

G646 1602

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

- INSTRUCTION BOOK 3518

DD FORM



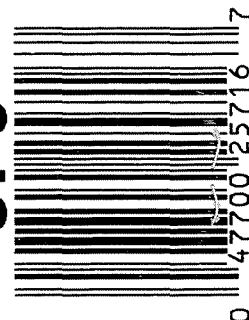
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461602

UPC



ORDER 25716

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

UPC



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

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C66461602

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	Ac
460	CHECK HEADSPACE		8-12-05	Ac
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		SEP 17 2005 OPERATOR	JD
500	ROLLMARK CALIBER		9-8-05	CWJ
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-12-05	WJ
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-6-05	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-05	MTM
	D) OIL FIRING PIN ASSEMBLY		10-10-05	RTZ
	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>6.0</u> <u>6.0</u> <u>6.5</u>	10/18/05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	10/18/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	10/18/05	DA
	J) ASSEMBLE STOCK		10-10-05	RT
	K) ASSEMBLE SWIVEL STUDS		10-18-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-12-05	AK
	M) IRON SIGHT ALIGNMENT		10-12-05	AK
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-12-05	AK
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	10/14/05	MJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	OK	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-14-05	MDM
670	FINAL INSPECTION A) HEADSPACE		10-18-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u> <u>2.45</u> <u>2.57</u> <u>2.99</u> <u>2.89</u>	10-17-05	TRL
	C) FUNCTION		10-18-05	BC
690	PACK		10/29/05	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 _____

TESTER _____

10/4/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.39	2.69		2.84	
PULL #2	2.46	2.80		2.90	
PULL #3	2.44	2.72		2.66	
PULL #4	2.67	2.63		2.79	
PULL #5	2.81	2.76		2.78	
TOTAL	12.77	13.60		13.97	
AVERAGE	2.55	2.72		2.79	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.98	3.28		
PULL #2	3.32	3.34		
PULL #3	3.39	3.36		
PULL #4	3.40	3.36		
PULL #5	3.28	3.43		
TOTAL	16.37	16.77		
AVERAGE	3.27	3.35		

	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	4.49	4.17		4.25
PULL #2	4.26	4.23		3.86
PULL #3	4.31	4.16		4.09
PULL #4	4.28	4.16		4.34
PULL #5	4.30	4.31		4.32
TOTAL	21.64	21.03		20.86
AVERAGE	4.33	4.21		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461602.___0

FILE DATE AND TIME: 10/14/2005 18:22

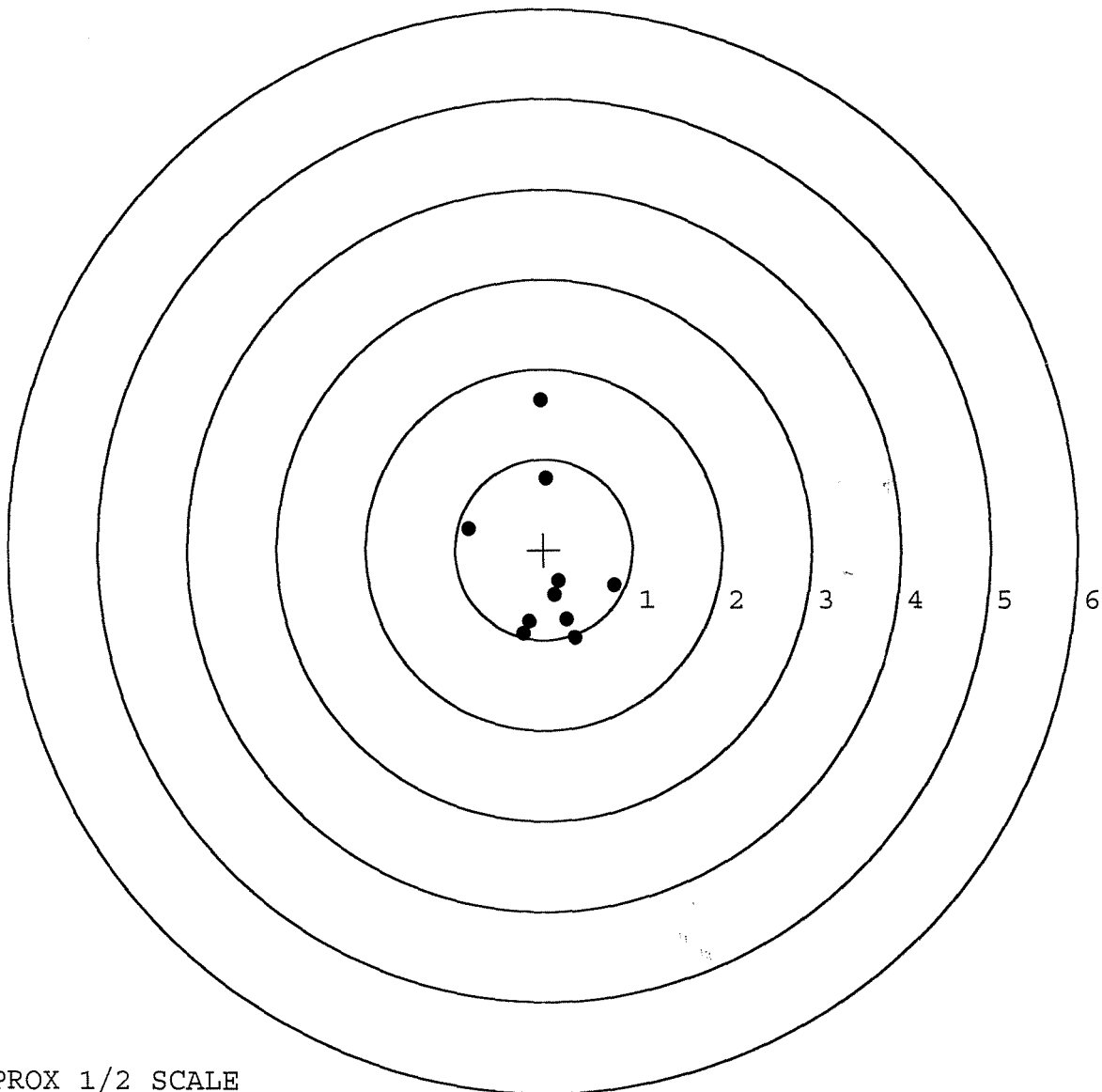
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.020
The Average Y Centroid of the Five Target Set:	-0.005
The Average Point of Impact of the Five Target Set:	0.020
The Average Mean Radius of the Five Target Set:	0.792
The Distance from POA to Centroid Target #1:	0.210
The Distance from Centroid Target #2 to Centroid Target #1:	0.118
The Distance from Centroid Target #3 to Centroid Target #1:	0.389
The Distance from Centroid Target #4 to Centroid Target #1:	0.348
The Distance from Centroid Target #5 to Centroid Target #1:	0.373

SERIAL NUMBER: G6461602.___0
TARGET NUMBER: 1
FILE DATE: 10/14/2005
FILE TIME: 18:22

X CENTROID: 0.041
Y CENTROID: -0.206
POA TO CENTROID: 0.210
HORZ SPREAD: 1.640
VERT SPREAD: 2.634
GROUP SPREAD: 2.664
MIN RADIUS: 0.189
MAX RADIUS: 1.864
MEAN RADIUS: 0.798
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.164	-0.349
2:	0.114	-0.505
3:	-0.173	-0.804
4:	-0.230	-0.939
5:	0.357	-0.978
6:	0.256	-0.776
7:	0.790	-0.388
8:	0.023	0.792
9:	-0.044	1.656
10:	-0.850	0.227

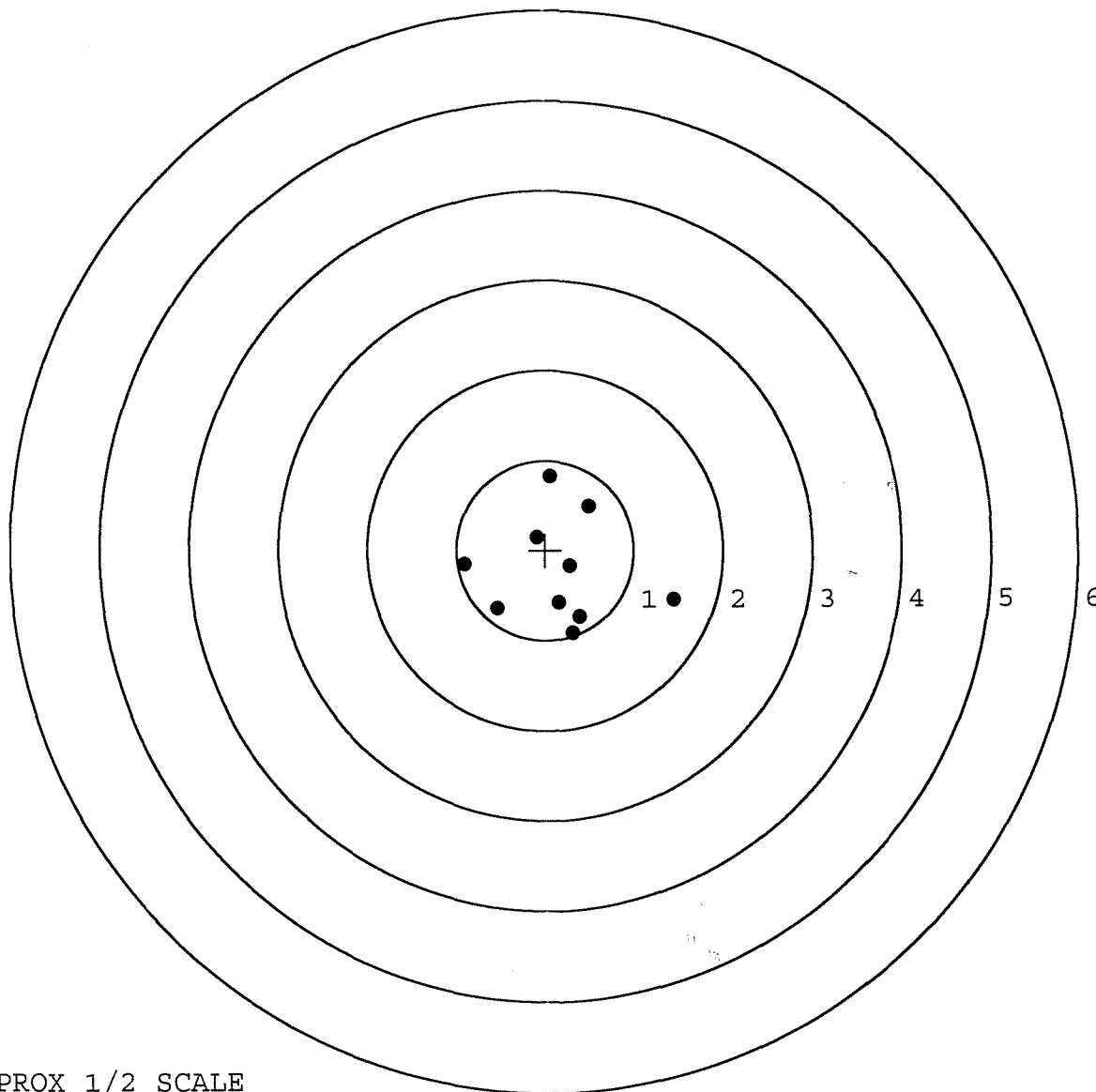


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461602. __0
TARGET NUMBER: 2
FILE DATE: 10/14/2005
FILE TIME: 18:22

X CENTROID: 0.155
Y CENTROID: -0.233
POA TO CENTROID: 0.280
HORZ SPREAD: 2.358
VERT SPREAD: 1.751
GROUP SPREAD: 2.391
MIN RADIUS: 0.133
MAX RADIUS: 1.329
MEAN RADIUS: 0.729
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.492	0.488
2:	0.054	0.826
3:	-0.913	-0.156
4:	-0.549	-0.650
5:	0.308	-0.925
6:	0.387	-0.743
7:	0.153	-0.582
8:	0.276	-0.177
9:	1.445	-0.554
10:	-0.099	0.146



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461602. __0

TARGET NUMBER: 3

FILE DATE: 10/14/2005

FILE TIME: 18:22

POINT#	X	Y
1:	-0.252	-0.217
2:	-0.500	-0.373
3:	-0.530	0.364
4:	-0.077	0.432
5:	0.312	0.200
6:	0.252	-0.092
7:	0.806	0.052
8:	0.235	-0.831
9:	-1.326	0.445
10:	-0.786	1.113

X CENTROID: -0.187

Y CENTROID: 0.109

POA TO CENTROID: 0.216

HORZ SPREAD: 2.132

VERT SPREAD: 1.944

GROUP SPREAD: 2.168

MIN RADIUS: 0.333

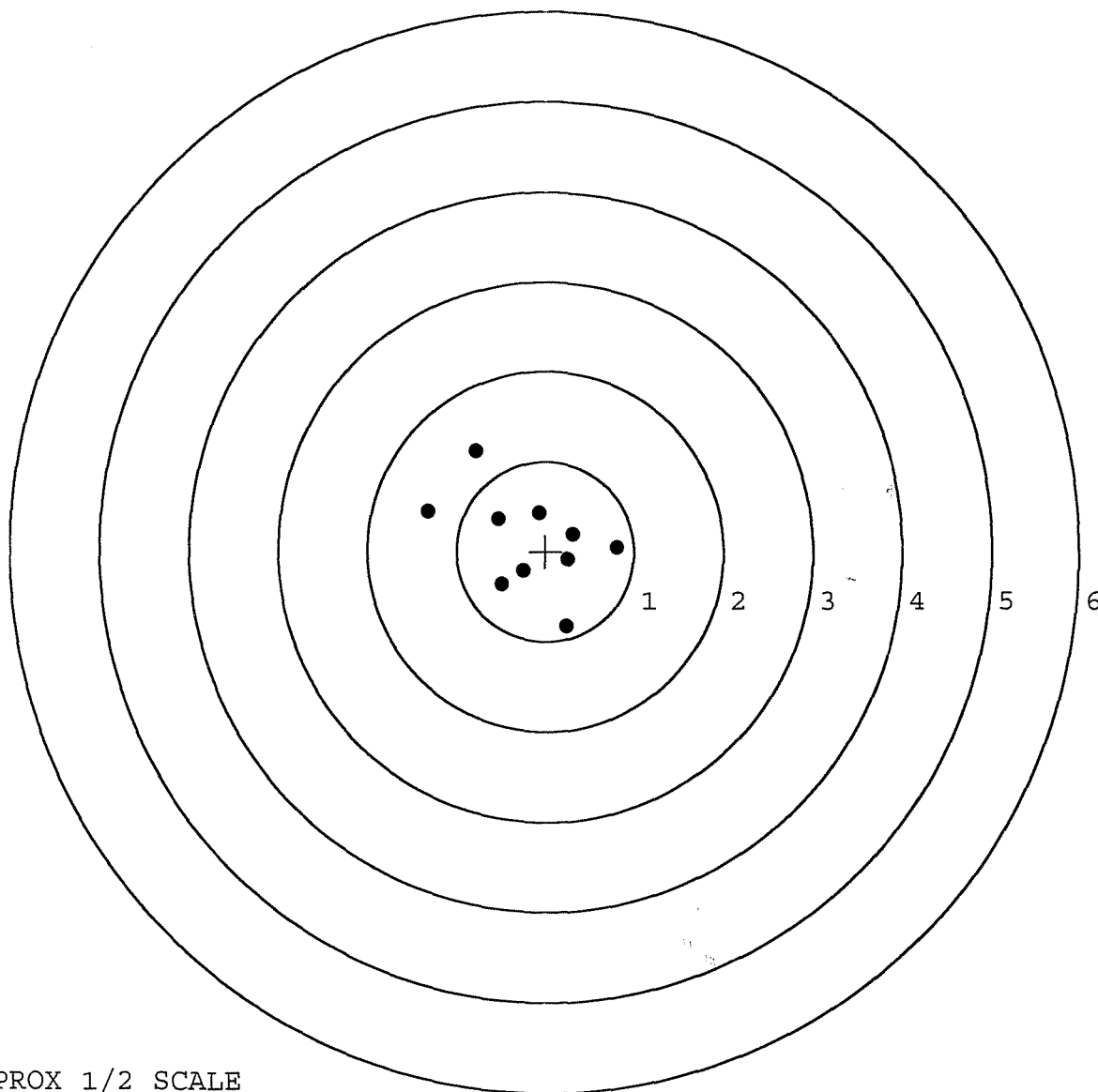
MAX RADIUS: 1.188

MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461602. __0

TARGET NUMBER: 4

FILE DATE: 10/14/2005

FILE TIME: 18:22

POINT#	X	Y
1:	-0.100	0.223
2:	-0.096	0.863
3:	-0.335	0.854
4:	-1.402	0.566
5:	-0.223	-0.446
6:	-0.334	-0.719
7:	0.774	-0.377
8:	1.598	0.048
9:	0.326	0.057
10:	0.526	0.331

X CENTROID: 0.073

Y CENTROID: 0.140

POA TO CENTROID: 0.158

HORZ SPREAD: 3.000

VERT SPREAD: 1.582

GROUP SPREAD: 3.044

MIN RADIUS: 0.192

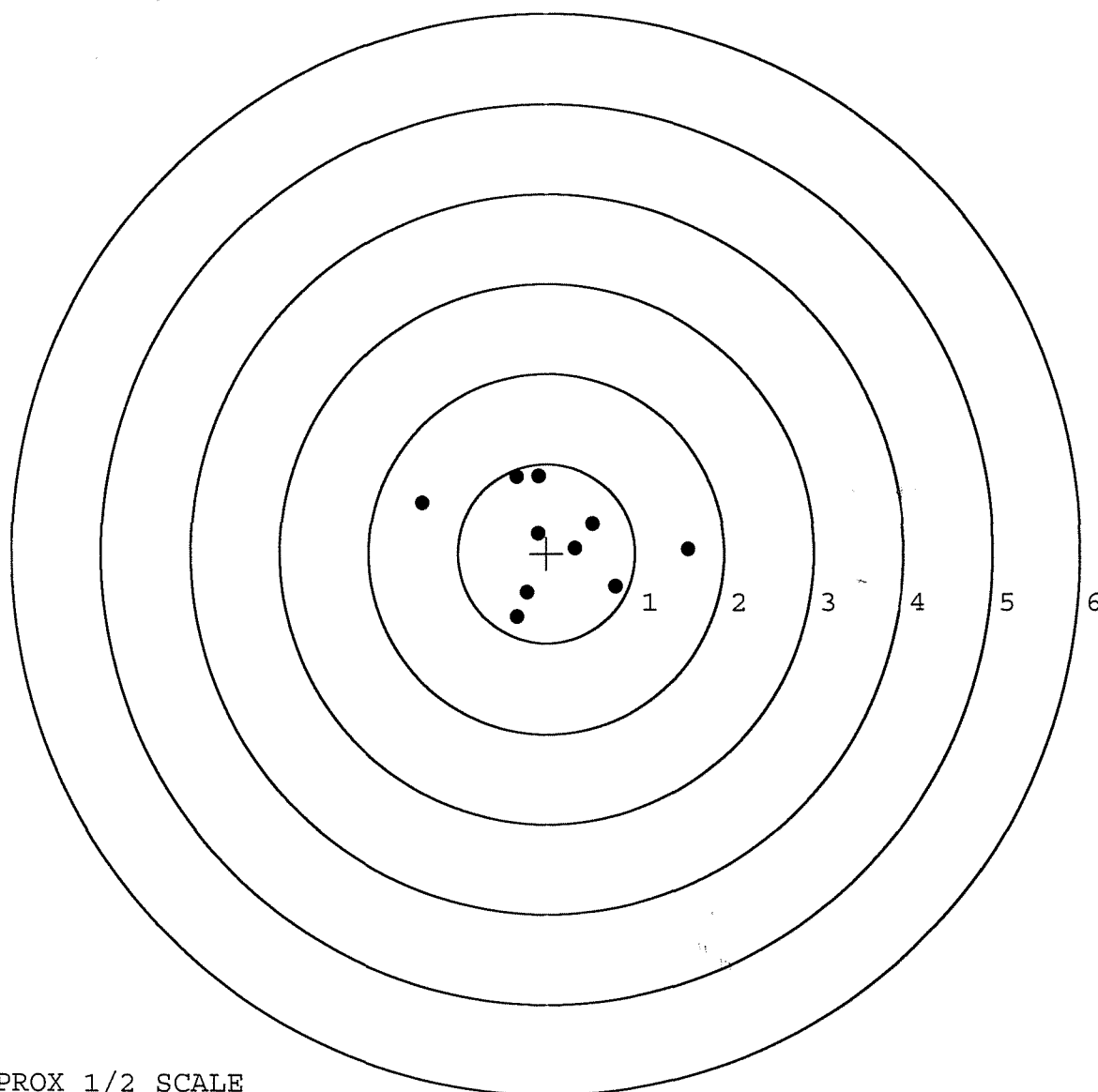
MAX RADIUS: 1.536

MEAN RADIUS: 0.806

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8

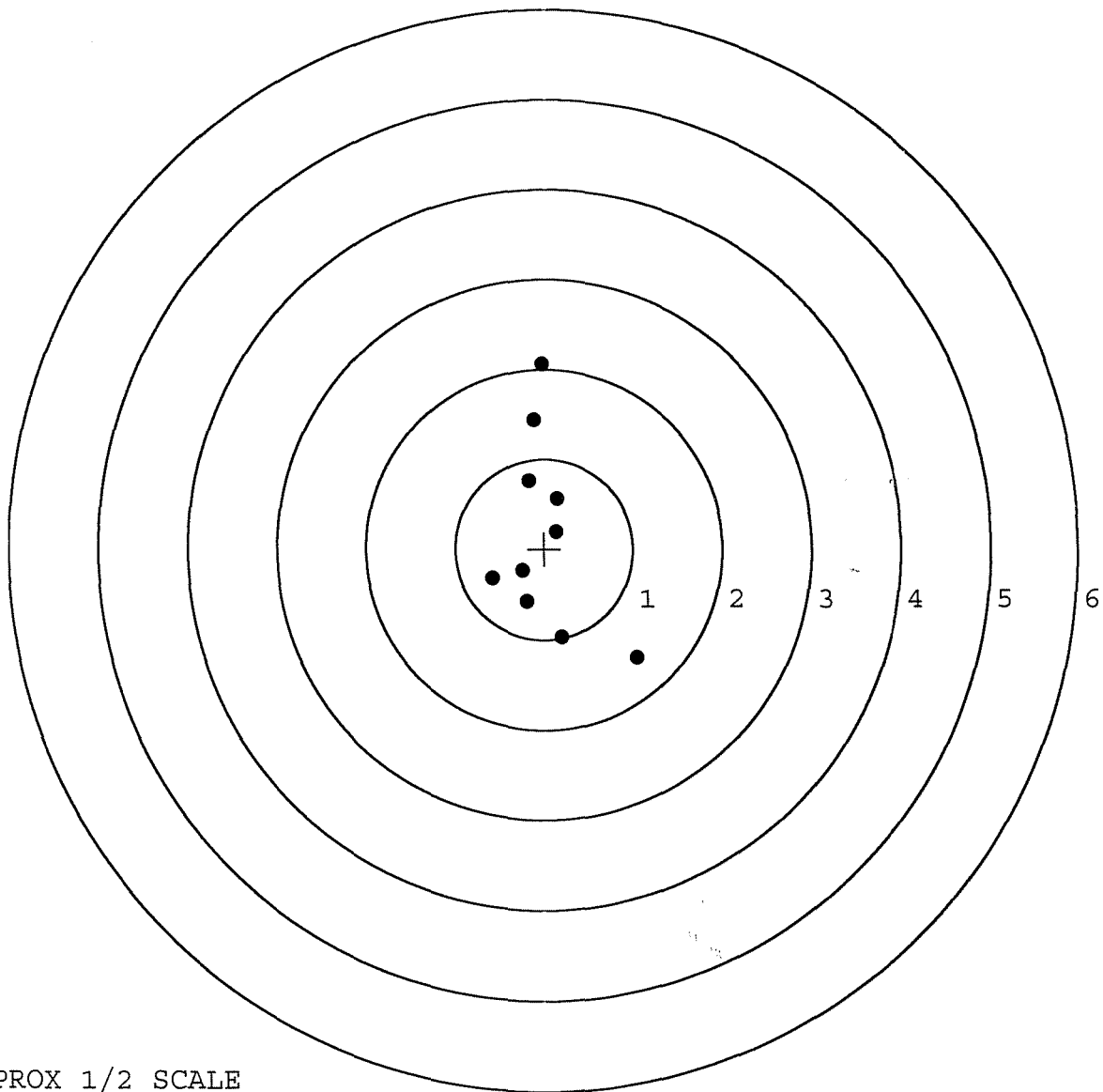


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461602. __0
 TARGET NUMBER: 5
 FILE DATE: 10/14/2005
 FILE TIME: 18:22

X CENTROID: 0.015
 Y CENTROID: 0.166
 POA TO CENTROID: 0.167
 HORZ SPREAD: 1.636
 VERT SPREAD: 3.261
 GROUP SPREAD: 3.435
 MIN RADIUS: 0.127
 MAX RADIUS: 1.891
 MEAN RADIUS: 0.924
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.250	-0.242
2:	-0.590	-0.333
3:	-0.198	-0.582
4:	0.194	-0.975
5:	1.046	-1.204
6:	0.142	0.555
7:	-0.174	0.755
8:	-0.123	1.438
9:	-0.033	2.057
10:	0.140	0.193



TARGET APPROX 1/2 SCALE