

G660 52 72

ORDER 25716

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

UPC



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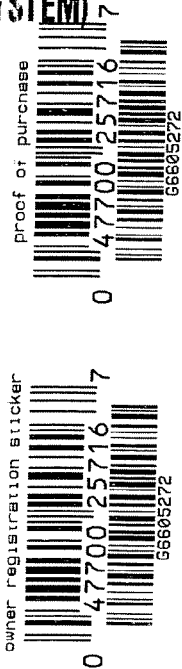
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

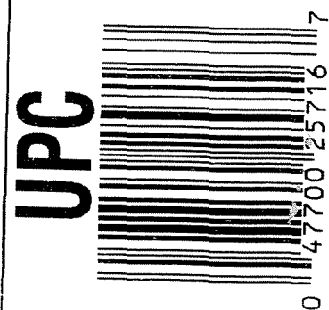


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6605272



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G660 5277

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	RTZ
420	ASSEMBLE ACTION		10-6-06	RTZ
430	ASSEMBLE TO STOCK		10-6-06	TRW
440	PROOF		10-7-06	TRW
460	CHECK HEADSPACE	INSPECTED	10-7-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 10 2006	10-7-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR APD	10-10-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-06	TRW
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-10-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/17/06	TRW
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-17-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-21-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

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OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.0</u> <u>8.0</u> <u>7.0</u>	11-10-06	L.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11-10-06	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.027</u> <u>.0265</u>	11-10-06	L.P.D.
	J) ASSEMBLE STOCK		10-21-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-17-06	BLG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-21-06	RTZ
	M) IRON SIGHT ALIGNMENT		10-21-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-21-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-23-06	TREW
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/23/06	W/R
670	FINAL INSPECTION A) HEADSPACE		11-17-06	BLG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.20</u> <u>2.44</u> <u>2.51</u> <u>2.41</u>	10-24-06	DA
	C) FUNCTION		11-17-06	BLG
690	PACK		11/18/06	DA

F004 REV 5/2006

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 9-13-06

TESTER R.P

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	261	268		246	
PULL #2	255	263		238	
PULL #3	260	254		244	
PULL #4	260	257		233	
PULL #5	262	260		241	
TOTAL	1298	1302		1202	
AVERAGE	259	260		240	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	300	324		
PULL #2	310	317		
PULL #3	307	312		
PULL #4	315	316		
PULL #5	314	314		
TOTAL	1546	1583		
AVERAGE	309	316		

	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	4.15	4.15		4.02
PULL #2	4.18	4.18		4.02
PULL #3	4.22	4.11		4.10
PULL #4	4.16	4.07		4.04
PULL #5	4.18	4.06		4.02
TOTAL	2089	2057		2020
AVERAGE	4.17	4.11		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605272.___0

FILE DATE AND TIME: 10/24/2006 06:37

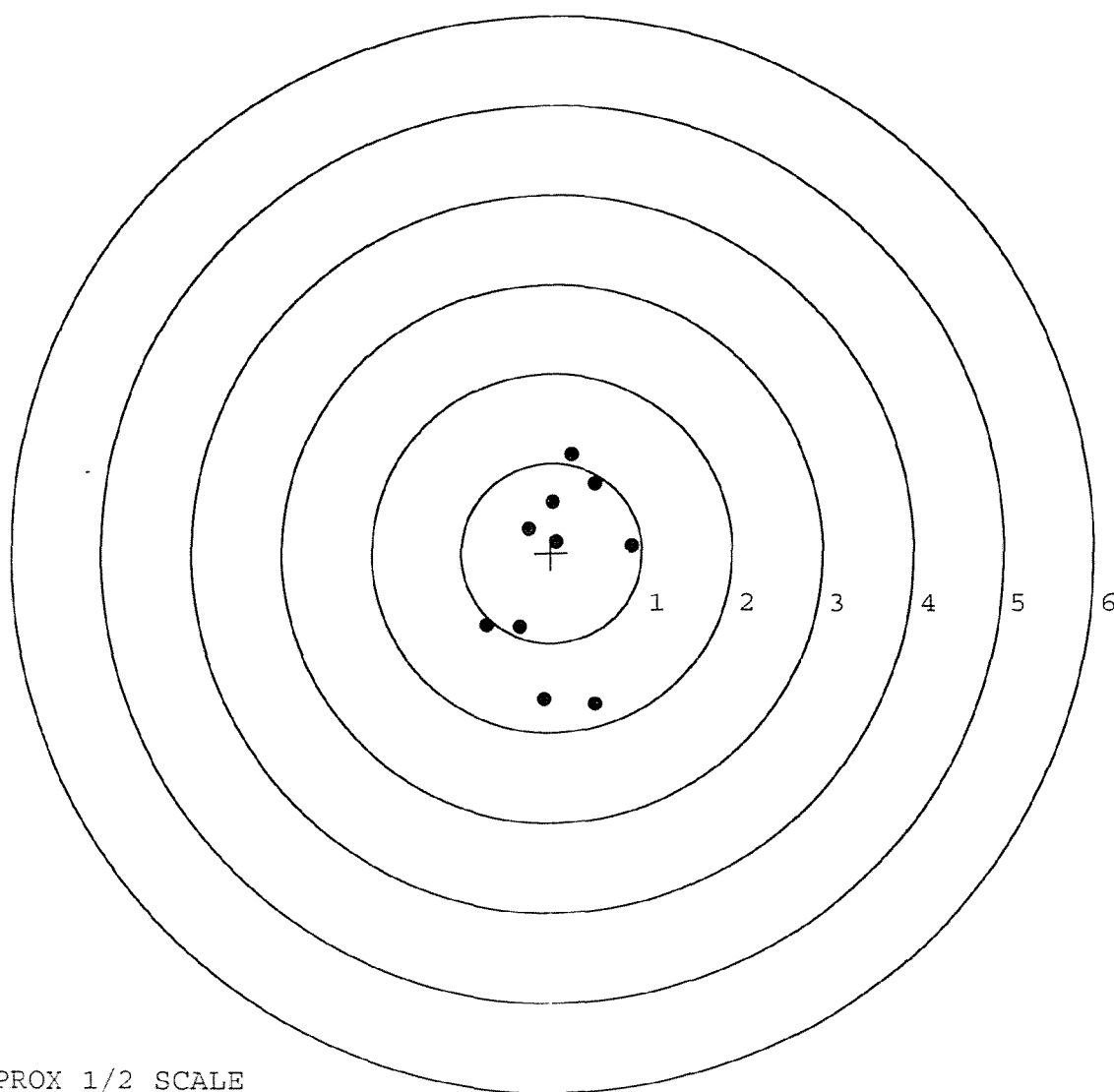
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.073
The Average Y Centroid of the Five Target Set:	-0.017
The Average Point of Impact of the Five Target Set:	0.075
The Average Mean Radius of the Five Target Set:	0.850
The Distance from POA to Centroid Target #1:	0.221
The Distance from Centroid Target #2 to Centroid Target #1:	0.129
The Distance from Centroid Target #3 to Centroid Target #1:	0.119
The Distance from Centroid Target #4 to Centroid Target #1:	0.461
The Distance from Centroid Target #5 to Centroid Target #1:	0.510

SERIAL NUMBER: G6605272. __0
TARGET NUMBER: 1
FILE DATE: 10/24/2006
FILE TIME: 06:37

POINT#	X	Y
1:	0.488	-1.692
2:	-0.076	-1.638
3:	-0.353	-0.826
4:	-0.719	-0.806
5:	0.881	0.077
6:	0.230	1.089
7:	0.483	0.768
8:	0.019	0.565
9:	0.066	0.124
10:	-0.258	0.267

X CENTROID: 0.076
Y CENTROID: -0.207
POA TO CENTROID: 0.221
HORZ SPREAD: 1.600
VERT SPREAD: 2.781
GROUP SPREAD: 2.793
MIN RADIUS: 0.331
MAX RADIUS: 1.541
MEAN RADIUS: 0.963
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

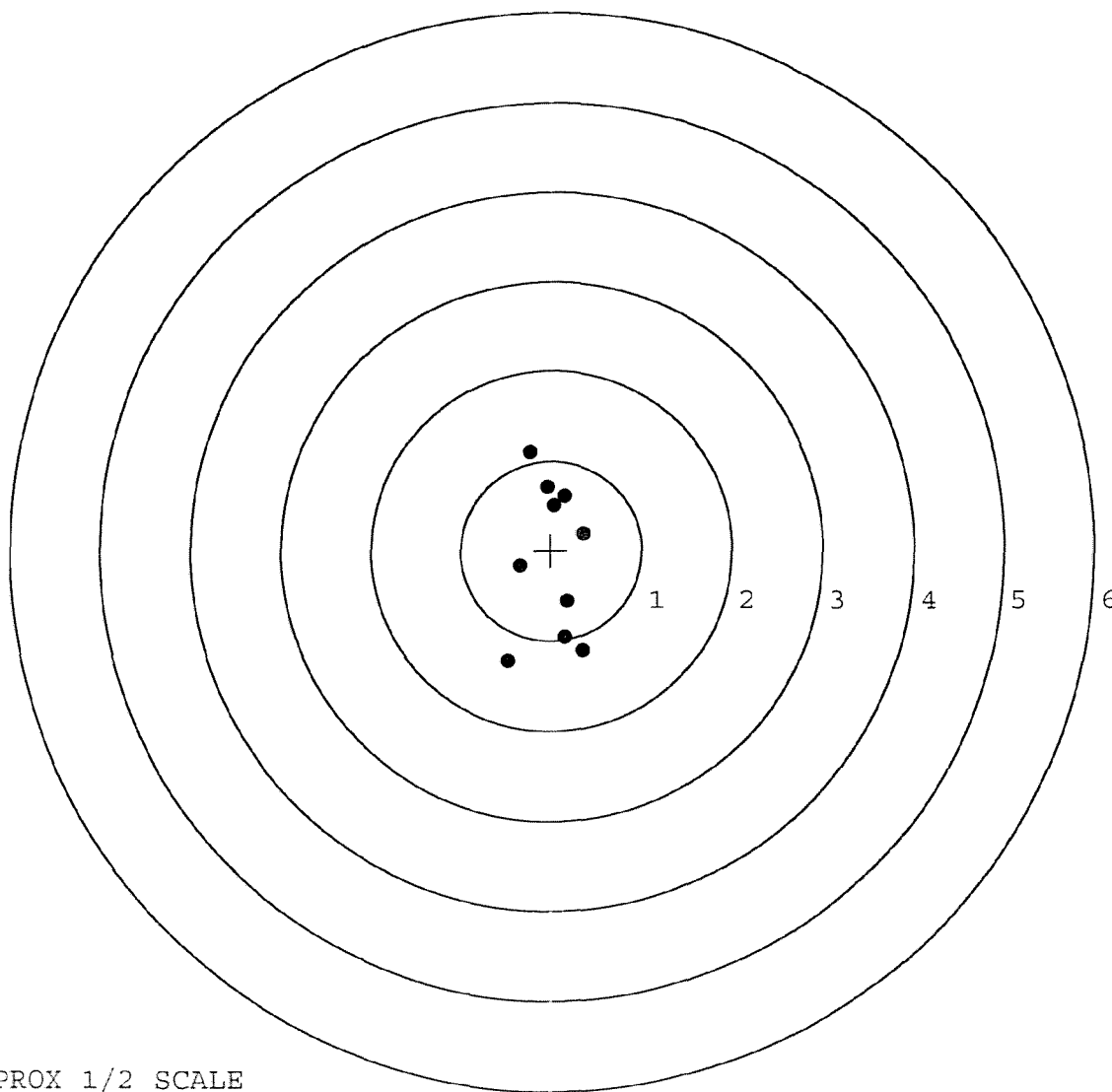


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605272. __0
TARGET NUMBER: 2
FILE DATE: 10/24/2006
FILE TIME: 06:37

X CENTROID: 0.015
Y CENTROID: -0.093
POA TO CENTROID: 0.094
HORZ SPREAD: 0.835
VERT SPREAD: 2.333
GROUP SPREAD: 2.346
MIN RADIUS: 0.364
MAX RADIUS: 1.236
MEAN RADIUS: 0.786
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.233	1.105
2:	-0.043	0.710
3:	0.155	0.613
4:	0.360	0.190
5:	-0.475	-1.228
6:	0.353	-1.115
7:	0.158	-0.970
8:	0.182	-0.569
9:	-0.341	-0.169
10:	0.035	0.501

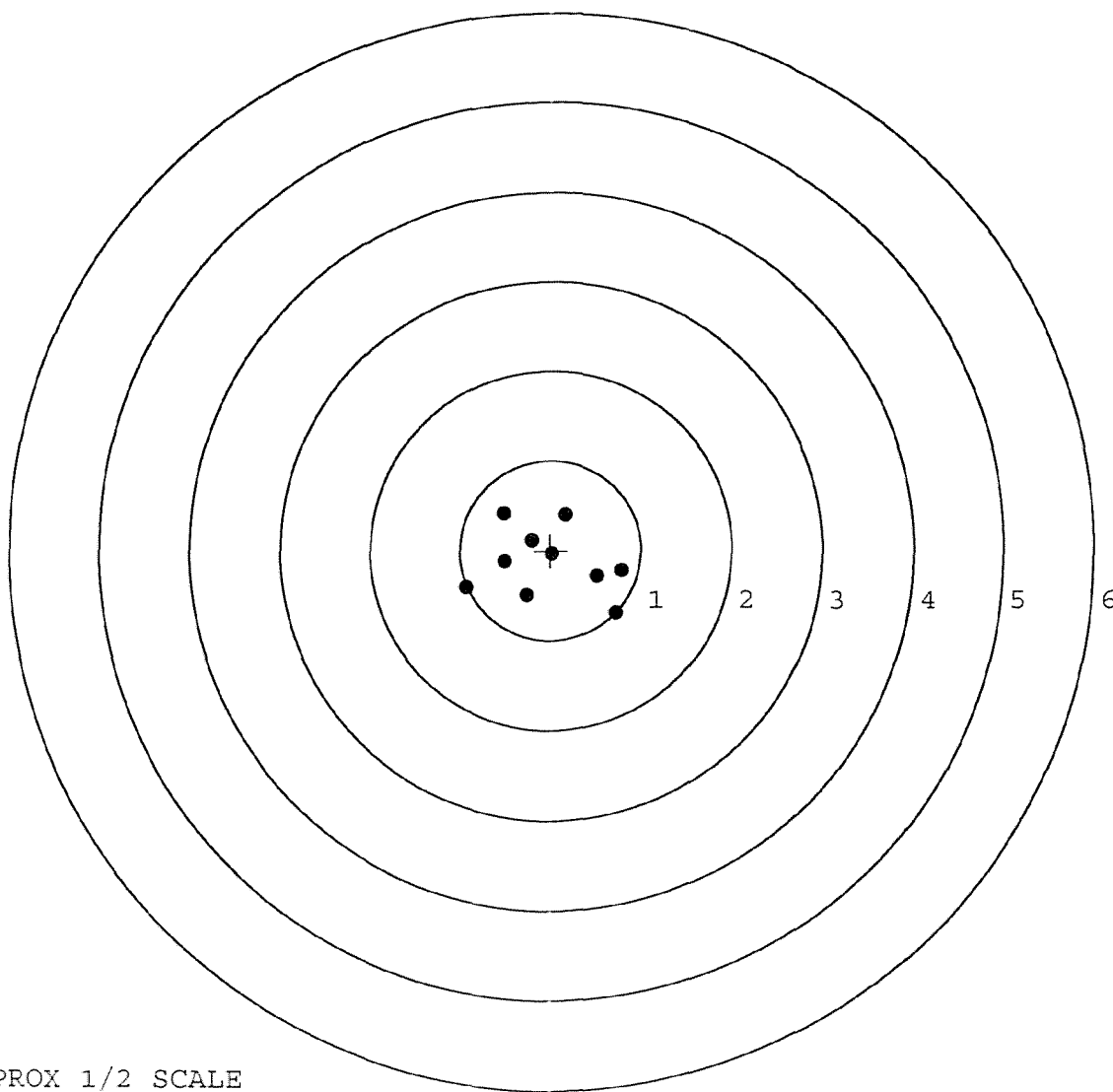


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605272. __0
TARGET NUMBER: 3
FILE DATE: 10/24/2006
FILE TIME: 06:37

X CENTROID: -0.020
Y CENTROID: -0.137
POA TO CENTROID: 0.138
HORZ SPREAD: 1.718
VERT SPREAD: 1.117
GROUP SPREAD: 1.728
MIN RADIUS: 0.106
MAX RADIUS: 0.953
MEAN RADIUS: 0.591
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.931	-0.416
2:	-0.260	-0.505
3:	-0.515	0.417
4:	-0.504	-0.122
5:	-0.208	0.120
6:	0.167	0.394
7:	0.020	-0.039
8:	0.787	-0.230
9:	0.725	-0.700
10:	0.516	-0.288

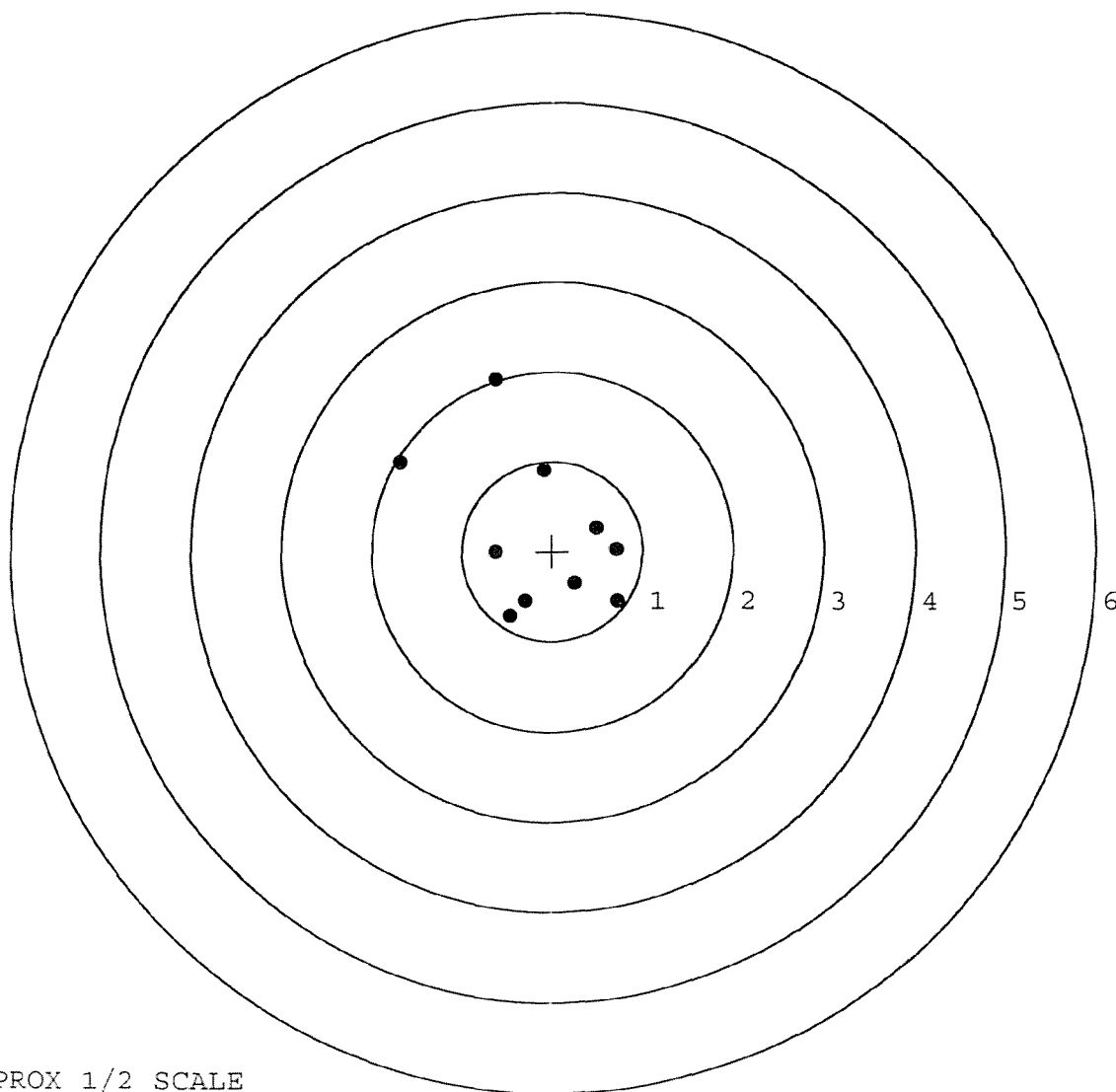


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605272. __0
TARGET NUMBER: 4
FILE DATE: 10/24/2006
FILE TIME: 06:37

POINT#	X	Y
1:	-0.630	1.915
2:	-1.687	0.990
3:	-0.088	0.903
4:	0.491	0.263
5:	0.711	0.026
6:	0.722	-0.555
7:	0.254	-0.365
8:	-0.633	-0.013
9:	-0.465	-0.726
10:	-0.296	-0.558

X CENTROID: -0.162
Y CENTROID: 0.188
POA TO CENTROID: 0.248
HORZ SPREAD: 2.409
VERT SPREAD: 2.641
GROUP SPREAD: 2.816
MIN RADIUS: 0.512
MAX RADIUS: 1.789
MEAN RADIUS: 0.986
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

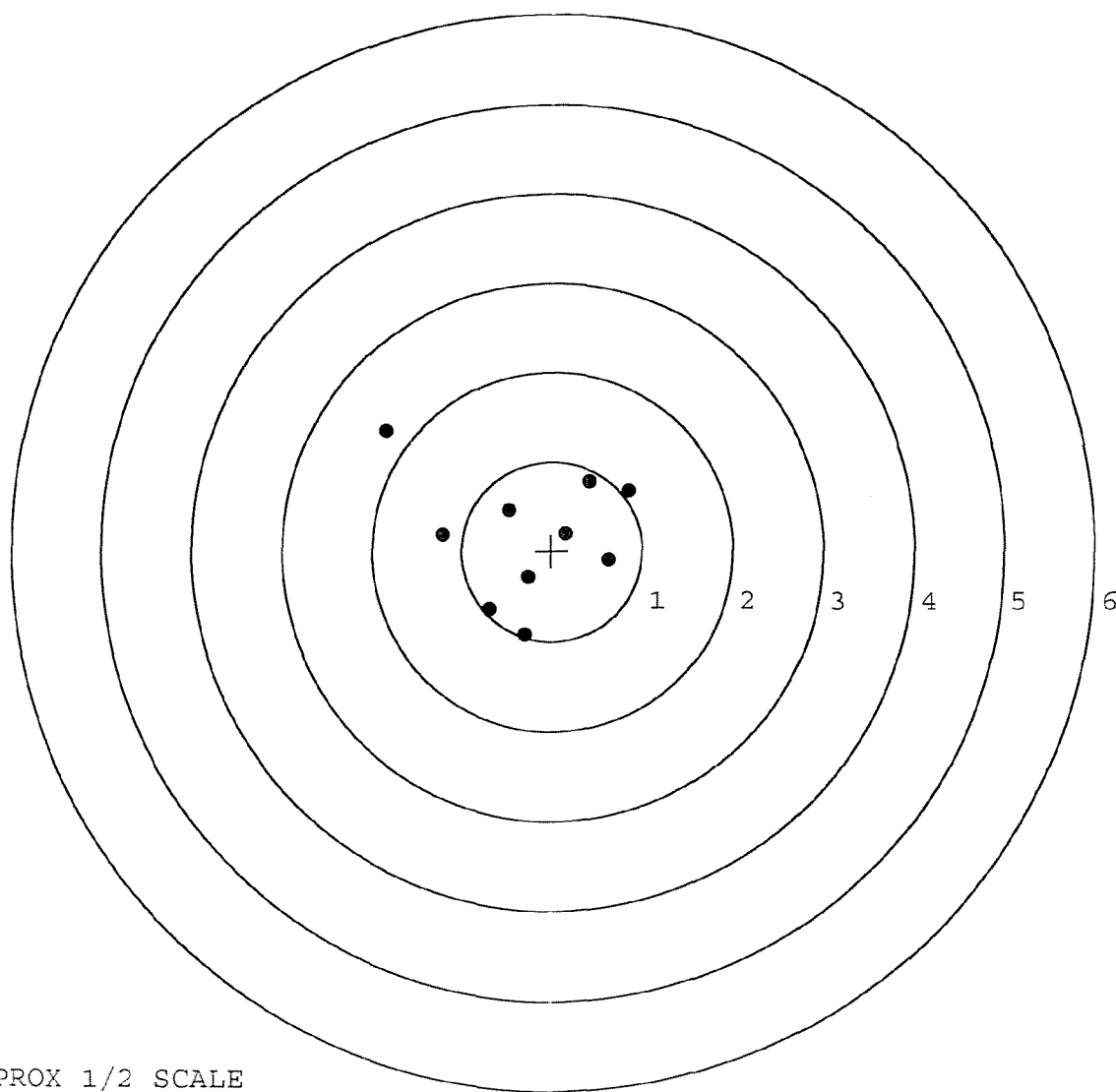


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605272. __ 0
TARGET NUMBER: 5
FILE DATE: 10/24/2006
FILE TIME: 06:37

POINT#	X	Y
1:	-0.302	-0.930
2:	-0.690	-0.652
3:	-0.261	-0.299
4:	0.629	-0.109
5:	0.151	0.192
6:	0.852	0.673
7:	0.415	0.776
8:	-0.477	0.454
9:	-1.217	0.177
10:	-1.847	1.341

X CENTROID: -0.275
Y CENTROID: 0.162
POA TO CENTROID: 0.319
HORZ SPREAD: 2.699
VERT SPREAD: 2.271
GROUP SPREAD: 2.869
MIN RADIUS: 0.355
MAX RADIUS: 1.965
MEAN RADIUS: 0.926
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE