

G-659 0198

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

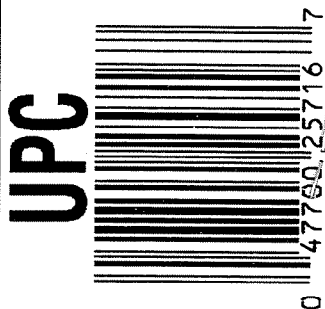
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6590198



ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590198

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-6-06	RTL
420	ASSEMBLE ACTION		9-7-06	RTL
430	ASSEMBLE TO STOCK		9-7-06	BS
440	PROOF		9-7-06	TRW
460	CHECK HEADSPACE	MAGNA FLUX INSPECTED	9-7-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 11 2006	9-7-06	RTL
480	MAGNAFLUX BBL ACTION	OPERATOR <u>curios</u>	9/11/06	<u>curios</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-11-06	CU
510	DRILL AND TAP SIGHT HOLES		9-11-06	TRW
520	GOFF BLAST BBL / REC		9-11-06	BS
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/14/06	BS
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-18-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-18-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-18-06	DA
	D) OIL FIRING PIN ASSEMBLY		9-19-06	BLG
	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>70</u> <u>70</u> <u>65</u>	10-20-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>40</u> <u>40</u> <u>40</u>	10-20-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-20-06	SD
	J) ASSEMBLE STOCK		9-19-06	BLC
	K) ASSEMBLE SWIVEL STUDS		11-8-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-19-06	BLC
	M) IRON SIGHT ALIGNMENT		9-19-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-19-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-19-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/19/06	M.P.D.
670	FINAL INSPECTION A) HEADSPACE		11-8-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.72</u> <u>2.75</u> <u>2.64</u> <u>2.77</u>	9-20-06	WA
	C) FUNCTION		11-8-06	L.P.D.
690	PACK		11/11/06	DA

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 9-18-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	260	240		240	
PULL #2	254	231		236	
PULL #3	251	250		237	
PULL #4	245	250		241	
PULL #5	260	235		248	
TOTAL	1270	1206		1202	
AVERAGE	254	241		240	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	303	311		
PULL #2	314	308		
PULL #3	315	307		
PULL #4	285	306		
PULL #5	287	309		
TOTAL	1504	1541		
AVERAGE	300	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	4.08	4.07		399
PULL #2	4.12	4.13		403
PULL #3	4.12	4.14		411
PULL #4	4.12	4.08		414
PULL #5	4.12	4.11		417
TOTAL	20.56	20.53		20.44
AVERAGE	4.11	4.10		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590198.__0
FILE DATE AND TIME: 09/20/2006 01:38

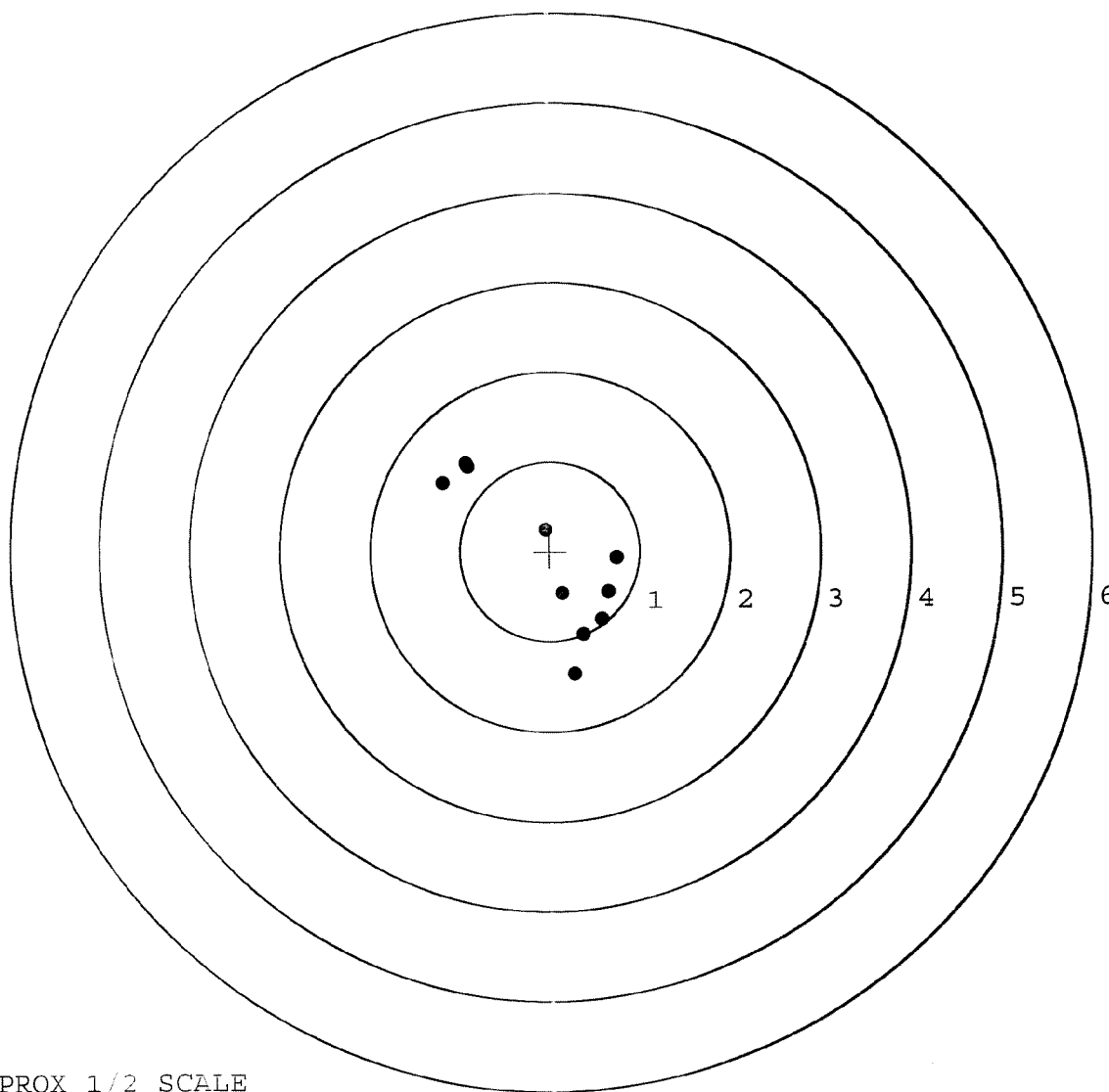
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.094
The Average Y Centroid of the Five Target Set:	-0.028
The Average Point of Impact of the Five Target Set:	0.099
The Average Mean Radius of the Five Target Set:	0.599
The Distance from POA to Centroid Target #1:	0.116
The Distance from Centroid Target #2 to Centroid Target #1:	0.091
The Distance from Centroid Target #3 to Centroid Target #1:	0.419
The Distance from Centroid Target #4 to Centroid Target #1:	0.248
The Distance from Centroid Target #5 to Centroid Target #1:	0.270

SERIAL NUMBER: G6590198. __0
TARGET NUMBER: 1
FILE DATE: 09/20/2006
FILE TIME: 01:38

X CENTROID: -0.033
Y CENTROID: -0.111
POA TO CENTROID: 0.116
HORZ SPREAD: 1.932
VERT SPREAD: 2.361
GROUP SPREAD: 2.593
MIN RADIUS: 0.356
MAX RADIUS: 1.455
MEAN RADIUS: 0.965
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.052	0.244
2:	0.367	-0.933
3:	0.578	-0.764
4:	0.650	-0.454
5:	0.743	-0.079
6:	0.140	-0.468
7:	-1.189	0.772
8:	-0.929	0.991
9:	-0.909	0.950
10:	0.273	-1.370

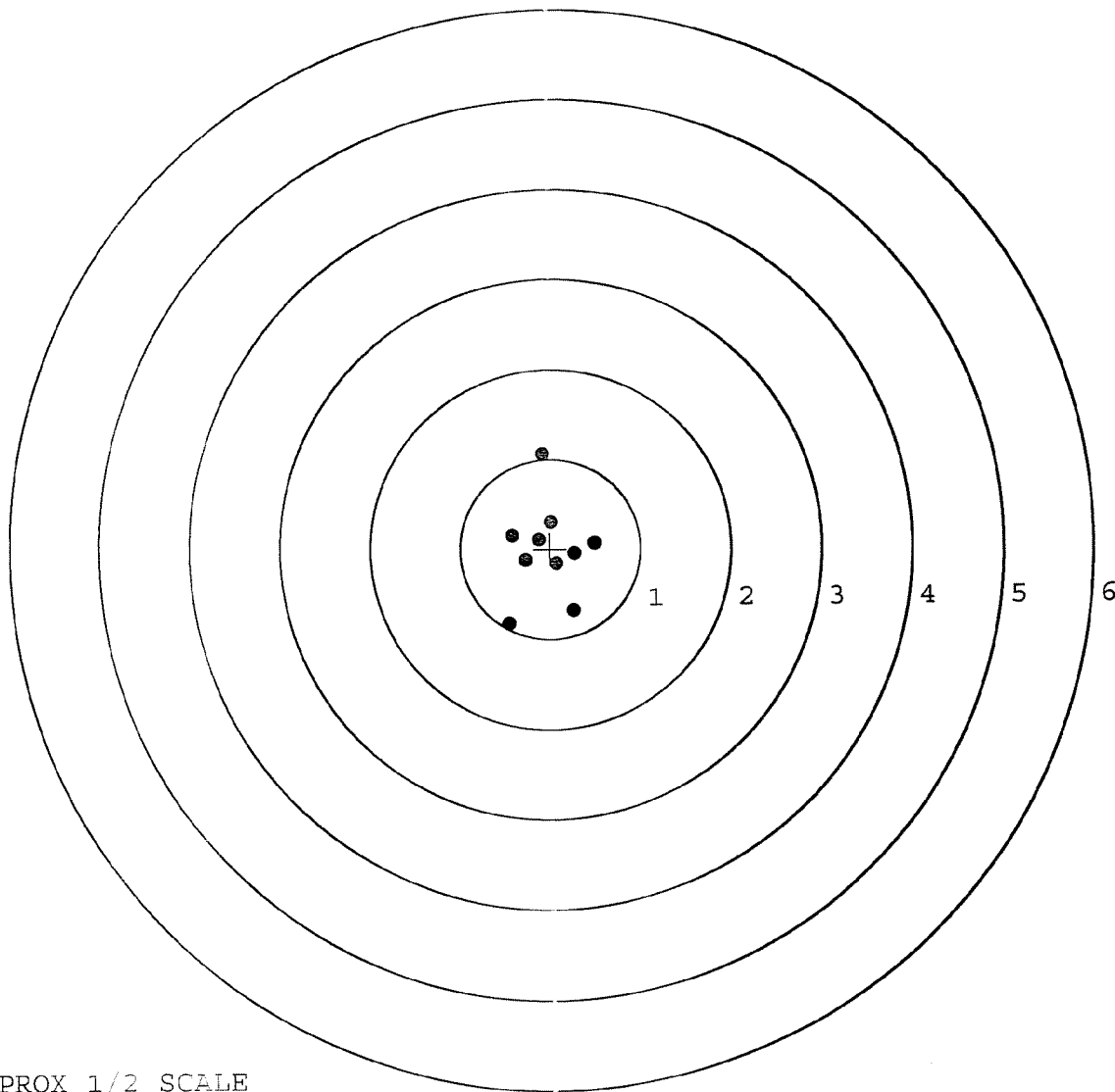


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590198. __0
TARGET NUMBER: 2
FILE DATE: 09/20/2006
FILE TIME: 01:38

X CENTROID: -0.026
Y CENTROID: -0.020
POA TO CENTROID: 0.033
HORZ SPREAD: 0.962
VERT SPREAD: 1.884
GROUP SPREAD: 1.923
MIN RADIUS: 0.161
MAX RADIUS: 1.076
MEAN RADIUS: 0.491
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.464	-0.830
2:	0.259	-0.687
3:	0.498	0.066
4:	-0.080	1.054
5:	-0.424	0.149
6:	0.012	0.298
7:	0.269	-0.060
8:	0.068	-0.167
9:	-0.275	-0.133
10:	-0.127	0.105

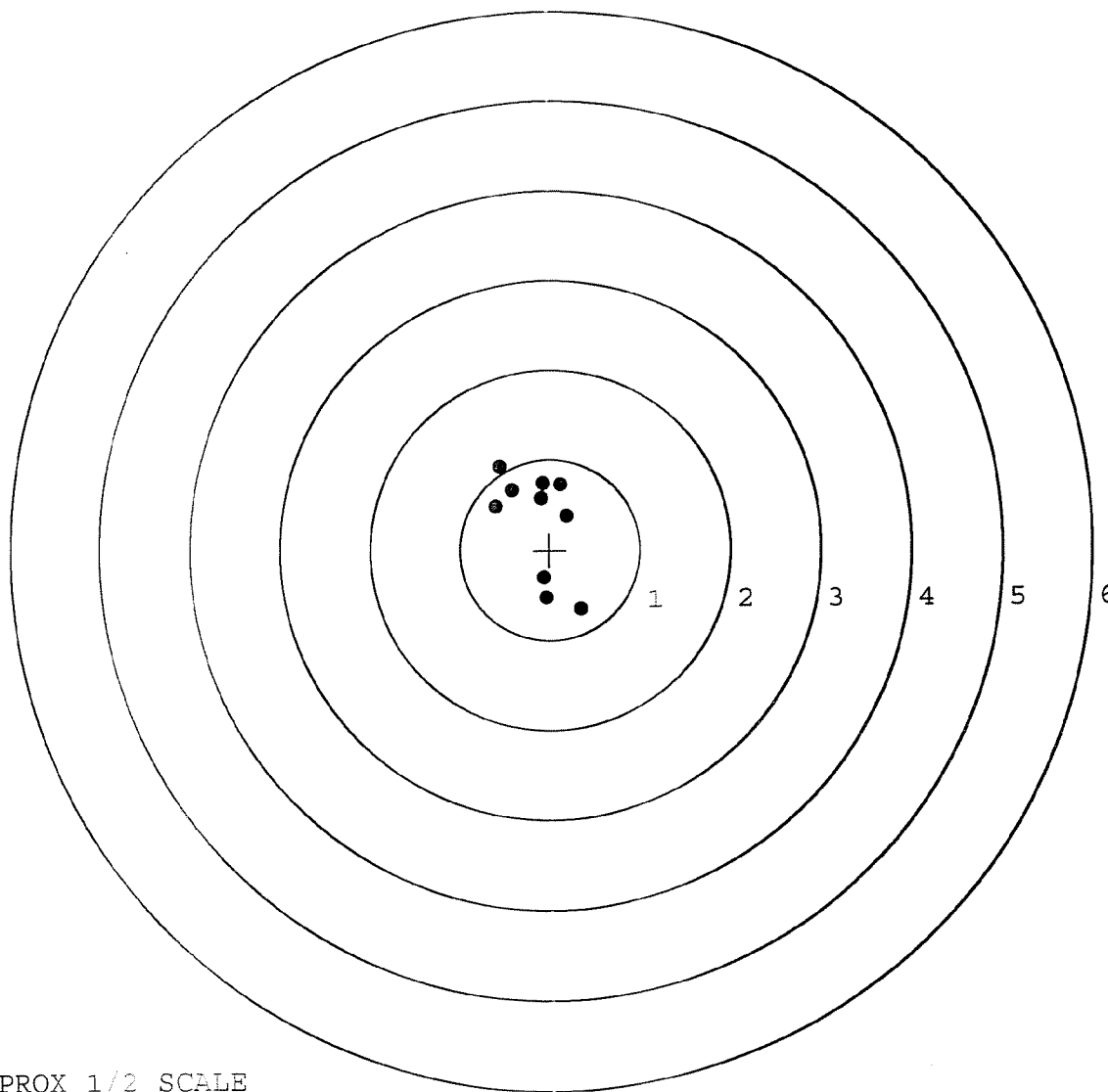


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590198. __0
TARGET NUMBER: 3
FILE DATE: 09/20/2006
FILE TIME: 01:38

X CENTROID: -0.121
Y CENTROID: 0.299
POA TO CENTROID: 0.322
HORZ SPREAD: 0.947
VERT SPREAD: 1.583
GROUP SPREAD: 1.821
MIN RADIUS: 0.270
MAX RADIUS: 1.064
MEAN RADIUS: 0.577
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.344	-0.658
2:	-0.070	-0.307
3:	0.190	0.380
4:	0.121	0.724
5:	-0.098	0.567
6:	-0.078	0.734
7:	-0.603	0.484
8:	-0.422	0.664
9:	-0.557	0.925
10:	-0.042	-0.528

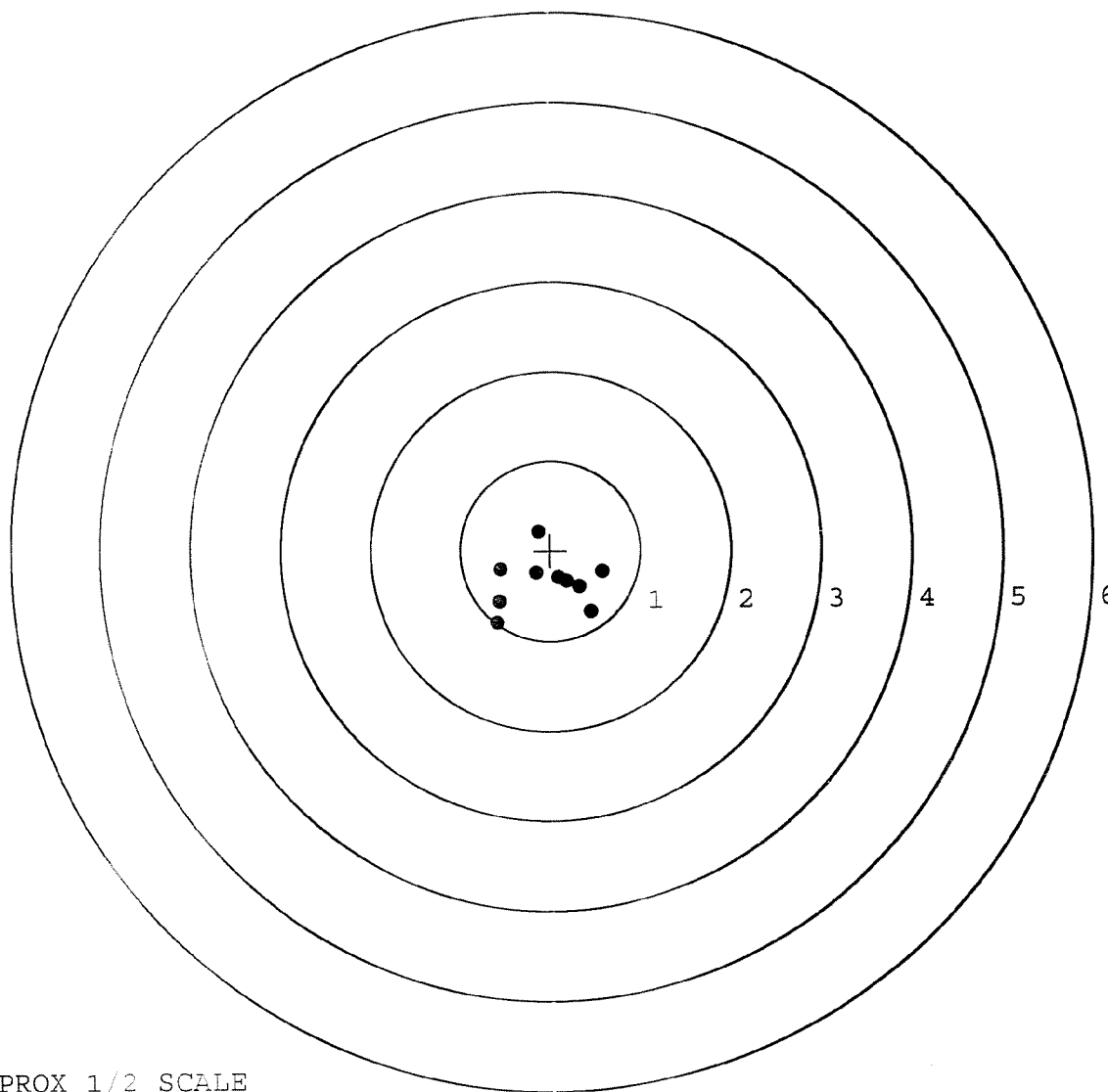


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590198. __0
TARGET NUMBER: 4
FILE DATE: 09/20/2006
FILE TIME: 01:38

X CENTROID: -0.041
Y CENTROID: -0.359
POA TO CENTROID: 0.361
HORZ SPREAD: 1.174
VERT SPREAD: 1.004
GROUP SPREAD: 1.301
MIN RADIUS: 0.141
MAX RADIUS: 0.706
MEAN RADIUS: 0.450
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.597	-0.795
2:	-0.573	-0.566
3:	-0.560	-0.213
4:	-0.163	-0.252
5:	0.089	-0.306
6:	0.577	-0.235
7:	0.448	-0.679
8:	0.321	-0.405
9:	0.180	-0.346
10:	-0.135	0.209

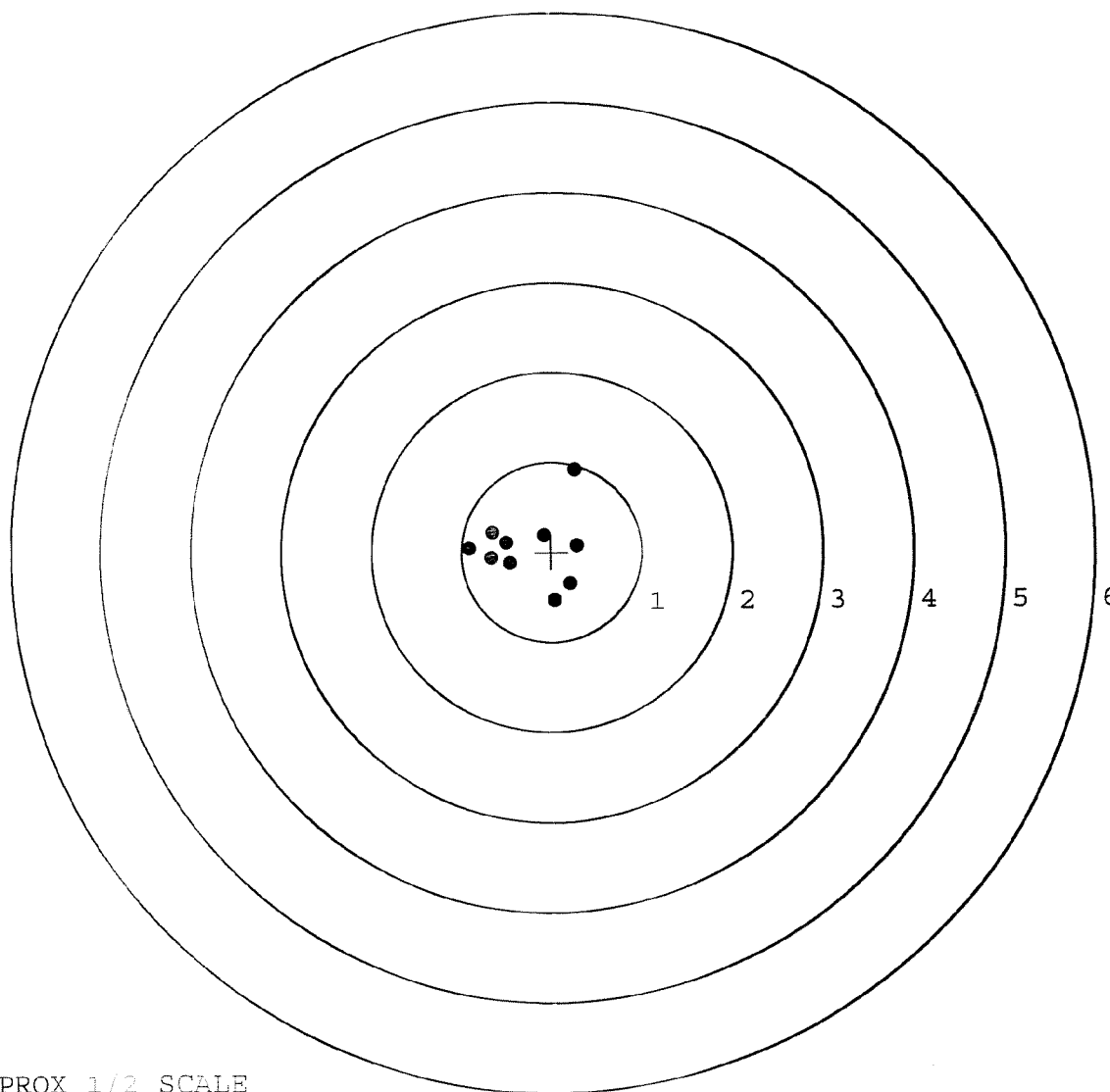


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590198. 0
TARGET NUMBER: 5
FILE DATE: 09/20/2006
FILE TIME: 01:38

X CENTROID: -0.250
Y CENTROID: 0.050
POA TO CENTROID: 0.255
HORZ SPREAD: 1.204
VERT SPREAD: 1.451
GROUP SPREAD: 1.468
MIN RADIUS: 0.217
MAX RADIUS: 1.005
MEAN RADIUS: 0.510
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
IN 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.035	-0.536
2:	0.210	-0.353
3:	0.286	0.077
4:	-0.086	0.192
5:	0.261	0.915
6:	-0.658	0.220
7:	-0.918	0.053
8:	-0.669	-0.062
9:	-0.500	0.113
10:	-0.463	-0.123



TARGET APPROX 1/2 SCALE