

G 646 1685

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



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UPC



SERIAL NO.



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

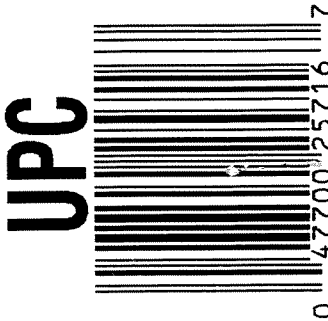
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461685



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G64611685

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-9-05	RTZ
440	PROOF		9-12-05	RTZ
460	CHECK HEADSPACE	INSPECTED	9-13-05	RTZ
470	DIS-ASSEMBLE ACTION	SEP 14 2005	9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>uncd</u>	9/14/05	<u>uncd</u>
500	ROLLMARK CALIBER		9-14-05	CW
510	DRILL AND TAP SIGHT HOLES		9-13-05	TRL
520	GOFF BLAST BBL / REC		9-19-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	<u>HR</u>
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-05	DA
	D) OIL FIRING PIN ASSEMBLY		9-23-05	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 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	10-13-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-13-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	10-13-05	Ac
	J) ASSEMBLE STOCK		9-23-05	RJL
	K) ASSEMBLE SWIVEL STUDS		10-13-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-10-05	Ac
	M) IRON SIGHT ALIGNMENT		10-10-05	Ac
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-10-05	Ac
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	10/11/05	mjd
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/11/05	WJW
670	FINAL INSPECTION A) HEADSPACE		10-13-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.31</u> <u>2.27</u> <u>2.05</u> <u>2.45</u>	10-12-05	BC
	C) FUNCTION		10-13-05	Ac
690	PACK		10/27/05	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 _____

9-16-05

TRLW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.29	2.76		2.23	
PULL #2	2.32	2.85		2.36	
PULL #3	2.57	2.03		2.30	
PULL #4	2.54	2.15		2.25	
PULL #5	2.33	2.16		2.23	
TOTAL	12.05	11.95		11.37	
AVERAGE	2.41	2.39		2.27	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.35		
PULL #2	3.22	3.25		
PULL #3	3.26	2.98		
PULL #4	3.19	3.27		
PULL #5	3.23	3.22		
TOTAL	16.17	16.07		
AVERAGE	3.23	3.21		

	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	4.67	4.30		4.30
PULL #2	4.61	4.44		4.27
PULL #3	4.53	4.42		4.25
PULL #4	4.65	4.25		3.91
PULL #5	4.61	4.15		4.13
TOTAL	23.07	21.56		20.86
AVERAGE	4.61	4.31		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461685.___0
FILE DATE AND TIME: 10/11/2005 18:28

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.124
The Average Y Centroid of the Five Target Set:	0.018
The Average Point of Impact of the Five Target Set:	0.125
The Average Mean Radius of the Five Target Set:	0.778
The Distance from POA to Centroid Target #1:	0.154
The Distance from Centroid Target #2 to Centroid Target #1:	0.229
The Distance from Centroid Target #3 to Centroid Target #1:	0.287
The Distance from Centroid Target #4 to Centroid Target #1:	0.101
The Distance from Centroid Target #5 to Centroid Target #1:	0.467

SERIAL NUMBER: G6461685. __0

TARGET NUMBER: 1

FILE DATE: 10/11/2005

FILE TIME: 18:28

X CENTROID: -0.021

Y CENTROID: -0.152

POA TO CENTROID: 0.154

HORZ SPREAD: 1.898

VERT SPREAD: 1.873

GROUP SPREAD: 2.218

MIN RADIUS: 0.240

MAX RADIUS: 1.135

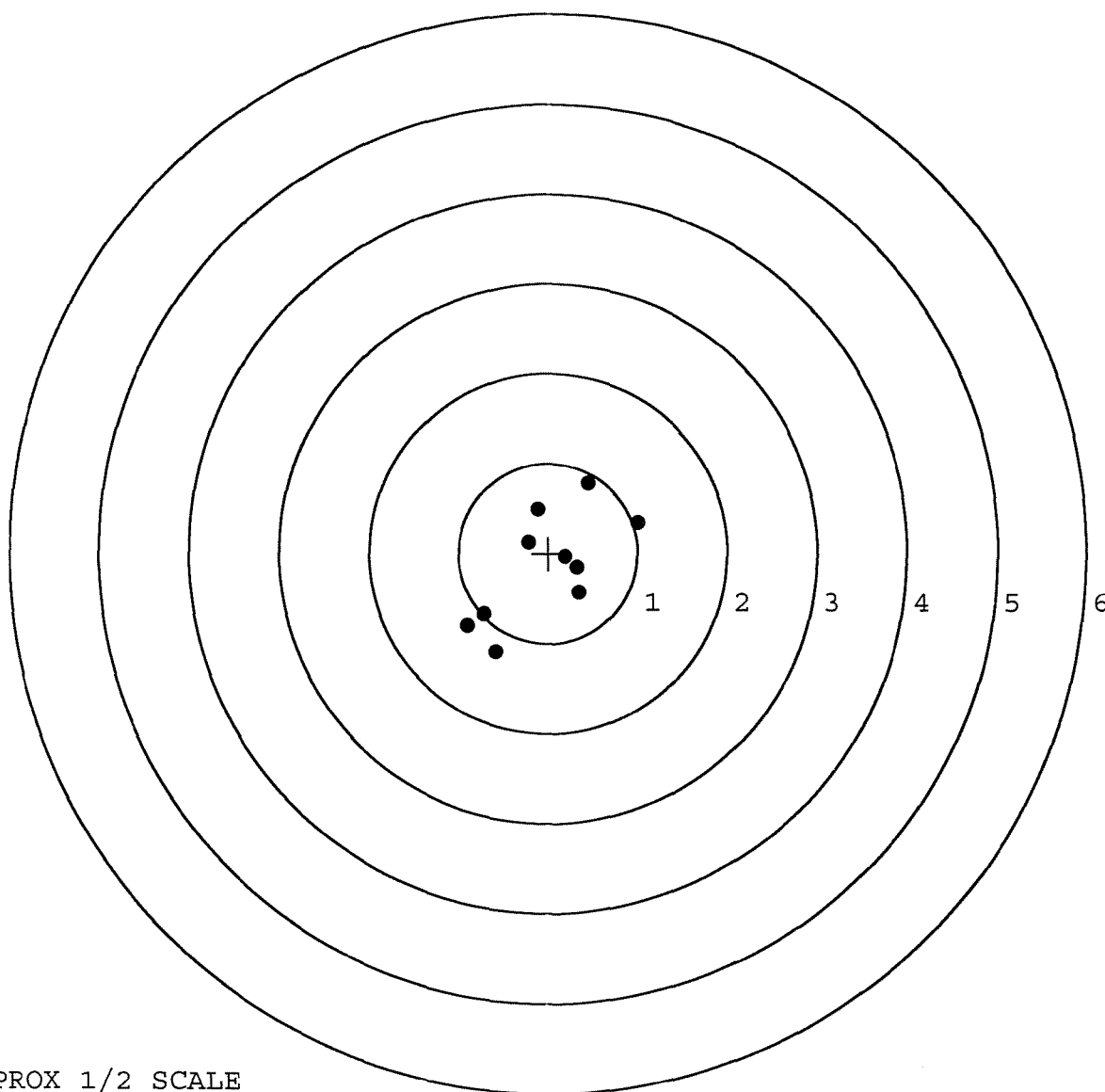
MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.192	-0.042
2:	0.331	-0.162
3:	0.348	-0.446
4:	1.003	0.338
5:	0.453	0.777
6:	-0.116	0.483
7:	-0.223	0.118
8:	-0.719	-0.682
9:	-0.895	-0.809
10:	-0.584	-1.096

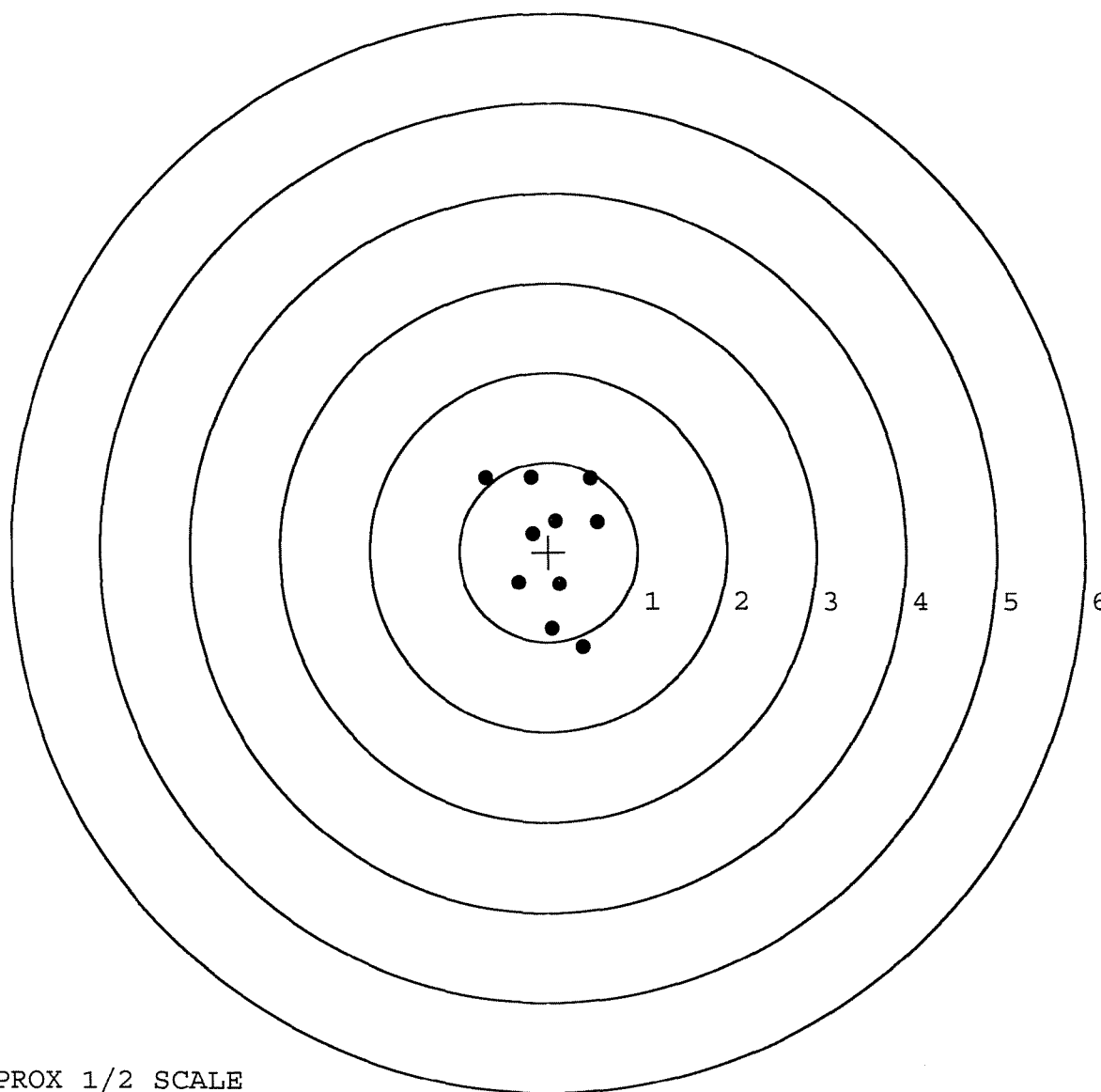


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461685. __0
TARGET NUMBER: 2
FILE DATE: 10/11/2005
FILE TIME: 18:28

X CENTROID: 0.028
Y CENTROID: 0.072
POA TO CENTROID: 0.077
HORZ SPREAD: 1.262
VERT SPREAD: 1.894
GROUP SPREAD: 2.187
MIN RADIUS: 0.242
MAX RADIUS: 1.194
MEAN RADIUS: 0.695
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.705	0.824
2:	-0.196	0.831
3:	0.479	0.814
4:	0.086	0.345
5:	0.557	0.331
6:	-0.174	0.205
7:	-0.337	-0.349
8:	0.124	-0.365
9:	0.043	-0.857
10:	0.400	-1.063



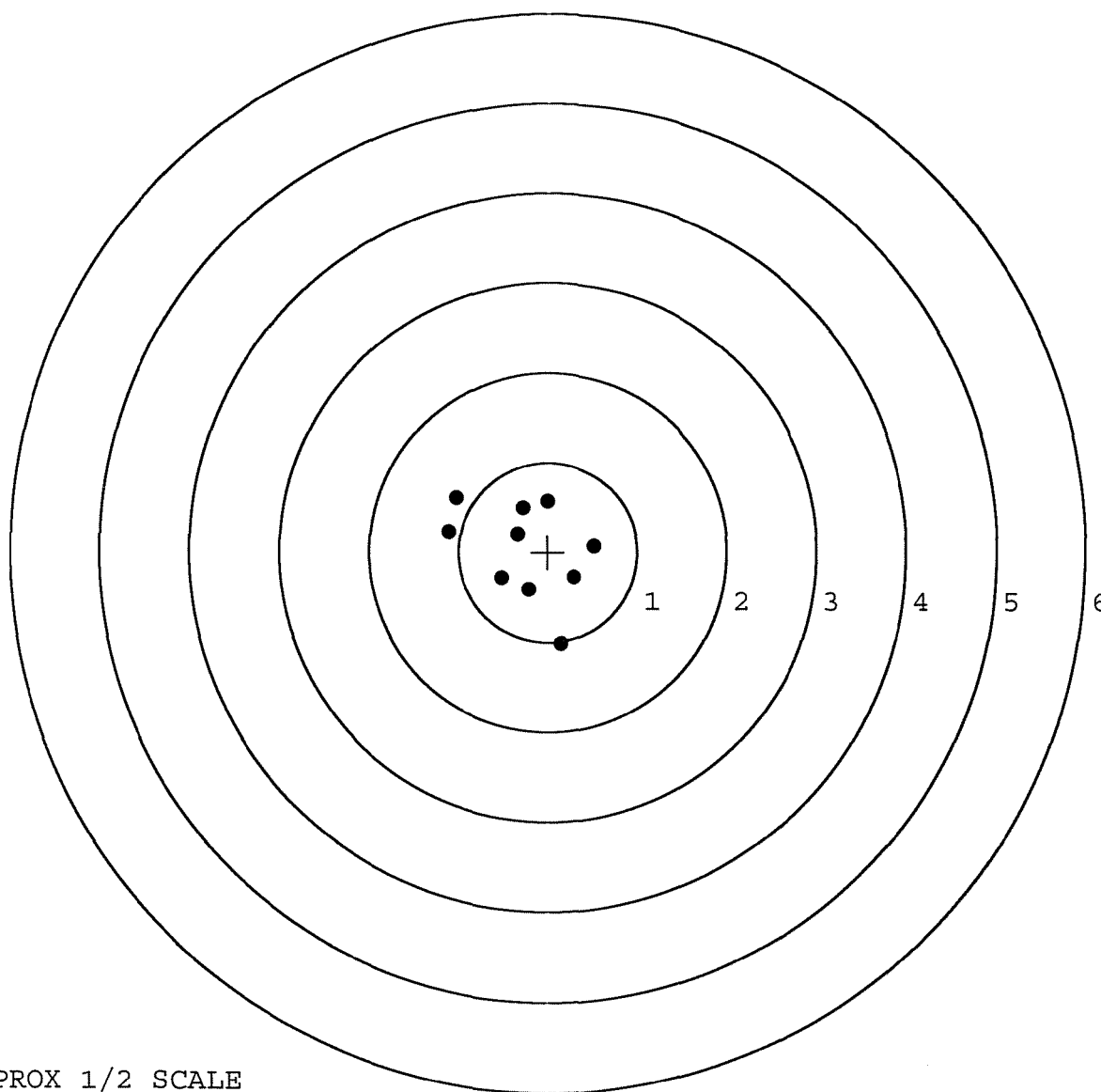
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461685. __0
TARGET NUMBER: 3
FILE DATE: 10/11/2005
FILE TIME: 18:28

X CENTROID: -0.255
Y CENTROID: 0.013
POA TO CENTROID: 0.256
HORZ SPREAD: 1.635
VERT SPREAD: 1.627
GROUP SPREAD: 2.011
MIN RADIUS: 0.202
MAX RADIUS: 1.112
MEAN RADIUS: 0.650

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.030	0.605
2:	-1.115	0.226
3:	-0.518	-0.289
4:	0.152	-1.022
5:	-0.216	-0.425
6:	0.294	-0.284
7:	0.520	0.073
8:	-0.345	0.194
9:	-0.286	0.489
10:	-0.010	0.565

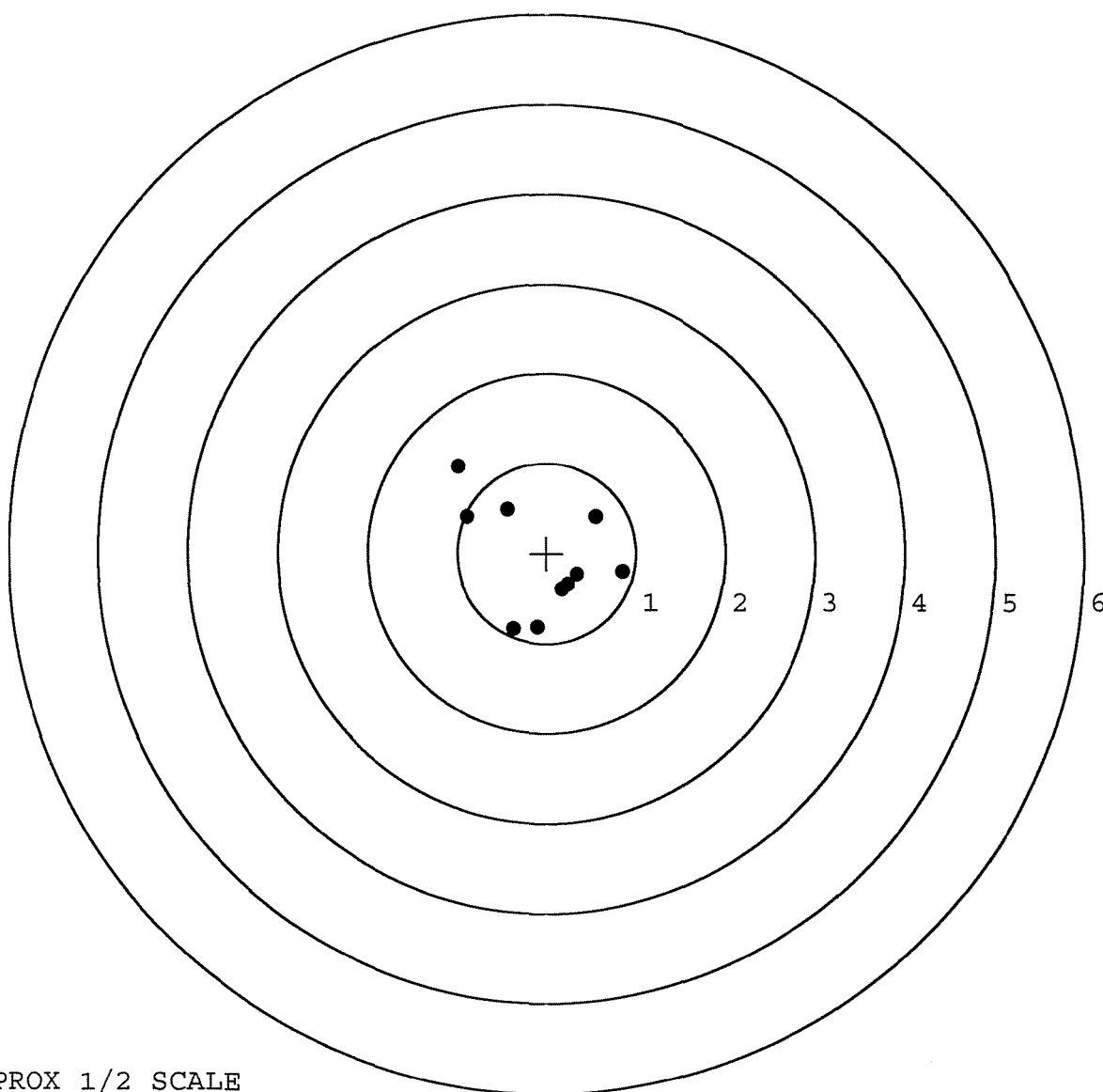


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461685. __0
TARGET NUMBER: 4
FILE DATE: 10/11/2005
FILE TIME: 18:28

POINT#	X	Y
1:	-0.987	0.965
2:	-0.891	0.401
3:	-0.439	0.486
4:	0.557	0.406
5:	0.853	-0.208
6:	0.343	-0.235
7:	0.167	-0.402
8:	-0.102	-0.822
9:	-0.373	-0.846
10:	0.237	-0.347

X CENTROID: -0.064
Y CENTROID: -0.060
POA TO CENTROID: 0.087
HORZ SPREAD: 1.840
VERT SPREAD: 1.811
GROUP SPREAD: 2.182
MIN RADIUS: 0.412
MAX RADIUS: 1.380
MEAN RADIUS: 0.757
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

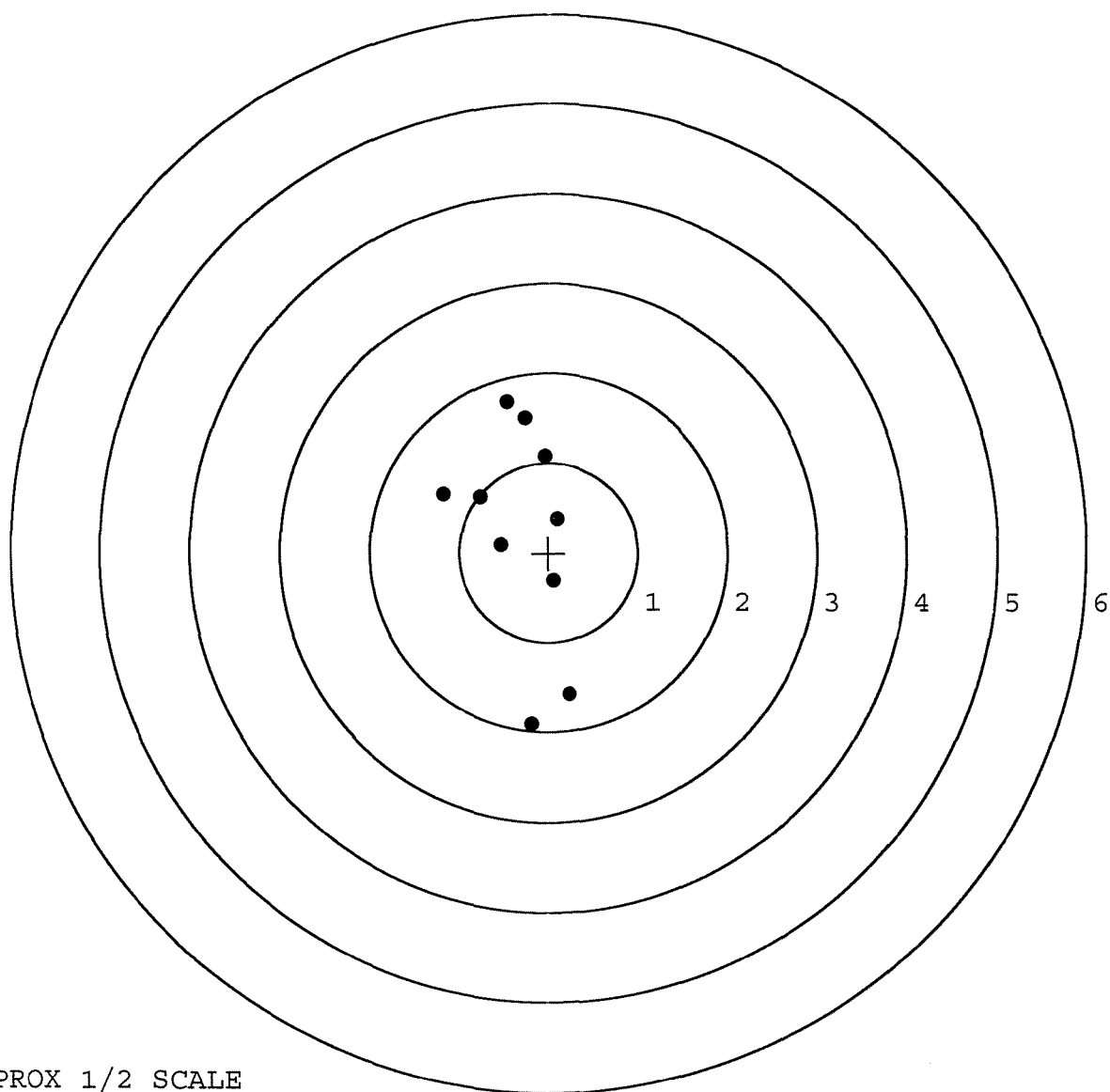


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461685. __0
TARGET NUMBER: 5
FILE DATE: 10/11/2005
FILE TIME: 18:28

X CENTROID: -0.306
Y CENTROID: 0.218
POA TO CENTROID: 0.375
HORZ SPREAD: 1.425
VERT SPREAD: 3.595
GROUP SPREAD: 3.606
MIN RADIUS: 0.254
MAX RADIUS: 2.142
MEAN RADIUS: 1.058
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.473	1.674
2:	-0.272	1.497
3:	-0.043	1.073
4:	0.094	0.374
5:	-0.531	0.100
6:	-0.760	0.624
7:	-1.183	0.652
8:	0.058	-0.309
9:	0.242	-1.583
10:	-0.188	-1.921



TARGET APPROX 1/2 SCALE