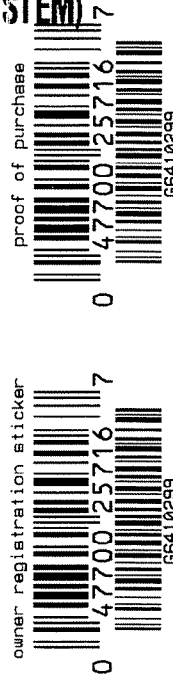


G6410299

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

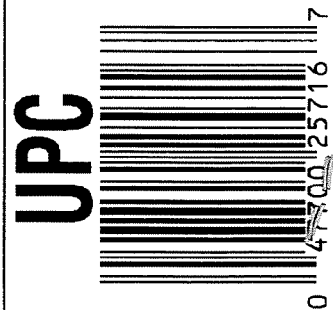
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6410299



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 # 66410299

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTL
600	PROOF		12-28-04	RT
607	CHECK HEADSPACE		12-28-04	RT
610	DIS-ASSEMBLE GUN		12-28-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			RT
615	ROLLMARK CALIBER		12/29/04	RT
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HL
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-12-05	RTL
	D) OIL FIRING PIN ASSEMBLY		1-12-05	RTL
	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>6.0</u> <u>5.5</u>	1-17-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>3.0</u>	1-17-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-17-05	DA
	J) ASSEMBLE STOCK		1-12-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-19-05	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	N/A		
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	1-13-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-13-05	TRW
655	FINAL INSPECTION A) HEADSPACE		1-19-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.56</u> <u>2.76</u> <u>2.77</u> <u>2.85</u>	1-17-05	DA
	C) FUNCTION		1-19-05	RT
660	PACK		1-20-05	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 11-10-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.77	2.26		2.09	
PULL #2	2.75	2.14		2.33	
PULL #3	2.84	2.18		2.18	
PULL #4	2.30	2.31		2.23	
PULL #5	2.39	2.23		2.18	
TOTAL	13.05	11.12		11.01	
AVERAGE	2.61	2.22		2.20	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.15		
PULL #2	3.42	3.12		
PULL #3	3.17	3.33		
PULL #4	3.19	3.36		
PULL #5	3.26	3.18		
TOTAL	16.37	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	4.33	4.14		4.33
PULL #2	4.56	4.20		4.35
PULL #3	4.53	4.32		4.43
PULL #4	4.36	4.34		4.27
PULL #5	4.53	4.01		4.01
TOTAL	22.31	21.01		21.39
AVERAGE	4.46	4.20		4.27

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410299.__1
FILE DATE AND TIME: 10/06/2005 18:15

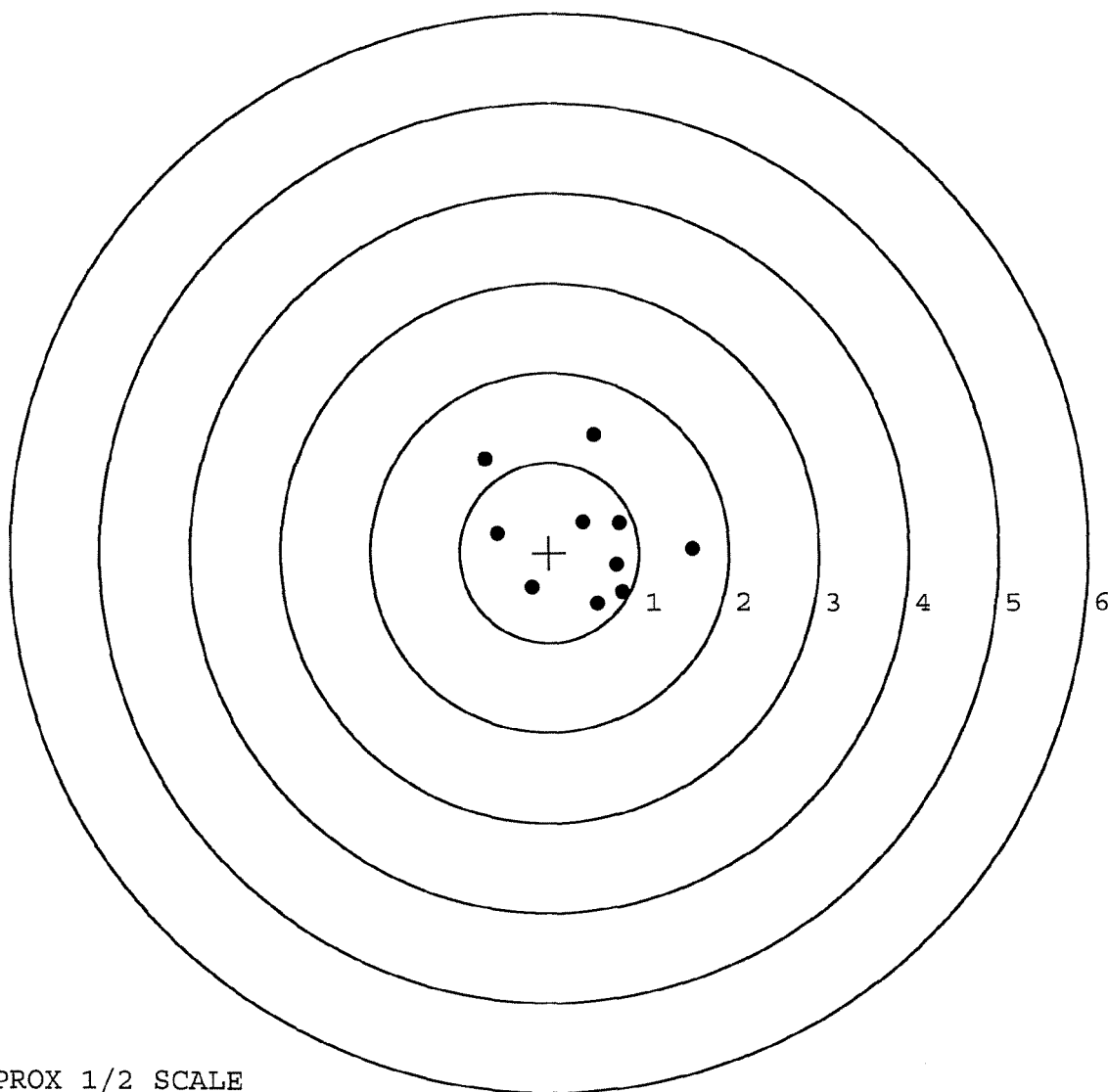
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.021
The Average Y Centroid of the Five Target Set:	0.008
The Average Point of Impact of the Five Target Set:	0.023
The Average Mean Radius of the Five Target Set:	0.889
The Distance from POA to Centroid Target #1:	0.424
The Distance from Centroid Target #2 to Centroid Target #1:	0.346
The Distance from Centroid Target #3 to Centroid Target #1:	0.549
The Distance from Centroid Target #4 to Centroid Target #1:	0.656
The Distance from Centroid Target #5 to Centroid Target #1:	0.666

SERIAL NUMBER: G6410299. __1
TARGET NUMBER: 1
FILE DATE: 10/06/2005
FILE TIME: 18:15

X CENTROID: 0.386
Y CENTROID: 0.175
POA TO CENTROID: 0.424
HORZ SPREAD: 2.315
VERT SPREAD: 1.874
GROUP SPREAD: 2.514
MIN RADIUS: 0.169
MAX RADIUS: 1.399
MEAN RADIUS: 0.810
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.814	-0.434
2:	0.752	-0.135
3:	0.776	0.335
4:	0.379	0.344
5:	1.594	0.049
6:	0.497	1.305
7:	-0.578	0.215
8:	-0.721	1.030
9:	-0.197	-0.389
10:	0.546	-0.569



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410299. __1

TARGET NUMBER: 2

FILE DATE: 10/06/2005

FILE TIME: 18:15

POINT#	X	Y
1:	0.096	-0.248
2:	0.321	0.090
3:	0.251	0.148
4:	0.470	0.416
5:	-0.286	0.537
6:	-0.350	0.057
7:	-0.701	0.467
8:	1.147	0.269
9:	0.267	-0.819
10:	-0.256	-1.052

X CENTROID: 0.096

Y CENTROID: -0.014

POA TO CENTROID: 0.097

HORZ SPREAD: 1.848

VERT SPREAD: 1.589

GROUP SPREAD: 1.927

MIN RADIUS: 0.224

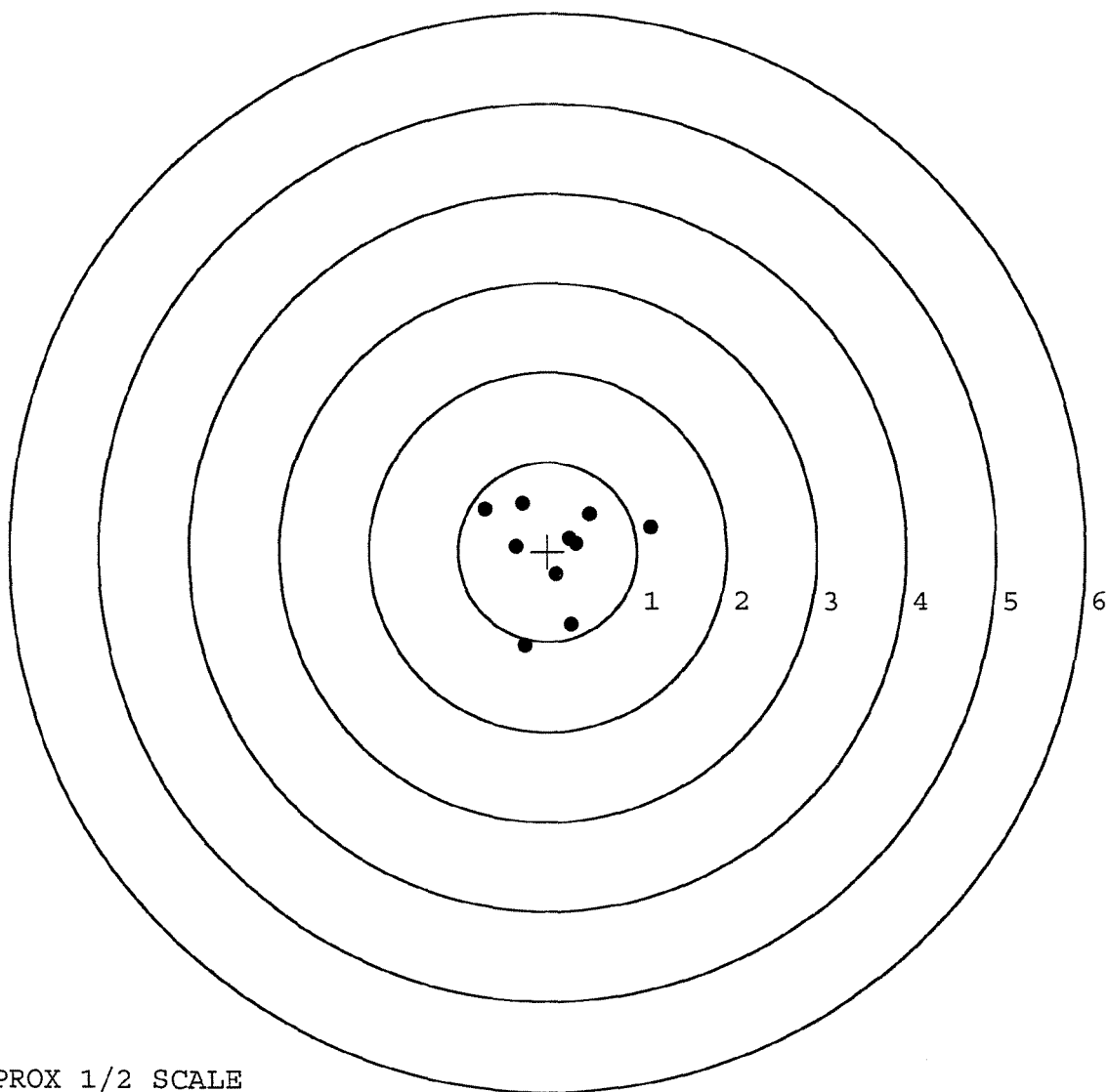
MAX RADIUS: 1.097

MEAN RADIUS: 0.634

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

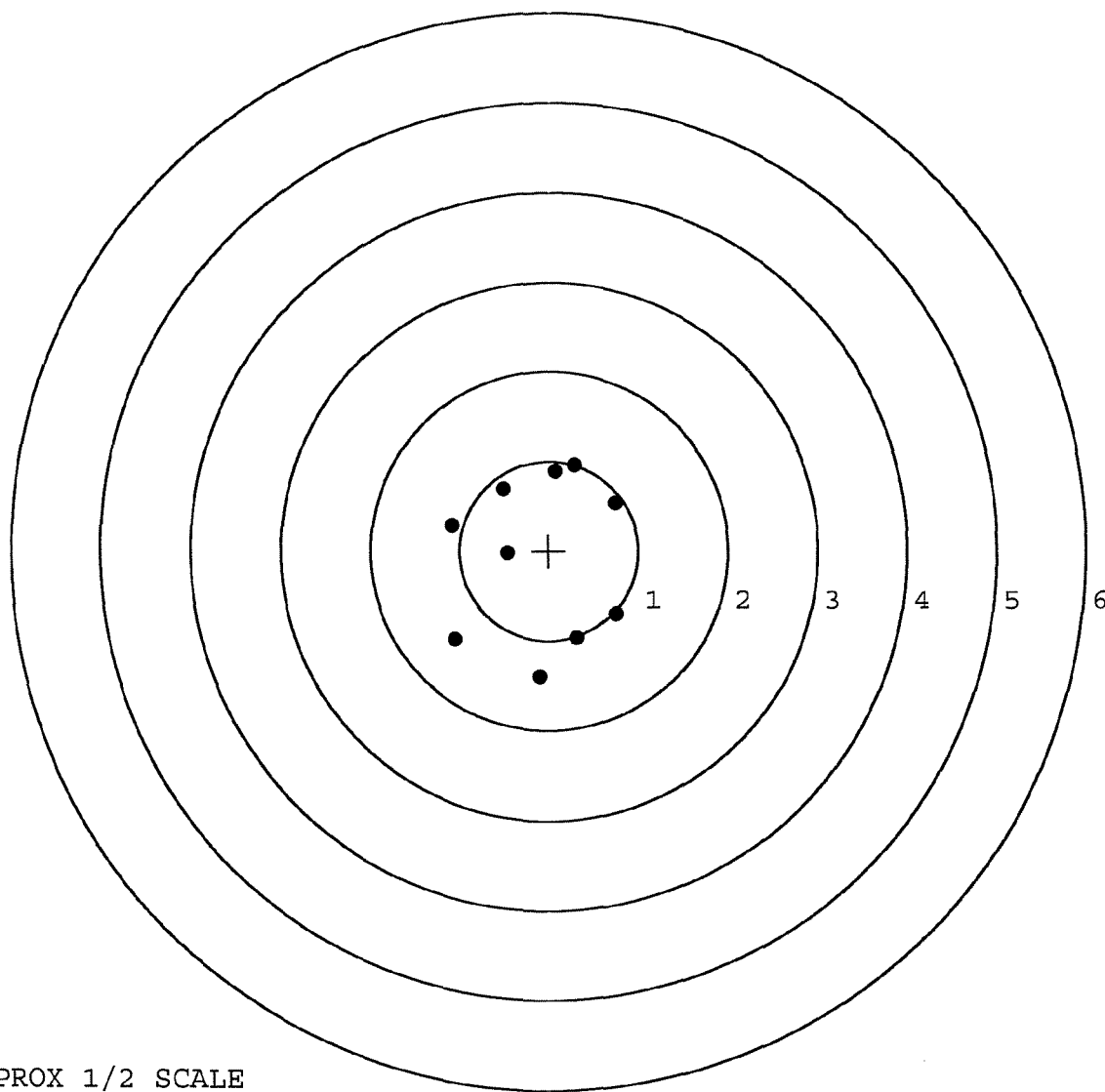


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410299. __1
TARGET NUMBER: 3
FILE DATE: 10/06/2005
FILE TIME: 18:15

X CENTROID: -0.103
Y CENTROID: -0.075
POA TO CENTROID: 0.127
HORZ SPREAD: 1.844
VERT SPREAD: 2.370
GROUP SPREAD: 2.402
MIN RADIUS: 0.363
MAX RADIUS: 1.335
MEAN RADIUS: 1.013
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.757	-0.713
2:	0.316	-0.977
3:	-0.103	-1.410
4:	-1.049	-0.990
5:	-0.463	-0.033
6:	-0.509	0.690
7:	-1.087	0.291
8:	0.077	0.892
9:	0.744	0.538
10:	0.288	0.960

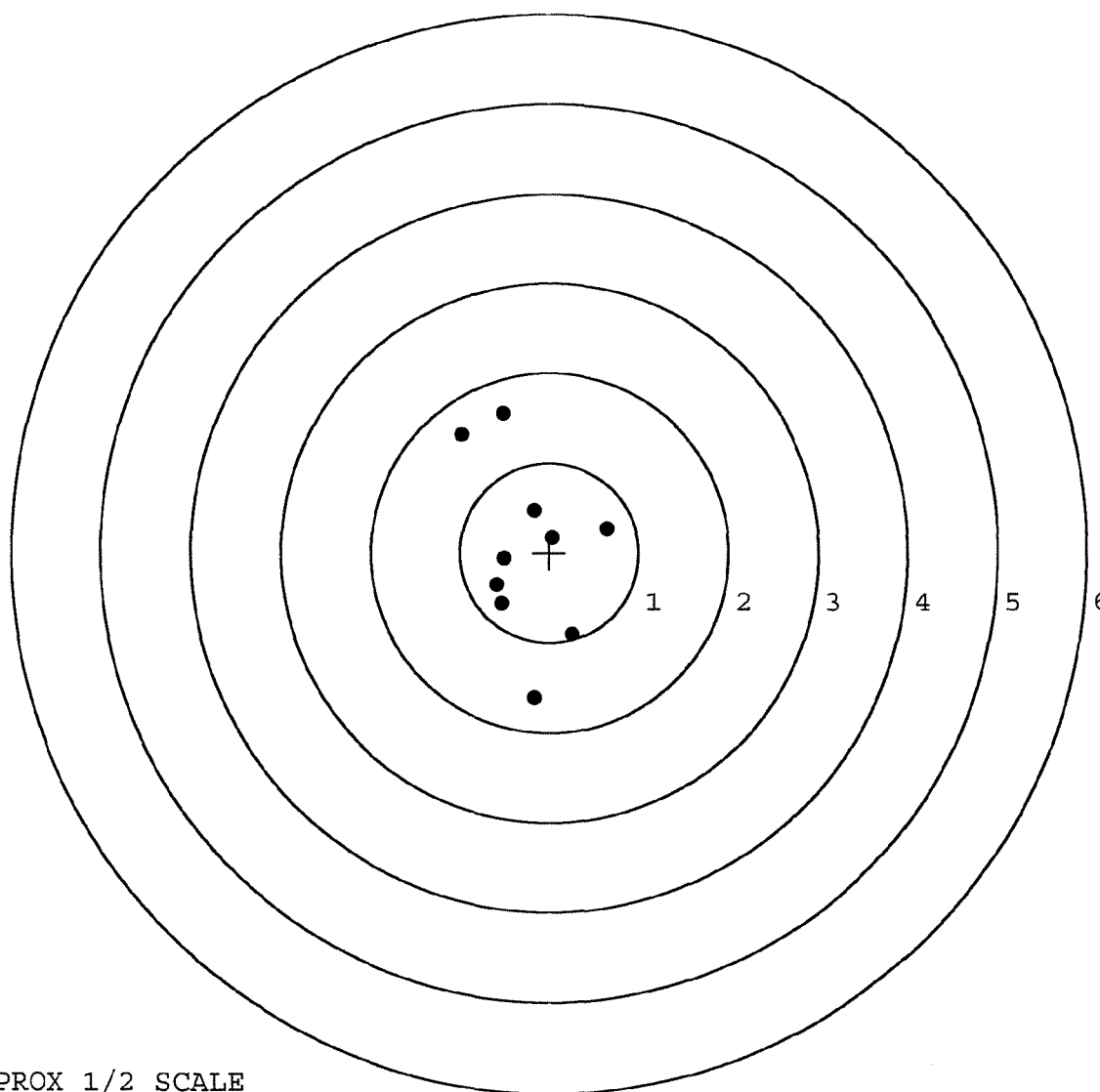


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410299. __1
TARGET NUMBER: 4
FILE DATE: 10/06/2005
FILE TIME: 18:15

POINT#	X	Y
1:	0.646	0.273
2:	0.036	0.172
3:	-0.171	0.467
4:	-0.501	-0.066
5:	-0.540	-0.569
6:	0.254	-0.914
7:	-0.978	1.316
8:	-0.516	1.552
9:	-0.171	-1.621
10:	-0.588	-0.357

X CENTROID: -0.253
Y CENTROID: 0.025
POA TO CENTROID: 0.254
HORZ SPREAD: 1.624
VERT SPREAD: 3.173
GROUP SPREAD: 3.192
MIN RADIUS: 0.264
MAX RADIUS: 1.648
MEAN RADIUS: 0.888
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

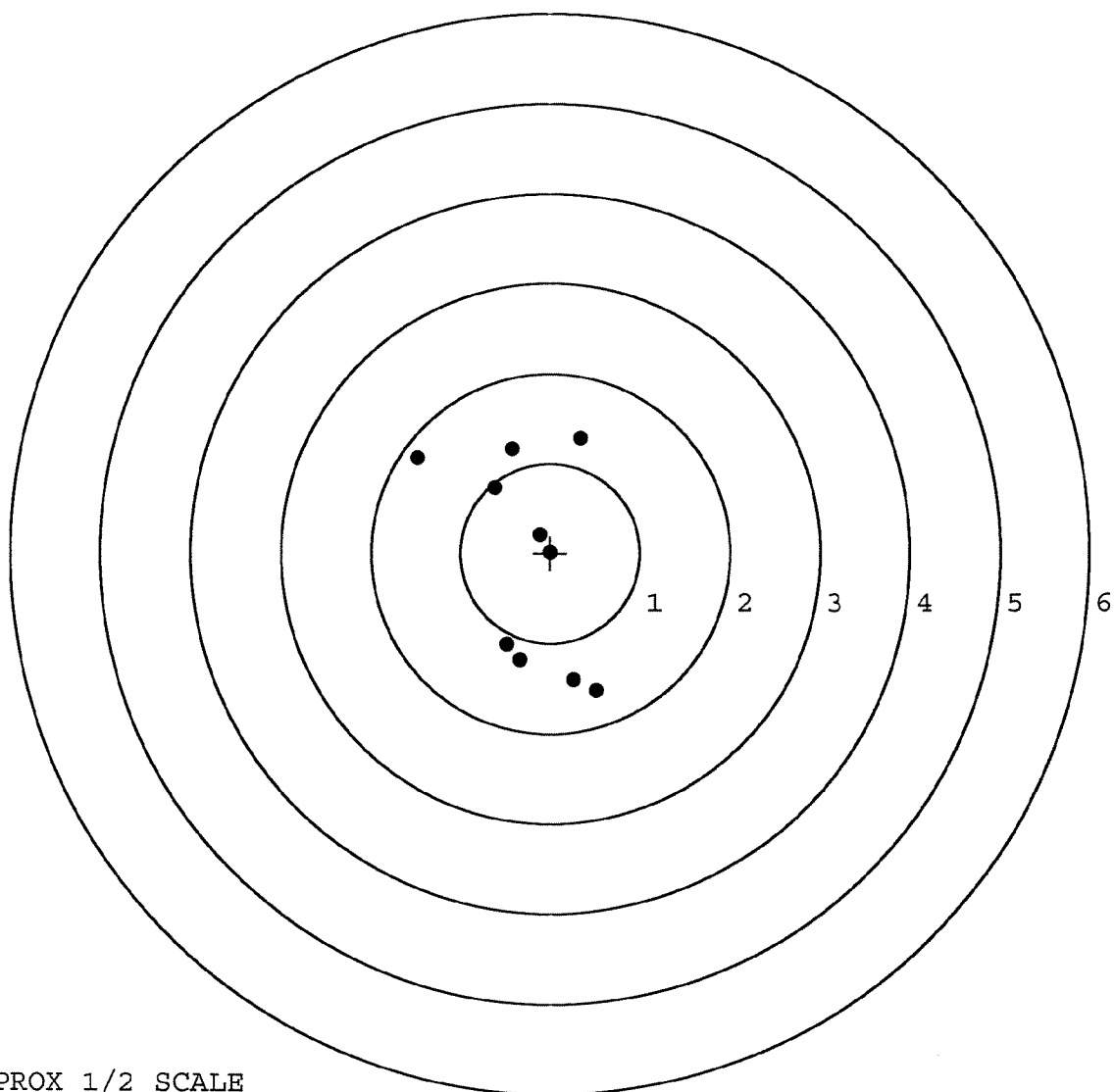


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410299. __1
TARGET NUMBER: 5
FILE DATE: 10/06/2005
FILE TIME: 18:15

X CENTROID: -0.233
Y CENTROID: -0.070
POA TO CENTROID: 0.243
HORZ SPREAD: 1.997
VERT SPREAD: 2.817
GROUP SPREAD: 3.277
MIN RADIUS: 0.246
MAX RADIUS: 1.687
MEAN RADIUS: 1.102
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.003	0.000
2:	-0.115	0.205
3:	-0.614	0.731
4:	-0.421	1.165
5:	-1.481	1.065
6:	0.341	1.284
7:	-0.484	-1.015
8:	-0.336	-1.190
9:	0.264	-1.411
10:	0.516	-1.533



TARGET APPROX 1/2 SCALE