

G 6605480

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

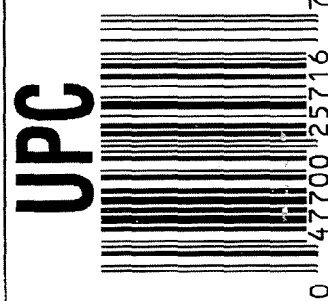


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6605480



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6605480

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-5-06	RTZ
420	ASSEMBLE ACTION		10-5-06	RTZ
430	ASSEMBLE TO STOCK		10-6-06	DK
440	PROOF		10-6-06	TRLW
460	CHECK HEADSPACE	INSPECTED	10-6-06	TRLW
470	DIS-ASSEMBLE ACTION	001 - 2006	10-6-06	RLC
480	MAGNAFLUX BBL ACTION	10/6/06	10/6/06	RLC
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-6-06	RP
510	DRILL AND TAP SIGHT HOLES		10-6-06	TRLW
520	GOFF BLAST BBL / REC		10-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/11/06	RLC
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/12/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/12/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/12/06	DA
	D) OIL FIRING PIN ASSEMBLY		10-19-06	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>6.0</u> <u>6.0</u> <u>7.0</u>	11-10-06	L.P.D.
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	11-10-06	L.P.D.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.028</u> <u>.027</u> <u>.027</u>	11-10-06	L.P.D.
	J) ASSEMBLE STOCK		10-19-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-18-06	BLG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-19-06	RP
	M) IRON SIGHT ALIGNMENT		10-19-06	RP
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-19-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-19-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/19/06	not
670	FINAL INSPECTION A) HEADSPACE		11-18-06	BLG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.40</u> <u>2.42</u> <u>2.41</u> <u>2.36</u> <u>2.38</u>	11-10-06	RP
	C) FUNCTION		11-18-06	BLG
690	PACK		12-8-06	RA

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 10-10-06

TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.33	2.11		2.20	
PULL #2	2.20	2.10		2.16	
PULL #3	2.24	2.09		2.23	
PULL #4	2.06	2.03		2.17	
PULL #5	2.17	2.07		2.20	
TOTAL	11.00	10.40		10.96	
AVERAGE	2.20	2.08		2.19	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.07		
PULL #2	3.12	3.05		
PULL #3	3.13	3.04		
PULL #4	3.08	3.08		
PULL #5	3.13	3.06		
TOTAL	15.58	15.30		
AVERAGE	3.11	3.06		

	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	4.35	4.37		4.59
PULL #2	4.38	4.38		4.48
PULL #3	4.42	4.44		4.56
PULL #4	4.35	4.32		4.45
PULL #5	4.35	4.41		4.51
TOTAL	21.85	21.92		22.59
AVERAGE	4.37	4.38		4.51

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6605480.__0

FILE DATE AND TIME: 10/23/2006 07:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

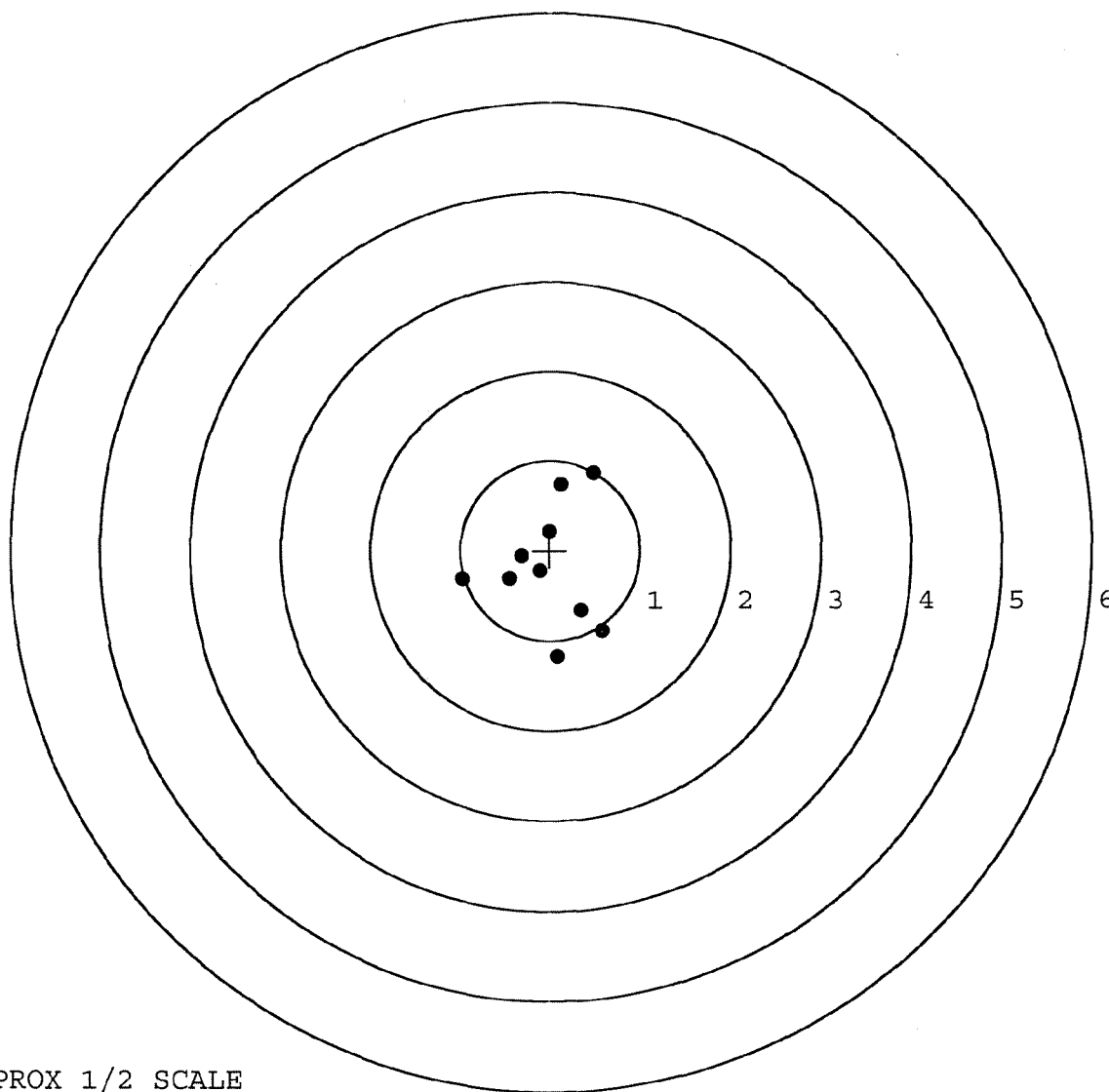
The Average X Centroid of the Five Target Set:	-0.065
The Average Y Centroid of the Five Target Set:	-0.053
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.743
The Distance from POA to Centroid Target #1:	0.187
The Distance from Centroid Target #2 to Centroid Target #1:	0.316
The Distance from Centroid Target #3 to Centroid Target #1:	0.252
The Distance from Centroid Target #4 to Centroid Target #1:	0.068
The Distance from Centroid Target #5 to Centroid Target #1:	0.075

SERIAL NUMBER: G6605480. __0
TARGET NUMBER: 1
FILE DATE: 10/23/2006
FILE TIME: 07:10

POINT#	X	Y
1:	0.489	0.863
2:	0.125	0.728
3:	-0.975	-0.320
4:	-0.448	-0.309
5:	-0.113	-0.228
6:	-0.315	-0.062
7:	-0.004	0.210
8:	0.348	-0.664
9:	0.581	-0.890
10:	0.093	-1.186

X CENTROID: -0.022
Y CENTROID: -0.186
POA TO CENTROID: 0.187
HORZ SPREAD: 1.556
VERT SPREAD: 2.049
GROUP SPREAD: 2.087
MIN RADIUS: 0.100
MAX RADIUS: 1.167
MEAN RADIUS: 0.685

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

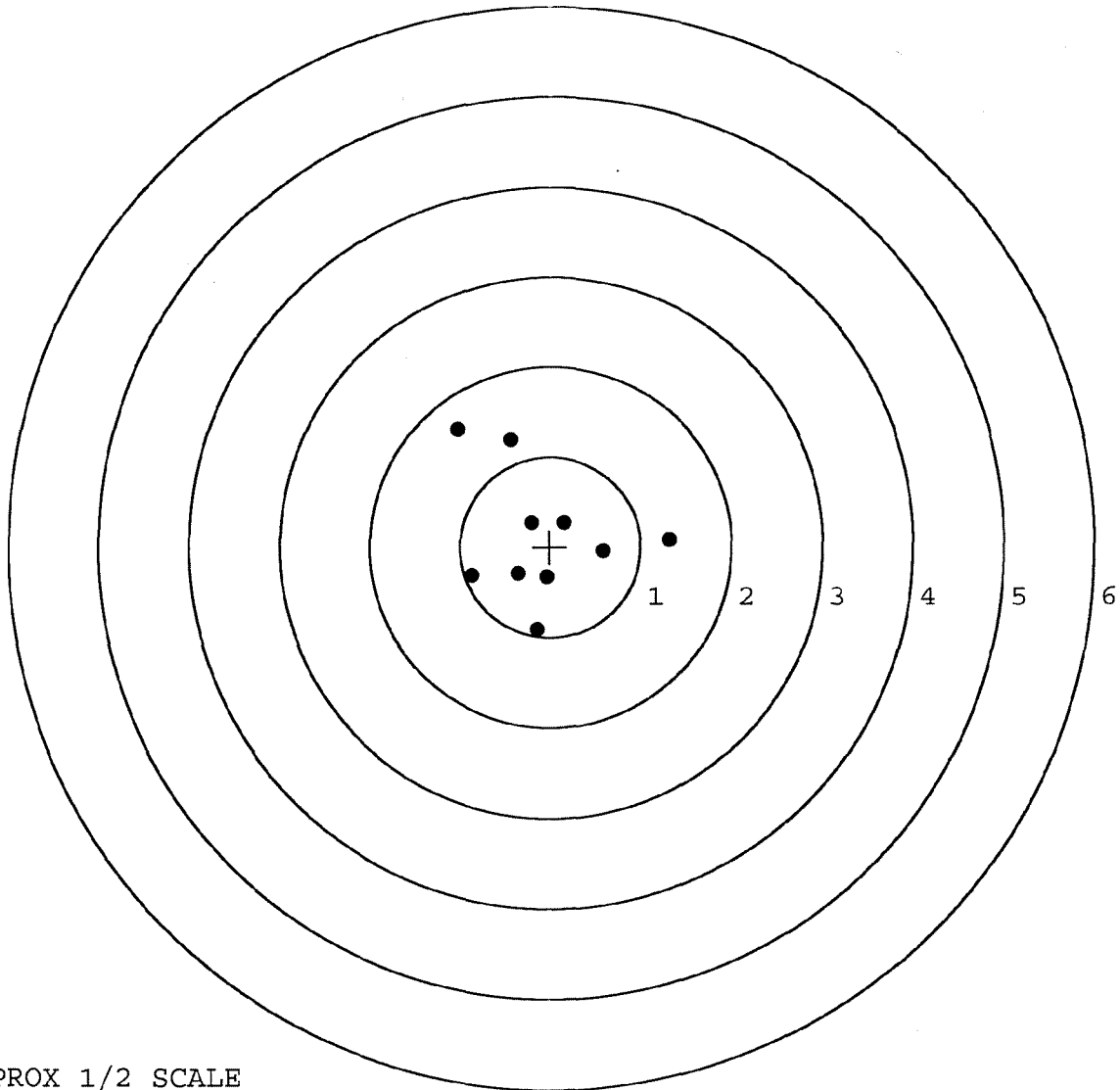


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605480. __0
TARGET NUMBER: 2
FILE DATE: 10/23/2006
FILE TIME: 07:10

POINT#	X	Y
1:	1.313	0.079
2:	0.595	-0.041
3:	-0.142	-0.923
4:	-0.434	1.193
5:	-1.029	1.298
6:	0.159	0.272
7:	-0.213	0.272
8:	-0.034	-0.339
9:	-0.355	-0.296
10:	-0.868	-0.314

X CENTROID: -0.101
Y CENTROID: 0.120
POA TO CENTROID: 0.157
HORZ SPREAD: 2.342
VERT SPREAD: 2.221
GROUP SPREAD: 2.640
MIN RADIUS: 0.189
MAX RADIUS: 1.500
MEAN RADIUS: 0.812
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

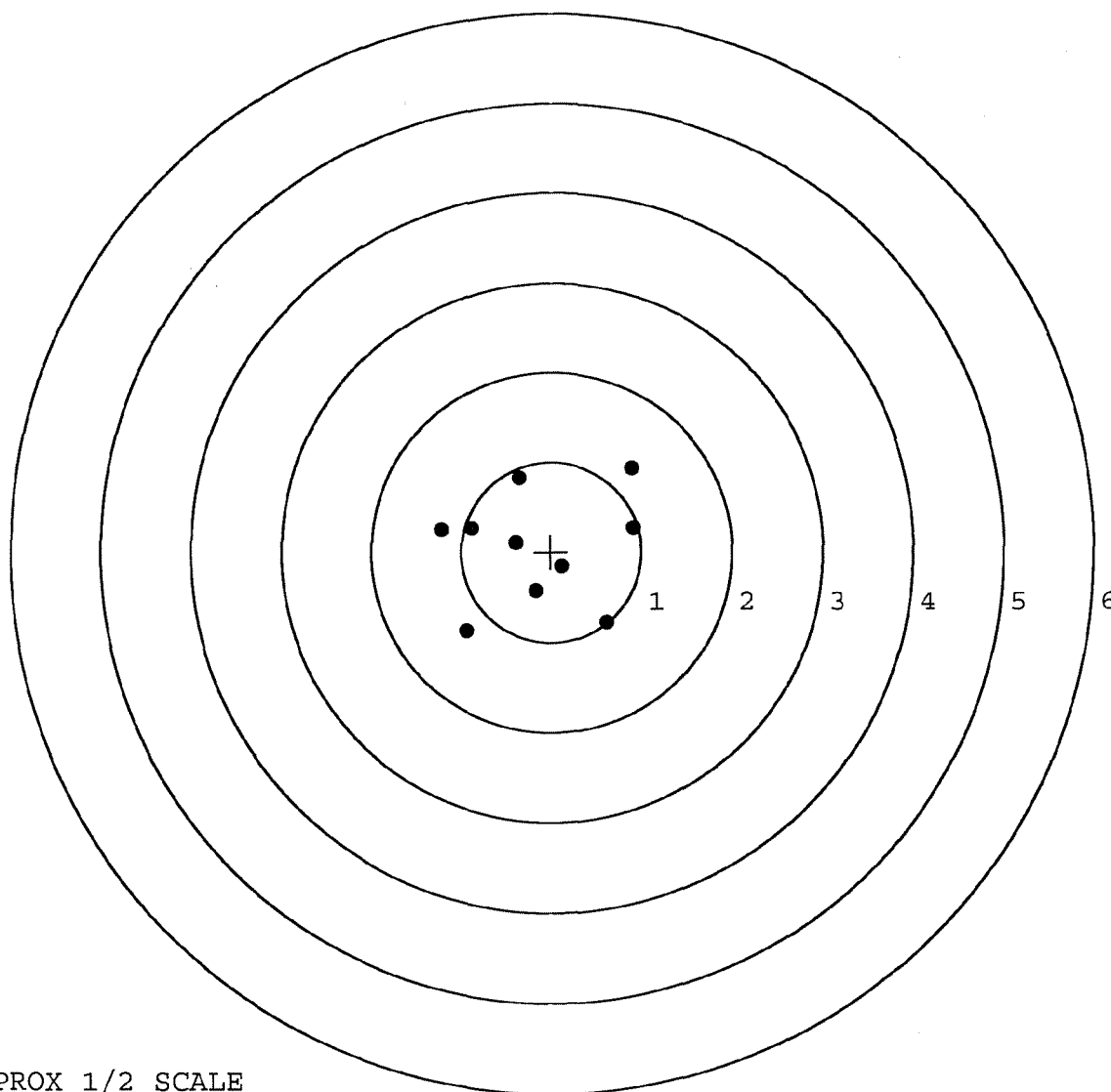


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605480. __0
TARGET NUMBER: 3
FILE DATE: 10/23/2006
FILE TIME: 07:10

POINT#	X	Y
1:	0.622	-0.786
2:	-0.941	-0.886
3:	-0.168	-0.438
4:	0.125	-0.166
5:	0.908	0.272
6:	0.900	0.927
7:	-0.359	0.824
8:	-0.399	0.102
9:	-0.887	0.266
10:	-1.225	0.243

X CENTROID: -0.142
Y CENTROID: 0.036
POA TO CENTROID: 0.147
HORZ SPREAD: 2.133
VERT SPREAD: 1.813
GROUP SPREAD: 2.584
MIN RADIUS: 0.265
MAX RADIUS: 1.371
MEAN RADIUS: 0.856
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605480. __0

TARGET NUMBER: 4

FILE DATE: 10/23/2006

FILE TIME: 07:10

POINT#	X	Y
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1:	1.393	-0.279
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2:	0.457	0.355
----	-------	-------

3:	-0.187	0.183
----	--------	-------

4:	-0.967	0.079
----	--------	-------

5:	-0.675	0.585
----	--------	-------

6:	-0.946	-0.703
----	--------	--------

7:	0.318	-0.268
----	-------	--------

8:	0.082	-0.292
----	-------	--------

9:	0.284	-0.422
----	-------	--------

10:	0.119	-0.418
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X CENTROID: -0.012

Y CENTROID: -0.118

POA TO CENTROID: 0.119

HORZ SPREAD: 2.360

VERT SPREAD: 1.288

GROUP SPREAD: 2.387

MIN RADIUS: 0.198

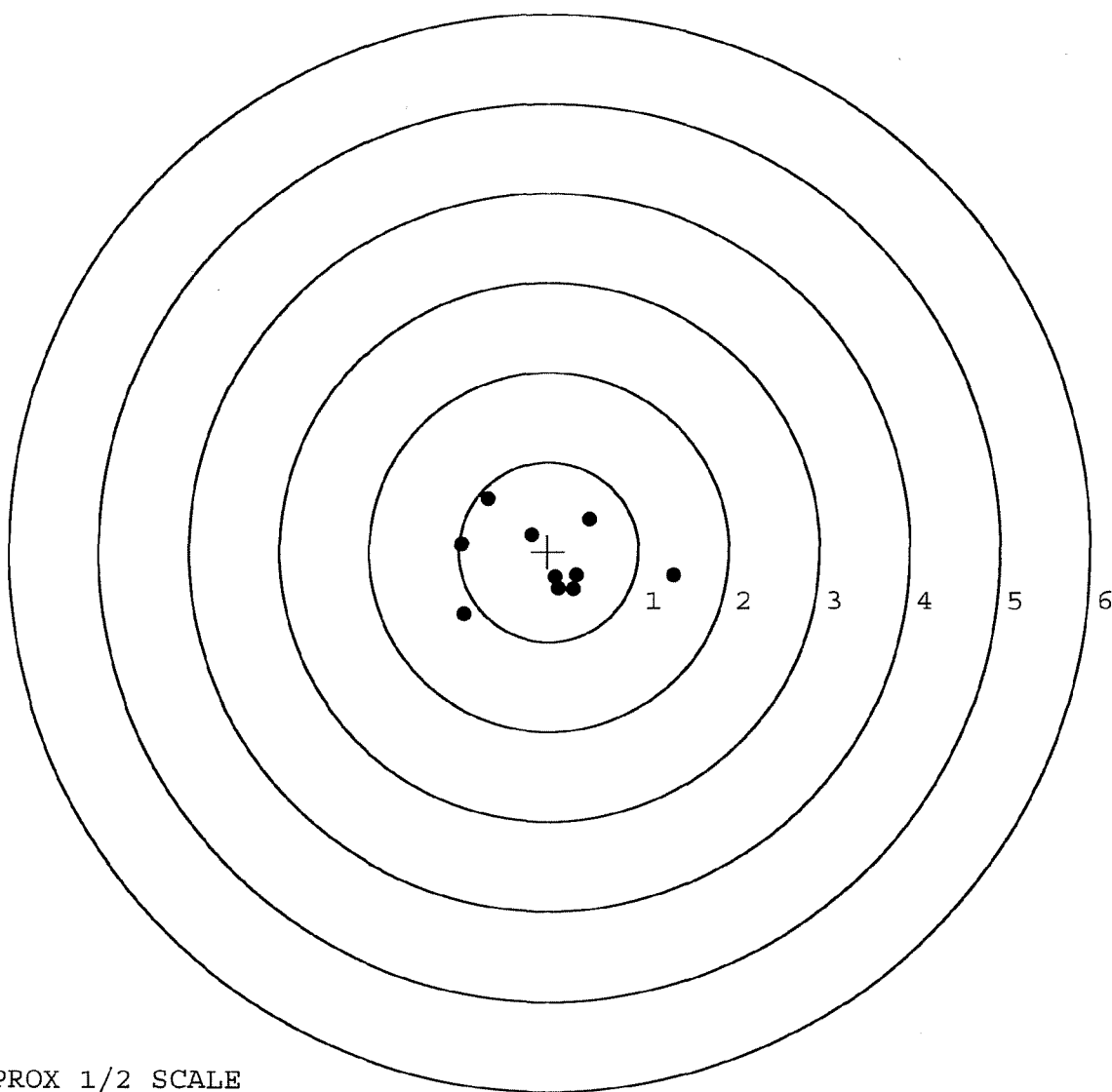
MAX RADIUS: 1.414

MEAN RADIUS: 0.678

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6605480. 0

TARGET NUMBER: 5

FILE DATE: 10/23/2006

FILE TIME: 07:10

POINT#	X	Y
1:	-1.349	-1.300
2:	-0.436	-0.808
3:	-0.693	-0.098
4:	0.849	0.037
5:	0.659	0.673
6:	0.025	0.296
7:	0.268	0.147
8:	0.250	-0.023
9:	-0.256	-0.157
10:	0.182	0.065

X CENTROID: -0.050

Y CENTROID: -0.117

POA TO CENTROID: 0.127

HORZ SPREAD: 2.198

VERT SPREAD: 1.973

GROUP SPREAD: 2.815

MIN RADIUS: 0.210

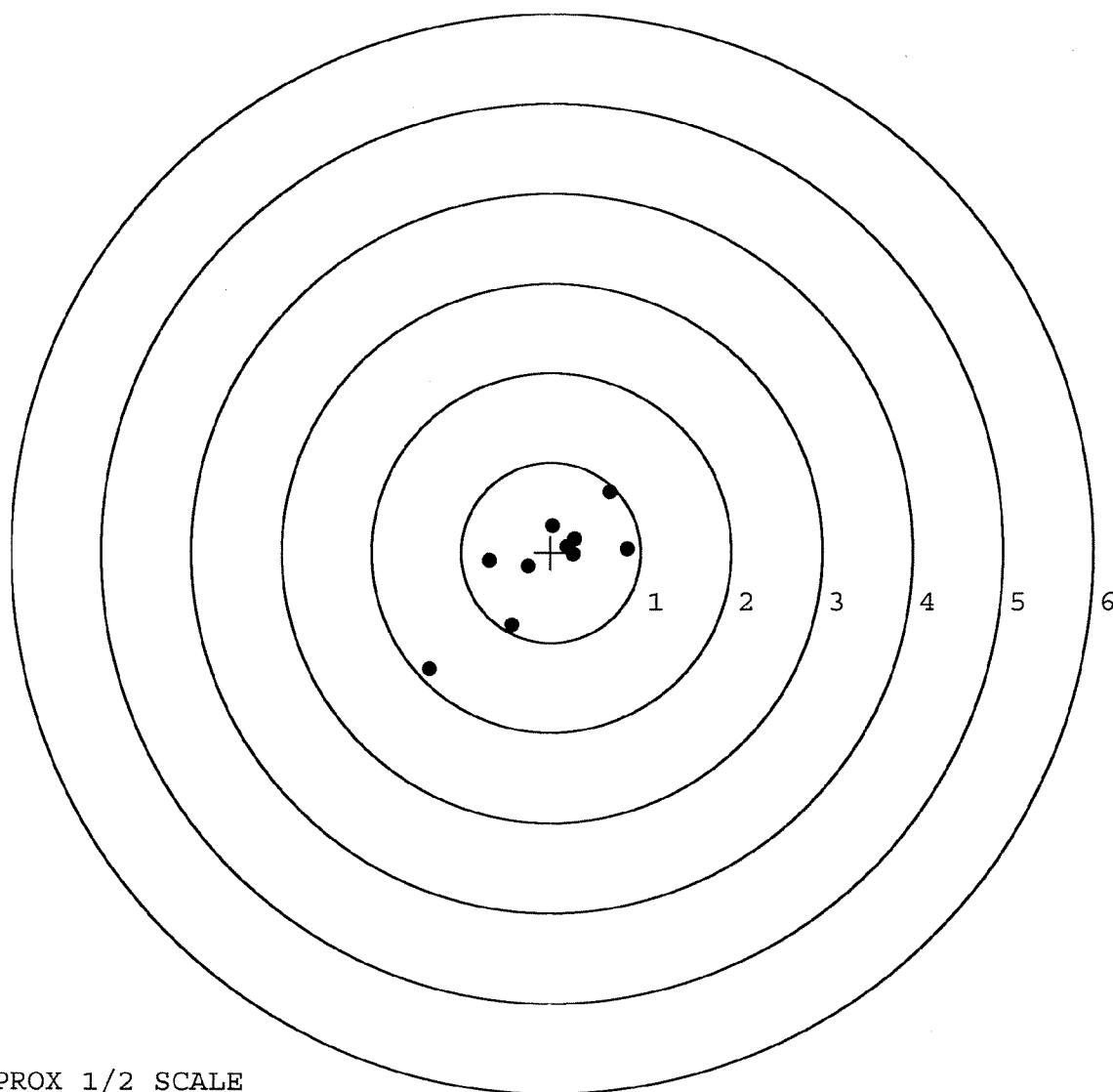
MAX RADIUS: 1.757

MEAN RADIUS: 0.682

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE