

G 646 1496

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

UPC



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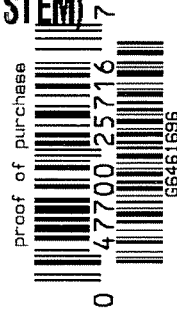
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

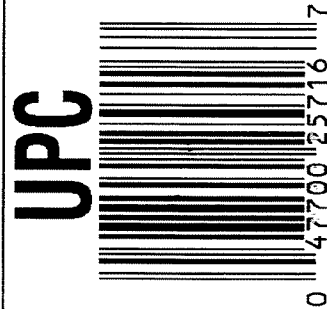


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461696



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6460 1696

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTZ
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTZ
470	DIS-ASSEMBLE ACTION	MAGNA-FLUX INSPECTED	9-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 SEP 6 8 2005 OPERATOR <i>[Signature]</i>	9/8/05	<i>[Signature]</i>
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	<i>[Signature]</i>
530 & 540	APPLY COATINGS (BARREL ACTION)		9/15	RB HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-19-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-19-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-19-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		9-19-05	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>8 lb.</u> <u>7 lb.</u> <u>6 lb.</u>	10-17-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lb.</u> <u>3 lb.</u> <u>3 lb.</u>	10-17-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-17-05	BC
	J) ASSEMBLE STOCK		9-19-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-17-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-12-05	Ac
	M) IRON SIGHT ALIGNMENT		10-12-05	Ac
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-12-05	Ac
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/14/05	mgj
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/14/05	wjw
670	FINAL INSPECTION A) HEADSPACE		10-17-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.10</u> <u>2.35</u> <u>2.37</u> <u>2.58</u>	10-17-05	BC
	C) FUNCTION		10-17-05	BC
690	PACK		10/28/05	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

9/15/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.67	2.17		2.49	
PULL #2	2.30	2.85		2.87	
PULL #3	2.76	2.07		2.14	
PULL #4	2.69	2.58		2.16	
PULL #5	2.89	2.65		2.72	
TOTAL	13.31	12.32		12.38	
AVERAGE	2.66	2.46		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.99	3.12		
PULL #2	3.04	3.04		
PULL #3	2.59	2.88		
PULL #4	3.04	3.03		
PULL #5	3.07	2.92		
TOTAL	14.73	14.99		
AVERAGE	2.95	3.00		

	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	4.38	3.92		4.21
PULL #2	4.11	4.25		4.01
PULL #3	4.32	4.38		4.18
PULL #4	4.16	4.14		4.54
PULL #5	4.17	4.42		4.55
TOTAL	21.14	21.11		21.49
AVERAGE	4.23	4.22		4.30

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461696.__0

FILE DATE AND TIME: 10/14/2005 18:08

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.079
The Average Y Centroid of the Five Target Set:	0.158
The Average Point of Impact of the Five Target Set:	0.176
The Average Mean Radius of the Five Target Set:	0.920
The Distance from POA to Centroid Target #1:	0.337
The Distance from Centroid Target #2 to Centroid Target #1:	0.716
The Distance from Centroid Target #3 to Centroid Target #1:	0.308
The Distance from Centroid Target #4 to Centroid Target #1:	0.088
The Distance from Centroid Target #5 to Centroid Target #1:	0.190

SERIAL NUMBER: G6461696. __0

TARGET NUMBER: 1

FILE DATE: 10/14/2005

FILE TIME: 18:08

X CENTROID: -0.043

Y CENTROID: 0.335

POA TO CENTROID: 0.337

HORZ SPREAD: 1.578

VERT SPREAD: 1.941

GROUP SPREAD: 2.159

MIN RADIUS: 0.321

MAX RADIUS: 1.320

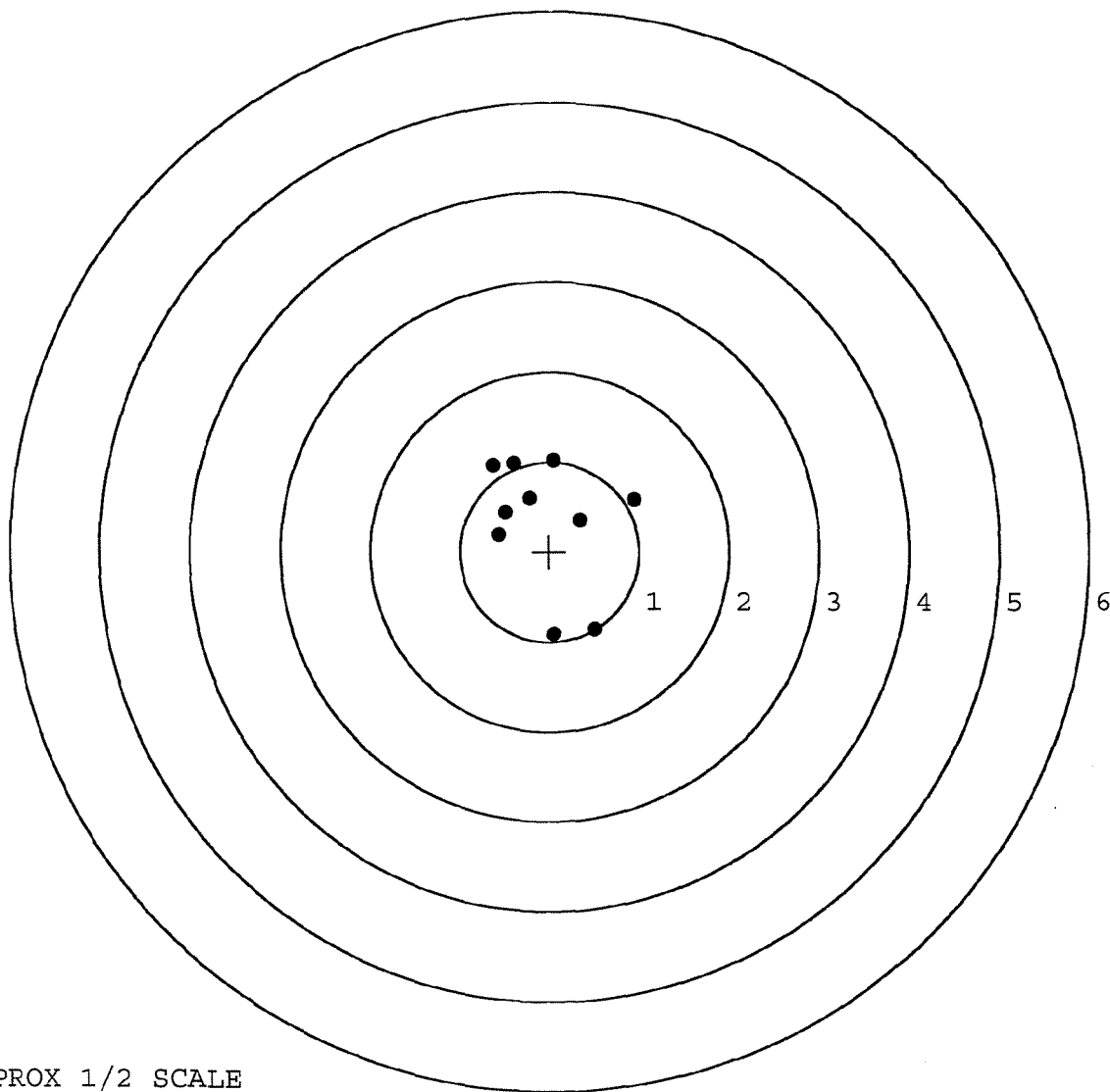
MEAN RADIUS: 0.760

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.563	0.191
2:	-0.495	0.440
3:	-0.225	0.599
4:	0.041	1.016
5:	-0.400	0.982
6:	-0.636	0.966
7:	0.343	0.358
8:	0.942	0.584
9:	0.512	-0.863
10:	0.056	-0.925



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461696. __0

TARGET NUMBER: 2

FILE DATE: 10/14/2005

FILE TIME: 18:08

POINT#	X	Y
1:	-0.304	0.309
2:	-0.555	0.446
3:	-0.712	0.231
4:	-0.526	0.100
5:	0.456	-0.134
6:	0.516	0.252
7:	0.647	0.406
8:	0.121	1.032
9:	-0.558	-2.561
10:	-0.689	-3.791

X CENTROID: -0.160

Y CENTROID: -0.371

POA TO CENTROID: 0.404

HORZ SPREAD: 1.359

VERT SPREAD: 4.823

GROUP SPREAD: 4.891

MIN RADIUS: 0.596

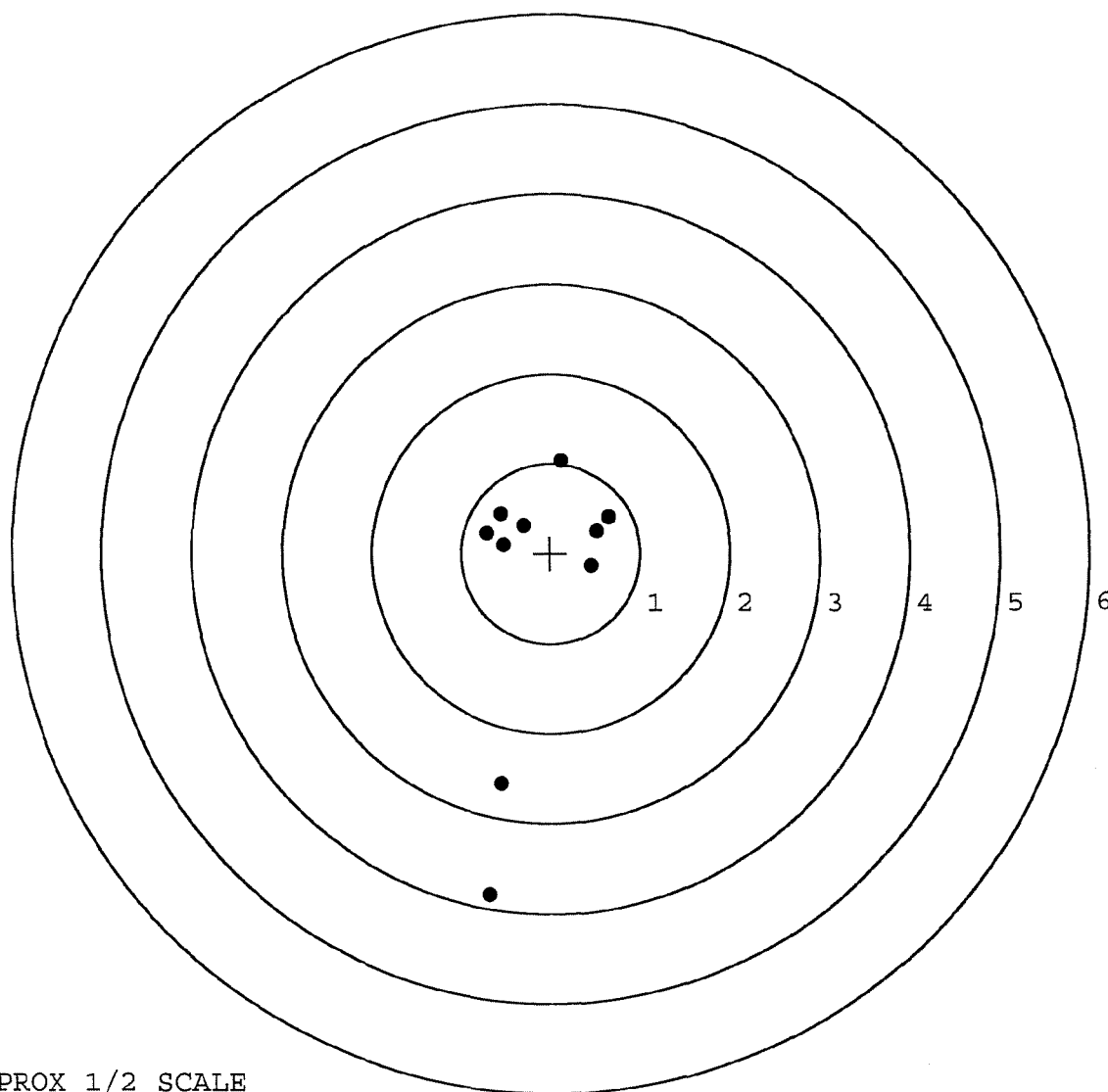
MAX RADIUS: 3.461

MEAN RADIUS: 1.283

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461696. 0

TARGET NUMBER: 3

FILE DATE: 10/14/2005

FILE TIME: 18:08

POINT#	X	Y
1:	-0.067	-0.017
2:	0.165	-0.300
3:	-0.261	-0.545
4:	0.304	0.146
5:	0.542	0.276
6:	0.338	1.021
7:	-0.478	0.441
8:	-0.973	-0.014
9:	-1.551	0.238
10:	1.079	-0.937

X CENTROID: -0.090

Y CENTROID: 0.031

POA TO CENTROID: 0.095

HORZ SPREAD: 2.630

VERT SPREAD: 1.958

GROUP SPREAD: 2.881

MIN RADIUS: 0.053

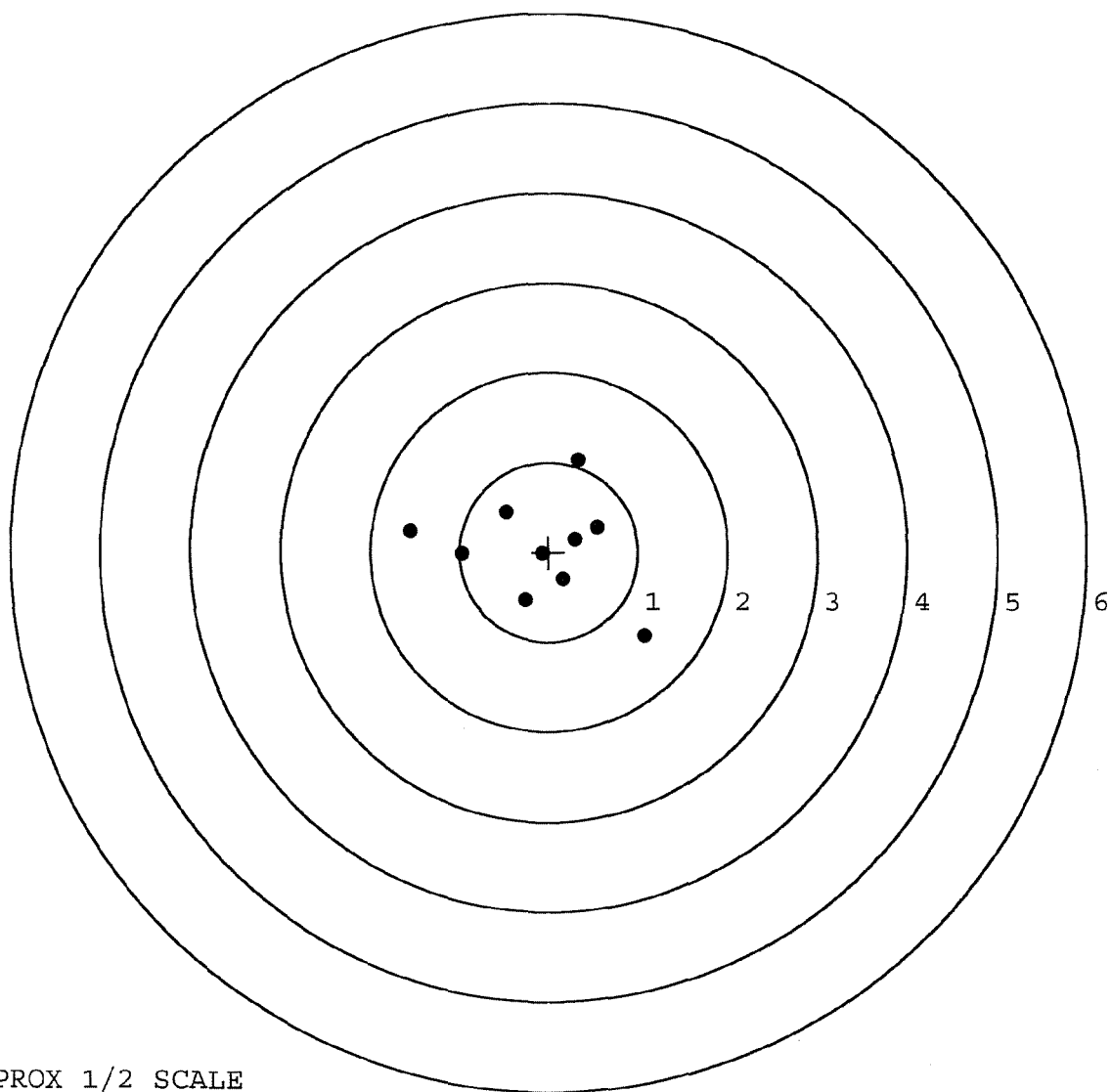
MAX RADIUS: 1.518

MEAN RADIUS: 0.768

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461696. __0

TARGET NUMBER: 4

FILE DATE: 10/14/2005

FILE TIME: 18:08

POINT#	X	Y
1:	-0.369	0.384
2:	-0.539	-0.080
3:	-0.950	-0.332
4:	0.040	-0.464
5:	0.532	0.234
6:	0.699	0.329
7:	0.329	0.630
8:	0.530	1.634

X CENTROID: 0.034

Y CENTROID: 0.292

POA TO CENTROID: 0.294

HORZ SPREAD: 1.649

VERT SPREAD: 2.098

GROUP SPREAD: 2.461

MIN RADIUS: 0.413

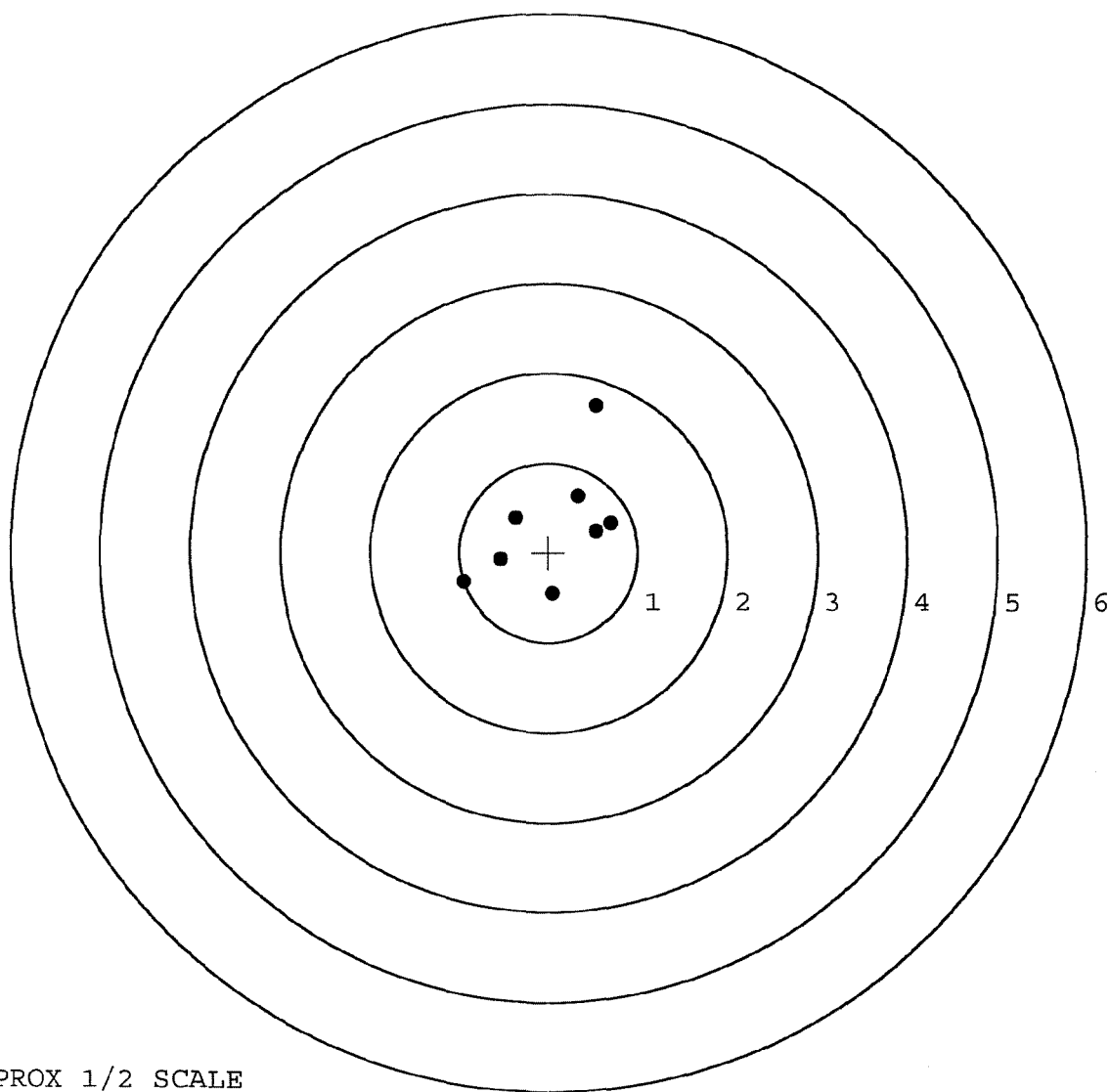
MAX RADIUS: 1.431

MEAN RADIUS: 0.758

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461696. __0

TARGET NUMBER: 5

FILE DATE: 10/14/2005

FILE TIME: 18:08

POINT#	X	Y
1:	-0.070	-0.343
2:	-0.350	-0.748
3:	0.400	-0.628
4:	0.704	-0.462
5:	0.237	0.569
6:	0.456	0.753
7:	-0.638	0.627
8:	-0.527	0.890
9:	-0.611	1.769
10:	-0.939	2.585

X CENTROID: -0.134

Y CENTROID: 0.501

POA TO CENTROID: 0.519

HORZ SPREAD: 1.643

VERT SPREAD: 3.333

GROUP SPREAD: 3.481

MIN RADIUS: 0.377

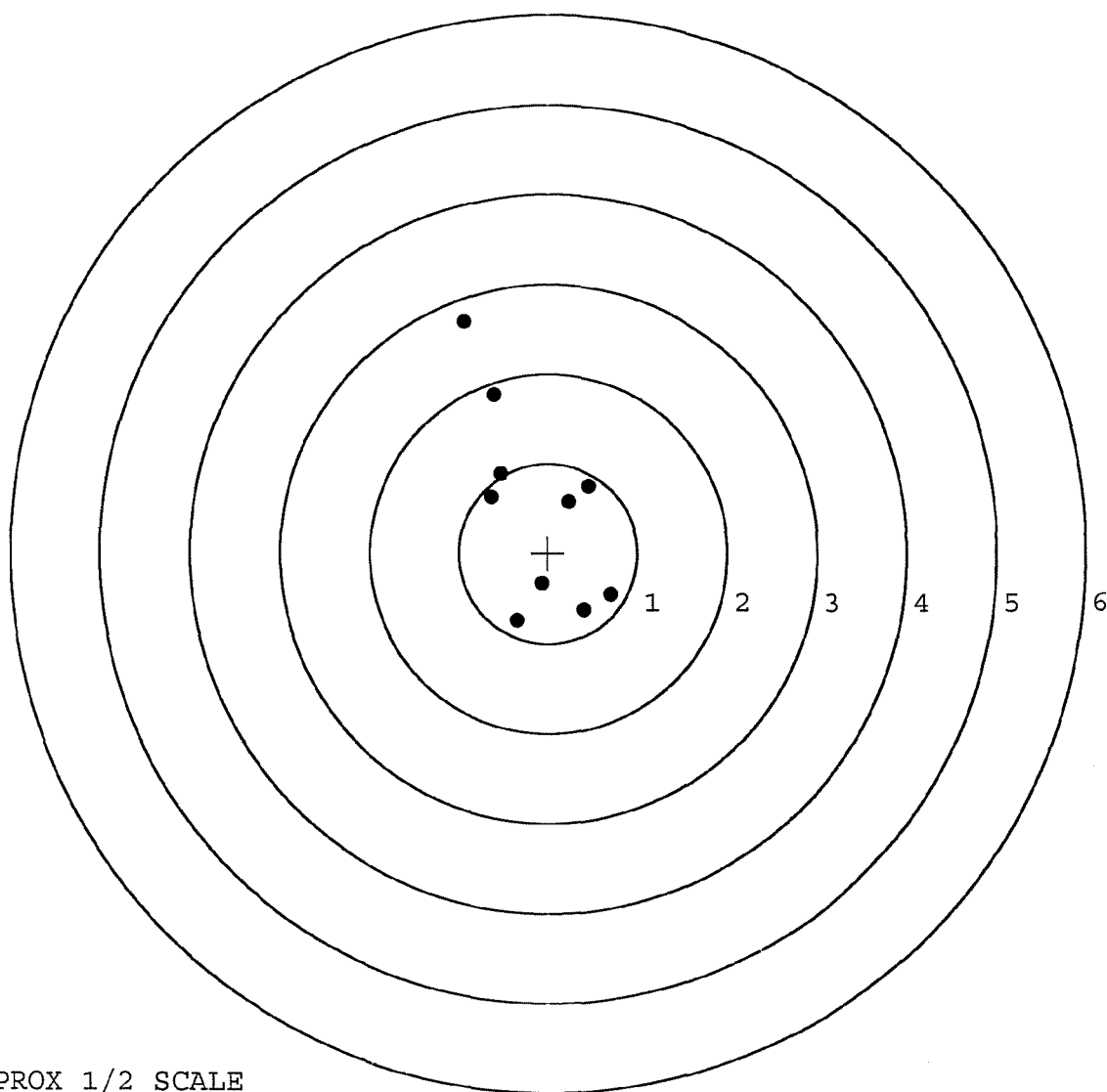
MAX RADIUS: 2.234

MEAN RADIUS: 1.032

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE