

G6605292

ORDER 25716

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

UPC



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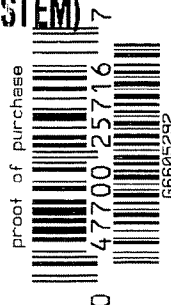
SERIAL NO.



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

G6605292



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6605 292

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-12-06	BLG
420	ASSEMBLE ACTION		10-13-06	BLG
430	ASSEMBLE TO STOCK		10-13-06	WIC
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>LPD</u>	10-17-06	LPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-16-06	W
510	DRILL AND TAP SIGHT HOLES		10-16-06	TRW
520	GOFF BLAST BBL / REC		10-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/20/06	TRW
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-24-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-24-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-24-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-4-06	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>40</u> <u>45</u> <u>40</u>	11-4-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>75</u> <u>82</u> <u>75</u>	11-4-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.025</u> <u>.025</u>	11-4-06	SD
	J) ASSEMBLE STOCK		11-4-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-17-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-17-06	RTZ
	M) IRON SIGHT ALIGNMENT		11-17-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-17-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	11-6-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-6-06	SD
670	FINAL INSPECTION A) HEADSPACE		11-17-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.49</u> <u>2.43</u> <u>2.41</u> <u>2.45</u>	11-13-06	SD
	C) FUNCTION		11-17-06	L.P.D.
690	PACK		2-5-07	WA

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 11-03-06

TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.55	2.16		2.34	
PULL #2	2.51	2.15		2.34	
PULL #3	2.53	2.18		2.33	
PULL #4	2.49	2.19		2.26	
PULL #5	2.64	2.13		2.29	
TOTAL	1272	1081		1156	
AVERAGE	254	216		231	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	2.91		
PULL #2	3.11	2.93		
PULL #3	3.16	2.94		
PULL #4	3.05	2.95		
PULL #5	3.04	2.93		
TOTAL	1543	1466		
AVERAGE	308	293		

	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	4.12	4.07		4.21
PULL #2	4.20	4.07		4.25
PULL #3	4.20	4.09		4.26
PULL #4	4.18	4.05		4.24
PULL #5	4.27	4.07		4.22
TOTAL	2097	2035		2118
AVERAGE	419	407		423

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605292.___0
FILE DATE AND TIME: 11/07/2006 05:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.047
The Average Y Centroid of the Five Target Set:	0.005
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.674
The Distance from POA to Centroid Target #1:	0.121
The Distance from Centroid Target #2 to Centroid Target #1:	0.125
The Distance from Centroid Target #3 to Centroid Target #1:	0.319
The Distance from Centroid Target #4 to Centroid Target #1:	0.135
The Distance from Centroid Target #5 to Centroid Target #1:	0.027

SERIAL NUMBER: G6605292. __0

TARGET NUMBER: 1

FILE DATE: 11/07/2006

FILE TIME: 05:50

X CENTROID: 0.118

Y CENTROID: 0.025

POA TO CENTROID: 0.121

HORZ SPREAD: 1.608

VERT SPREAD: 1.678

GROUP SPREAD: 2.184

MIN RADIUS: 0.196

MAX RADIUS: 1.339

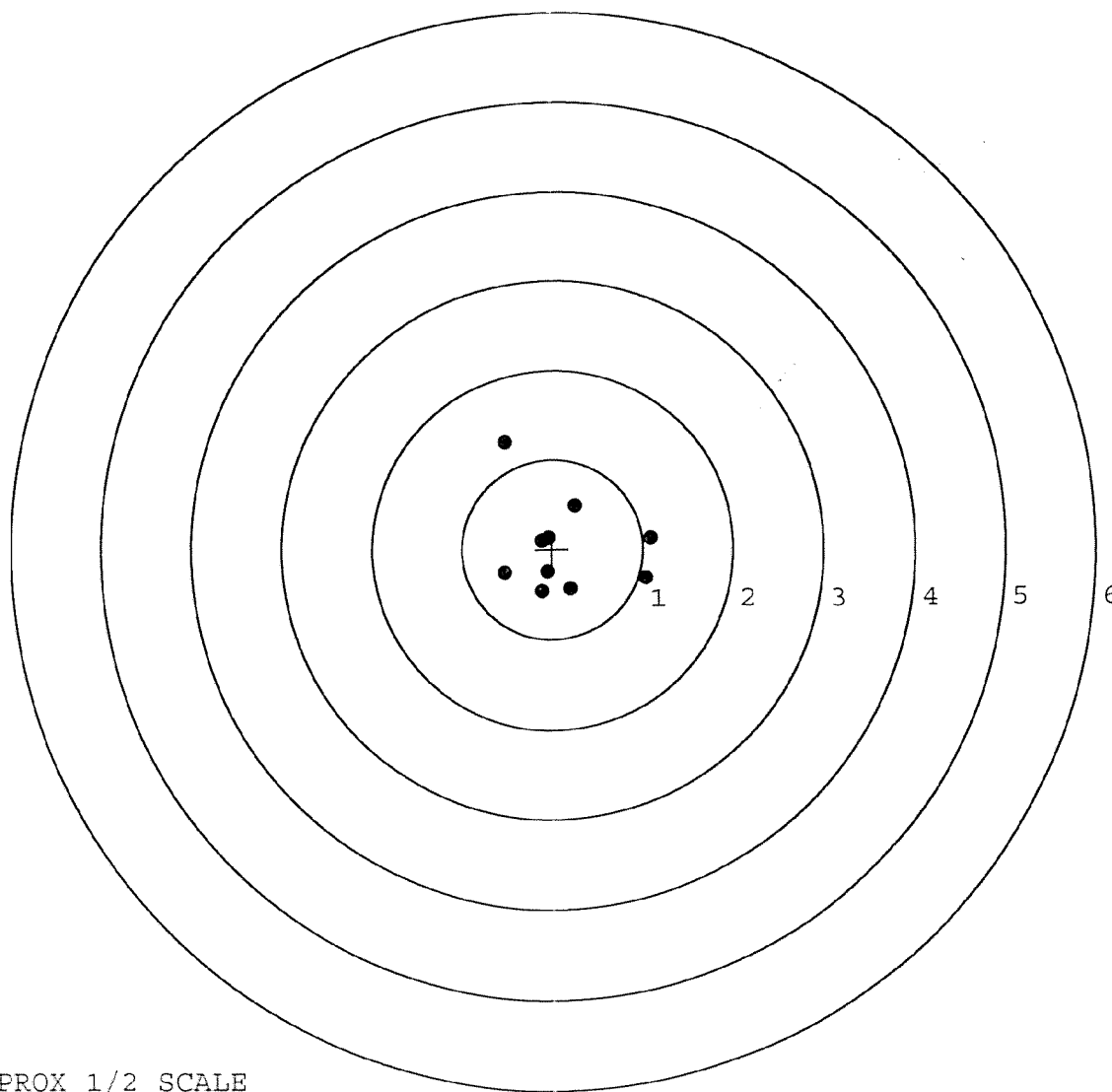
MEAN RADIUS: 0.629

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.032	-0.333
2:	1.081	0.121
3:	0.259	0.484
4:	-0.524	1.199
5:	-0.527	-0.264
6:	-0.045	0.132
7:	0.201	-0.453
8:	-0.118	-0.479
9:	-0.057	-0.258
10:	-0.118	0.097

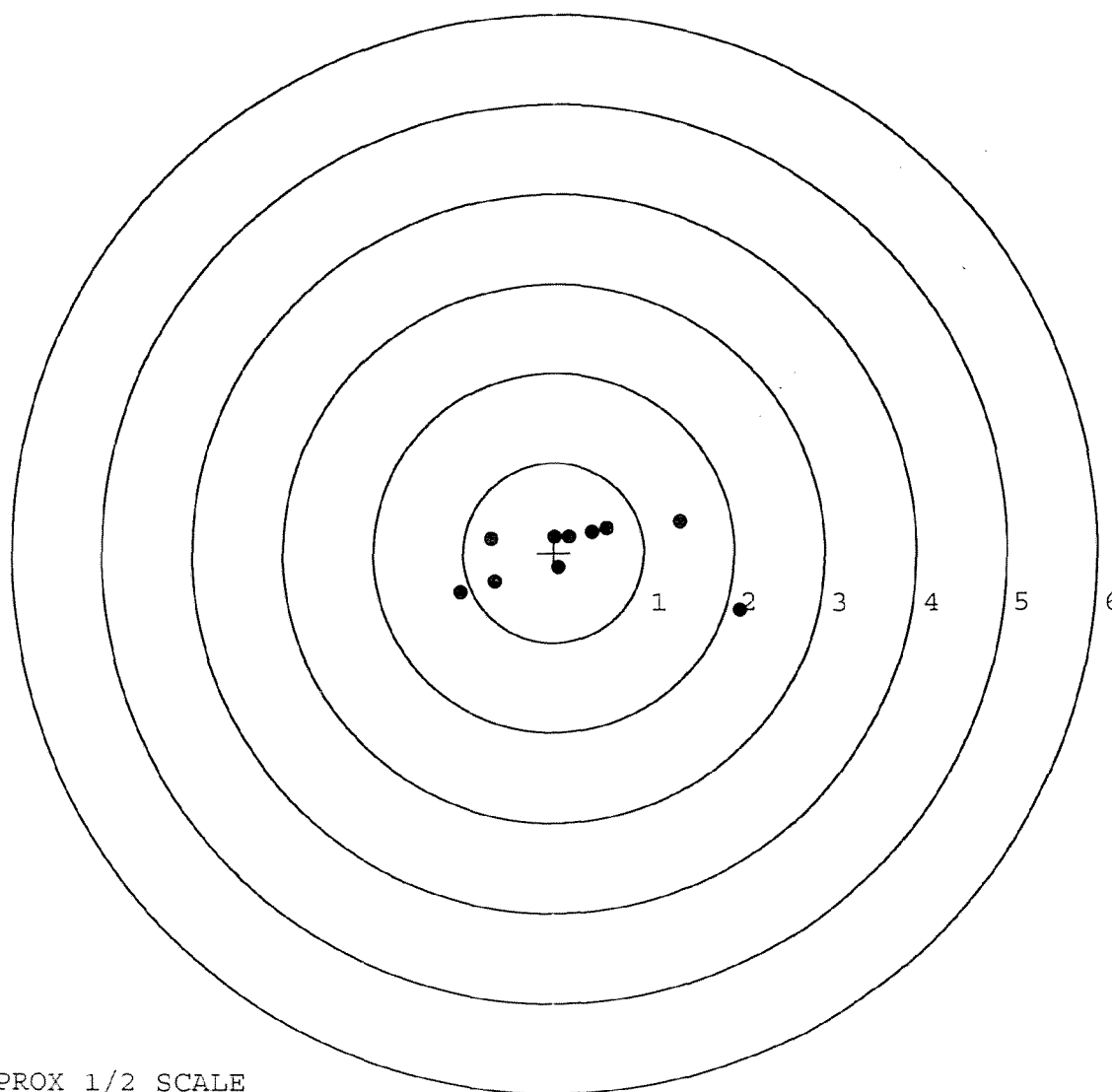


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605292. __0
TARGET NUMBER: 2
FILE DATE: 11/07/2006
FILE TIME: 05:50

X CENTROID: 0.233
Y CENTROID: -0.024
POA TO CENTROID: 0.234
HORZ SPREAD: 3.092
VERT SPREAD: 0.992
GROUP SPREAD: 3.098
MIN RADIUS: 0.212
MAX RADIUS: 1.936
MEAN RADIUS: 0.789
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	2.065	-0.651
2:	1.399	0.341
3:	0.585	0.273
4:	0.171	0.178
5:	0.048	-0.169
6:	0.008	0.178
7:	-0.697	0.157
8:	-0.647	-0.326
9:	-1.027	-0.453
10:	0.424	0.229



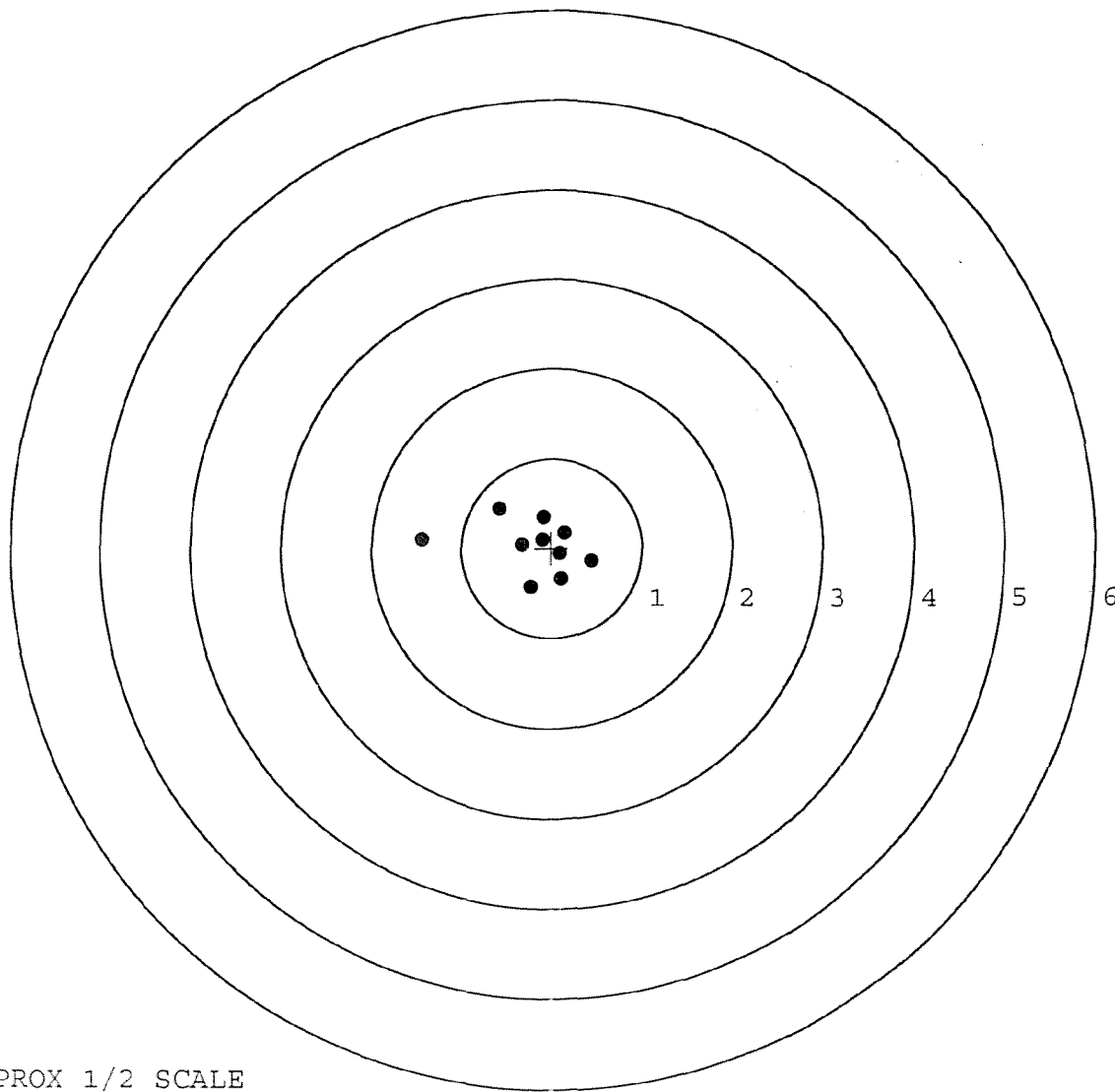
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605292. __0
TARGET NUMBER: 3
FILE DATE: 11/07/2006
FILE TIME: 05:50

X CENTROID: -0.201
Y CENTROID: 0.023
POA TO CENTROID: 0.202
HORZ SPREAD: 1.883
VERT SPREAD: 0.883
GROUP SPREAD: 1.899
MIN RADIUS: 0.123
MAX RADIUS: 1.243
MEAN RADIUS: 0.471

POINT#	X	Y
1:	-1.441	0.102
2:	-0.586	0.449
3:	-0.238	-0.434
4:	0.109	-0.347
5:	0.442	-0.143
6:	0.144	0.170
7:	-0.100	0.349
8:	-0.335	0.045
9:	0.099	-0.061
10:	-0.103	0.097

IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

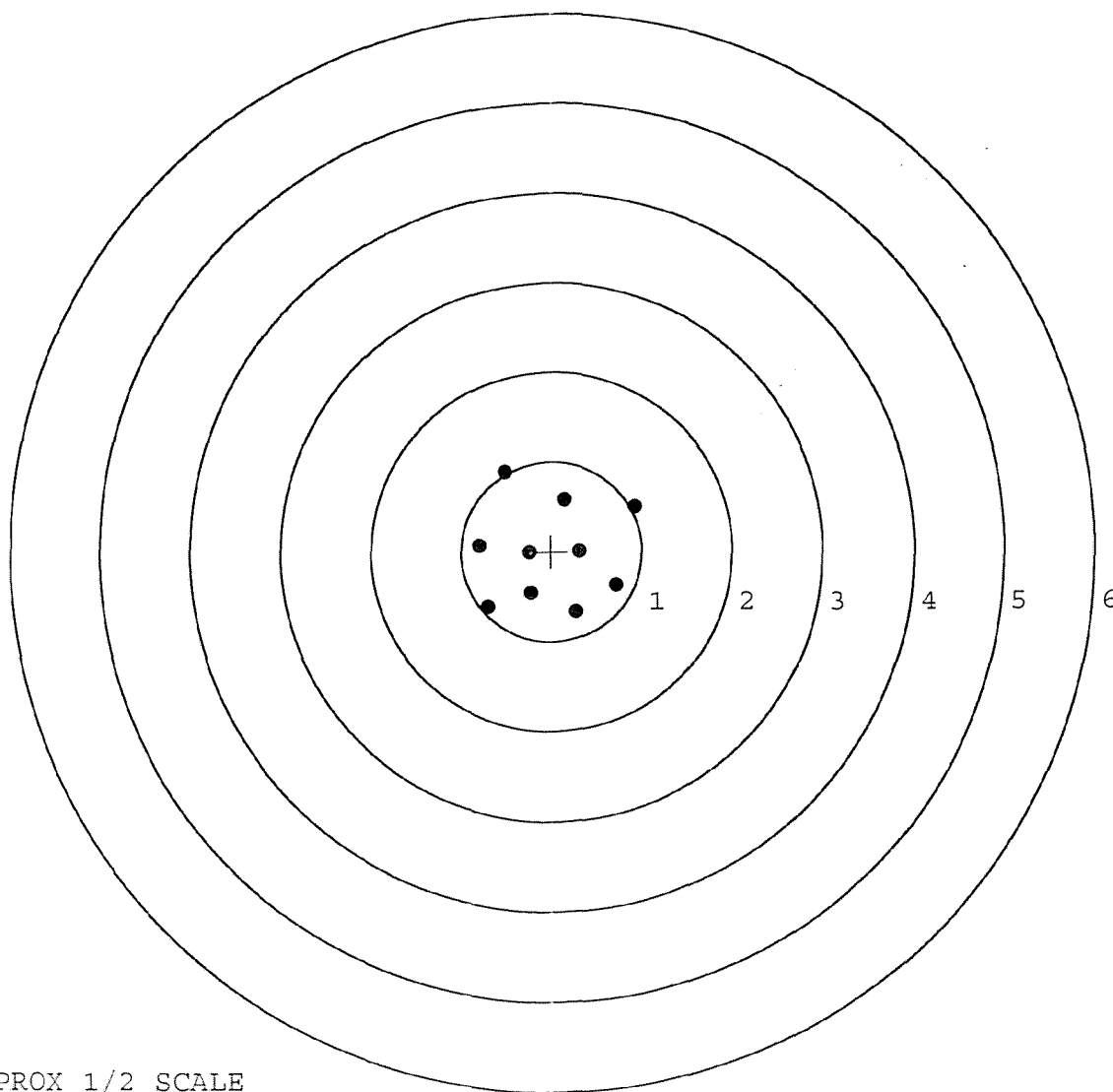


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605292. __0
TARGET NUMBER: 4
FILE DATE: 11/07/2006
FILE TIME: 05:50

POINT#	X	Y
1:	0.275	-0.677
2:	0.718	-0.374
3:	0.923	0.500
4:	0.147	0.574
5:	0.313	-0.002
6:	-0.516	0.891
7:	-0.802	0.071
8:	-0.242	-0.009
9:	-0.228	-0.462
10:	-0.704	-0.615

X CENTROID: -0.012
Y CENTROID: -0.010
POA TO CENTROID: 0.016
HORZ SPREAD: 1.725
VERT SPREAD: 1.568
GROUP SPREAD: 1.972
MIN RADIUS: 0.230
MAX RADIUS: 1.065
MEAN RADIUS: 0.701
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

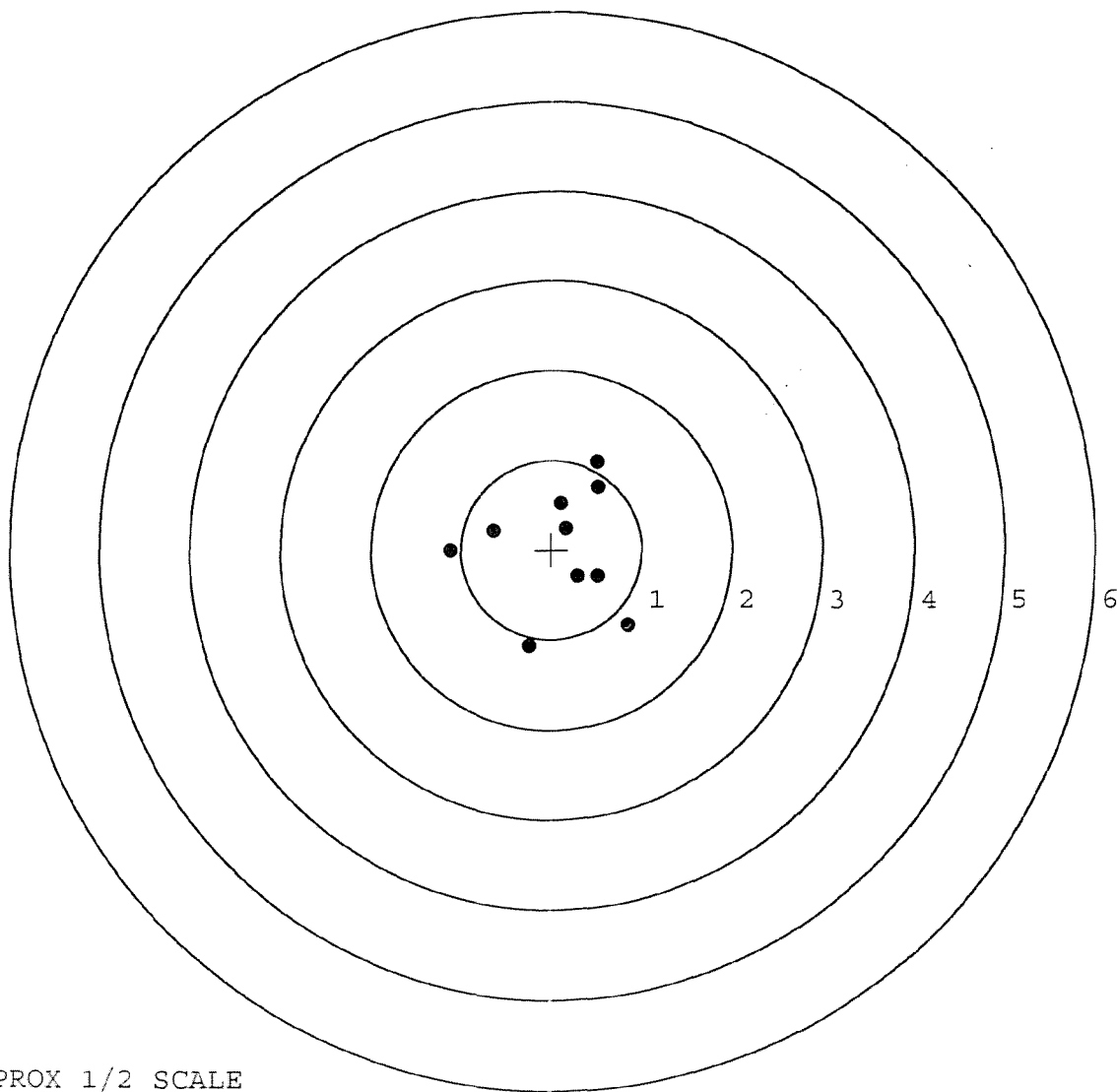


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605292. __0
TARGET NUMBER: 5
FILE DATE: 11/07/2006
FILE TIME: 05:50

POINT#	X	Y
1:	-0.250	-1.079
2:	0.853	-0.843
3:	0.517	-0.298
4:	0.294	-0.301
5:	-1.125	-0.014
6:	-0.646	0.215
7:	0.509	0.982
8:	0.515	0.704
9:	0.163	0.234
10:	0.113	0.516

X CENTROID: 0.094
Y CENTROID: 0.012
POA TO CENTROID: 0.095
HORZ SPREAD: 1.978
VERT SPREAD: 2.061
GROUP SPREAD: 2.145
MIN RADIUS: 0.233
MAX RADIUS: 1.220
MEAN RADIUS: 0.777
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE