

G6590055

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

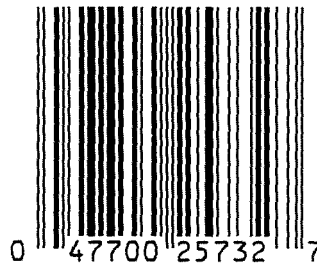
UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6590055



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6590055

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLC
420	ASSEMBLE ACTION		6/22/06	BLC
430	ASSEMBLE TO STOCK		6-23-06	R.P.
440	PROOF	MAGNA-FLUX INSPECTED	6-23-06	TRW
460	CHECK HEADSPACE		6-23-06	TRW
470	DIS-ASSEMBLE ACTION	JUN 27 2006	6-26-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	6-27-06	APD
490	MAGNAFLUX BOLT			
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	(LC)
530 & 540	APPLY COATINGS (BARREL ACTION)		7/12	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-13-06	BLC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-13-06	BLC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-13-06	BLC
	D) OIL FIRING PIN ASSEMBLY		7-31-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		7-17-06	RD

F004 REV 5/2006

OP #	OPERATION NAME	2 LBS MIN 10 LBS MAX	READINGS	DATE	INITIALS
560	F) SAFETY ON FORCE		<u>7.2</u> <u>6.5</u> <u>6.5</u>	7-13-06	DA
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>4.5</u>	7-18-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			7-18-06	BLC-
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	7-18-06	DA
	J) ASSEMBLE STOCK			7-13-06	BLC-
	K) ASSEMBLE SWIVEL STUDS				
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u> FAIL <u>PASS</u> FAIL	7-17-06	TRW
	MALFUNCTION <i>FPO</i>		CORRECTION <i>OK</i>	7-18-06	TRW
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION <i>N/A</i>		
	MALFUNCTION		CORRECTION		
660	INSPECT FOR LIVE AMMO			7-17-06	BD
670	FINAL INSPECTION A) HEADSPACE			7-31-06	BLC-
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.58</u> <u>2.53</u> <u>2.54</u> <u>2.72</u>	7-18-06	DA
	C) FUNCTION			7-31-06	BLC-
690	PACK			7-31-06	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)

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	2.50	2.64		2.58	
PULL #2	2.64	2.51		2.59	
PULL #3	2.61	2.63		2.42	
PULL #4	2.66	2.55		2.50	
PULL #5	2.63	2.64		2.55	
TOTAL	13.04	12.87		12.64	
AVERAGE	2.60	2.57		2.52	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.12		
PULL #2	2.95	3.12		
PULL #3	3.13	3.14		
PULL #4	3.00	3.03		
PULL #5	3.12	3.13		
TOTAL	15.24	15.54		
AVERAGE	3.04	3.10		

	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	4.11	3.87		4.06
PULL #2	4.02	3.97		3.94
PULL #3	4.09	4.09		3.98
PULL #4	4.03	4.01		4.10
PULL #5	3.99	3.96		4.07
TOTAL	20.24	19.90		20.15
AVERAGE	4.04	3.98		4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590055.___0
FILE DATE AND TIME: 07/17/2006 08:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.043
The Average Y Centroid of the Five Target Set:	0.104
The Average Point of Impact of the Five Target Set:	0.113
The Average Mean Radius of the Five Target Set:	0.789
The Distance from POA to Centroid Target #1:	0.318
The Distance from Centroid Target #2 to Centroid Target #1:	0.080
The Distance from Centroid Target #3 to Centroid Target #1:	0.312
The Distance from Centroid Target #4 to Centroid Target #1:	0.297
The Distance from Centroid Target #5 to Centroid Target #1:	0.446

SERIAL NUMBER: G6590055. __0

TARGET NUMBER: 1

FILE DATE: 07/17/2006

FILE TIME: 08:11

POINT#	X	Y
1:	0.263	0.733
2:	-0.213	0.643
3:	-0.083	0.224
4:	0.347	0.041
5:	-0.181	-0.836
6:	0.038	-0.242
7:	-0.122	-0.256
8:	-0.310	-0.298
9:	0.762	1.463
10:	0.562	1.523

X CENTROID: 0.106

Y CENTROID: 0.300

POA TO CENTROID: 0.318

HORZ SPREAD: 1.072

VERT SPREAD: 2.359

GROUP SPREAD: 2.485

MIN RADIUS: 0.204

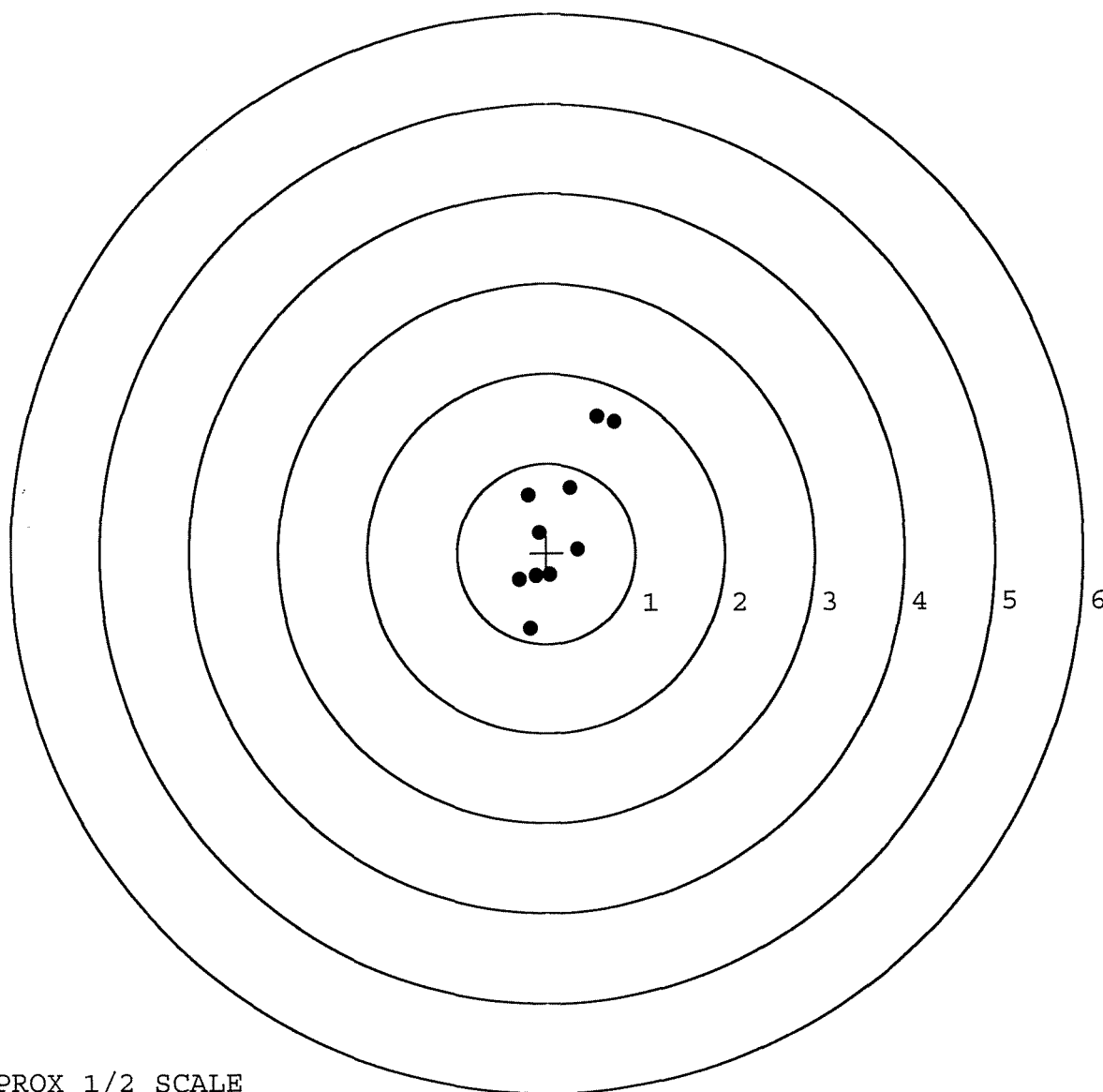
MAX RADIUS: 1.336

MEAN RADIUS: 0.717

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590055. __0

TARGET NUMBER: 2

FILE DATE: 07/17/2006

FILE TIME: 08:11

POINT#	X	Y
1:	0.855	0.585
2:	0.636	0.976
3:	0.990	1.405
4:	-0.979	1.158
5:	0.416	0.090
6:	-0.083	-0.529
7:	-0.315	-0.385
8:	-0.288	0.225
9:	-0.548	0.048
10:	-0.270	-0.107

X CENTROID: 0.041

Y CENTROID: 0.347

POA TO CENTROID: 0.349

HORZ SPREAD: 1.969

VERT SPREAD: 1.934

GROUP SPREAD: 2.215

MIN RADIUS: 0.351

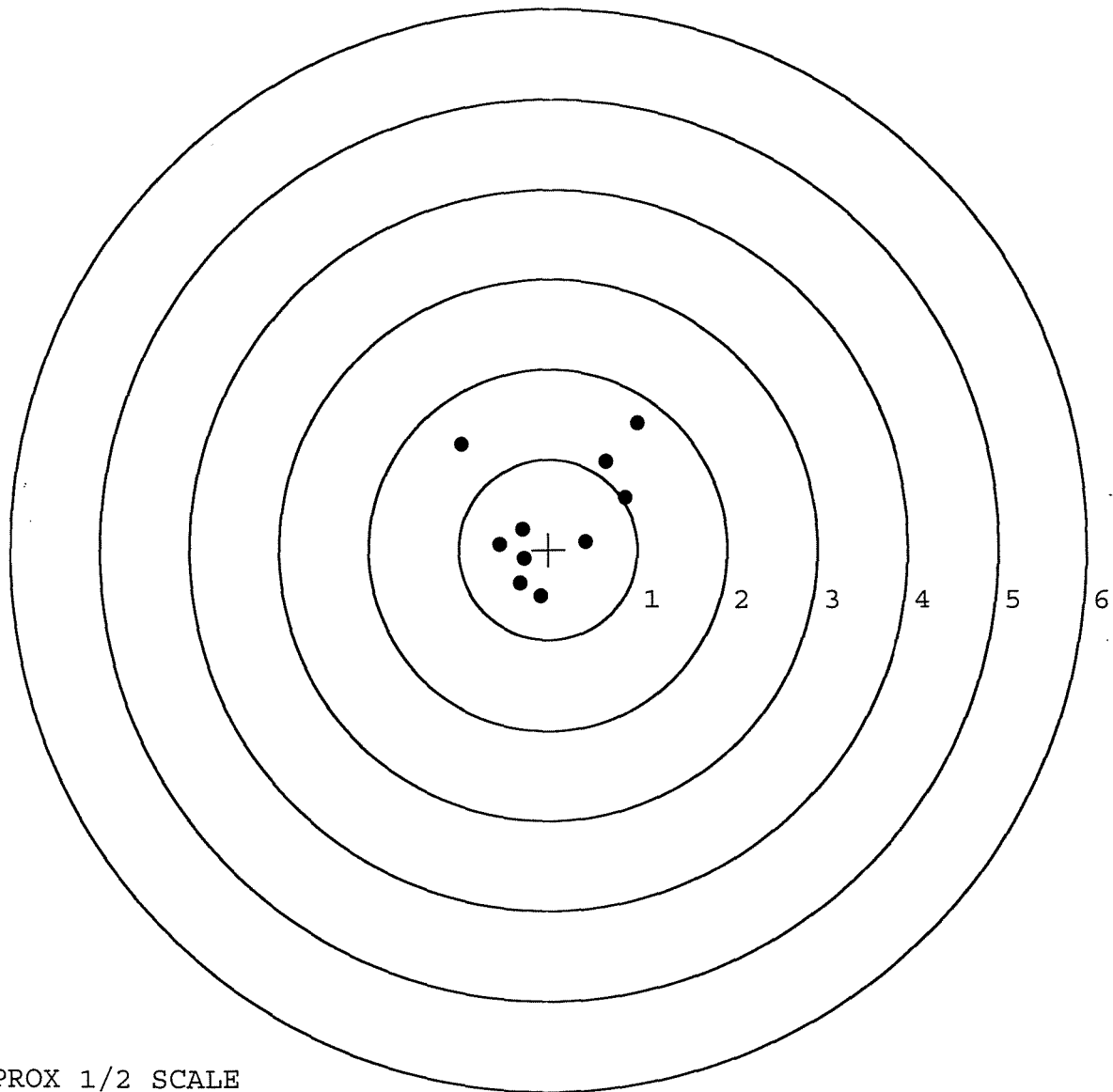
MAX RADIUS: 1.421

MEAN RADIUS: 0.815

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

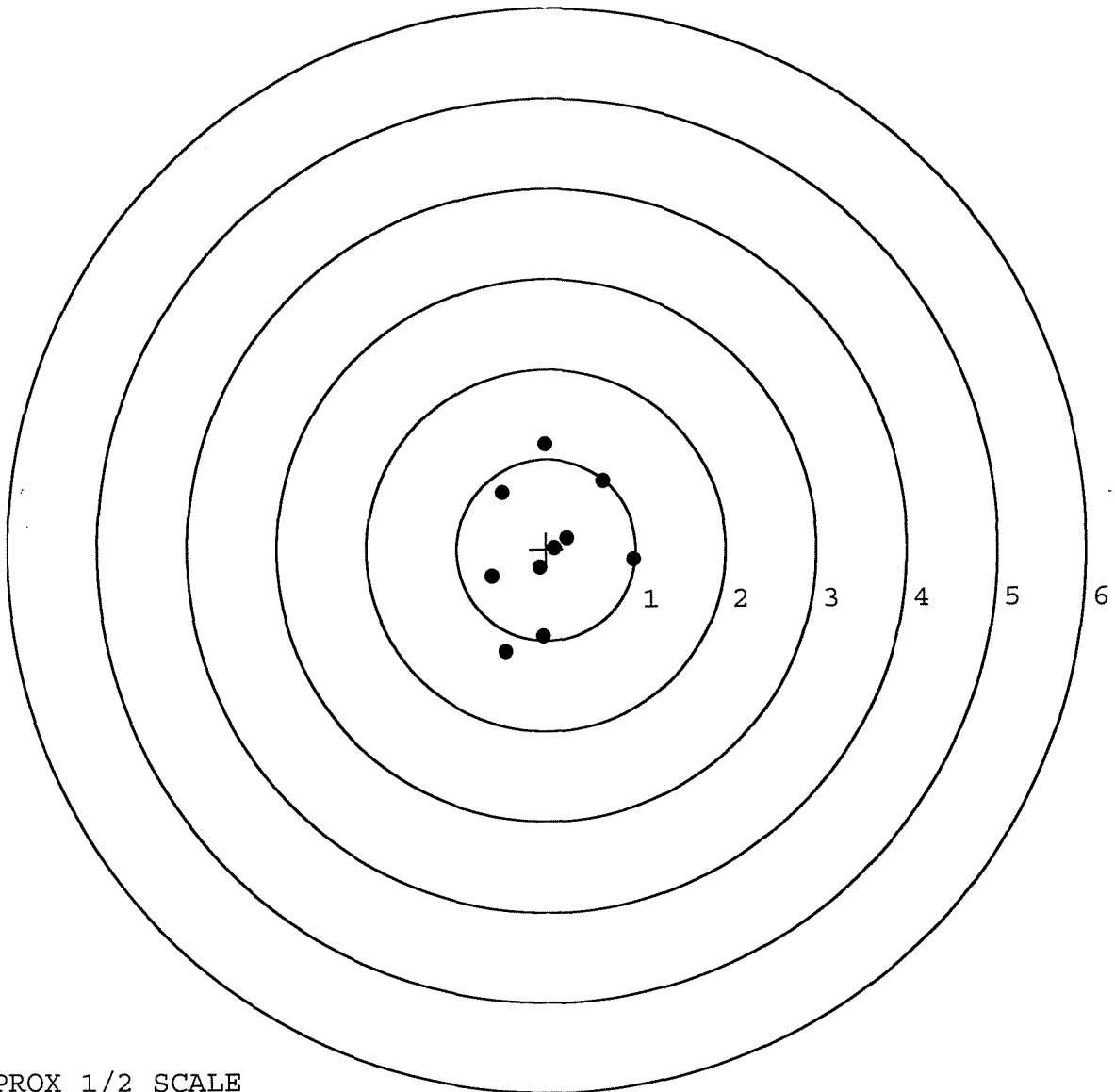


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590055. __0
TARGET NUMBER: 3
FILE DATE: 07/17/2006
FILE TIME: 08:11

POINT#	X	Y
1:	0.980	-0.118
2:	0.628	0.754
3:	-0.015	1.164
4:	-0.495	0.627
5:	-0.034	-0.966
6:	-0.455	-1.132
7:	-0.610	-0.298
8:	-0.075	-0.200
9:	0.093	0.018
10:	0.232	0.132

X CENTROID: 0.025
Y CENTROID: -0.002
POA TO CENTROID: 0.025
HORZ SPREAD: 1.590
VERT SPREAD: 2.296
GROUP SPREAD: 2.338
MIN RADIUS: 0.071
MAX RADIUS: 1.228
MEAN RADIUS: 0.735
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590055. __0

TARGET NUMBER: 4

FILE DATE: 07/17/2006

FILE TIME: 08:11

POINT#	X	Y
1:	-0.107	-1.140
2:	-0.686	-1.040
3:	0.310	-0.678
4:	-0.140	-0.290
5:	0.179	-0.242
6:	0.338	-0.049
7:	0.394	1.030
8:	0.073	0.660
9:	-0.015	1.062
10:	0.105	0.778

X CENTROID: 0.045

Y CENTROID: 0.009

POA TO CENTROID: 0.046

HORZ SPREAD: 1.080

VERT SPREAD: 2.202

GROUP SPREAD: 2.335

MIN RADIUS: 0.285

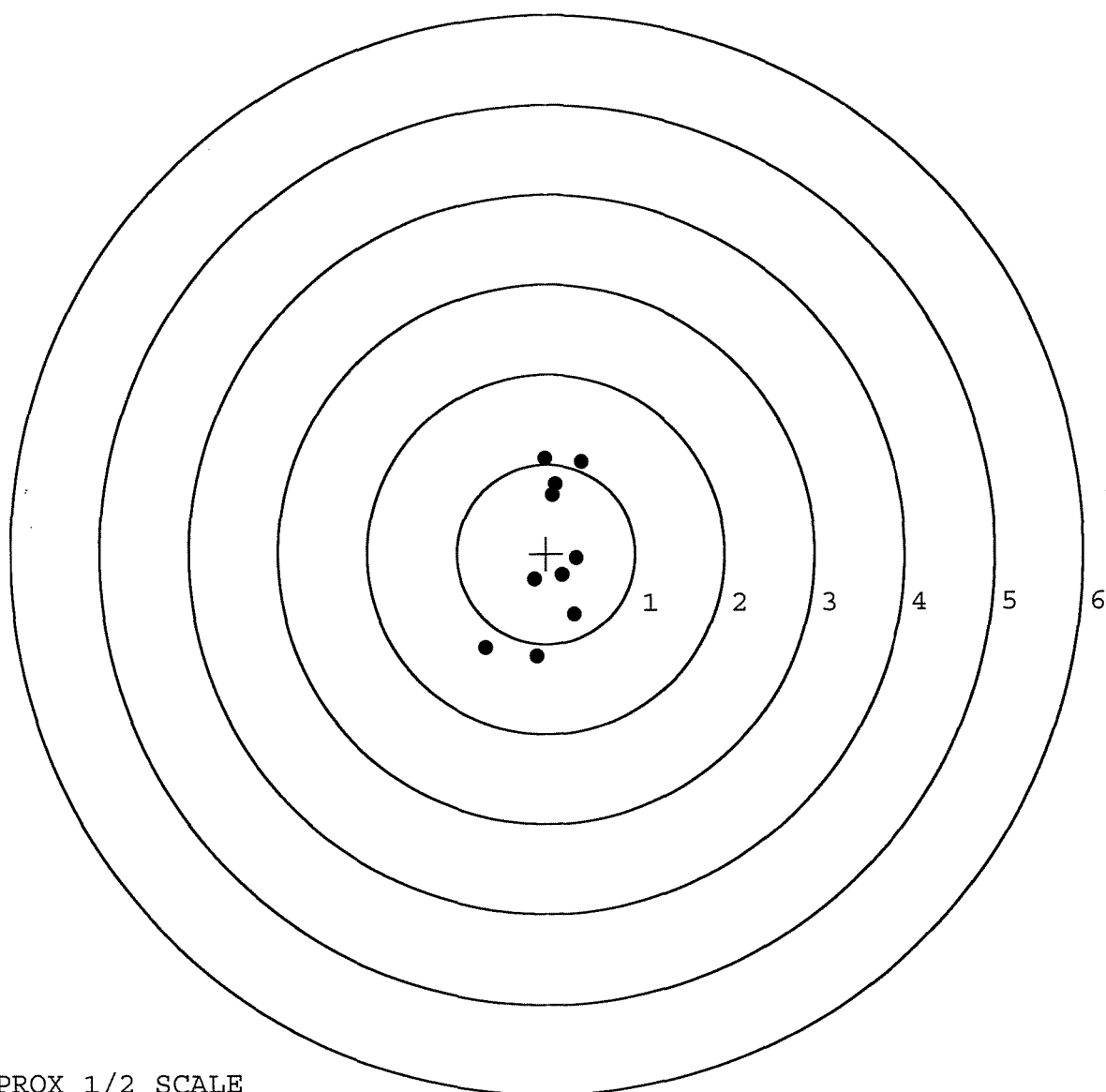
MAX RADIUS: 1.279

MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590055. __0

TARGET NUMBER: 5

FILE DATE: 07/17/2006

FILE TIME: 08:11

POINT#	X	Y
1:	1.127	-0.468
2:	0.733	-0.433
3:	0.734	-1.014
4:	0.497	0.118
5:	0.016	0.955
6:	-0.147	-0.230
7:	-0.764	-0.183
8:	-0.933	0.341
9:	-1.810	-0.376
10:	0.541	-0.042

X CENTROID: -0.001

Y CENTROID: -0.133

POA TO CENTROID: 0.133

HORZ SPREAD: 2.937

VERT SPREAD: 1.969

GROUP SPREAD: 2.938

MIN RADIUS: 0.176

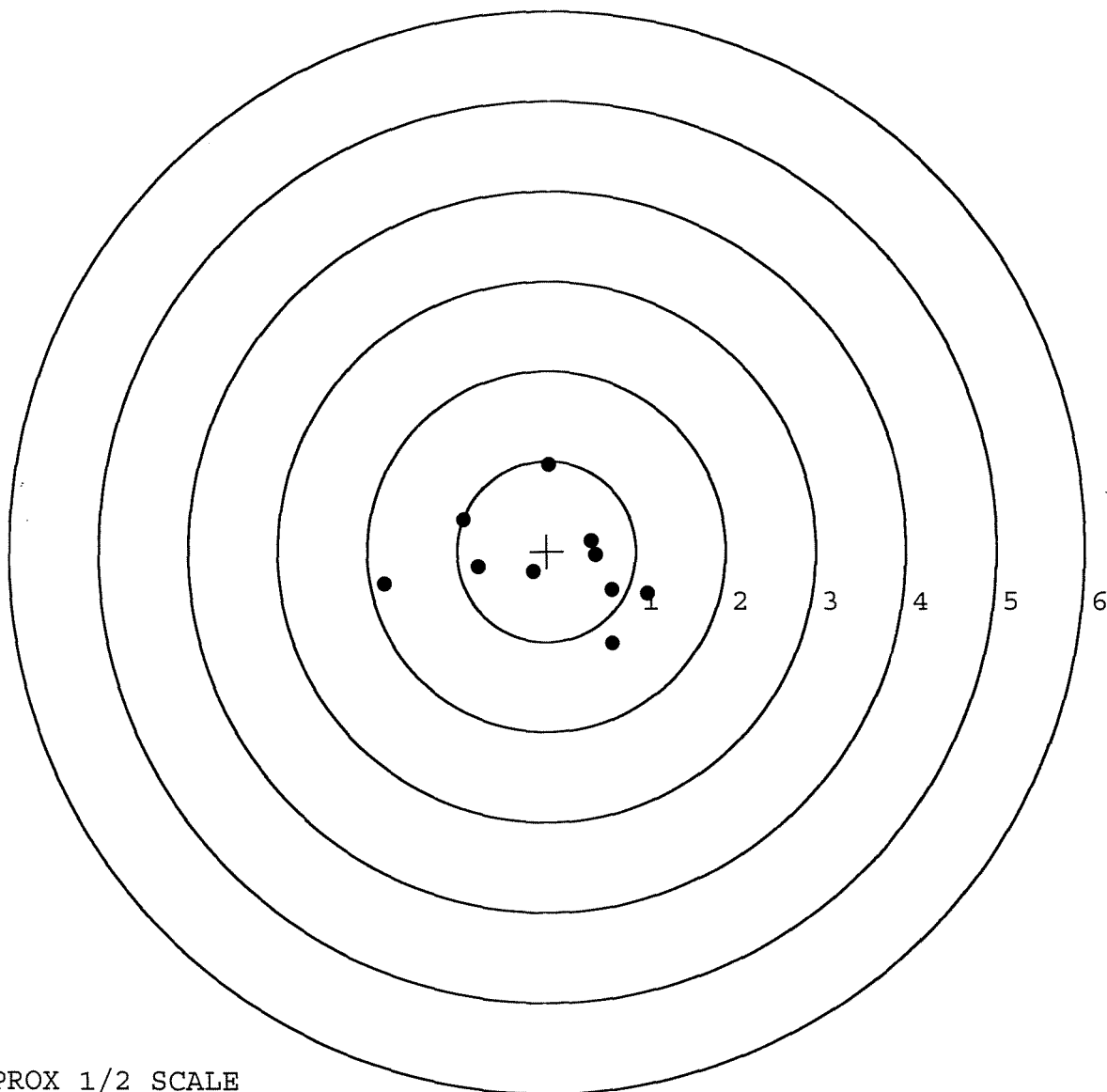
MAX RADIUS: 1.826

MEAN RADIUS: 0.912

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE