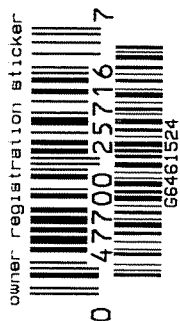


G646 1524

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

G6461524

UPC



ORDER 25716

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

UPC



0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



G6461524

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6461524

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-4-05	RTL
440	PROOF	MAGNA-FLUX	10-5-05	BG
460	CHECK HEADSPACE	INSPECTED	10-5-05	BG
470	DIS-ASSEMBLE ACTION	OCT 10 2005	10-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	6/18/80 OPERATOR <u>mm</u>	10/10/05	<u>mm</u>
500	ROLLMARK CALIBER		10-10-05	CW
510	DRILL AND TAP SIGHT HOLES		10-7-05	TRW
520	GOFF BLAST BBL / REC		10-14-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/19/05	TEB
	(BOLT)		10/19/05	TEB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10/20/05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/20/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/20/05	DA
	D) OIL FIRING PIN ASSEMBLY		10-20-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.9</u> <u>6.9</u>	11/11/05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>3.1</u>	11/11/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1022</u> <u>1023</u>	11/11/05	DA
	J) ASSEMBLE STOCK		10/26/05	RTL
	K) ASSEMBLE SWIVEL STUDS		11-17-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-17-05	BC
	M) IRON SIGHT ALIGNMENT		11-17-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-17-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10/27/05	MJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/27/05	mjm
670	FINAL INSPECTION A) HEADSPACE		11-17-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.82</u> <u>2.82</u> <u>2.88</u> <u>2.74</u>	11/11/05	DA
	C) FUNCTION		11-17-05	BC
690	PACK			

AVERAGE OF 10 CYCLES PER TEST

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 10-26-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.61	2.60		2.53	
PULL #2	2.54	2.53		2.27	
PULL #3	2.56	2.34		2.58	
PULL #4	2.41	2.61		2.53	
PULL #5	2.62	2.51		2.65	
TOTAL	12.74	12.59		12.56	
AVERAGE	2.54	2.51		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	2.91		
PULL #2	3.06	3.15		
PULL #3	2.94	3.06		
PULL #4	2.96	3.23		
PULL #5	3.11	3.19		
TOTAL	15.15	15.54		
AVERAGE	3.03	3.10		

	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	4.05	4.28		3.97
PULL #2	4.03	4.25		3.98
PULL #3	4.03	4.18		4.04
PULL #4	4.02	4.26		4.08
PULL #5	4.00	4.20		4.09
TOTAL	20.13	21.17		20.16
AVERAGE	4.02	4.23		4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461524.___0
FILE DATE AND TIME: 10/31/2005 11:35

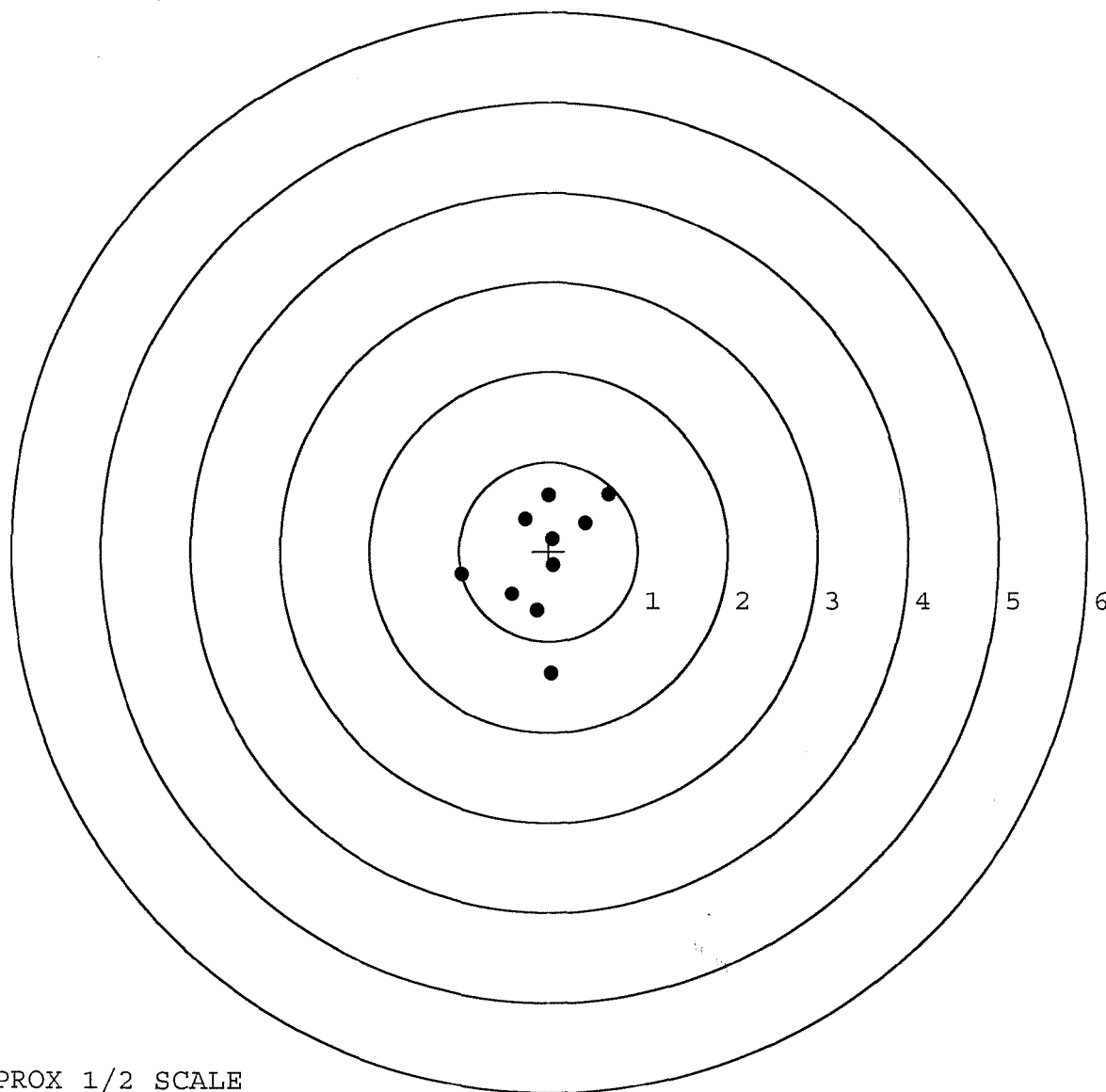
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.047
The Average Y Centroid of the Five Target Set:	-0.156
The Average Point of Impact of the Five Target Set:	0.162
The Average Mean Radius of the Five Target Set:	0.830
The Distance from POA to Centroid Target #1:	0.104
The Distance from Centroid Target #2 to Centroid Target #1:	0.170
The Distance from Centroid Target #3 to Centroid Target #1:	0.064
The Distance from Centroid Target #4 to Centroid Target #1:	0.125
The Distance from Centroid Target #5 to Centroid Target #1:	0.169

SERIAL NUMBER: G6461524. __0
TARGET NUMBER: 1
FILE DATE: 10/31/2005
FILE TIME: 11:35

POINT#	X	Y
1:	0.027	-1.354
2:	-0.134	-0.664
3:	-0.414	-0.479
4:	-0.972	-0.254
5:	0.050	-0.160
6:	0.044	0.135
7:	0.408	0.314
8:	0.668	0.635
9:	-0.013	0.626
10:	-0.270	0.357

X CENTROID: -0.061
Y CENTROID: -0.084
POA TO CENTROID: 0.104
HORZ SPREAD: 1.640
VERT SPREAD: 1.989
GROUP SPREAD: 2.090
MIN RADIUS: 0.134
MAX RADIUS: 1.273
MEAN RADIUS: 0.653
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

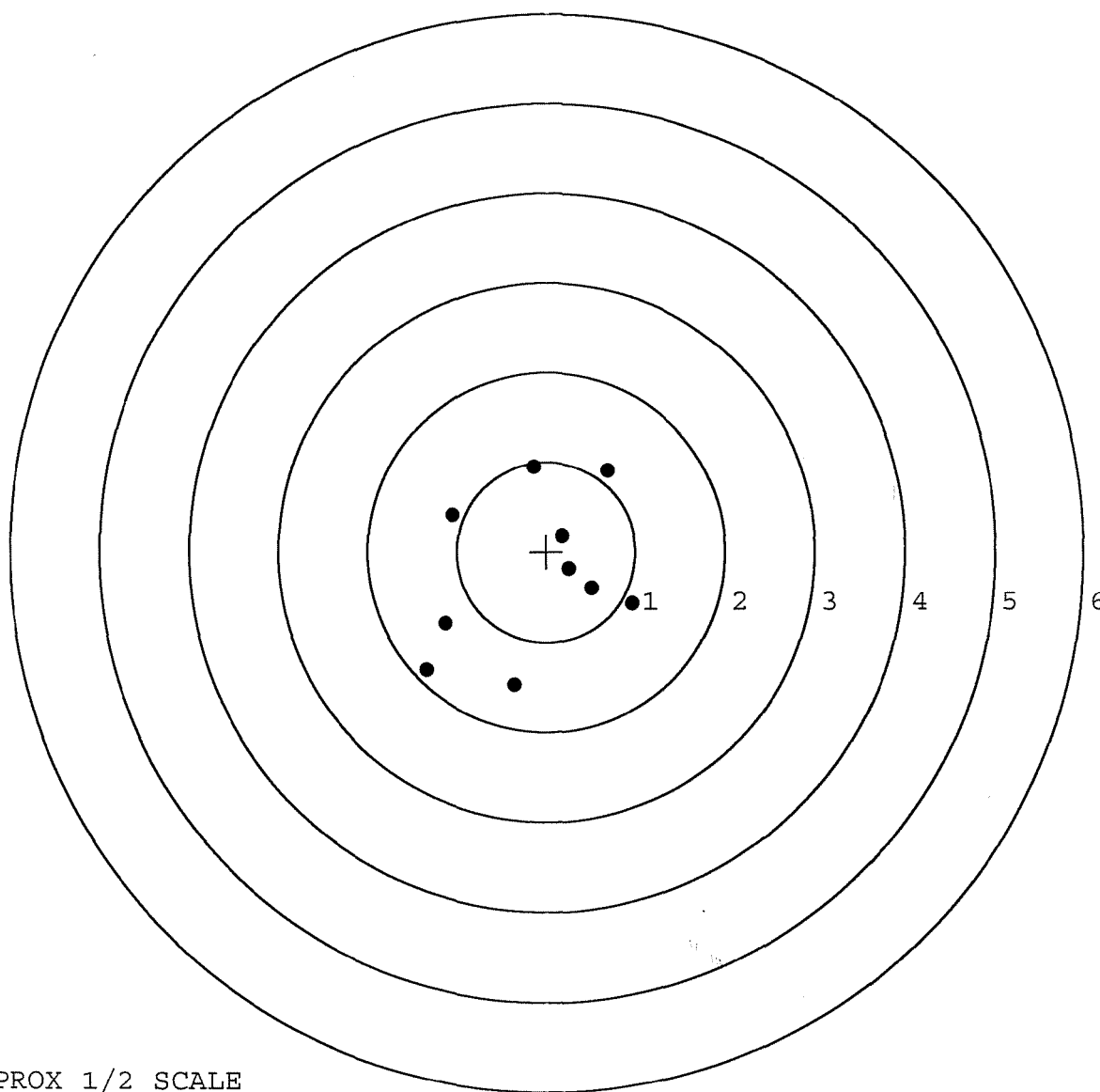


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461524. __0
TARGET NUMBER: 2
FILE DATE: 10/31/2005
FILE TIME: 11:35

X CENTROID: -0.144
Y CENTROID: -0.233
POA TO CENTROID: 0.274
HORZ SPREAD: 2.301
VERT SPREAD: 2.423
GROUP SPREAD: 3.003
MIN RADIUS: 0.403
MAX RADIUS: 1.612
MEAN RADIUS: 1.047
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.961	-0.574
2:	0.508	-0.406
3:	0.257	-0.189
4:	0.184	0.176
5:	0.688	0.902
6:	-0.142	0.946
7:	-1.054	0.402
8:	-1.134	-0.797
9:	-1.340	-1.313
10:	-0.364	-1.477

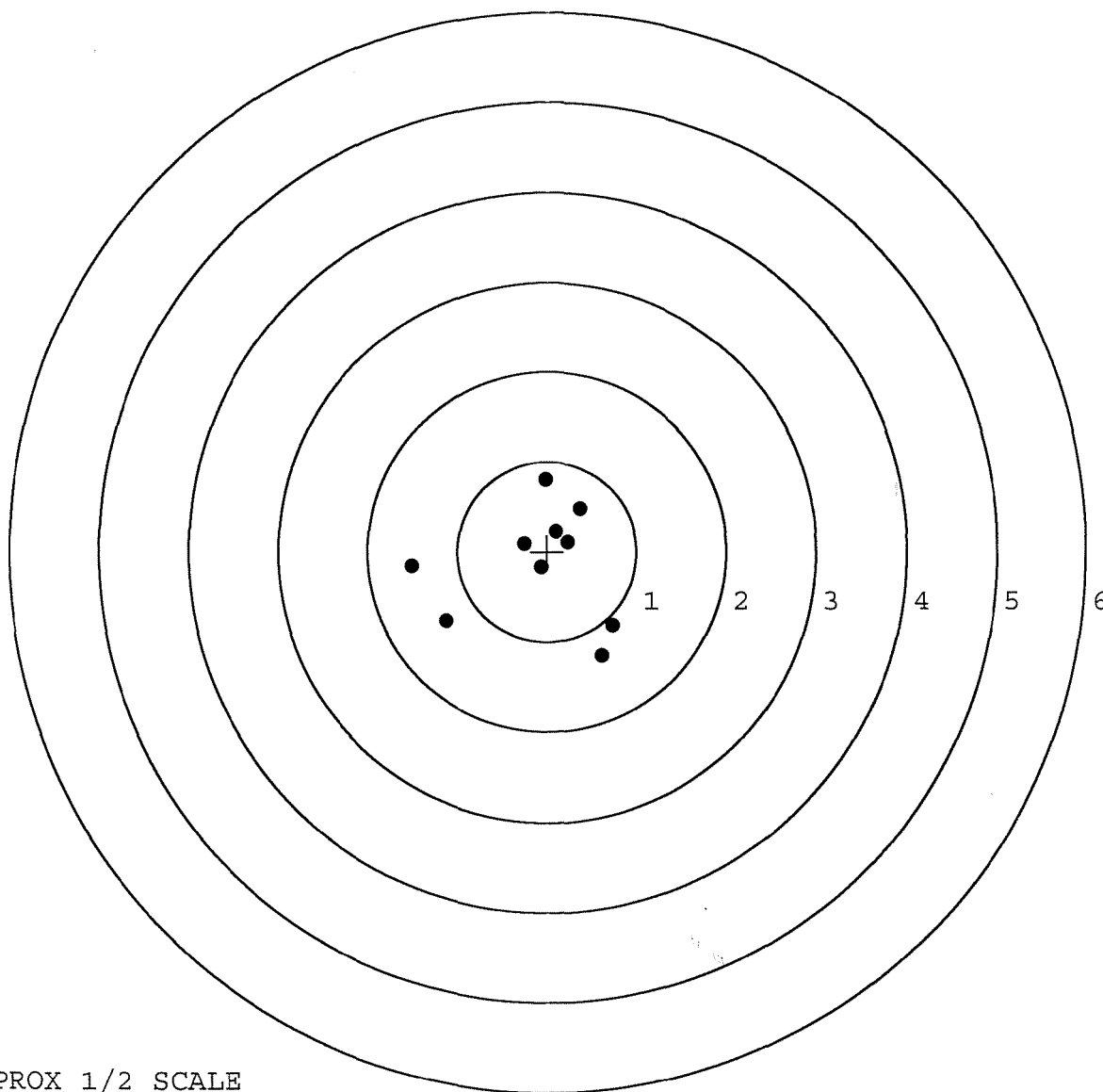


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461524. __0
TARGET NUMBER: 3
FILE DATE: 10/31/2005
FILE TIME: 11:35

X CENTROID: -0.093
Y CENTROID: -0.140
POA TO CENTROID: 0.168
HORZ SPREAD: 2.235
VERT SPREAD: 1.957
GROUP SPREAD: 2.347
MIN RADIUS: 0.045
MAX RADIUS: 1.414
MEAN RADIUS: 0.781
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.620	-1.159
2:	0.728	-0.822
3:	-0.069	-0.178
4:	0.237	0.113
5:	0.097	0.221
6:	-0.258	0.092
7:	0.370	0.479
8:	-0.024	0.798
9:	-1.507	-0.166
10:	-1.128	-0.777

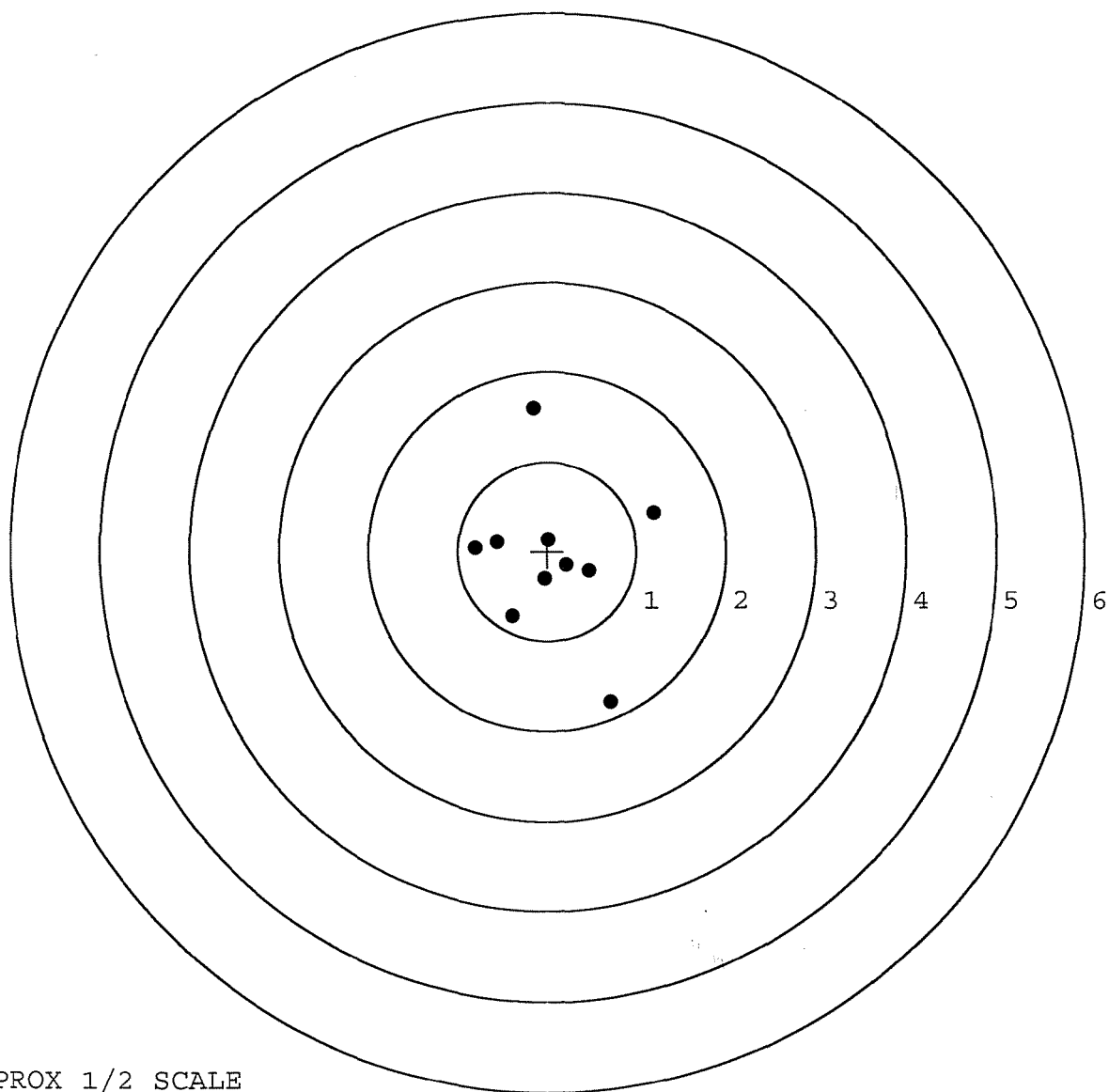


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461524. __0
TARGET NUMBER: 4
FILE DATE: 10/31/2005
FILE TIME: 11:35

POINT#	X	Y
1:	0.711	-1.674
2:	-0.396	-0.729
3:	1.191	0.430
4:	-0.163	1.593
5:	-0.801	0.041
6:	-0.561	0.110
7:	0.007	0.127
8:	0.215	-0.149
9:	0.473	-0.218
10:	-0.035	-0.313

X CENTROID: 0.064
Y CENTROID: -0.078
POA TO CENTROID: 0.101
HORZ SPREAD: 1.992
VERT SPREAD: 3.267
GROUP SPREAD: 3.382
MIN RADIUS: 0.167
MAX RADIUS: 1.722
MEAN RADIUS: 0.803
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

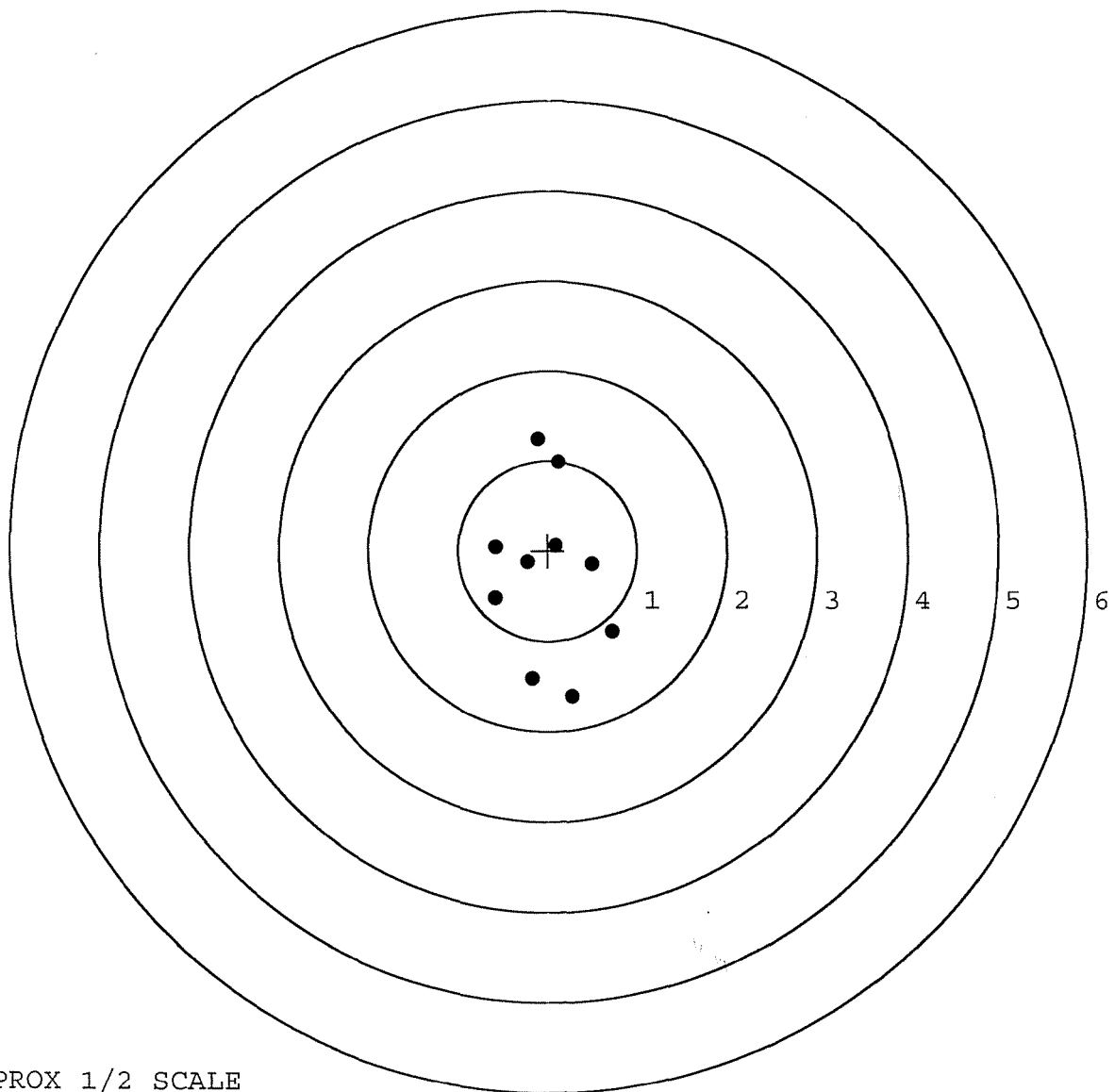


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461524. __ 0
TARGET NUMBER: 5
FILE DATE: 10/31/2005
FILE TIME: 11:35

X CENTROID: 0.000
Y CENTROID: -0.242
POA TO CENTROID: 0.242
HORZ SPREAD: 1.305
VERT SPREAD: 2.845
GROUP SPREAD: 2.872
MIN RADIUS: 0.253
MAX RADIUS: 1.481
MEAN RADIUS: 0.864
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.277	-1.611
2:	-0.178	-1.418
3:	0.716	-0.900
4:	0.494	-0.147
5:	0.087	0.056
6:	-0.227	-0.131
7:	-0.581	0.044
8:	-0.589	-0.532
9:	0.114	0.983
10:	-0.114	1.234



TARGET APPROX 1/2 SCALE