

G-646 1776

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

UPC



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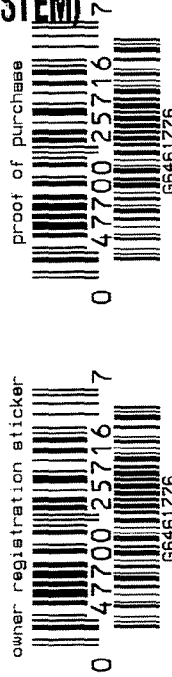
SERIAL NO.



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

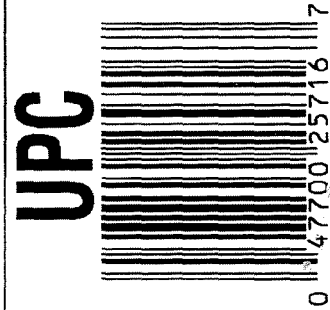
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461776



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461774

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-12-05	RTZ
440	PROOF		9-15-05	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-16-05	RTZ
470	DIS-ASSEMBLE ACTION	SEP 21 2005	9-16-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	9/80 OPERATOR <i>unus</i>	9/20/05	<i>unus</i>
500	ROLLMARK CALIBER		9-20-05	CW
510	DRILL AND TAP SIGHT HOLES		9-20-05	TRL
520	GOFF BLAST BBL / REC		9-21-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/22	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	WJM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	WJM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	WJM
	D) OIL FIRING PIN ASSEMBLY		10-18-05	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 lb</u> <u>6 lb</u> <u>6 lb</u>	10/25/05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lb</u> <u>2 lb</u> <u>2 lb</u>	10/25/05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10/25/05	BC
	J) ASSEMBLE STOCK		10-18-05	RT
	K) ASSEMBLE SWIVEL STUDS		10/25/05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-18-05	AC
	M) IRON SIGHT ALIGNMENT		10-18-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-18-05	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/19/05	MD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/19/05	MD
670	FINAL INSPECTION A) HEADSPACE		10/25/05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.75</u> <u>2.76</u> <u>2.78</u> <u>2.77</u>	10/25/05	BC
	C) FUNCTION		10/25/05	BC
690	PACK		10/24/05	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 10-12-05

TESTER M.M

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.55	2.58		2.47	
PULL #2	2.55	2.50		2.56	
PULL #3	2.38	2.49		2.47	
PULL #4	2.46	2.40		2.50	
PULL #5	2.45	2.48		2.51	
TOTAL	12.39	12.45		12.51	
AVERAGE	2.48	2.49		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.13		
PULL #2	3.21	3.11		
PULL #3	2.70	3.09		
PULL #4	3.26	2.71		
PULL #5	3.19	3.08		
TOTAL	15.58	15.12		
AVERAGE	3.12	3.02		

	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	4.15	4.03		4.04
PULL #2	4.19	4.06		4.27
PULL #3	4.16	3.93		4.21
PULL #4	4.15	3.94		3.89
PULL #5	3.91	3.92		4.23
TOTAL	20.56	19.88		20.64
AVERAGE	4.11	3.98		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461776.__0
FILE DATE AND TIME: 10/19/2005 17:01

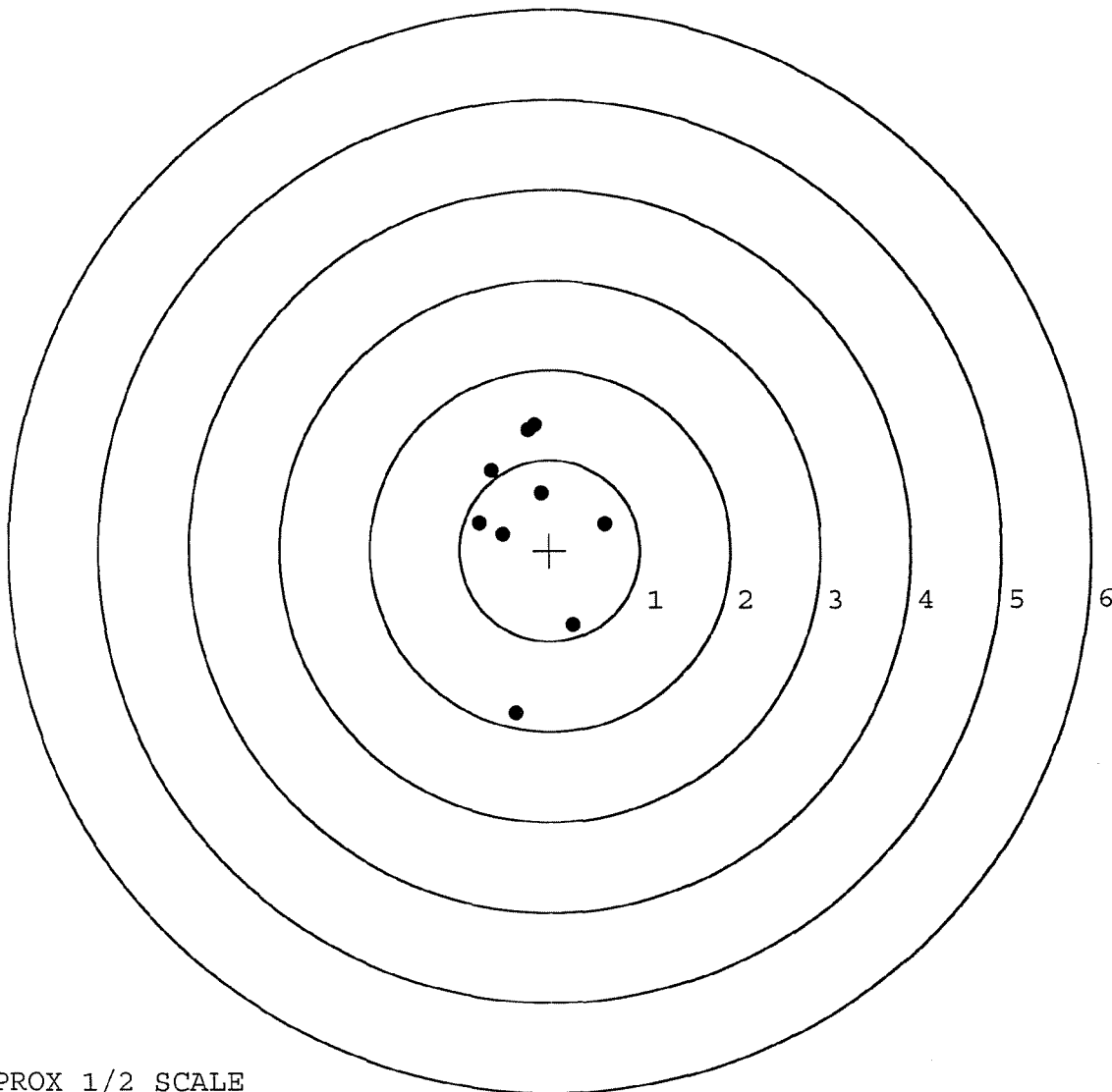
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.086
The Average Y Centroid of the Five Target Set:	0.222
The Average Point of Impact of the Five Target Set:	0.238
The Average Mean Radius of the Five Target Set:	0.988
The Distance from POA to Centroid Target #1:	0.343
The Distance from Centroid Target #2 to Centroid Target #1:	0.297
The Distance from Centroid Target #3 to Centroid Target #1:	0.446
The Distance from Centroid Target #4 to Centroid Target #1:	0.201
The Distance from Centroid Target #5 to Centroid Target #1:	0.206

SERIAL NUMBER: G6461776. __0
TARGET NUMBER: 1
FILE DATE: 10/19/2005
FILE TIME: 17:01

X CENTROID: -0.217
Y CENTROID: 0.266
POA TO CENTROID: 0.343
HORZ SPREAD: 1.395
VERT SPREAD: 3.190
GROUP SPREAD: 3.198
MIN RADIUS: 0.311
MAX RADIUS: 2.074
MEAN RADIUS: 0.922
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.517	0.184
2:	-0.783	0.311
3:	-0.646	0.886
4:	-0.161	1.389
5:	-0.237	1.332
6:	-0.095	0.627
7:	0.612	0.294
8:	0.258	-0.830
9:	-0.384	-1.801



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461776. __0

TARGET NUMBER: 2

FILE DATE: 10/19/2005

FILE TIME: 17:01

POINT#	X	Y
1:	-0.351	-0.075
2:	-0.180	-0.282
3:	-0.281	-0.541
4:	0.578	0.036
5:	0.910	0.710
6:	0.748	0.928
7:	-1.217	0.834
8:	-1.852	0.877
9:	-1.494	-1.406
10:	0.023	-1.237

X CENTROID: -0.312

Y CENTROID: -0.016

POA TO CENTROID: 0.312

HORZ SPREAD: 2.762

VERT SPREAD: 2.334

GROUP SPREAD: 3.236

MIN RADIUS: 0.071

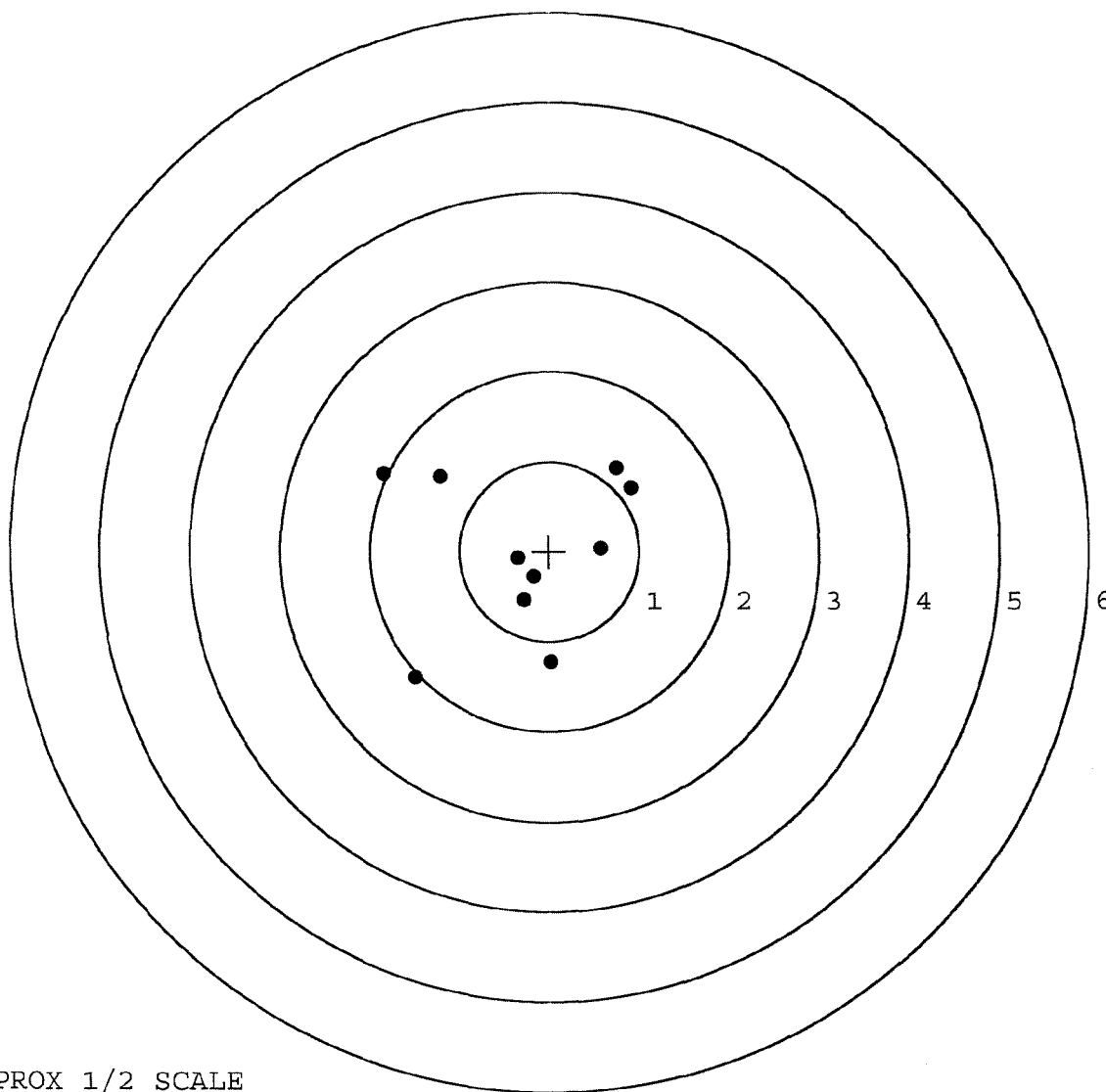
MAX RADIUS: 1.825

MEAN RADIUS: 1.074

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461776. __0

TARGET NUMBER: 3

FILE DATE: 10/19/2005

FILE TIME: 17:01

POINT#	X	Y
1:	-0.126	-0.335
2:	-0.212	0.409
3:	0.111	0.529
4:	0.299	0.986
5:	1.528	1.278
6:	0.864	-0.359
7:	0.605	-1.395
8:	-0.985	-1.429
9:	-0.167	2.169
10:	0.102	2.348

X CENTROID: 0.202

Y CENTROID: 0.420

POA TO CENTROID: 0.466

HORZ SPREAD: 2.513

VERT SPREAD: 3.777

GROUP SPREAD: 3.930

MIN RADIUS: 0.142

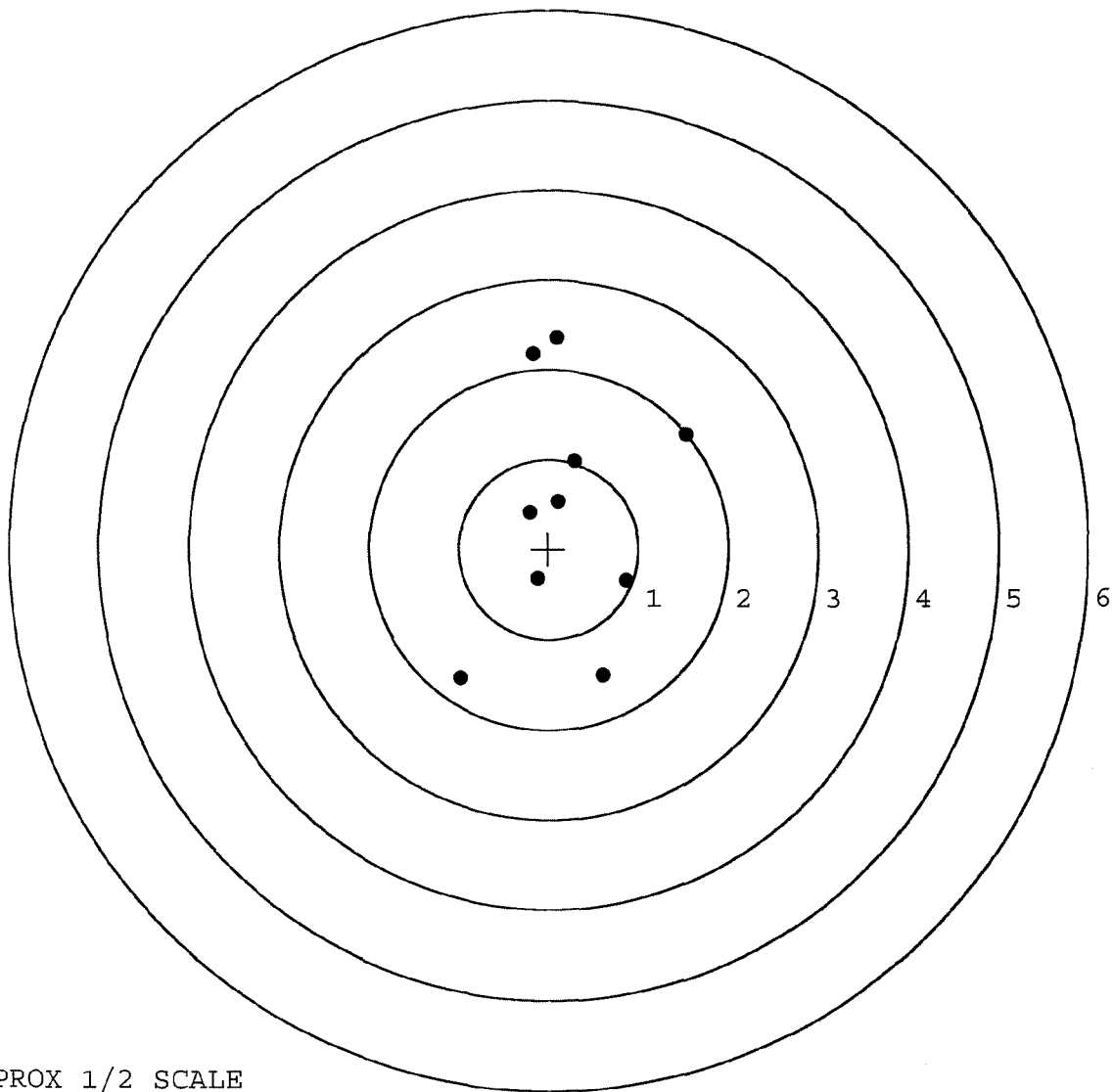
MAX RADIUS: 2.197

MEAN RADIUS: 1.233

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461776. 0

TARGET NUMBER: 4

FILE DATE: 10/19/2005

FILE TIME: 17:01

POINT#	X	Y
1:	-0.124	-0.268
2:	-0.773	-0.817
3:	0.172	-0.791
4:	0.821	-0.158
5:	0.570	0.450
6:	0.214	0.587
7:	-0.690	0.765
8:	-0.429	0.718
9:	-0.303	0.487
10:	-0.312	0.164

X CENTROID: -0.085

Y CENTROID: 0.114

POA TO CENTROID: 0.142

HORZ SPREAD: 1.594

VERT SPREAD: 1.582

GROUP SPREAD: 1.846

MIN RADIUS: 0.232

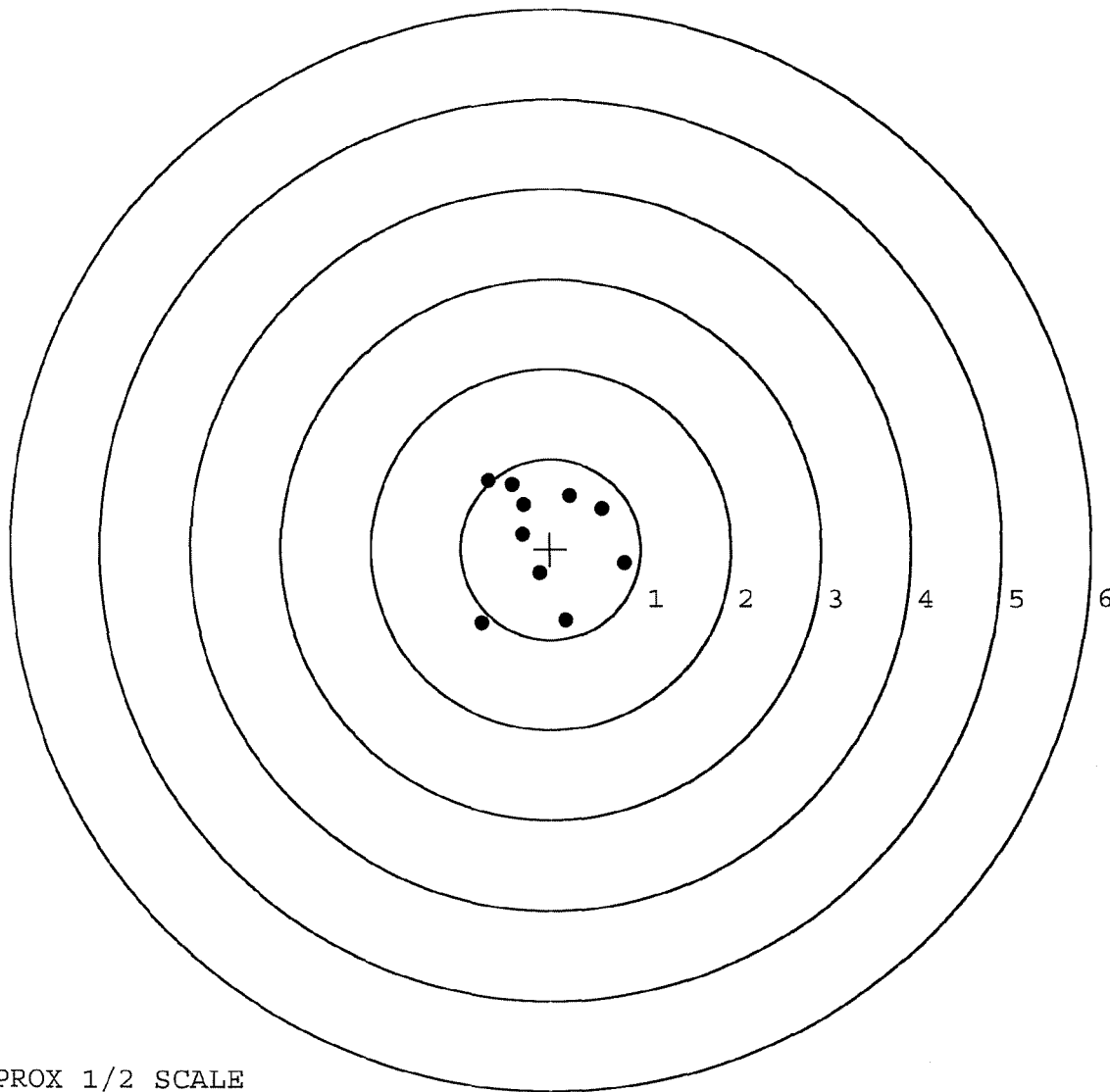
MAX RADIUS: 1.157

MEAN RADIUS: 0.697

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461776.___0

TARGET NUMBER: 5

FILE DATE: 10/19/2005

FILE TIME: 17:01

POINT#	X	Y
1:	-0.090	0.385
2:	0.444	0.282
3:	0.385	-0.689
4:	-0.509	-0.285
5:	-1.336	0.043
6:	-0.120	0.828
7:	0.461	1.251
8:	0.748	1.291
9:	0.006	1.859
10:	-0.188	-1.720

X CENTROID: -0.020

Y CENTROID: 0.325

POA TO CENTROID: 0.325

HORZ SPREAD: 2.084

VERT SPREAD: 3.579

GROUP SPREAD: 3.584

MIN RADIUS: 0.093

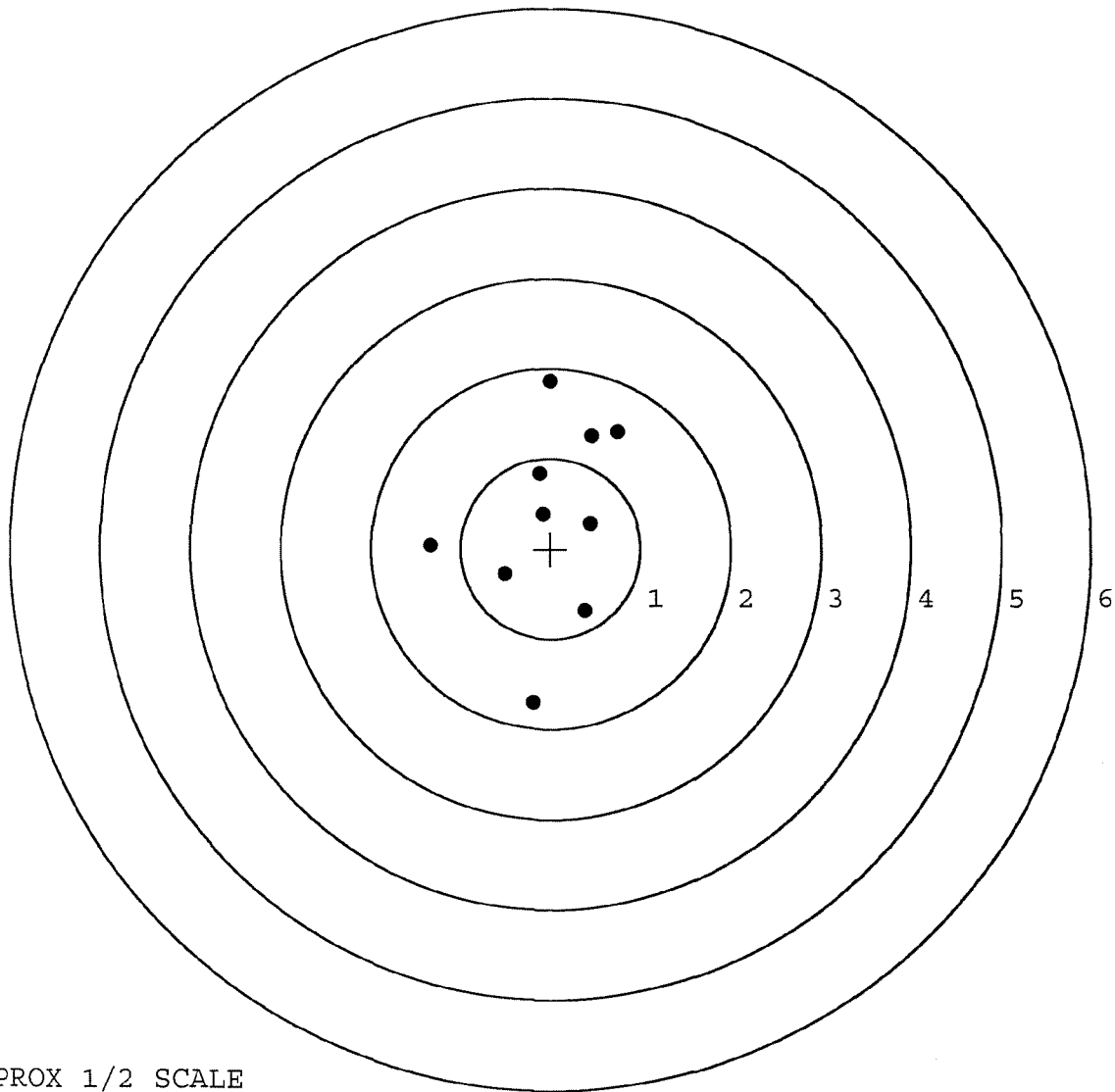
MAX RADIUS: 2.051

MEAN RADIUS: 1.015

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE