

G-6414392

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 1651



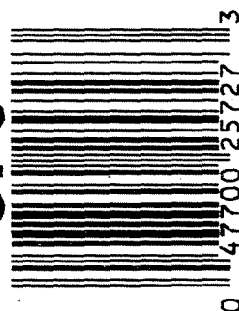
ORDER NO. 25727

BARREL LENGTH 24"

CAPACITY 5

G6414392

UPC



ORDER 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS

UPC



ORDER 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS

UPC



SERIAL NO.



12/10/2004 1:21:34 PM

Crib

Original

25727

M/24 7.62 NATO (RIFLE W/SCOPE&SIGHTS)



.MA25727

Shop Order: SWS667663A



.ABSWS667663A

Start Date: 12/17/2004

Finish Date: 1/12/2005

0540

01PC001

Flat Black Powder Coat, Barrel and



0003592015

0560

89SWS1

Reassemble Action.



0003592016

0690

89SWS1

Pack Rifle



0003592027

0700

89SWS1

Stencil SWS Container



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414392

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTZ
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		10/27/04	AB
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRW
620	APPLY COATINGS (BARREL ACTION)		10/30	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-9-04	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-04	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-04	RTZ
	D) OIL FIRING PIN ASSEMBLY		11-9-04	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>816s</u> <u>816s</u> <u>816s</u>	<u>12-15-04</u>	<u>AC</u>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>216s</u> <u>216s</u> <u>216s</u>	<u>12-15-04</u>	<u>AC</u>
	H) TRIGGER PULL TEST AND RETAINABILITY		<u>12-17-04</u>	<u>RTL</u>
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.023</u> <u>.023</u>	<u>12-15-04</u>	<u>AC</u>
	J) ASSEMBLE STOCK		<u>11-9-04</u>	<u>RTL</u>
	K) ASSEMBLE SWIVEL STUDS		<u>12-14-04</u>	<u>CR</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>12-14-04</u>	<u>CR</u>
	M) IRON SIGHT ALIGNMENT		<u>12-14-04</u>	<u>CR</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>12-14-04</u>	<u>RTL</u>
640	GALLERY TEST AND TARGET	PASS FAIL	<u>12-14-04</u>	<u>TRW</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		<u>12-14-04</u>	<u>TRW</u>
655	FINAL INSPECTION A) HEADSPACE		<u>12-17-04</u>	<u>RTL</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>245</u> <u>263</u> <u>234</u> <u>239</u> <u>244</u>	<u>12-17-04</u>	<u>RTL</u>
	C) FUNCTION		<u>12-17-04</u>	<u>RTL</u>
660	PACK		<u>12-17-04</u>	<u>RA</u>

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 6-14-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.44	2.35		2.39	
PULL #2	2.68	2.31		2.29	
PULL #3	2.57	2.28		2.32	
PULL #4	2.43	2.27		2.31	
PULL #5	2.59	2.26		2.29	
TOTAL	12.71	11.47		11.60	
AVERAGE	2.54	2.29		2.32	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.35		
PULL #2	3.32	3.27		
PULL #3	3.32	3.29		
PULL #4	3.38	3.21		
PULL #5	3.36	3.38		
TOTAL	16.53	16.50		
AVERAGE	3.30	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	4.20	4.21		4.51
PULL #2	4.15	4.27		4.45
PULL #3	4.20	4.22		4.44
PULL #4	4.19	4.27		4.22
PULL #5	4.23	4.24		4.37
TOTAL	20.97	21.21		21.99
AVERAGE	4.19	4.24		4.39

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414392.___0

FILE DATE AND TIME: 12/14/2004 11:42

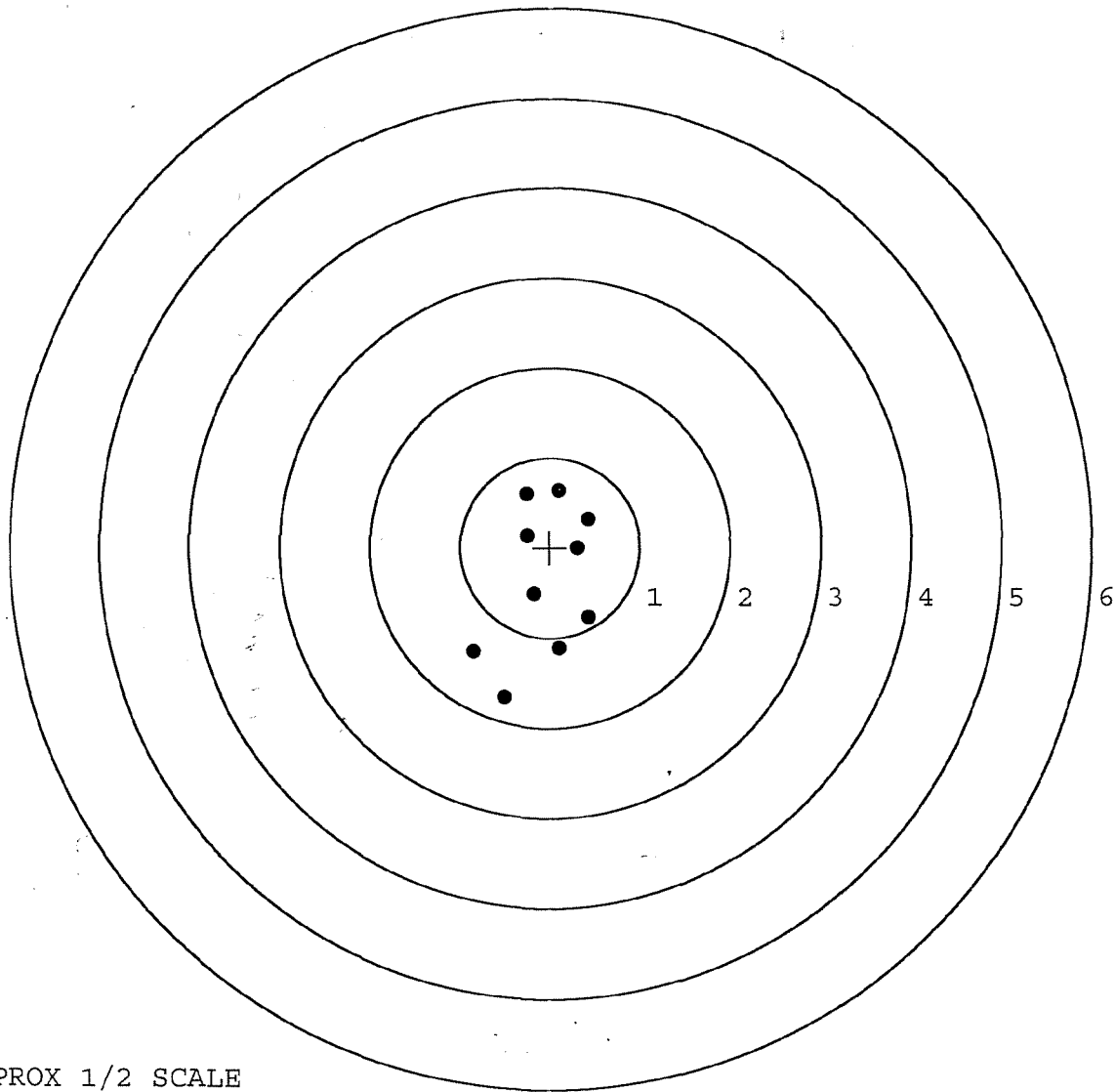
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.031
The Average Y Centroid of the Five Target Set:	-0.039
The Average Point of Impact of the Five Target Set:	0.050
The Average Mean Radius of the Five Target Set:	0.808
The Distance from POA to Centroid Target #1:	0.363
The Distance from Centroid Target #2 to Centroid Target #1:	0.378
The Distance from Centroid Target #3 to Centroid Target #1:	0.383
The Distance from Centroid Target #4 to Centroid Target #1:	0.505
The Distance from Centroid Target #5 to Centroid Target #1:	0.422

SERIAL NUMBER: G6414392: __0
TARGET NUMBER: 1
FILE DATE: 12/14/2004
FILE TIME: 11:42

POINT#	X	Y
1:	0.424	0.314
2:	0.308	-0.010
3:	-0.259	0.131
4:	0.095	0.637
5:	-0.263	0.599
6:	-0.174	-0.521
7:	0.427	-0.778
8:	0.100	-1.115
9:	-0.859	-1.154
10:	-0.505	-1.662

X CENTROID: -0.071
Y CENTROID: -0.356
POA TO CENTROID: 0.363
HORZ SPREAD: 1.286
VERT SPREAD: 2.299
GROUP SPREAD: 2.376
MIN RADIUS: 0.195
MAX RADIUS: 1.376
MEAN RADIUS: 0.797
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

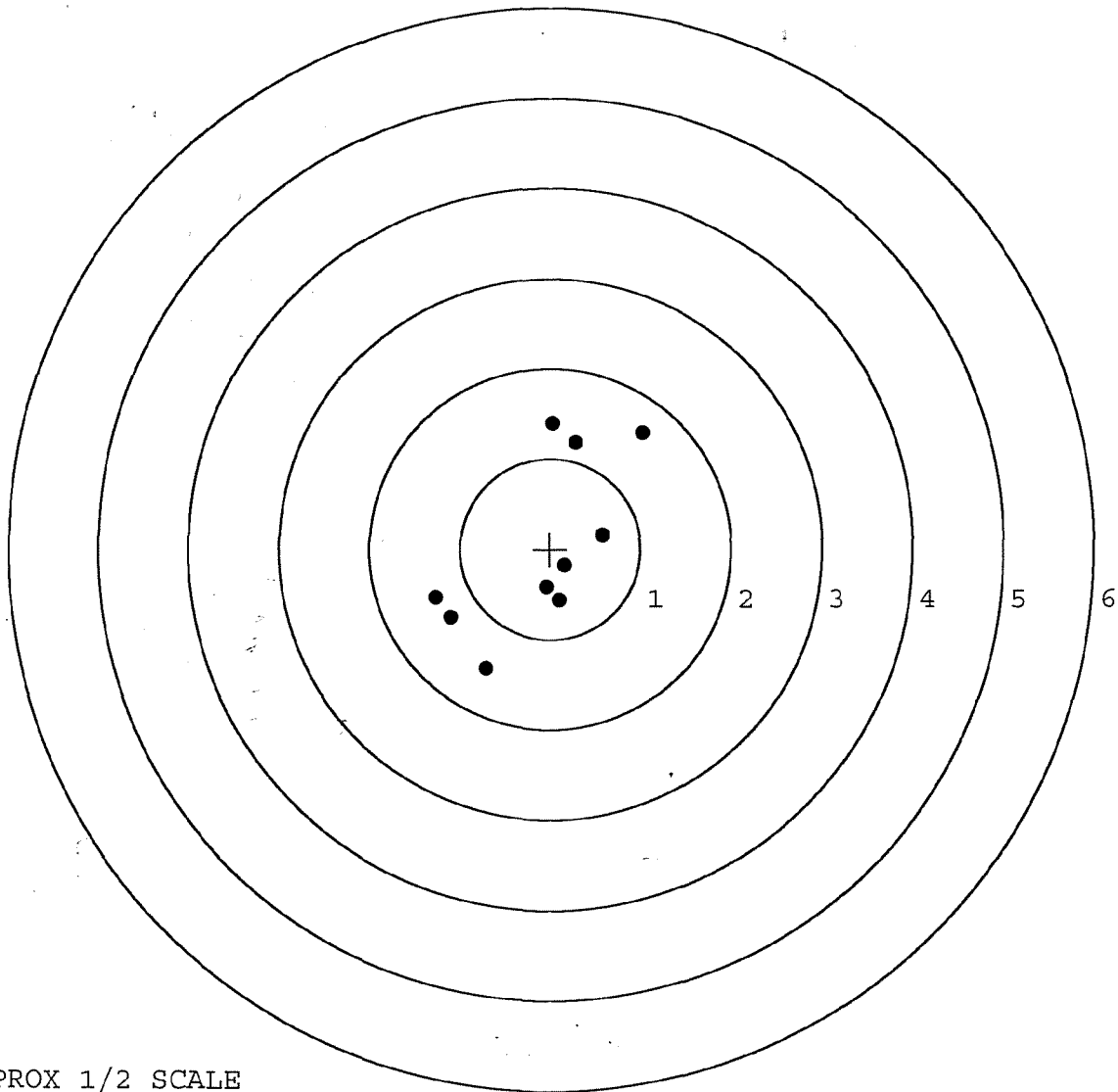


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414392: __0
TARGET NUMBER: 2
FILE DATE: 12/14/2004
FILE TIME: 11:42

X CENTROID: -0.096
Y CENTROID: 0.021
POA TO CENTROID: 0.098
HORZ SPREAD: 2.291
VERT SPREAD: 2.722
GROUP SPREAD: 3.143
MIN RADIUS: 0.330
MAX RADIUS: 1.688
MEAN RADIUS: 1.044
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.720	-1.331
2:	-1.106	-0.760
3:	-1.269	-0.541
4:	0.104	-0.568
5:	-0.043	-0.424
6:	0.163	-0.184
7:	0.579	0.160
8:	1.022	1.285
9:	0.285	1.180
10:	0.027	1.391

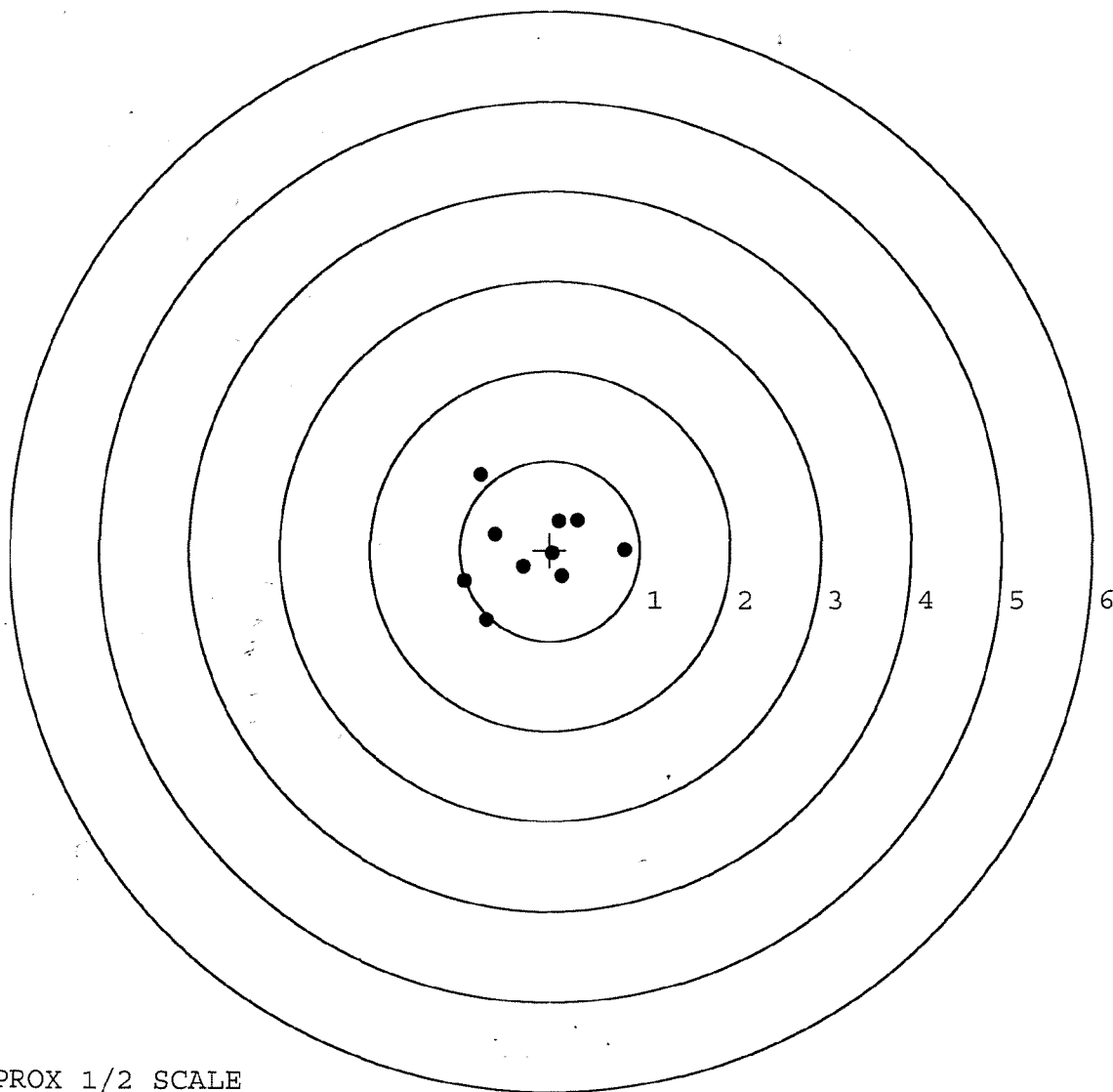


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414392:___0
TARGET NUMBER: 3
FILE DATE: 12/14/2004
FILE TIME: 11:42

POINT#	X	Y
1:	0.832	0.003
2:	0.306	0.332
3:	0.099	0.326
4:	0.140	-0.290
5:	-0.711	-0.767
6:	-0.949	-0.346
7:	-0.618	0.178
8:	-0.775	0.844
9:	0.031	-0.034
10:	-0.298	-0.184

X CENTROID: -0.194
Y CENTROID: 0.006
POA TO CENTROID: 0.194
HORZ SPREAD: 1.781
VERT SPREAD: 1.611
GROUP SPREAD: 1.815
MIN RADIUS: 0.217
MAX RADIUS: 1.026
MEAN RADIUS: 0.619
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

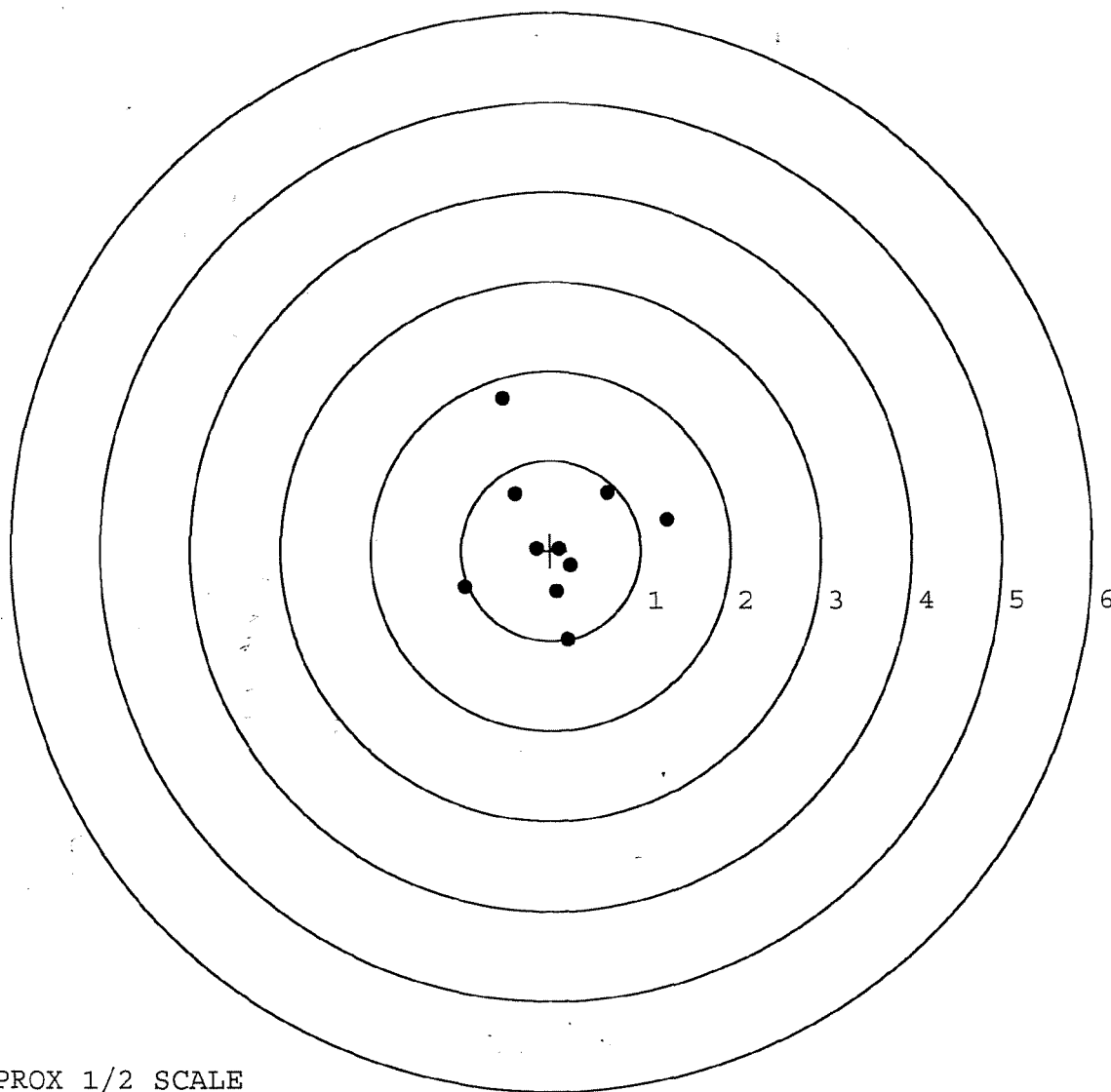


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414392. 0
TARGET NUMBER: 4
FILE DATE: 12/14/2004
FILE TIME: 11:42

X CENTROID: 0.046
Y CENTROID: 0.136
POA TO CENTROID: 0.143
HORZ SPREAD: 2.250
VERT SPREAD: 2.687
GROUP SPREAD: 2.784
MIN RADIUS: 0.121
MAX RADIUS: 1.667
MEAN RADIUS: 0.794
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.290	0.346
2:	0.633	0.646
3:	0.190	-0.990
4:	0.071	-0.459
5:	0.095	0.026
6:	-0.155	0.026
7:	-0.960	-0.400
8:	-0.394	0.631
9:	-0.540	1.697
10:	0.226	-0.163



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414392: __0

TARGET NUMBER: 5

FILE DATE: 12/14/2004

FILE TIME: 11:42

POINT#	X	Y
1:	0.169	-0.672
2:	0.013	-0.952
3:	0.937	0.164
4:	0.680	0.164
5:	1.410	0.610
6:	-0.172	0.487
7:	-0.093	-0.234
8:	-0.527	-0.397
9:	-0.550	-0.130
10:	-0.270	0.940

X CENTROID: 0.160

Y CENTROID: -0.002

POA TO CENTROID: 0.160

HORZ SPREAD: 1.960

VERT SPREAD: 1.892

GROUP SPREAD: 2.183

MIN RADIUS: 0.343

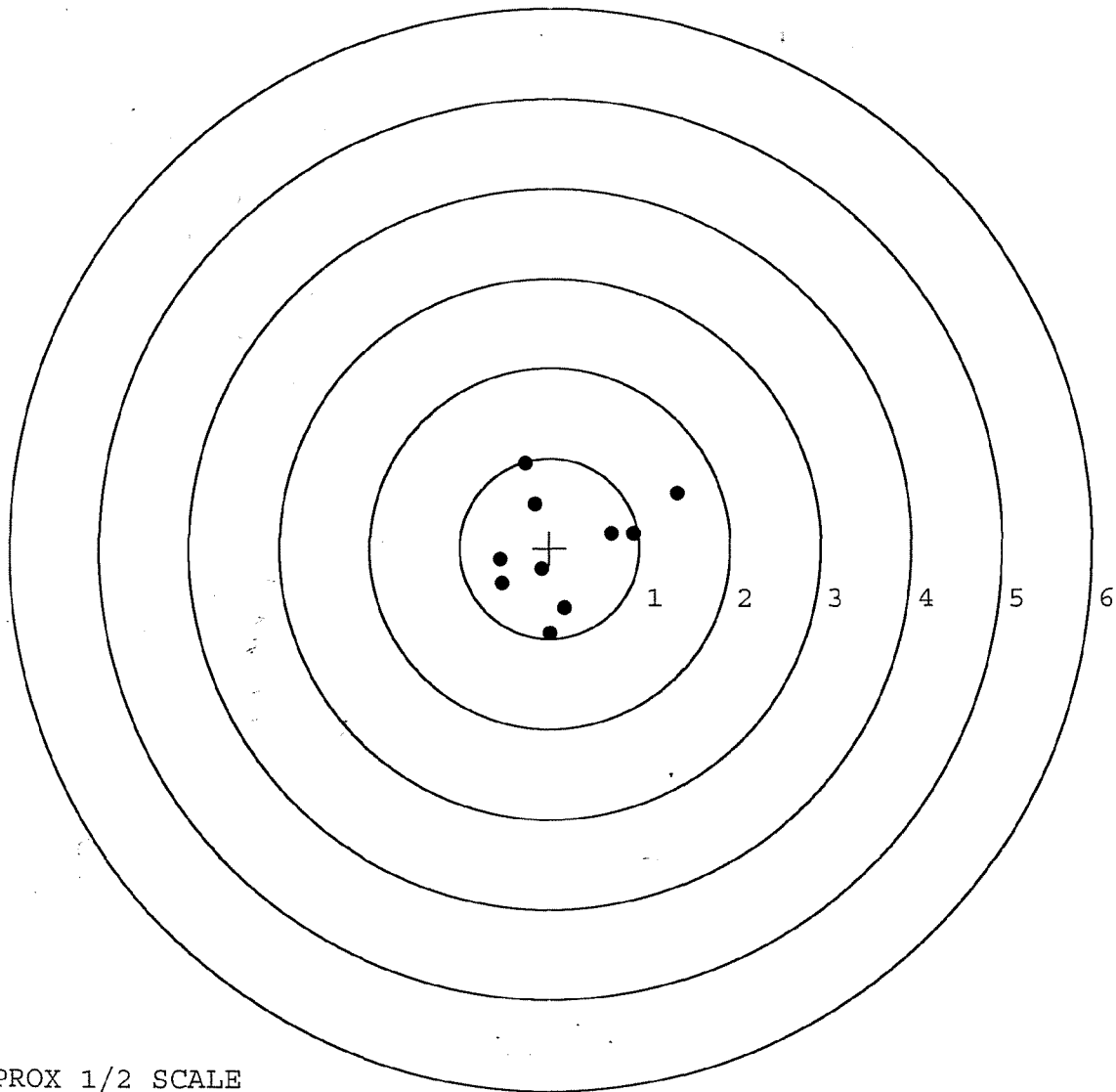
MAX RADIUS: 1.392

MEAN RADIUS: 0.785

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE