

G-652 1429

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

- INSTRUCTION BOOK 3518

DD FORM



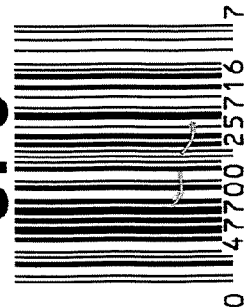
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6521429

UPC



ORDER 25716

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

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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66521429

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-16-06	RTZ
440	PROOF		1/17/06	mgp
460	CHECK HEADSPACE		1/17/06	mgp
470	DIS-ASSEMBLE ACTION	MAGNA-FLUX INSPECTED	1/17/06	mgp
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP 4/80 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	H6
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1/27/06	mgp
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1/27/06	mgp
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1/27/06	mgp
	D) OIL FIRING PIN ASSEMBLY		1-30-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3/7/06	mgp

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>6.0</u>	2/2/06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.0</u> <u>2.0</u>	2/2/06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		3/17/06	MJD
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	3/17/06	MJD
	J) ASSEMBLE STOCK		1-30-06	RTL
	K) ASSEMBLE SWIVEL STUDS		3/17/06	MJD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-30-06	RTL
	M) IRON SIGHT ALIGNMENT		1-30-06	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-30-06	RTL
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	2-1-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		2-1-06	JH
670	FINAL INSPECTION A) HEADSPACE		3/17/06	MJD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.25</u> <u>2.22</u> <u>2.18</u> <u>2.22</u>	2/2/06	DA
	C) FUNCTION		3/17/06	MJD
690	PACK		3-24-06	109A

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 1-27-06

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.47	2.43		2.64	
PULL #2	2.48	2.27		2.71	
PULL #3	2.28	2.22		2.53	
PULL #4	2.50	2.28		2.63	
PULL #5	2.37	2.25		2.59	
TOTAL	12.10	11.45		13.10	
AVERAGE	2.42	2.29		2.62	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.29		
PULL #2	3.07	3.26		
PULL #3	3.08	3.23		
PULL #4	3.29	3.28		
PULL #5	3.22	3.18		
TOTAL				
AVERAGE				

	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	4.19	4.18		4.31
PULL #2	4.32	4.53		4.72
PULL #3	4.26	4.21		4.32
PULL #4	4.11	4.23		4.25
PULL #5	4.65	4.21		4.23
TOTAL	21.53	21.36		21.83
AVERAGE	4.30	4.27		4.36

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521429.__0

FILE DATE AND TIME: 02/01/2006 05:12

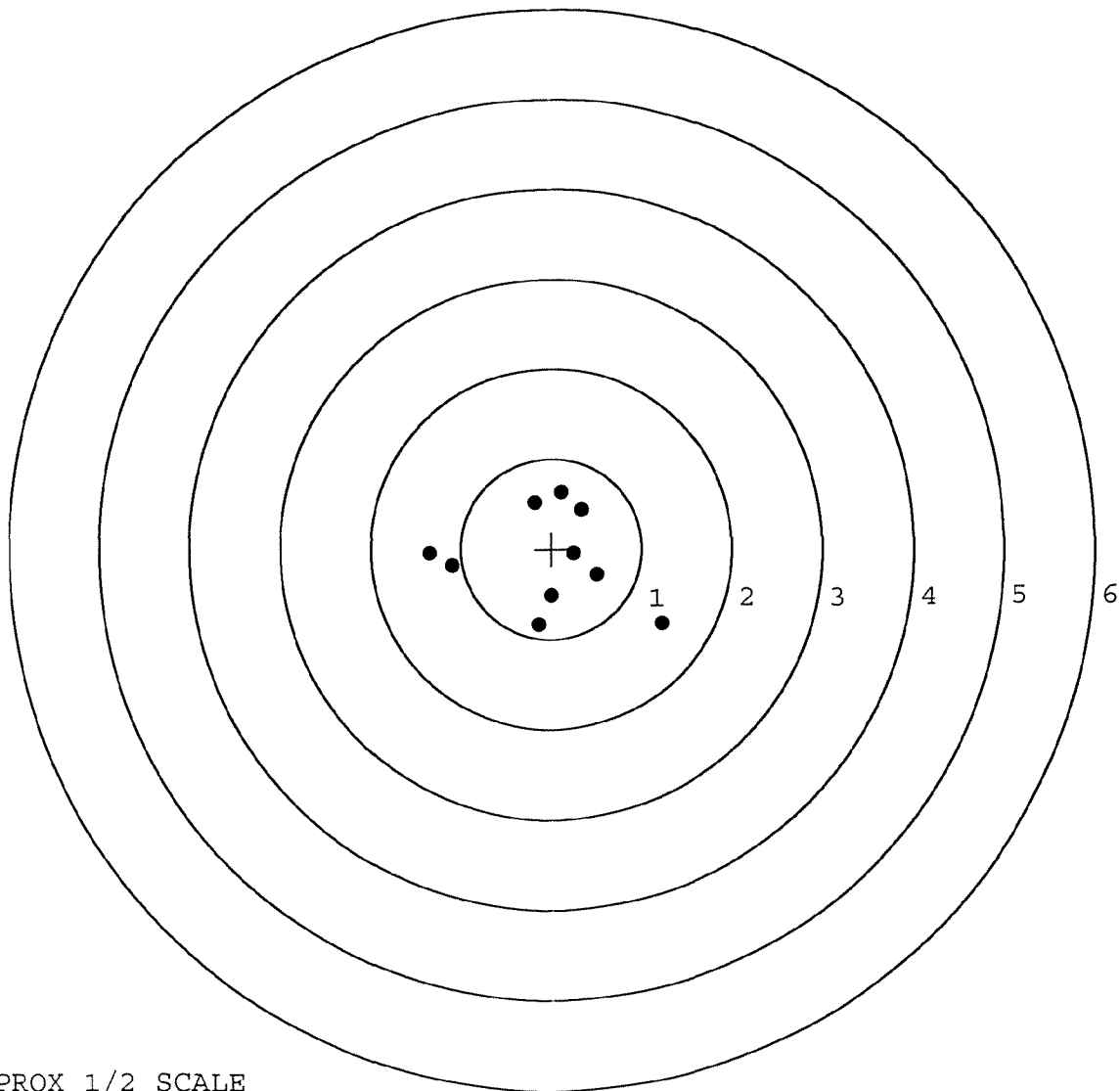
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.004
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.061
The Average Mean Radius of the Five Target Set:	0.686
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.068
The Distance from Centroid Target #3 to Centroid Target #1:	0.192
The Distance from Centroid Target #4 to Centroid Target #1:	0.243
The Distance from Centroid Target #5 to Centroid Target #1:	0.054

SERIAL NUMBER: G6521429. __0
 TARGET NUMBER: 1
 FILE DATE: 02/01/2006
 FILE TIME: 05:12

X CENTROID: -0.032
 Y CENTROID: -0.122
 POA TO CENTROID: 0.126
 HORZ SPREAD: 2.572
 VERT SPREAD: 1.474
 GROUP SPREAD: 2.689
 MIN RADIUS: 0.288
 MAX RADIUS: 1.444
 MEAN RADIUS: 0.790
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.223	-0.836
2:	0.501	-0.299
3:	0.248	-0.054
4:	0.346	0.430
5:	0.120	0.631
6:	-0.176	0.515
7:	0.004	-0.525
8:	-0.142	-0.843
9:	-1.095	-0.190
10:	-1.349	-0.050



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521429. _0

TARGET NUMBER: 2

FILE DATE: 02/01/2006

FILE TIME: 05:12

POINT#	X	Y
1:	0.490	-0.432
2:	0.306	-0.472
3:	0.127	-0.600
4:	0.217	-0.026
5:	-0.050	0.377
6:	-0.501	0.335
7:	-0.347	-0.050
8:	-0.089	0.007
9:	-0.042	-0.305
10:	0.179	-0.356

X CENTROID: 0.029

Y CENTROID: -0.152

POA TO CENTROID: 0.155

HORZ SPREAD: 0.991

VERT SPREAD: 0.977

GROUP SPREAD: 1.253

MIN RADIUS: 0.168

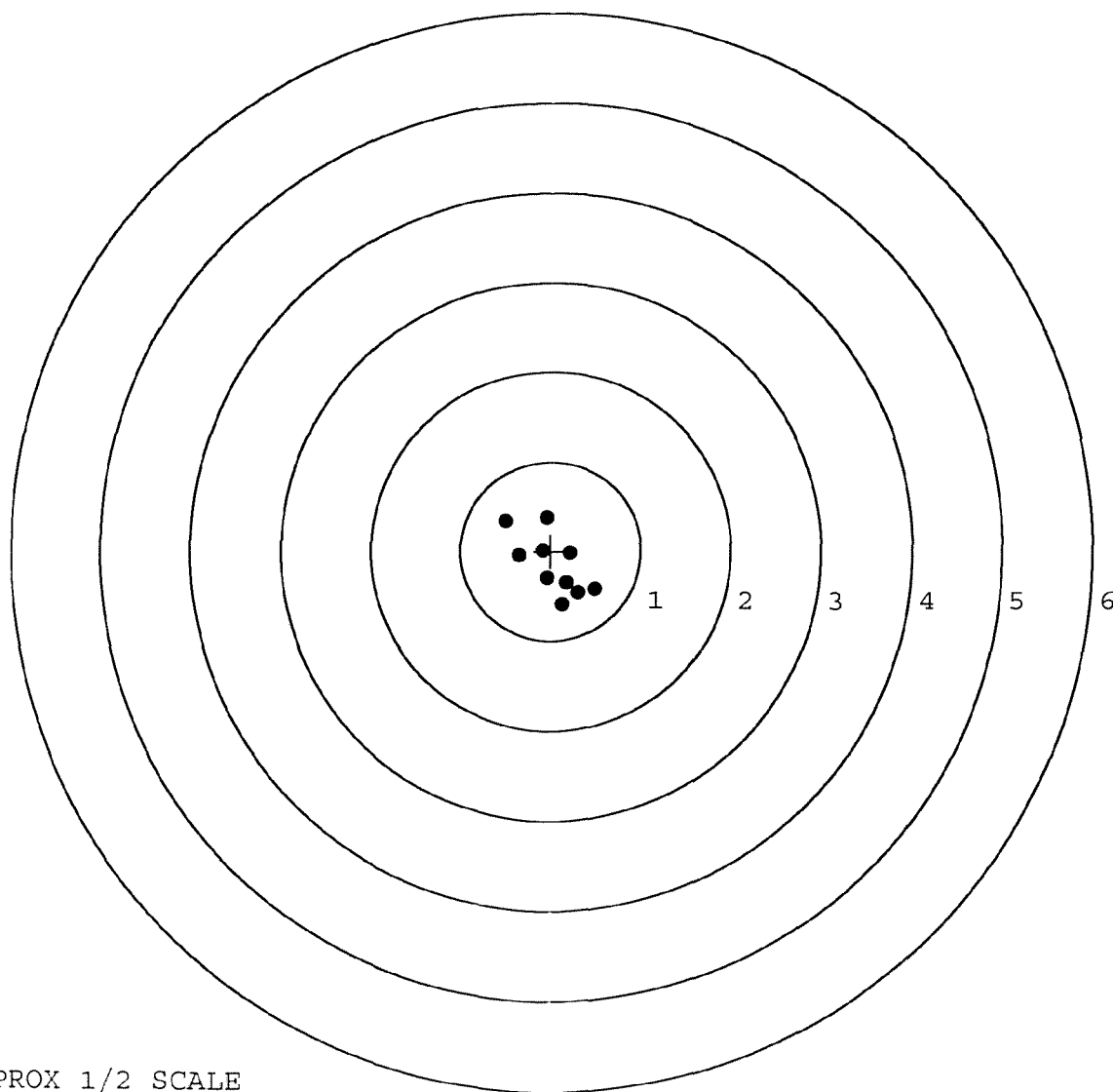
MAX RADIUS: 0.720

MEAN RADIUS: 0.391

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

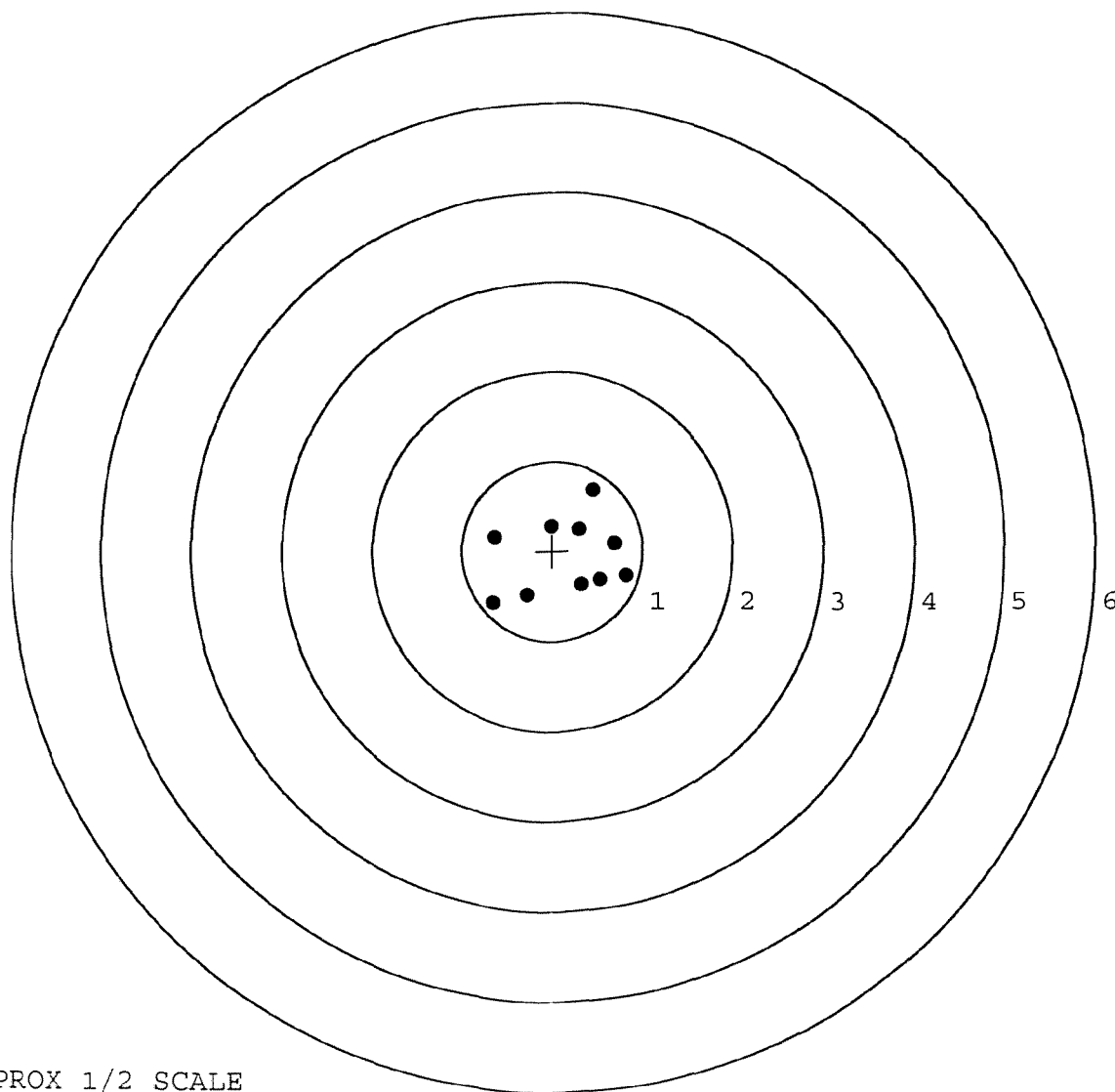


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521429. __0
TARGET NUMBER: 3
FILE DATE: 02/01/2006
FILE TIME: 05:12

POINT#	X	Y
1:	0.451	0.680
2:	0.684	0.084
3:	0.294	0.235
4:	-0.018	0.279
5:	-0.640	0.159
6:	-0.658	-0.575
7:	-0.284	-0.490
8:	0.322	-0.386
9:	0.532	-0.320
10:	0.815	-0.279

X CENTROID: 0.150
Y CENTROID: -0.061
POA TO CENTROID: 0.162
HORZ SPREAD: 1.473
VERT SPREAD: 1.255
GROUP SPREAD: 1.675
MIN RADIUS: 0.330
MAX RADIUS: 0.957
MEAN RADIUS: 0.598
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



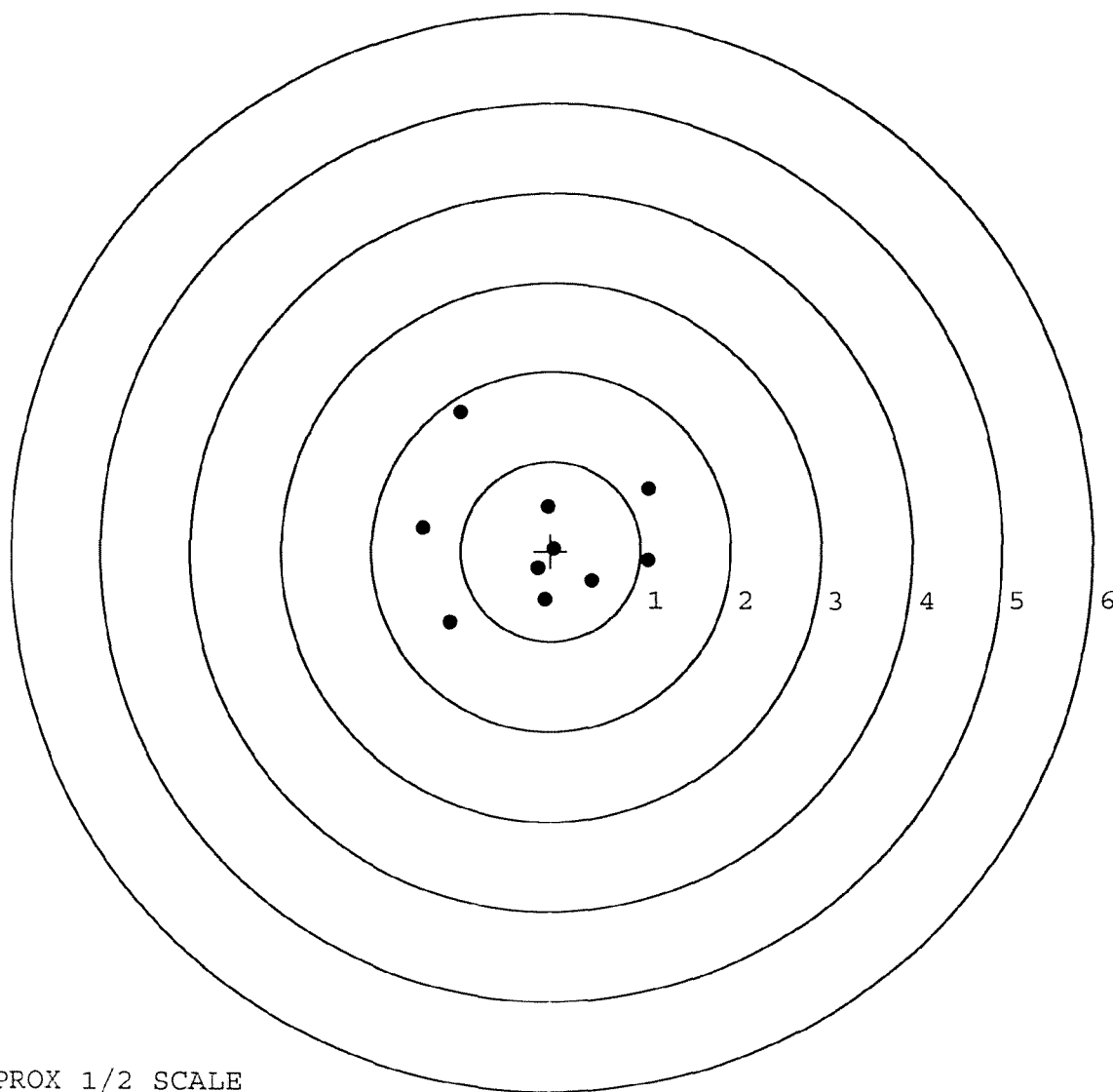
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521429. __0
TARGET NUMBER: 4
FILE DATE: 02/01/2006
FILE TIME: 05:12

POINT#	X	Y
1:	1.083	-0.111
2:	1.085	0.692
3:	-0.036	0.496
4:	-1.122	-0.797
5:	-1.429	0.263
6:	-1.010	1.546
7:	0.039	0.033
8:	-0.145	-0.192
9:	0.457	-0.332
10:	-0.071	-0.540

X CENTROID: -0.115
Y CENTROID: 0.106
POA TO CENTROID: 0.156
HORZ SPREAD: 2.514
VERT SPREAD: 2.343
GROUP SPREAD: 2.670
MIN RADIUS: 0.170
MAX RADIUS: 1.696
MEAN RADIUS: 0.916

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521429. 0

TARGET NUMBER: 5

FILE DATE: 02/01/2006

FILE TIME: 05:12

POINT#	X	Y
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1:	0.818	-0.773
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2:	1.037	0.096
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3:	-0.368	-0.907
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4:	-0.686	-0.715
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5:	0.270	0.201
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6:	-0.033	0.381
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7:	-0.226	0.180
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8:	-0.662	0.060
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9:	-0.720	0.624
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10:	0.465	0.124
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X CENTROID: -0.011

Y CENTROID: -0.073

POA TO CENTROID: 0.074

HORZ SPREAD: 1.757

VERT SPREAD: 1.531

GROUP SPREAD: 2.078

MIN RADIUS: 0.332

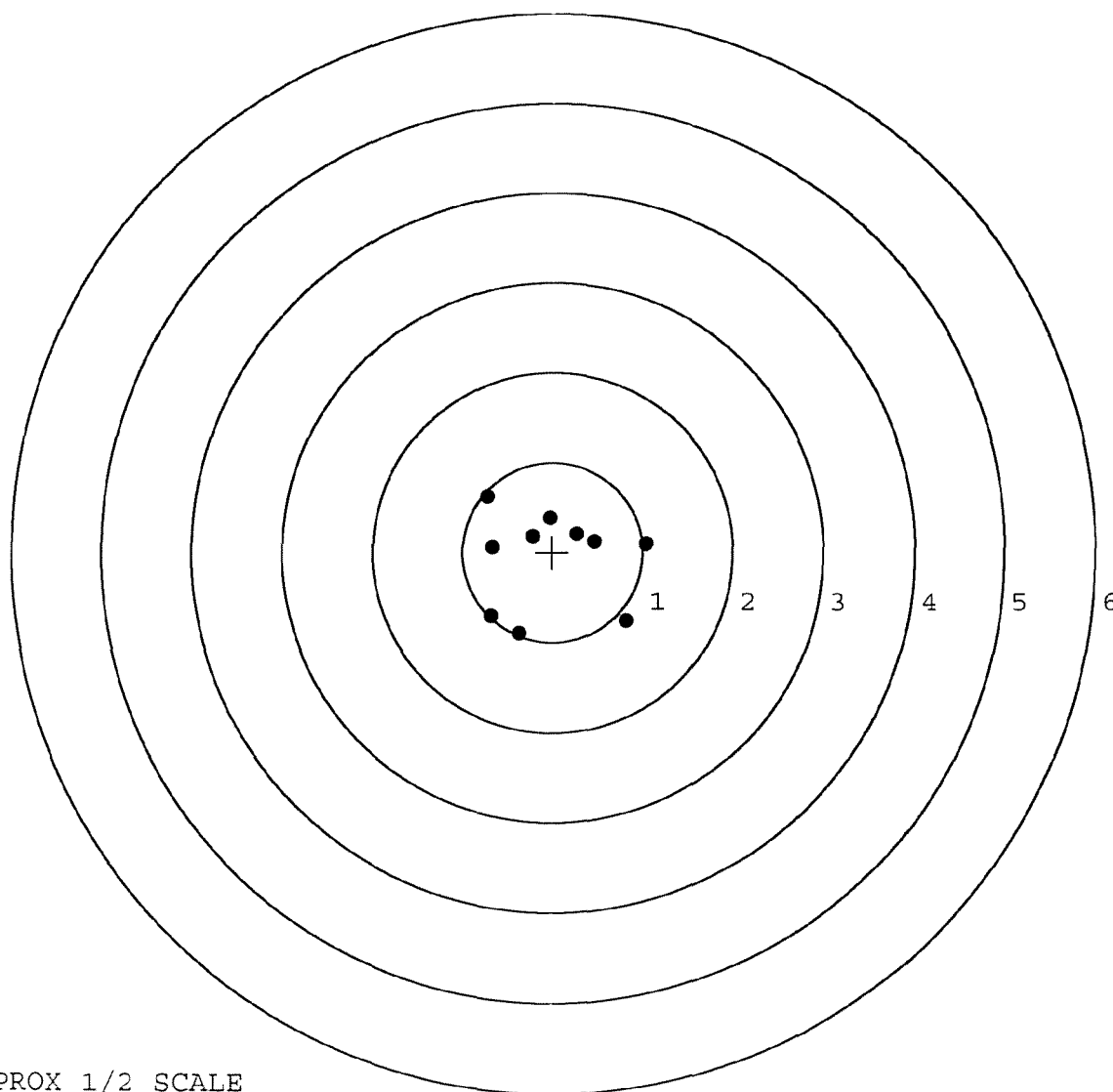
MAX RADIUS: 1.085

MEAN RADIUS: 0.734

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE