

G-652 1453

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

- INSTRUCTION BOOK

DD FORM

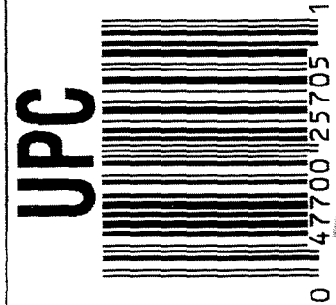


ORDER NO. 25705

BARREL LENGTH 24"

CAPACITY 6

G6521453



ORDER 25705

M/24 7.62 NATO S.W.S. (LESS SCOPE)

UPC



0 47700 25705 1

ORDER 25705

M/24 7.62 NATO S.W.S. (LESS SCOPE)

UPC



0 47700 25705 1

SERIAL NO.



66521453

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C6521453

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		1-11-06	RTZ
440	PROOF		1-11-06	AC
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-11-06	AC
470	DIS-ASSEMBLE ACTION	JAN 13 2006	1-20-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <i>unred</i>	1/13/06	<i>unred</i>
500	ROLLMARK CALIBER		1-30-06	CW
510	DRILL AND TAP SIGHT HOLES		1-12-06	TRW
520	GOFF BLAST BBL / REC		1-16-06	UB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		1/18/06	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		1-19-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-19-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-19-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-19-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5⁰</u> <u>5⁰</u> <u>5⁰</u>	1-20-06	RTZ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2⁰</u> <u>2⁰</u> <u>2⁰</u>	1-20-06	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY		1-20-06	RTZ
	I) FIRING PIN INDENT .020 MIN			
	J) ASSEMBLE STOCK		1-19-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		1-20-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-20-06	RTZ
	M) IRON SIGHT ALIGNMENT		1-20-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-20-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	1-20-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-20-06	KH
670	FINAL INSPECTION A) HEADSPACE		1-20-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.55</u> <u>2.55</u> <u>2.49</u> <u>2.101</u>	1-20-06	RTZ
	C) FUNCTION		1-20-06	RTZ
690	PACK		1-20-06	RTZ

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 1-19-06

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	2.60		2.59 2.59	
PULL #2	2.57	2.55		2.55	
PULL #3	2.58	2.47		2.60	
PULL #4	2.61	2.29		2.56	
PULL #5	2.58	2.41		2.47	
TOTAL	12.94	12.32		12.77	
AVERAGE	2.58	2.46		2.55	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.10		
PULL #2	3.09	3.18		
PULL #3	3.14	3.02		
PULL #4	3.11	2.79		
PULL #5	3.14	3.08		
TOTAL	15.58	15.17		
AVERAGE	3.11	3.03		

	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	4.14	4.09		4.05
PULL #2	4.09	4.05		4.07
PULL #3	4.08	4.09		4.02
PULL #4	4.10	4.09		4.07
PULL #5	4.12	4.17		4.06
TOTAL	20.53	20.49		20.27
AVERAGE	4.10	4.09		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521453.___0
FILE DATE AND TIME: 01/20/2006 11:26

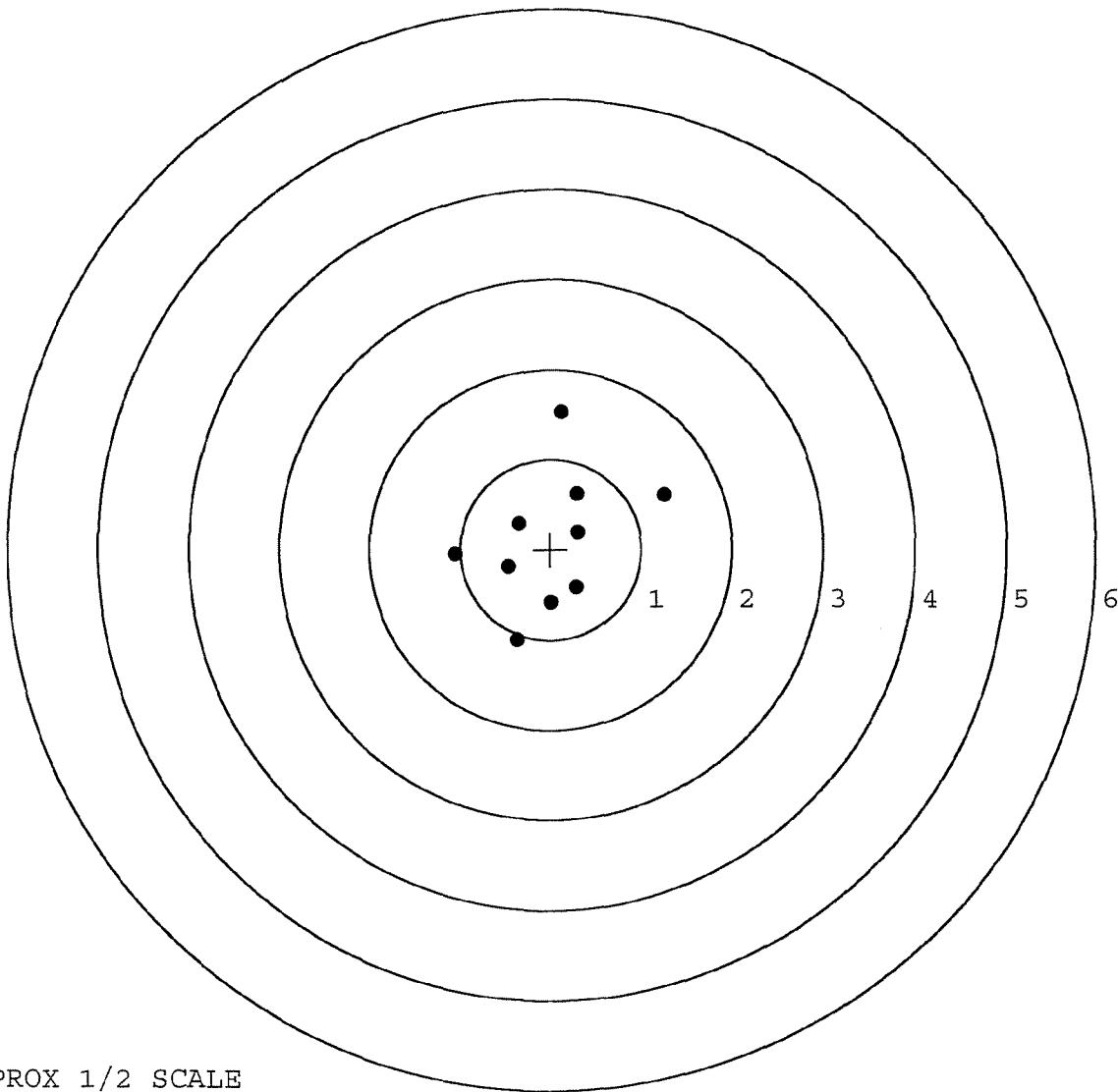
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.061
The Average Y Centroid of the Five Target Set:	0.073
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.791
The Distance from POA to Centroid Target #1:	0.095
The Distance from Centroid Target #2 to Centroid Target #1:	0.100
The Distance from Centroid Target #3 to Centroid Target #1:	0.094
The Distance from Centroid Target #4 to Centroid Target #1:	0.136
The Distance from Centroid Target #5 to Centroid Target #1:	0.231

SERIAL NUMBER: G6521453. __ 0
TARGET NUMBER: 1
FILE DATE: 01/20/2006
FILE TIME: 11:26

X CENTROID: -0.002
Y CENTROID: 0.095
POA TO CENTROID: 0.095
HORZ SPREAD: 2.315
VERT SPREAD: 2.527
GROUP SPREAD: 2.573
MIN RADIUS: 0.311
MAX RADIUS: 1.436
MEAN RADIUS: 0.815
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.255	0.603
2:	0.117	1.526
3:	0.291	0.617
4:	0.294	0.189
5:	0.280	-0.426
6:	-0.005	-0.588
7:	-0.369	-1.001
8:	-0.469	-0.196
9:	-0.354	0.283
10:	-1.060	-0.055



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521453. __0

TARGET NUMBER: 2

FILE DATE: 01/20/2006

FILE TIME: 11:26

POINT#	X	Y
1:	1.592	0.270
2:	1.050	0.701
3:	0.289	1.367
4:	-0.332	0.859
5:	-0.263	0.479
6:	-0.268	0.331
7:	0.210	-0.160
8:	0.252	-1.346
9:	-0.271	-0.911
10:	-1.363	-0.234

X CENTROID: 0.090

Y CENTROID: 0.136

POA TO CENTROID: 0.163

HORZ SPREAD: 2.955

VERT SPREAD: 2.713

GROUP SPREAD: 2.998

MIN RADIUS: 0.319

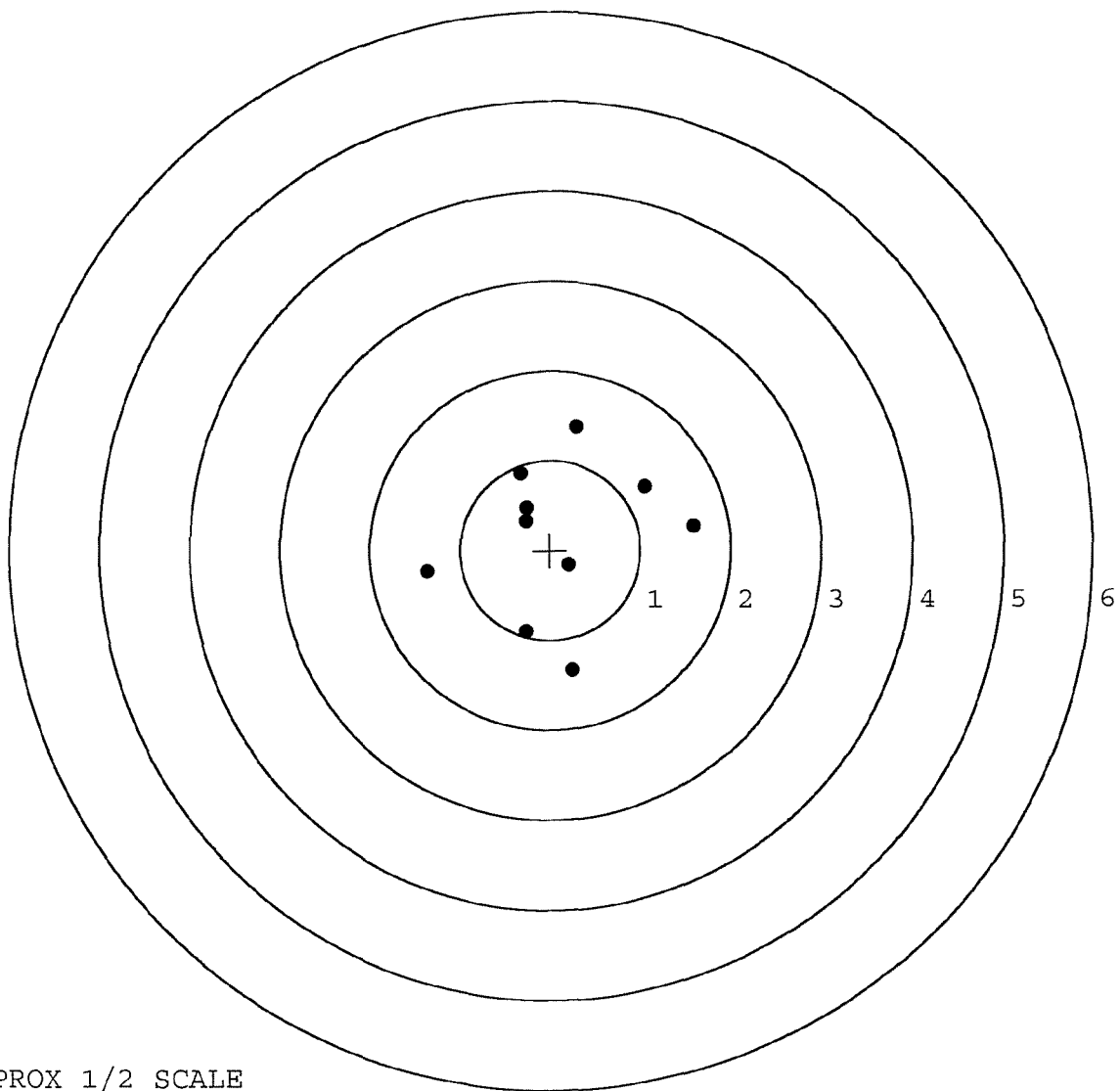
MAX RADIUS: 1.508

MEAN RADIUS: 1.002

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

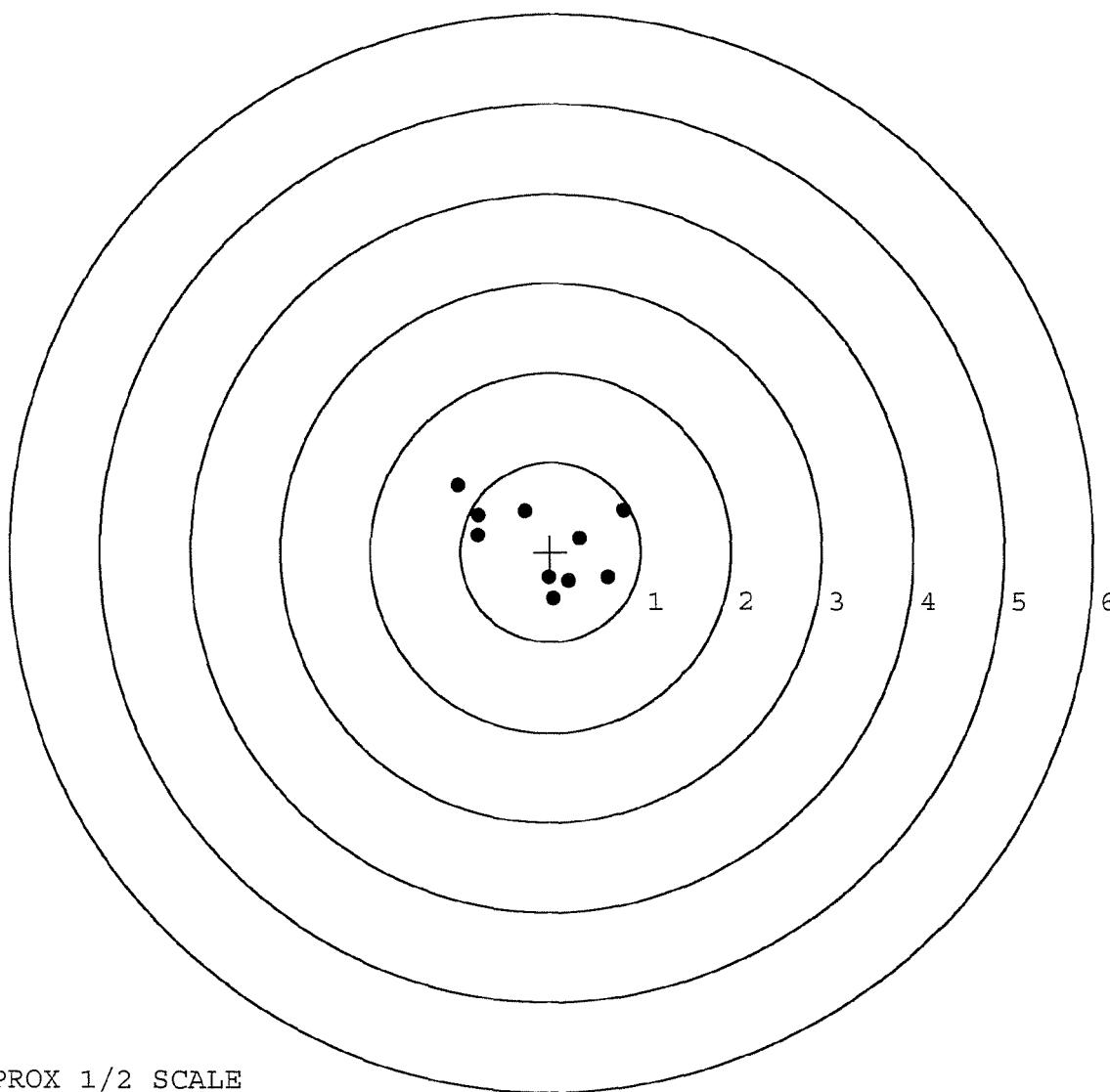


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521453. __0
TARGET NUMBER: 3
FILE DATE: 01/20/2006
FILE TIME: 11:26

POINT#	X	Y
1:	0.637	-0.283
2:	0.813	0.471
3:	0.314	0.157
4:	-0.288	0.455
5:	-1.032	0.743
6:	-0.806	0.407
7:	-0.808	0.187
8:	-0.024	-0.286
9:	0.202	-0.326
10:	0.030	-0.525

X CENTROID: -0.096
Y CENTROID: 0.100
POA TO CENTROID: 0.139
HORZ SPREAD: 1.845
VERT SPREAD: 1.268
GROUP SPREAD: 1.959
MIN RADIUS: 0.393
MAX RADIUS: 1.135
MEAN RADIUS: 0.680
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521453. __0

TARGET NUMBER: 4

FILE DATE: 01/20/2006

FILE TIME: 11:26

POINT#	X	Y
1:	0.616	-0.741
2:	1.233	0.053
3:	-0.728	-0.841
4:	-0.564	1.150
5:	-0.544	0.517
6:	-0.307	0.273
7:	0.529	0.345
8:	0.483	0.132
9:	0.119	-0.306
10:	0.074	-0.628

X CENTROID: 0.091

Y CENTROID: -0.005

POA TO CENTROID: 0.091

HORZ SPREAD: 1.961

VERT SPREAD: 1.991

GROUP SPREAD: 2.229

MIN RADIUS: 0.303

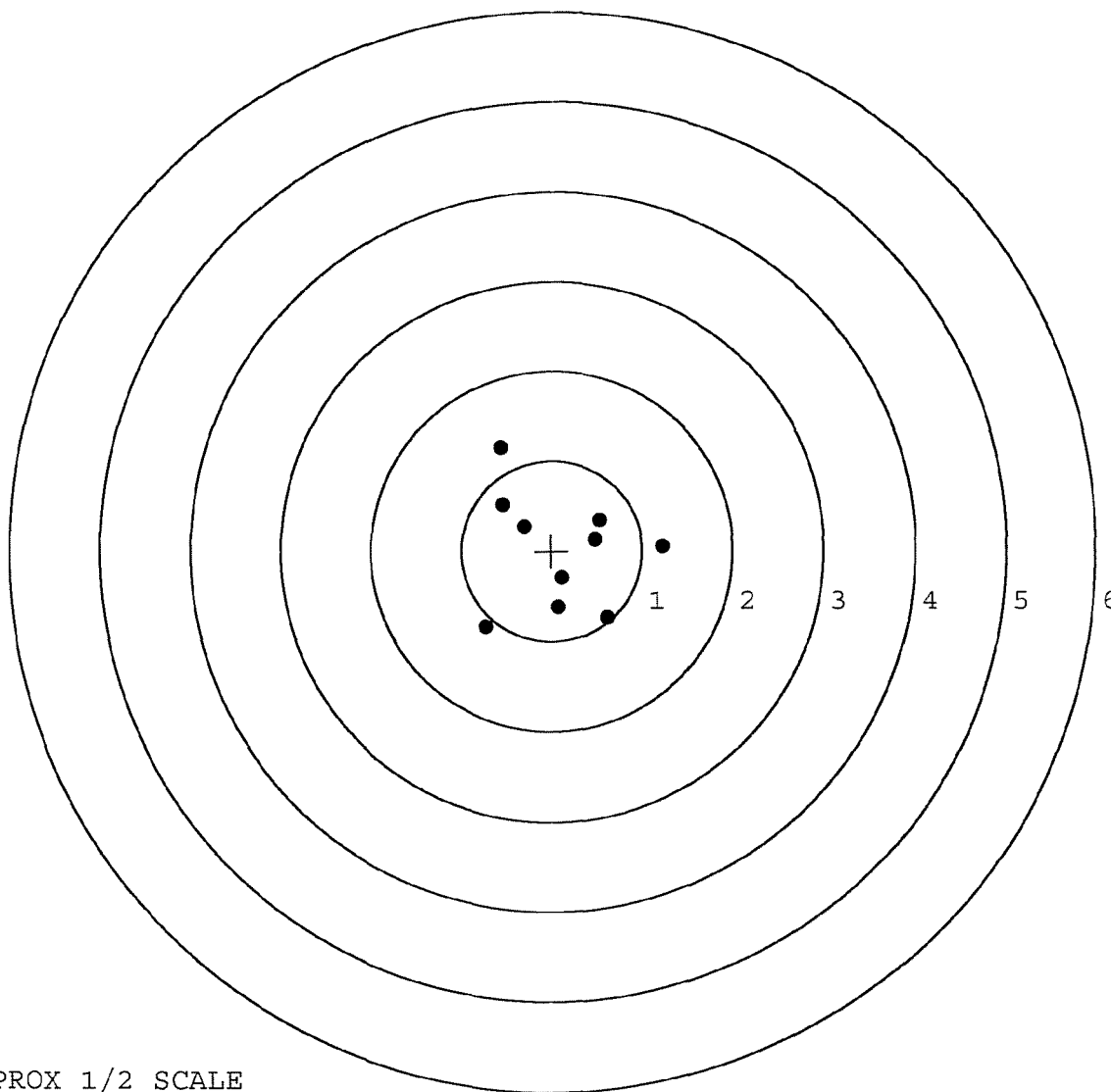
MAX RADIUS: 1.328

MEAN RADIUS: 0.775

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521453. __0

TARGET NUMBER: 5

FILE DATE: 01/20/2006

FILE TIME: 11:26

POINT#	X	Y
1:	1.359	0.544
2:	0.817	-0.191
3:	0.505	-0.147
4:	0.387	-0.502
5:	-0.034	-0.887
6:	0.152	0.213
7:	0.162	0.857
8:	-0.550	0.585
9:	-0.740	-0.235
10:	0.171	0.175

X CENTROID: 0.223

Y CENTROID: 0.041

POA TO CENTROID: 0.227

HORZ SPREAD: 2.099

VERT SPREAD: 1.744

GROUP SPREAD: 2.239

MIN RADIUS: 0.144

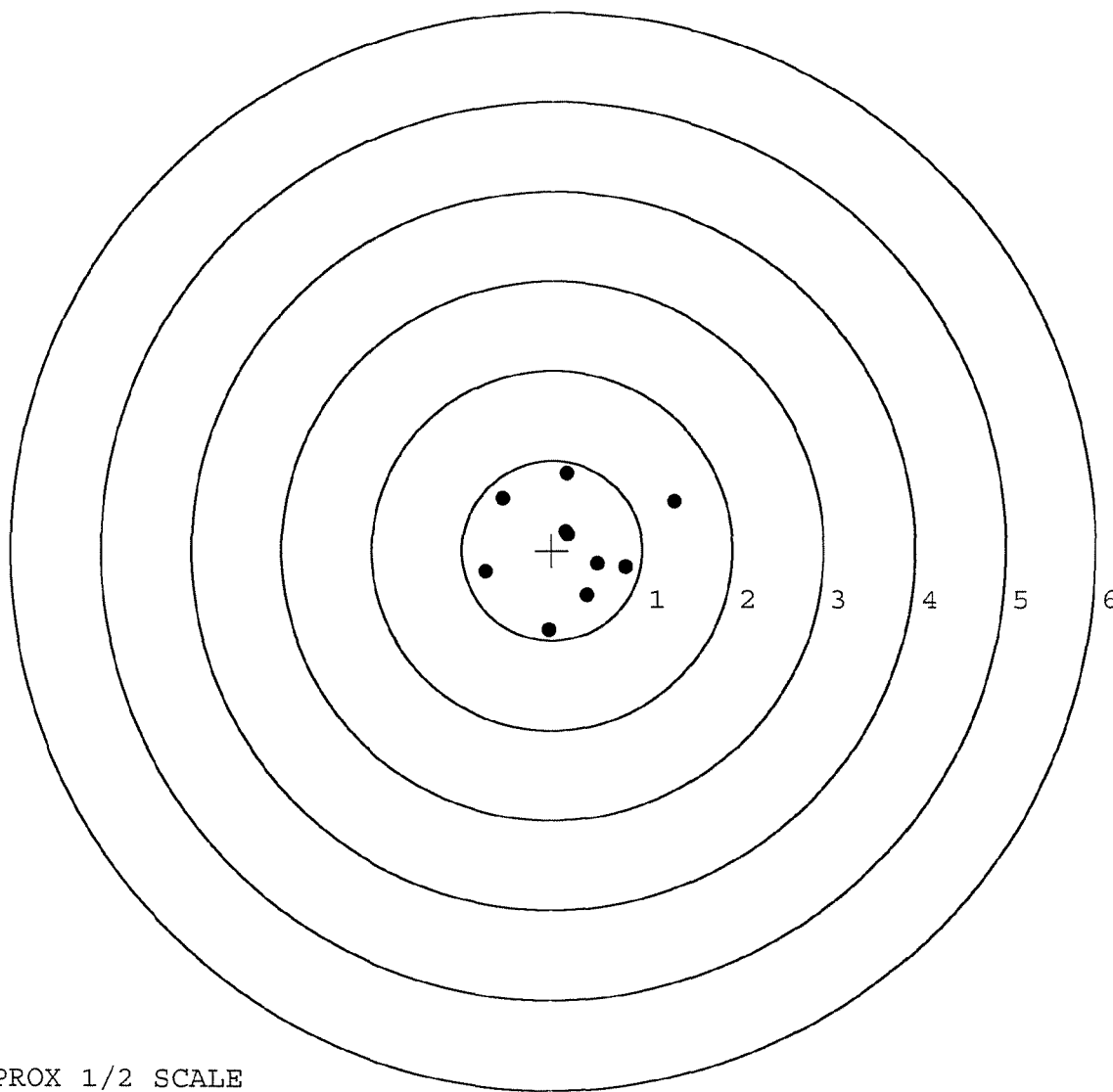
MAX RADIUS: 1.242

MEAN RADIUS: 0.684

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE