

G-652 1401

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



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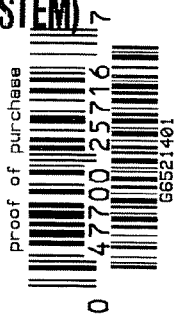
SERIAL NO.

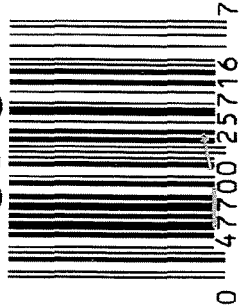


M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6521401	
UPC	
	

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521401

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-16-06	RTZ
440	PROOF		1/17/06	MJD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1/17/06	MJD
470	DIS-ASSEMBLE ACTION		1/17/06	MJD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 480 JAN 20 2006 OPERATOR <u>APD</u>	1/20/06	APD
500	ROLLMARK CALIBER		1-19-06	CW
510	DRILL AND TAP SIGHT HOLES		1-19-06	TRW
520	GOFF BLAST BBL / REC		1-20-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1/25	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-6-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-6-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-6-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-6-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	3/10/06	MJD

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.5</u> <u>4.5</u> <u>4.5</u>	2/7/06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	2/7/06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/10/06	MJB
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3/10/06	MJB
	J) ASSEMBLE STOCK		2-6-06	RT
	K) ASSEMBLE SWIVEL STUDS		3/10/06	MJB
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-6-06	RT
	M) IRON SIGHT ALIGNMENT		2-6-06	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-6-06	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	2-6-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-6-06	KH
670	FINAL INSPECTION A) HEADSPACE		3/10/06	MJB
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.26</u> <u>2.32</u> <u>2.30</u> <u>2.32</u> <u>2.46</u>	2/7/06	DA
	C) FUNCTION		3/10/06	MJB
690	PACK			

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 2-3-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.42		2.44	
PULL #2	2.31	2.44		2.47	
PULL #3	2.34	2.44		2.52	
PULL #4	2.57	2.32		2.30	
PULL #5	2.55	2.47		2.57	
TOTAL	12.31	12.09		12.30	
AVERAGE	2.46	2.41		2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.03		
PULL #2	3.08	2.99		
PULL #3	3.06	2.90		
PULL #4	3.08	3.08		
PULL #5	3.10	3.03		
TOTAL	15.35	15.03		
AVERAGE	3.07	3.00		

	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	4.01	4.08		4.17
PULL #2	4.10	4.09		4.02
PULL #3	4.11	4.10		4.23
PULL #4	4.09	3.98		4.06
PULL #5	4.08	4.15		4.14
TOTAL	20.39	20.40		20.62
AVERAGE	4.07	4.08		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521401.___0
FILE DATE AND TIME: 02/06/2006 04:22

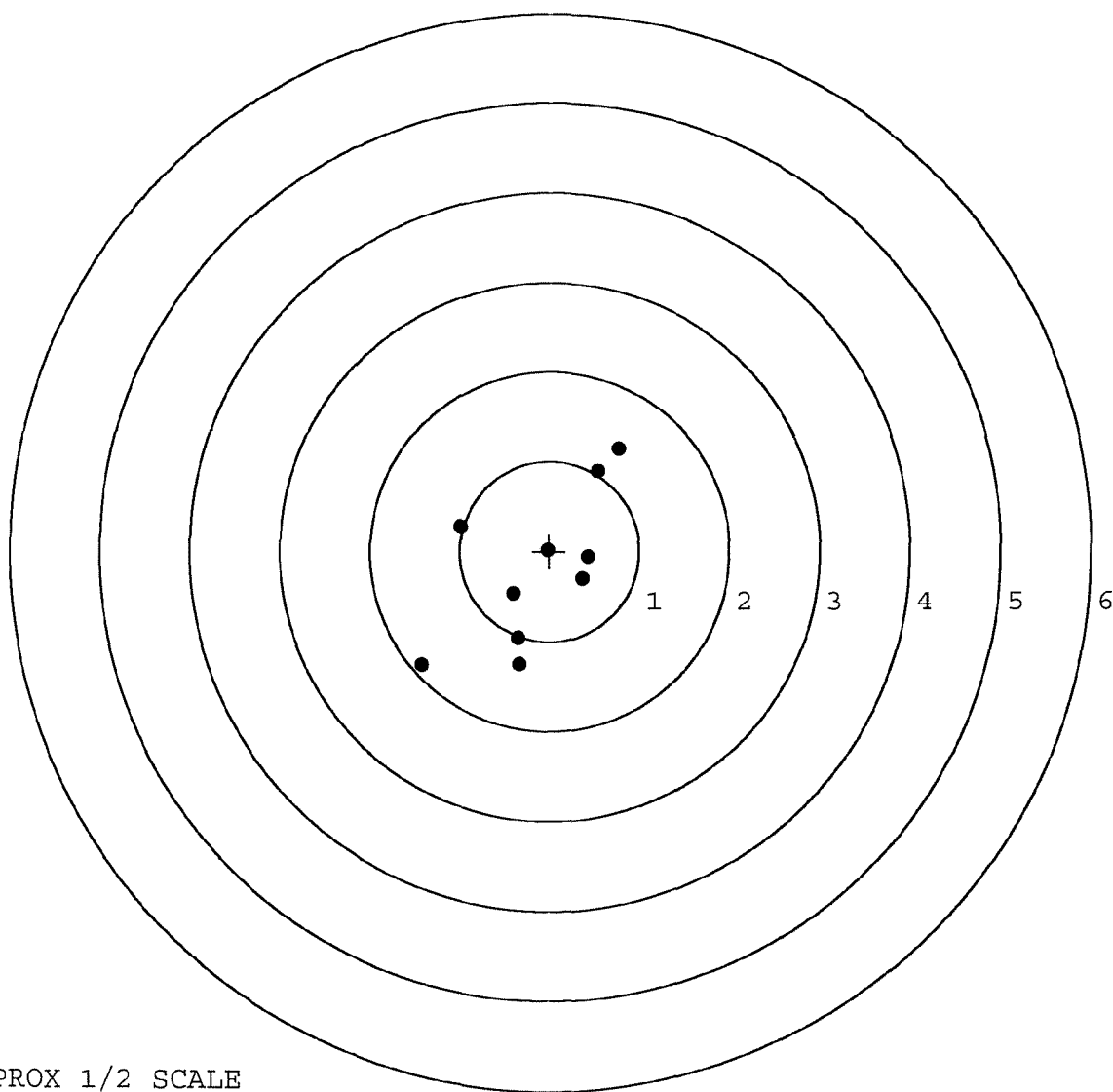
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.071
The Average Y Centroid of the Five Target Set:	-0.106
The Average Point of Impact of the Five Target Set:	0.128
The Average Mean Radius of the Five Target Set:	0.649
The Distance from POA to Centroid Target #1:	0.244
The Distance from Centroid Target #2 to Centroid Target #1:	0.169
The Distance from Centroid Target #3 to Centroid Target #1:	0.201
The Distance from Centroid Target #4 to Centroid Target #1:	0.085
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: G6521401. __0
TARGET NUMBER: 1
FILE DATE: 02/06/2006
FILE TIME: 04:22

X CENTROID: -0.138
Y CENTROID: -0.202
POA TO CENTROID: 0.244
HORZ SPREAD: 2.194
VERT SPREAD: 2.408
GROUP SPREAD: 3.258
MIN RADIUS: 0.249
MAX RADIUS: 1.664
MEAN RADIUS: 0.917
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.779	1.140
2:	0.546	0.891
3:	0.437	-0.063
4:	0.370	-0.302
5:	-0.016	0.016
6:	-0.403	-0.468
7:	-0.998	0.270
8:	-1.415	-1.268
9:	-0.349	-0.972
10:	-0.328	-1.260



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521401. 0

TARGET NUMBER: 2

FILE DATE: 02/06/2006

FILE TIME: 04:22

POINT#	X	Y
1:	0.830	-0.268
2:	0.235	-0.732
3:	-0.328	-0.676
4:	-0.721	-0.460
5:	-0.534	-0.071
6:	0.092	0.031
7:	0.194	0.128
8:	0.040	0.356
9:	-0.193	0.511
10:	-0.443	0.761

X CENTROID: -0.083

Y CENTROID: -0.042

POA TO CENTROID: 0.093

HORZ SPREAD: 1.551

VERT SPREAD: 1.493

GROUP SPREAD: 1.637

MIN RADIUS: 0.189

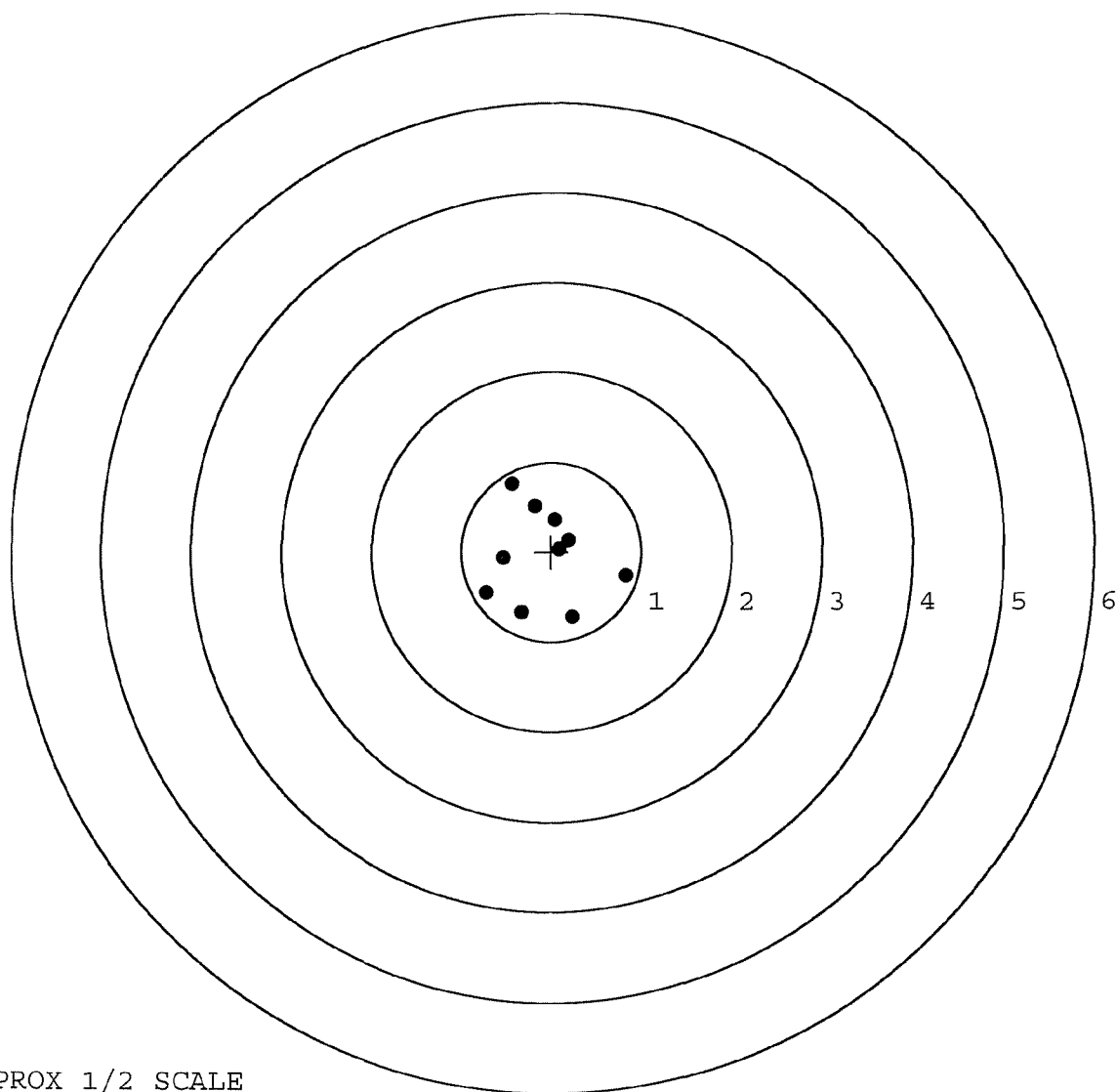
MAX RADIUS: 0.940

MEAN RADIUS: 0.597

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

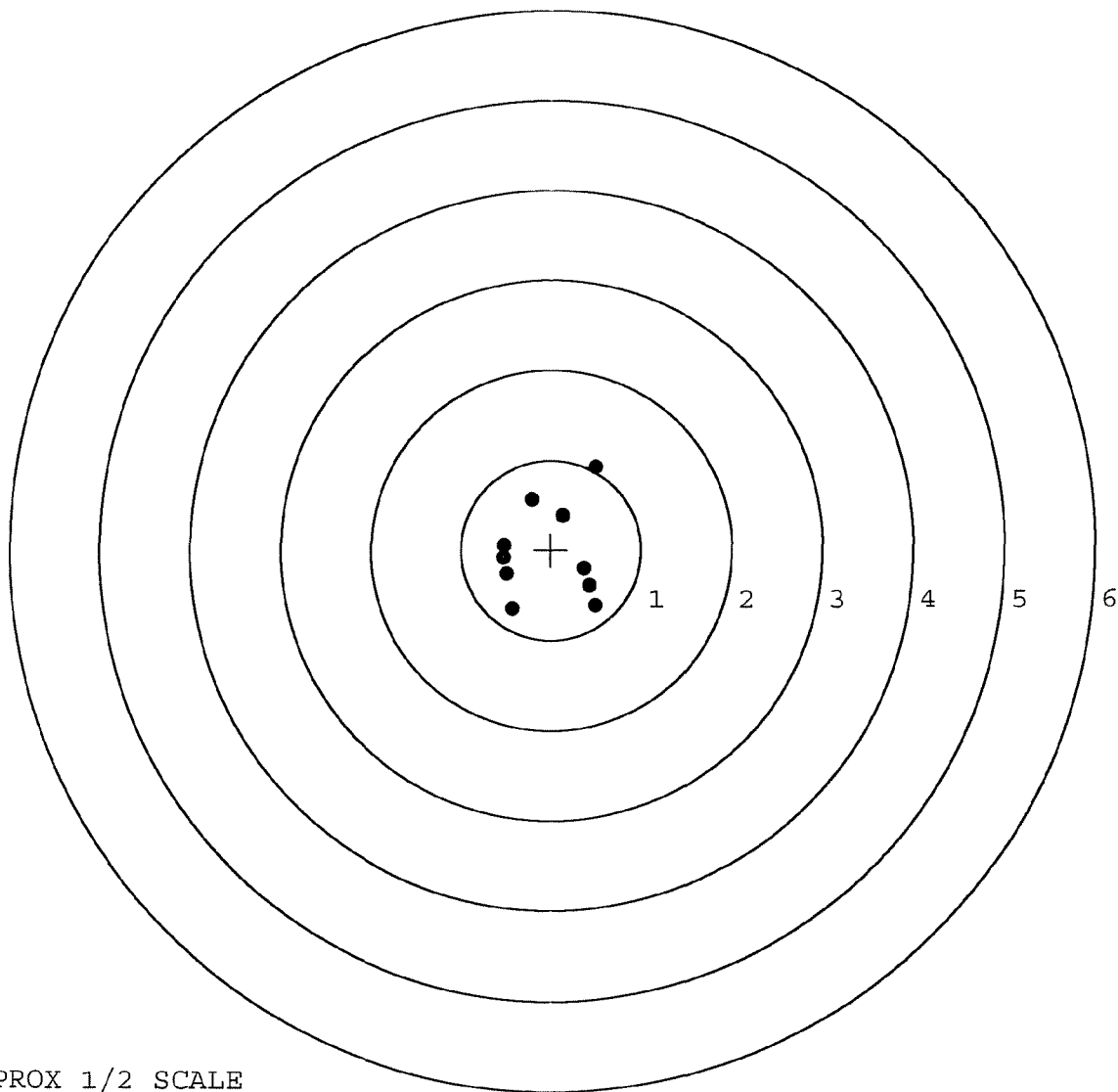


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521401.___0
TARGET NUMBER: 3
FILE DATE: 02/06/2006
FILE TIME: 04:22

X CENTROID: -0.027
Y CENTROID: -0.034
POA TO CENTROID: 0.043
HORZ SPREAD: 1.032
VERT SPREAD: 1.585
GROUP SPREAD: 1.839
MIN RADIUS: 0.434
MAX RADIUS: 1.096
MEAN RADIUS: 0.625
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.497	-0.620
2:	0.427	-0.402
3:	0.370	-0.209
4:	-0.429	-0.660
5:	-0.498	-0.273
6:	-0.524	0.047
7:	0.130	0.383
8:	-0.218	0.561
9:	0.503	0.925
10:	-0.529	-0.091



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521401.___0

TARGET NUMBER: 4

FILE DATE: 02/06/2006

FILE TIME: 04:22

POINT#	X	Y
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1:	0.716	-0.537
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2:	0.550	0.080
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3:	0.479	0.422
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4:	0.195	0.369
----	-------	-------

5:	-0.012	0.011
----	--------	-------

6:	-0.218	-0.281
----	--------	--------

7:	-0.463	-0.773
----	--------	--------

8:	-0.611	-0.481
----	--------	--------

9:	-0.670	-0.259
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10:	-0.836	0.112
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X CENTROID: -0.087

Y CENTROID: -0.134

POA TO CENTROID: 0.160

HORZ SPREAD: 1.552

VERT SPREAD: 1.195

GROUP SPREAD: 1.682

MIN RADIUS: 0.163

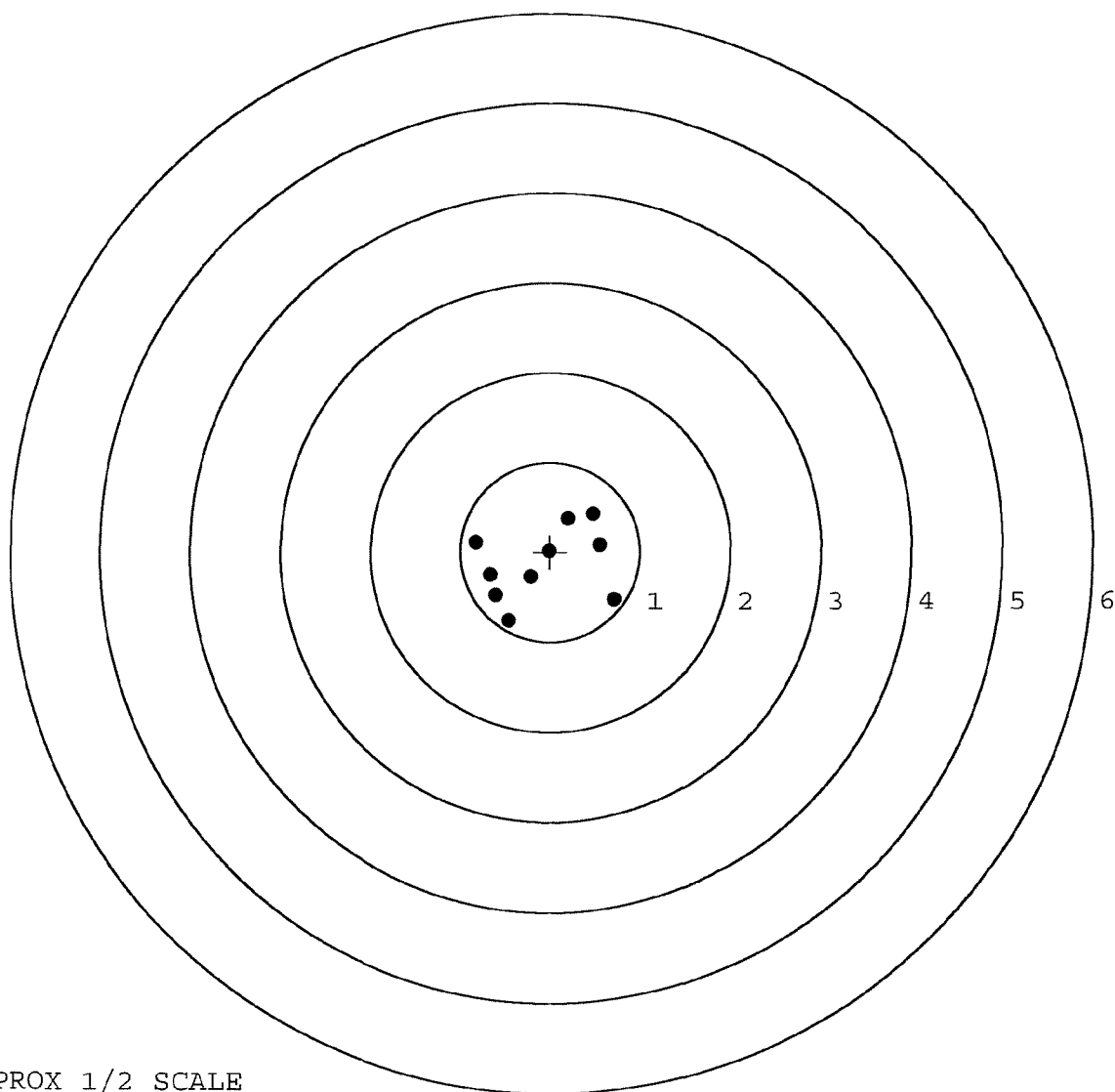
MAX RADIUS: 0.899

MEAN RADIUS: 0.606

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521401.___0

TARGET NUMBER: 5

FILE DATE: 02/06/2006

FILE TIME: 04:22

POINT#	X	Y
1:	0.482	-0.811
2:	-0.720	0.294
3:	0.114	0.435
4:	0.416	0.078
5:	0.277	-0.235
6:	0.001	-0.616
7:	-0.227	-0.593
8:	-0.339	-0.042
9:	-0.273	0.260
10:	0.054	0.047

X CENTROID: -0.022

Y CENTROID: -0.118

POA TO CENTROID: 0.120

HORZ SPREAD: 1.202

VERT SPREAD: 1.246

GROUP SPREAD: 1.633

MIN RADIUS: 0.182

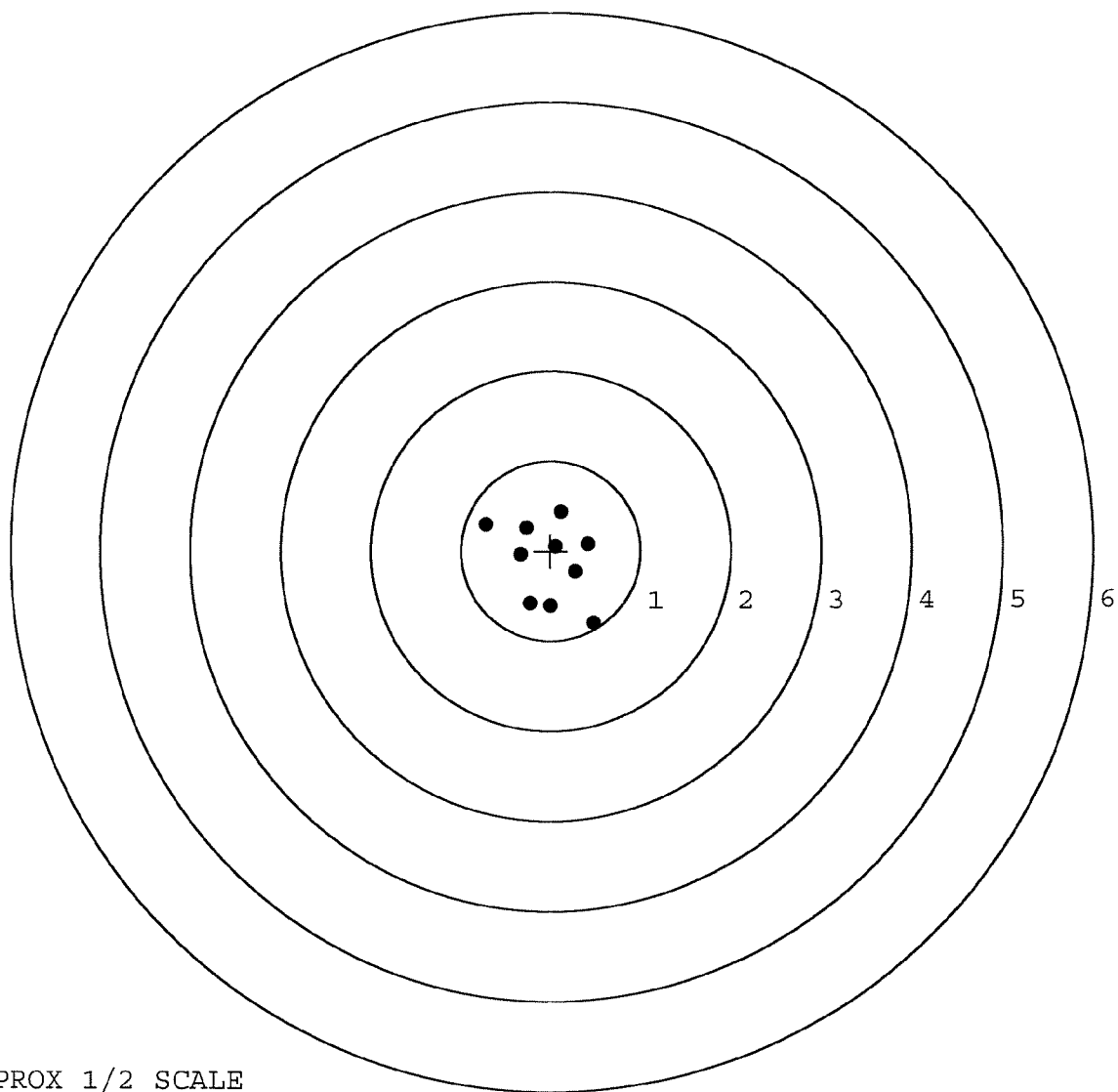
MAX RADIUS: 0.856

MEAN RADIUS: 0.502

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE