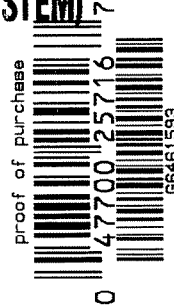


G-646 1593

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

- INSTRUCTION BOOK 3518

DD FORM

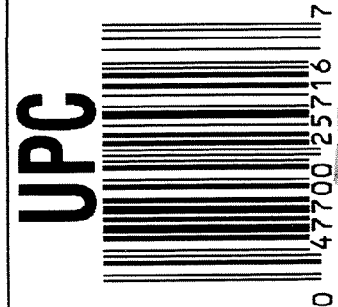


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461593



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 # G 6461593

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/1/05	CD
440	PROOF		11/1/05	CD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	11/1/05	CD
470	DIS-ASSEMBLE ACTION	JAN 05 2006	11/1/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 EJECTOR <i>mmg</i>	1/5/06	<i>mmg</i>
500	ROLLMARK CALIBER		1/5/06	CW
510	DRILL AND TAP SIGHT HOLES		1-5-06	BR
520	GOFF BLAST BBL / REC		1-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1/6/06	<i>mmg</i>
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-9-06	BG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-9-06	BG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-9-06	BG
	D) OIL FIRING PIN ASSEMBLY		1-9-06	BG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1-10-06	AE

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.0</u> <u>5.75</u>	1-10-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>2.25</u> <u>2.25</u>	1-10-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		1-10-06	AC
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	1-10-09	TRW
	J) ASSEMBLE STOCK		1-9-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		1-10-06	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-9-06	BG
	M) IRON SIGHT ALIGNMENT		1-9-06	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-9-06	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-9-06	mjm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1/9/06	mfg
670	FINAL INSPECTION A) HEADSPACE		1-10-06	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.16</u> <u>2.21</u> <u>2.22</u> <u>2.21</u>	1-10-06	TRW
	C) FUNCTION		1-10-06	AC
690	PACK		1-11-06	RTA

**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 1-7-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.52		2.58	
PULL #2	2.51	2.56		2.60	
PULL #3	2.43	2.51		2.40	
PULL #4	2.43	2.66		2.63	
PULL #5	2.37	2.47		2.64	
TOTAL	12.24	12.72		12.85	
AVERAGE	2.44	2.54		2.57	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.96	2.95		
PULL #2	3.20	3.04		
PULL #3	3.12	2.91		
PULL #4	3.05	3.05		
PULL #5	3.07	2.91		
TOTAL	15.40	14.86		
AVERAGE	3.08	2.97		

	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	4.24	4.15		4.15
PULL #2	4.27	4.26		4.18
PULL #3	4.17	4.25		4.18
PULL #4	4.27	4.26		4.27
PULL #5	4.21	4.22		4.09
TOTAL	21.16	21.14		20.87
AVERAGE	4.23	4.22		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461593.___0
FILE DATE AND TIME: 01/09/2006 23:18

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.188
The Average Y Centroid of the Five Target Set:	0.068
The Average Point of Impact of the Five Target Set:	0.200
The Average Mean Radius of the Five Target Set:	0.799
The Distance from POA to Centroid Target #1:	0.209
The Distance from Centroid Target #2 to Centroid Target #1:	0.190
The Distance from Centroid Target #3 to Centroid Target #1:	0.260
The Distance from Centroid Target #4 to Centroid Target #1:	0.144
The Distance from Centroid Target #5 to Centroid Target #1:	0.598

SERIAL NUMBER: G6461593. 0

TARGET NUMBER: 1

FILE DATE: 01/09/2006

FILE TIME: 23:18

POINT#	X	Y
--------	---	---

1:	-0.899	1.043
----	--------	-------

2:	-0.435	0.803
----	--------	-------

3:	-0.577	0.423
----	--------	-------

4:	-0.379	0.177
----	--------	-------

5:	-0.409	-0.294
----	--------	--------

6:	-0.484	-1.000
----	--------	--------

7:	-0.016	-1.189
----	--------	--------

8:	0.119	-0.419
----	-------	--------

9:	0.683	-0.344
----	-------	--------

10:	0.647	-0.351
-----	-------	--------

X CENTROID: -0.175

Y CENTROID: -0.115

POA TO CENTROID: 0.209

HORZ SPREAD: 1.582

VERT SPREAD: 2.232

GROUP SPREAD: 2.400

MIN RADIUS: 0.295

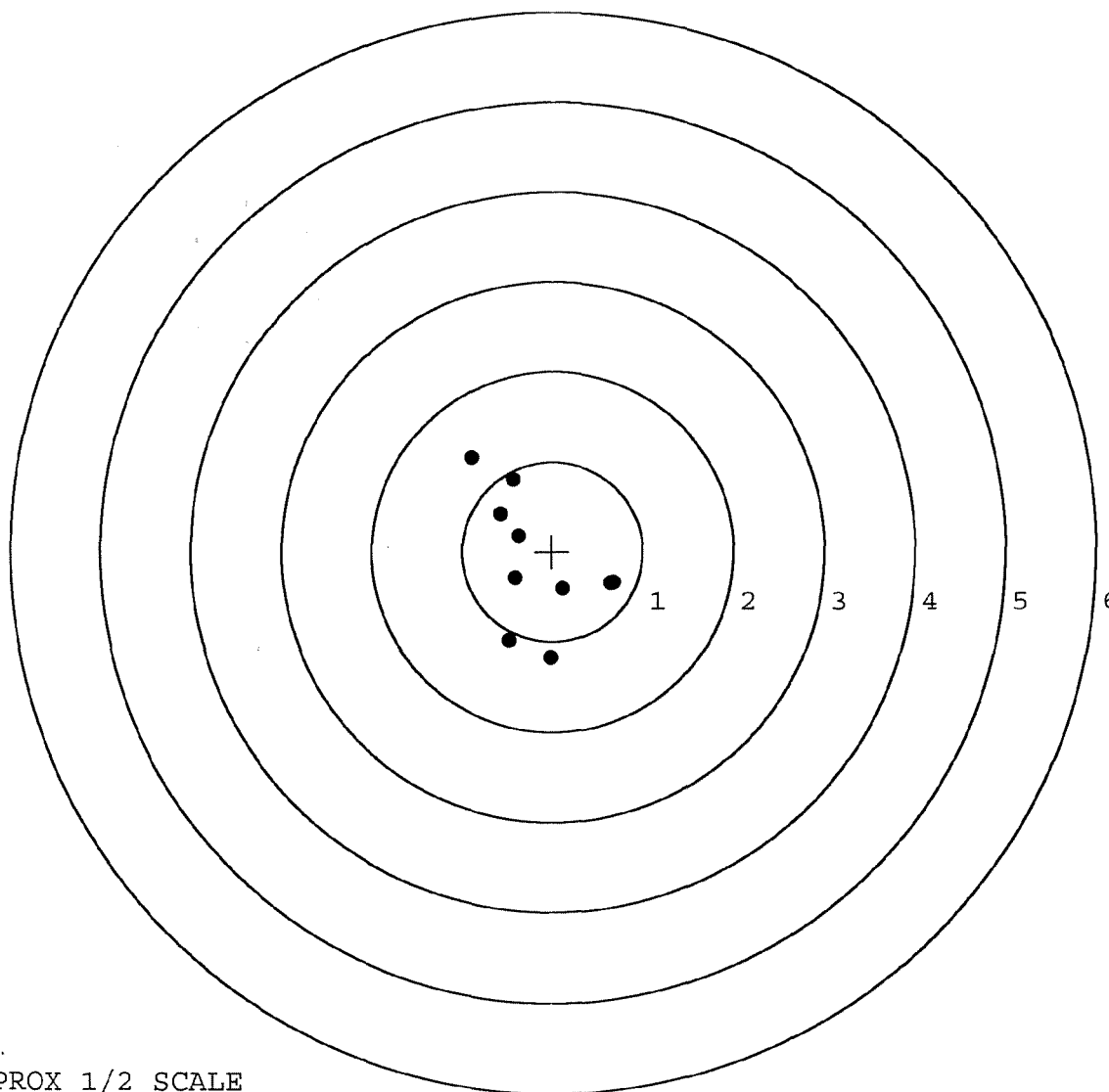
MAX RADIUS: 1.366

MEAN RADIUS: 0.783

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

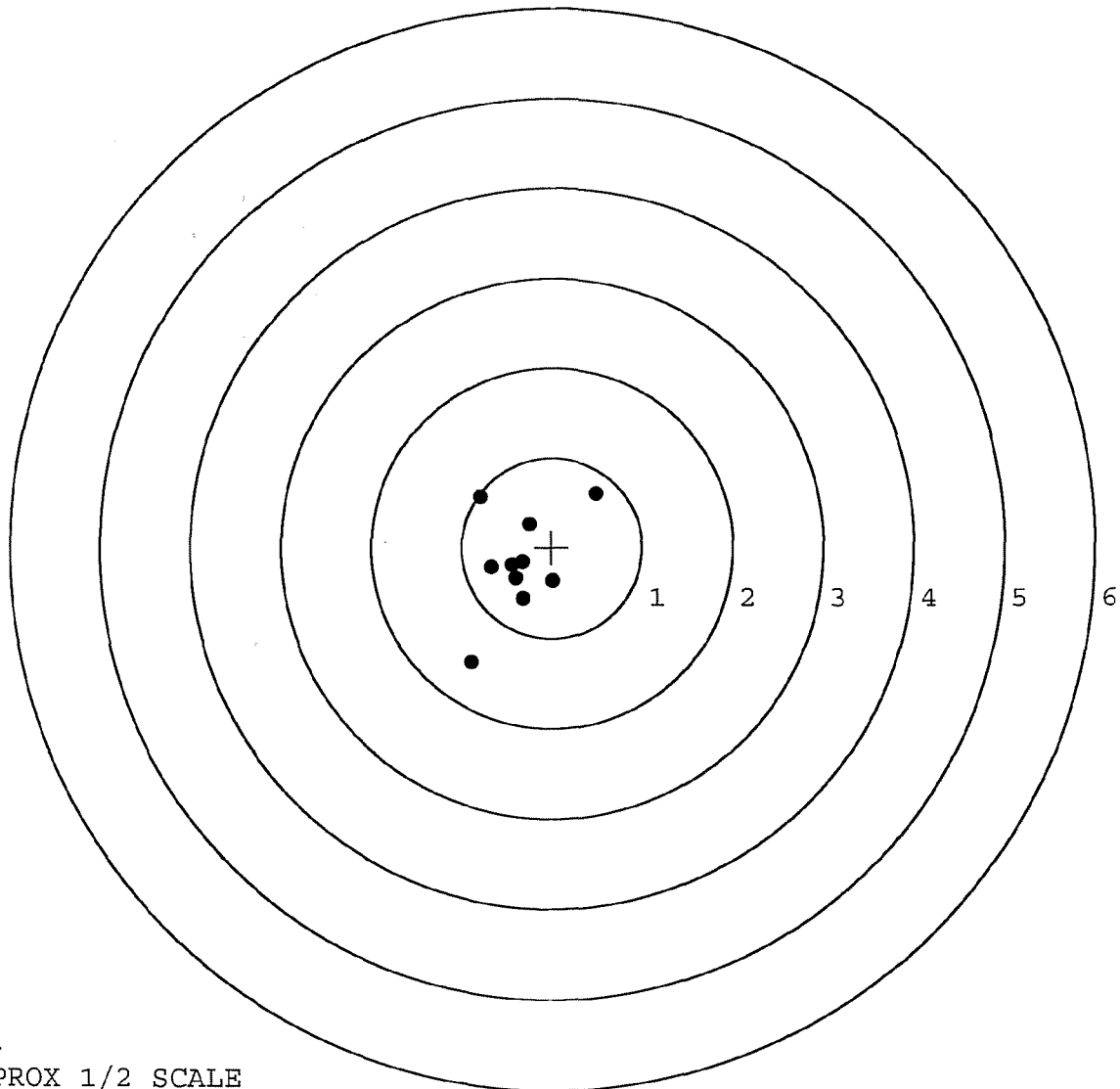


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461593. __ 0
TARGET NUMBER: 2
FILE DATE: 01/09/2006
FILE TIME: 23:18

POINT#	X	Y
1:	-0.798	0.560
2:	-0.251	0.257
3:	0.490	0.604
4:	0.016	-0.374
5:	-0.320	-0.165
6:	-0.673	-0.223
7:	-0.314	-0.567
8:	-0.886	-1.269
9:	-0.395	-0.341
10:	-0.437	-0.195

X CENTROID: -0.357
Y CENTROID: -0.171
POA TO CENTROID: 0.396
HORZ SPREAD: 1.376
VERT SPREAD: 1.873
GROUP SPREAD: 2.324
MIN RADIUS: 0.037
MAX RADIUS: 1.219
MEAN RADIUS: 0.510
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

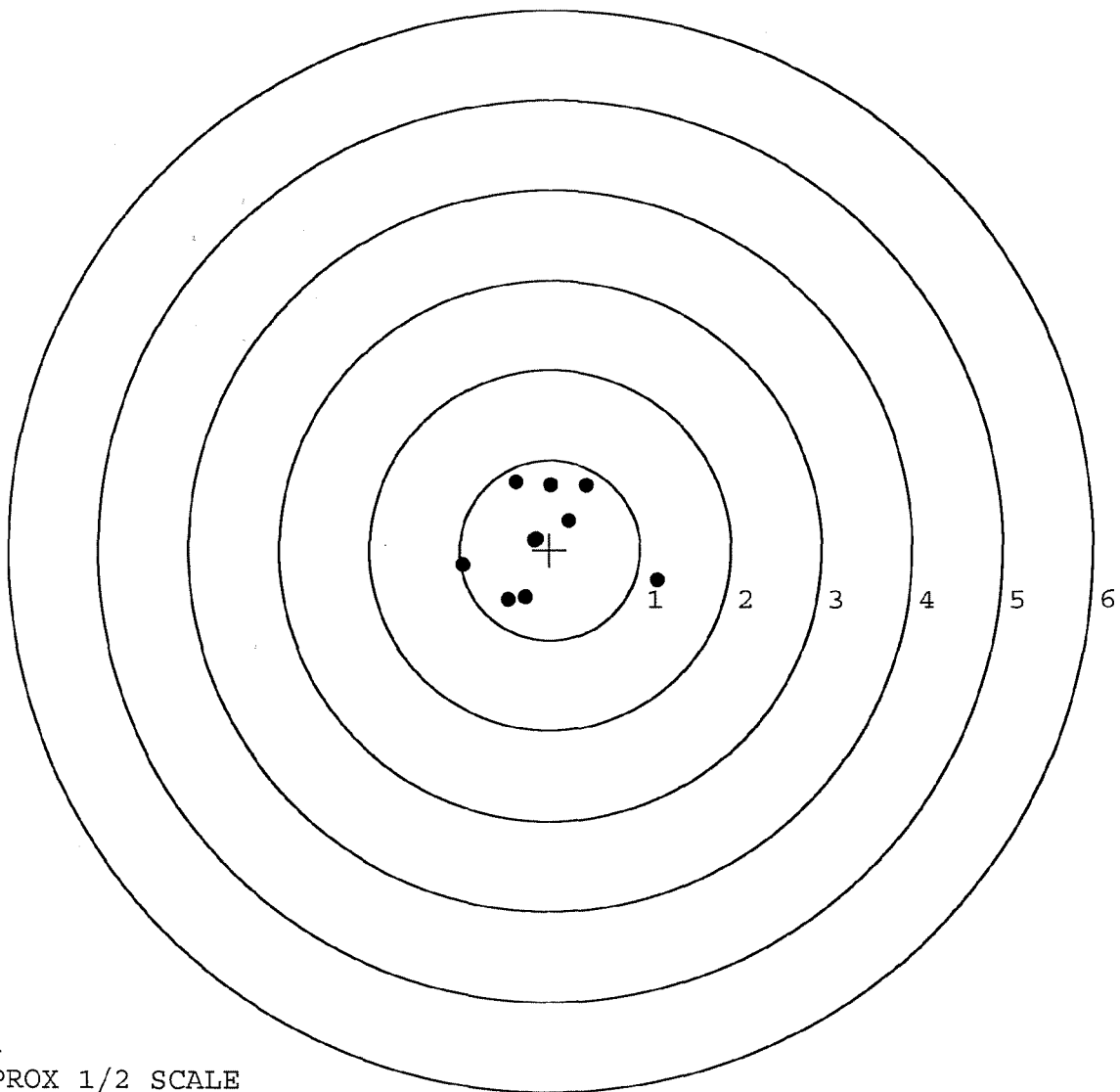


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461593. __0
TARGET NUMBER: 3
FILE DATE: 01/09/2006
FILE TIME: 23:18

POINT#	X	Y
1:	-0.377	0.759
2:	0.007	0.726
3:	0.406	0.723
4:	0.207	0.322
5:	-0.175	0.109
6:	-0.964	-0.173
7:	-0.462	-0.554
8:	-0.268	-0.529
9:	1.192	-0.337
10:	-0.154	0.124

X CENTROID: -0.059
Y CENTROID: 0.117
POA TO CENTROID: 0.131
HORZ SPREAD: 2.156
VERT SPREAD: 1.313
GROUP SPREAD: 2.162
MIN RADIUS: 0.095
MAX RADIUS: 1.331
MEAN RADIUS: 0.638
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461593. __0

TARGET NUMBER: 4

FILE DATE: 01/09/2006

FILE TIME: 23:18

POINT#	X	Y
--------	---	---

1:	0.130	0.567
----	-------	-------

2:	0.511	0.422
----	-------	-------

3:	0.452	-0.095
----	-------	--------

4:	1.180	-0.423
----	-------	--------

5:	-0.017	1.234
----	--------	-------

6:	-0.642	1.610
----	--------	-------

7:	-1.113	-0.351
----	--------	--------

8:	-1.498	-0.473
----	--------	--------

9:	-1.049	-1.173
----	--------	--------

10:	0.467	-1.044
-----	-------	--------

X CENTROID: -0.158

Y CENTROID: 0.027

POA TO CENTROID: 0.160

HORZ SPREAD: 2.678

VERT SPREAD: 2.783

GROUP SPREAD: 2.876

MIN RADIUS: 0.612

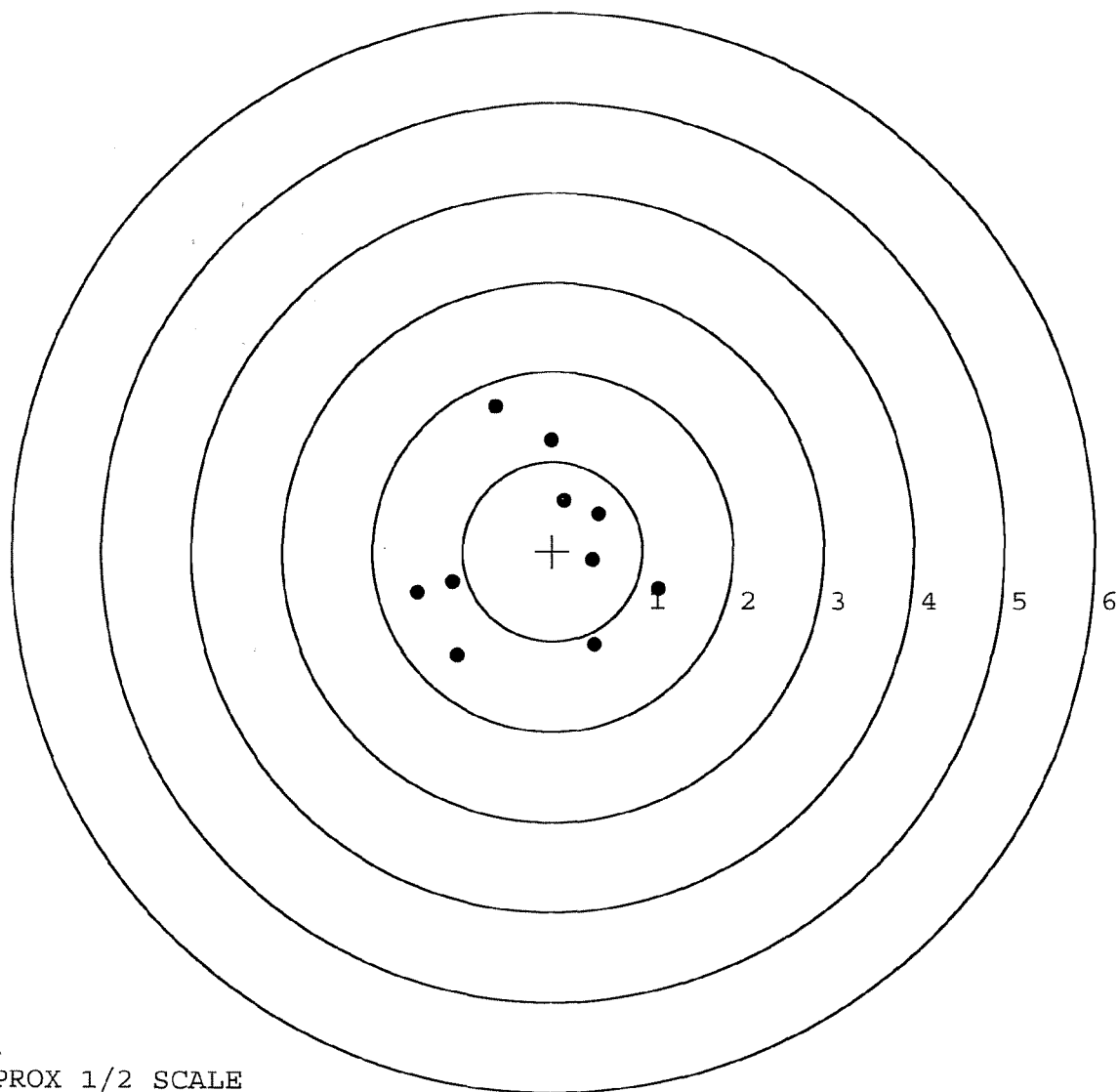
MAX RADIUS: 1.655

MEAN RADIUS: 1.148

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 9



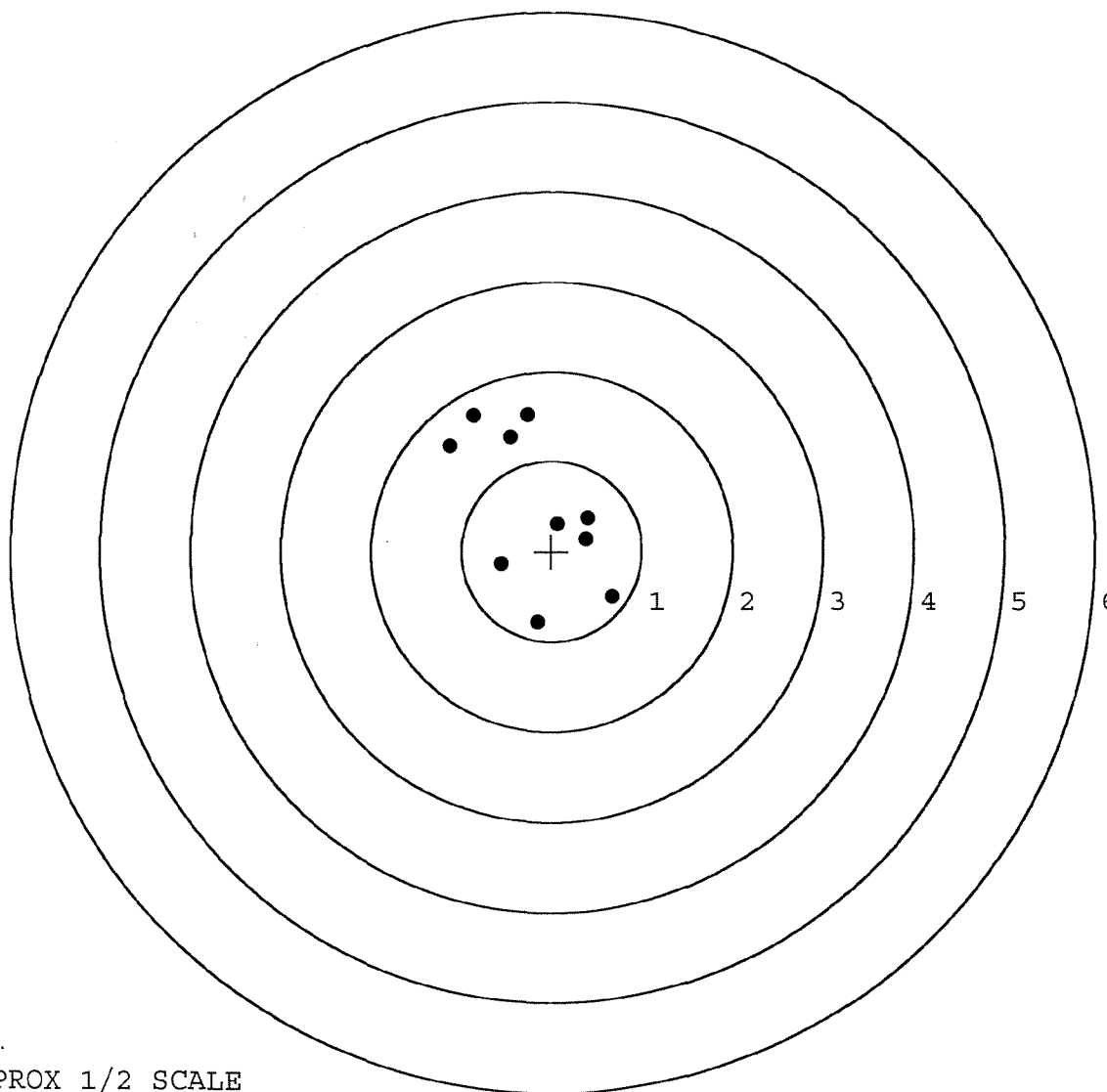
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461593. 0
TARGET NUMBER: 5
FILE DATE: 01/09/2006
FILE TIME: 23:18

X CENTROID: -0.193
Y CENTROID: 0.482
POA TO CENTROID: 0.519
HORZ SPREAD: 1.811
VERT SPREAD: 2.309
GROUP SPREAD: 2.536
MIN RADIUS: 0.313
MAX RADIUS: 1.317
MEAN RADIUS: 0.915

POINT#	X	Y
1:	0.063	0.302
2:	0.395	0.372
3:	0.386	0.138
4:	0.679	-0.505
5:	-0.160	-0.790
6:	-0.554	-0.143
7:	-1.132	1.163
8:	-0.871	1.502
9:	-0.466	1.265
10:	-0.268	1.519

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE