

G 659 1535

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

- INSTRUCTION BOOK 3518

DD FORM



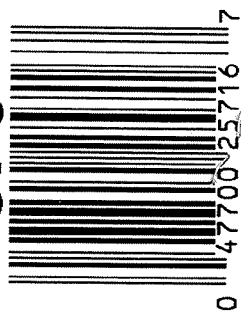
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591535

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591535

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-3-06	BLG
420	ASSEMBLE ACTION		8-3-06	BLG
430	ASSEMBLE TO STOCK		8-4-06	DK
440	PROOF		8-4-06	BLG
460	CHECK HEADSPACE		8-4-06	BLG
470	DIS-ASSEMBLE ACTION		8-4-06	BLG
480	MAGNAFLUX BBL ACTION		8/17/06	mmf
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-16-06	TRW
520	GOFF BLAST BBL / REC		8-17-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/31/06	TS
560	RE-ASSEMBLE ACTION		8-21-06	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-21-06	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-21-06	RP
	D) OIL FIRING PIN ASSEMBLY		8-31-06	A
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		10-11-06	SD

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.9</u> <u>5.5</u>	9-5-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	9-5-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10-11-06	SD
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.025</u> <u>.026</u>	9-5-06	DA
	J) ASSEMBLE STOCK		8-31-06	AC
	K) ASSEMBLE SWIVEL STUDS		10-11-06	SD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-31-06	AC
	M) IRON SIGHT ALIGNMENT		8-31-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-31-06	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-1-06	TRE
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-1-06	
670	FINAL INSPECTION A) HEADSPACE		10-11-06	SD
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u> <u>2.42</u> <u>2.40</u> <u>2.35</u> <u>2.38</u>	9-5-06	DA
	C) FUNCTION		10-11-06	SD
690	PACK		10-31-06	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 8-31-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	252	252		253	
PULL #2	248	251		254	
PULL #3	260	255		255	
PULL #4	244	258		250	
PULL #5	253	254		244	
TOTAL	1257	1270		1256	
AVERAGE	251	254		251	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	317	306		
PULL #2	315	321		
PULL #3	325	315		
PULL #4	333	315		
PULL #5	335	313		
TOTAL	1625	1570		
AVERAGE	325	314		

	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	400	401		4.19
PULL #2	404	400		4.05
PULL #3	397	401		4.01
PULL #4	417	400		4.08
PULL #5	406	399		4.10
TOTAL	2024	2001		20.43
AVERAGE	404	400		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591535.__0
FILE DATE AND TIME: 09/01/2006 14:19

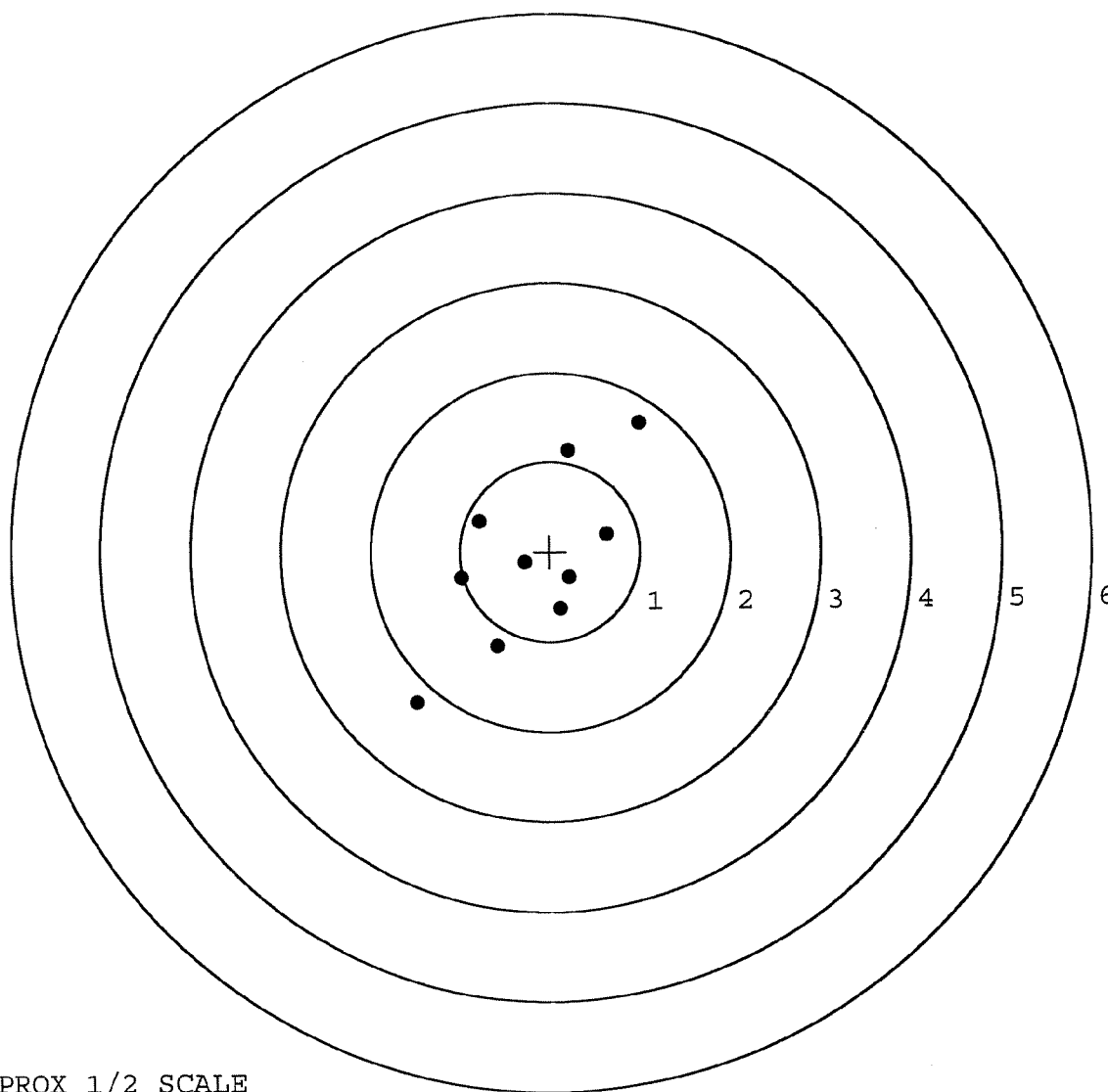
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.176
The Average Y Centroid of the Five Target Set:	-0.110
The Average Point of Impact of the Five Target Set:	0.208
The Average Mean Radius of the Five Target Set:	0.777
The Distance from POA to Centroid Target #1:	0.218
The Distance from Centroid Target #2 to Centroid Target #1:	0.080
The Distance from Centroid Target #3 to Centroid Target #1:	0.282
The Distance from Centroid Target #4 to Centroid Target #1:	0.147
The Distance from Centroid Target #5 to Centroid Target #1:	0.015

SERIAL NUMBER: G6591535. __0
 TARGET NUMBER: 1
 FILE DATE: 09/01/2006
 FILE TIME: 14:19

POINT#	X	Y
1:	-1.492	-1.672
2:	-0.590	-1.052
3:	0.117	-0.637
4:	0.216	-0.290
5:	-0.284	-0.120
6:	-0.980	-0.288
7:	-0.784	0.345
8:	0.633	0.188
9:	0.213	1.122
10:	0.999	1.429

X CENTROID: -0.195
 Y CENTROID: -0.098
 POA TO CENTROID: 0.218
 HORZ SPREAD: 2.491
 VERT SPREAD: 3.101
 GROUP SPREAD: 3.978
 MIN RADIUS: 0.092
 MAX RADIUS: 2.040
 MEAN RADIUS: 0.989
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591535. __0

TARGET NUMBER: 2

FILE DATE: 09/01/2006

FILE TIME: 14:19

X CENTROID: -0.181

Y CENTROID: -0.019

POA TO CENTROID: 0.182

HORZ SPREAD: 1.516

VERT SPREAD: 2.894

GROUP SPREAD: 2.980

MIN RADIUS: 0.164

MAX RADIUS: 1.597

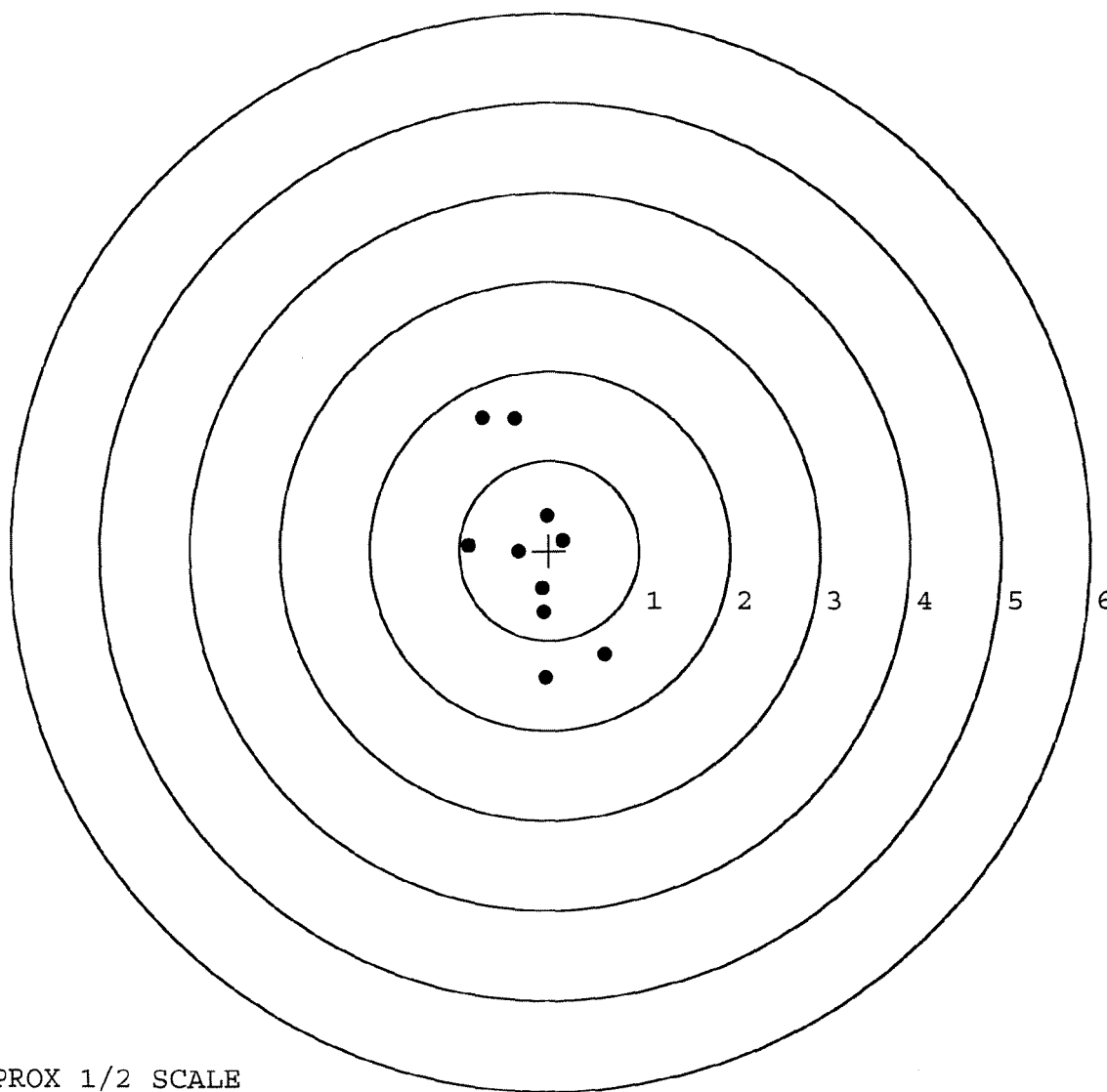
MEAN RADIUS: 0.867

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.037	-1.420
2:	0.622	-1.155
3:	-0.061	-0.691
4:	-0.079	-0.422
5:	-0.894	0.054
6:	0.156	0.120
7:	-0.029	0.393
8:	-0.748	1.474
9:	-0.393	1.461
10:	-0.344	-0.007



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591535. 0

TARGET NUMBER: 3

FILE DATE: 09/01/2006

FILE TIME: 14:19

X CENTROID: -0.148

Y CENTROID: -0.375

POA TO CENTROID: 0.403

HORZ SPREAD: 1.202

VERT SPREAD: 2.146

GROUP SPREAD: 2.415

MIN RADIUS: 0.228

MAX RADIUS: 1.366

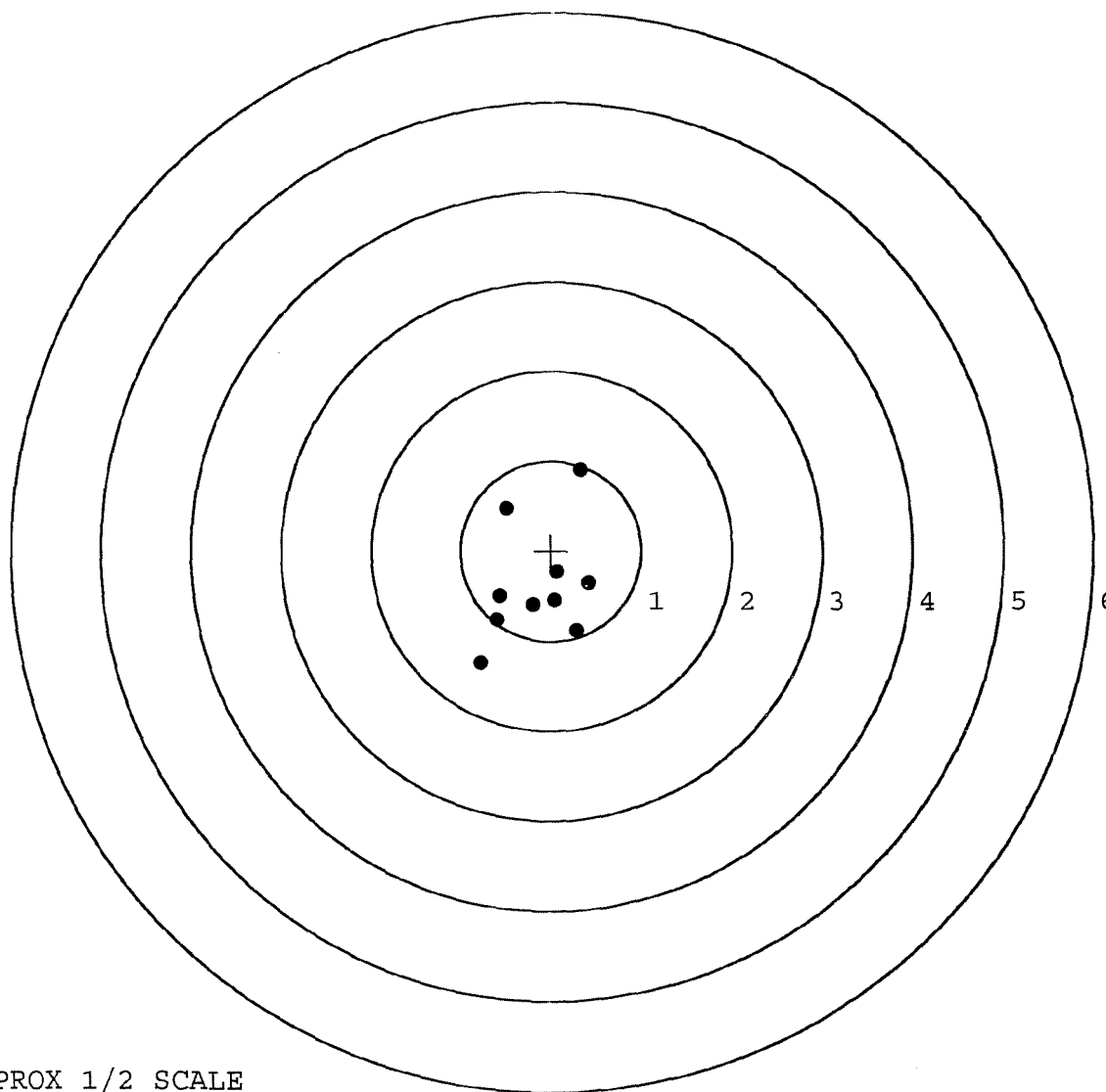
MEAN RADIUS: 0.637

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.330	0.904
2:	-0.499	0.467
3:	0.290	-0.882
4:	0.044	-0.550
5:	0.424	-0.355
6:	-0.196	-0.598
7:	-0.569	-0.496
8:	-0.596	-0.763
9:	-0.778	-1.242
10:	0.072	-0.238



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591535.___0

TARGET NUMBER: 4

FILE DATE: 09/01/2006

FILE TIME: 14:19

X CENTROID: -0.175

Y CENTROID: 0.049

POA TO CENTROID: 0.182

HORZ SPREAD: 1.328

VERT SPREAD: 1.169

GROUP SPREAD: 1.610

MIN RADIUS: 0.357

MAX RADIUS: 0.936

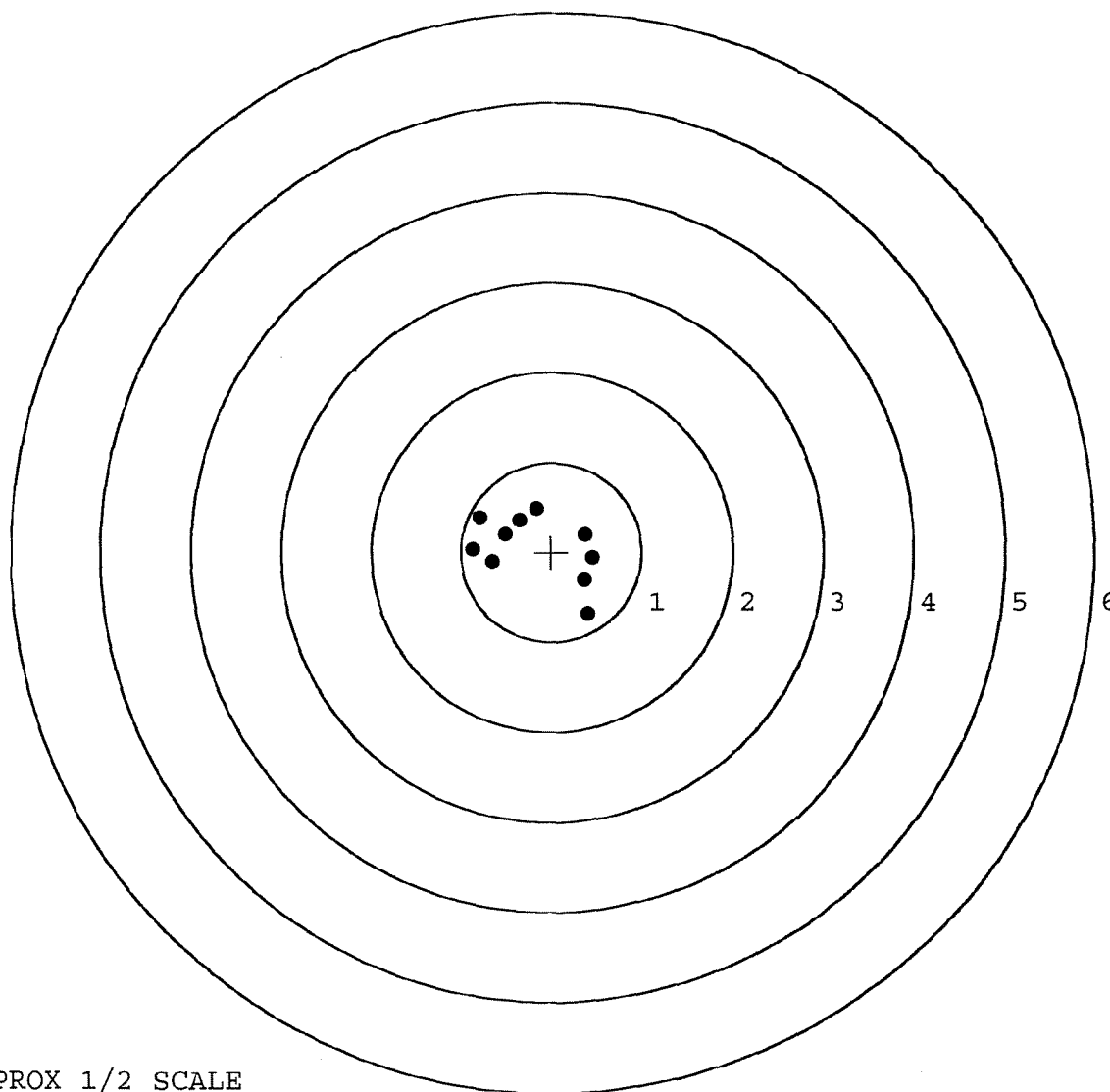
MEAN RADIUS: 0.586

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.403	-0.687
2:	0.373	-0.314
3:	0.459	-0.062
4:	0.369	0.198
5:	-0.168	0.482
6:	-0.358	0.355
7:	-0.658	-0.107
8:	-0.869	0.033
9:	-0.795	0.389
10:	-0.508	0.198



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591535. __0

TARGET NUMBER: 5

FILE DATE: 09/01/2006

FILE TIME: 14:19

POINT#	X	Y
1:	1.068	-0.721
2:	1.034	-0.146
3:	0.073	-0.734
4:	-0.964	-0.885
5:	-0.681	-0.440
6:	-0.260	0.000
7:	-0.216	0.306
8:	-0.239	0.755
9:	-0.613	0.302
10:	-1.024	0.516

X CENTROID: -0.182

Y CENTROID: -0.105

POA TO CENTROID: 0.210

HORZ SPREAD: 2.092

VERT SPREAD: 1.640

GROUP SPREAD: 2.430

MIN RADIUS: 0.130

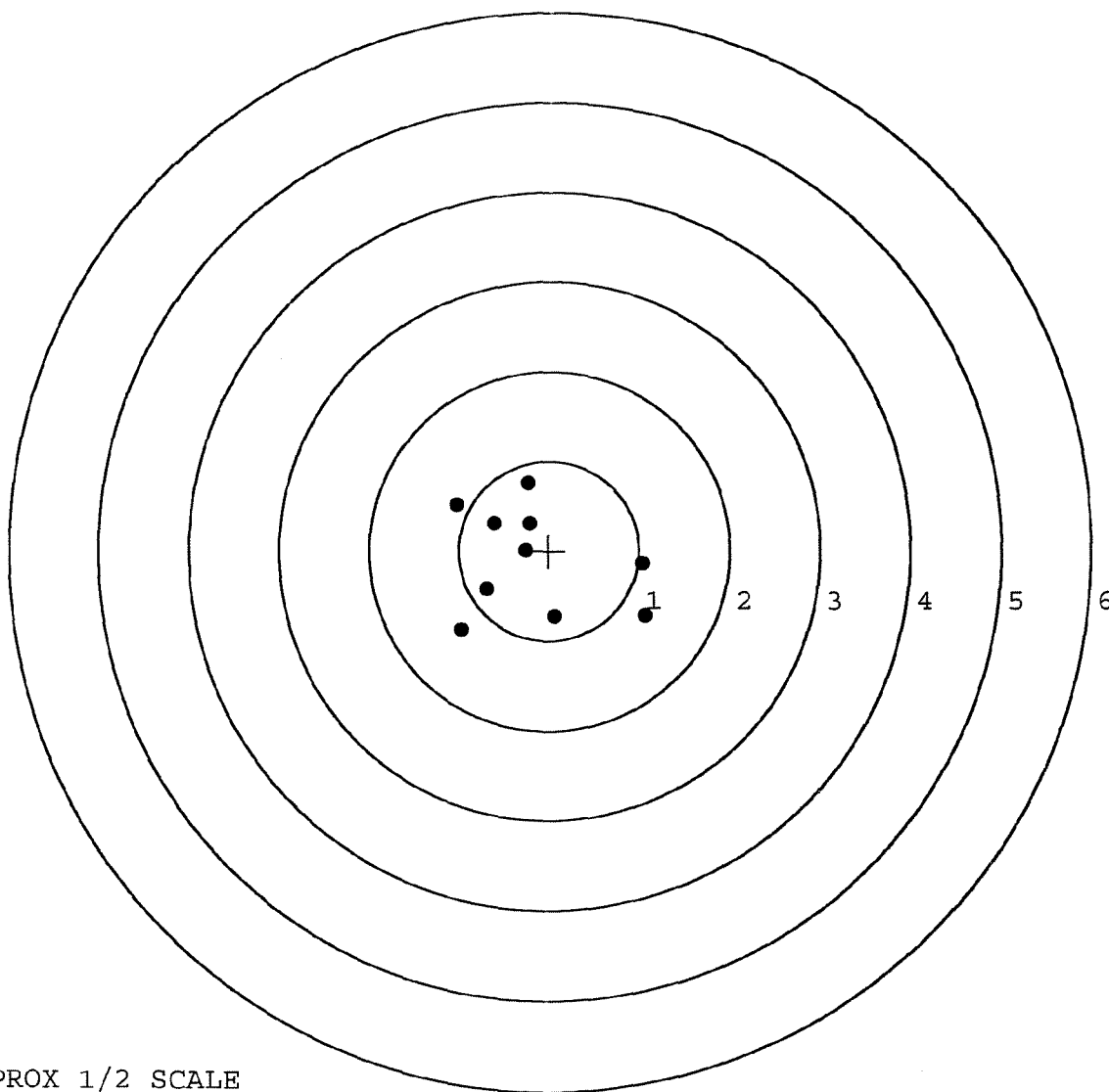
MAX RADIUS: 1.394

MEAN RADIUS: 0.804

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE