

G 652 1409

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

- INSTRUCTION BOOK 3518

DD FORM

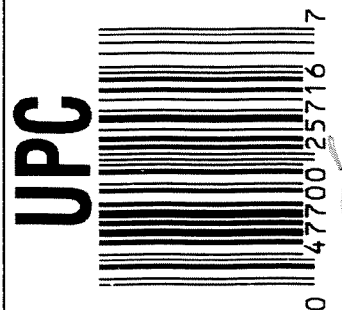


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6521409



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



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



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521409

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-16-06	RTZ
440	PROOF	MAGNA-FLUX INSPECTED	1/17/06	MPB
460	CHECK HEADSPACE	JAN 20 2006	1/17/06	MPB
470	DIS-ASSEMBLE ACTION	OPERATOR <u>APD</u>	1/17/06	MPB
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 480	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	MP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-30-06	BG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-30-06	BG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-30-06	BG
	D) OIL FIRING PIN ASSEMBLY		1-31-06	A
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/14/06	MPB

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>	2/3/06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	2/3/06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.023</u>	3-14-06	RA
	J) ASSEMBLE STOCK		2-1-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		3/14/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-1-06	RTZ
	M) IRON SIGHT ALIGNMENT		2-1-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-1-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	2-2-06	MOM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2/2/06	MJD
670	FINAL INSPECTION A) HEADSPACE			
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.83</u> <u>2.89</u> <u>2.79</u> <u>2.74</u>	2/3/06	RA
	C) FUNCTION		3/14/06	MJD
690	PACK		3-28-06	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)

DATE 1-24-06

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.56	2.79		2.34	
PULL #2	2.59	2.75		2.33	
PULL #3	2.26	2.73		2.54	
PULL #4	2.79	2.56		2.63	
PULL #5	2.85	2.66		2.18	
TOTAL	13.05	13.49		12.02	
AVERAGE	2.61	2.69		2.40	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.16		
PULL #2	3.44	3.19		
PULL #3	3.37	3.10		
PULL #4	3.13	3.14		
PULL #5	3.45	3.13		
TOTAL	16.85	15.72		
AVERAGE	3.37	3.14		

	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	4.11	4.24		3.99
PULL #2	4.62	4.25		4.22
PULL #3	4.19	4.27		4.39
PULL #4	4.53	4.29		4.24
PULL #5	4.10	4.15		4.14
TOTAL	21.55	21.20		20.98
AVERAGE	4.31	4.24		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521409.__0
FILE DATE AND TIME: 02/02/2006 15:36

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.021
The Average Y Centroid of the Five Target Set:	0.056
The Average Point of Impact of the Five Target Set:	0.060
The Average Mean Radius of the Five Target Set:	0.592
The Distance from POA to Centroid Target #1:	0.229
The Distance from Centroid Target #2 to Centroid Target #1:	0.363
The Distance from Centroid Target #3 to Centroid Target #1:	0.238
The Distance from Centroid Target #4 to Centroid Target #1:	0.083
The Distance from Centroid Target #5 to Centroid Target #1:	0.366

SERIAL NUMBER: G6521409. __0

TARGET NUMBER: 1

FILE DATE: 02/02/2006

FILE TIME: 15:36

POINT#	X	Y
1:	-0.342	-0.208
2:	-0.967	0.567
3:	-0.552	0.571
4:	-0.213	0.642
5:	0.053	0.521
6:	0.171	0.219
7:	0.573	0.215
8:	0.490	0.020
9:	0.721	-0.396
10:	0.587	0.083

X CENTROID: 0.052

Y CENTROID: 0.223

POA TO CENTROID: 0.229

HORZ SPREAD: 1.688

VERT SPREAD: 1.038

GROUP SPREAD: 1.943

MIN RADIUS: 0.119

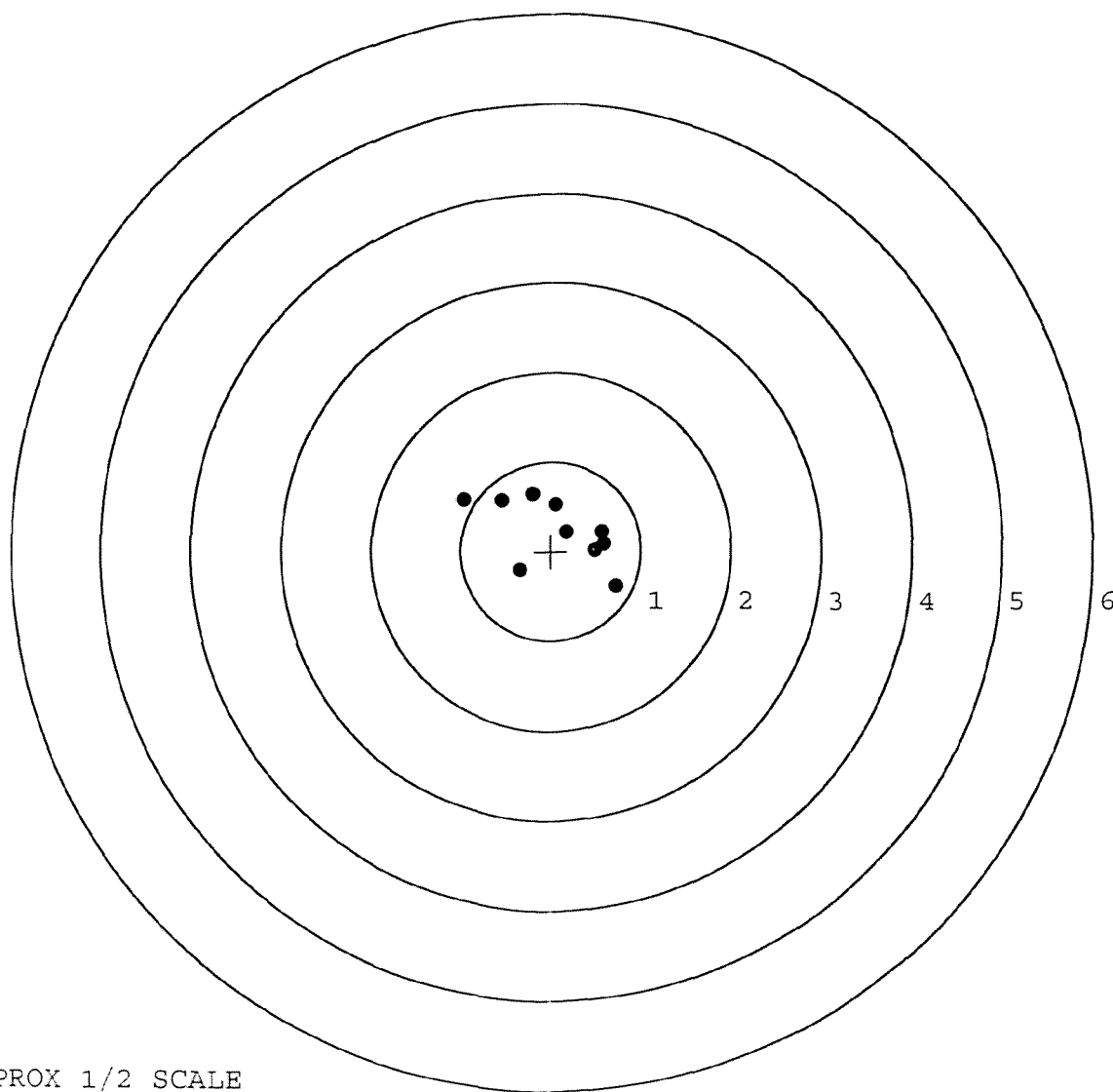
MAX RADIUS: 1.075

MEAN RADIUS: 0.574

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521409. __0

TARGET NUMBER: 2

FILE DATE: 02/02/2006

FILE TIME: 15:36

POINT#	X	Y
1:	0.936	0.122
2:	0.536	-0.324
3:	0.119	-0.297
4:	-0.174	-0.283
5:	-0.292	-0.036
6:	-0.107	0.205
7:	-0.099	0.635
8:	-1.019	0.075
9:	-0.973	-0.107
10:	-0.940	-0.352

X CENTROID: -0.201

Y CENTROID: -0.036

POA TO CENTROID: 0.205

HORZ SPREAD: 1.955

VERT SPREAD: 0.987

GROUP SPREAD: 1.956

MIN RADIUS: 0.091

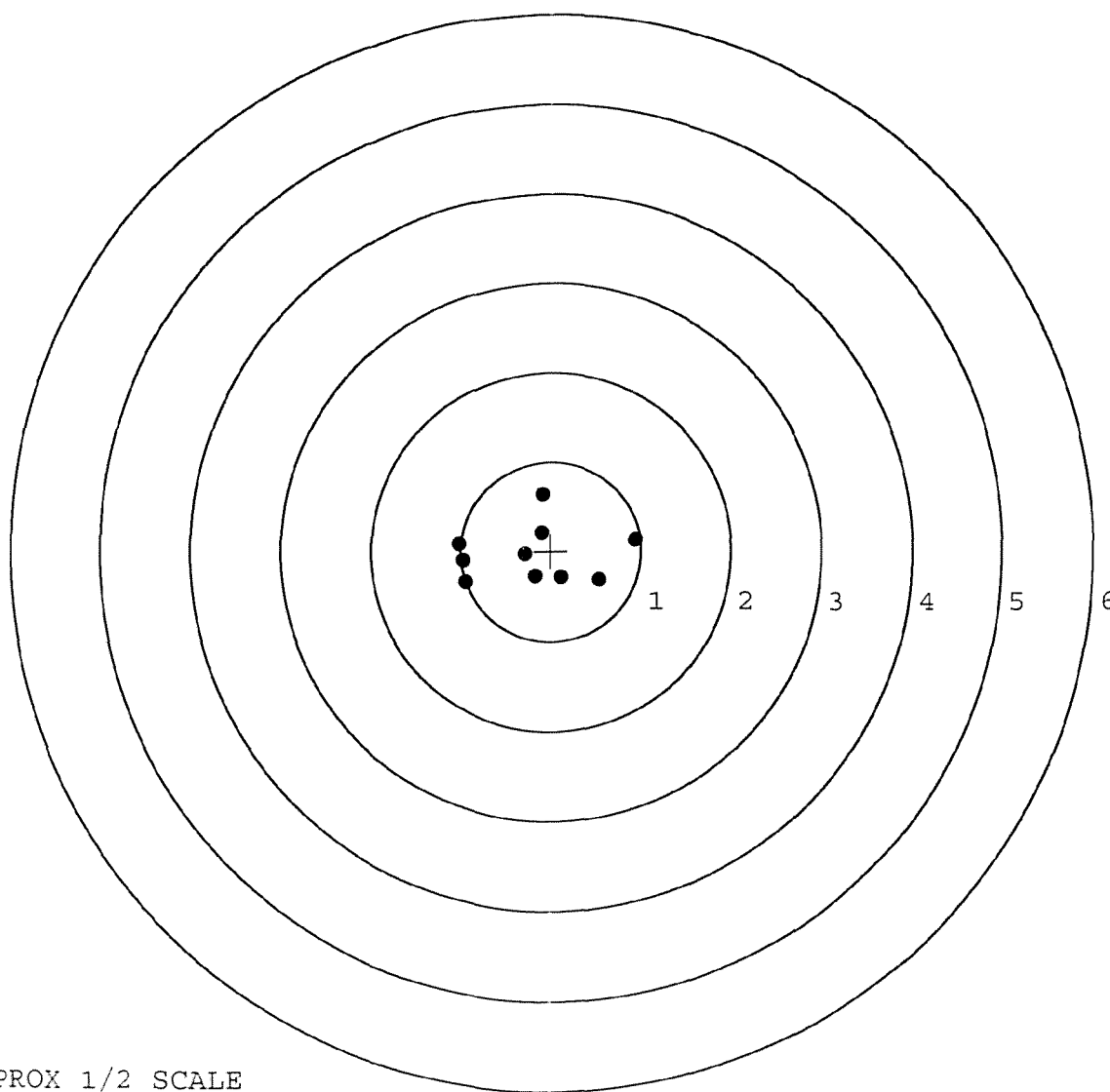
MAX RADIUS: 1.148

MEAN RADIUS: 0.603

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

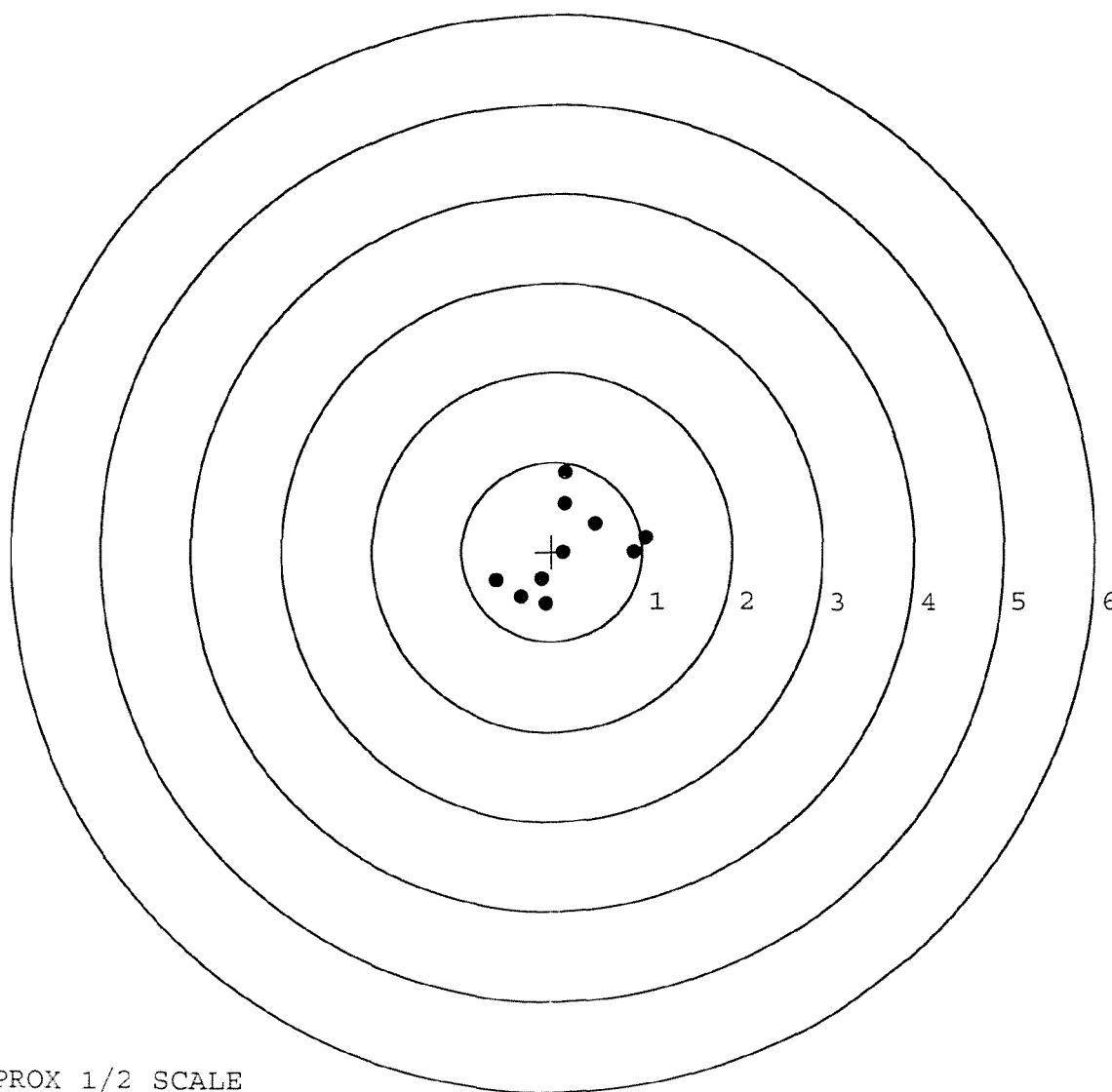


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521409. __0
TARGET NUMBER: 3
FILE DATE: 02/02/2006
FILE TIME: 15:36

POINT#	X	Y
1:	-0.068	-0.586
2:	-0.343	-0.506
3:	-0.116	-0.304
4:	-0.614	-0.318
5:	0.129	-0.013
6:	0.476	0.319
7:	0.146	0.537
8:	0.152	0.885
9:	1.036	0.165
10:	0.907	-0.004

X CENTROID: 0.171
Y CENTROID: 0.017
POA TO CENTROID: 0.171
HORZ SPREAD: 1.650
VERT SPREAD: 1.471
GROUP SPREAD: 1.719
MIN RADIUS: 0.052
MAX RADIUS: 0.878
MEAN RADIUS: 0.615
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

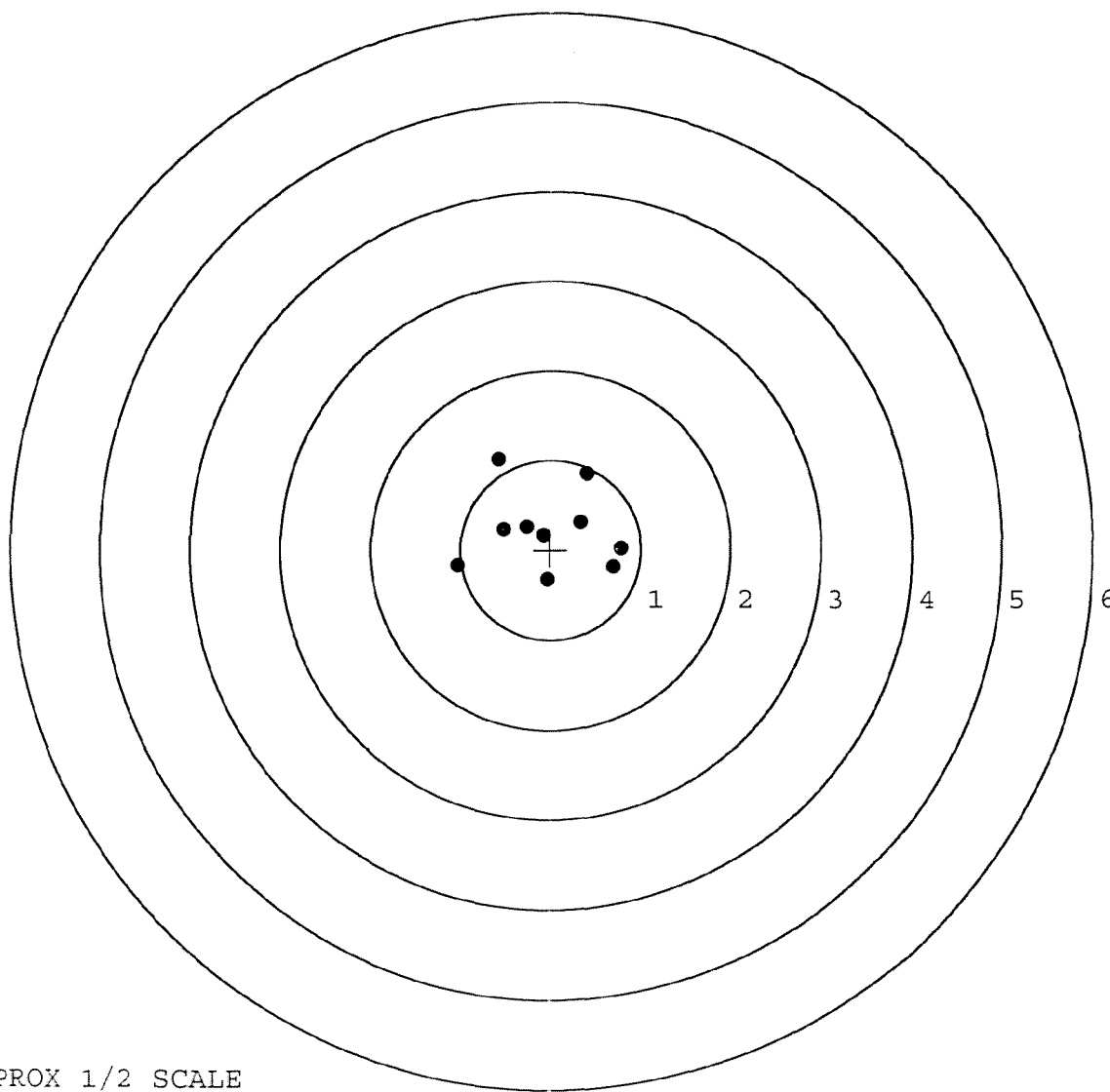


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521409. __0
TARGET NUMBER: 4
FILE DATE: 02/02/2006
FILE TIME: 15:36

POINT#	X	Y
1:	-1.028	-0.179
2:	-0.039	-0.337
3:	0.698	-0.194
4:	0.782	0.017
5:	0.330	0.309
6:	0.403	0.850
7:	-0.574	1.011
8:	-0.522	0.230
9:	-0.271	0.255
10:	-0.078	0.165

X CENTROID: -0.030
Y CENTROID: 0.213
POA TO CENTROID: 0.215
HORZ SPREAD: 1.810
VERT SPREAD: 1.348
GROUP SPREAD: 1.821
MIN RADIUS: 0.068
MAX RADIUS: 1.072
MEAN RADIUS: 0.620
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

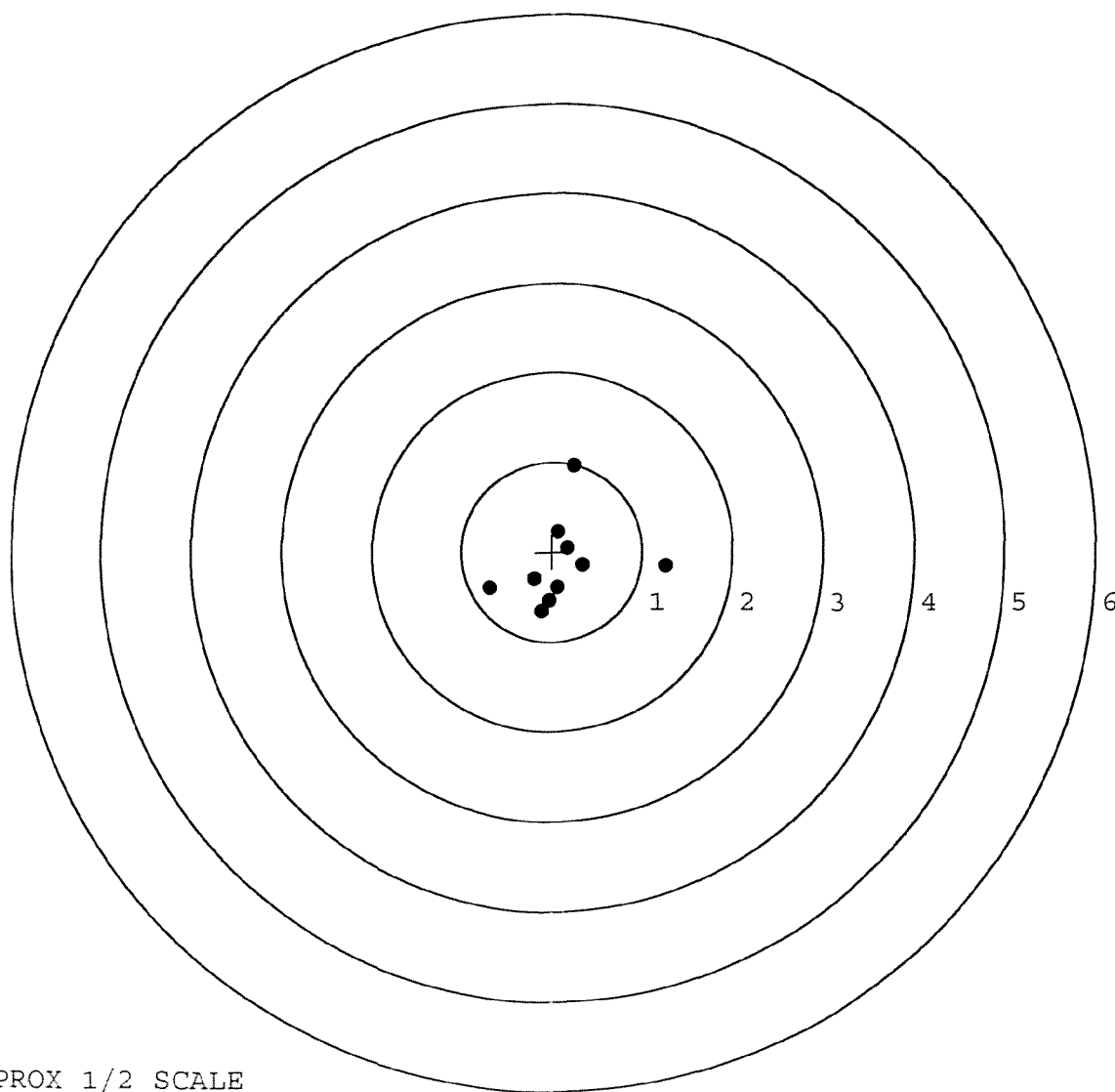


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521409. __0
TARGET NUMBER: 5
FILE DATE: 02/02/2006
FILE TIME: 15:36

POINT#	X	Y
1:	1.259	-0.159
2:	0.253	0.958
3:	0.072	0.226
4:	0.175	0.042
5:	0.346	-0.152
6:	-0.197	-0.294
7:	0.065	-0.395
8:	-0.116	-0.666
9:	-0.027	-0.541
10:	-0.689	-0.395

X CENTROID: 0.114
Y CENTROID: -0.138
POA TO CENTROID: 0.179
HORZ SPREAD: 1.948
VERT SPREAD: 1.624
GROUP SPREAD: 1.962
MIN RADIUS: 0.190
MAX RADIUS: 1.145
MEAN RADIUS: 0.549
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE