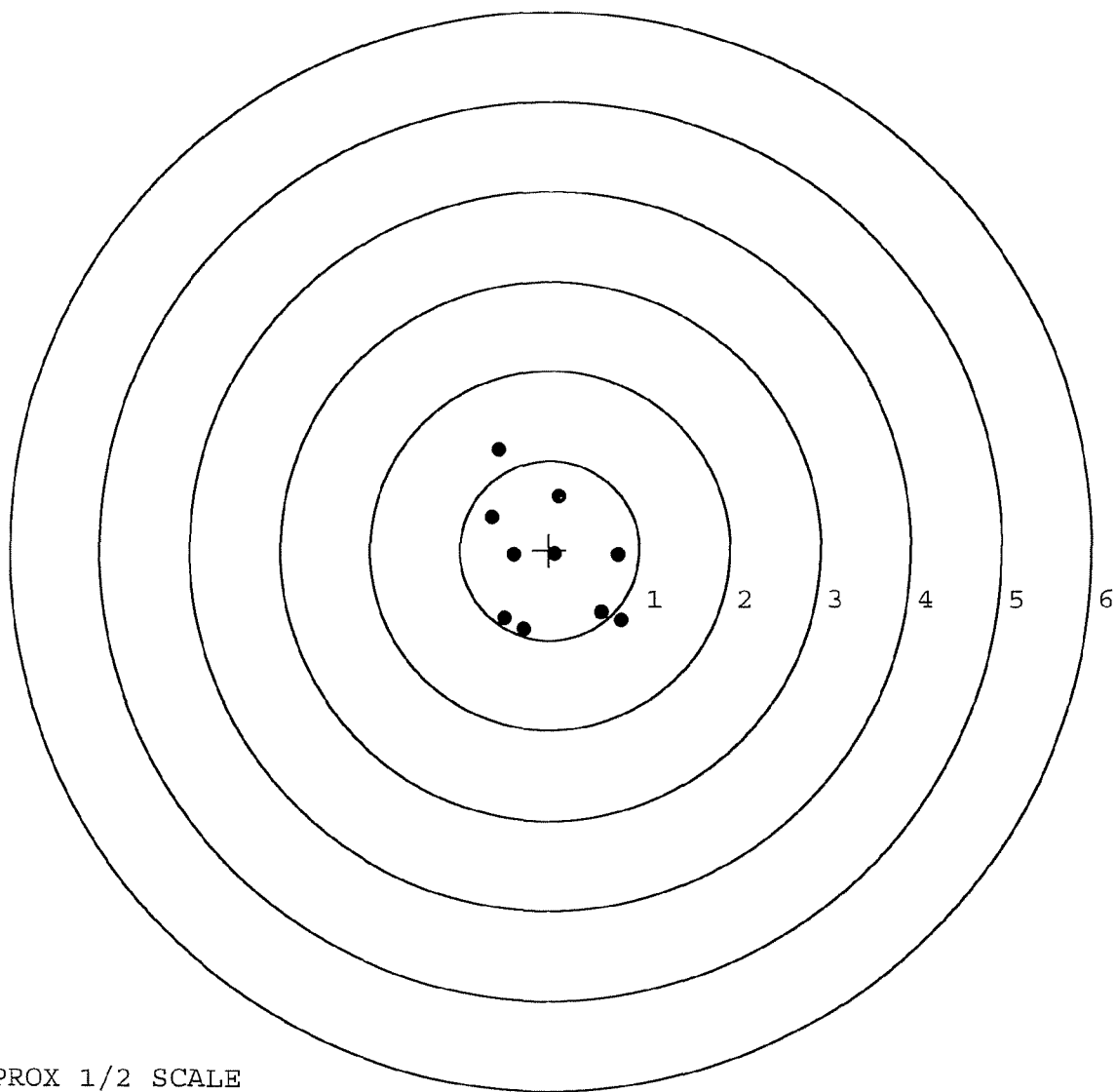
MAX RADIUS: 1.356

MEAN RADIUS: 0.768

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521387. 0

TARGET NUMBER: 2

FILE DATE: 02/09/2006

FILE TIME: 07:41

POINT#	X	Y
1:	1.276	0.036
2:	0.353	0.906
3:	-0.178	1.185
4:	0.641	-0.489
5:	0.370	-0.426
6:	-0.136	-0.496
7:	-0.261	0.101
8:	-0.408	-0.156
9:	-0.689	-0.128
10:	-0.632	-0.442

X CENTROID: 0.034

Y CENTROID: 0.009

POA TO CENTROID: 0.035

HORZ SPREAD: 1.965

VERT SPREAD: 1.681

GROUP SPREAD: 1.972

MIN RADIUS: 0.309

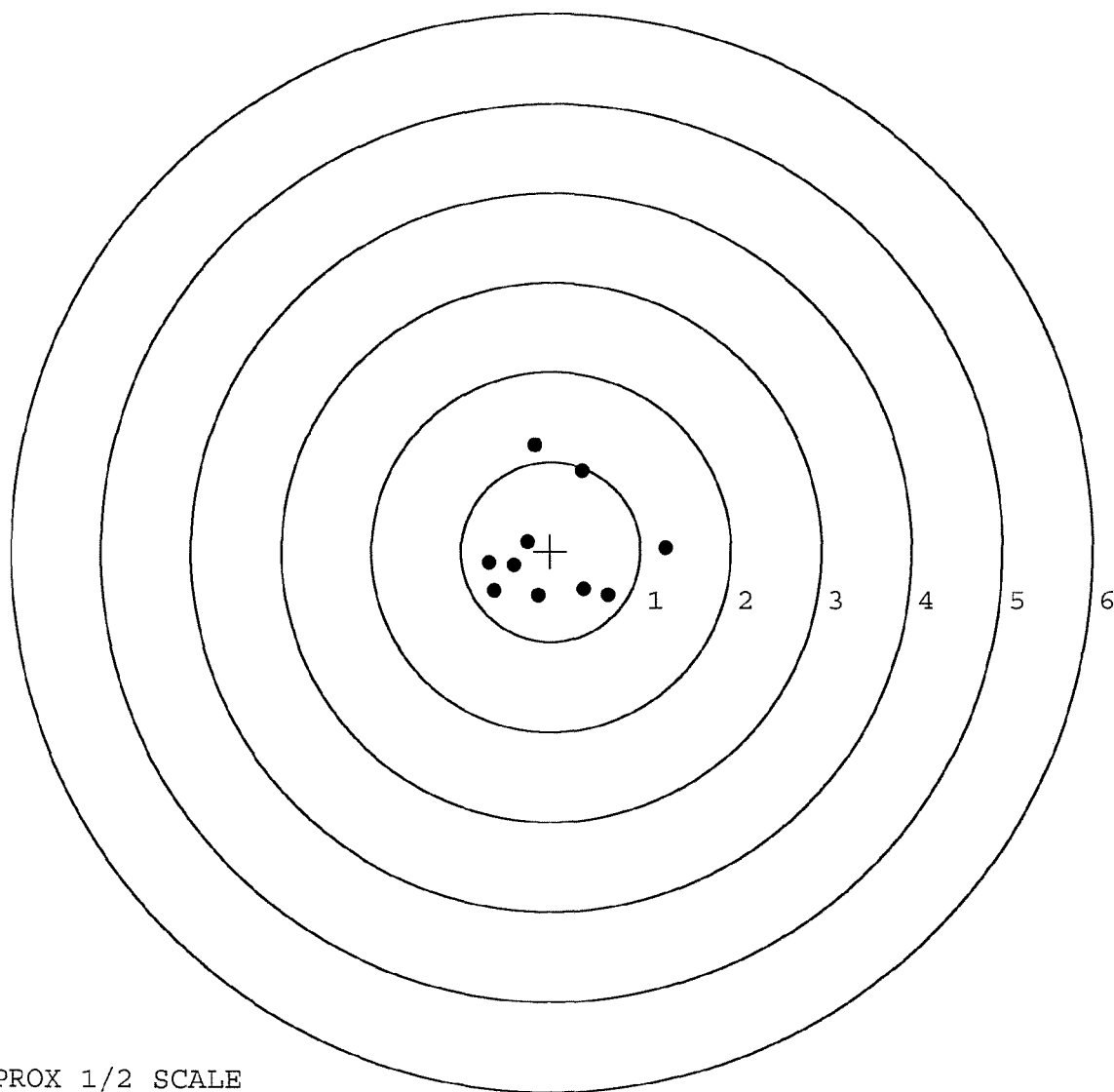
MAX RADIUS: 1.243

MEAN RADIUS: 0.758

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521387. 0

TARGET NUMBER: 3

FILE DATE: 02/09/2006

FILE TIME: 07:41

POINT#	X	Y
--------	---	---

1:	0.692	-0.797
----	-------	--------

2:	0.666	-0.153
----	-------	--------

3:	0.581	0.012
----	-------	-------

4:	0.071	-0.605
----	-------	--------

5:	-0.041	-0.522
----	--------	--------

6:	-0.508	-0.115
----	--------	--------

7:	0.075	0.639
----	-------	-------

8:	-0.248	0.573
----	--------	-------

9:	-0.508	0.716
----	--------	-------

10:	-1.544	0.622
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X CENTROID: -0.076

Y CENTROID: 0.037

POA TO CENTROID: 0.085

HORZ SPREAD: 2.236

VERT SPREAD: 1.513

GROUP SPREAD: 2.648

MIN RADIUS: 0.458

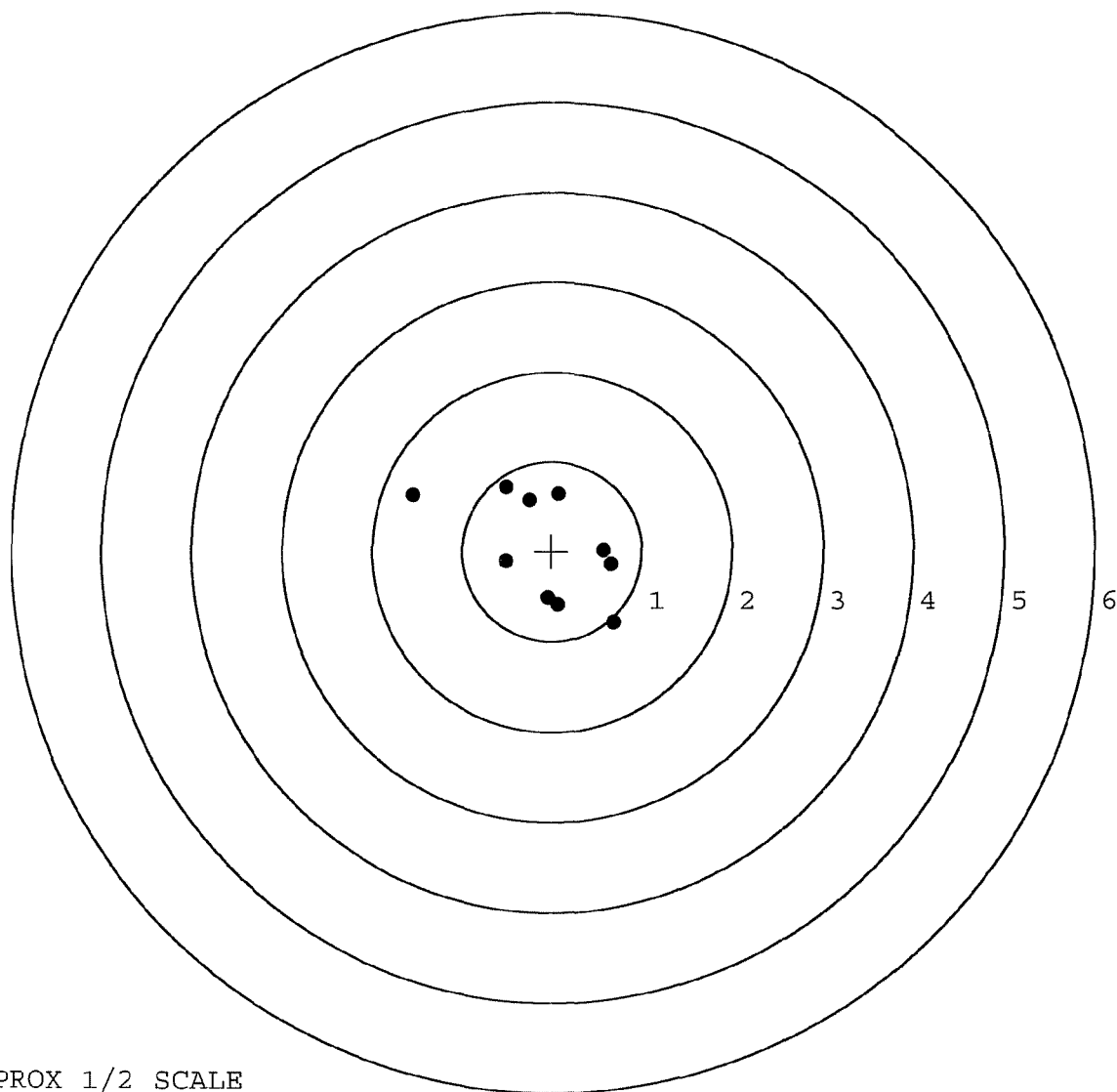
MAX RADIUS: 1.580

MEAN RADIUS: 0.780

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521387. 0

TARGET NUMBER: 4

FILE DATE: 02/09/2006

FILE TIME: 07:41

POINT#	X	Y
1:	-0.099	0.872
2:	-0.271	0.160
3:	-0.511	0.512
4:	-0.862	0.643
5:	-0.940	0.029
6:	0.479	-0.125
7:	0.924	-0.248
8:	0.619	-0.547
9:	0.139	-0.645
10:	-0.183	0.055

X CENTROID: -0.071

Y CENTROID: 0.071

POA TO CENTROID: 0.100

HORZ SPREAD: 1.864

VERT SPREAD: 1.517

GROUP SPREAD: 1.996

MIN RADIUS: 0.114

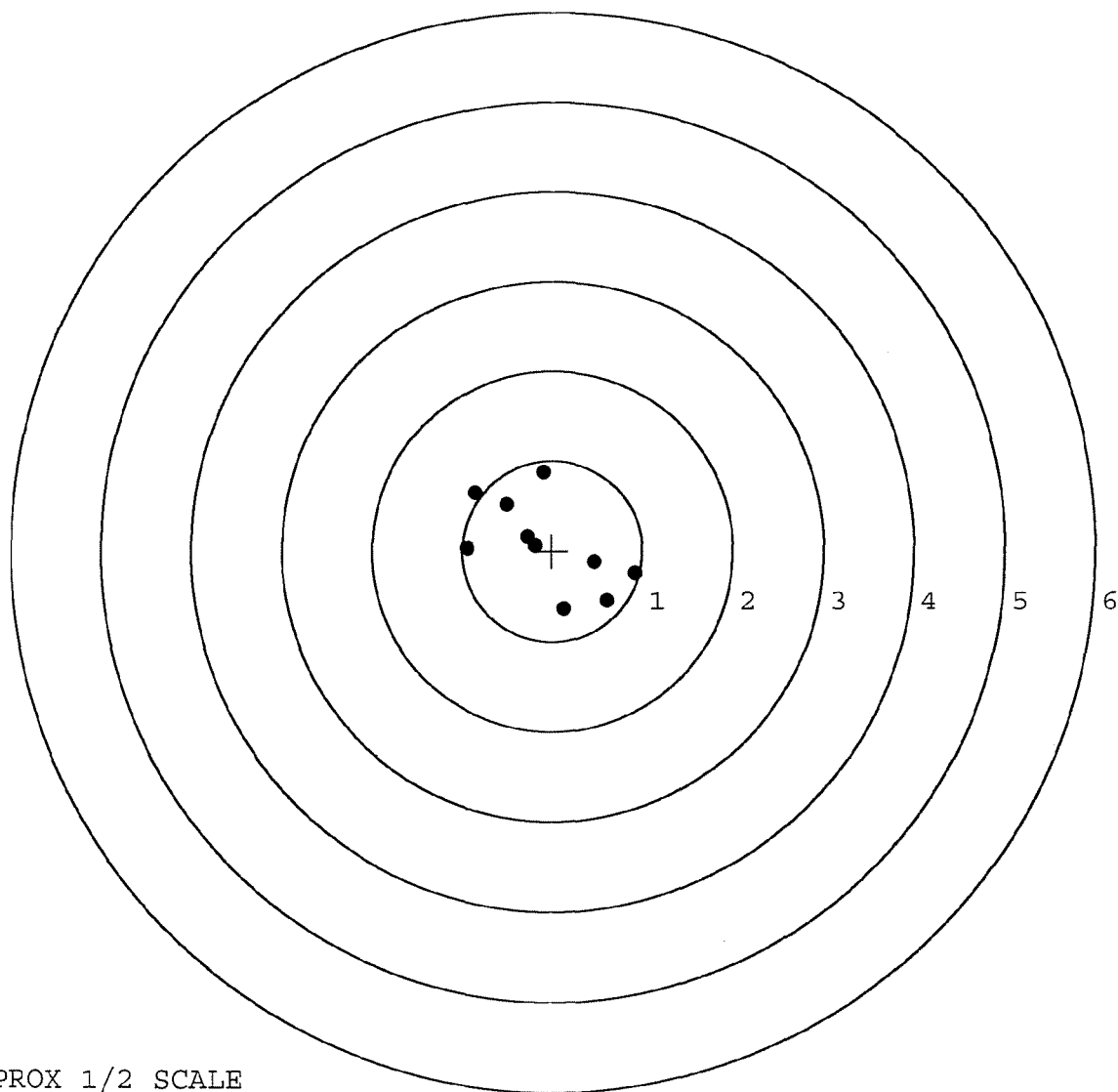
MAX RADIUS: 1.044

MEAN RADIUS: 0.690

IN 1 IN DIAMETER: 2

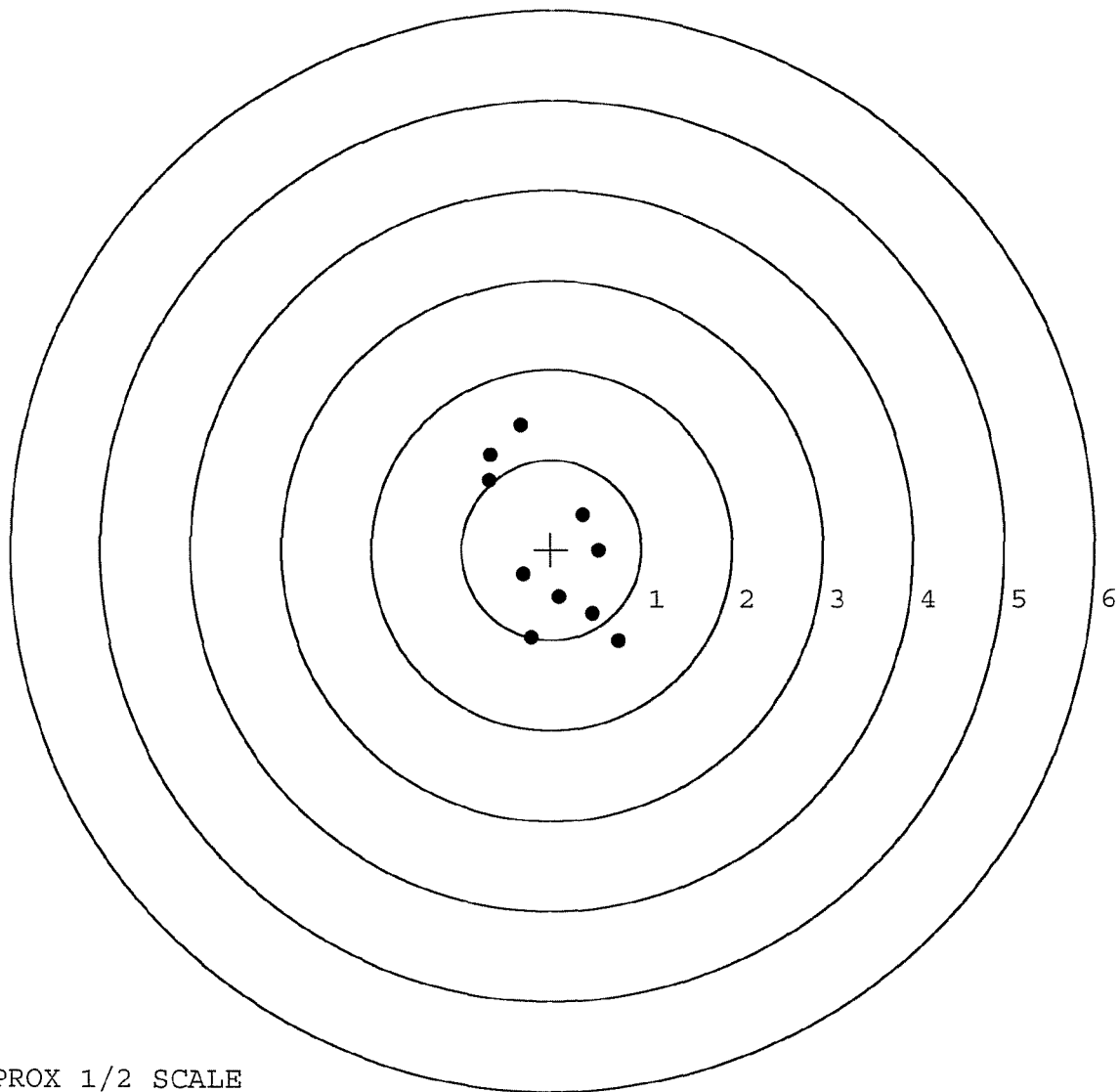
IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521387. 0	POINT#	X	Y
TARGET NUMBER: 5	1:	0.749	-1.019
FILE DATE: 02/09/2006	2:	0.463	-0.708
FILE TIME: 07:41	3:	0.091	-0.531
	4:	-0.225	-0.984
X CENTROID: -0.009	5:	-0.311	-0.275
Y CENTROID: 0.008	6:	0.530	-0.013
POA TO CENTROID: 0.012	7:	0.347	0.388
HORZ SPREAD: 1.443	8:	-0.694	0.776
VERT SPREAD: 2.404	9:	-0.686	1.058
GROUP SPREAD: 2.645	10:	-0.353	1.385
MIN RADIUS: 0.414			
MAX RADIUS: 1.420			
MEAN RADIUS: 0.887			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 5			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE