

G 6591537

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

- INSTRUCTION BOOK 3518

DD FORM

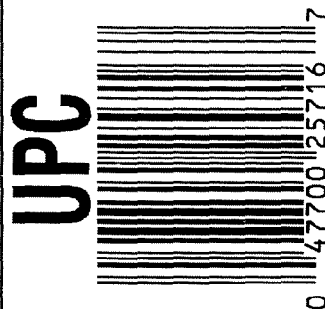


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591537



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 # G6591537

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-16-06	RTZ
420	ASSEMBLE ACTION		8-16-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF	MAGNA-FLUX	8-16-06	L.P.D.
460	CHECK HEADSPACE	INSPECTED	8-16-06	L.P.D.
470	DIS-ASSEMBLE ACTION	AUG 17 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <i>mm</i>	8/17/06	<i>mm</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-17-06	TRW
520	GOFF BLAST BBL / REC		8-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/24/06	LB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-7-06	AK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-7-06	AK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-7-06	AK
	D) OIL FIRING PIN ASSEMBLY		9-11-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/11/06	<i>mm</i>

F004 REV 5/2006

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M2400167617

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>55</u> <u>60</u> <u>55</u>	9-13-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>35</u> <u>35</u>	9-13-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	nom
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	9-13-06	RA
	J) ASSEMBLE STOCK		9-11-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		10/11/06	nom
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-11-06	RTZ
	M) IRON SIGHT ALIGNMENT		9-11-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-11-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL <u>(PASS)</u> FAIL	9-12-06	TRC
	MALFUNCTION <i>MCW</i>	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/12/06	RF
670	FINAL INSPECTION A) HEADSPACE		10/11/06	nom
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.76</u> <u>2.66</u> <u>2.55</u> <u>2.54</u>	9-13-06	RA
	C) FUNCTION		10/11/06	nom
690	PACK		11/2/06	RA

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M2400167618

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 9.8.07

TESTER MTH

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.45	2.28	2.51	
PULL #2	2.57	2.53	2.46	
PULL #3	2.37	2.46	2.48	
PULL #4	2.47	2.42	2.52	
PULL #5	2.28	2.40	2.55	
TOTAL	12.14	12.09	12.52	
AVERAGE	2.43	2.42	2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.01	3.02	
PULL #2	3.07	3.03	
PULL #3	3.15	2.75	
PULL #4	3.05	3.19	
PULL #5	3.17	3.03	
TOTAL	15.45	15.02	
AVERAGE	3.09	3.00	

	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	4.07	4.08		4.03
PULL #2	3.86	3.72		4.11
PULL #3	3.94	4.06		4.13
PULL #4	3.96	3.71		4.09
PULL #5	3.89	3.65		4.10
TOTAL	19.72	19.20		20.46
AVERAGE	3.94	3.84		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591537.__0
FILE DATE AND TIME: 09/13/2006 01:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.781
The Distance from POA to Centroid Target #1:	0.336
The Distance from Centroid Target #2 to Centroid Target #1:	0.461
The Distance from Centroid Target #3 to Centroid Target #1:	0.186
The Distance from Centroid Target #4 to Centroid Target #1:	0.270
The Distance from Centroid Target #5 to Centroid Target #1:	0.726

SERIAL NUMBER: G6591537. __0

TARGET NUMBER: 1

FILE DATE: 09/13/2006

FILE TIME: 01:29

POINT#	X	Y
1:	-0.829	0.360
2:	-0.545	0.187
3:	0.695	0.528
4:	1.744	-0.461
5:	0.253	-0.110
6:	-0.494	-0.713
7:	-0.685	-1.002
8:	0.702	-0.576
9:	0.891	-0.378
10:	0.779	-0.073

X CENTROID: 0.251

Y CENTROID: -0.224

POA TO CENTROID: 0.336

HORZ SPREAD: 2.573

VERT SPREAD: 1.530

GROUP SPREAD: 2.701

MIN RADIUS: 0.114

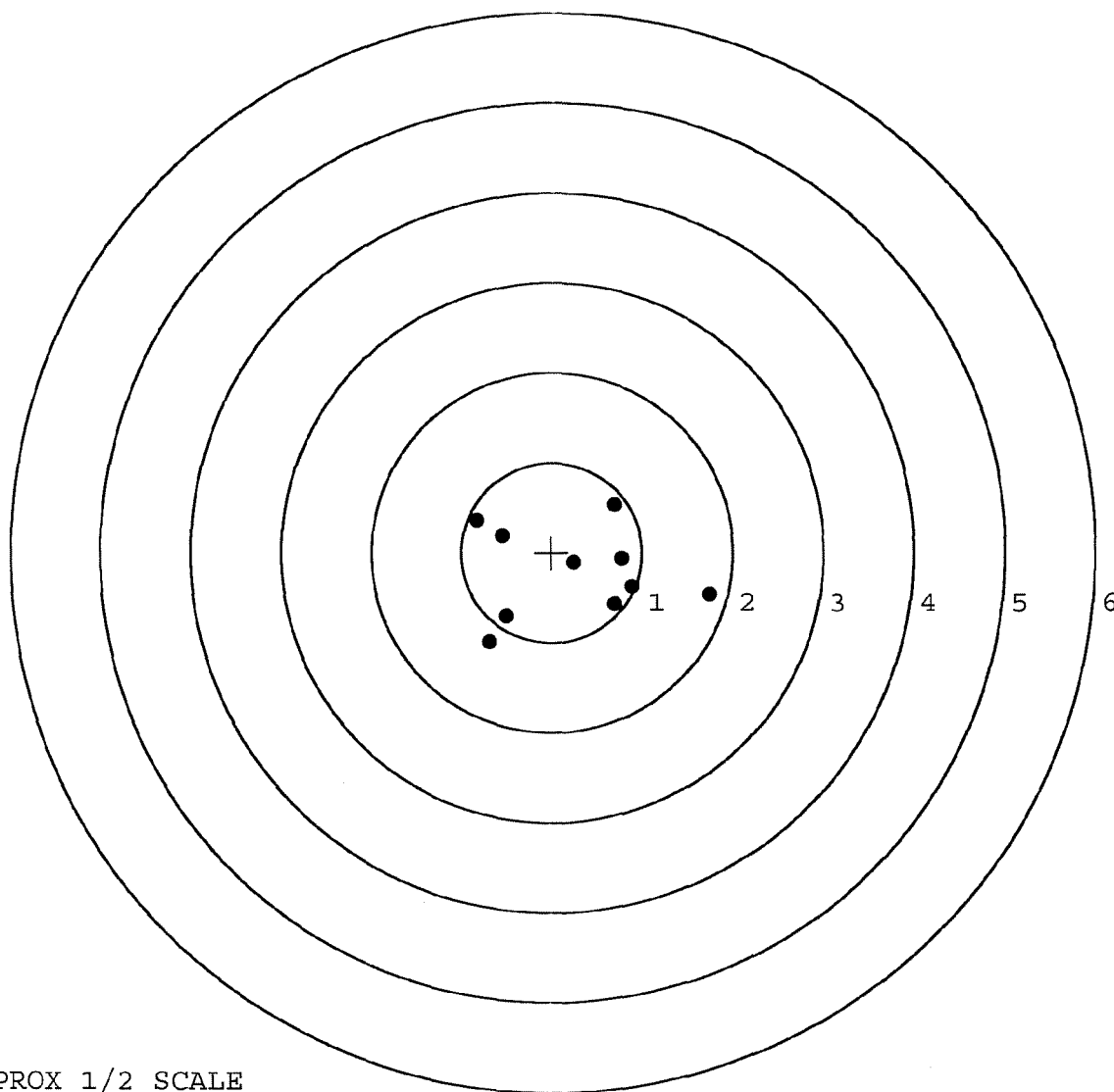
MAX RADIUS: 1.512

MEAN RADIUS: 0.851

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591537. 0

TARGET NUMBER: 2

FILE DATE: 09/13/2006

FILE TIME: 01:29

POINT#	X	Y
1:	-0.847	0.631
2:	-1.270	0.331
3:	-0.775	-0.046
4:	-0.420	-0.209
5:	-0.359	0.400
6:	0.070	0.485
7:	0.774	0.130
8:	0.611	-0.208
9:	0.015	-0.818
10:	0.494	-1.065

X CENTROID: -0.171

Y CENTROID: -0.037

POA TO CENTROID: 0.175

HORZ SPREAD: 2.044

VERT SPREAD: 1.696

GROUP SPREAD: 2.250

MIN RADIUS: 0.303

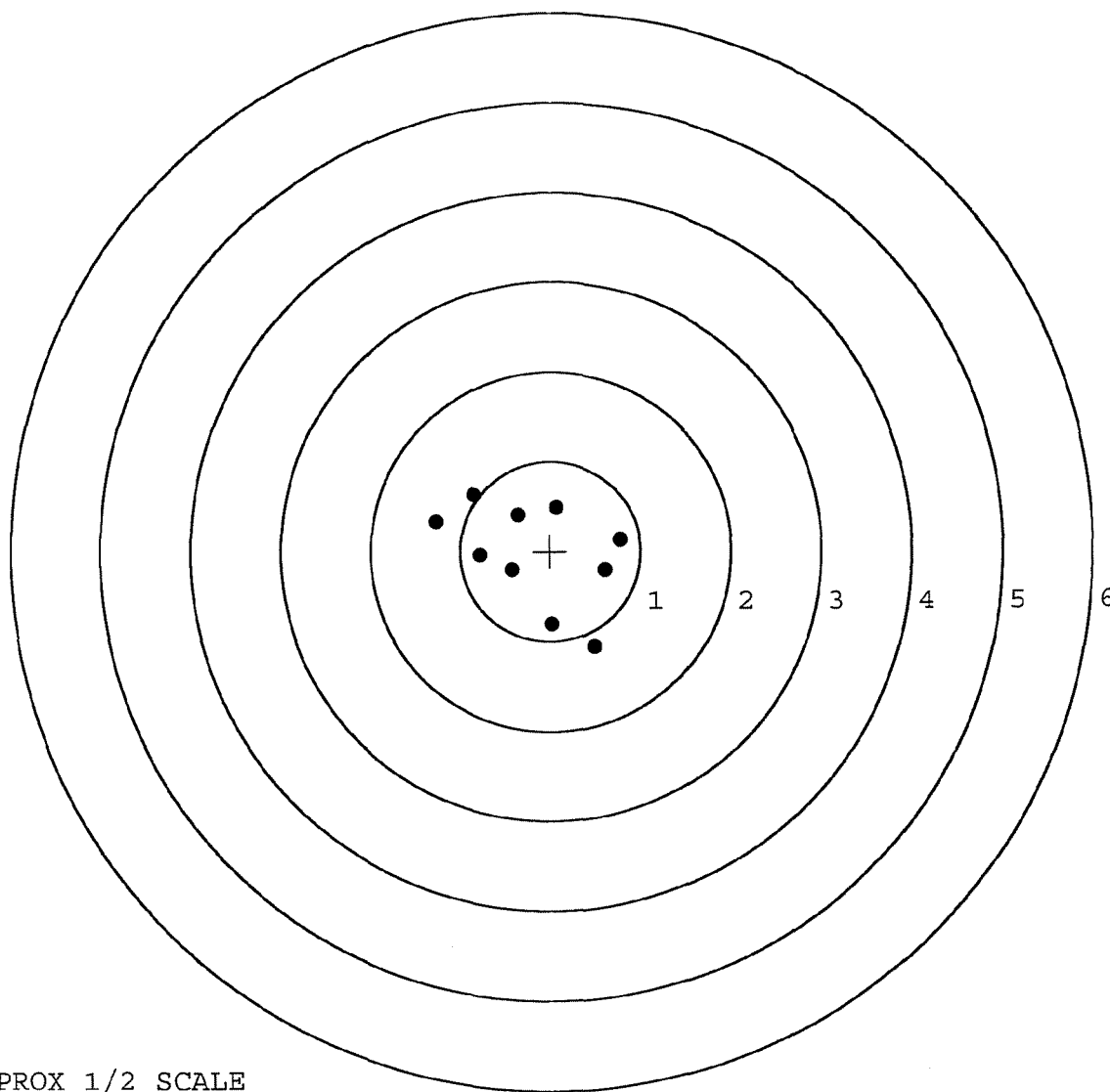
MAX RADIUS: 1.224

MEAN RADIUS: 0.785

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591537. __0

TARGET NUMBER: 3

FILE DATE: 09/13/2006

FILE TIME: 01:29

POINT#	X	Y
1:	0.079	0.720
2:	-0.430	0.591
3:	-0.560	0.130
4:	-1.087	-0.143
5:	0.447	0.102
6:	1.109	-0.363
7:	0.123	-0.382
8:	0.367	-0.432
9:	0.111	-0.826
10:	0.591	-1.024

X CENTROID: 0.075

Y CENTROID: -0.163

POA TO CENTROID: 0.179

HORZ SPREAD: 2.196

VERT SPREAD: 1.744

GROUP SPREAD: 2.207

MIN RADIUS: 0.224

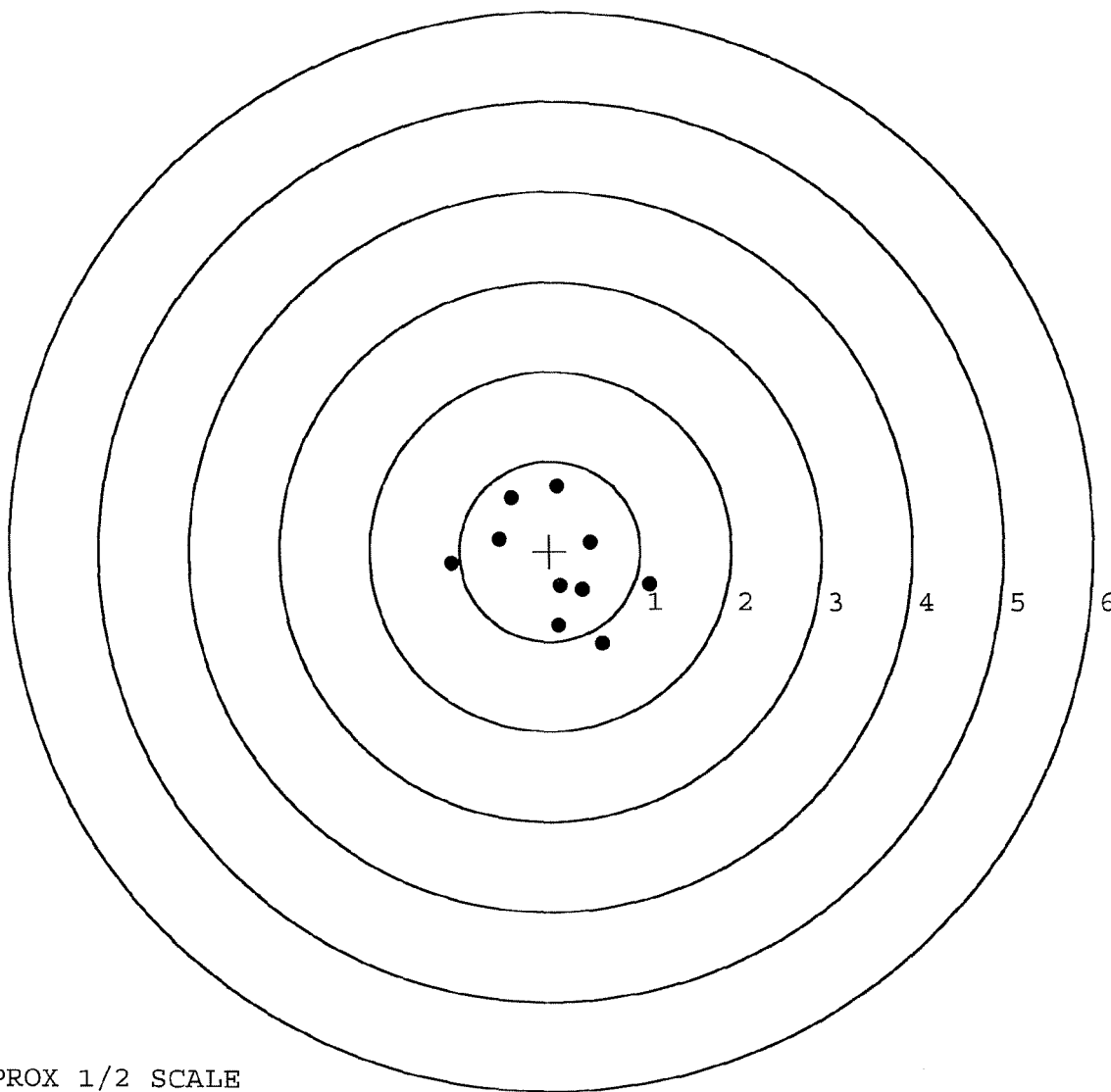
MAX RADIUS: 1.162

MEAN RADIUS: 0.745

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

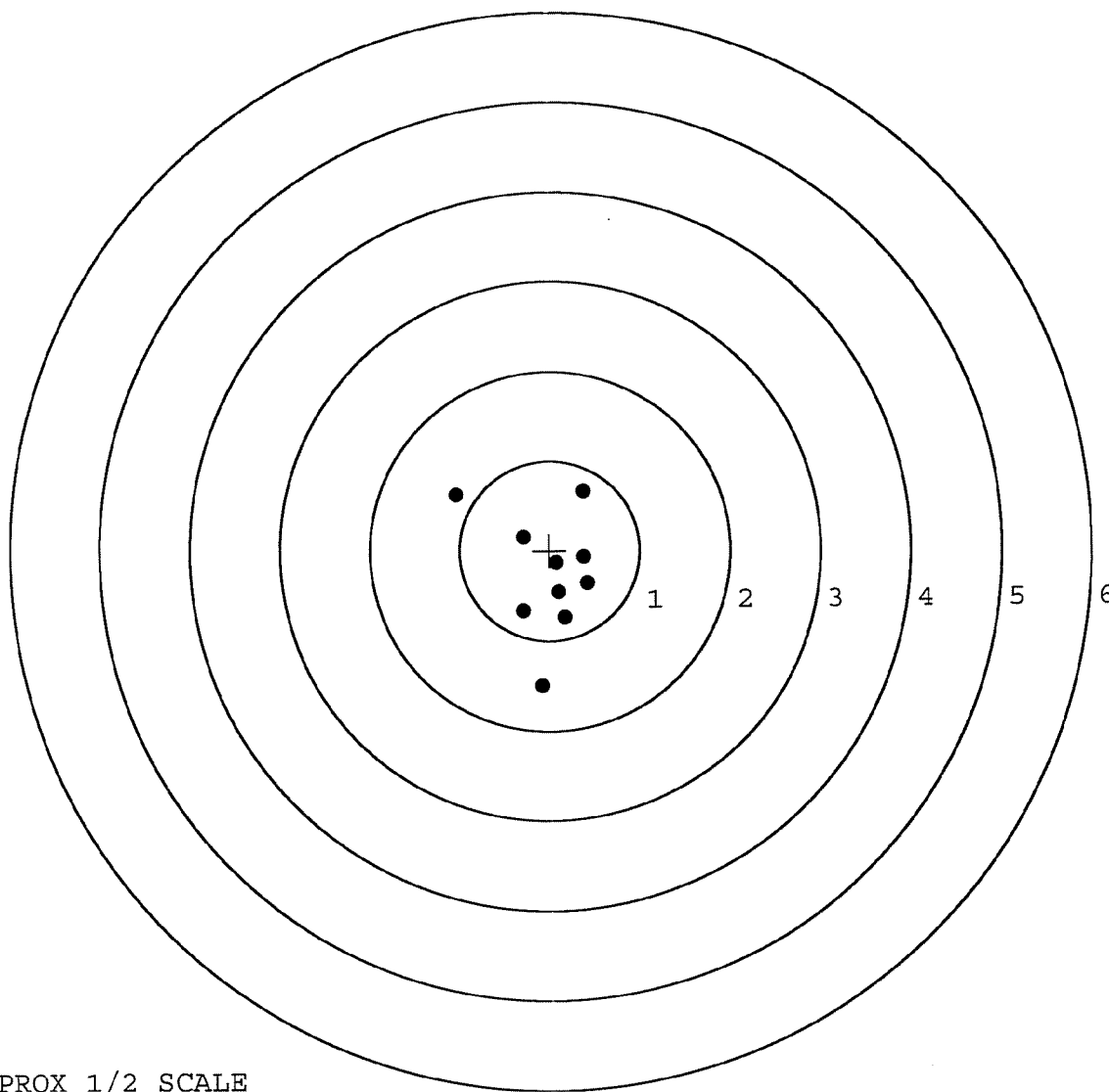


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591537.___0
TARGET NUMBER: 4
FILE DATE: 09/13/2006
FILE TIME: 01:29

X CENTROID: -0.017
Y CENTROID: -0.254
POA TO CENTROID: 0.254
HORZ SPREAD: 1.458
VERT SPREAD: 2.167
GROUP SPREAD: 2.337
MIN RADIUS: 0.149
MAX RADIUS: 1.350
MEAN RADIUS: 0.641
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.382	0.663
2:	-1.036	0.632
3:	-0.288	0.152
4:	-0.087	-1.504
5:	-0.297	-0.674
6:	0.168	-0.751
7:	0.103	-0.467
8:	0.422	-0.370
9:	0.383	-0.077
10:	0.080	-0.140

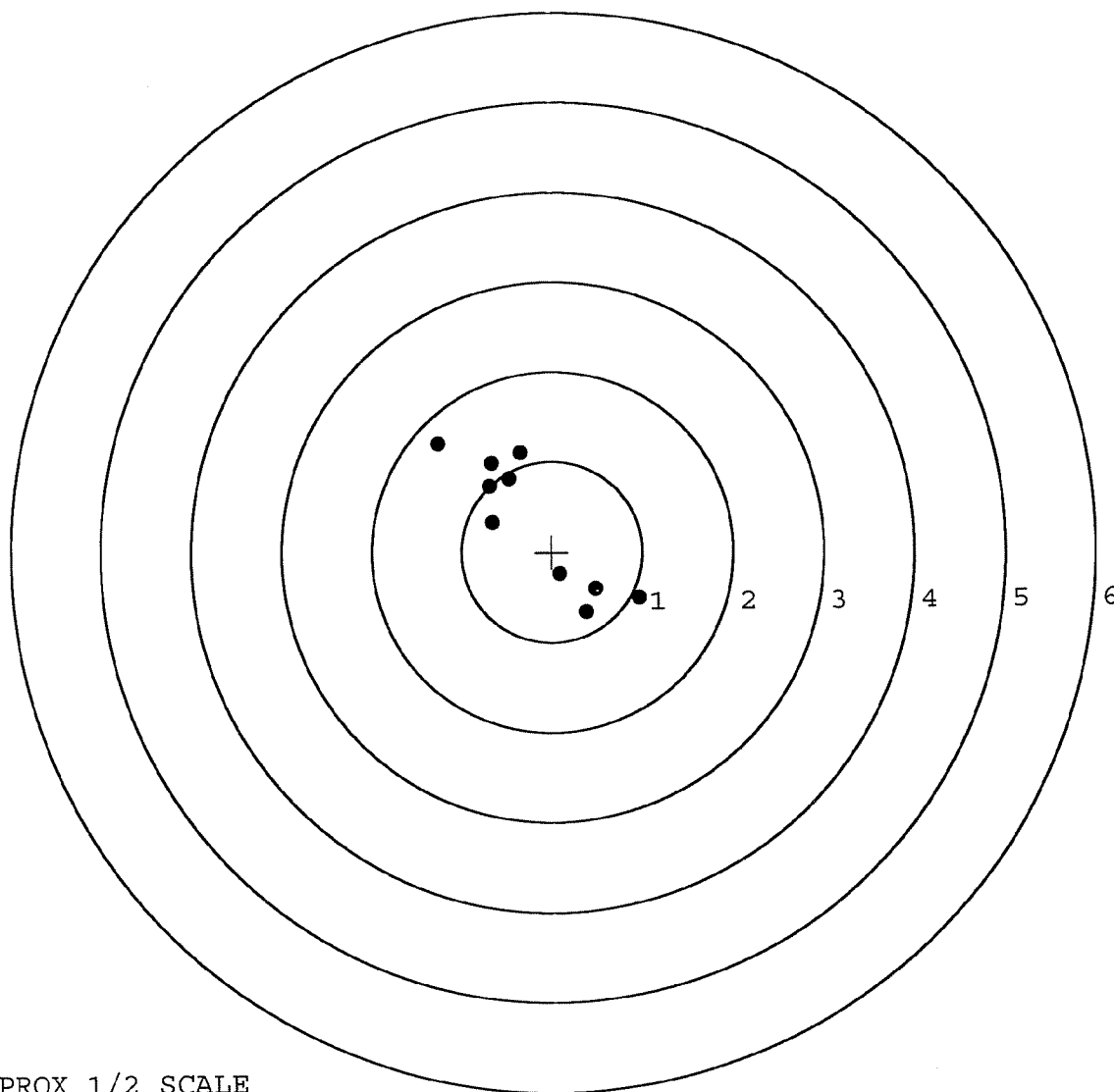


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591537.___0
TARGET NUMBER: 5
FILE DATE: 09/13/2006
FILE TIME: 01:29

POINT#	X	Y
1:	0.965	-0.518
2:	0.481	-0.410
3:	0.384	-0.672
4:	0.088	-0.243
5:	-0.659	0.331
6:	-1.260	1.202
7:	-0.344	1.097
8:	-0.472	0.809
9:	-0.689	0.731
10:	-0.661	0.986

X CENTROID: -0.217
Y CENTROID: 0.331
POA TO CENTROID: 0.396
HORZ SPREAD: 2.225
VERT SPREAD: 1.874
GROUP SPREAD: 2.812
MIN RADIUS: 0.442
MAX RADIUS: 1.455
MEAN RADIUS: 0.882
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE