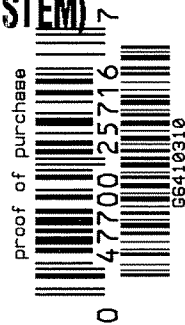


G6410310

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

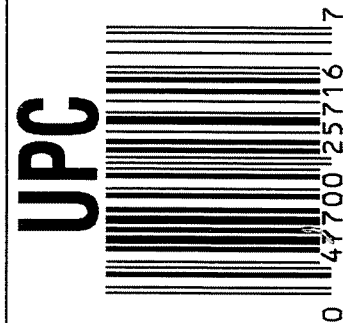
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6410310



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

UPC



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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C641 0310

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTZ
600	PROOF		12-29-04	RTZ
607	CHECK HEADSPACE		12-29-04	RTZ
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-30-04	RTZ
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1-18-05	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		1-13-04	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-13-04	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>6.2</u> <u>5.5</u> <u>5.5</u>	1-22-05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.2</u>	1-22-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1023</u> <u>1025</u>	1-22-05	DA
	J) ASSEMBLE STOCK		1-13-05	RTL
	K) ASSEMBLE SWIVEL STUDS		1-24-05	RTL
	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			
	GALLERY TEST AND TARGET			
640		PASS FAIL	1-14-05	AK
	MALFUNCTION <i>Feeds hard</i>	CORRECTION <i>OK</i>	1-21-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-14-05	AC
655	FINAL INSPECTION A) HEADSPACE		1-24-05	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.79</u> <u>2.85</u> <u>2.68</u> <u>2.63</u>	1-22-05	DA
	C) FUNCTION		1-24-05	RTL
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 10-29-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.24	2.11		2.09	
PULL #2	2.19	2.11		2.15	
PULL #3	2.27	2.11		2.15	
PULL #4	2.21	2.08		2.25	
PULL #5	2.13	2.06		2.11	
TOTAL	11.04	10.47		10.75	
AVERAGE	2.20	2.09		2.15	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.23		
PULL #2	3.36	3.32		
PULL #3	3.29	3.19		
PULL #4	3.33	3.39		
PULL #5	3.31	3.37		
TOTAL	16.63	16.50		
AVERAGE	3.32	3.30		

	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	4.08	4.38		4.03
PULL #2	4.35	4.41		4.20
PULL #3	4.29	4.35		4.33
PULL #4	4.34	4.34		4.17
PULL #5	4.28	4.37		4.21
TOTAL	21.34	21.85		20.94
AVERAGE	4.26	4.37		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410310.___1
FILE DATE AND TIME: 09/08/2005 11:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

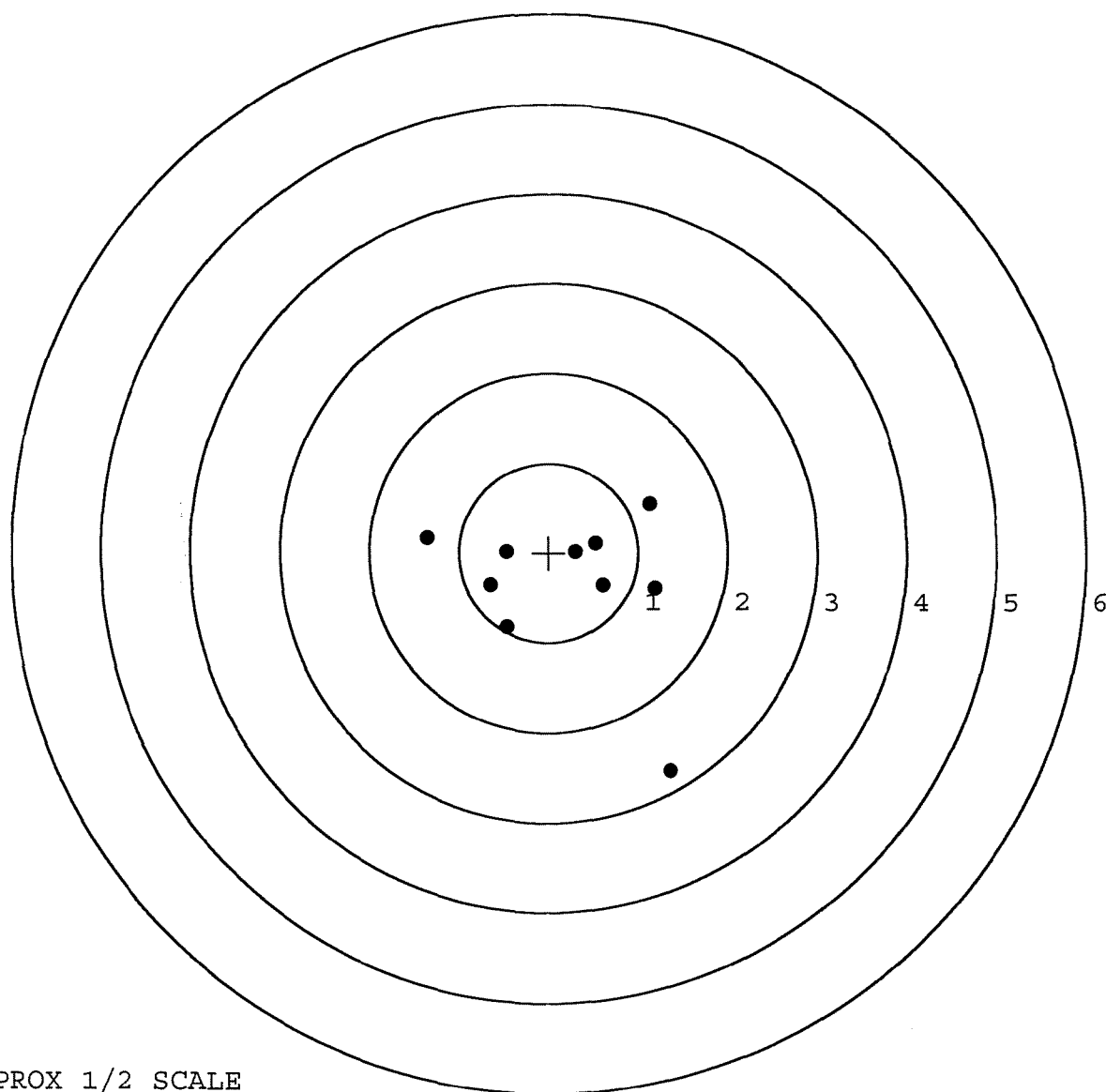
The Average X Centroid of the Five Target Set:	-0.020
The Average Y Centroid of the Five Target Set:	-0.176
The Average Point of Impact of the Five Target Set:	0.177
The Average Mean Radius of the Five Target Set:	0.998
The Distance from POA to Centroid Target #1:	0.418
The Distance from Centroid Target #2 to Centroid Target #1:	0.373
The Distance from Centroid Target #3 to Centroid Target #1:	0.405
The Distance from Centroid Target #4 to Centroid Target #1:	0.308
The Distance from Centroid Target #5 to Centroid Target #1:	0.685

SERIAL NUMBER: G6410310. __1
TARGET NUMBER: 1
FILE DATE: 09/08/2005
FILE TIME: 11:30

X CENTROID: 0.219
Y CENTROID: -0.356
POA TO CENTROID: 0.418
HORZ SPREAD: 2.723
VERT SPREAD: 2.964
GROUP SPREAD: 3.755
MIN RADIUS: 0.375
MAX RADIUS: 2.365
MEAN RADIUS: 1.009

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.193	-0.406
2:	0.610	-0.361
3:	1.125	0.541
4:	0.528	0.111
5:	0.303	0.009
6:	-0.470	0.012
7:	-0.653	-0.366
8:	-0.463	-0.839
9:	-1.354	0.162
10:	1.369	-2.423



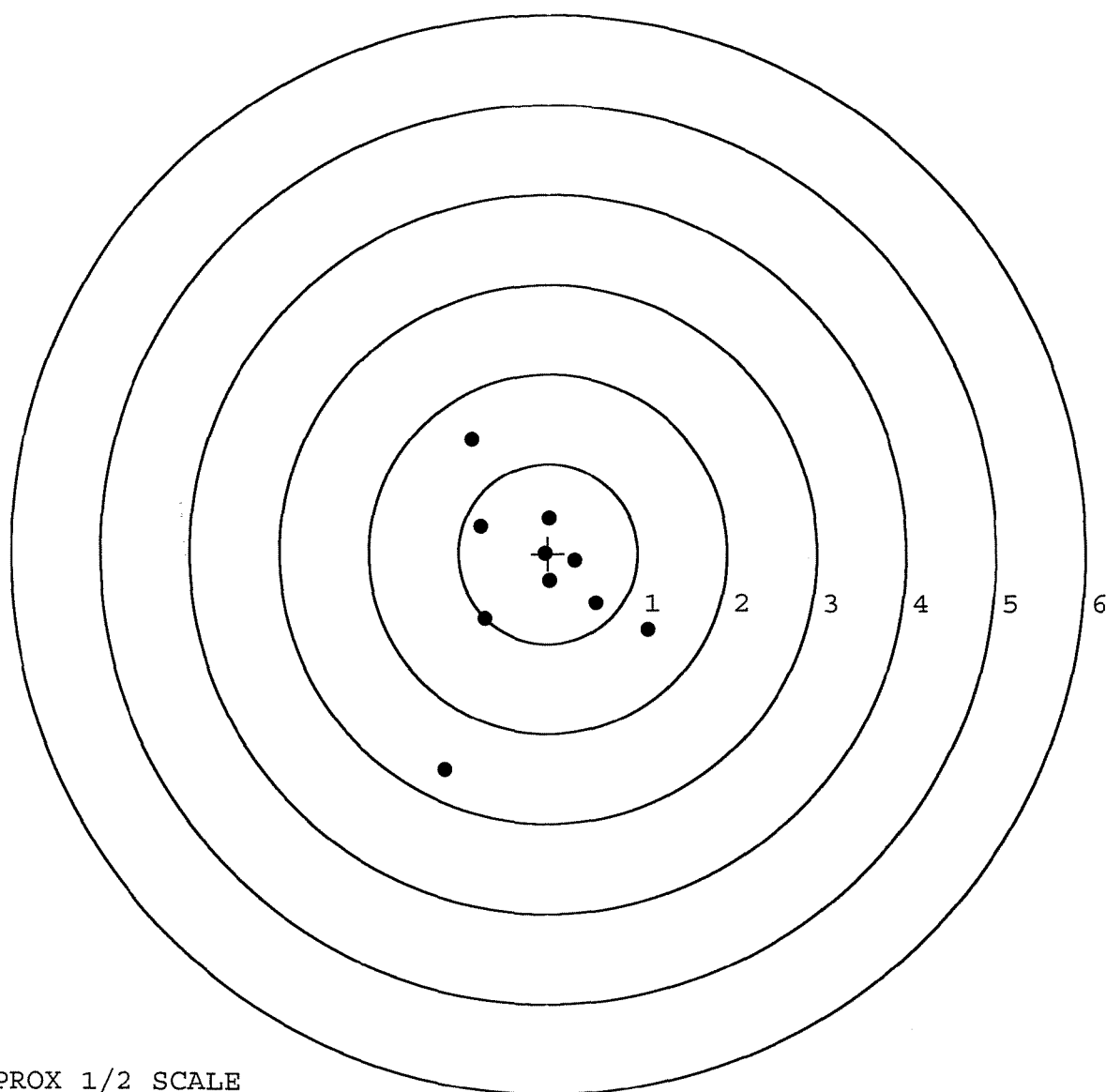
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410310. 1
TARGET NUMBER: 2
FILE DATE: 09/08/2005
FILE TIME: 11:30

X CENTROID: -0.150
Y CENTROID: -0.297
POA TO CENTROID: 0.332
HORZ SPREAD: 2.271
VERT SPREAD: 3.684
GROUP SPREAD: 3.696
MIN RADIUS: 0.167
MAX RADIUS: 2.340
MEAN RADIUS: 0.942

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.119	-0.848
2:	0.546	-0.549
3:	0.304	-0.081
4:	0.017	-0.304
5:	-0.036	-0.003
6:	0.014	0.390
7:	-0.753	0.296
8:	-0.706	-0.729
9:	-0.852	1.273
10:	-1.152	-2.411



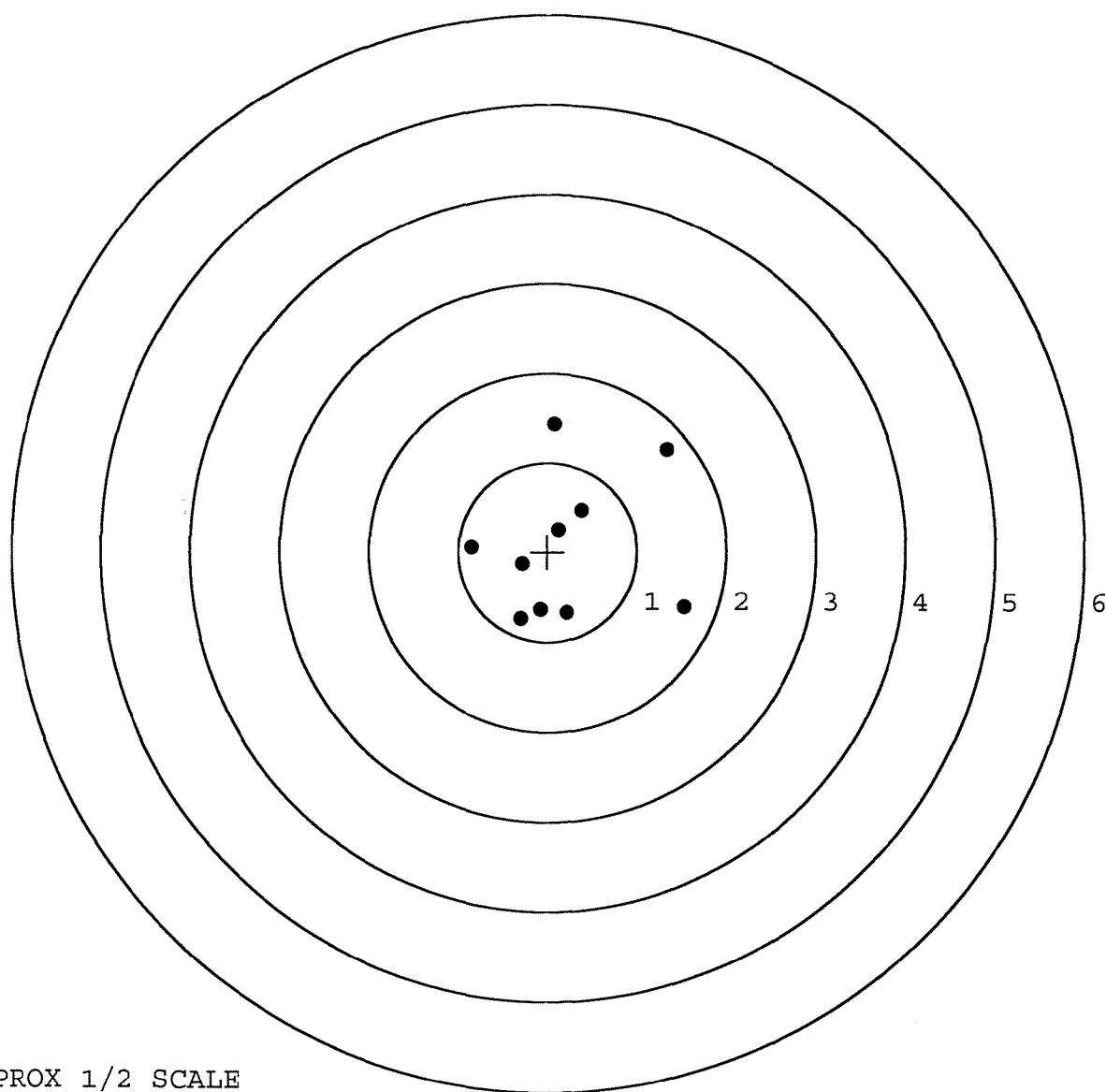
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410310.___1
TARGET NUMBER: 3
FILE DATE: 09/08/2005
FILE TIME: 11:30

X CENTROID: 0.213
Y CENTROID: 0.049
POA TO CENTROID: 0.218
HORZ SPREAD: 2.381
VERT SPREAD: 2.181
GROUP SPREAD: 2.501
MIN RADIUS: 0.220
MAX RADIUS: 1.565
MEAN RADIUS: 0.914

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.533	-0.615
2:	1.333	1.142
3:	0.068	1.429
4:	0.384	0.462
5:	0.116	0.246
6:	0.214	-0.684
7:	-0.085	-0.653
8:	-0.301	-0.752
9:	-0.285	-0.139
10:	-0.848	0.054

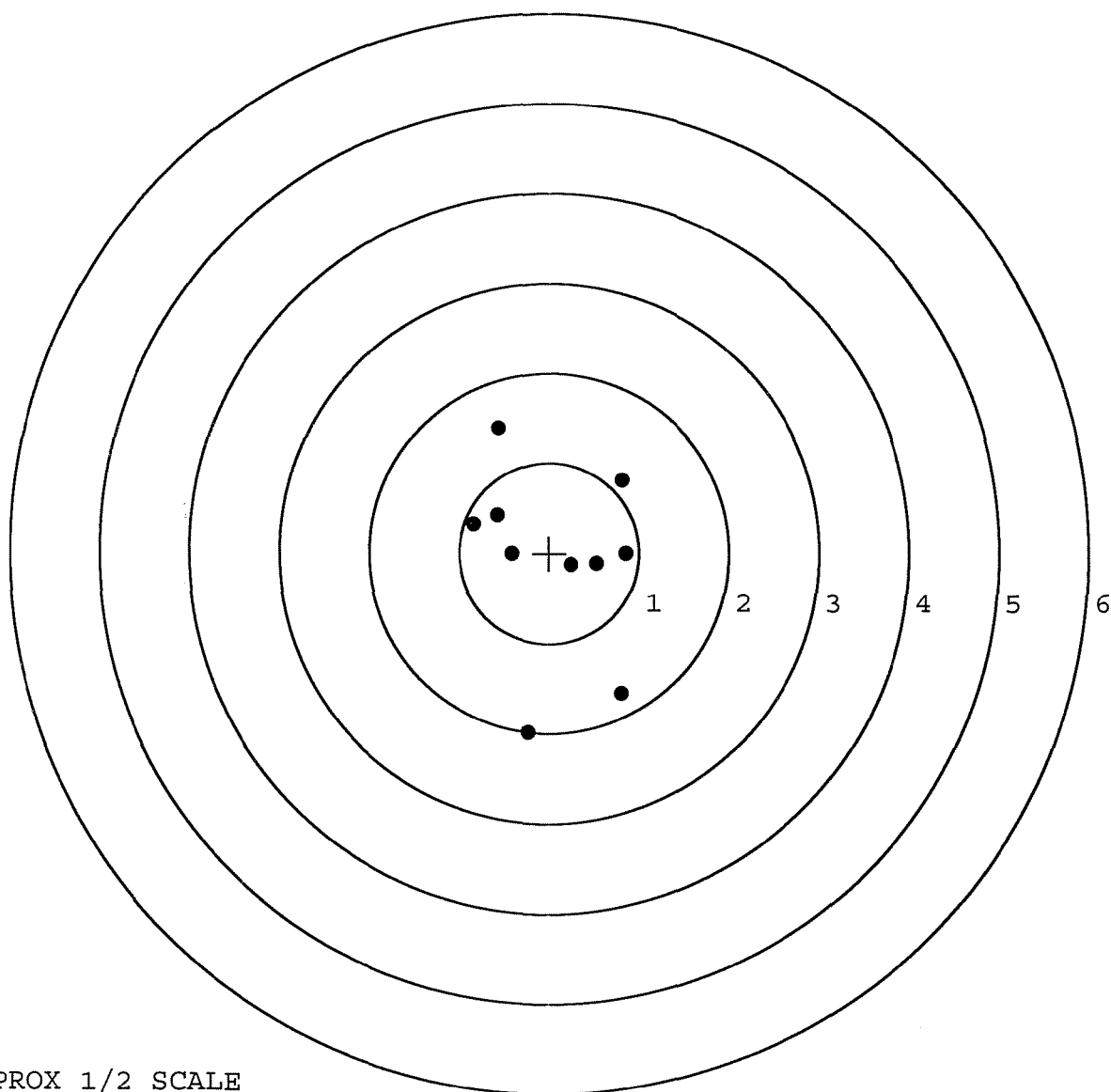


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410310.___1
TARGET NUMBER: 4
FILE DATE: 09/08/2005
FILE TIME: 11:30

X CENTROID: 0.061
Y CENTROID: -0.091
POA TO CENTROID: 0.110
HORZ SPREAD: 1.697
VERT SPREAD: 3.385
GROUP SPREAD: 3.402
MIN RADIUS: 0.184
MAX RADIUS: 1.932
MEAN RADIUS: 1.011
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.812	-1.566
2:	-0.237	-2.000
3:	0.814	0.806
4:	-0.572	1.385
5:	-0.841	0.316
6:	-0.577	0.414
7:	-0.416	-0.010
8:	0.242	-0.128
9:	0.532	-0.116
10:	0.856	-0.012



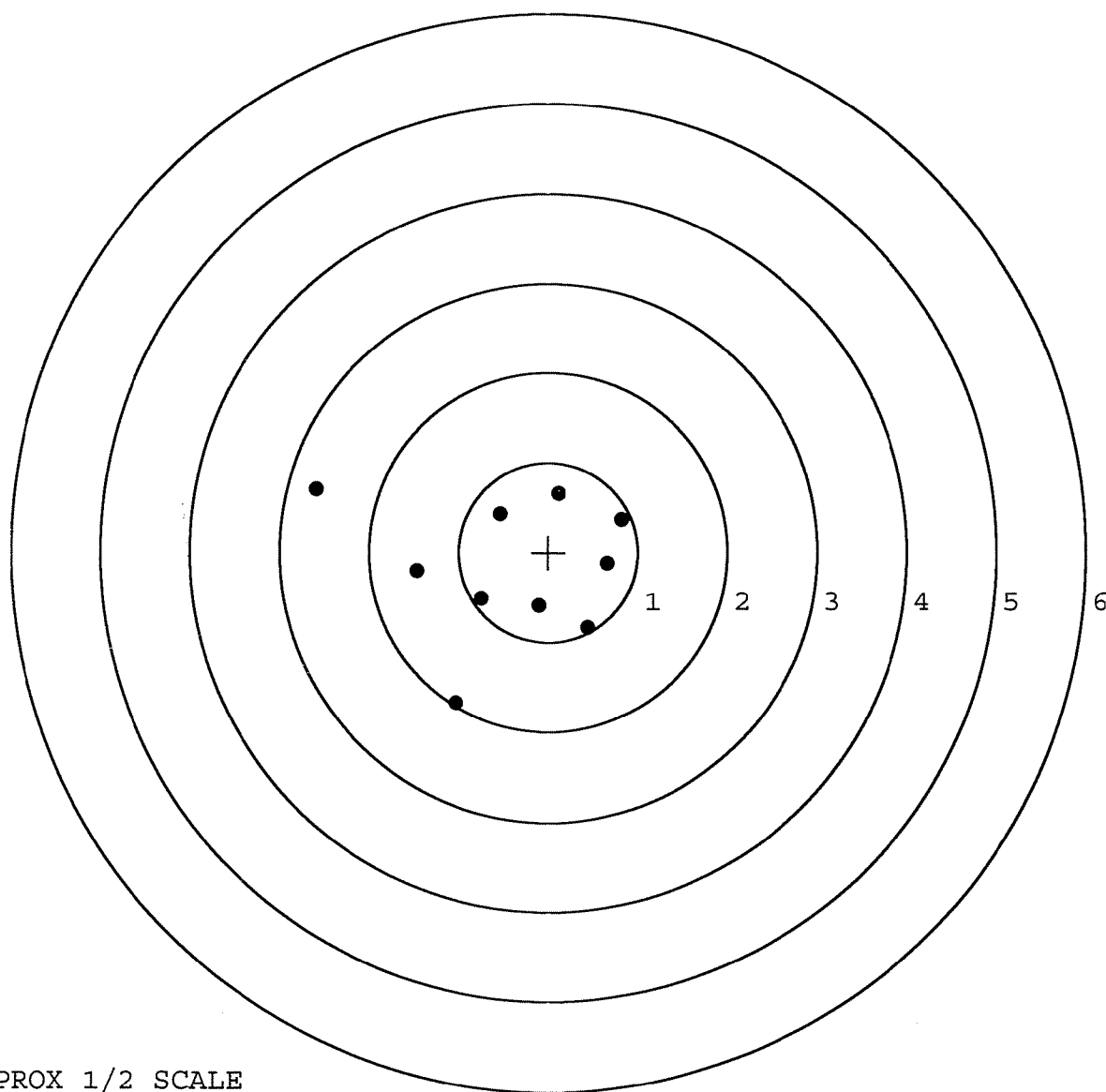
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410310.___1
TARGET NUMBER: 5
FILE DATE: 09/08/2005
FILE TIME: 11:30

X CENTROID: -0.444
Y CENTROID: -0.183
POA TO CENTROID: 0.480
HORZ SPREAD: 3.409
VERT SPREAD: 2.382
GROUP SPREAD: 3.425
MIN RADIUS: 0.448
MAX RADIUS: 2.318
MEAN RADIUS: 1.116

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

POINT#	X	Y
1:	0.444	-0.845
2:	0.662	-0.132
3:	0.822	0.365
4:	0.117	0.654
5:	-0.535	0.429
6:	-0.113	-0.600
7:	-0.747	-0.514
8:	-1.034	-1.682
9:	-1.469	-0.209
10:	-2.587	0.700



TARGET APPROX 1/2 SCALE