

G660 5469

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



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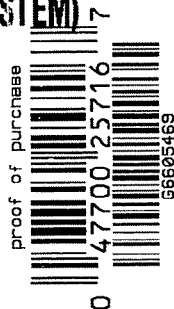
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

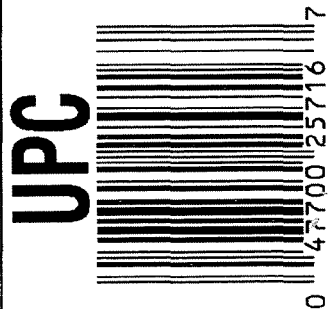


ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6605469



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6605469

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE			
420	ASSEMBLE ACTION		10-3-06	SD
430	ASSEMBLE TO STOCK		10-4-06	DK
440	PROOF		10-4-06	TRLW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-4-06	TRLW
470	DIS-ASSEMBLE ACTION	OCT 05 2006	10-4-06	SD
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	10-03-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-6-06	RA
510	DRILL AND TAP SIGHT HOLES		10-4-06	SD
520	GOFF BLAST BBL / REC		10-9-06	UB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/13/06	FB
560	RE-ASSEMBLE ACTION		10-19-06	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-19-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-19-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-26-06	RTZ
	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>8.0</u> <u>8.0</u> <u>8.0</u>	11/13/06	nom
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	11/13/06	nom
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	11/13/06	nom
	J) ASSEMBLE STOCK		10-26-06	RT
	K) ASSEMBLE SWIVEL STUDS		11-16-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-26-06	RT
	M) IRON SIGHT ALIGNMENT		10-26-06	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-26-06	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-26-06	nom
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11-16-06	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		10-26-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>239</u> <u>2.37</u> <u>237</u> <u>248</u> <u>250</u>	11/10/06	nom
	C) FUNCTION		11-16-06	L.P.D.
690	PACK		11/13/06	RT

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 9-9-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.50		2.33	
PULL #2	2.43	2.60		2.47	
PULL #3	2.54	2.54		2.49	
PULL #4	2.58	2.56		2.49	
PULL #5	2.61	2.56		2.51	
TOTAL	12.53	12.76		12.29	
AVERAGE	2.50	2.55		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.00	2.81		
PULL #2	3.03	2.94		
PULL #3	2.93	3.00		
PULL #4	3.08	2.99		
PULL #5	3.07	2.96		
TOTAL	15.11	14.70		
AVERAGE	3.02	2.94		

	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	4.07	3.95		4.11
PULL #2	3.95	3.99		4.06
PULL #3	3.99	4.01		4.10
PULL #4	4.03	3.92		4.15
PULL #5	3.95	3.97		4.07
TOTAL	19.99	19.84		20.49
AVERAGE	3.99	3.96		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605469.___0
FILE DATE AND TIME: 10/27/2006 06:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.002
The Average Y Centroid of the Five Target Set:	0.062
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.578
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.046
The Distance from Centroid Target #3 to Centroid Target #1:	0.120
The Distance from Centroid Target #4 to Centroid Target #1:	0.152
The Distance from Centroid Target #5 to Centroid Target #1:	0.089

SERIAL NUMBER: G6605469. __ 0

TARGET NUMBER: 1

FILE DATE: 10/27/2006

FILE TIME: 06:10

POINT#	X	Y
1:	-0.745	0.517
2:	0.348	0.832
3:	0.860	0.226
4:	-0.634	-0.289
5:	-0.001	-0.423
6:	-0.293	0.186
7:	0.055	0.292
8:	0.173	0.031
9:	-0.142	-0.216
10:	-0.105	0.007

X CENTROID: -0.048

Y CENTROID: 0.116

POA TO CENTROID: 0.126

HORZ SPREAD: 1.605

VERT SPREAD: 1.255

GROUP SPREAD: 1.631

MIN RADIUS: 0.123

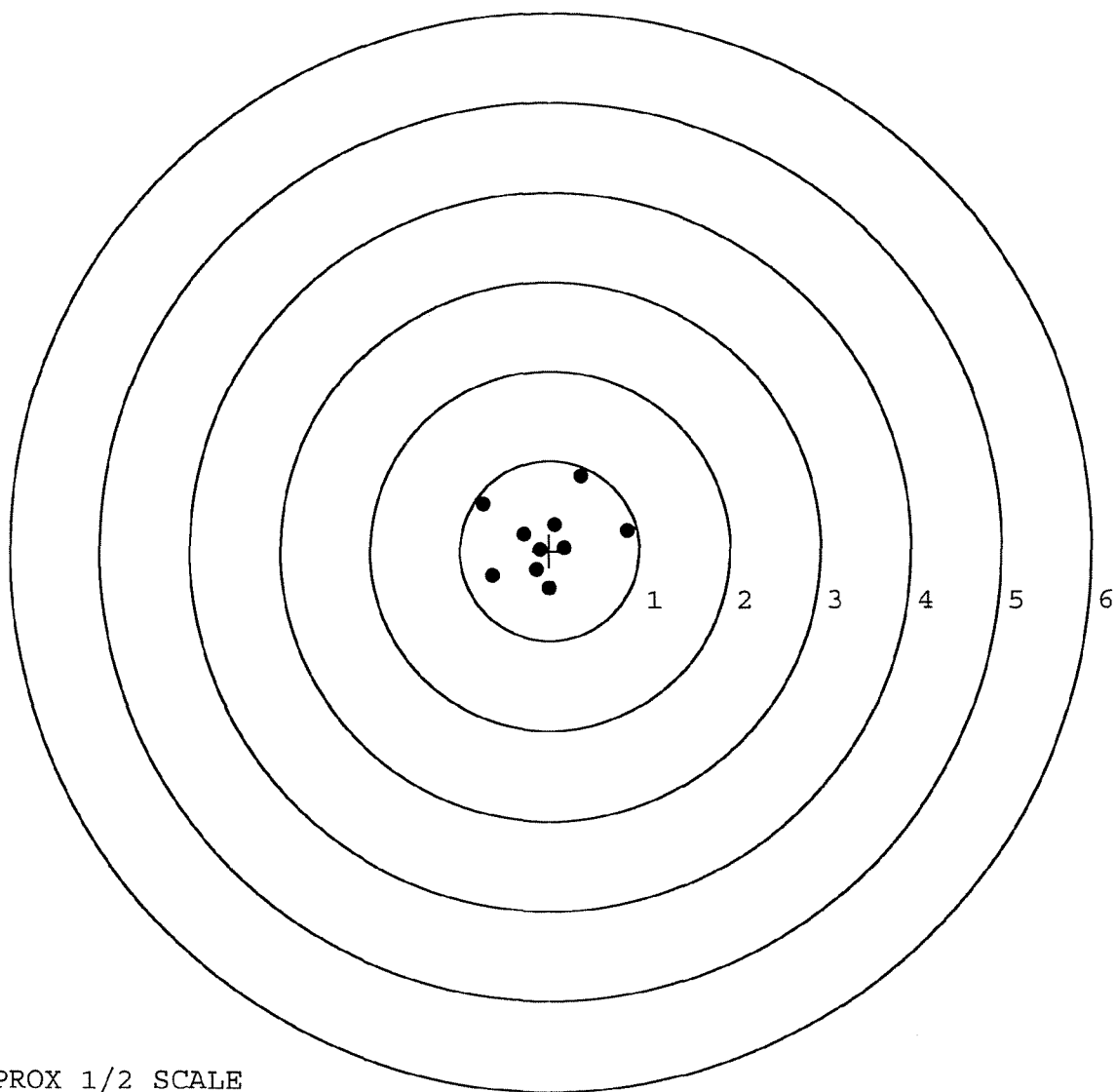
MAX RADIUS: 0.915

MEAN RADIUS: 0.495

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605469. __0

TARGET NUMBER: 2

FILE DATE: 10/27/2006

FILE TIME: 06:10

POINT#	X	Y
1:	-0.181	0.861
2:	0.492	0.548
3:	-0.710	-0.362
4:	-0.545	0.176
5:	-0.236	0.213
6:	-0.105	0.144
7:	0.571	-0.216
8:	-0.063	-0.351
9:	0.237	-0.222
10:	0.151	-0.077

X CENTROID: -0.039

Y CENTROID: 0.071

POA TO CENTROID: 0.081

HORZ SPREAD: 1.281

VERT SPREAD: 1.223

GROUP SPREAD: 1.333

MIN RADIUS: 0.098

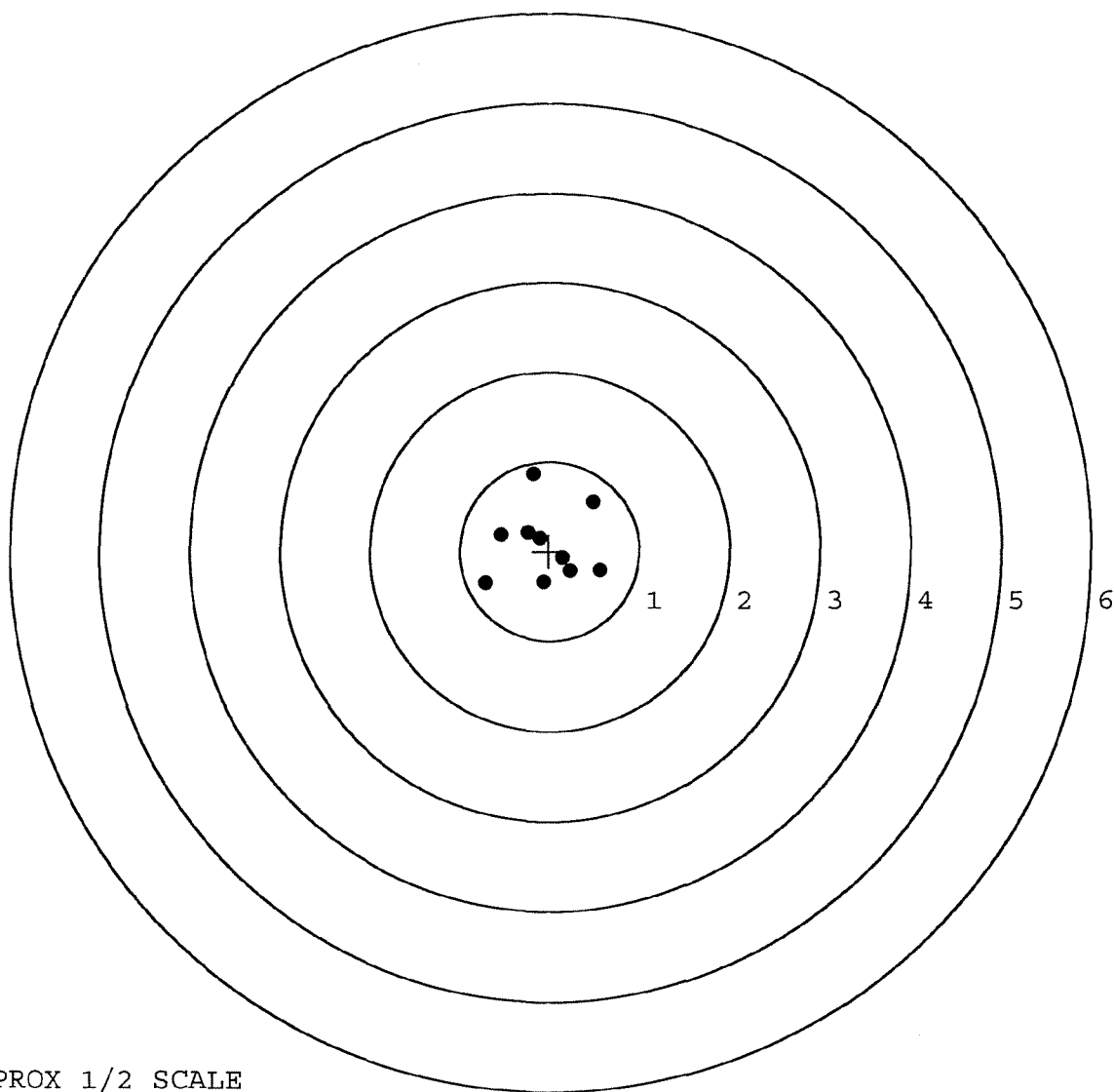
MAX RADIUS: 0.802

MEAN RADIUS: 0.491

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605469. __0

TARGET NUMBER: 3

FILE DATE: 10/27/2006

FILE TIME: 06:10

POINT#	X	Y
1:	0.452	-1.396
2:	0.693	-0.819
3:	-0.645	0.817
4:	-0.836	0.194
5:	-0.318	-0.140
6:	0.085	-0.156
7:	-0.062	0.199
8:	0.582	0.515
9:	0.373	0.539
10:	0.063	0.584

X CENTROID: 0.039

Y CENTROID: 0.034

POA TO CENTROID: 0.051

HORZ SPREAD: 1.529

VERT SPREAD: 2.213

GROUP SPREAD: 2.470

MIN RADIUS: 0.194

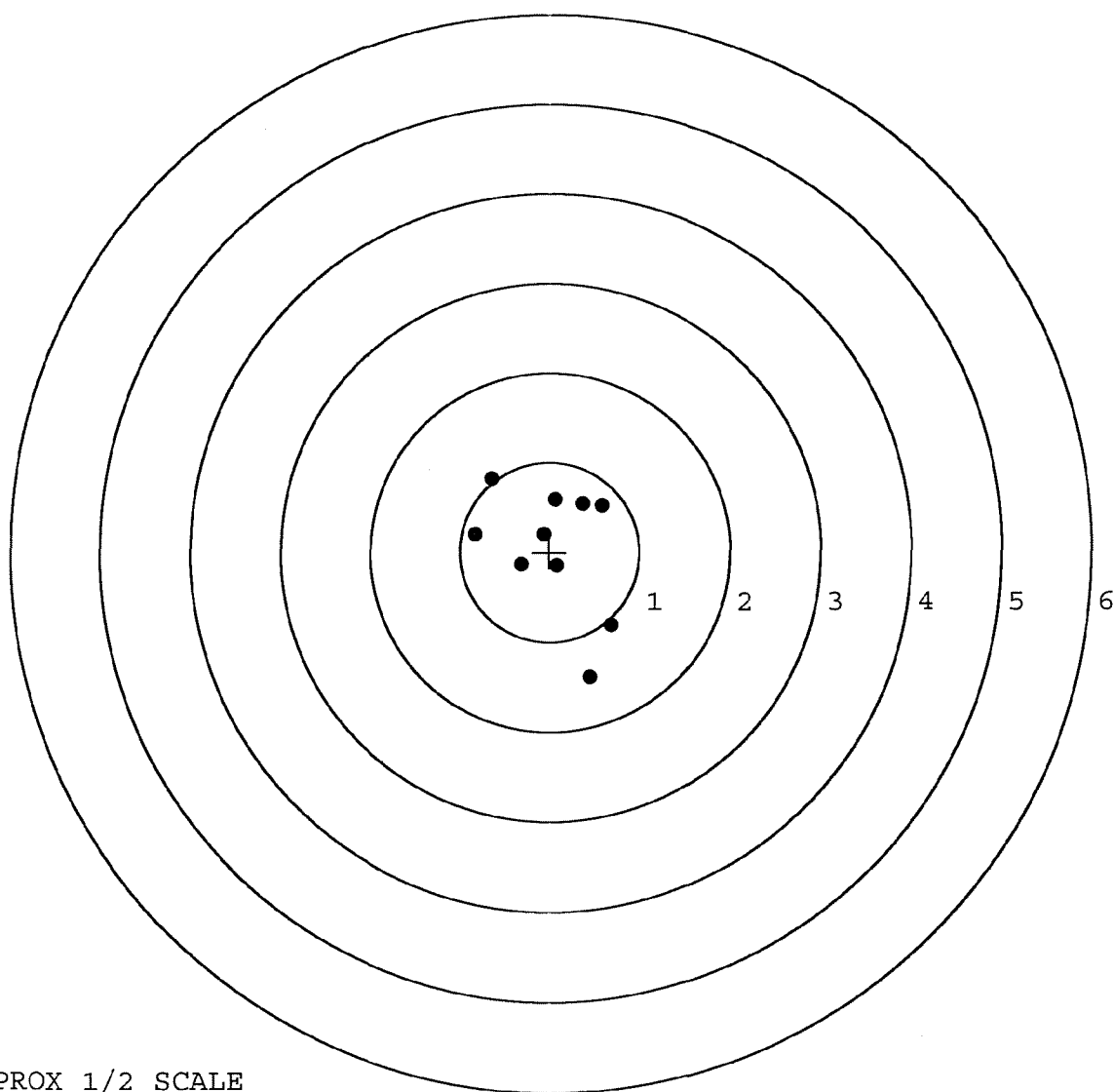
MAX RADIUS: 1.488

MEAN RADIUS: 0.716

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605469. __0

TARGET NUMBER: 4

FILE DATE: 10/27/2006

FILE TIME: 06:10

POINT#	X	Y
1:	0.480	0.528
2:	0.594	0.039
3:	0.624	-0.189
4:	0.369	-0.347
5:	-0.081	-0.417
6:	-0.445	-0.207
7:	-0.967	-0.024
8:	-0.476	0.089
9:	-0.054	0.213
10:	0.160	0.126

X CENTROID: 0.020

Y CENTROID: -0.019

POA TO CENTROID: 0.028

HORZ SPREAD: 1.591

VERT SPREAD: 0.945

GROUP SPREAD: 1.600

MIN RADIUS: 0.201

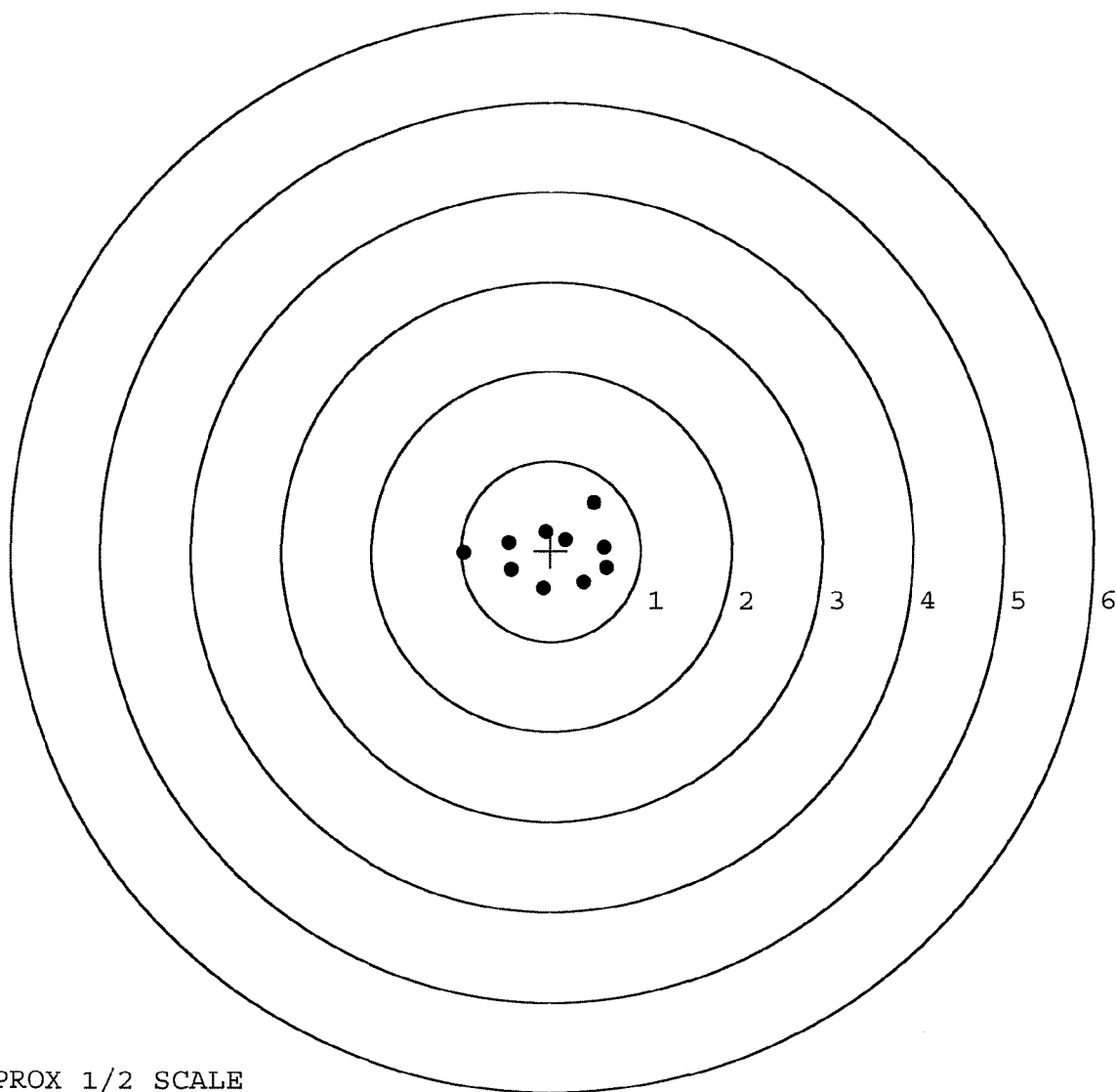
MAX RADIUS: 0.987

MEAN RADIUS: 0.525

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605469. __0

TARGET NUMBER: 5

FILE DATE: 10/27/2006

FILE TIME: 06:10

POINT#	X	Y
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1:	-0.148	-0.588
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2:	0.524	-0.662
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3:	0.613	-0.214
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4:	0.575	1.215
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5:	0.247	0.751
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6:	-0.699	0.755
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7:	-0.347	0.242
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8:	-0.427	-0.153
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9:	0.124	-0.225
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10:	-0.063	-0.044
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X CENTROID: 0.040

Y CENTROID: 0.108

POA TO CENTROID: 0.115

HORZ SPREAD: 1.312

VERT SPREAD: 1.877

GROUP SPREAD: 1.943

MIN RADIUS: 0.183

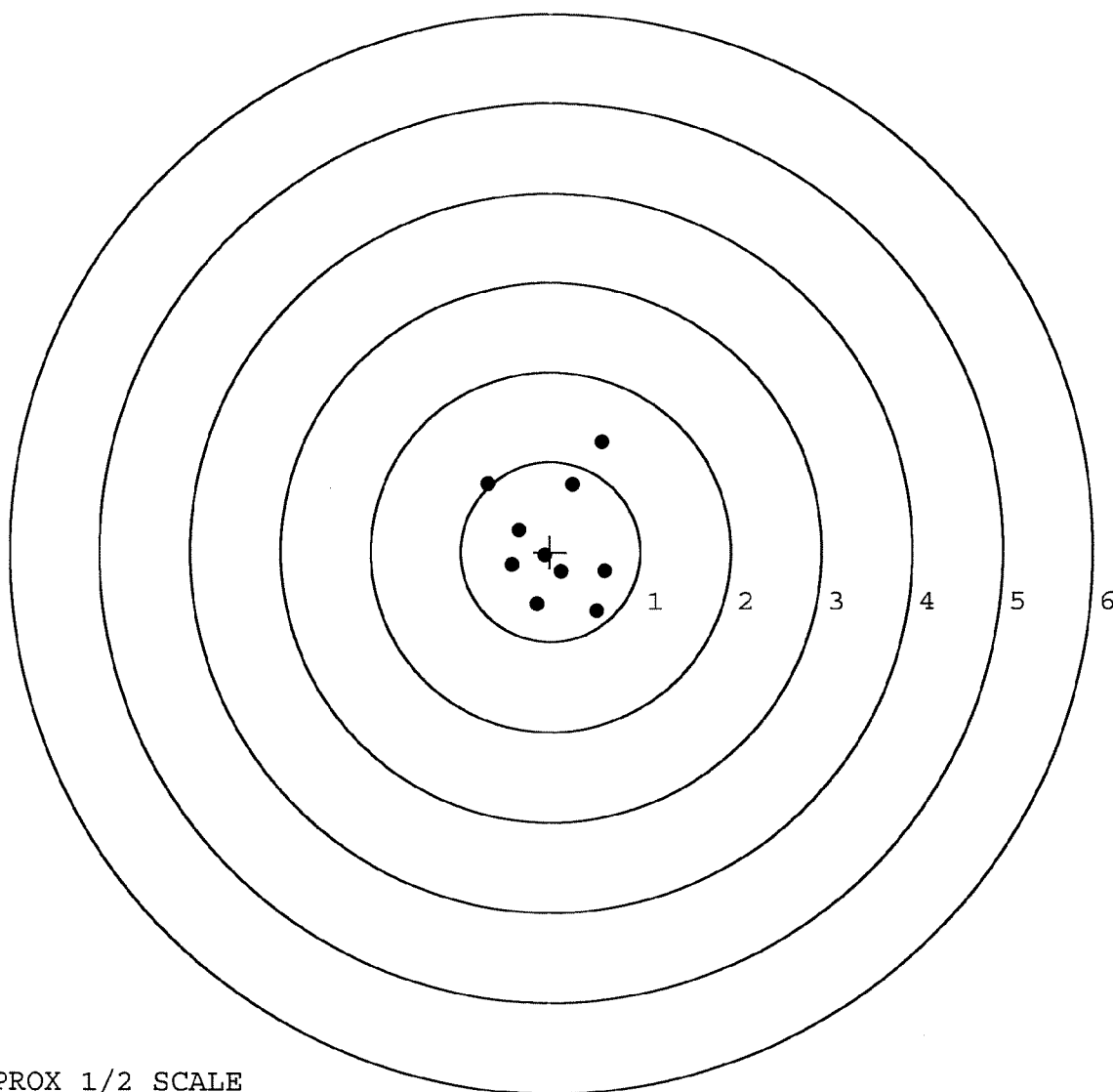
MAX RADIUS: 1.230

MEAN RADIUS: 0.665

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE