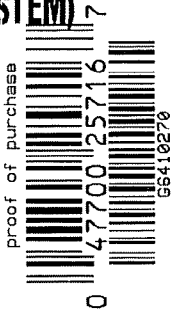


G-6410270

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

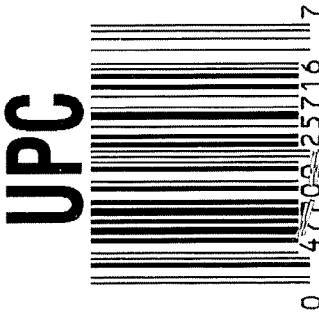
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6410270



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

UPC



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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410270

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTZ
600	PROOF		12-29-04	R
607	CHECK HEADSPACE		12-29-04	R
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	TRLW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-13-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-13-05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-14-05	RR
	D) OIL FIRING PIN ASSEMBLY		1-14-05	RR
	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>5.5</u> <u>5.5</u> <u>5.5</u>	1-19-05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.9</u> <u>3.9</u> <u>3.9</u>	1-19-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.025</u>	1-19-05	DA
	J) ASSEMBLE STOCK		1-14-05	RTL
	K) ASSEMBLE SWIVEL STUDS		1-19-05	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	NA		
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	1-18-05	A
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION NA		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-18-05	A
655	FINAL INSPECTION A) HEADSPACE		1-19-05	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.24</u> <u>2.23</u> <u>2.20</u> <u>2.20</u> <u>2.17</u>	1-19-05	DA
	C) FUNCTION		1-19-05	RTL
660	PACK		1-20-05	DA

AVERAGE SET FORCE
 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 10-23-04
 TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.41	2.53		2.13	
PULL #2	2.54	2.60		2.11	
PULL #3	2.60	2.60		2.10	
PULL #4	2.78	2.53		2.18	
PULL #5	2.70	2.48		2.15	
TOTAL	13.03	12.74		10.67	
AVERAGE	2.60	2.54		2.13	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.20		
PULL #2	3.37	3.21		
PULL #3	3.09	3.35		
PULL #4	3.32	3.19		
PULL #5	3.28	3.19		
TOTAL	16.38	16.14		
AVERAGE	3.27	3.22		

	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	4.09		3.94
PULL #2	4.39	4.15		3.93
PULL #3	4.30	4.21		3.95
PULL #4	4.44	4.17		4.04
PULL #5	4.35	4.22		4.04
TOTAL	21.83	20.84		19.90
AVERAGE	4.36	4.16		3.98

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410270.___1

FILE DATE AND TIME: 10/07/2005 08:18

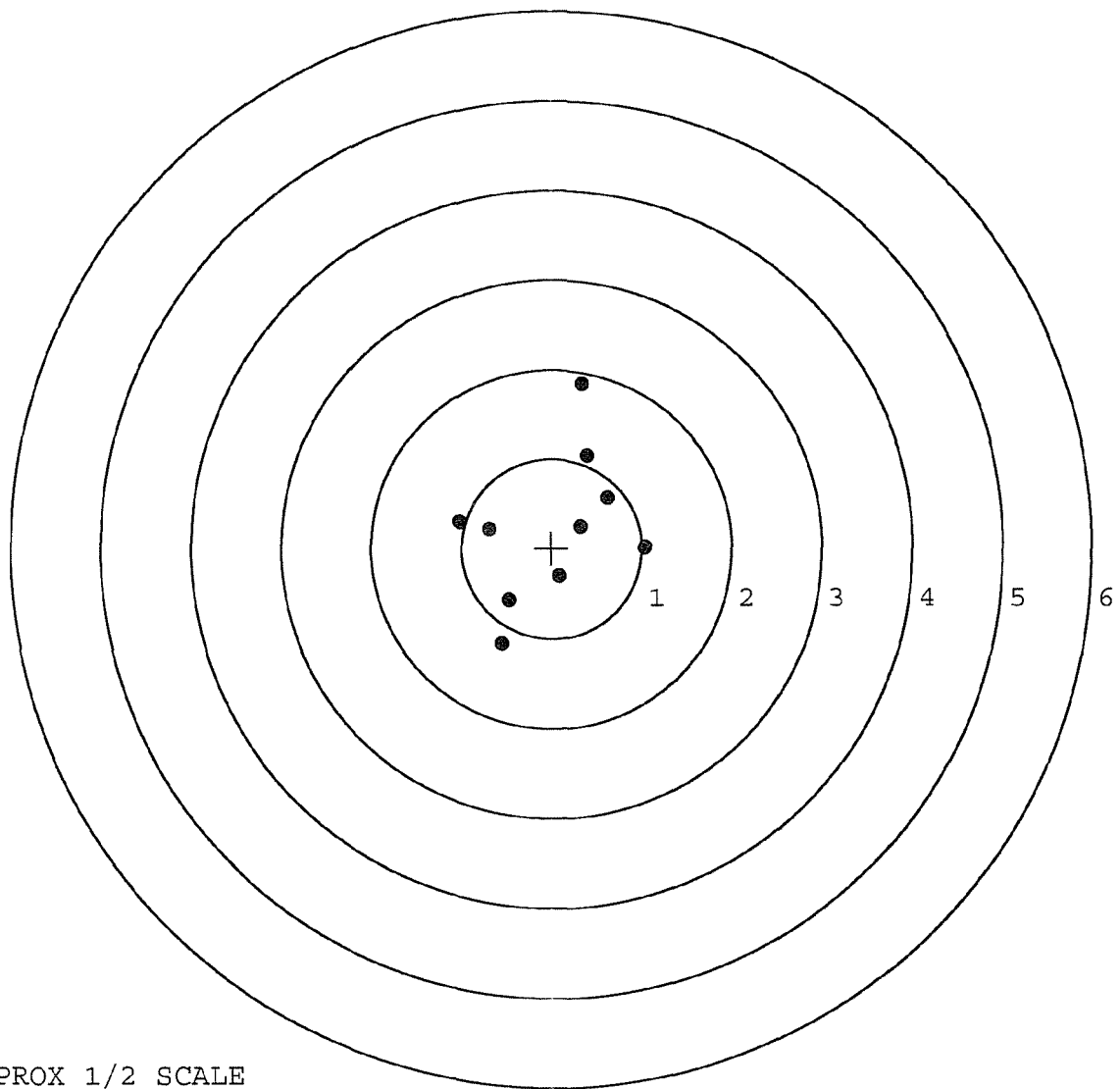
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.033
The Average Y Centroid of the Five Target Set:	-0.157
The Average Point of Impact of the Five Target Set:	0.160
The Average Mean Radius of the Five Target Set:	0.847
The Distance from POA to Centroid Target #1:	0.223
The Distance from Centroid Target #2 to Centroid Target #1:	0.632
The Distance from Centroid Target #3 to Centroid Target #1:	0.394
The Distance from Centroid Target #4 to Centroid Target #1:	0.464
The Distance from Centroid Target #5 to Centroid Target #1:	0.448

SERIAL NUMBER: G6410270. __1
TARGET NUMBER: 1
FILE DATE: 10/07/2005
FILE TIME: 08:18

X CENTROID: 0.005
Y CENTROID: 0.223
POA TO CENTROID: 0.223
HORZ SPREAD: 2.056
VERT SPREAD: 2.907
GROUP SPREAD: 3.041
MIN RADIUS: 0.312
MAX RADIUS: 1.652
MEAN RADIUS: 0.925
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.036	0.008
2:	0.624	0.564
3:	0.317	0.241
4:	0.400	1.040
5:	0.336	1.842
6:	0.088	-0.315
7:	-0.696	0.212
8:	-1.020	0.287
9:	-0.474	-0.584
10:	-0.558	-1.065

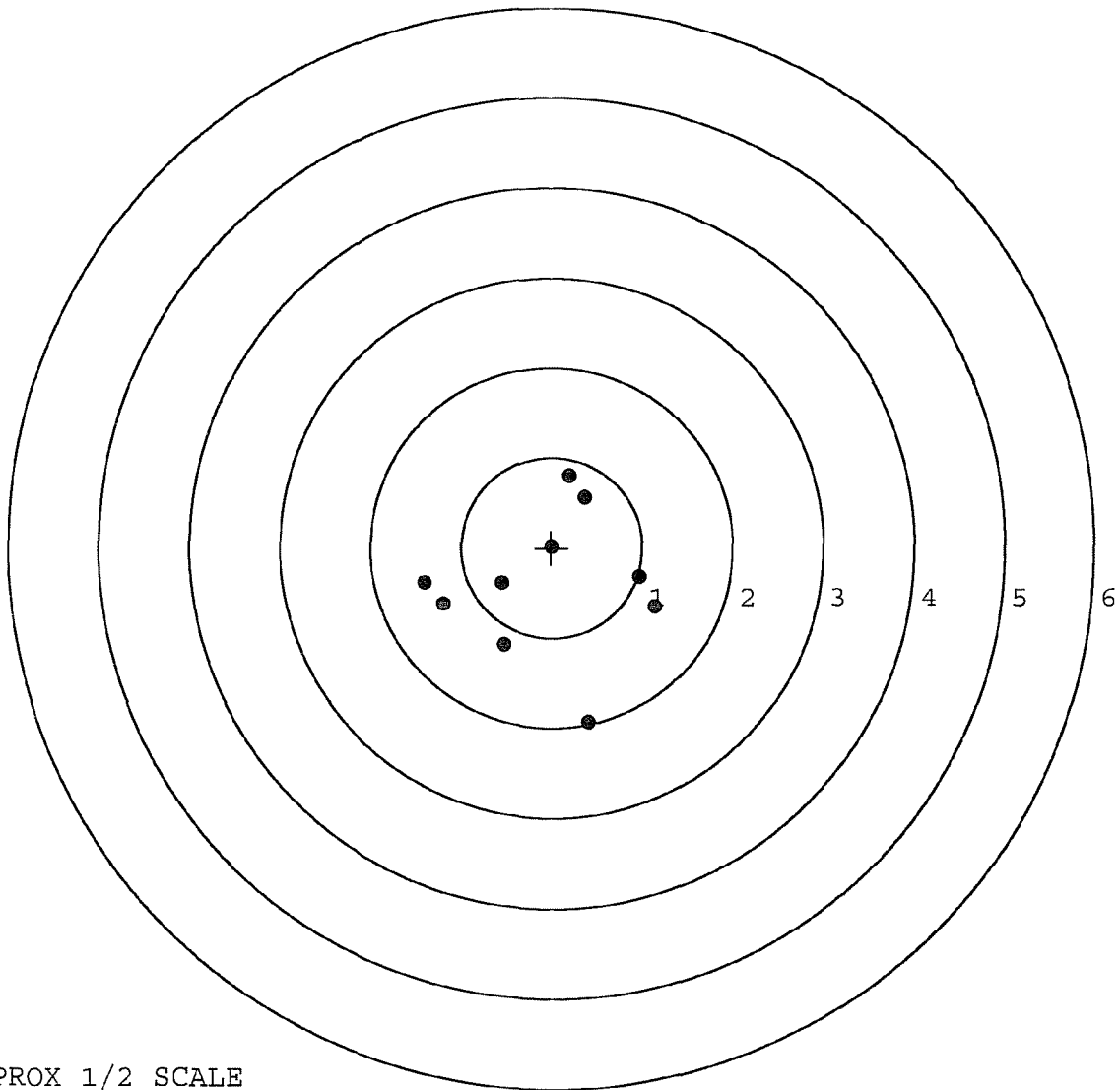


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410270. __1
TARGET NUMBER: 2
FILE DATE: 10/07/2005
FILE TIME: 08:18

POINT#	X	Y
1:	1.139	-0.654
2:	0.971	-0.322
3:	0.001	0.016
4:	-0.550	-0.395
5:	-0.527	-1.083
6:	0.413	-1.941
7:	-1.195	-0.633
8:	-1.404	-0.396
9:	0.362	0.559
10:	0.194	0.795

X CENTROID: -0.060
Y CENTROID: -0.405
POA TO CENTROID: 0.410
HORZ SPREAD: 2.543
VERT SPREAD: 2.736
GROUP SPREAD: 2.745
MIN RADIUS: 0.426
MAX RADIUS: 1.607
MEAN RADIUS: 1.039
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 9

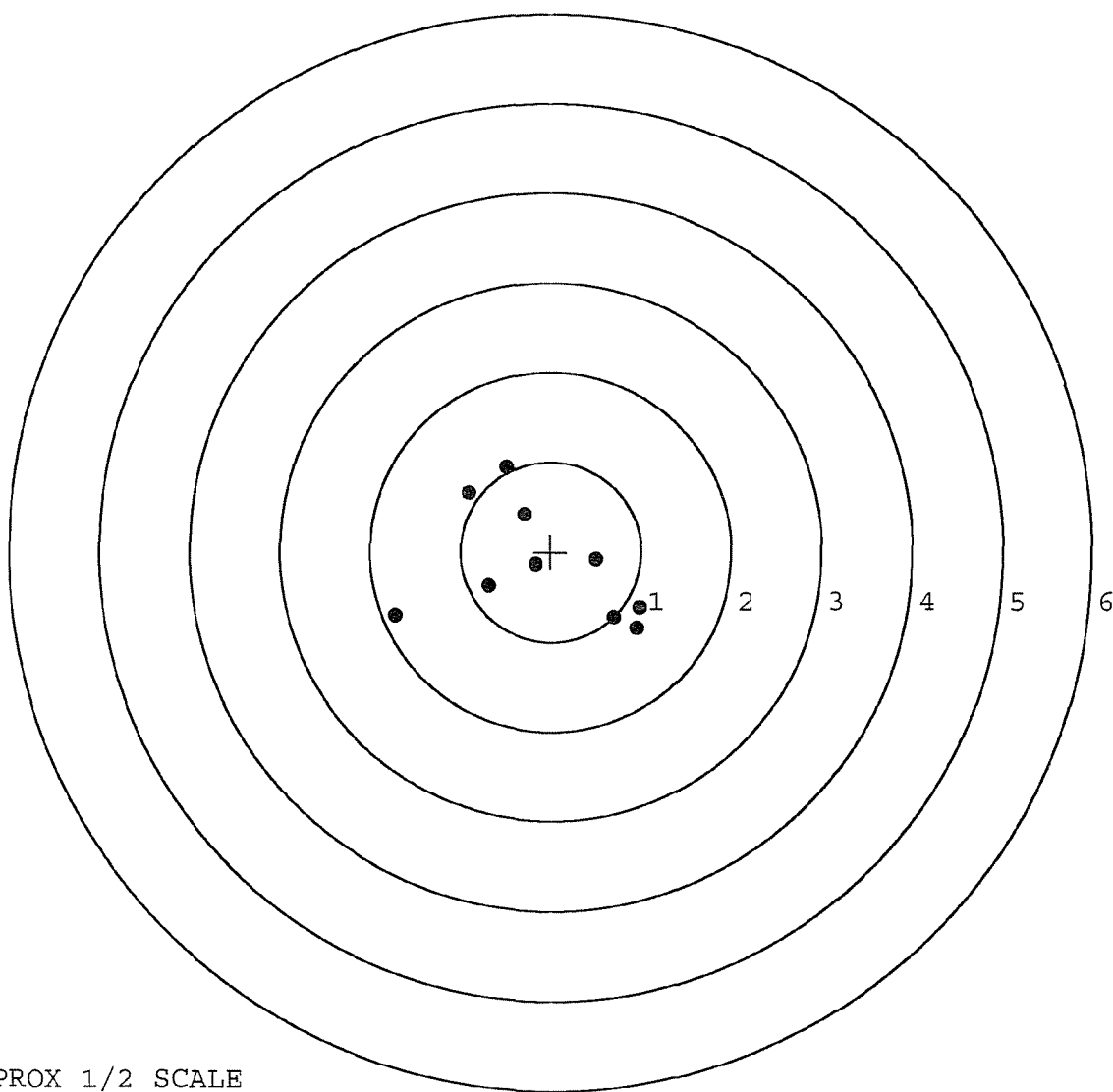


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410270. __1
TARGET NUMBER: 3
FILE DATE: 10/07/2005
FILE TIME: 08:18

X CENTROID: -0.115
Y CENTROID: -0.153
POA TO CENTROID: 0.191
HORZ SPREAD: 2.704
VERT SPREAD: 1.790
GROUP SPREAD: 2.706
MIN RADIUS: 0.059
MAX RADIUS: 1.705
MEAN RADIUS: 0.934
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.948	-0.852
2:	0.981	-0.621
3:	0.695	-0.727
4:	0.505	-0.083
5:	-0.173	-0.142
6:	-0.688	-0.387
7:	-1.723	-0.718
8:	-0.295	0.414
9:	-0.907	0.651
10:	-0.491	0.938

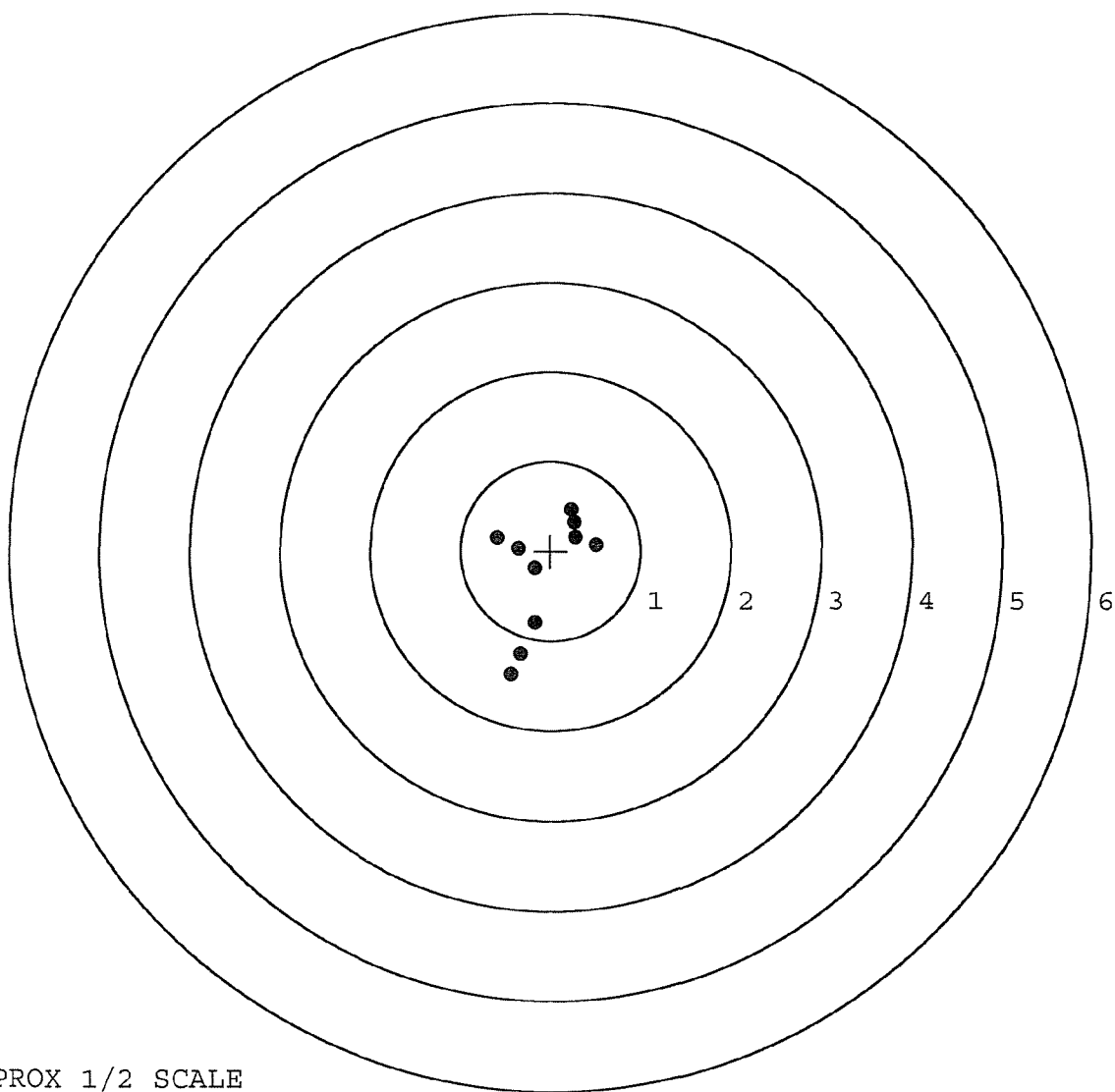


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410270.___1
TARGET NUMBER: 4
FILE DATE: 10/07/2005
FILE TIME: 08:18

X CENTROID: -0.083
Y CENTROID: -0.233
POA TO CENTROID: 0.247
HORZ SPREAD: 1.094
VERT SPREAD: 1.841
GROUP SPREAD: 1.959
MIN RADIUS: 0.098
MAX RADIUS: 1.199
MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.443	-1.376
2:	-0.339	-1.150
3:	-0.174	-0.801
4:	0.499	0.073
5:	0.267	0.155
6:	0.258	0.321
7:	0.226	0.465
8:	-0.175	-0.197
9:	-0.358	0.031
10:	-0.595	0.152



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410270.___1

TARGET NUMBER: 5

FILE DATE: 10/07/2005

FILE TIME: 08:18

POINT#	X	Y
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1:	0.064	-0.100
----	-------	--------

2:	0.305	-0.006
----	-------	--------

3:	0.230	0.432
----	-------	-------

4:	0.075	0.857
----	-------	-------

5:	-1.219	-0.480
----	--------	--------

6:	-0.365	-0.064
----	--------	--------

7:	-0.070	-0.974
----	--------	--------

8:	0.469	-0.565
----	-------	--------

9:	1.041	-0.406
----	-------	--------

10:	0.369	-0.865
-----	-------	--------

X CENTROID: 0.090

Y CENTROID: -0.217

POA TO CENTROID: 0.235

HORZ SPREAD: 2.260

VERT SPREAD: 1.831

GROUP SPREAD: 2.261

MIN RADIUS: 0.120

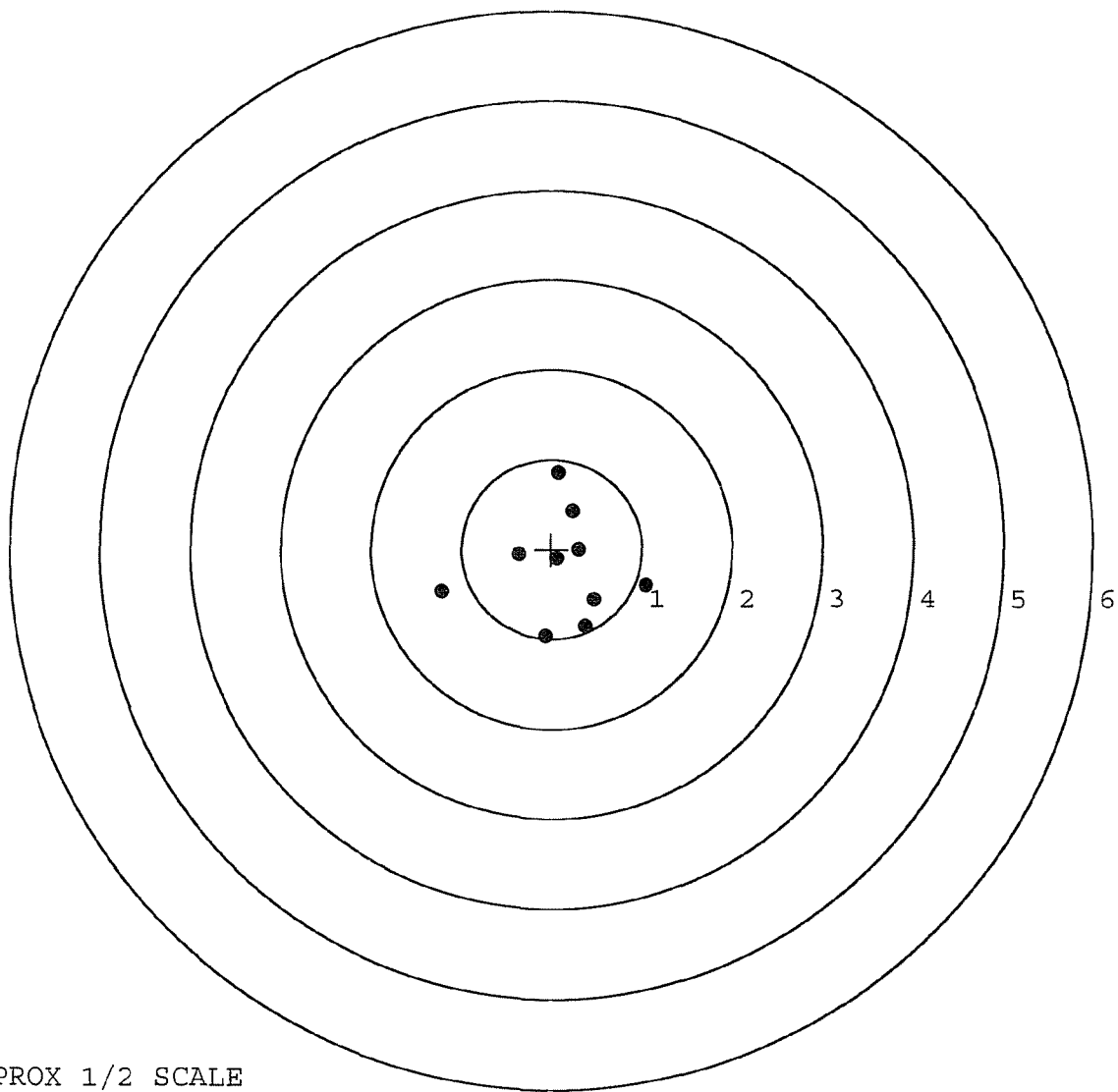
MAX RADIUS: 1.335

MEAN RADIUS: 0.694

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE