

G 452 1412

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

- INSTRUCTION BOOK 3518

DD FORM



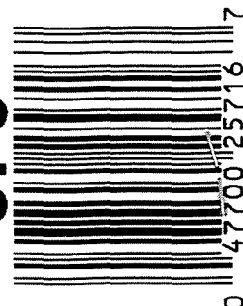
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521412

UPC



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

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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521412

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-16-06	RTZ
440	PROOF		1/17/06	MMJ
460	CHECK HEADSPACE	MAGNA - FLUX	1/17/06	MMJ
470	DIS-ASSEMBLE ACTION	INSPECTED	1/17/06	MMJ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 480 JAN 20 2006 OPERATOR <u>CRD</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		1-30-06	BC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-30-06	BC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-30-06	BC
	D) OIL FIRING PIN ASSEMBLY		2-3-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/10/06	MMJ

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9.0</u> <u>9.0</u> <u>8.5</u>	2-8-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.0</u>	2-8-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		3/10/06	MPD
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3/10/06	MPD
	J) ASSEMBLE STOCK		2-3-06	RSL
	K) ASSEMBLE SWIVEL STUDS		3/10/06	MPD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3/10/06	MPD
	M) IRON SIGHT ALIGNMENT		3/10/06	MPD
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3/10/06	MPD
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	2/13/06	MPD
	MALFUNCTION FPO	CORRECTION OK	2-8-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-3-06	MDW
670	FINAL INSPECTION A) HEADSPACE		3/10/06	MPD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.22</u> <u>2.23</u> <u>2.26</u> <u>2.26</u> <u>2.11</u>	2-8-06	TRW
	C) FUNCTION		3/10/06	MPD
690	PACK		3-22-06	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 2-2-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.60	2.39		2.53	
PULL #2	2.57	2.61		2.54	
PULL #3	2.49	2.46		2.25	
PULL #4	2.57	2.51		2.56	
PULL #5	2.63	2.48		2.54	
TOTAL	12.86	12.45		12.42	
AVERAGE	2.57	2.49		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.11		
PULL #2	3.11	3.16		
PULL #3	3.10	3.23		
PULL #4	3.17	3.17		
PULL #5	3.19	3.23		
TOTAL	15.72	15.90		
AVERAGE	3.14	3.18		

	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	4.26	4.01		3.99
PULL #2	4.25	3.95		4.04
PULL #3	4.18	4.11		4.01
PULL #4	4.30	4.04		3.99
PULL #5	3.85	3.95		4.06
TOTAL	20.84	20.06		20.09
AVERAGE	4.16	4.01		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521412.___0
FILE DATE AND TIME: 02/03/2006 15:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.069
The Average Y Centroid of the Five Target Set:	0.077
The Average Point of Impact of the Five Target Set:	0.103
The Average Mean Radius of the Five Target Set:	0.527
The Distance from POA to Centroid Target #1:	0.251
The Distance from Centroid Target #2 to Centroid Target #1:	0.292
The Distance from Centroid Target #3 to Centroid Target #1:	0.253
The Distance from Centroid Target #4 to Centroid Target #1:	0.168
The Distance from Centroid Target #5 to Centroid Target #1:	0.347

SERIAL NUMBER: G6521412. __ 0

TARGET NUMBER: 1

FILE DATE: 02/03/2006

FILE TIME: 15:23

POINT#	X	Y
1:	0.256	-0.143
2:	0.589	-0.288
3:	0.627	-0.082
4:	0.512	0.130
5:	0.492	0.223
6:	0.337	0.669
7:	0.182	0.534
8:	-0.295	0.427
9:	-0.451	-0.343
10:	0.226	-0.710

X CENTROID: 0.248

Y CENTROID: 0.042

POA TO CENTROID: 0.251

HORZ SPREAD: 1.078

VERT SPREAD: 1.379

GROUP SPREAD: 1.283

MIN RADIUS: 0.185

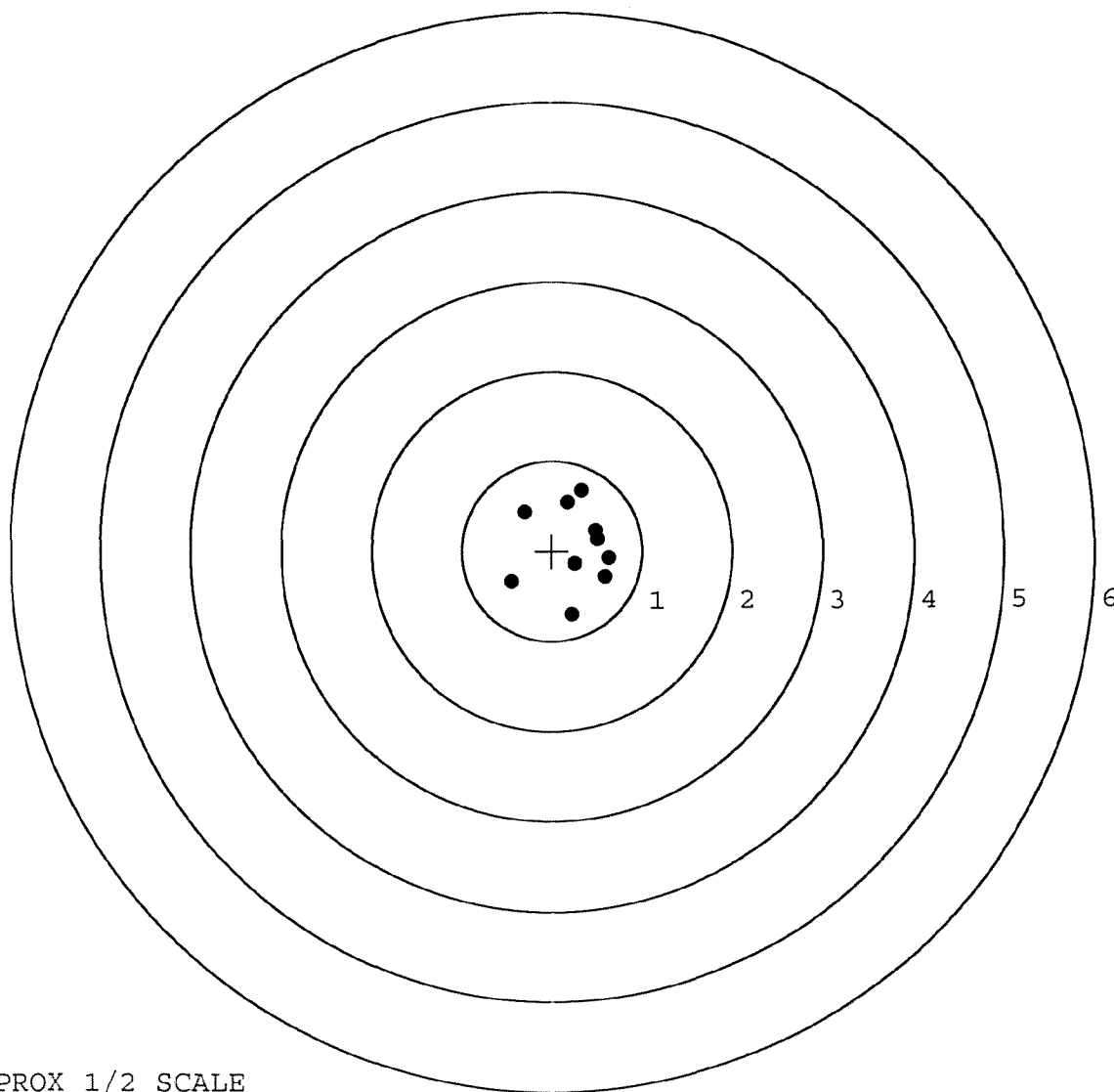
MAX RADIUS: 0.797

MEAN RADIUS: 0.499

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

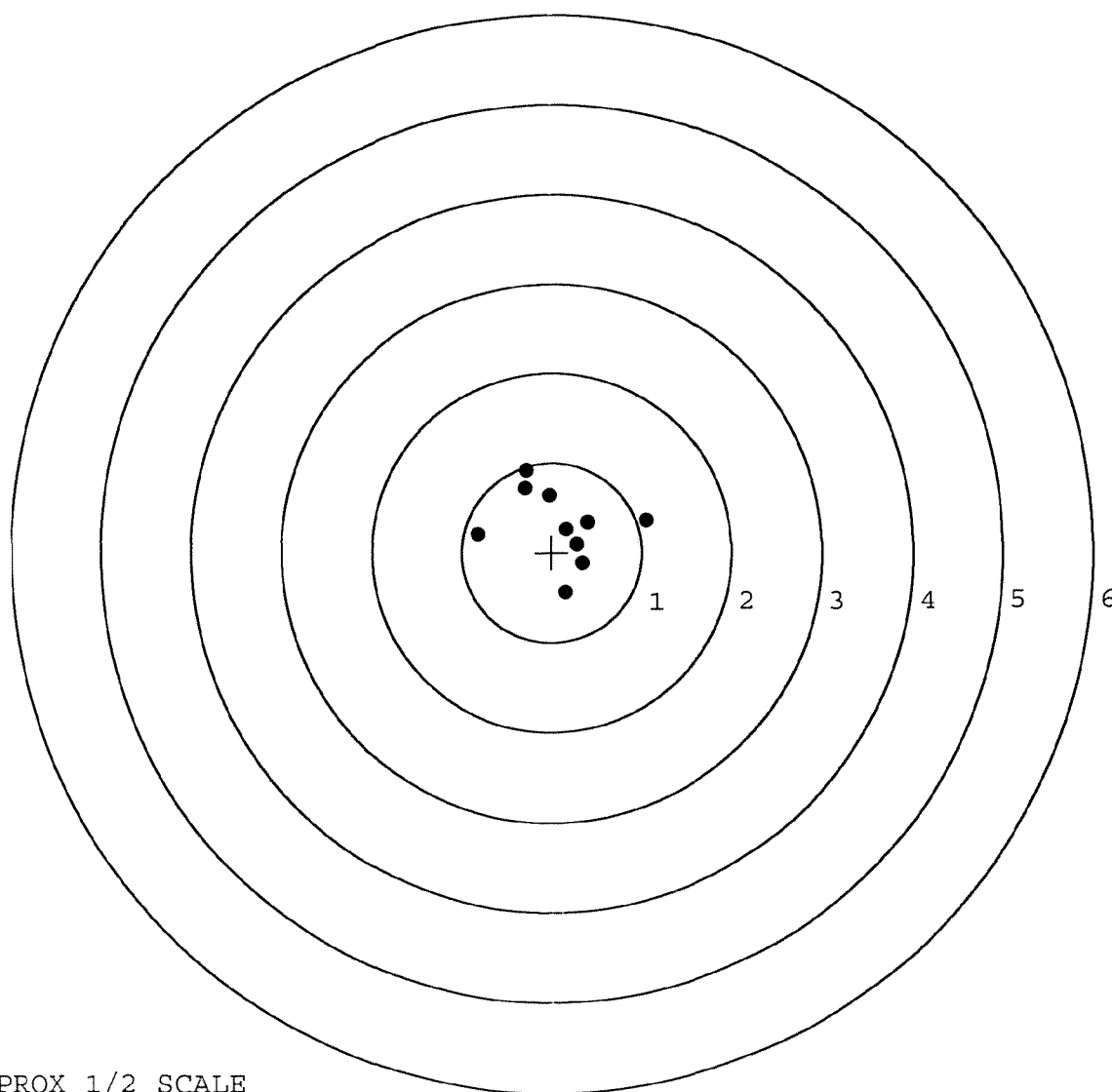


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521412. __0
TARGET NUMBER: 2
FILE DATE: 02/03/2006
FILE TIME: 15:23

POINT#	X	Y
1:	0.157	-0.453
2:	0.343	-0.124
3:	0.284	0.093
4:	0.170	0.256
5:	0.409	0.337
6:	1.058	0.354
7:	-0.015	0.639
8:	-0.293	0.716
9:	-0.284	0.914
10:	-0.816	0.208

X CENTROID: 0.101
Y CENTROID: 0.294
POA TO CENTROID: 0.311
HORZ SPREAD: 1.874
VERT SPREAD: 1.367
GROUP SPREAD: 1.880
MIN RADIUS: 0.079
MAX RADIUS: 0.959
MEAN RADIUS: 0.544
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

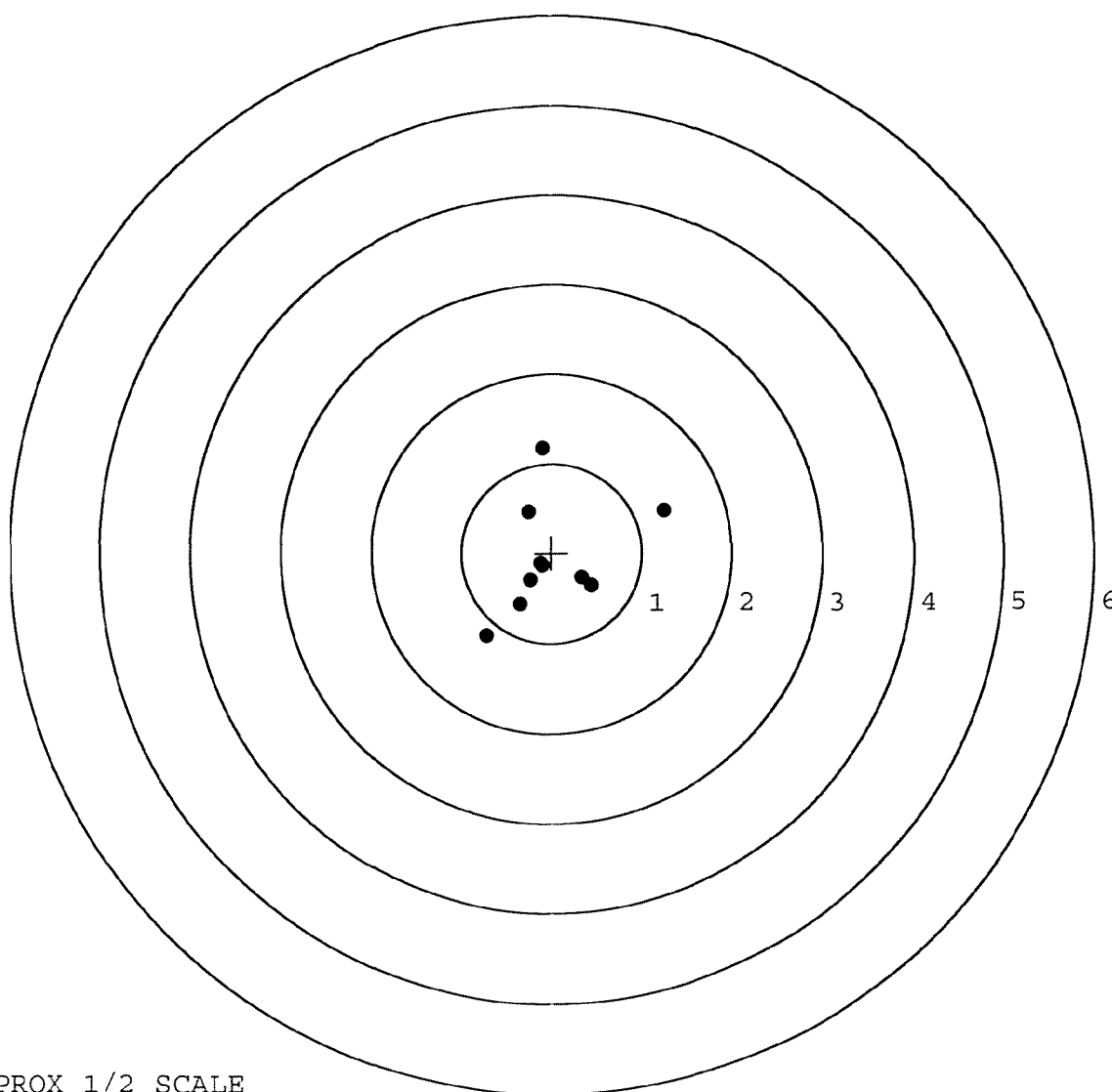


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521412. __0
TARGET NUMBER: 3
FILE DATE: 02/03/2006
FILE TIME: 15:23

POINT#	X	Y
1:	0.334	-0.274
2:	0.445	-0.364
3:	1.251	0.477
4:	-0.095	1.172
5:	-0.249	0.462
6:	-0.105	-0.145
7:	-0.239	-0.301
8:	-0.351	-0.569
9:	-0.123	-0.114
10:	-0.720	-0.917

X CENTROID: 0.015
Y CENTROID: -0.057
POA TO CENTROID: 0.059
HORZ SPREAD: 1.971
VERT SPREAD: 2.089
GROUP SPREAD: 2.414
MIN RADIUS: 0.148
MAX RADIUS: 1.347
MEAN RADIUS: 0.649
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521412.___0

TARGET NUMBER: 4

FILE DATE: 02/03/2006

FILE TIME: 15:23

POINT#	X	Y
1:	0.062	0.828
2:	-0.671	0.271
3:	0.163	0.535
4:	0.199	0.177
5:	0.361	-0.021
6:	0.410	-0.261
7:	0.385	-0.530
8:	0.086	-0.291
9:	-0.178	-0.284
10:	-0.025	0.002

X CENTROID: 0.079

Y CENTROID: 0.043

POA TO CENTROID: 0.090

HORZ SPREAD: 1.081

VERT SPREAD: 1.358

GROUP SPREAD: 1.396

MIN RADIUS: 0.112

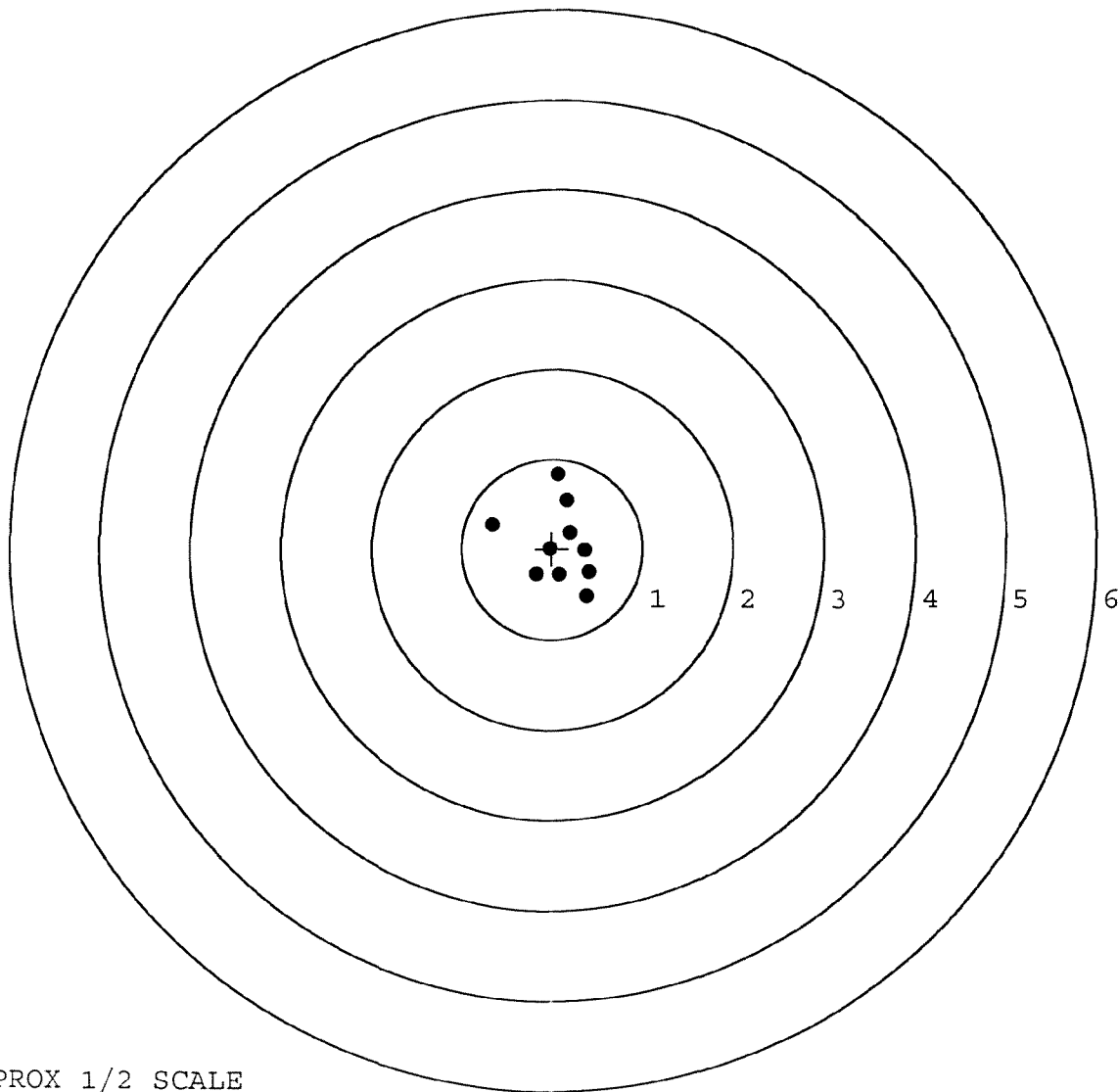
MAX RADIUS: 0.786

MEAN RADIUS: 0.450

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

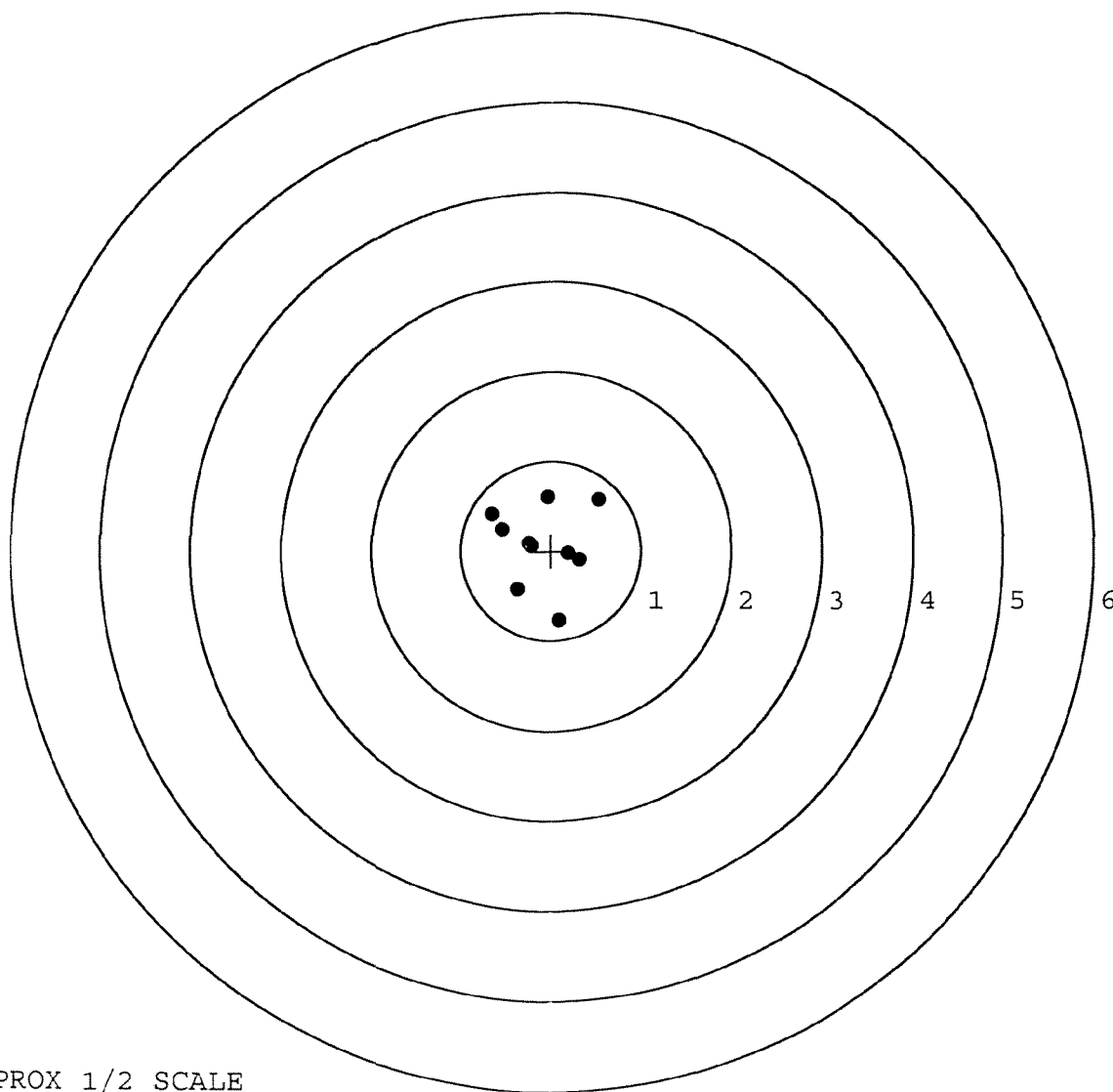


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521412. __0
TARGET NUMBER: 5
FILE DATE: 02/03/2006
FILE TIME: 15:23

X CENTROID: -0.099
Y CENTROID: 0.064
POA TO CENTROID: 0.118
HORZ SPREAD: 1.190
VERT SPREAD: 1.383
GROUP SPREAD: 1.422
MIN RADIUS: 0.126
MAX RADIUS: 0.866
MEAN RADIUS: 0.496
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.524	0.572
2:	-0.041	0.601
3:	-0.666	0.416
4:	-0.548	0.242
5:	-0.247	0.087
6:	-0.380	-0.428
7:	0.088	-0.782
8:	0.191	-0.030
9:	0.317	-0.103
10:	-0.225	0.064



TARGET APPROX 1/2 SCALE