

G 6410295

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

G6410295



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

UPC



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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL6410295

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	K
607	CHECK HEADSPACE	MAGNA - FLUX	1-4-05	K
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 0 1 2005 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRLW
620	APPLY COATINGS (BARREL ACTION)		1/10/05	x/p
	(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		1-21-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-21-05	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</u> <u>6</u> <u>6</u>	1-26-05	RT
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>20</u> <u>20</u> <u>20</u>	1-26-05	RT
	H) TRIGGER PULL TEST AND RETAINABILITY		1-26-05	RT
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.022</u> <u>.022</u>	1-26-05	RT
	J) ASSEMBLE STOCK		1-21-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-26-05	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT	N.A.		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	1-25-05	AC
	MALFUNCTION <u>OK</u>	CORRECTION <u>OK</u>	1-25-05	AC
	MALFUNCTION <u>MCW</u>	CORRECTION <u>OK</u>	1-25-05	AC
	MALFUNCTION	CORRECTION	N.A.	
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-25-05	AC
655	FINAL INSPECTION A) HEADSPACE		1-26-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.65</u> <u>2.71</u> <u>2.65</u> <u>2.76</u>	1-26-05	RT
	C) FUNCTION		1-26-05	RT
660	PACK		1-26-05	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 1-14-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.44	2.28		2.18	
PULL #2	2.20	2.33		2.25	
PULL #3	2.19	2.28		2.28	
PULL #4	2.35	2.25		2.30	
PULL #5	2.34	2.12		2.30	
TOTAL	11.52	11.26		11.31	
AVERAGE	2.30	2.25		2.26	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.03		
PULL #2	3.25	3.05		
PULL #3	3.16	3.09		
PULL #4	3.19	3.11		
PULL #5	3.25	3.13		
TOTAL	15.99	15.41		
AVERAGE	3.19	3.08		

	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	4.25	4.28		4.19
PULL #2	4.39	4.35		4.25
PULL #3	4.28	4.33		4.26
PULL #4	4.31	4.33		4.27
PULL #5	4.34	4.35		4.19
TOTAL	21.57	21.64		21.16
AVERAGE	4.31	4.32		4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410295.__1
FILE DATE AND TIME: 09/09/2005 10:50

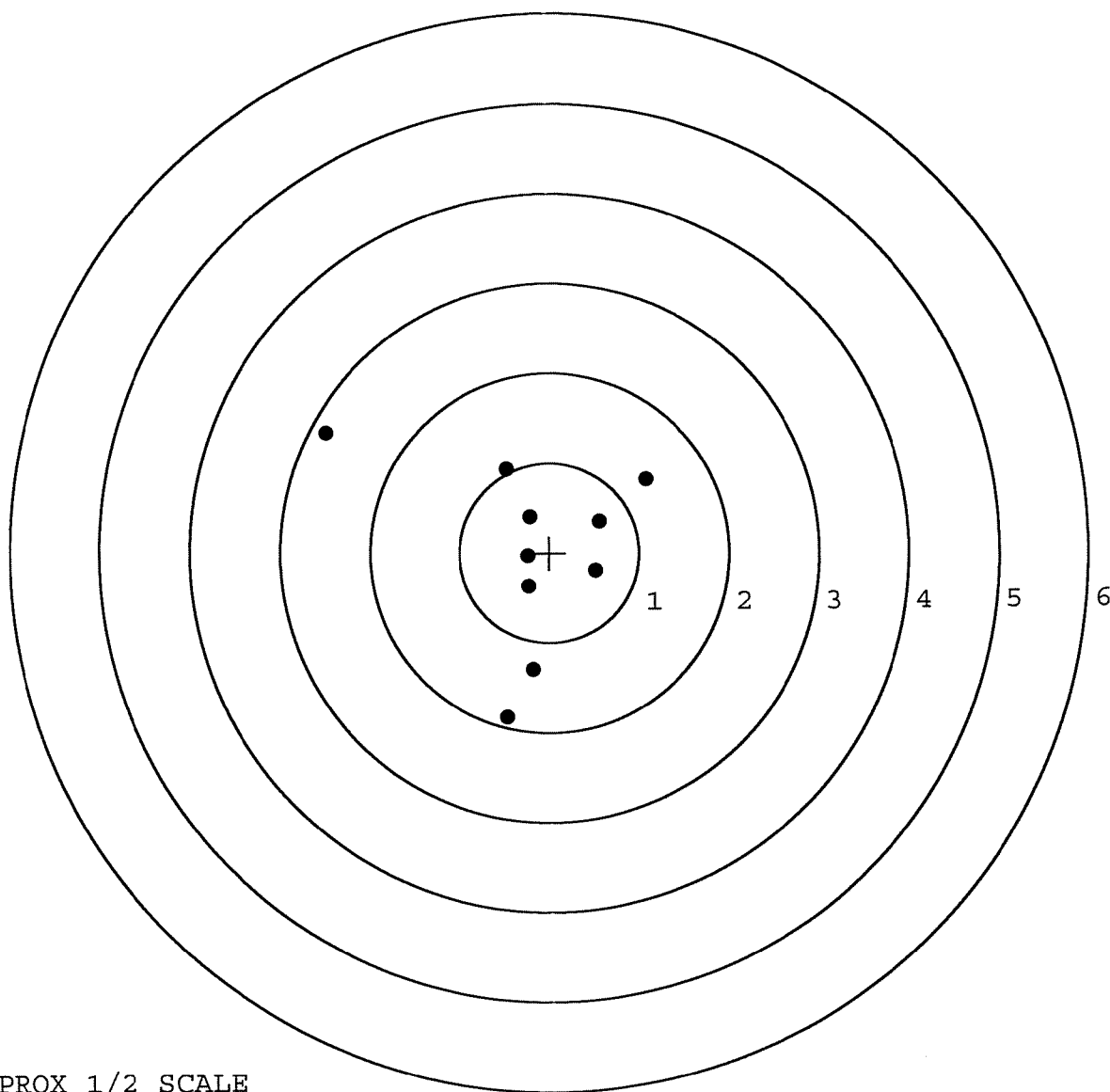
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.110
The Average Y Centroid of the Five Target Set:	-0.111
The Average Point of Impact of the Five Target Set:	0.156
The Average Mean Radius of the Five Target Set:	0.969
The Distance from POA to Centroid Target #1:	0.217
The Distance from Centroid Target #2 to Centroid Target #1:	0.129
The Distance from Centroid Target #3 to Centroid Target #1:	0.372
The Distance from Centroid Target #4 to Centroid Target #1:	0.270
The Distance from Centroid Target #5 to Centroid Target #1:	0.535

SERIAL NUMBER: G6410295._1
TARGET NUMBER: 1
FILE DATE: 09/09/2005
FILE TIME: 10:50

X CENTROID: -0.216
Y CENTROID: 0.011
POA TO CENTROID: 0.217
HORZ SPREAD: 3.568
VERT SPREAD: 3.188
GROUP SPREAD: 3.765
MIN RADIUS: 0.056
MAX RADIUS: 2.640
MEAN RADIUS: 1.075
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.082	0.812
2:	0.566	0.347
3:	0.519	-0.204
4:	-0.195	-1.301
5:	-0.483	-1.829
6:	-0.237	-0.376
7:	-0.243	-0.038
8:	-0.217	0.405
9:	-0.468	0.940
10:	-2.486	1.359

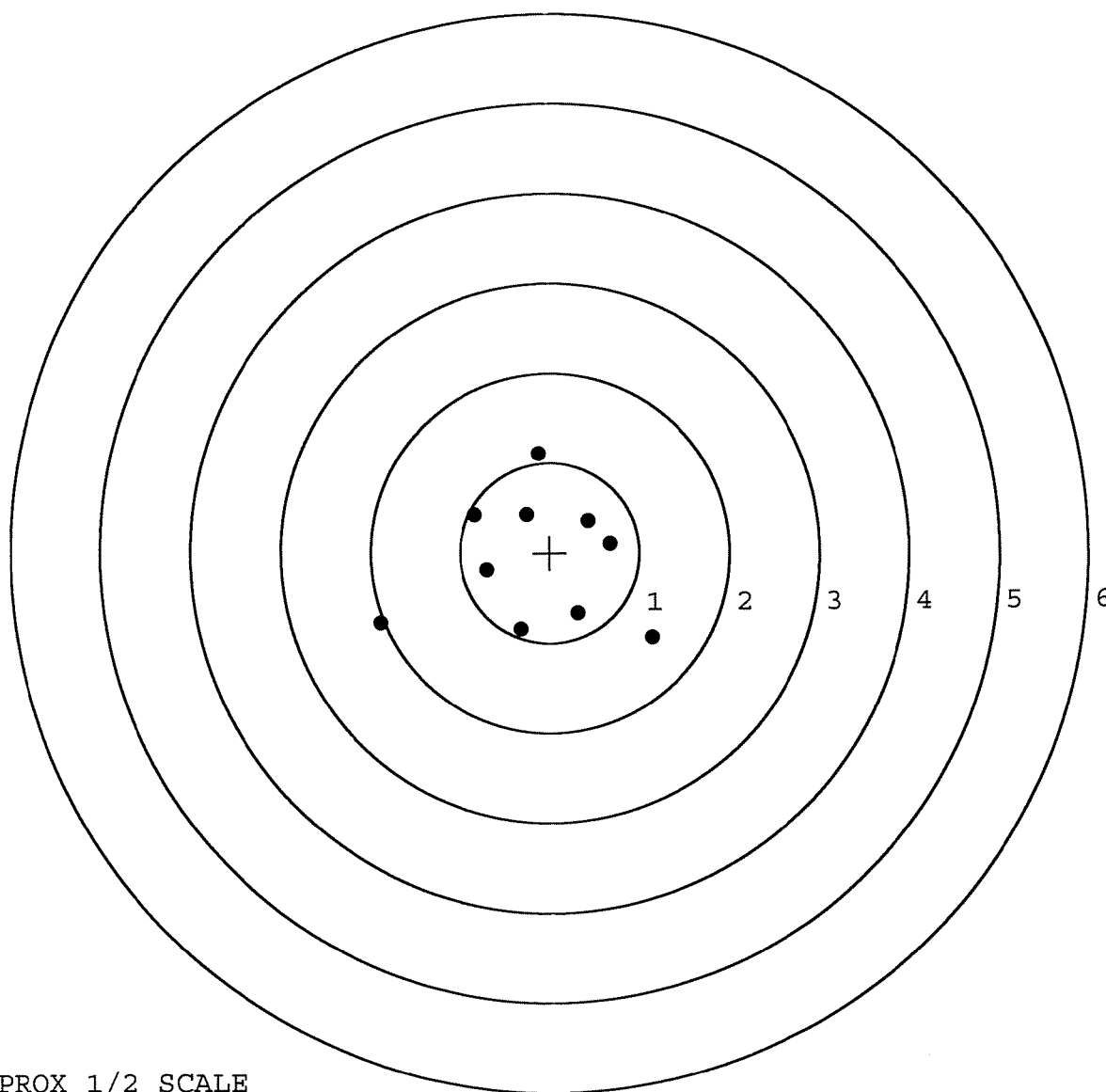


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410295. __1
TARGET NUMBER: 2
FILE DATE: 09/09/2005
FILE TIME: 10:50

X CENTROID: -0.158
Y CENTROID: -0.103
POA TO CENTROID: 0.189
HORZ SPREAD: 3.030
VERT SPREAD: 2.054
GROUP SPREAD: 3.036
MIN RADIUS: 0.536
MAX RADIUS: 1.858
MEAN RADIUS: 0.967
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.136	-0.950
2:	0.316	-0.674
3:	-0.333	-0.847
4:	-0.702	-0.191
5:	-1.894	-0.767
6:	0.679	0.096
7:	0.434	0.348
8:	-0.258	0.423
9:	-0.838	0.423
10:	-0.124	1.104



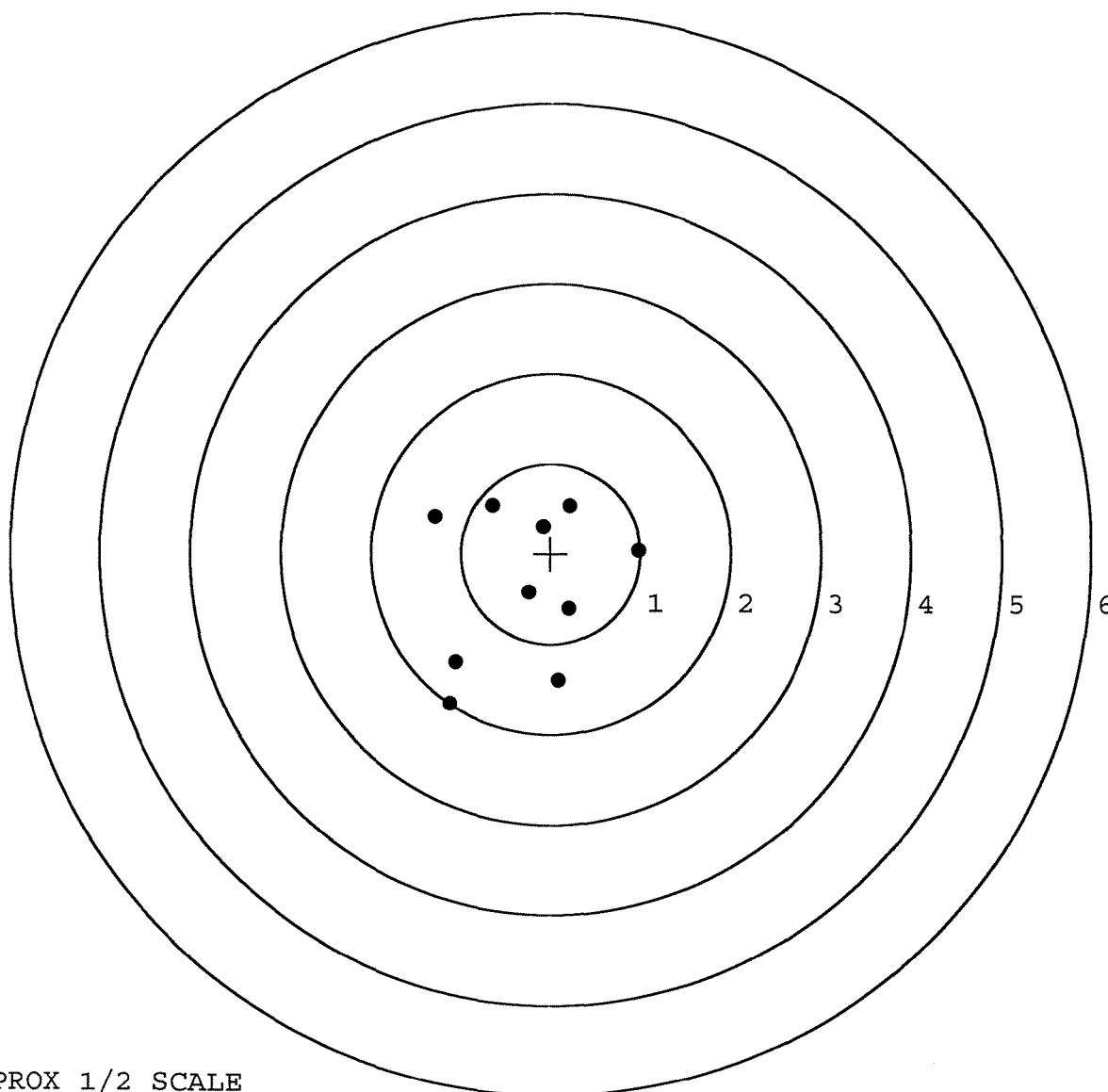
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410295. __1
TARGET NUMBER: 3
FILE DATE: 09/09/2005
FILE TIME: 10:50

X CENTROID: -0.299
Y CENTROID: -0.351
POA TO CENTROID: 0.461
HORZ SPREAD: 2.281
VERT SPREAD: 2.198
GROUP SPREAD: 2.706
MIN RADIUS: 0.102
MAX RADIUS: 1.549
MEAN RADIUS: 0.973

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.982	0.039
2:	0.088	-1.402
3:	0.201	-0.616
4:	-0.246	-0.438
5:	0.210	0.532
6:	-0.093	0.299
7:	-0.649	0.535
8:	-1.299	0.411
9:	-1.060	-1.206
10:	-1.122	-1.663

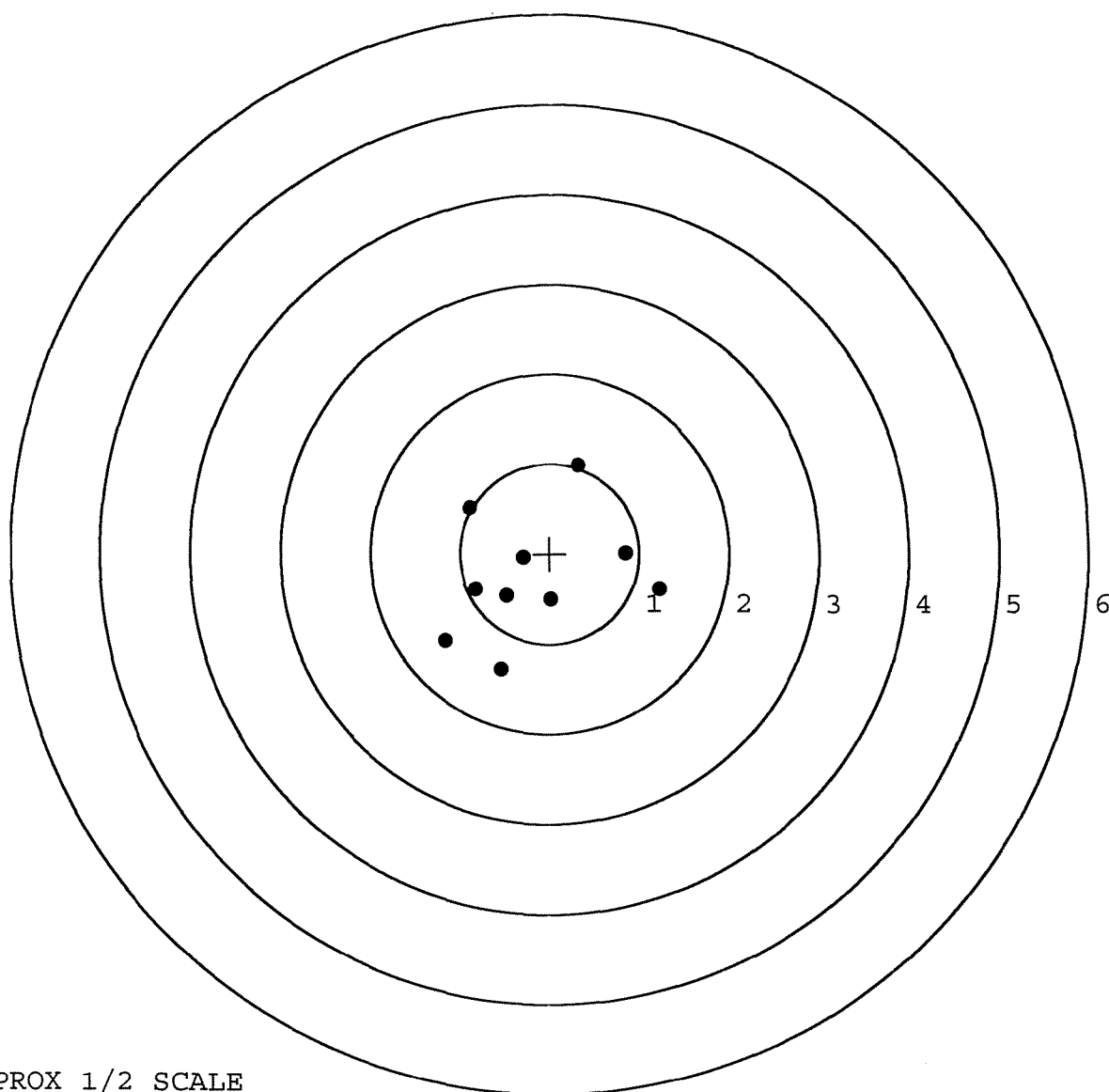


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410295. __1
TARGET NUMBER: 4
FILE DATE: 09/09/2005
FILE TIME: 10:50

X CENTROID: -0.177
Y CENTROID: -0.256
POA TO CENTROID: 0.311
HORZ SPREAD: 2.401
VERT SPREAD: 2.267
GROUP SPREAD: 2.470
MIN RADIUS: 0.245
MAX RADIUS: 1.417
MEAN RADIUS: 0.877
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 10

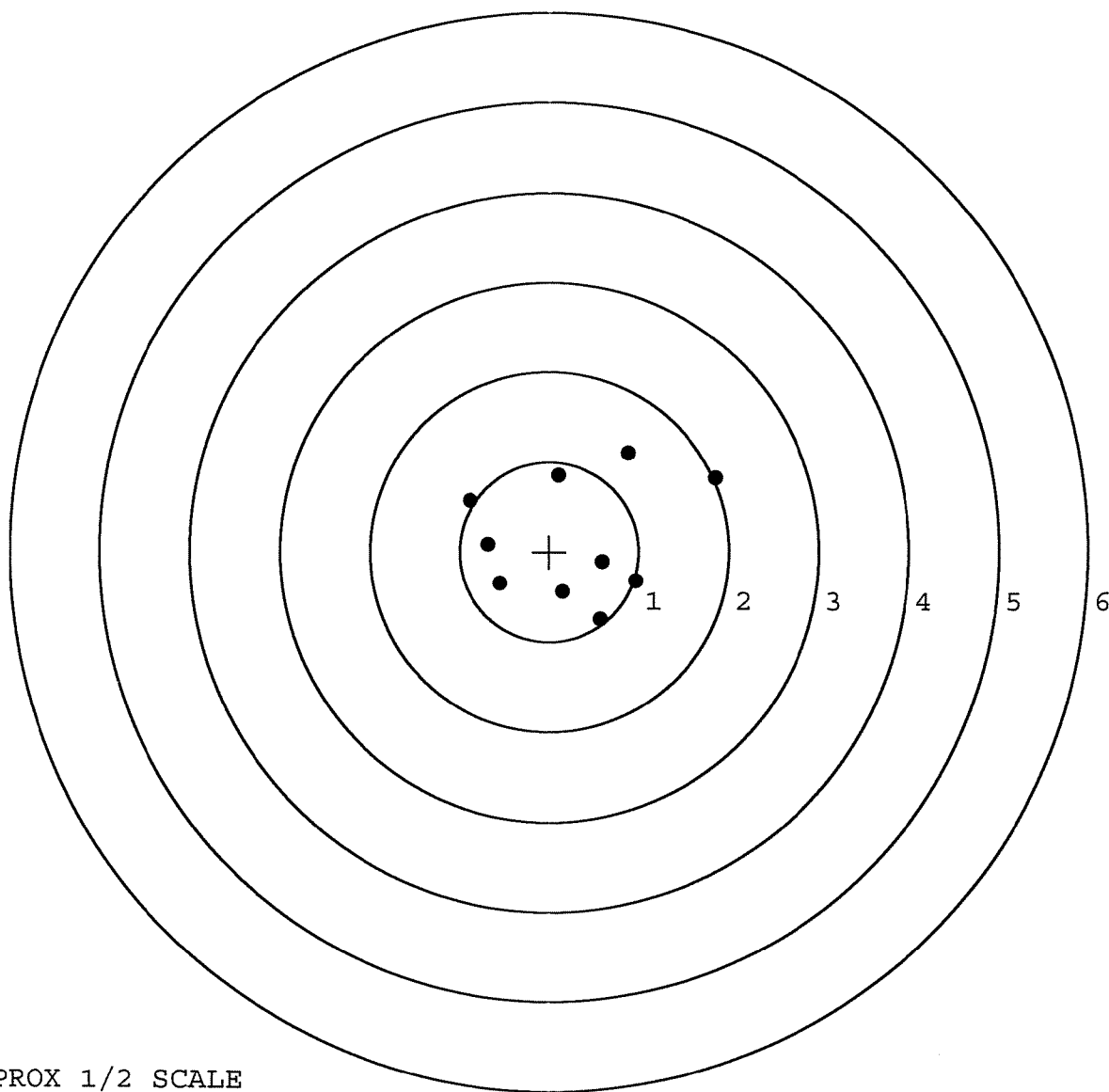
POINT#	X	Y
1:	1.233	-0.394
2:	0.849	0.011
3:	0.018	-0.510
4:	-0.297	-0.042
5:	-0.476	-0.467
6:	-0.537	-1.284
7:	-1.168	-0.973
8:	-0.826	-0.394
9:	-0.891	0.509
10:	0.322	0.983



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410295. __1
TARGET NUMBER: 5
FILE DATE: 09/09/2005
FILE TIME: 10:50

	POINT#	X	Y
	1:	1.853	0.825
	2:	0.884	1.099
	3:	0.102	0.850
	4:	-0.880	0.572
X CENTROID:	5:	0.151	-0.452
Y CENTROID:	6:	0.597	-0.115
POA TO CENTROID:	7:	0.971	-0.331
HORZ SPREAD:	8:	0.580	-0.754
VERT SPREAD:	9:	-0.680	0.086
GROUP SPREAD:	10:	-0.552	-0.358
MIN RADIUS:		0.391	
MAX RADIUS:		1.694	
MEAN RADIUS:		0.954	
# IN 1 IN DIAMETER:		1	
# IN 2 IN DIAMETER:		7	
# in 3 IN DIAMETER:		9	



TARGET APPROX 1/2 SCALE