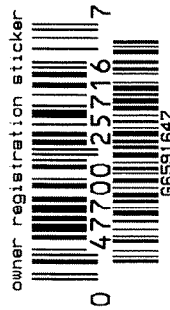


G 6591647

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

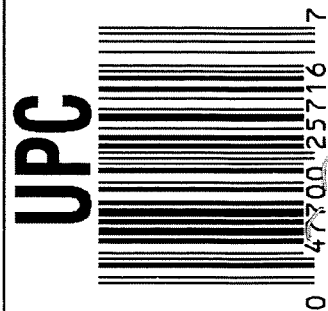
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591647



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.



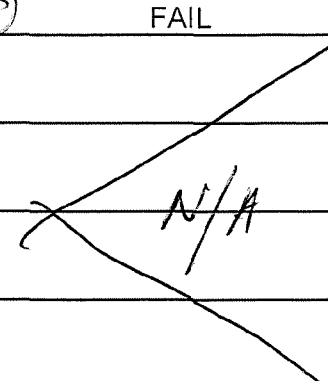
M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL #

G6591647

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	MAGNA-FLUX INSPECTED	8-4-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 17 2006	8-4-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mmas</u>	8/17/06	<u>mmas</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-16-06	DRW
520	GOFF BLAST BBL / REC		8-17-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/21/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-21-06	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-21-06	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-21-06	MTM
	D) OIL FIRING PIN ASSEMBLY		8-29-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/12/06	mmas

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4.0</u> <u>6.0</u> <u>6.0</u>	8-30-06	19A
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	8-30-06	19A
	H) TRIGGER PULL TEST AND RETAINABILITY		10/12/06	non
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8-30-06	19A
	J) ASSEMBLE STOCK		8-29-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/12/06	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-29-06	BLG
	M) IRON SIGHT ALIGNMENT		8-29-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-29-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-29-06	8.1.1.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-29-06	WTH
670	FINAL INSPECTION A) HEADSPACE		10/12/06	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u> <u>2.65</u> <u>2.50</u> <u>2.54</u> <u>2.61</u>	8-30-06	DA
	C) FUNCTION		10/12/06	non
690	PACK		11/2/06	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 8-28-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	228	2.23		2.24	
PULL #2	230	2.27		2.42	
PULL #3	234	2.28		2.44	
PULL #4	236	2.34		2.53	
PULL #5	234	2.29		2.54	
TOTAL	11.62	11.41		12.17	
AVERAGE	2.32	2.28		2.43	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	324	341		
PULL #2	324	328		
PULL #3	314	325		
PULL #4	313	325		
PULL #5	314	324		
TOTAL	15.89	16.43		
AVERAGE	3.17	3.28		

	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	426	4.09		4.37
PULL #2	410	4.08		4.37
PULL #3	409	4.10		4.38
PULL #4	414	4.07		4.31
PULL #5	413	4.09		4.29
TOTAL	20.72	20.43		21.72
AVERAGE	4.14	4.08		4.34

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591647.___0
FILE DATE AND TIME: 08/29/2006 20:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.040
The Average Y Centroid of the Five Target Set:	0.004
The Average Point of Impact of the Five Target Set:	0.040
The Average Mean Radius of the Five Target Set:	0.731
The Distance from POA to Centroid Target #1:	0.192
The Distance from Centroid Target #2 to Centroid Target #1:	0.121
The Distance from Centroid Target #3 to Centroid Target #1:	0.270
The Distance from Centroid Target #4 to Centroid Target #1:	0.234
The Distance from Centroid Target #5 to Centroid Target #1:	0.303

SERIAL NUMBER: G6591647. 0

TARGET NUMBER: 1

FILE DATE: 08/29/2006

FILE TIME: 20:06

POINT#	X	Y
1:	-1.783	0.021
2:	-1.283	0.333
3:	-0.576	0.507
4:	-0.363	0.227
5:	-0.152	0.465
6:	1.046	0.520
7:	0.284	0.154
8:	0.659	-0.203
9:	0.431	-0.679
10:	0.068	-0.387

X CENTROID: -0.167

Y CENTROID: 0.096

POA TO CENTROID: 0.192

HORZ SPREAD: 2.829

VERT SPREAD: 1.199

GROUP SPREAD: 2.873

MIN RADIUS: 0.236

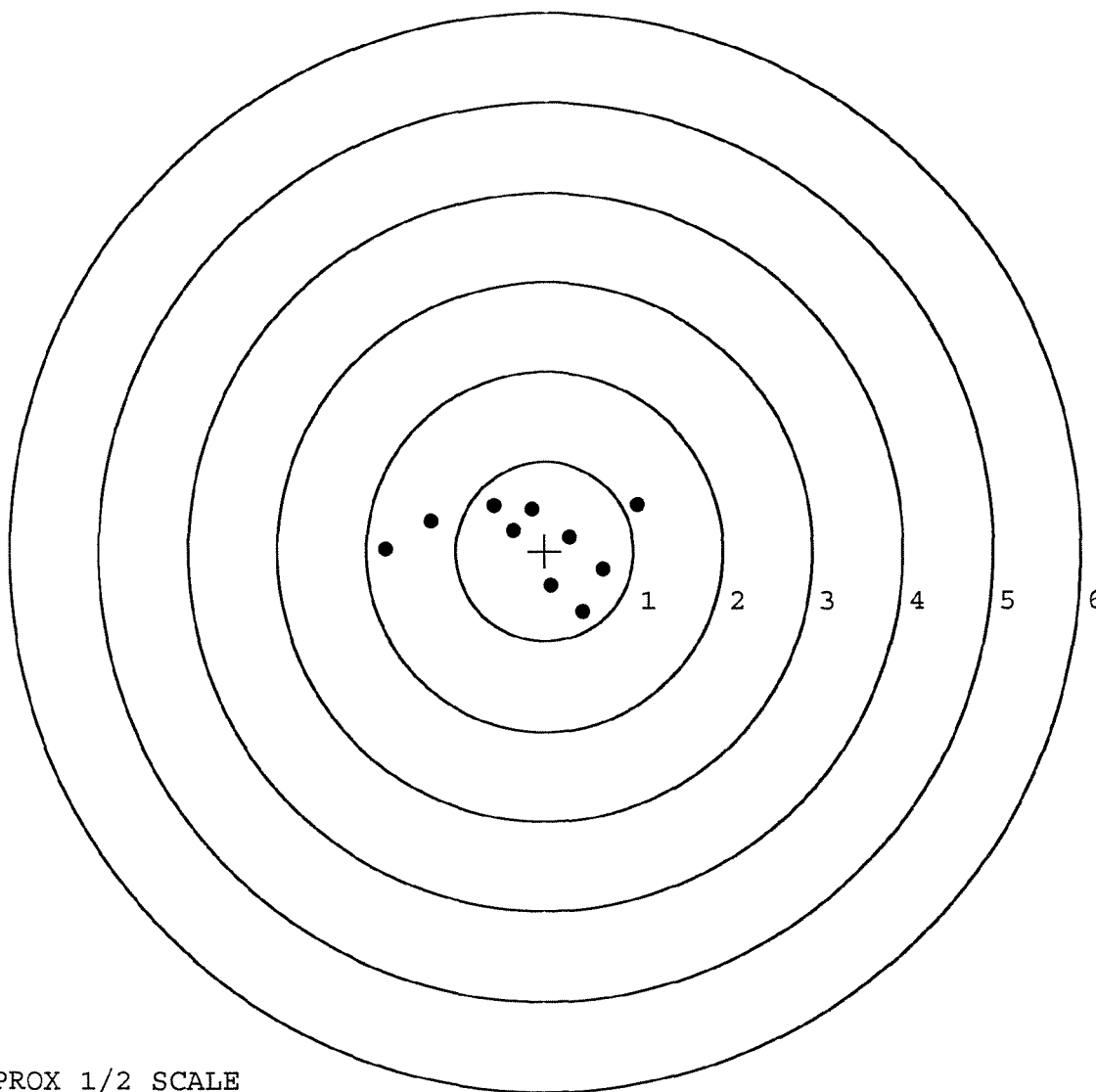
MAX RADIUS: 1.618

MEAN RADIUS: 0.808

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591647. 0

TARGET NUMBER: 2

FILE DATE: 08/29/2006

FILE TIME: 20:06

POINT#	X	Y
1:	-0.858	-0.510
2:	0.266	-0.917
3:	1.231	-0.498
4:	0.168	0.817
5:	0.437	0.302
6:	-0.274	-0.004
7:	-0.065	0.223
8:	-0.776	0.628
9:	-0.438	0.523
10:	-0.182	0.654

X CENTROID: -0.049

Y CENTROID: 0.122

POA TO CENTROID: 0.131

HORZ SPREAD: 2.089

VERT SPREAD: 1.734

GROUP SPREAD: 2.301

MIN RADIUS: 0.102

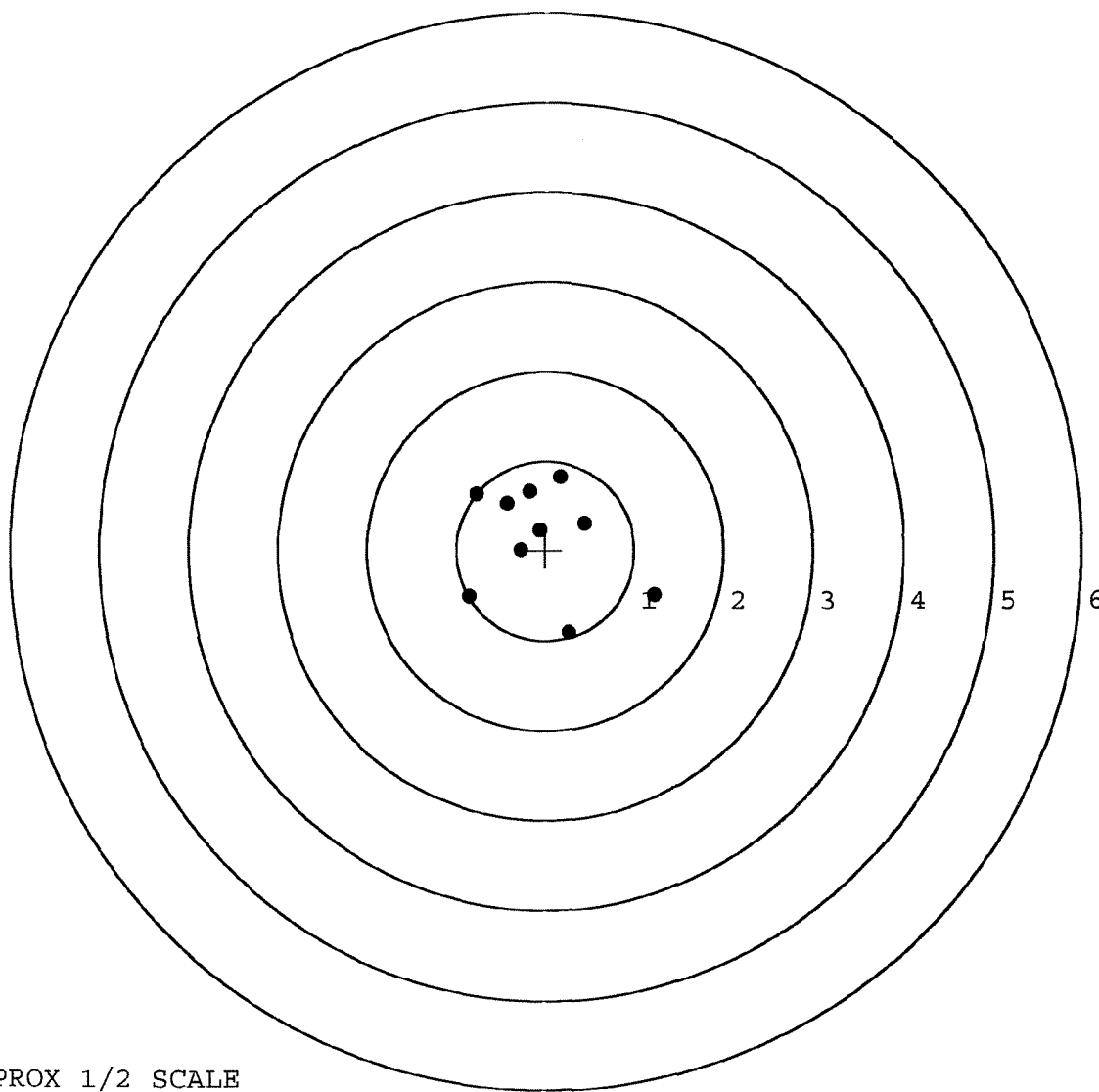
MAX RADIUS: 1.422

MEAN RADIUS: 0.713

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

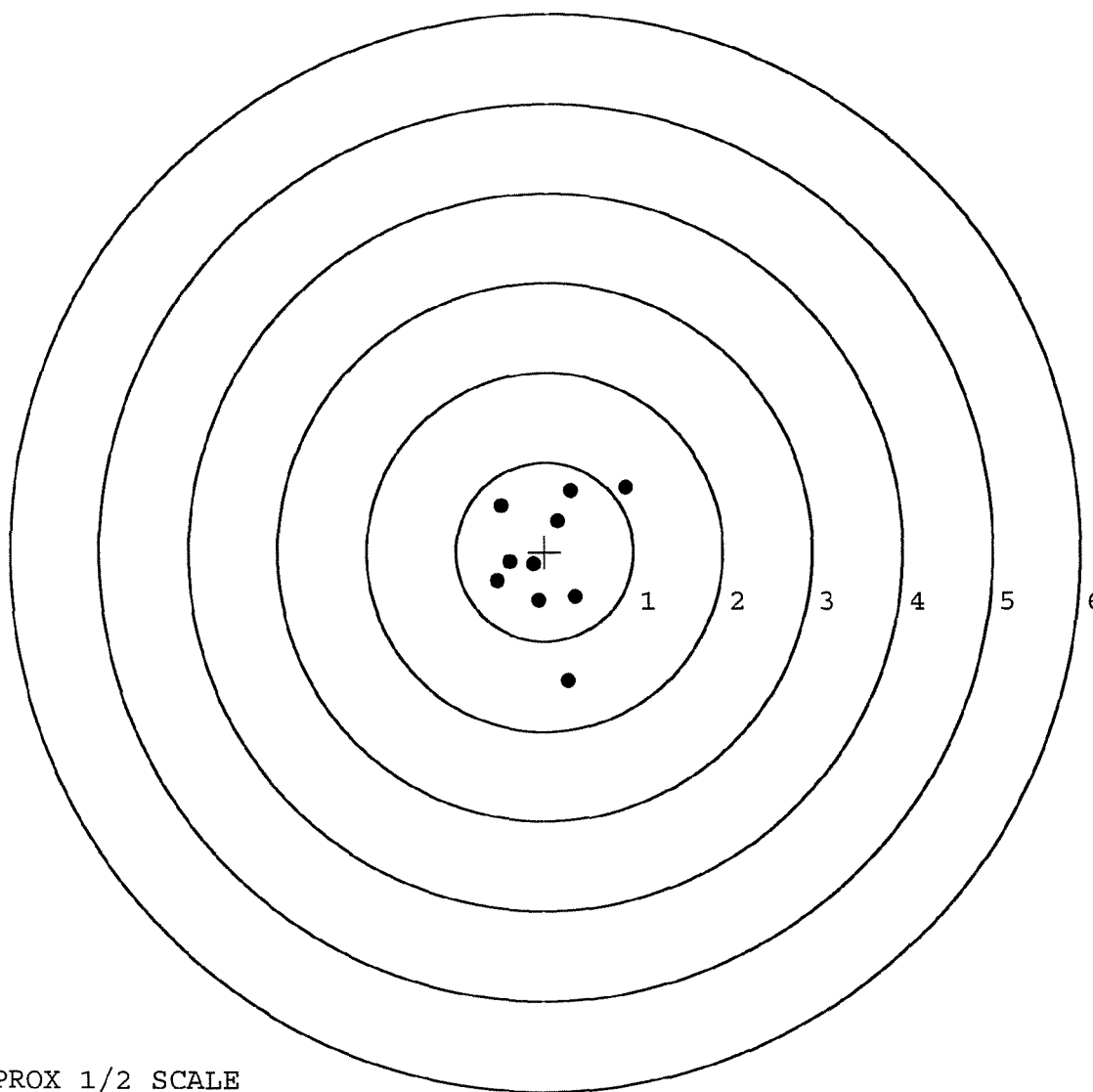
SERIAL NUMBER: G6591647. __0

TARGET NUMBER: 3

FILE DATE: 08/29/2006

FILE TIME: 20:06

	POINT#	X	Y
	1:	0.273	-1.444
	2:	0.345	-0.512
	3:	-0.072	-0.551
	4:	0.910	0.720
X CENTROID:	5:	0.292	0.681
Y CENTROID:	6:	0.141	0.342
POA TO CENTROID:	7:	-0.496	0.507
HORZ SPREAD:	8:	-0.130	-0.143
VERT SPREAD:	9:	-0.534	-0.339
GROUP SPREAD:	10:	-0.394	-0.116
MIN RADIUS:		0.173	
MAX RADIUS:		1.379	
MEAN RADIUS:		0.684	
# IN 1 IN DIAMETER:		4	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591647. 0

TARGET NUMBER: 4

FILE DATE: 08/29/2006

FILE TIME: 20:06

X CENTROID: 0.067

Y CENTROID: 0.085

POA TO CENTROID: 0.108

HORZ SPREAD: 2.261

VERT SPREAD: 1.016

GROUP SPREAD: 2.282

MIN RADIUS: 0.340

MAX RADIUS: 1.399

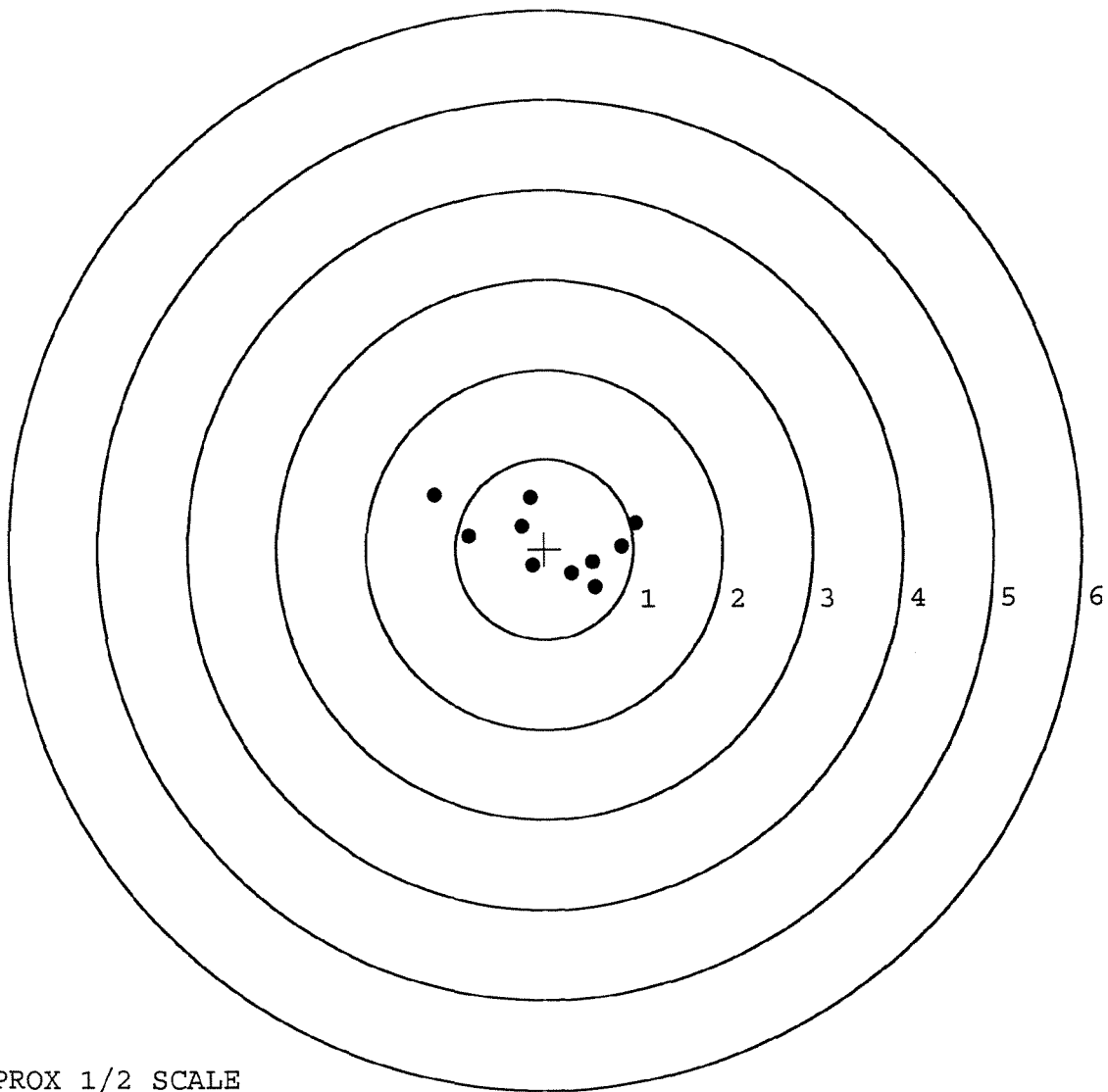
MEAN RADIUS: 0.702

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.236	0.595
2:	-0.848	0.141
3:	-0.261	0.253
4:	-0.162	0.573
5:	-0.135	-0.188
6:	1.025	0.284
7:	0.570	-0.421
8:	0.304	-0.268
9:	0.546	-0.148
10:	0.870	0.030



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591647. __0

TARGET NUMBER: 5

FILE DATE: 08/29/2006

FILE TIME: 20:06

POINT#	X	Y
1:	0.403	0.788
2:	-0.625	0.514
3:	-0.594	0.378
4:	-1.384	-0.439
5:	-0.218	-1.145
6:	-0.042	-0.519
7:	0.525	-0.554
8:	0.628	-0.373
9:	0.315	-0.359
10:	0.154	-0.251

X CENTROID: -0.084

Y CENTROID: -0.196

POA TO CENTROID: 0.213

HORZ SPREAD: 2.012

VERT SPREAD: 1.933

GROUP SPREAD: 2.168

MIN RADIUS: 0.244

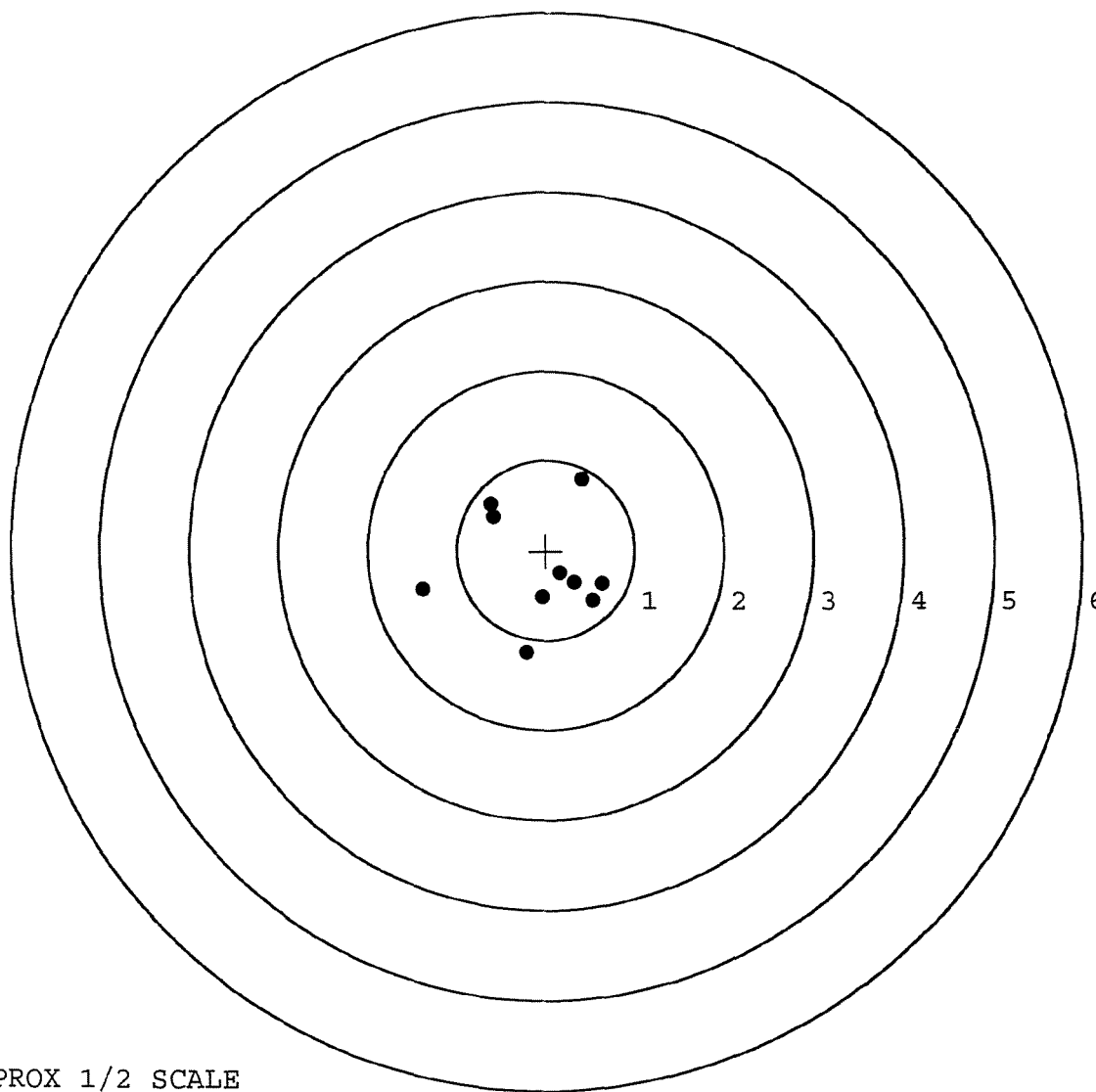
MAX RADIUS: 1.323

MEAN RADIUS: 0.748

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE