

G-6590054

ORDER 25727
M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
UPC



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UPC



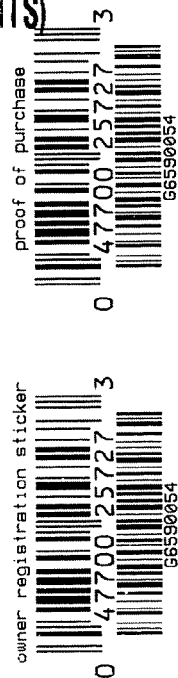
SERIAL NO.



M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 1651

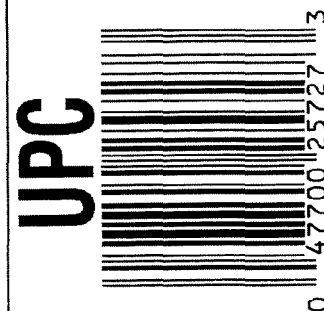


ORDER NO. **25727**

BARREL LENGTH 24"

CAPACITY 5

G6590054



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590054

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLG
420	ASSEMBLE ACTION		6/22/06	BLG
430	ASSEMBLE TO STOCK		6-23-06	R.P.
440	PROOF		6-23-06	TRW
460	CHECK HEADSPACE	MAGNA - FLUX	6-23-06	TRW
470	DIS-ASSEMBLE ACTION	INSPECTED	6-26-06	BLG
480	MAGNAFLUX BBL ACTION	JUN 27 2006		
490	MAGNAFLUX BOLT	OPERATOR <u>[Signature]</u>	6-27-06	APD
500	ROLLMARK CALIBER		6-27-06	CW
510	DRILL AND TAP SIGHT HOLES		6-26-06	TRW
520	GOFF BLAST BBL / REC		6-28-06	LG
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-18-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-18-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-18-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		7-18-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>7.0</u>	7-20-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.5</u>	7-20-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.020</u> <u>.020</u> <u>.020</u>	7-20-06	DA
	J) ASSEMBLE STOCK		7-18-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-9-06	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-18-06	RTZ
	M) IRON SIGHT ALIGNMENT		7-18-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-18-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	7-19-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-19-06	BD
670	FINAL INSPECTION A) HEADSPACE		8-9-06	A
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.72</u> <u>2.80</u> <u>2.79</u> <u>2.76</u>	7-20-06	DA
	C) FUNCTION		8-9-06	A
690	PACK			

F004 REV 5/2006

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)

DATE

7-17-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	245	251		250	
PULL #2	254	245		253	
PULL #3	240	253		256	
PULL #4	261	261		248	
PULL #5	260	264		255	
TOTAL	1260	1274		1262	
AVERAGE	252	254		252	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	310	306		
PULL #2	297	307		
PULL #3	311	304		
PULL #4	313	313		
PULL #5	286	312		
TOTAL	1517	1542		
AVERAGE	303	308		

	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	415	423		419
PULL #2	393	419		400
PULL #3	399	426		402
PULL #4	418	418		416
PULL #5	417	403		411
TOTAL	2042	2089		2048
AVERAGE	408	417		409

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590054.___0
FILE DATE AND TIME: 07/19/2006 08:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.048
The Average Y Centroid of the Five Target Set:	-0.085
The Average Point of Impact of the Five Target Set:	0.098
The Average Mean Radius of the Five Target Set:	0.748
The Distance from POA to Centroid Target #1:	0.052
The Distance from Centroid Target #2 to Centroid Target #1:	0.059
The Distance from Centroid Target #3 to Centroid Target #1:	0.394
The Distance from Centroid Target #4 to Centroid Target #1:	0.171
The Distance from Centroid Target #5 to Centroid Target #1:	0.039

SERIAL NUMBER: G6590054. __0

TARGET NUMBER: 1

FILE DATE: 07/19/2006

FILE TIME: 08:24

POINT#	X	Y
1:	1.147	-0.124
2:	0.746	-0.117
3:	0.496	0.402
4:	-0.129	-0.740
5:	-1.020	-0.085
6:	-0.587	-0.164
7:	-0.377	-0.022
8:	-0.246	0.076
9:	0.035	0.013
10:	0.011	0.246

X CENTROID: 0.008

Y CENTROID: -0.052

POA TO CENTROID: 0.052

HORZ SPREAD: 2.167

VERT SPREAD: 1.142

GROUP SPREAD: 2.167

MIN RADIUS: 0.070

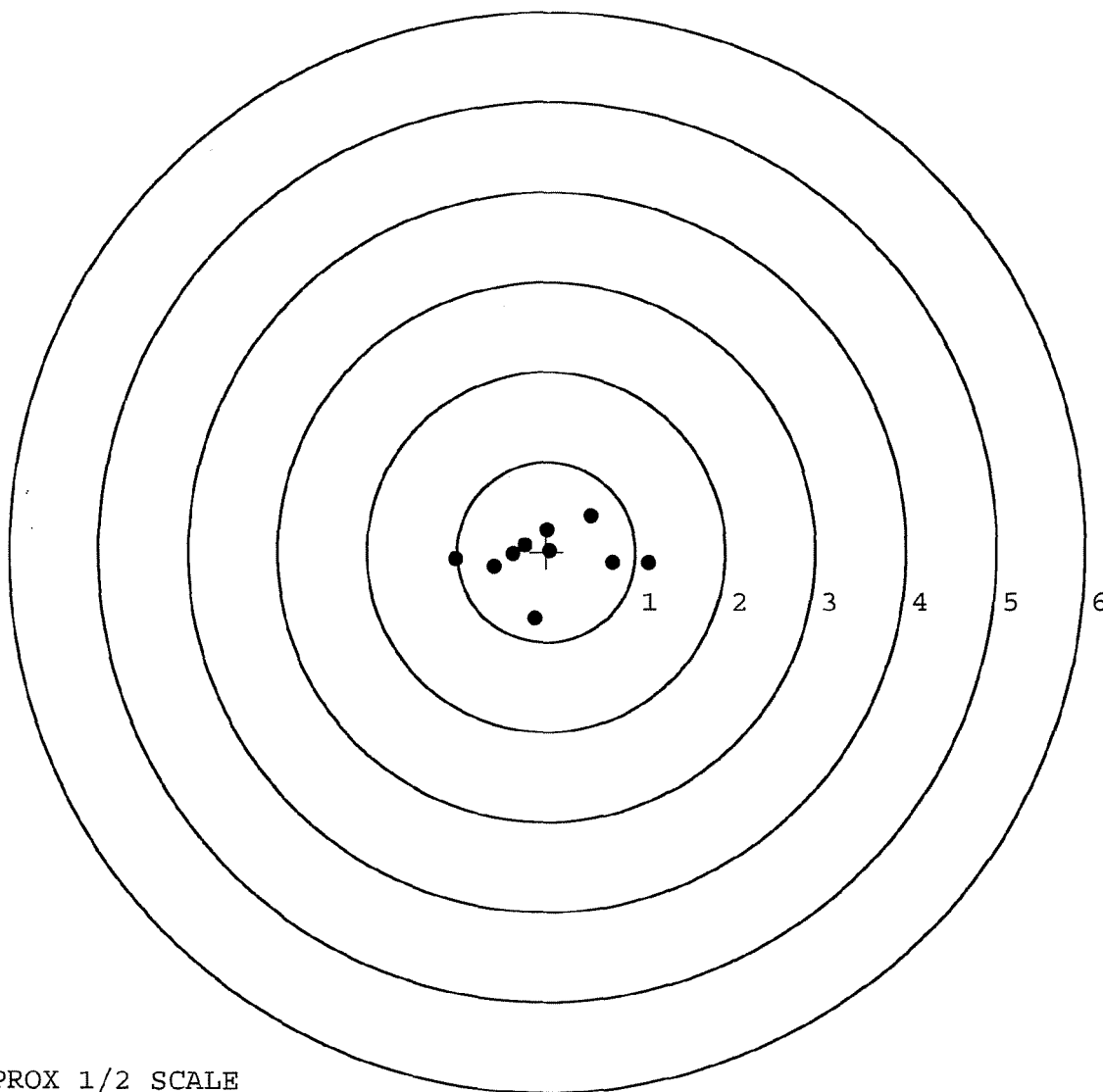
MAX RADIUS: 1.142

MEAN RADIUS: 0.592

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

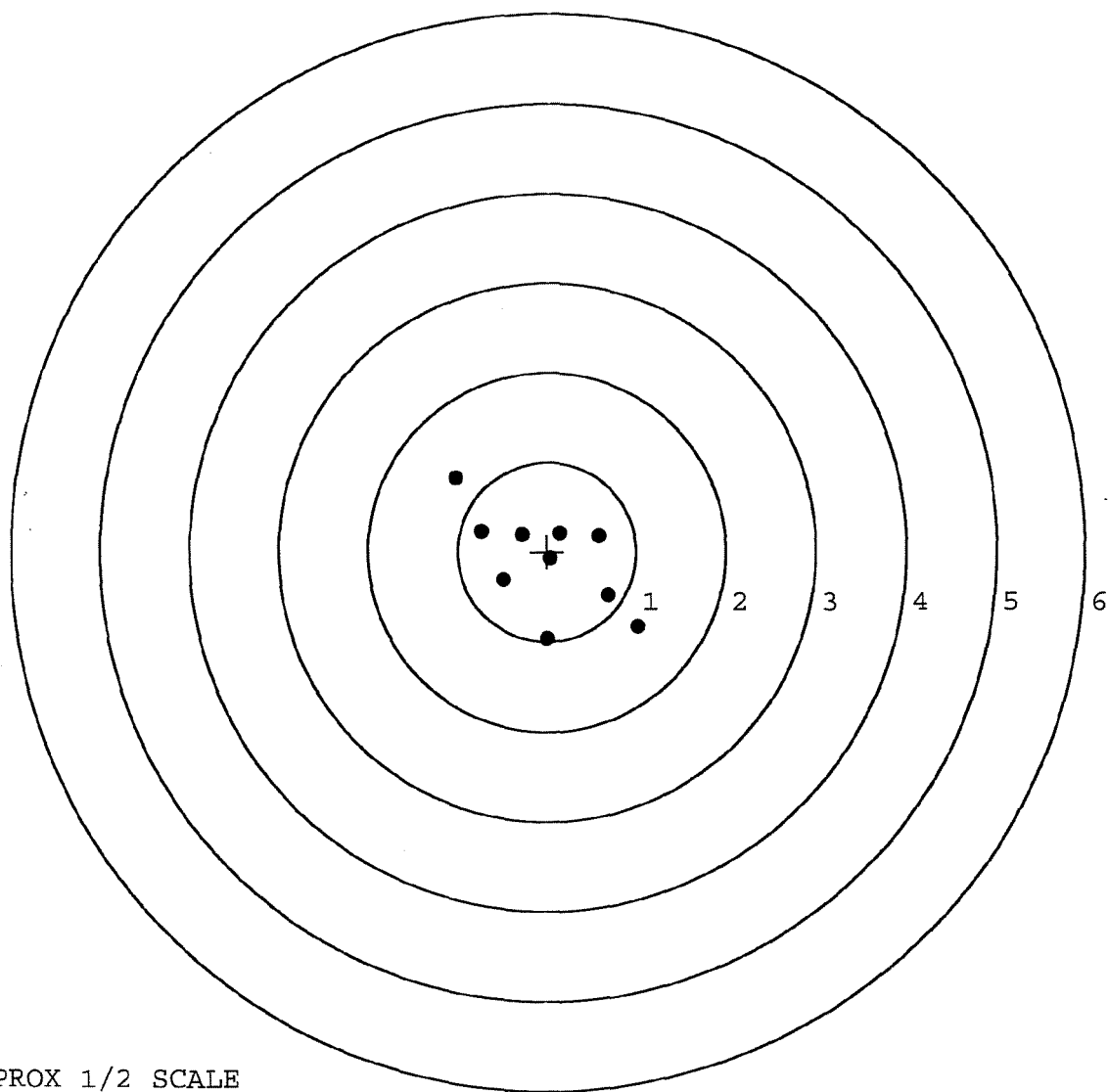
SERIAL NUMBER: G6590054. __0

TARGET NUMBER: 2

FILE DATE: 07/19/2006

FILE TIME: 08:24

	POINT#	X	Y
	1:	1.021	-0.836
	2:	0.690	-0.488
	3:	0.001	-0.980
	4:	0.576	0.177
X CENTROID:	5:	-0.495	-0.322
Y CENTROID:	6:	-0.745	0.225
POA TO CENTROID:	7:	-1.033	0.820
HORZ SPREAD:	8:	0.040	-0.075
VERT SPREAD:	9:	-0.292	0.187
GROUP SPREAD:	10:	0.137	0.213
MIN RADIUS:		0.060	
MAX RADIUS:		1.381	
MEAN RADIUS:		0.712	
# IN 1 IN DIAMETER:		3	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

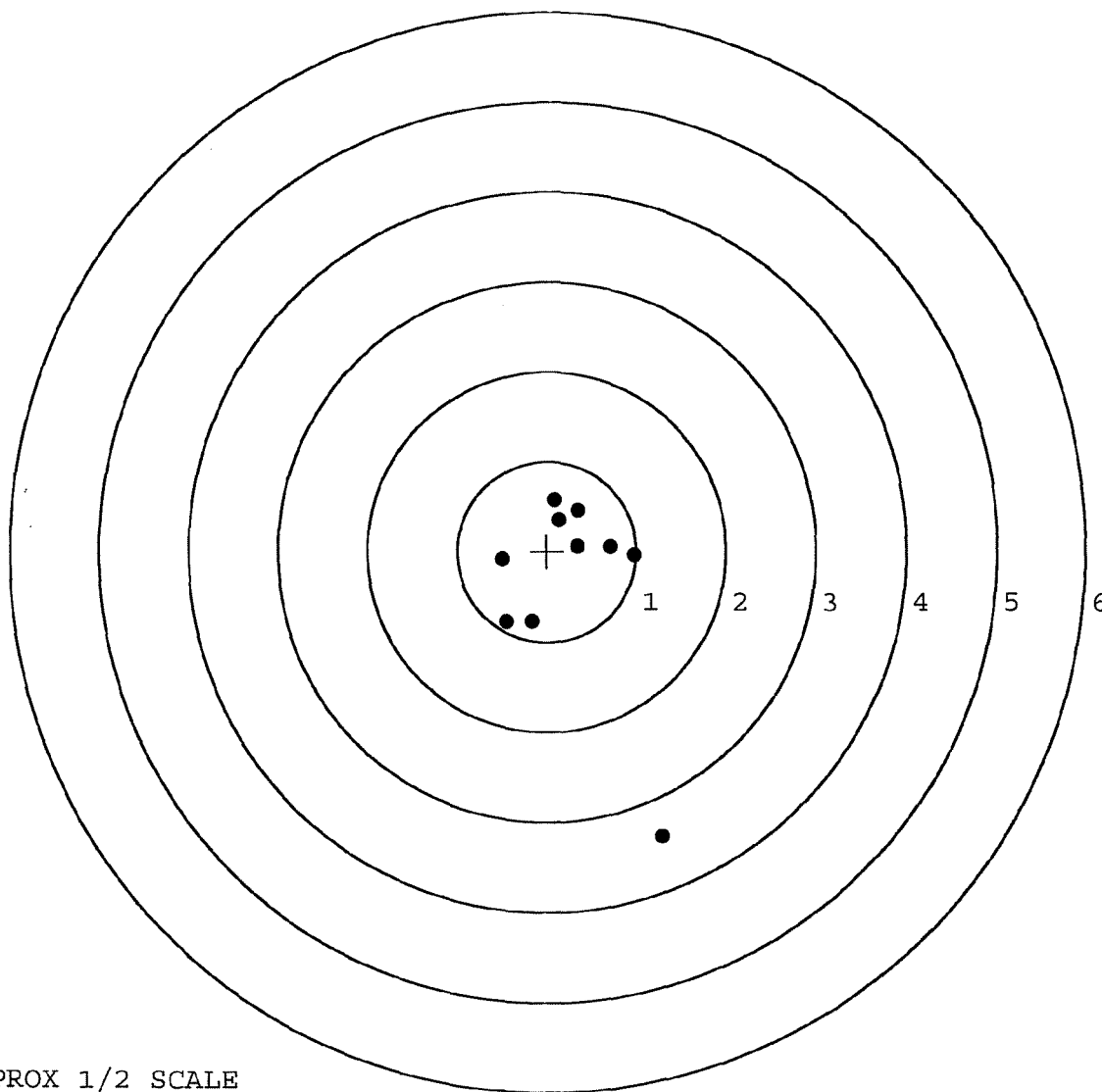
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TARGET NUMBER: 3

FILE DATE: 07/19/2006

FILE TIME: 08:24

	POINT#	X	Y
	1:	0.982	-0.041
	2:	0.711	0.050
	3:	0.343	0.055
	4:	0.343	0.457
	5:	0.084	0.567
	6:	0.131	0.340
	7:	-0.504	-0.100
	8:	-0.458	-0.776
	9:	-0.167	-0.775
	10:	1.313	-3.165
X CENTROID:		0.278	
Y CENTROID:		-0.339	
POA TO CENTROID:		0.438	
HORZ SPREAD:		1.817	
VERT SPREAD:		3.732	
GROUP SPREAD:		3.929	
MIN RADIUS:		0.399	
MAX RADIUS:		3.010	
MEAN RADIUS:		0.947	
# IN 1 IN DIAMETER:		1	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		9	



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590054. __0

TARGET NUMBER: 4

FILE DATE: 07/19/2006

FILE TIME: 08:24

POINT#	X	Y
1:	-0.141	-1.309
2:	-0.263	-0.945
3:	0.006	-0.674
4:	0.316	-0.333
5:	0.439	0.688
6:	0.292	0.748
7:	0.110	1.211
8:	-0.055	0.789
9:	-0.101	0.345
10:	-0.654	0.671

X CENTROID: -0.005

Y CENTROID: 0.119

POA TO CENTROID: 0.119

HORZ SPREAD: 1.093

VERT SPREAD: 2.520

GROUP SPREAD: 2.532

MIN RADIUS: 0.245

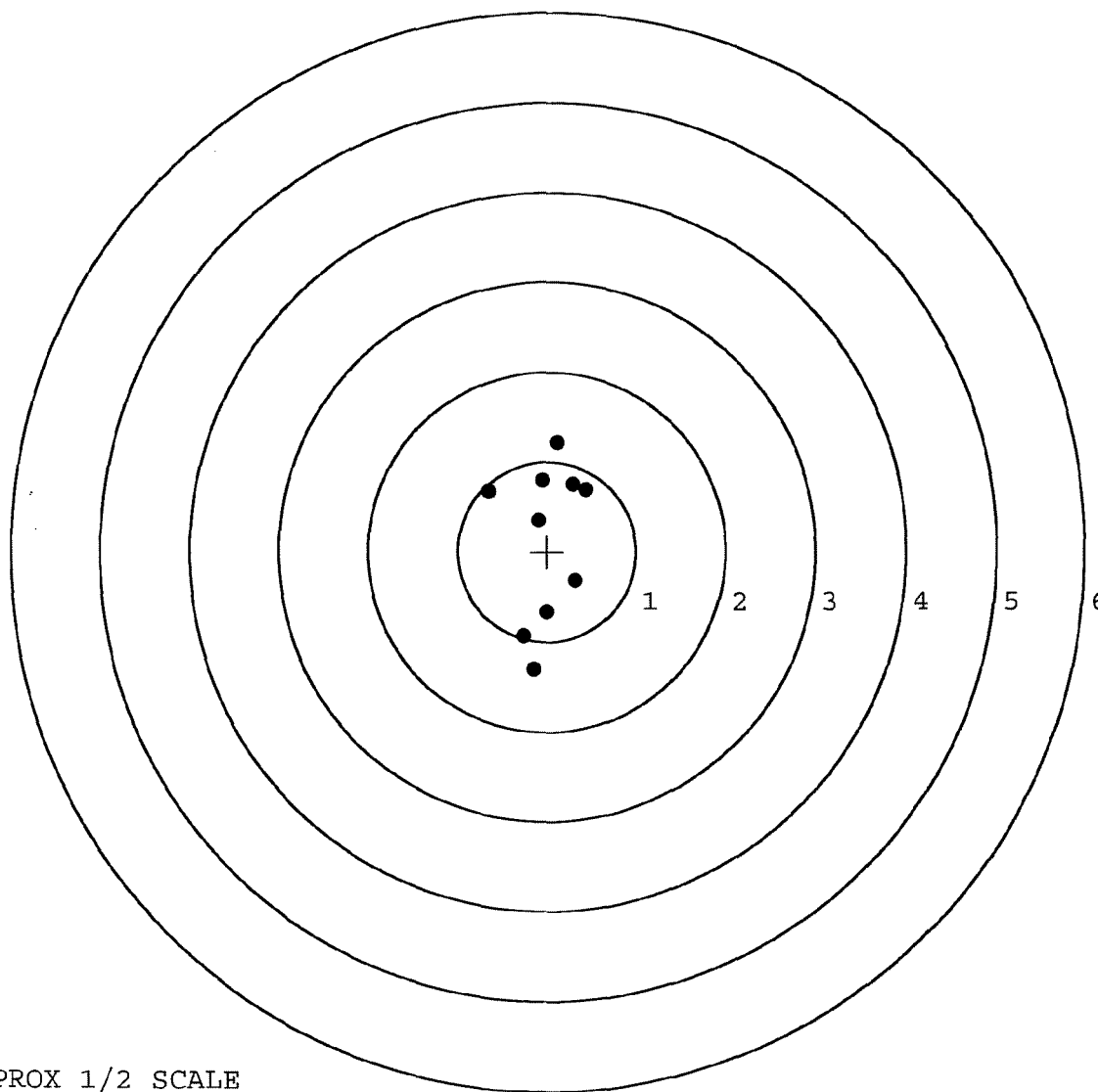
MAX RADIUS: 1.435

MEAN RADIUS: 0.816

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

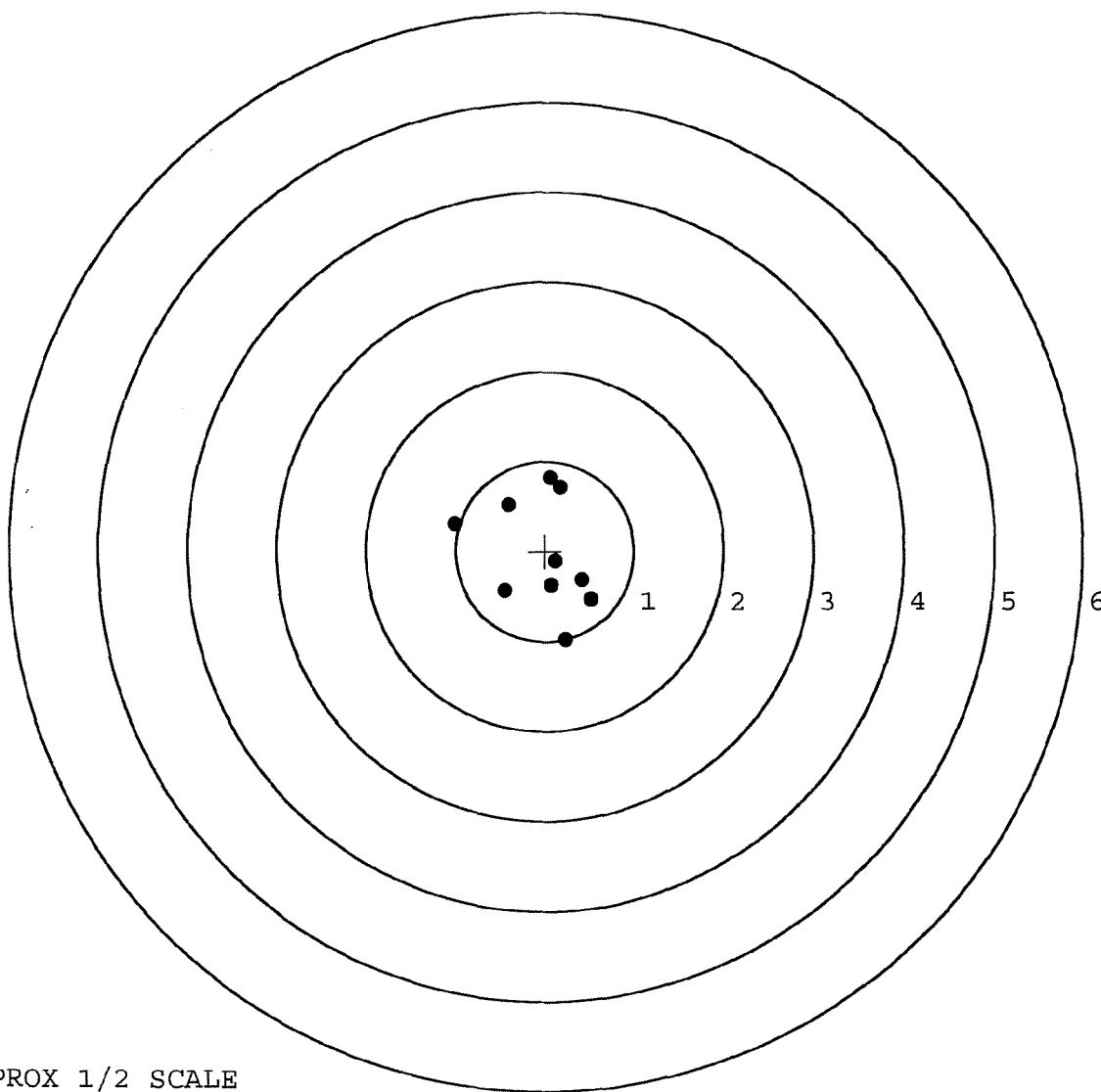
SERIAL NUMBER: G6590054. __0

TARGET NUMBER: 5

FILE DATE: 07/19/2006

FILE TIME: 08:24

	POINT#	X	Y
	1:	0.168	0.708
	2:	0.059	0.815
	3:	-0.419	0.510
	4:	-1.014	0.294
X CENTROID:	5:	-0.458	-0.444
Y CENTROID:	6:	0.237	-0.986
POA TO CENTROID:	7:	0.118	-0.117
HORZ SPREAD:	8:	0.068	-0.385
VERT SPREAD:	9:	0.414	-0.321
GROUP SPREAD:	10:	0.520	-0.534
MIN RADIUS:		0.165	
MAX RADIUS:		1.040	
MEAN RADIUS:		0.670	
# IN 1 IN DIAMETER:		2	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590054.___0
FILE DATE AND TIME: 11/10/2006 15:16

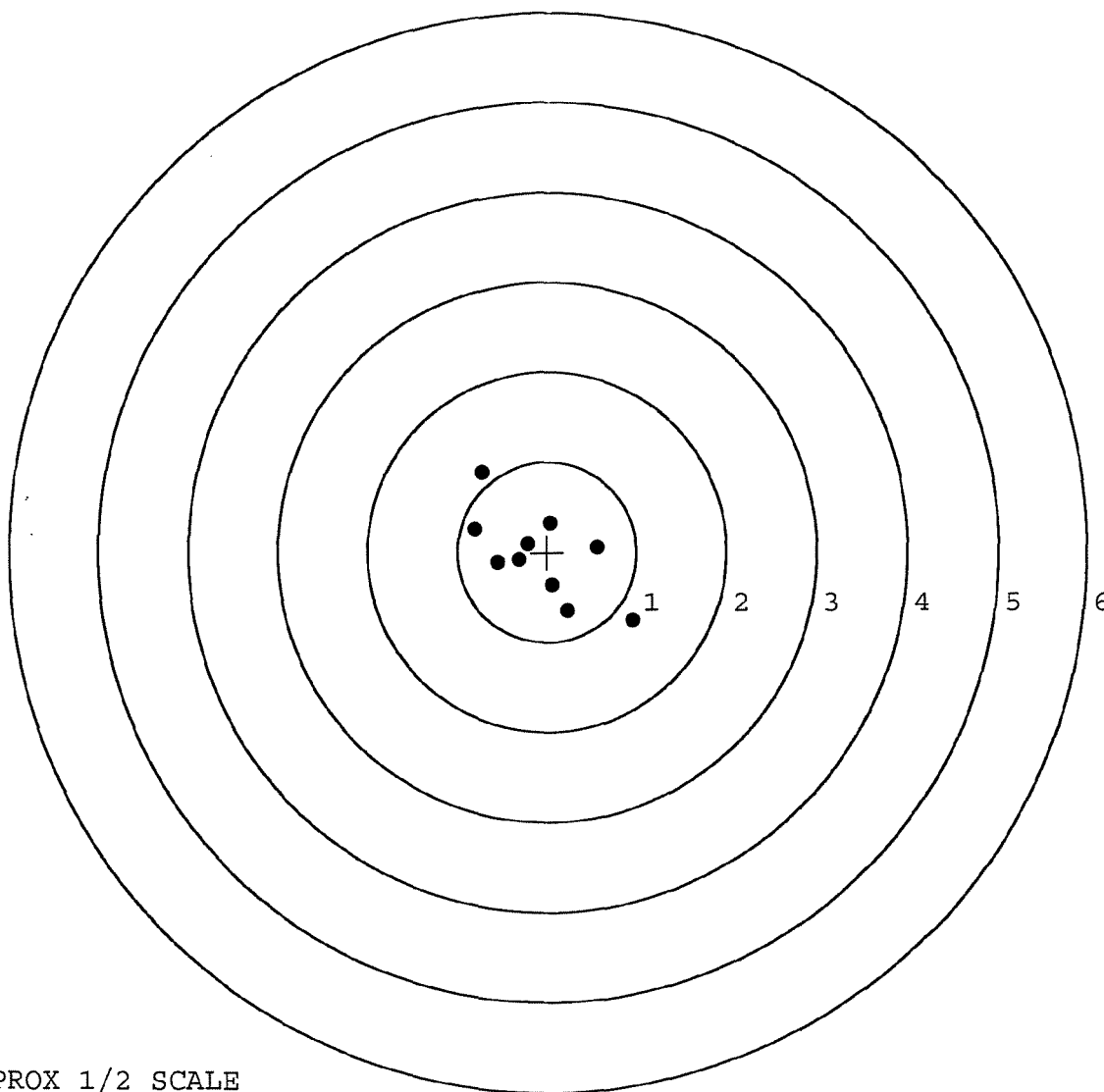
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.062
The Average Y Centroid of the Five Target Set:	-0.128
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.575
The Distance from POA to Centroid Target #1:	0.087
The Distance from Centroid Target #2 to Centroid Target #1:	0.299
The Distance from Centroid Target #3 to Centroid Target #1:	0.060
The Distance from Centroid Target #4 to Centroid Target #1:	0.145
The Distance from Centroid Target #5 to Centroid Target #1:	0.095

SERIAL NUMBER: G6590054. __0
TARGET NUMBER: 1
FILE DATE: 11/10/2006
FILE TIME: 15:16

X CENTROID: -0.079
Y CENTROID: -0.038
POA TO CENTROID: 0.087
HORZ SPREAD: 1.774
VERT SPREAD: 1.643
GROUP SPREAD: 2.365
MIN RADIUS: 0.191
MAX RADIUS: 1.267
MEAN RADIUS: 0.619
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.963	-0.760
2:	0.566	0.059
3:	0.033	0.326
4:	0.237	-0.655
5:	0.057	-0.372
6:	-0.218	0.092
7:	-0.319	-0.088
8:	-0.556	-0.118
9:	-0.811	0.253
10:	-0.738	0.883

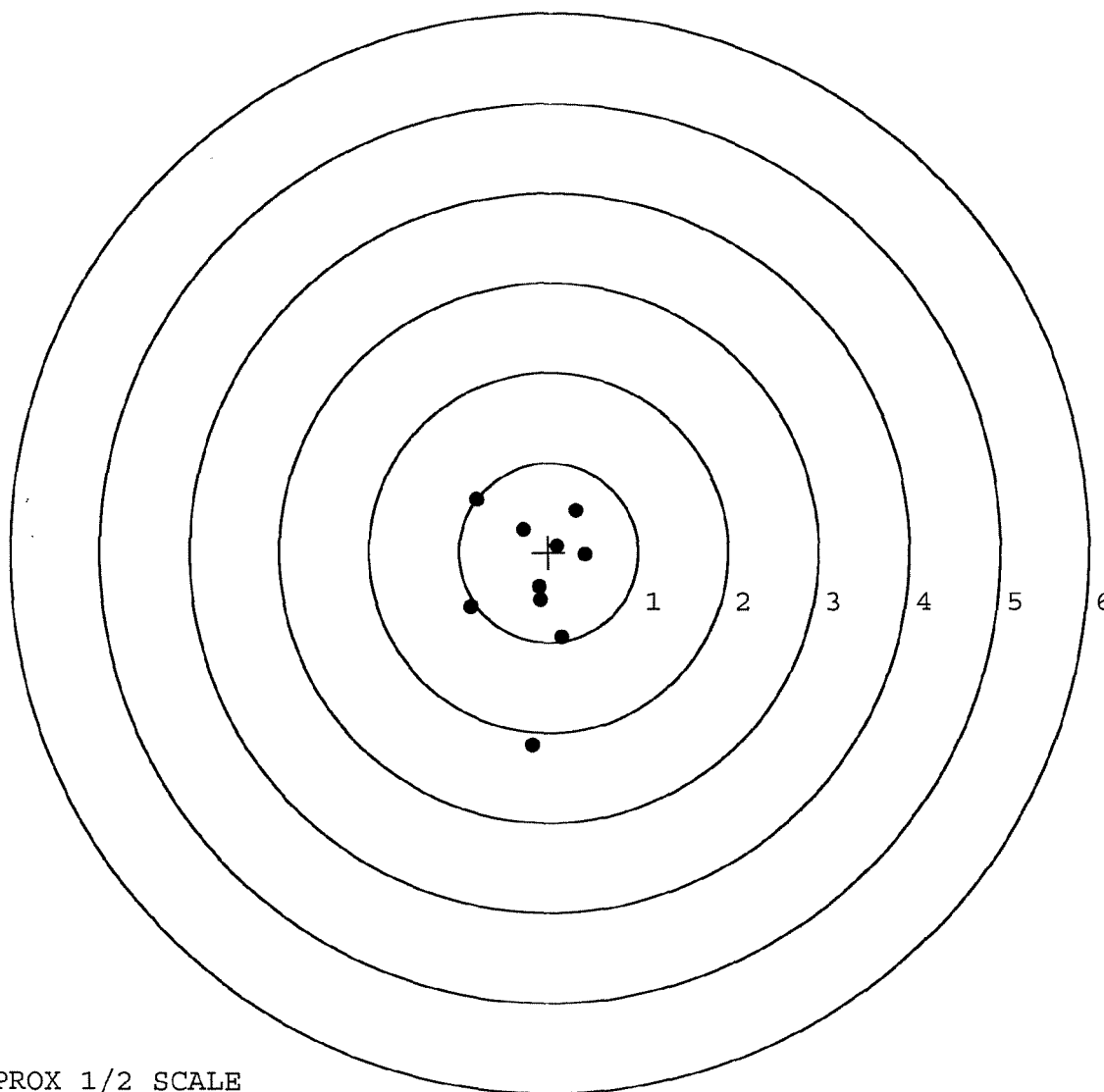


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590054. __ 0
TARGET NUMBER: 2
FILE DATE: 11/10/2006
FILE TIME: 15:16

POINT#	X	Y
1:	-0.178	-2.153
2:	0.152	-0.950
3:	-0.866	-0.619
4:	-0.094	-0.545
5:	-0.111	-0.394
6:	0.407	-0.029
7:	0.098	0.069
8:	-0.291	0.253
9:	0.305	0.472
10:	-0.801	0.588

X CENTROID: -0.138
Y CENTROID: -0.331
POA TO CENTROID: 0.358
HORZ SPREAD: 1.273
VERT SPREAD: 2.741
GROUP SPREAD: 2.811
MIN RADIUS: 0.069
MAX RADIUS: 1.823
MEAN RADIUS: 0.732
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

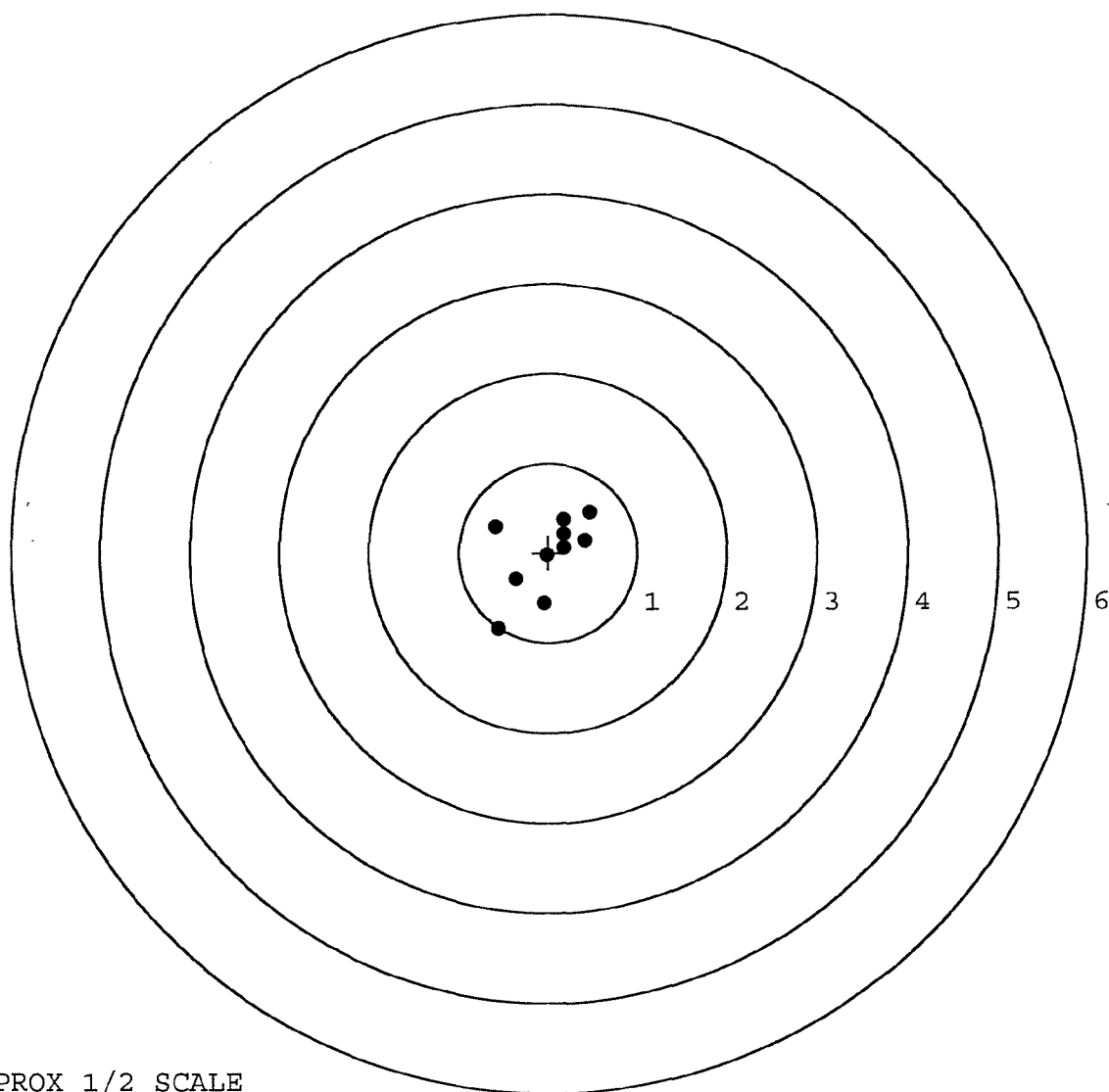


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590054. __0
TARGET NUMBER: 3
FILE DATE: 11/10/2006
FILE TIME: 15:16

X CENTROID: -0.021
Y CENTROID: -0.022
POA TO CENTROID: 0.030
HORZ SPREAD: 1.057
VERT SPREAD: 1.308
GROUP SPREAD: 1.662
MIN RADIUS: 0.011
MAX RADIUS: 0.992
MEAN RADIUS: 0.473
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.050	-0.569
2:	-0.362	-0.298
3:	-0.565	-0.851
4:	-0.596	0.298
5:	0.461	0.457
6:	0.172	0.367
7:	0.412	0.144
8:	-0.023	-0.033
9:	0.173	0.054
10:	0.169	0.212

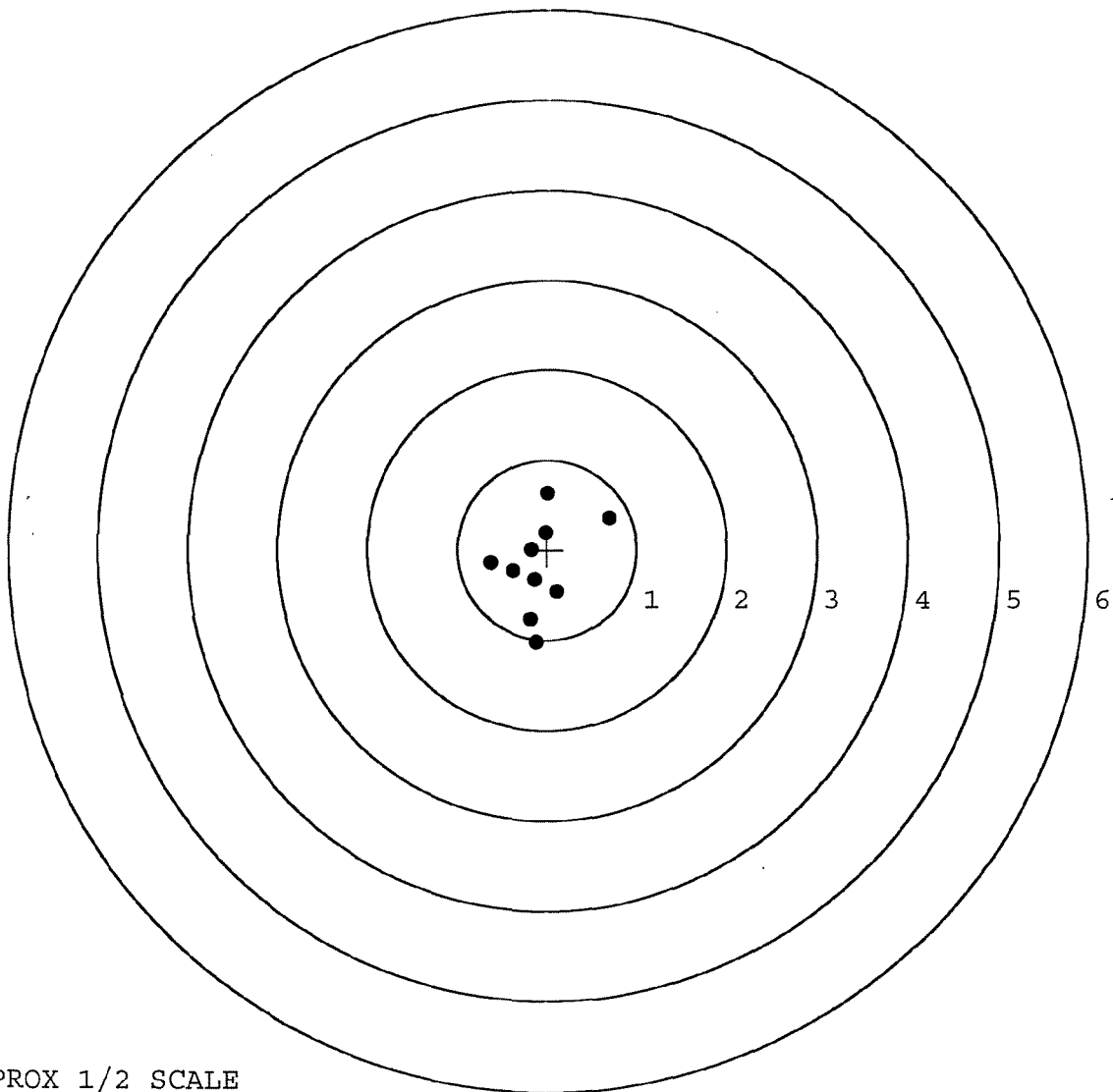


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590054. __0
TARGET NUMBER: 4
FILE DATE: 11/10/2006
FILE TIME: 15:16

X CENTROID: -0.085
Y CENTROID: -0.182
POA TO CENTROID: 0.201
HORZ SPREAD: 1.323
VERT SPREAD: 1.660
GROUP SPREAD: 1.608
MIN RADIUS: 0.165
MAX RADIUS: 0.943
MEAN RADIUS: 0.516
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.121	-1.033
2:	-0.180	-0.776
3:	0.107	-0.470
4:	0.690	0.355
5:	0.004	0.627
6:	-0.017	0.192
7:	-0.143	-0.337
8:	-0.178	0.002
9:	-0.633	-0.150
10:	-0.380	-0.234

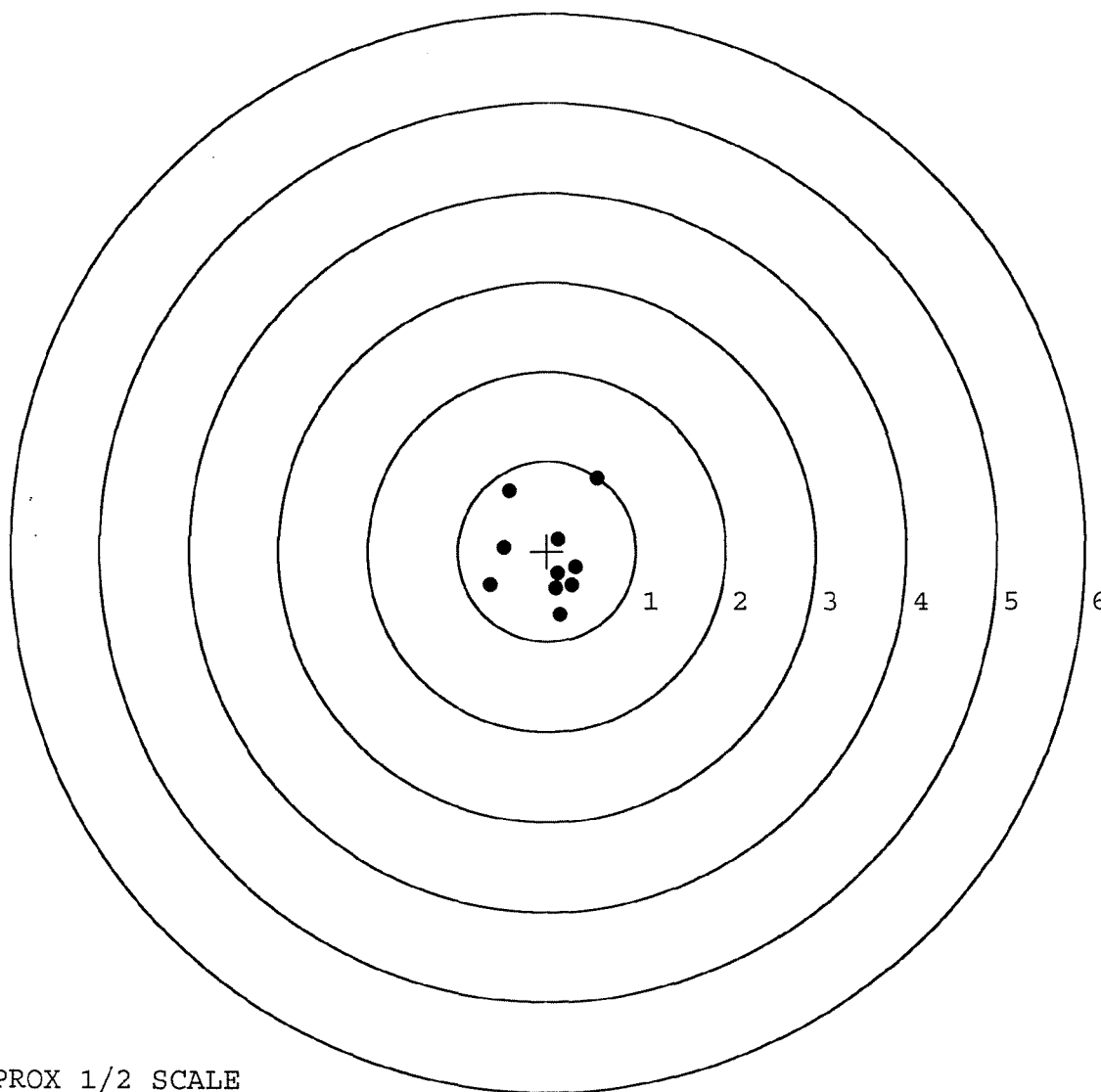


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590054. 0
TARGET NUMBER: 5
FILE DATE: 11/10/2006
FILE TIME: 15:16

X CENTROID: 0.012
Y CENTROID: -0.065
POA TO CENTROID: 0.066
HORZ SPREAD: 1.199
VERT SPREAD: 1.531
GROUP SPREAD: 1.692
MIN RADIUS: 0.216
MAX RADIUS: 1.041
MEAN RADIUS: 0.534
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.565	0.818
2:	0.130	0.133
3:	-0.433	0.669
4:	-0.485	0.041
5:	-0.634	-0.376
6:	0.322	-0.176
7:	0.124	-0.249
8:	0.282	-0.374
9:	0.152	-0.713
10:	0.101	-0.419



TARGET APPROX 1/2 SCALE