

G646 1767

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

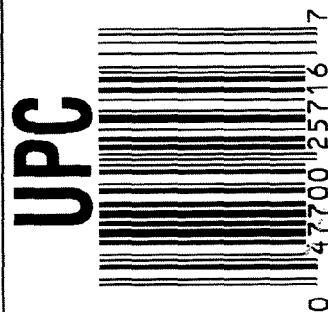


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461767



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6461767

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/28/05	CD
440	PROOF		10/28/05	CD
460	CHECK HEADSPACE		10/28/05	CD
470	DIS-ASSEMBLE ACTION		10/28/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/80 unad	11/14/05	unad
500	ROLLMARK CALIBER		11/4/05	CW
510	DRILL AND TAP SIGHT HOLES		11/3/05	BR
520	GOFF BLAST BBL / REC		11/15/05	UB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		11/14/05	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		11/22/05	RTA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/22/05	RTA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/22/05	RTA
	D) OIL FIRING PIN ASSEMBLY		11-30-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	12-13-05	TC

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.5</u> <u>7.5</u> <u>7.0</u>	12-12-05	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	12-12-05	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.024</u> <u>.023</u>	12-12-05	TRW
	J) ASSEMBLE STOCK		11-30-05	RTL
	K) ASSEMBLE SWIVEL STUDS		12-13-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-8-05	BG
	M) IRON SIGHT ALIGNMENT		12-8-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-8-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	12/9/05	MJM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12/9/05	MJM
670	FINAL INSPECTION A) HEADSPACE		12-13-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.40</u> <u>2.33</u> <u>2.42</u> <u>2.33</u>	12/12/05	R.P.
	C) FUNCTION		12-13-05	BG
690	PACK		1-13-06	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 11-22-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.52	2.56		2.60	
PULL #2	2.51	2.48		2.68	
PULL #3	2.59	2.51		2.66	
PULL #4	2.49	2.55		2.46	
PULL #5	2.54	2.51		2.55	
TOTAL	12.65	12.61		12.95	
AVERAGE	2.53	2.52		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.96	3.08		
PULL #2	3.19	3.05		
PULL #3	3.08	3.26		
PULL #4	2.90	3.25		
PULL #5	3.02	3.22		
TOTAL	15.15	15.86		
AVERAGE	3.03	3.17		

	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	4.14	4.23		4.01
PULL #2	4.15	4.12		4.02
PULL #3	4.11	4.12		3.96
PULL #4	4.05	4.13		4.15
PULL #5	4.16	4.24		4.10
TOTAL	20.61	20.84		20.24
AVERAGE	4.12	4.16		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461767.___0
FILE DATE AND TIME: 12/09/2005 22:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.117
The Average Y Centroid of the Five Target Set:	0.165
The Average Point of Impact of the Five Target Set:	0.202
The Average Mean Radius of the Five Target Set:	0.641
The Distance from POA to Centroid Target #1:	0.712
The Distance from Centroid Target #2 to Centroid Target #1:	0.742
The Distance from Centroid Target #3 to Centroid Target #1:	0.572
The Distance from Centroid Target #4 to Centroid Target #1:	0.741
The Distance from Centroid Target #5 to Centroid Target #1:	0.855

SERIAL NUMBER: G6461767. __0

TARGET NUMBER: 1

FILE DATE: 12/09/2005

FILE TIME: 22:50

POINT#	X	Y
1:	-0.295	-0.318
2:	-0.674	-0.091
3:	-0.235	0.286
4:	0.020	0.398
5:	0.475	0.264
6:	0.612	-0.095
7:	-1.385	0.374
8:	-1.801	0.505
9:	-1.941	-0.287
10:	-1.735	0.477

X CENTROID: -0.696

Y CENTROID: 0.151

POA TO CENTROID: 0.712

HORZ SPREAD: 2.553

VERT SPREAD: 0.823

GROUP SPREAD: 2.560

MIN RADIUS: 0.243

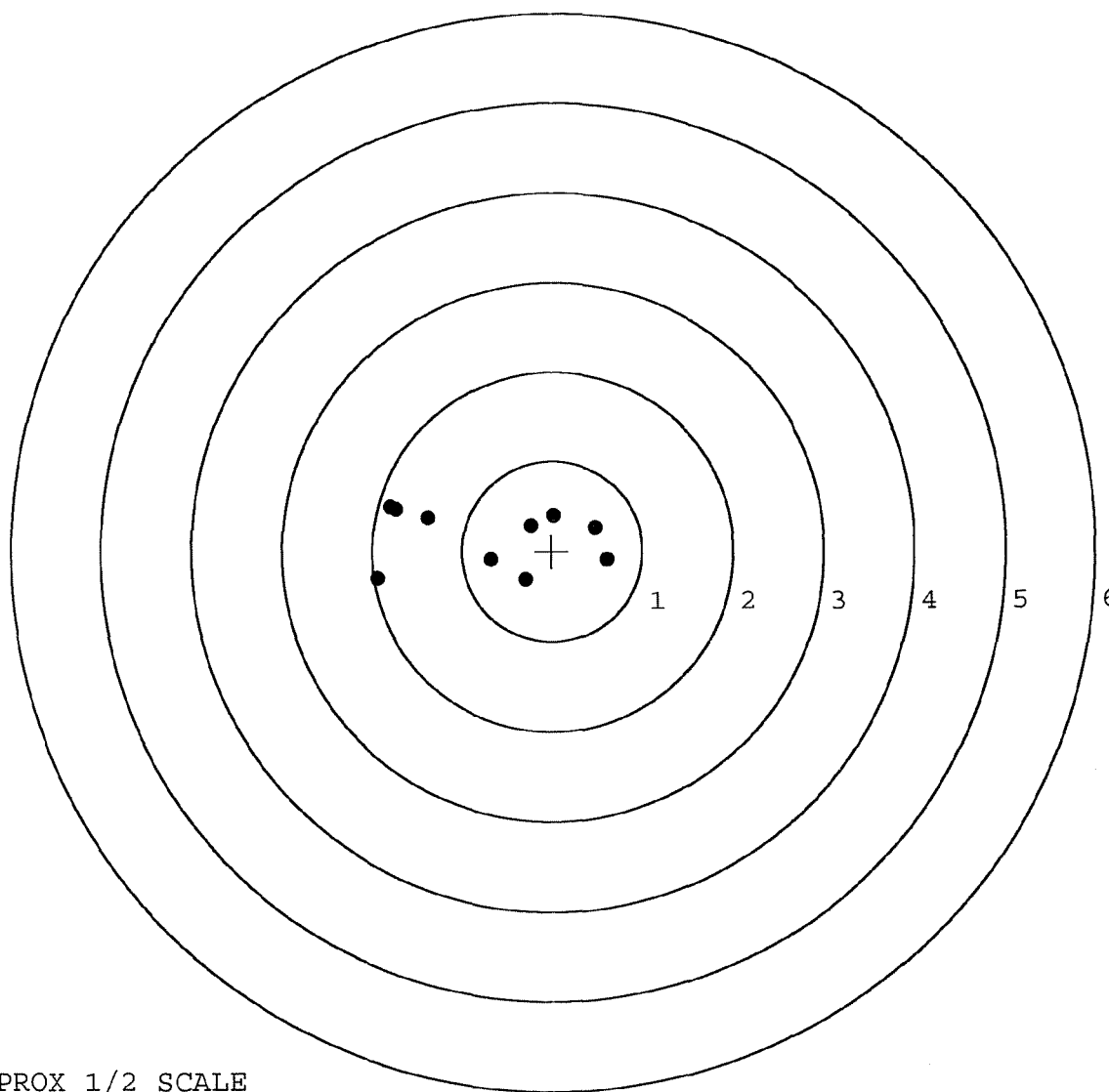
MAX RADIUS: 1.331

MEAN RADIUS: 0.890

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461767. __0

TARGET NUMBER: 2

FILE DATE: 12/09/2005

FILE TIME: 22:50

POINT#	X	Y
1:	-0.013	-0.977
2:	-0.071	-0.476
3:	0.285	-0.380
4:	0.042	-0.118
5:	0.314	0.137
6:	0.242	0.458
7:	0.742	0.404
8:	0.021	1.004
9:	-0.266	0.538
10:	-0.853	0.451

X CENTROID: 0.044

Y CENTROID: 0.104

POA TO CENTROID: 0.113

HORZ SPREAD: 1.595

VERT SPREAD: 1.981

GROUP SPREAD: 1.981

MIN RADIUS: 0.222

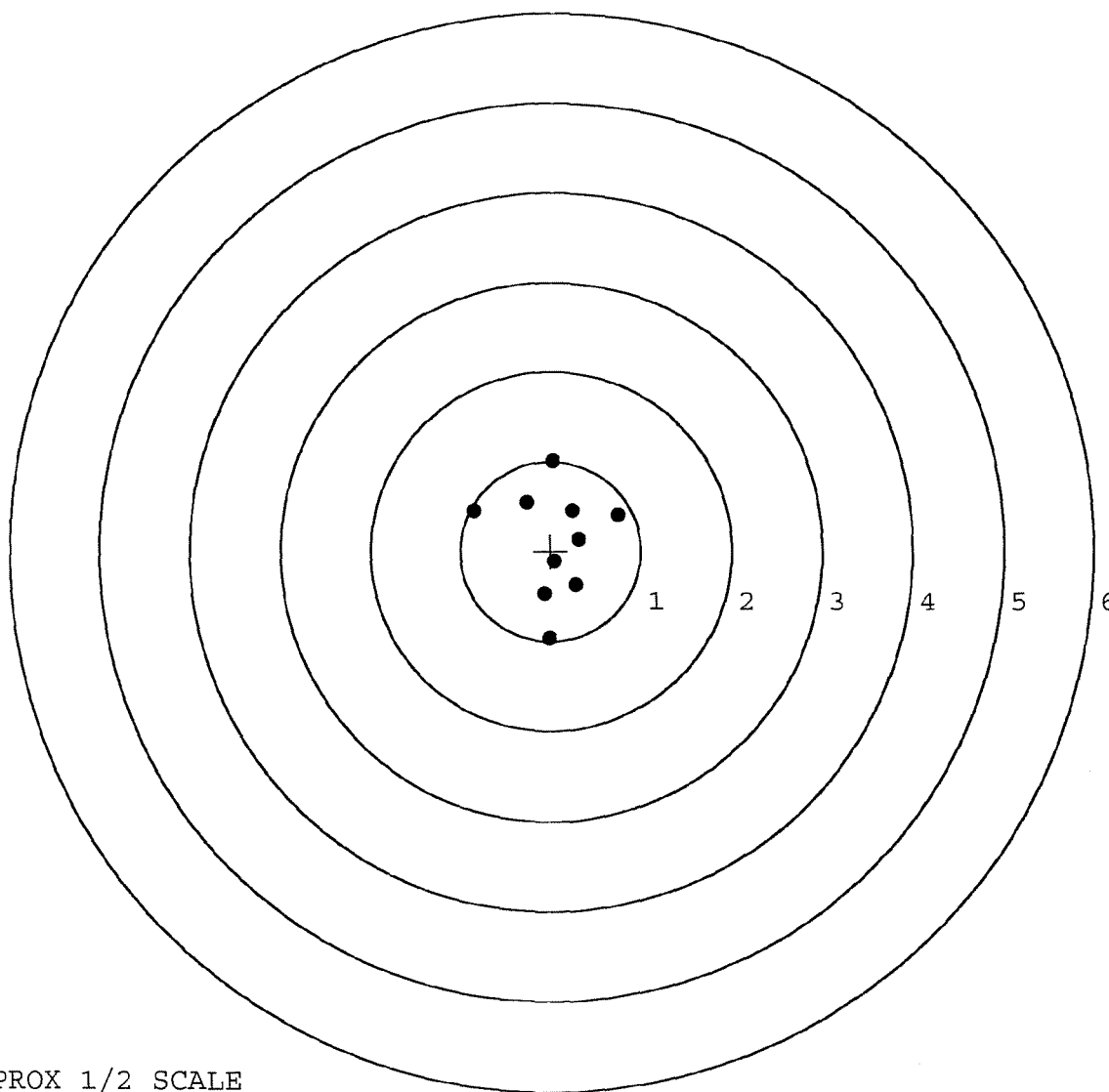
MAX RADIUS: 1.083

MEAN RADIUS: 0.627

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

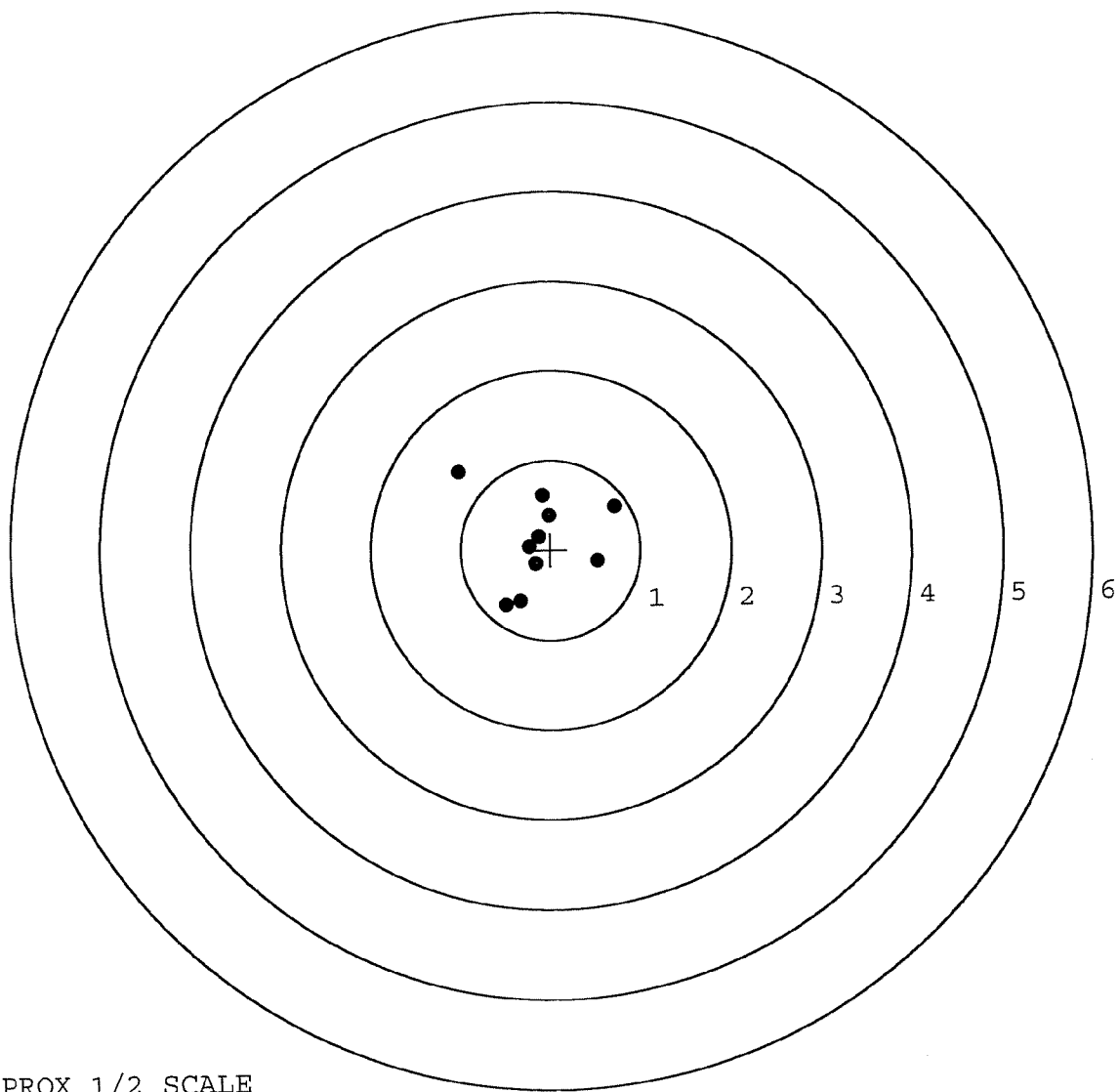


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461767. __0
 TARGET NUMBER: 3
 FILE DATE: 12/09/2005
 FILE TIME: 22:50

POINT#	X	Y
1:	0.521	-0.129
2:	0.715	0.479
3:	-0.085	0.607
4:	-0.014	0.382
5:	-0.234	0.035
6:	-0.173	-0.160
7:	-0.341	-0.569
8:	-0.506	-0.611
9:	-1.009	0.880
10:	-0.131	0.148

X CENTROID: -0.126
 Y CENTROID: 0.106
 POA TO CENTROID: 0.165
 HORZ SPREAD: 1.724
 VERT SPREAD: 1.491
 GROUP SPREAD: 1.833
 MIN RADIUS: 0.042
 MAX RADIUS: 1.174
 MEAN RADIUS: 0.554
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

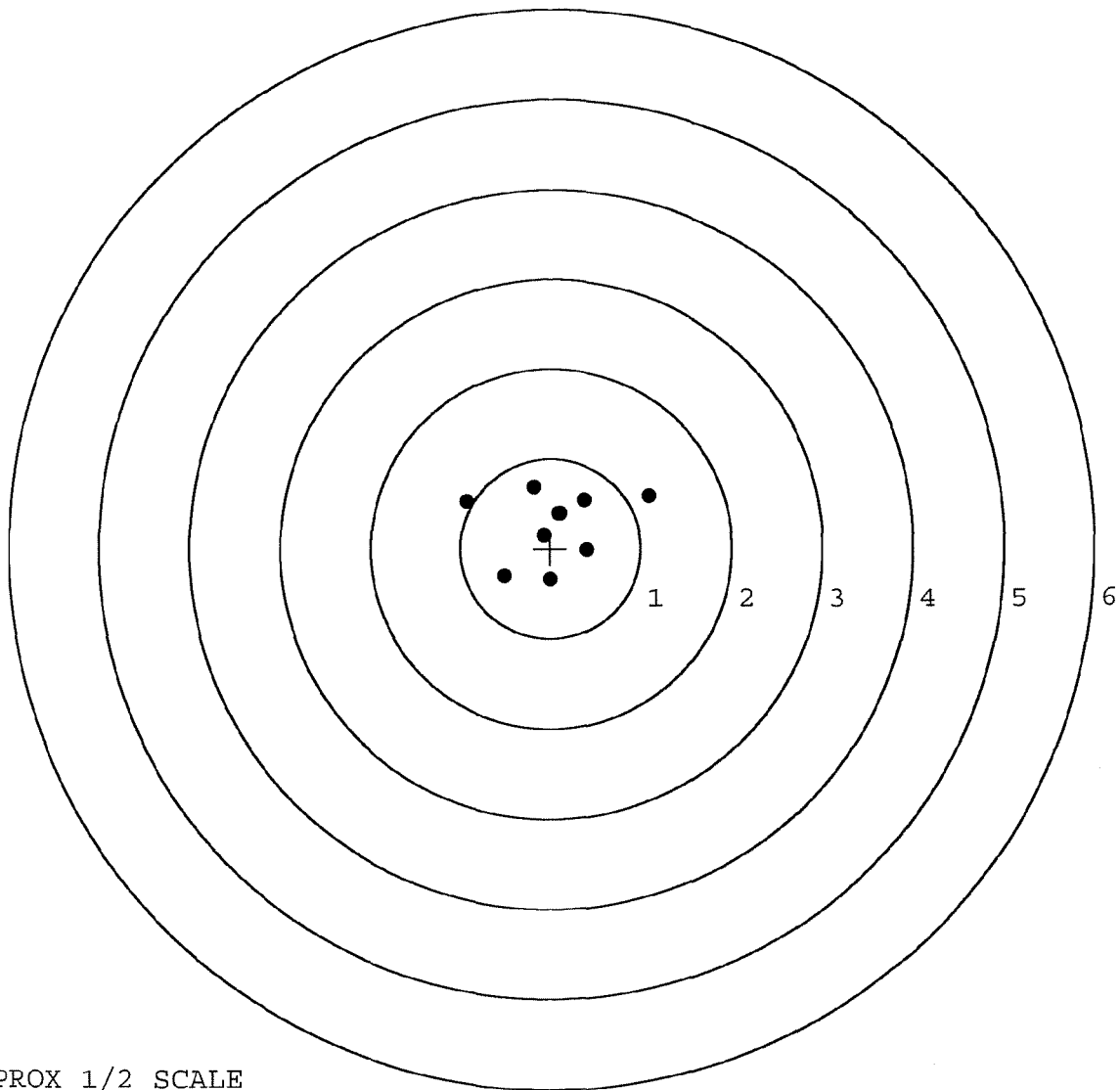


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461767. 0
TARGET NUMBER: 4
FILE DATE: 12/09/2005
FILE TIME: 22:50

X CENTROID: 0.037
Y CENTROID: 0.257
POA TO CENTROID: 0.260
HORZ SPREAD: 2.020
VERT SPREAD: 1.035
GROUP SPREAD: 2.021
MIN RADIUS: 0.145
MAX RADIUS: 1.101
MEAN RADIUS: 0.534
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.090	0.392
2:	0.376	0.537
3:	-0.184	0.682
4:	-0.002	-0.353
5:	-0.513	-0.310
6:	-0.931	0.525
7:	1.089	0.583
8:	0.107	0.387
9:	-0.071	0.144
10:	0.410	-0.015

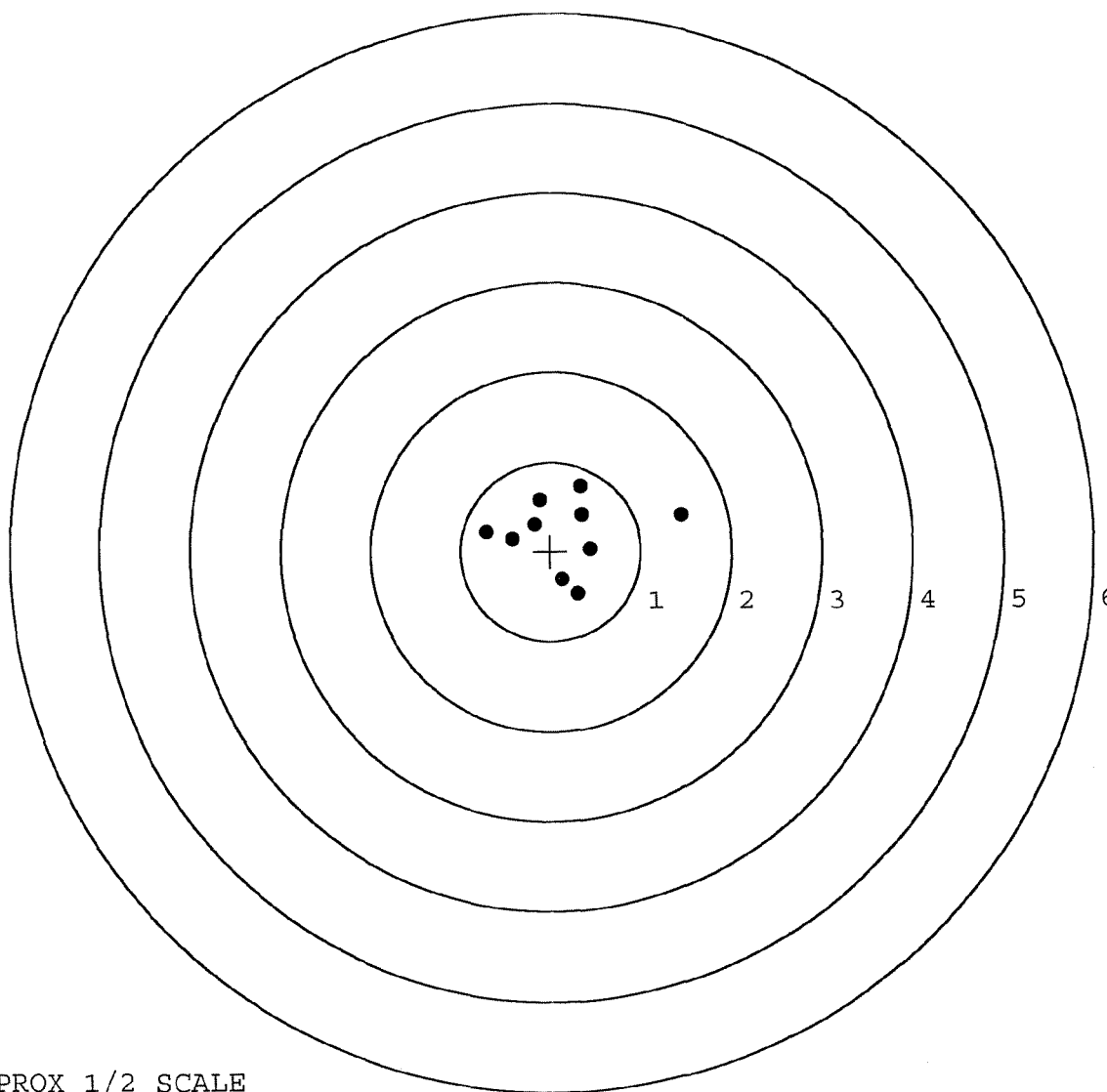


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461767. __0
TARGET NUMBER: 5
FILE DATE: 12/09/2005
FILE TIME: 22:50

X CENTROID: 0.157
Y CENTROID: 0.205
POA TO CENTROID: 0.258
HORZ SPREAD: 2.153
VERT SPREAD: 1.217
GROUP SPREAD: 2.160
MIN RADIUS: 0.289
MAX RADIUS: 1.303
MEAN RADIUS: 0.598
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.443	0.029
2:	0.306	-0.478
3:	0.128	-0.317
4:	-0.709	0.226
5:	-0.423	0.146
6:	-0.185	0.302
7:	-0.122	0.575
8:	0.337	0.739
9:	0.351	0.419
10:	1.444	0.405



TARGET APPROX 1/2 SCALE