

G 6416213

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC



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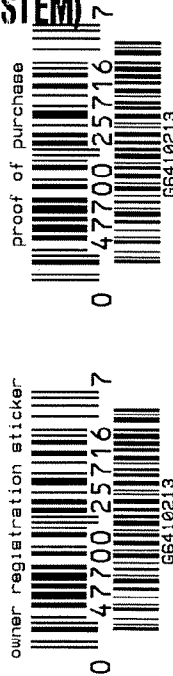
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

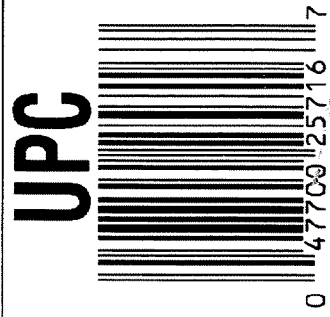


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6410213



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6410213

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTZ
600	PROOF		12-29-04	K
607	CHECK HEADSPACE		12-29-04	AC
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-13-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-13-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-14-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-14-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.5</u> <u>6.0</u>	1-22-05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.2</u>	1-22-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.022</u> <u>1.022</u> <u>1.023</u>	1-22-05	DA
	J) ASSEMBLE STOCK		1-14-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-24-05	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT	NA		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	1-17-05	DA
	MALFUNCTION <i>Feeds Hard</i>	CORRECTION <i>OK</i>	1-21-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-17-05	DA
655	FINAL INSPECTION A) HEADSPACE		1-24-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.31</u> <u>2.38</u> <u>2.22</u> <u>2.38</u>	1-22-05	DA
	C) FUNCTION		1-24-05	RT
660	PACK		1-24-05	DA

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)

SERIAL NO.

DATE 10-23-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.17		2.19	
PULL #2	2.31	2.47		2.11	
PULL #3	2.25	2.32		2.13	
PULL #4	2.33	2.21		2.24	
PULL #5	2.53	2.30		2.04	
TOTAL	11.73	11.47		10.71	
AVERAGE	2.34	2.29		2.14	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.31		
PULL #2	3.21	3.35		
PULL #3	3.24	3.34		
PULL #4	3.31	3.30		
PULL #5	3.31	3.41		
TOTAL	16.26	16.71		
AVERAGE	3.25	3.34		

	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	4.09	4.26		4.38
PULL #2	4.25	4.57		4.37
PULL #3	4.14	4.40		4.44
PULL #4	4.33	4.40		4.45
PULL #5	4.36	4.09		4.57
TOTAL	21.17	21.72		22.21
AVERAGE	4.23	4.34		4.44

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410213.__1

FILE DATE AND TIME: 09/26/2005 10:21

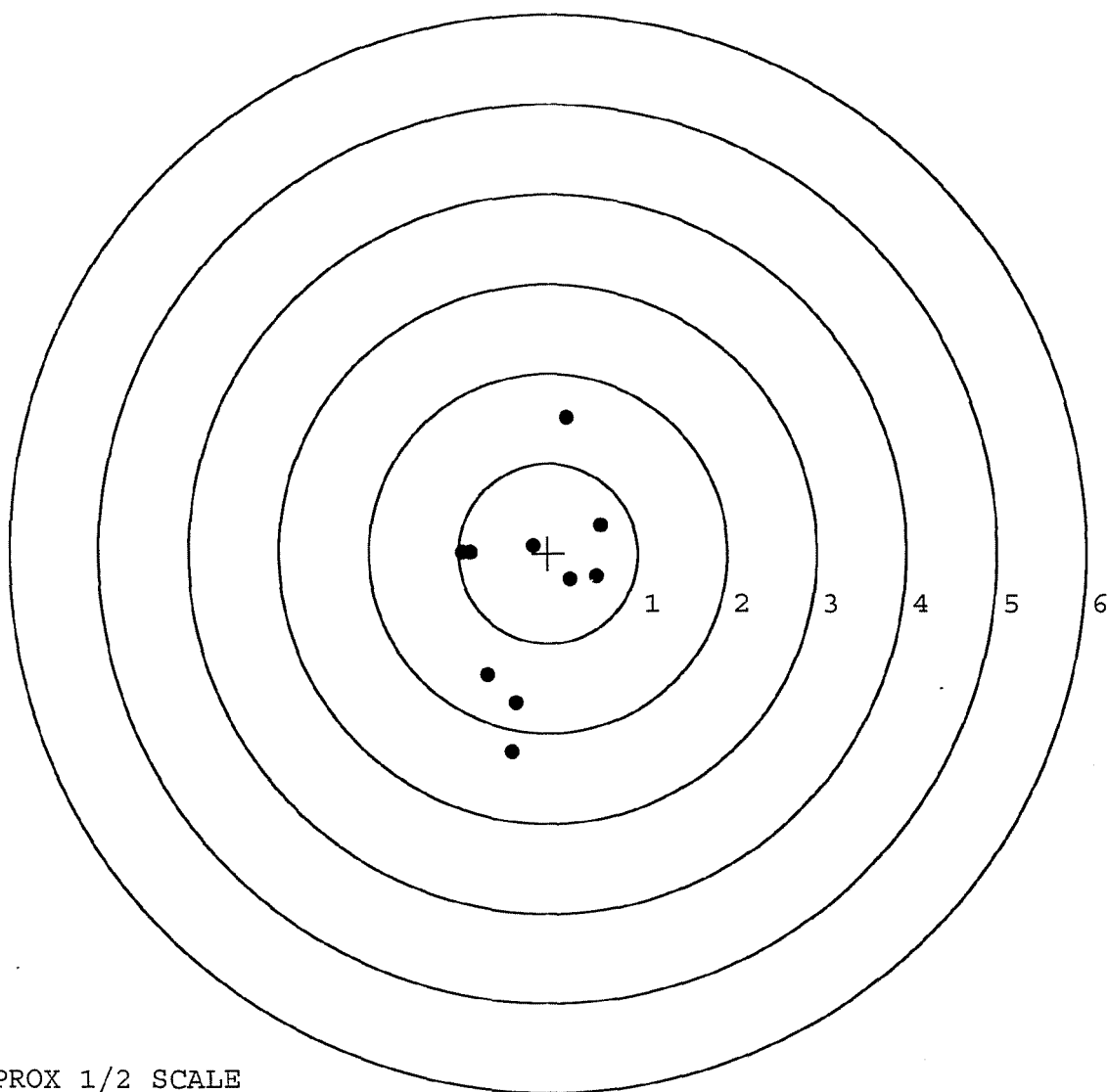
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.156
The Average Y Centroid of the Five Target Set:	-0.061
The Average Point of Impact of the Five Target Set:	0.168
The Average Mean Radius of the Five Target Set:	1.086
The Distance from POA to Centroid Target #1:	0.431
The Distance from Centroid Target #2 to Centroid Target #1:	0.346
The Distance from Centroid Target #3 to Centroid Target #1:	0.404
The Distance from Centroid Target #4 to Centroid Target #1:	0.548
The Distance from Centroid Target #5 to Centroid Target #1:	0.370

SERIAL NUMBER: G6410213. __1
TARGET NUMBER: 1
FILE DATE: 09/26/2005
FILE TIME: 10:21

POINT#	X	Y
1:	-0.399	-2.216
2:	-0.355	-1.672
3:	-0.673	-1.365
4:	0.542	-0.257
5:	0.248	-0.292
6:	0.586	0.315
7:	-0.167	0.084
8:	-0.870	0.000
9:	-0.956	-0.001
10:	0.203	1.511

X CENTROID: -0.184
Y CENTROID: -0.389
POA TO CENTROID: 0.431
HORZ SPREAD: 1.542
VERT SPREAD: 3.727
GROUP SPREAD: 3.775
MIN RADIUS: 0.443
MAX RADIUS: 1.939
MEAN RADIUS: 1.051
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

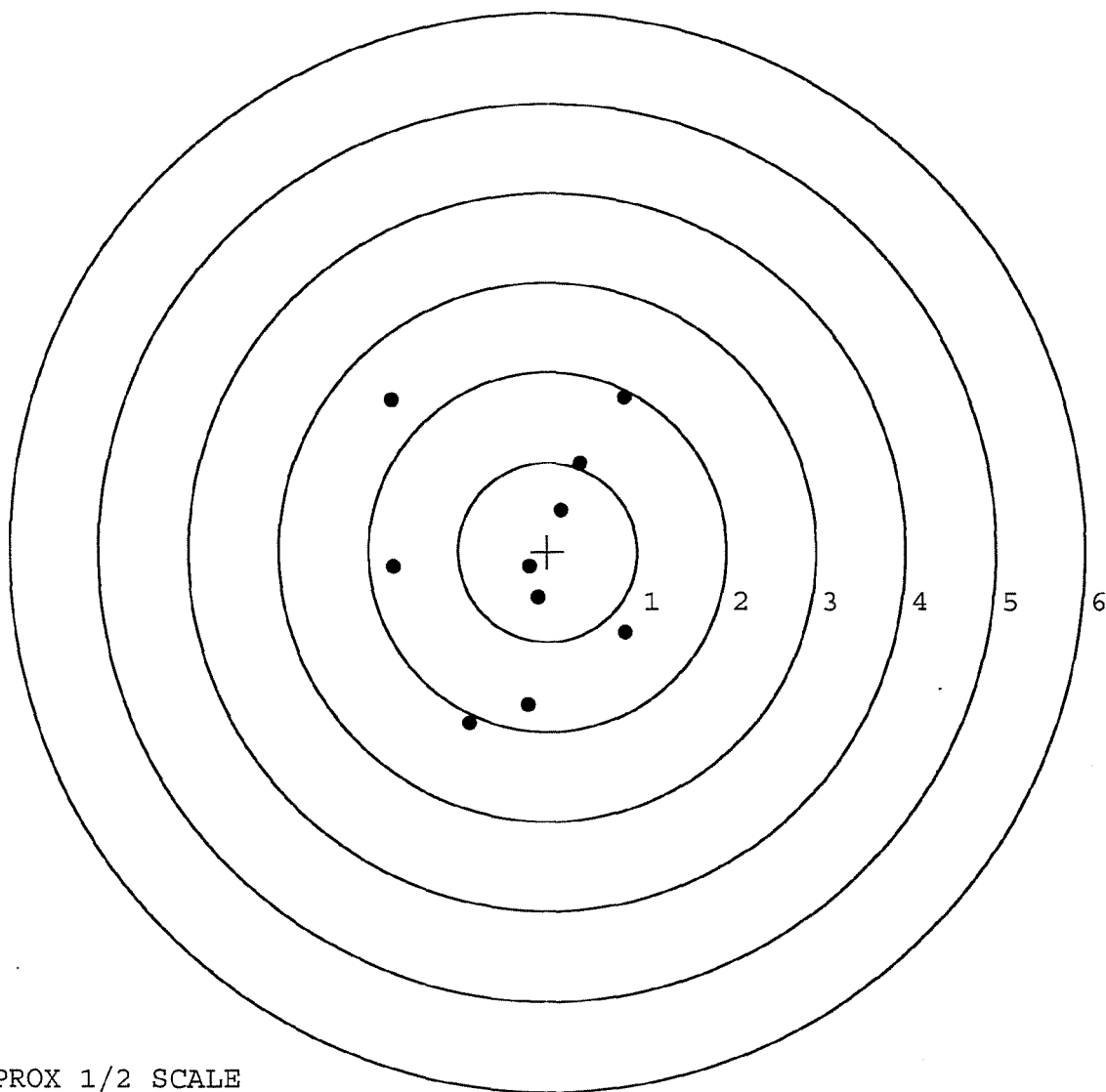


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410213. __1
TARGET NUMBER: 2
FILE DATE: 09/26/2005
FILE TIME: 10:21

POINT#	X	Y
1:	0.870	-0.895
2:	-0.102	-0.519
3:	-0.216	-1.711
4:	-0.864	-1.914
5:	-0.202	-0.167
6:	-1.722	-0.181
7:	0.151	0.472
8:	0.365	0.990
9:	0.859	1.720
10:	-1.743	1.686

X CENTROID: -0.260
Y CENTROID: -0.052
POA TO CENTROID: 0.266
HORZ SPREAD: 2.613
VERT SPREAD: 3.634
GROUP SPREAD: 3.724
MIN RADIUS: 0.129
MAX RADIUS: 2.284
MEAN RADIUS: 1.338
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 6

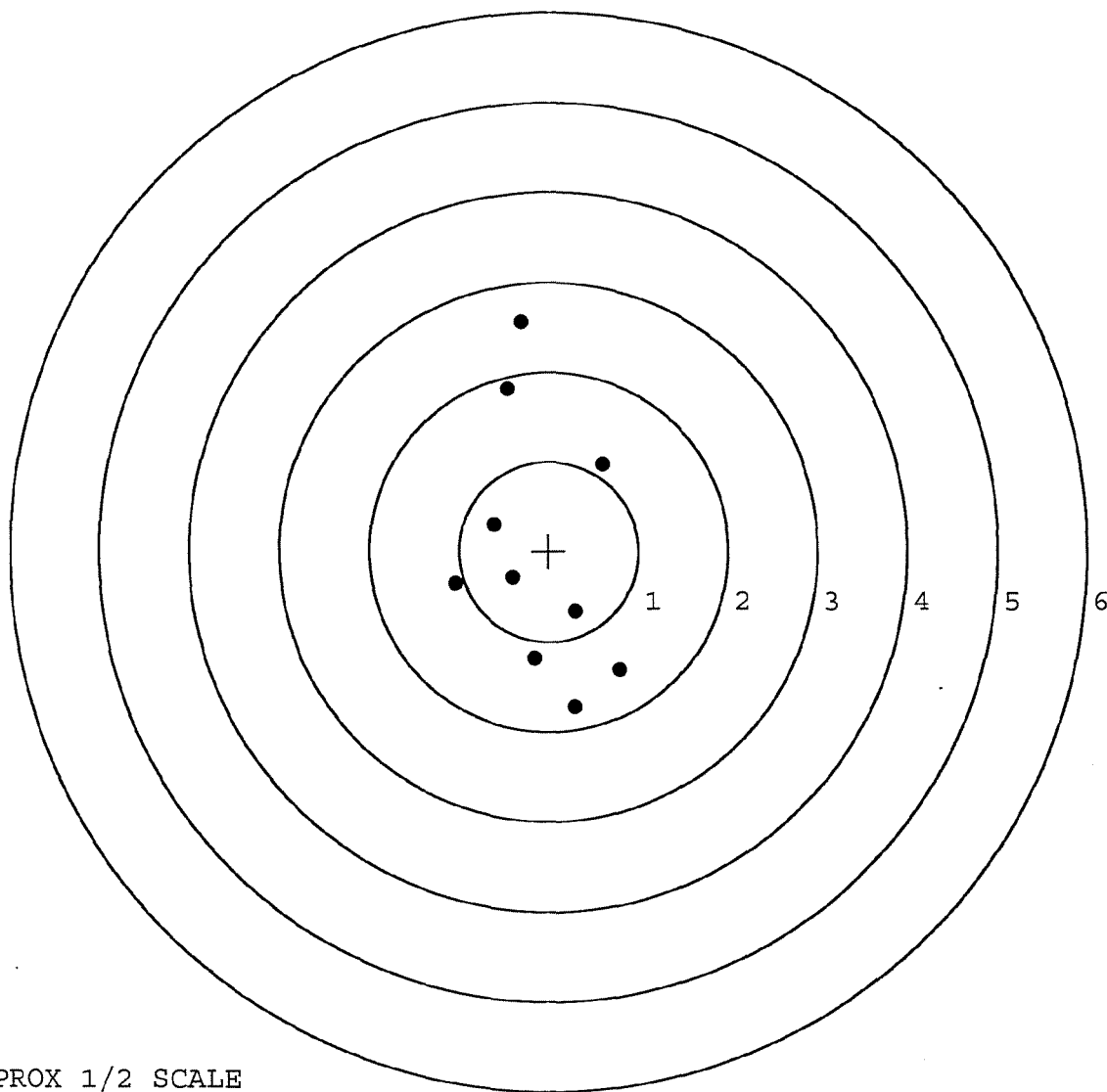


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410213. __1
 TARGET NUMBER: 3
 FILE DATE: 09/26/2005
 FILE TIME: 10:21

X CENTROID: -0.101
 Y CENTROID: 0.006
 POA TO CENTROID: 0.101
 HORZ SPREAD: 1.843
 VERT SPREAD: 4.289
 GROUP SPREAD: 4.332
 MIN RADIUS: 0.427
 MAX RADIUS: 2.563
 MEAN RADIUS: 1.299
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 3
 # in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.800	-1.311
2:	-0.154	-1.191
3:	0.301	-0.673
4:	-0.402	-0.296
5:	-1.043	-0.372
6:	-0.616	0.295
7:	0.602	0.969
8:	-0.472	1.810
9:	-0.316	2.560
10:	0.294	-1.729



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410213. __1

TARGET NUMBER: 4

FILE DATE: 09/26/2005

FILE TIME: 10:21

POINT#	X	Y
1:	-0.234	-1.457
2:	-0.079	-1.116
3:	-0.245	-0.513
4:	-1.358	0.794
5:	0.194	1.378
6:	0.156	0.945
7:	-0.123	0.632
8:	0.254	0.453
9:	0.244	0.312
10:	0.290	0.075

X CENTROID: -0.090

Y CENTROID: 0.150

POA TO CENTROID: 0.175

HORZ SPREAD: 1.648

VERT SPREAD: 2.835

GROUP SPREAD: 2.867

MIN RADIUS: 0.371

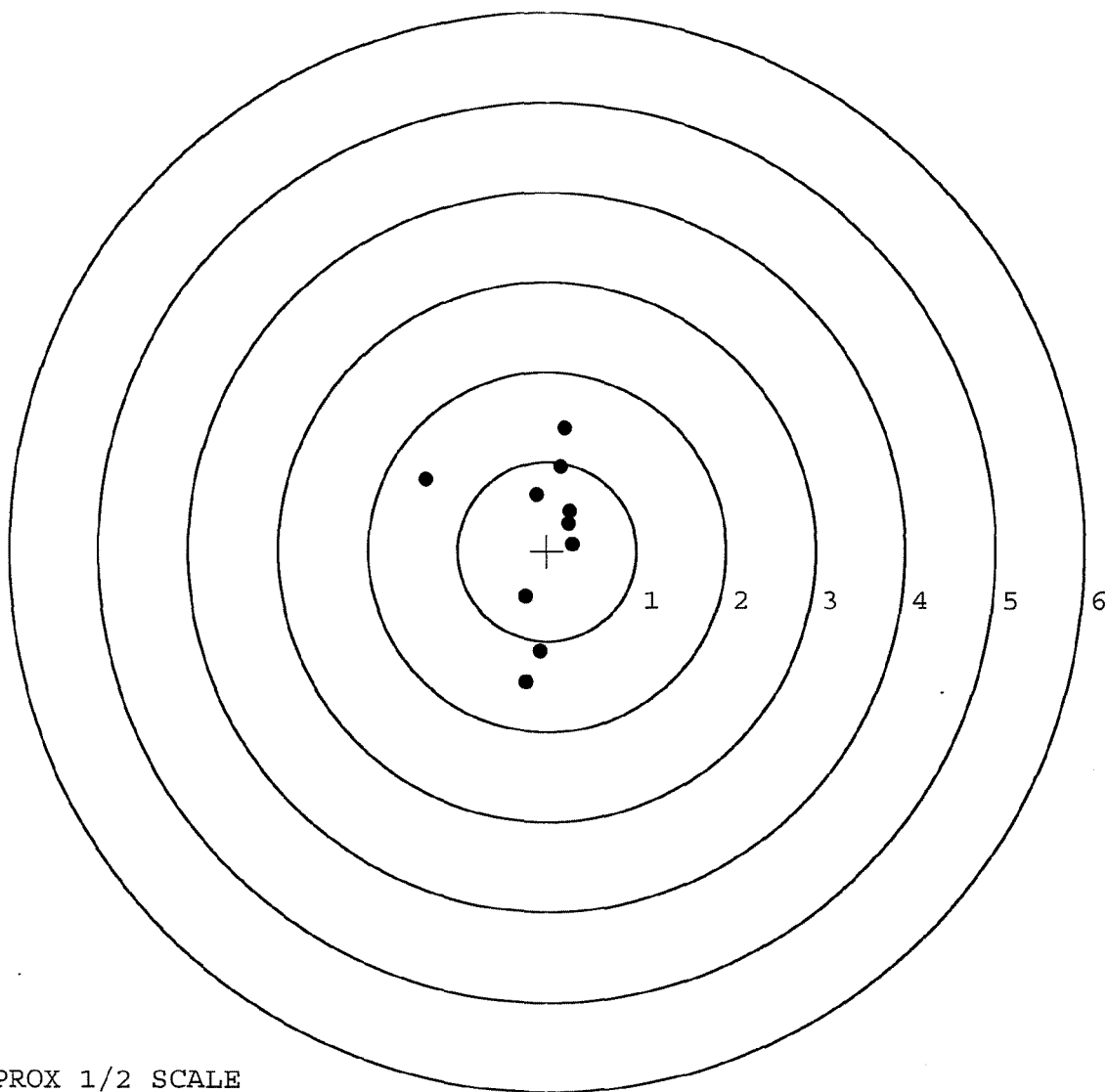
MAX RADIUS: 1.614

MEAN RADIUS: 0.878

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

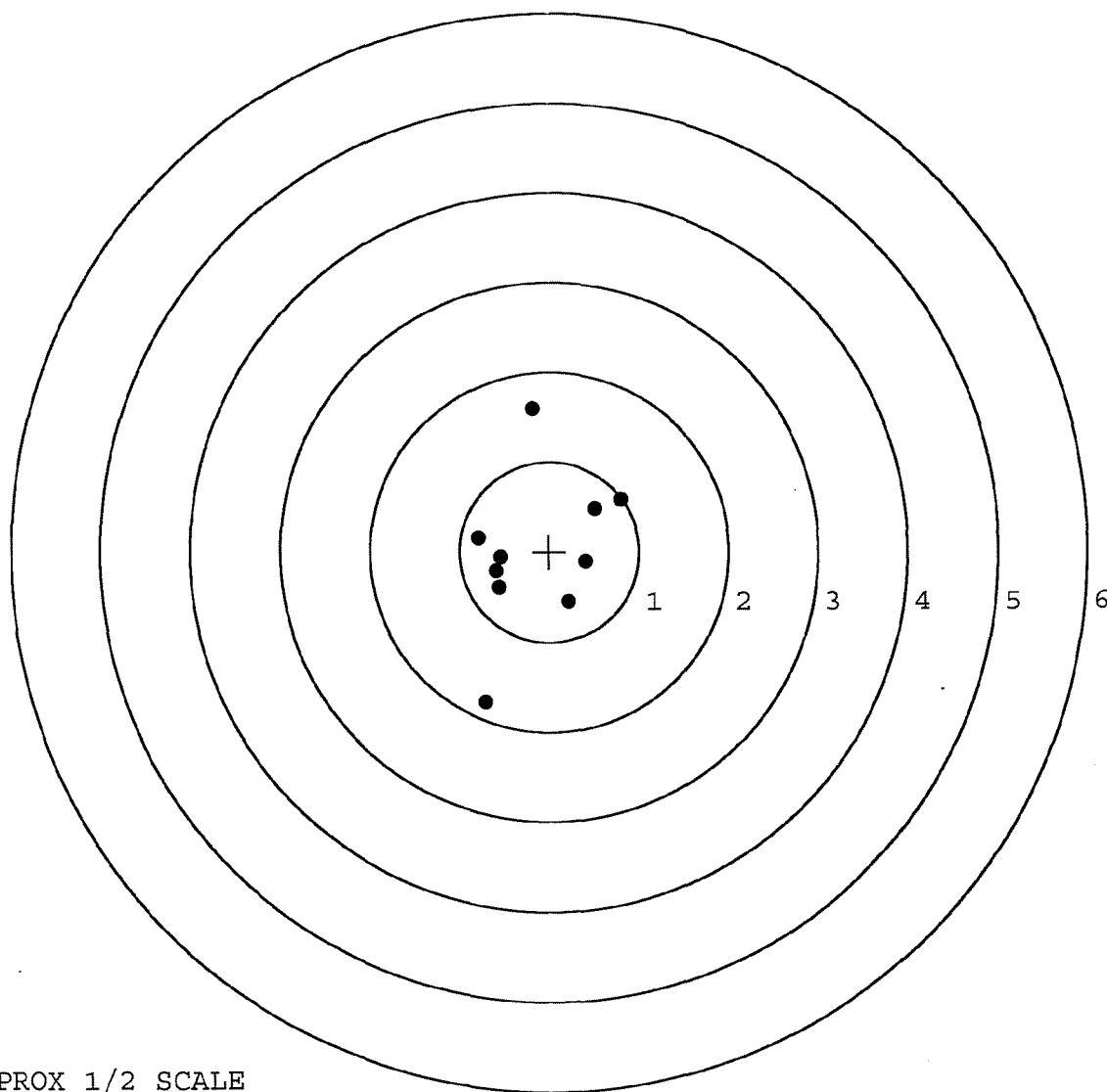


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410213. __1
TARGET NUMBER: 5
FILE DATE: 09/26/2005
FILE TIME: 10:21

X CENTROID: -0.146
Y CENTROID: -0.021
POA TO CENTROID: 0.148
HORZ SPREAD: 1.588
VERT SPREAD: 3.258
GROUP SPREAD: 3.300
MIN RADIUS: 0.398
MAX RADIUS: 1.742
MEAN RADIUS: 0.862
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.800	0.575
2:	0.508	0.474
3:	0.408	-0.108
4:	0.214	-0.557
5:	-0.562	-0.398
6:	-0.542	-0.063
7:	-0.788	0.159
8:	-0.189	1.590
9:	-0.715	-1.668
10:	-0.598	-0.217



TARGET APPROX 1/2 SCALE