

6605274

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYS1

UPC



0 47700 25716 7

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SERIAL NO.

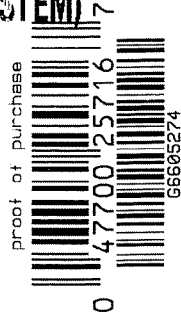


66605274

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

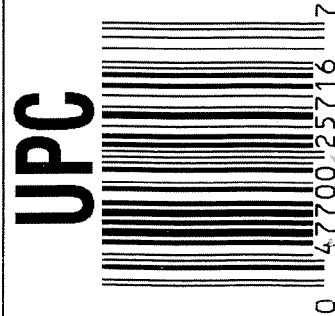
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6605274



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6605274

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-13-06	BLG
420	ASSEMBLE ACTION		10-13-06	BLG
430	ASSEMBLE TO STOCK		10-13-06	WR
440	PROOF		10-13-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-13-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 17 2006	10-13-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	10-17-06	CPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-15-06	CW
510	DRILL AND TAP SIGHT HOLES		10-16-06	TRW
520	GOFF BLAST BBL / REC		10/19	TL
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/25/06	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		11-10-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-10-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-10-06	SD
	D) OIL FIRING PIN ASSEMBLY		12-5-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4°</u> <u>4°</u> <u>5°</u>	12-14-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>8°</u> <u>7°</u> <u>7°</u>	12-14-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12-14-06	SD
	J) ASSEMBLE STOCK		12-5-06	BLG
	K) ASSEMBLE SWIVEL STUDS		12-18-06	BLG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-18-06	BLG
	M) IRON SIGHT ALIGNMENT		12-18-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-18-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	12/5/06	nom
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12/5/06	MPD
670	FINAL INSPECTION A) HEADSPACE		12-18-06	BLG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.41</u> <u>2.46</u> <u>2.45</u> <u>2.43</u> <u>2.52</u>	12-14-06	BLG
	C) FUNCTION		12-18-06	BLG
690	PACK		26-07	PA

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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 11-13-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	250	242	234	
PULL #2	238	245	239	
PULL #3	245	225	246	
PULL #4	242	229	232	
PULL #5	242	217	243	
TOTAL	1217	1158	1194	
AVERAGE	243	231	238	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	311	283	
PULL #2	323	311	
PULL #3	280	308	
PULL #4	308	288	
PULL #5	318	310	
TOTAL	1540	1500	
AVERAGE	308	300	

	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	4.205	4.11		4.09
PULL #2	4.24	4.02		396
PULL #3	4.13	4.23		4.02
PULL #4	4.11	4.21		4.00
PULL #5	4.29	4.11		4.05
TOTAL	21.02	20.68		20.12
AVERAGE	4.20	4.13		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605274.___0
FILE DATE AND TIME: 12/06/2006 06:18

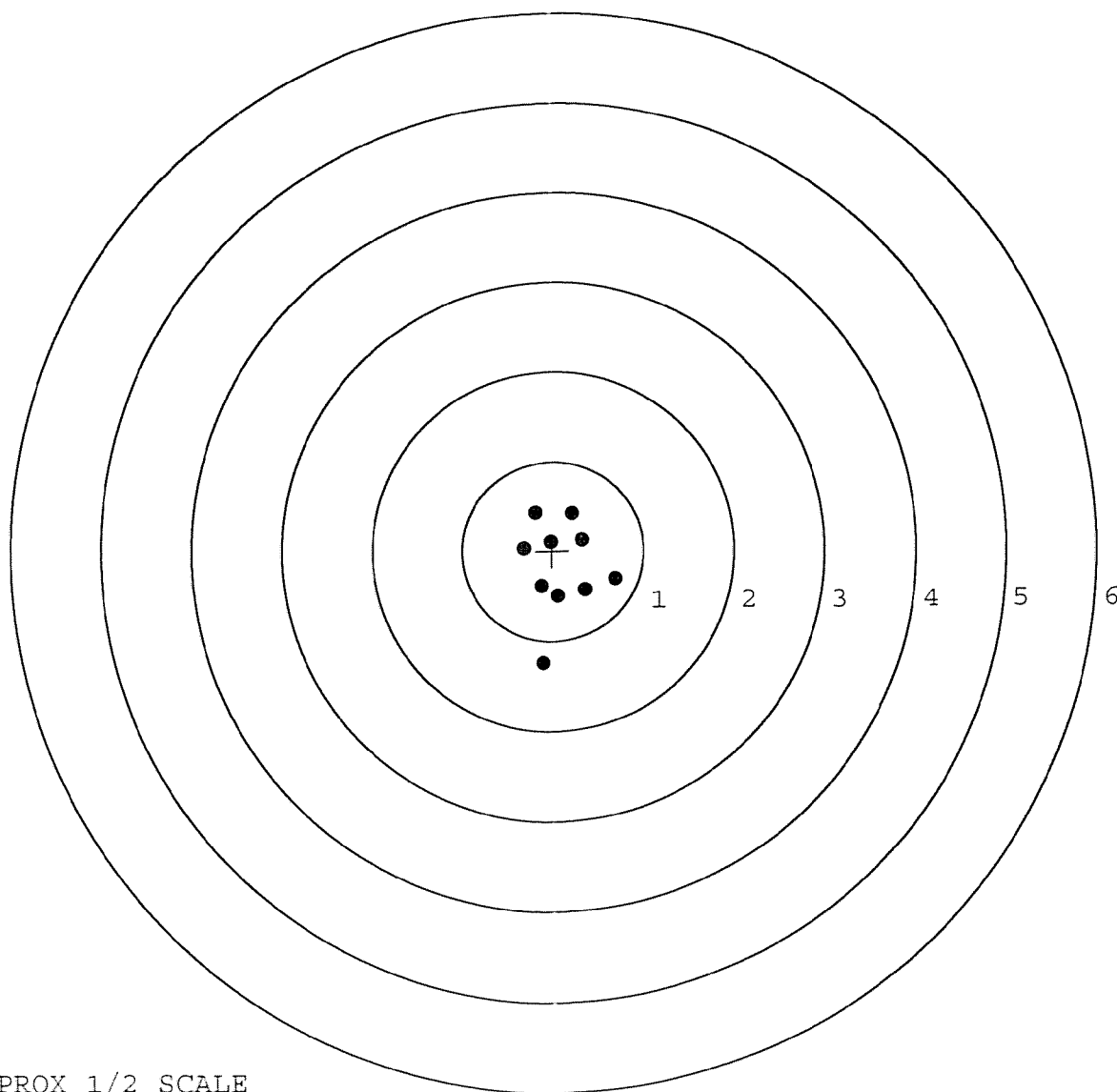
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.026
The Average Y Centroid of the Five Target Set:	-0.043
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.558
The Distance from POA to Centroid Target #1:	0.205
The Distance from Centroid Target #2 to Centroid Target #1:	0.120
The Distance from Centroid Target #3 to Centroid Target #1:	0.221
The Distance from Centroid Target #4 to Centroid Target #1:	0.151
The Distance from Centroid Target #5 to Centroid Target #1:	0.316

SERIAL NUMBER: G6605274. __0
TARGET NUMBER: 1
FILE DATE: 12/06/2006
FILE TIME: 06:18

X CENTROID: 0.091
Y CENTROID: -0.184
POA TO CENTROID: 0.205
HORZ SPREAD: 1.009
VERT SPREAD: 1.675
GROUP SPREAD: 1.694
MIN RADIUS: 0.303
MAX RADIUS: 1.082
MEAN RADIUS: 0.514
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.109	-1.248
2:	0.690	-0.324
3:	0.360	-0.446
4:	0.061	-0.512
5:	-0.123	-0.399
6:	-0.319	0.032
7:	-0.188	0.427
8:	0.221	0.414
9:	0.330	0.114
10:	-0.018	0.098



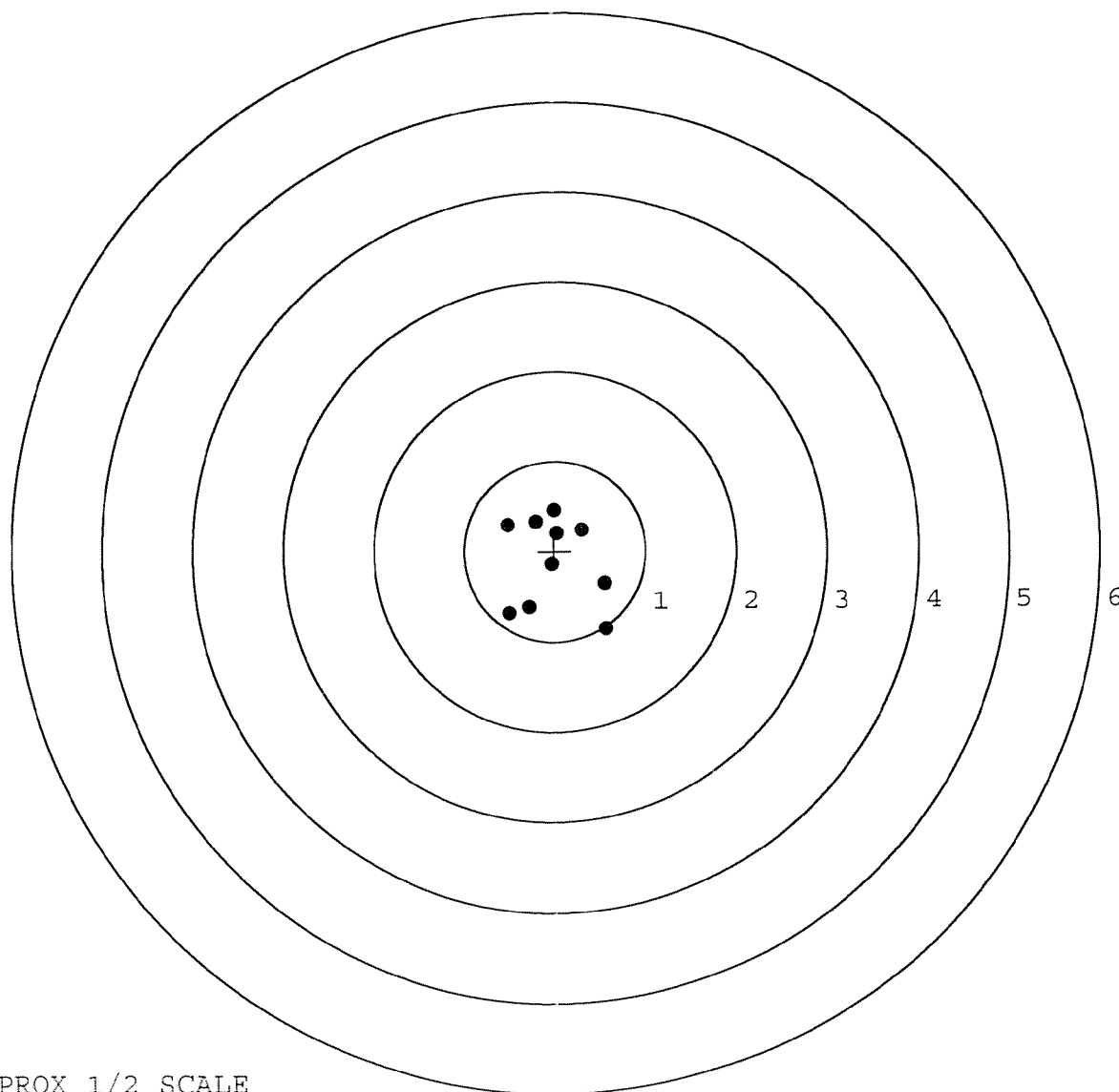
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605274. __0
TARGET NUMBER: 2
FILE DATE: 12/06/2006
FILE TIME: 06:18

X CENTROID: -0.010
Y CENTROID: -0.118
POA TO CENTROID: 0.118
HORZ SPREAD: 1.079
VERT SPREAD: 1.318
GROUP SPREAD: 1.582
MIN RADIUS: 0.034
MAX RADIUS: 0.943
MEAN RADIUS: 0.539

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

POINT#	X	Y
1:	-0.505	-0.681
2:	-0.286	-0.615
3:	0.564	-0.866
4:	0.549	-0.365
5:	-0.028	-0.147
6:	0.300	0.232
7:	-0.515	0.291
8:	-0.208	0.323
9:	0.006	0.452
10:	0.027	0.195

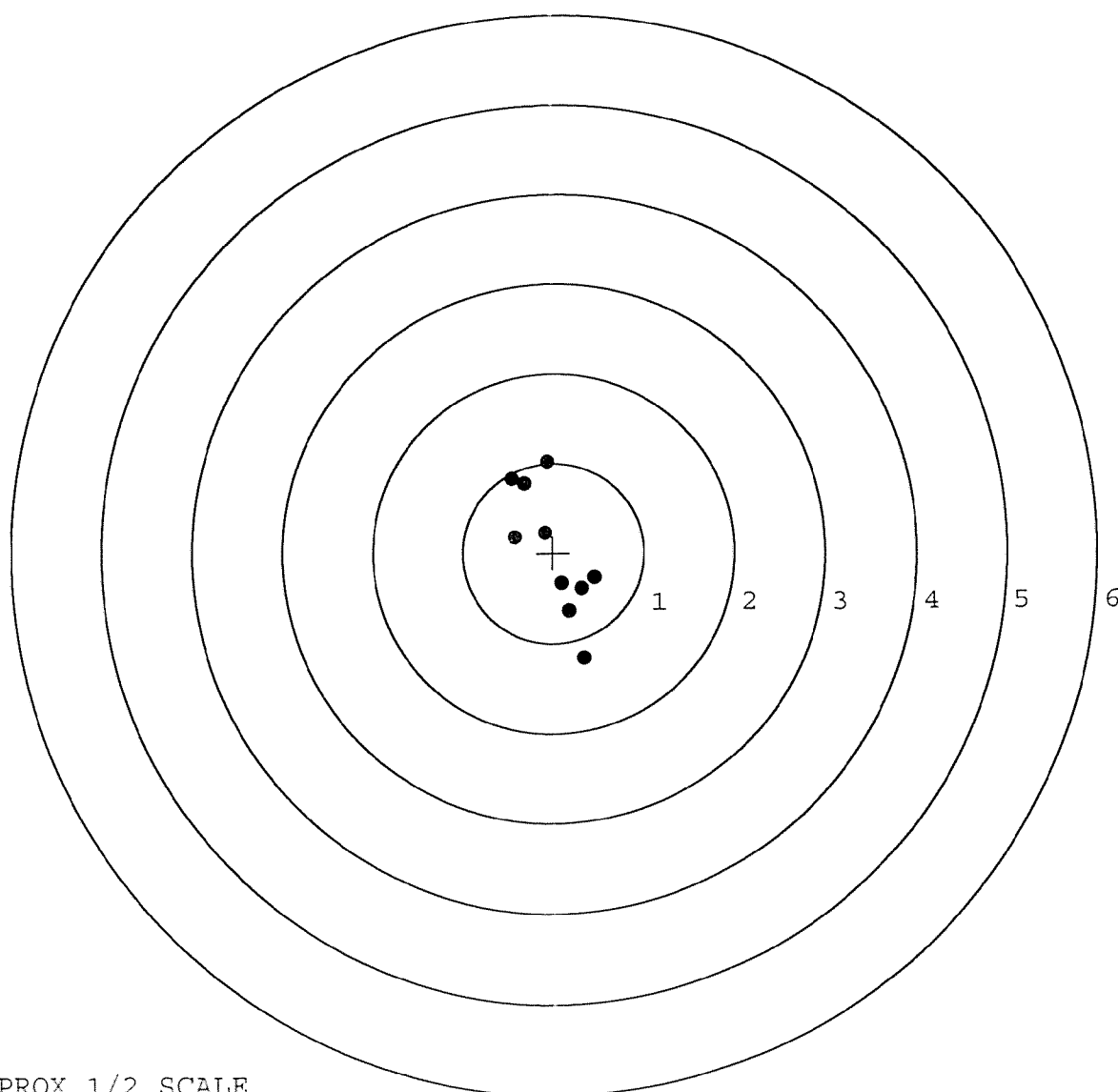


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605274. __0
TARGET NUMBER: 3
FILE DATE: 12/06/2006
FILE TIME: 06:18

X CENTROID: 0.004
Y CENTROID: 0.019
POA TO CENTROID: 0.019
HORZ SPREAD: 0.912
VERT SPREAD: 2.188
GROUP SPREAD: 2.225
MIN RADIUS: 0.226
MAX RADIUS: 1.233
MEAN RADIUS: 0.681
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.061	1.020
2:	-0.318	0.780
3:	-0.454	0.827
4:	-0.424	0.180
5:	-0.093	0.223
6:	0.458	-0.285
7:	0.096	-0.341
8:	0.179	-0.647
9:	0.341	-1.168
10:	0.317	-0.403

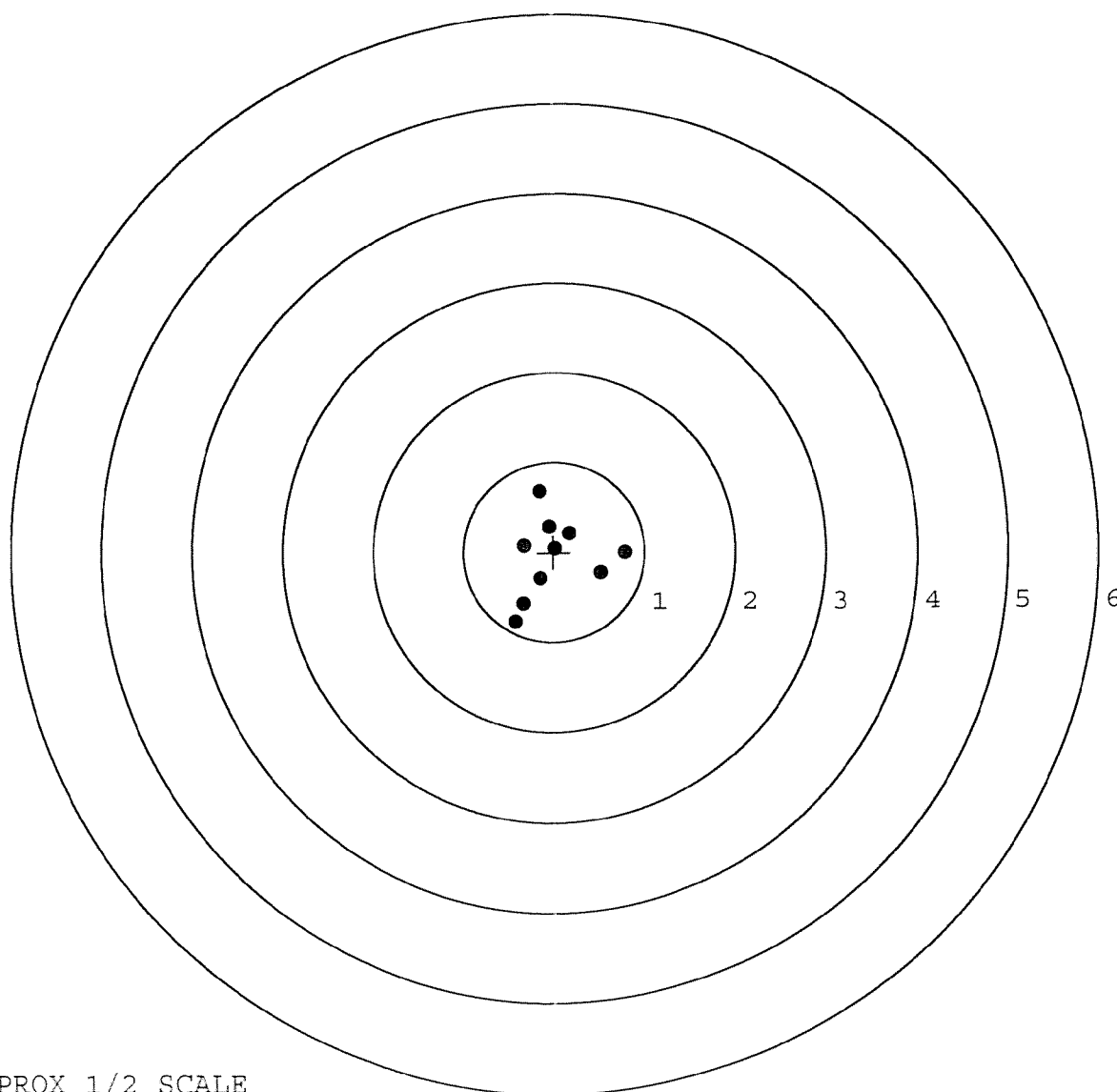


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605274. __0
TARGET NUMBER: 4
FILE DATE: 12/06/2006
FILE TIME: 06:18

X CENTROID: 0.004
Y CENTROID: -0.061
POA TO CENTROID: 0.061
HORZ SPREAD: 1.209
VERT SPREAD: 1.450
GROUP SPREAD: 1.475
MIN RADIUS: 0.105
MAX RADIUS: 0.834
MEAN RADIUS: 0.494
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.426	-0.775
2:	-0.334	-0.574
3:	-0.153	-0.297
4:	0.515	-0.235
5:	0.783	-0.013
6:	-0.156	0.675
7:	0.176	0.213
8:	0.017	0.043
9:	-0.331	0.075
10:	-0.052	0.280

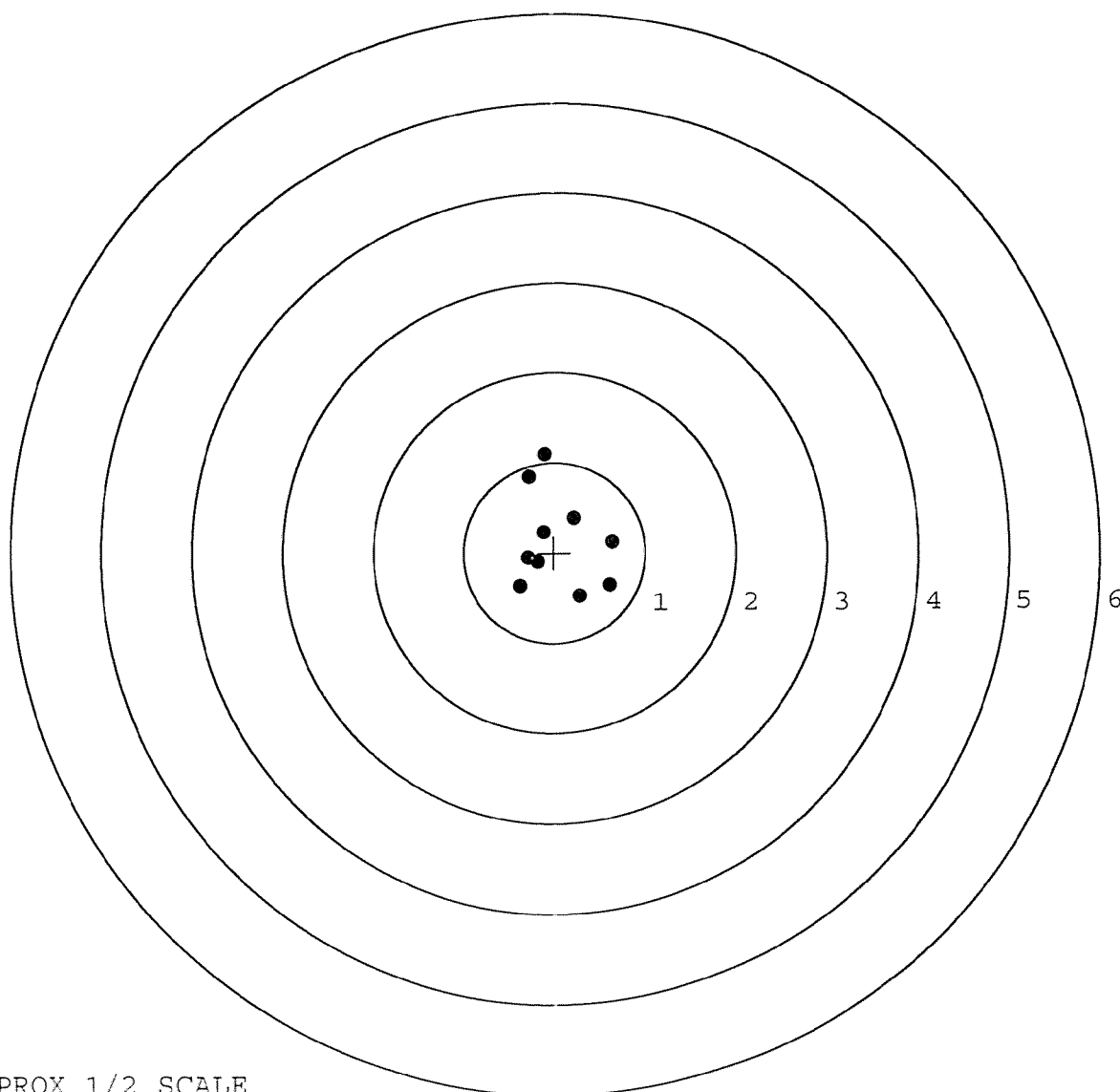


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605274. __0
TARGET NUMBER: 5
FILE DATE: 12/06/2006
FILE TIME: 06:18

X CENTROID: 0.041
Y CENTROID: 0.128
POA TO CENTROID: 0.134
HORZ SPREAD: 1.013
VERT SPREAD: 1.571
GROUP SPREAD: 1.618
MIN RADIUS: 0.191
MAX RADIUS: 0.969
MEAN RADIUS: 0.562
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.285	-0.484
2:	0.611	-0.363
3:	0.638	0.115
4:	-0.375	-0.372
5:	-0.181	-0.105
6:	-0.293	-0.059
7:	-0.119	0.233
8:	0.220	0.382
9:	-0.101	1.087
10:	-0.280	0.845



TARGET APPROX 1/2 SCALE