

G 652 1418

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

- INSTRUCTION BOOK 3518

DD FORM



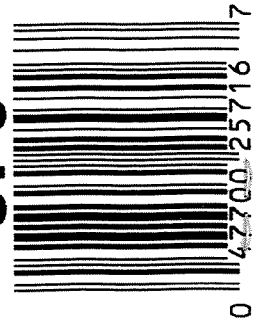
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6521418

UPC



ORDER 25716

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

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ORDER 25716

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66521418

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-16-06	RTL
440	PROOF		1/17/06	mgg
460	CHECK HEADSPACE	MAGNA-FLUX	1/17/06	mgg
470	DIS-ASSEMBLE ACTION	INSPECTED	1/17/06	mgg
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 480 JAN 20 2006 OPERATOR <u>CPD</u>	1/30/06	APD
500	ROLLMARK CALIBER		1-19-06	CW
510	DRILL AND TAP SIGHT HOLES		1-19-06	TRL
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	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		1-30-06	A
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/14/06	mgg

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>4.0</u> <u>4.0</u>	2/3/06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	2/3/06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/14/06	MDA
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.022</u>	3-14-06	DA
	J) ASSEMBLE STOCK		1-31-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		3/14/06	MDA
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-31-06	RTZ
	M) IRON SIGHT ALIGNMENT		1-31-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-31-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-31-06	MDM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2/1/06	MDA
670	FINAL INSPECTION A) HEADSPACE		3/14/06	MDA
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.87</u> <u>2.86</u> <u>2.88</u> <u>2.89</u>	2/3/06	DA
	C) FUNCTION		3/14/06	MDA
690	PACK		3-28-06	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 1-24-06

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	2.64		2.63	
PULL #2	2.47	2.60		2.54	
PULL #3	2.49	2.60		2.63	
PULL #4	2.57	2.54		2.63	
PULL #5	2.59	2.55		2.60	
TOTAL	12.63	12.93		13.03	
AVERAGE	2.52	2.58		2.60	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.05		
PULL #2	3.11	3.31		
PULL #3	3.06	3.02		
PULL #4	3.26	3.26		
PULL #5	2.97	3.04		
TOTAL	15.55	15.68		
AVERAGE	3.11	3.13		

	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	4.18	4.17		4.14
PULL #2	3.91	4.00		4.23
PULL #3	3.94	3.95		4.25
PULL #4	3.96	3.96		4.14
PULL #5	3.94	3.96		4.15
TOTAL	19.93	20.04		20.91
AVERAGE	3.98	4.00		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521418.___0
FILE DATE AND TIME: 02/01/2006 15:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

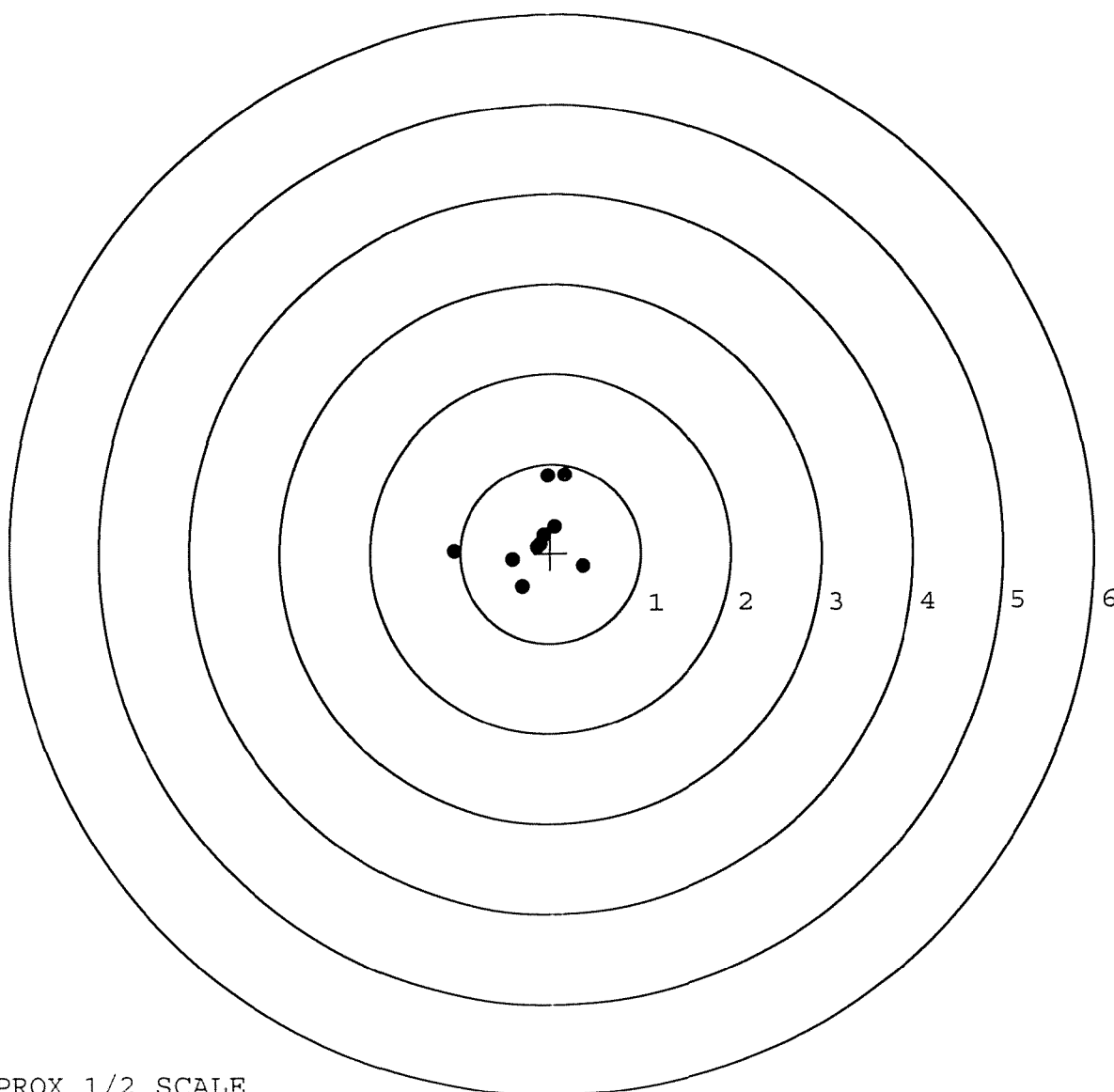
The Average X Centroid of the Five Target Set:	-0.070
The Average Y Centroid of the Five Target Set:	0.107
The Average Point of Impact of the Five Target Set:	0.128
The Average Mean Radius of the Five Target Set:	0.527
The Distance from POA to Centroid Target #1:	0.245
The Distance from Centroid Target #2 to Centroid Target #1:	0.256
The Distance from Centroid Target #3 to Centroid Target #1:	0.199
The Distance from Centroid Target #4 to Centroid Target #1:	0.193
The Distance from Centroid Target #5 to Centroid Target #1:	0.216

SERIAL NUMBER: G6521418. __0
TARGET NUMBER: 1
FILE DATE: 02/01/2006
FILE TIME: 15:42

X CENTROID: -0.161
Y CENTROID: 0.185
POA TO CENTROID: 0.245
HORZ SPREAD: 1.439
VERT SPREAD: 1.251
GROUP SPREAD: 1.503
MIN RADIUS: 0.088
MAX RADIUS: 0.927
MEAN RADIUS: 0.449

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.366	-0.149
2:	-0.317	-0.372
3:	-1.073	0.021
4:	-0.424	-0.069
5:	0.052	0.294
6:	-0.115	0.102
7:	-0.032	0.869
8:	0.161	0.879
9:	-0.150	0.073
10:	-0.075	0.204



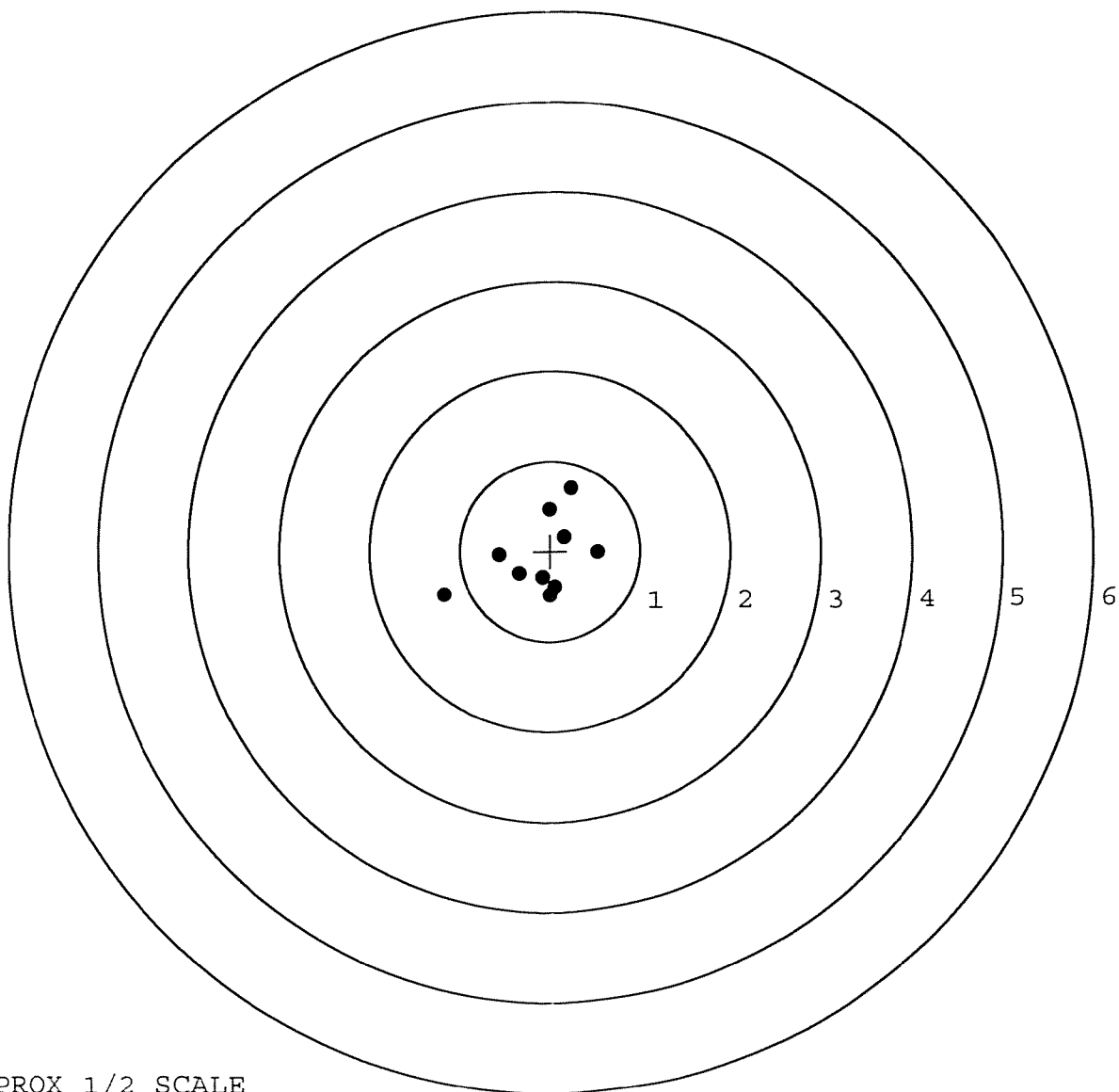
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521418. __0
TARGET NUMBER: 2
FILE DATE: 02/01/2006
FILE TIME: 15:42

X CENTROID: -0.122
Y CENTROID: -0.068
POA TO CENTROID: 0.140
HORZ SPREAD: 1.703
VERT SPREAD: 1.196
GROUP SPREAD: 1.839
MIN RADIUS: 0.231
MAX RADIUS: 1.133
MEAN RADIUS: 0.532

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.527	-0.022
2:	0.157	0.157
3:	-0.008	0.462
4:	0.234	0.697
5:	-0.565	-0.040
6:	-1.176	-0.483
7:	-0.007	-0.499
8:	-0.345	-0.250
9:	-0.090	-0.297
10:	0.051	-0.405



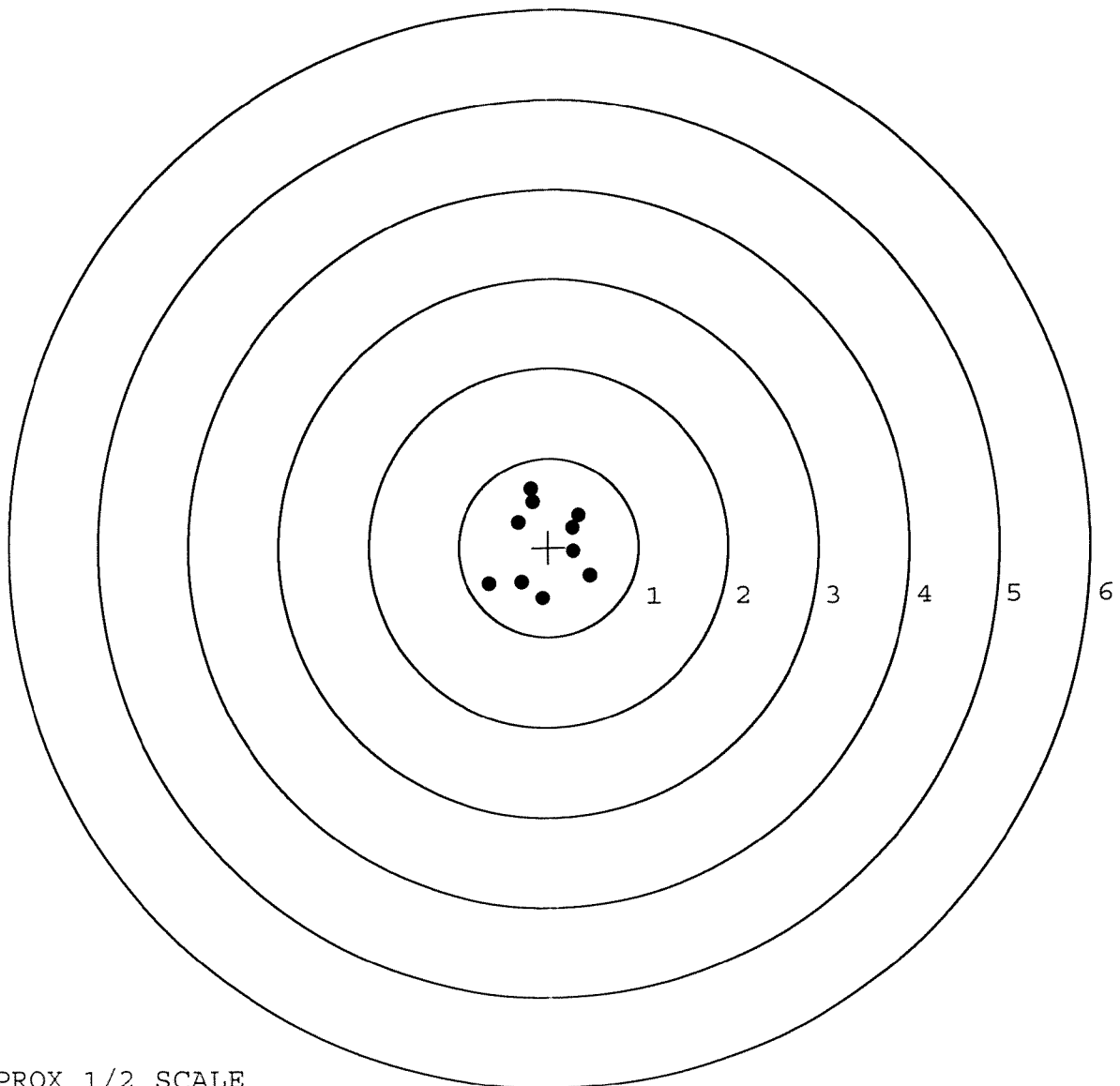
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521418. 0
TARGET NUMBER: 3
FILE DATE: 02/01/2006
FILE TIME: 15:42

X CENTROID: -0.040
Y CENTROID: 0.027
POA TO CENTROID: 0.048
HORZ SPREAD: 1.126
VERT SPREAD: 1.231
GROUP SPREAD: 1.252
MIN RADIUS: 0.330
MAX RADIUS: 0.758
MEAN RADIUS: 0.520

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.199	0.654
2:	-0.174	0.508
3:	-0.339	0.284
4:	-0.663	-0.404
5:	-0.306	-0.388
6:	-0.067	-0.577
7:	0.463	-0.325
8:	0.280	-0.053
9:	0.272	0.219
10:	0.334	0.354



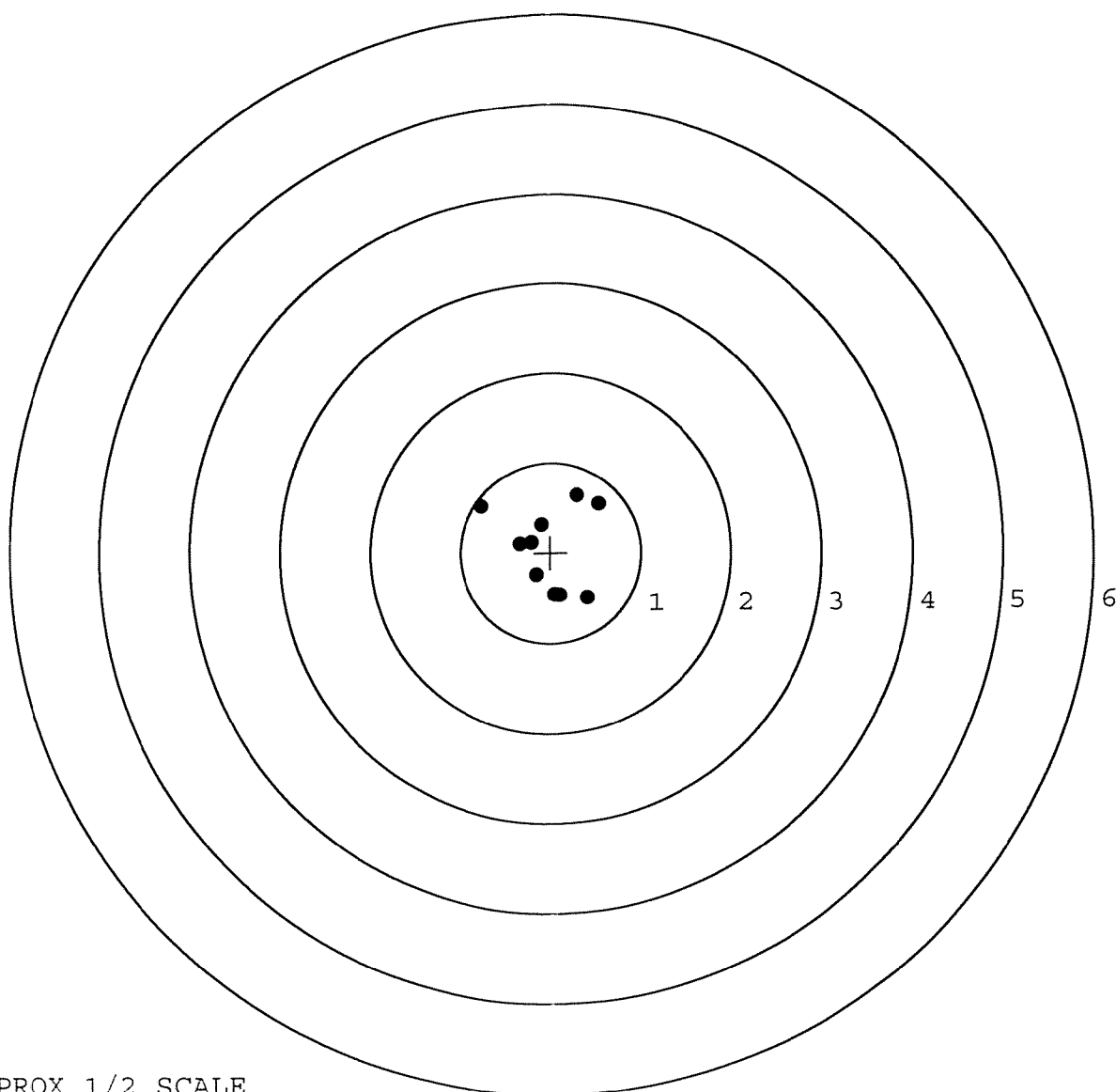
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521418.___0
TARGET NUMBER: 4
FILE DATE: 02/01/2006
FILE TIME: 15:42

X CENTROID: -0.020
Y CENTROID: 0.053
POA TO CENTROID: 0.057
HORZ SPREAD: 1.307
VERT SPREAD: 1.142
GROUP SPREAD: 1.567
MIN RADIUS: 0.208
MAX RADIUS: 0.885
MEAN RADIUS: 0.521

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.538	0.546
2:	0.294	0.636
3:	-0.101	0.311
4:	-0.342	0.104
5:	-0.219	0.114
6:	-0.769	0.526
7:	-0.160	-0.247
8:	0.045	-0.473
9:	0.410	-0.506
10:	0.103	-0.476



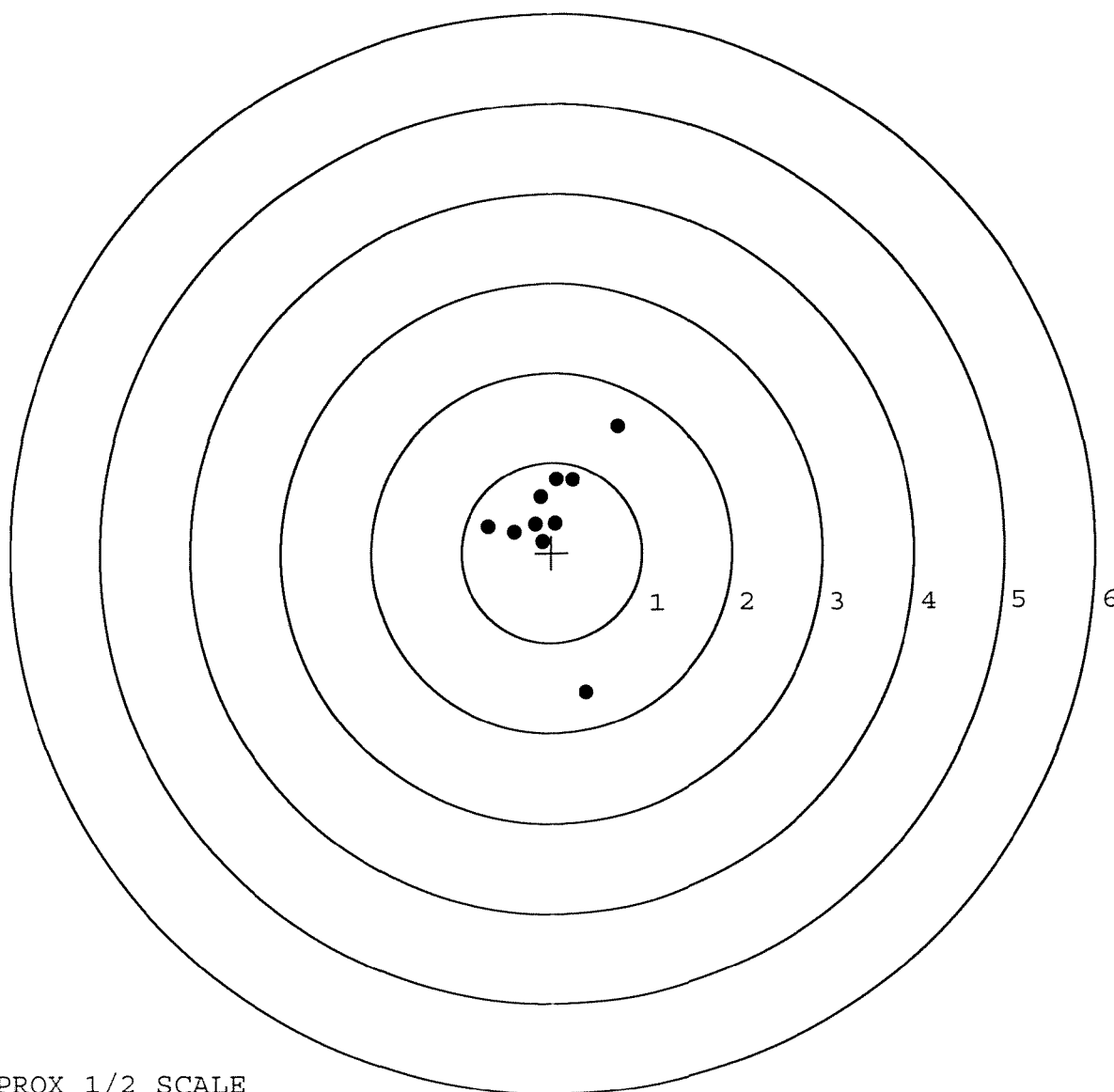
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521418. 0
TARGET NUMBER: 5
FILE DATE: 02/01/2006
FILE TIME: 15:42

X CENTROID: -0.007
Y CENTROID: 0.336
POA TO CENTROID: 0.336
HORZ SPREAD: 1.451
VERT SPREAD: 2.960
GROUP SPREAD: 2.982
MIN RADIUS: 0.050
MAX RADIUS: 1.934
MEAN RADIUS: 0.613

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.746	1.402
2:	0.239	0.801
3:	0.058	0.812
4:	-0.126	0.616
5:	-0.705	0.292
6:	-0.416	0.232
7:	-0.102	0.122
8:	0.042	0.326
9:	-0.185	0.318
10:	0.383	-1.558



TARGET APPROX 1/2 SCALE