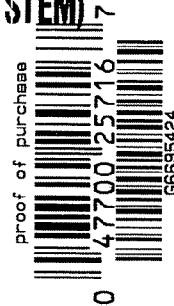


G 669 5424

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

- INSTRUCTION BOOK 3518

BM FORM

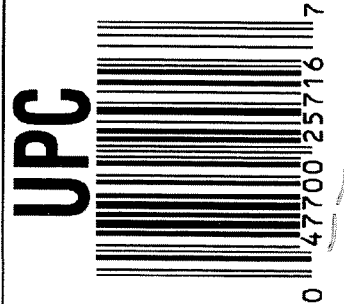


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6695424



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 # G669 5424

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		12-5-07	RTZ
420	ASSEMBLE ACTION		12-5-07	RTZ
430	ASSEMBLE TO STOCK		12-5-07	RTZ
440	PROOF		12-6-07	TRW
460	CHECK HEADSPACE	MAGNA - FLUX	12-6-07	TRW
470	DIS-ASSEMBLE ACTION	2.7mm	12-6-07	RTZ
480	MAGNAFLUX BBL ACTION		12-10-07	JB
490	MAGNAFLUX BOLT	OPERATOR JB		
500	ROLLMARK CALIBER		12-7-07	CW
510	DRILL AND TAP SIGHT HOLES		12-7-07	FM
520	GOFF BLAST BBL / REC		12-11-07	ZY
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		12/14/07	JB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-19-07	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-19-07	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-19-07	DA
	D) OIL FIRING PIN ASSEMBLY			
	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>55</u> <u>55</u> <u>55</u>	1-3-08	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>35</u> <u>35</u> <u>35</u>	1-3-08	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.1023</u> <u>.023</u> <u>.023</u>	1-3-08	DA
	J) ASSEMBLE STOCK			
	K) ASSEMBLE SWIVEL STUDS		1-8-08	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-8-08	RT
	M) IRON SIGHT ALIGNMENT		1-8-08	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-8-08	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-2-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-2-08	FM
670	FINAL INSPECTION A) HEADSPACE		1-8-08	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.27</u> <u>2.61</u> <u>2.56</u> <u>2.37</u>	1-3-08	DA
	C) FUNCTION		1-8-08	RT
690	PACK		1-8-08	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 11-5-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.41		2.72	
PULL #2	2.42	2.22		2.60	
PULL #3	2.47	2.31		2.77	
PULL #4	2.31	2.40		2.51	
PULL #5	2.29	2.29		2.44	
TOTAL	12.11	11.63		13.04	
AVERAGE	2.42	2.32		2.60	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.25		
PULL #2	3.04	3.27		
PULL #3	3.10	3.16		
PULL #4	3.09	3.18		
PULL #5	3.38	3.12		
TOTAL	15.76	15.98		
AVERAGE	3.15	3.19		

	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	4.27	4.00		4.04
PULL #2	4.10	4.22		4.19
PULL #3	4.16	4.08		4.04
PULL #4	4.10	4.13		4.03
PULL #5	4.14	4.04		4.11
TOTAL	20.77	20.47		20.41
AVERAGE	4.15	4.09		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695424. __0

FILE DATE AND TIME: 01/03/2008 14:36

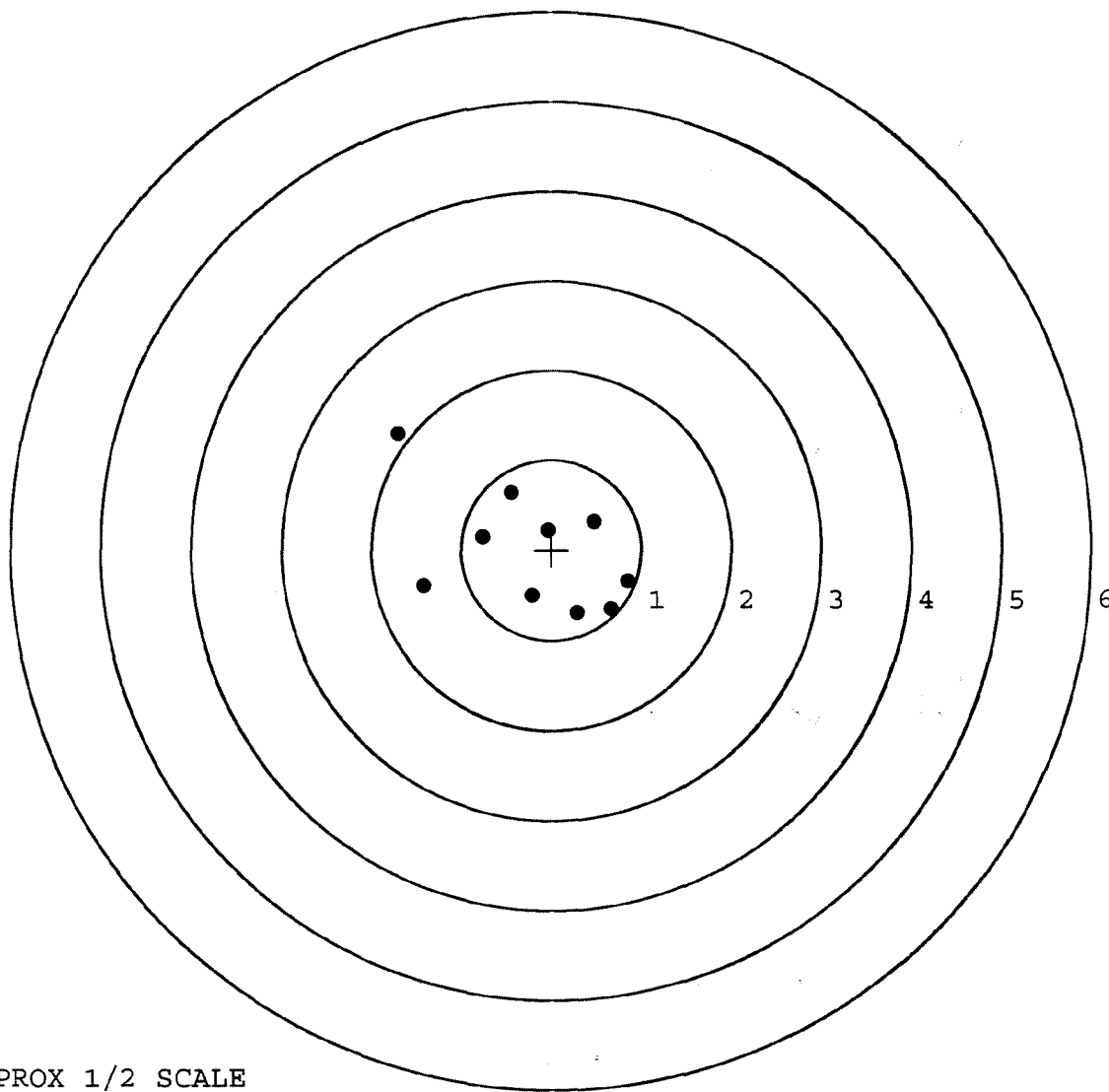
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.079
The Average Y Centroid of the Five Target Set:	0.008
The Average Point of Impact of the Five Target Set:	0.079
The Average Mean Radius of the Five Target Set:	0.631
The Distance from POA to Centroid Target #1:	0.231
The Distance from Centroid Target #2 to Centroid Target #1:	0.246
The Distance from Centroid Target #3 to Centroid Target #1:	0.201
The Distance from Centroid Target #4 to Centroid Target #1:	0.159
The Distance from Centroid Target #5 to Centroid Target #1:	0.208

SERIAL NUMBER: G6695424. __ 0
TARGET NUMBER: 1
FILE DATE: 01/03/2008
FILE TIME: 14:36

X CENTROID: -0.231
Y CENTROID: -0.002
POA TO CENTROID: 0.231
HORZ SPREAD: 2.556
VERT SPREAD: 1.976
GROUP SPREAD: 3.058
MIN RADIUS: 0.290
MAX RADIUS: 1.954
MEAN RADIUS: 0.911
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.852	-0.351
2:	0.660	-0.658
3:	0.282	-0.694
4:	-0.219	-0.513
5:	0.474	0.319
6:	-0.038	0.214
7:	-0.443	0.636
8:	-0.762	0.145
9:	-1.415	-0.405
10:	-1.704	1.282



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695424. 0

TARGET NUMBER: 2

FILE DATE: 01/03/2008

FILE TIME: 14:36

POINT#	X	Y
--------	---	---

1:	-0.038	-0.864
----	--------	--------

2:	0.774	-0.190
----	-------	--------

3:	0.320	-0.052
----	-------	--------

4:	0.421	0.344
----	-------	-------

5:	-0.269	0.678
----	--------	-------

6:	-0.599	0.542
----	--------	-------

7:	-0.309	0.167
----	--------	-------

8:	-0.504	-0.057
----	--------	--------

9:	-0.178	-0.111
----	--------	--------

10:	0.481	0.008
-----	-------	-------

X CENTROID: 0.010

Y CENTROID: 0.046

POA TO CENTROID: 0.048

HORZ SPREAD: 1.373

VERT SPREAD: 1.542

GROUP SPREAD: 1.559

MIN RADIUS: 0.245

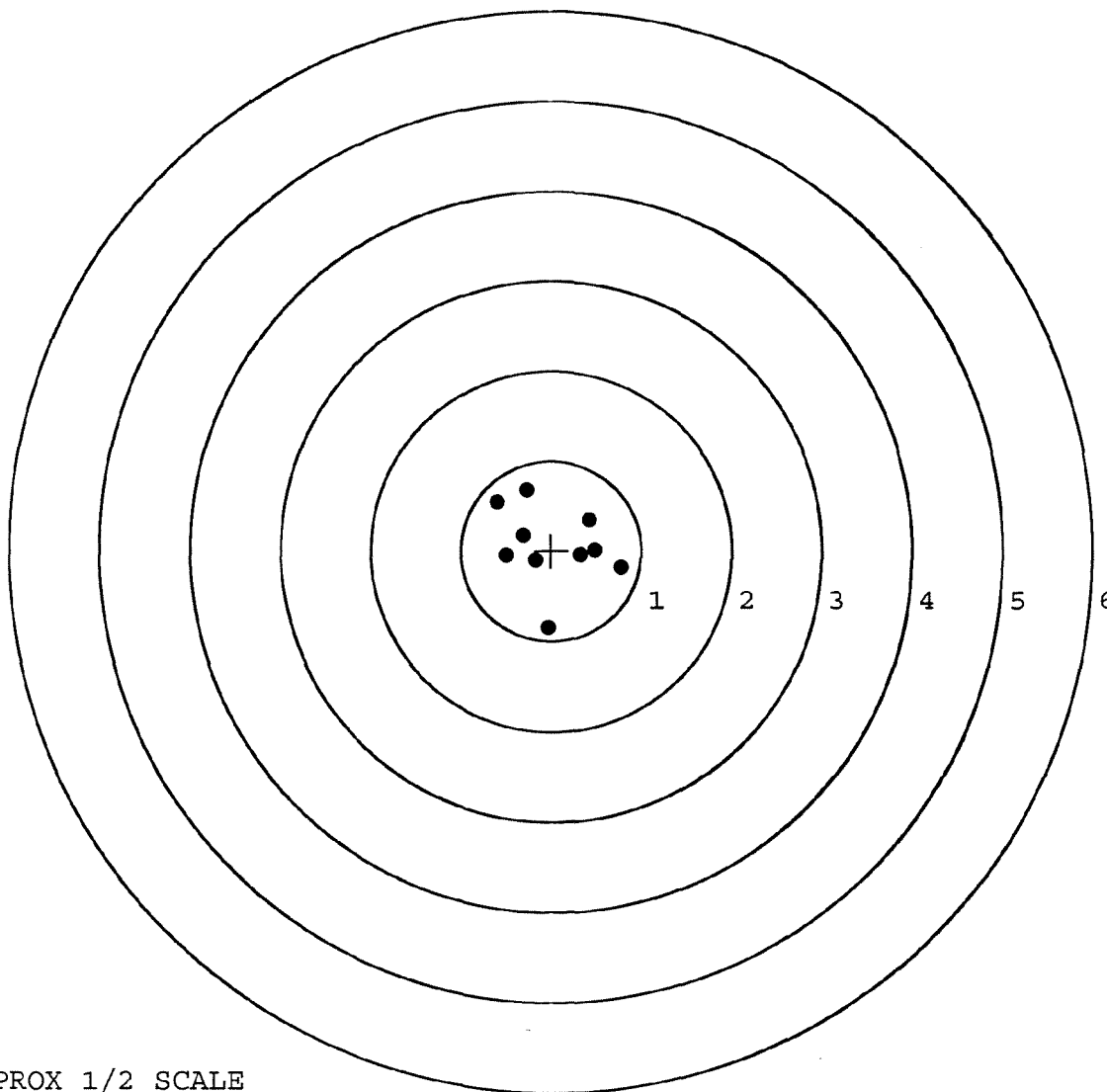
MAX RADIUS: 0.912

MEAN RADIUS: 0.560

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

IN 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695424. __0

TARGET NUMBER: 3

FILE DATE: 01/03/2008

FILE TIME: 14:36

POINT#	X	Y
--------	---	---

1:	0.304	-1.101
----	-------	--------

2:	-0.485	-0.726
----	--------	--------

3:	-0.291	-0.414
----	--------	--------

4:	-0.500	-0.249
----	--------	--------

5:	-0.670	0.356
----	--------	-------

6:	0.649	0.548
----	-------	-------

7:	0.246	0.069
----	-------	-------

8:	0.236	0.417
----	-------	-------

9:	0.121	0.393
----	-------	-------

10:	0.016	0.152
-----	-------	-------

X CENTROID: -0.037

Y CENTROID: -0.055

POA TO CENTROID: 0.067

HORZ SPREAD: 1.319

VERT SPREAD: 1.649

GROUP SPREAD: 1.753

MIN RADIUS: 0.214

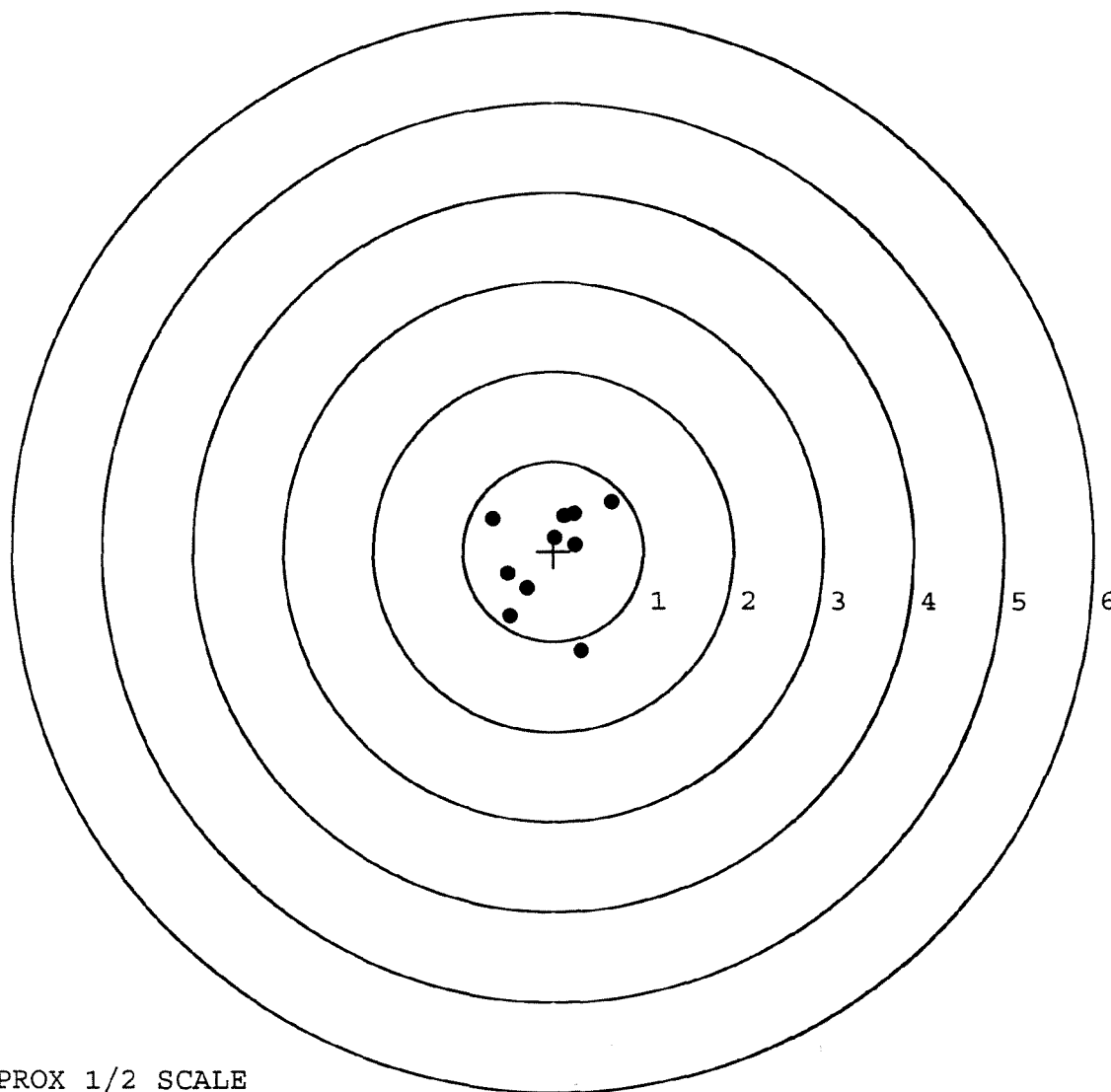
MAX RADIUS: 1.100

MEAN RADIUS: 0.606

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695424. __ 0

TARGET NUMBER: 4

FILE DATE: 01/03/2008

FILE TIME: 14:36

POINT#	X	Y
1:	-0.888	0.416
2:	-0.371	0.405
3:	0.195	0.343
4:	0.457	0.195
5:	0.557	-0.148
6:	0.335	-0.528
7:	0.073	0.038
8:	-0.081	-0.239
9:	-0.293	-0.409
10:	-0.800	-0.622

X CENTROID: -0.082

Y CENTROID: -0.055

POA TO CENTROID: 0.098

HORZ SPREAD: 1.445

VERT SPREAD: 1.038

GROUP SPREAD: 1.551

MIN RADIUS: 0.180

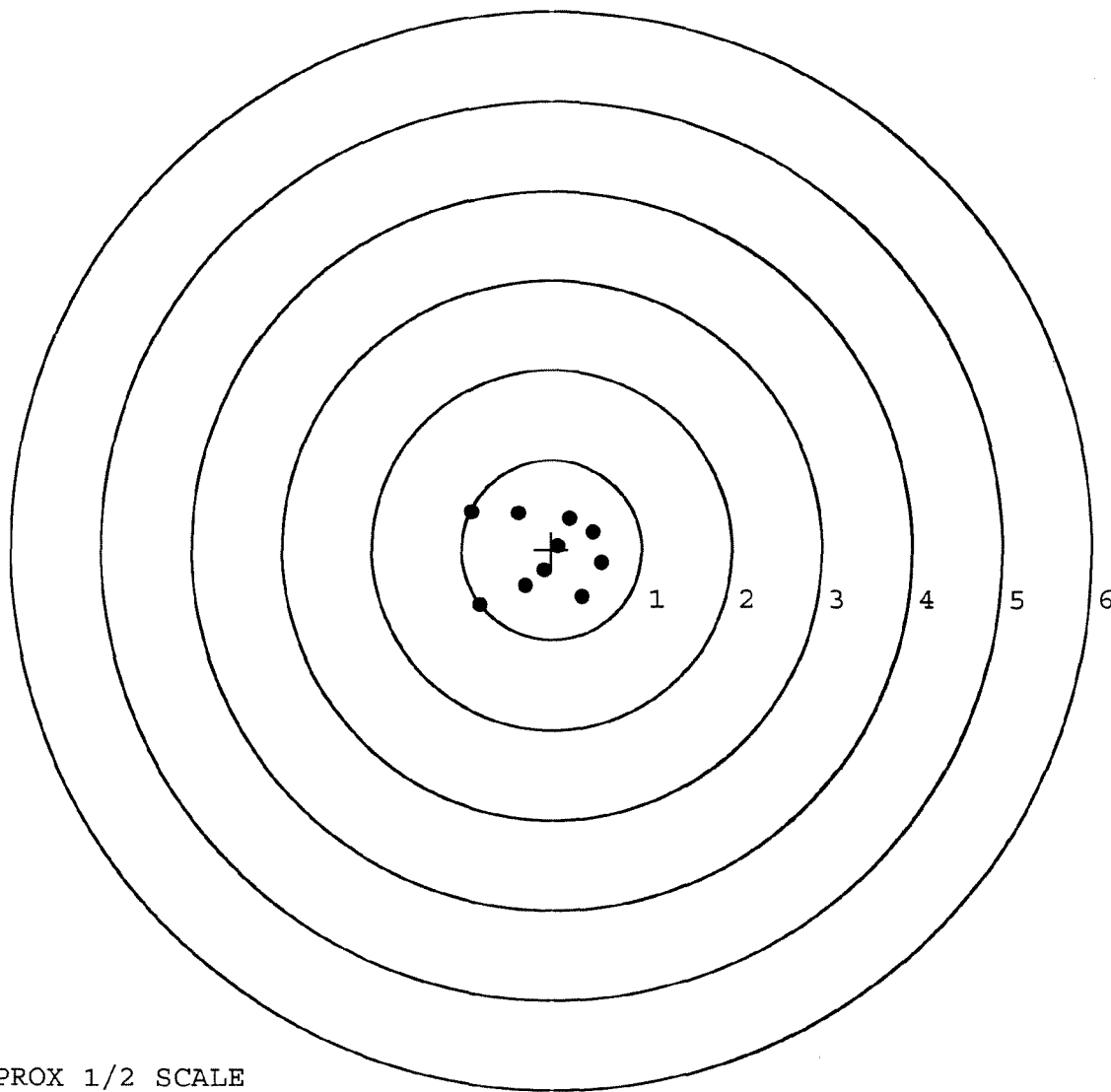
MAX RADIUS: 0.934

MEAN RADIUS: 0.552

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695424. __0

TARGET NUMBER: 5

FILE DATE: 01/03/2008

FILE TIME: 14:36

POINT#	X	Y
--------	---	---

1:	0.010	0.941
----	-------	-------

2:	-0.349	0.600
----	--------	-------

3:	0.800	0.160
----	-------	-------

4:	0.227	0.241
----	-------	-------

5:	0.070	0.100
----	-------	-------

6:	0.209	-0.211
----	-------	--------

7:	-0.044	-0.086
----	--------	--------

8:	-0.192	-0.637
----	--------	--------

9:	-0.525	0.016
----	--------	-------

10:	-0.746	-0.058
-----	--------	--------

X CENTROID: -0.054

Y CENTROID: 0.107

POA TO CENTROID: 0.119

HORZ SPREAD: 1.546

VERT SPREAD: 1.578

GROUP SPREAD: 1.561

MIN RADIUS: 0.124

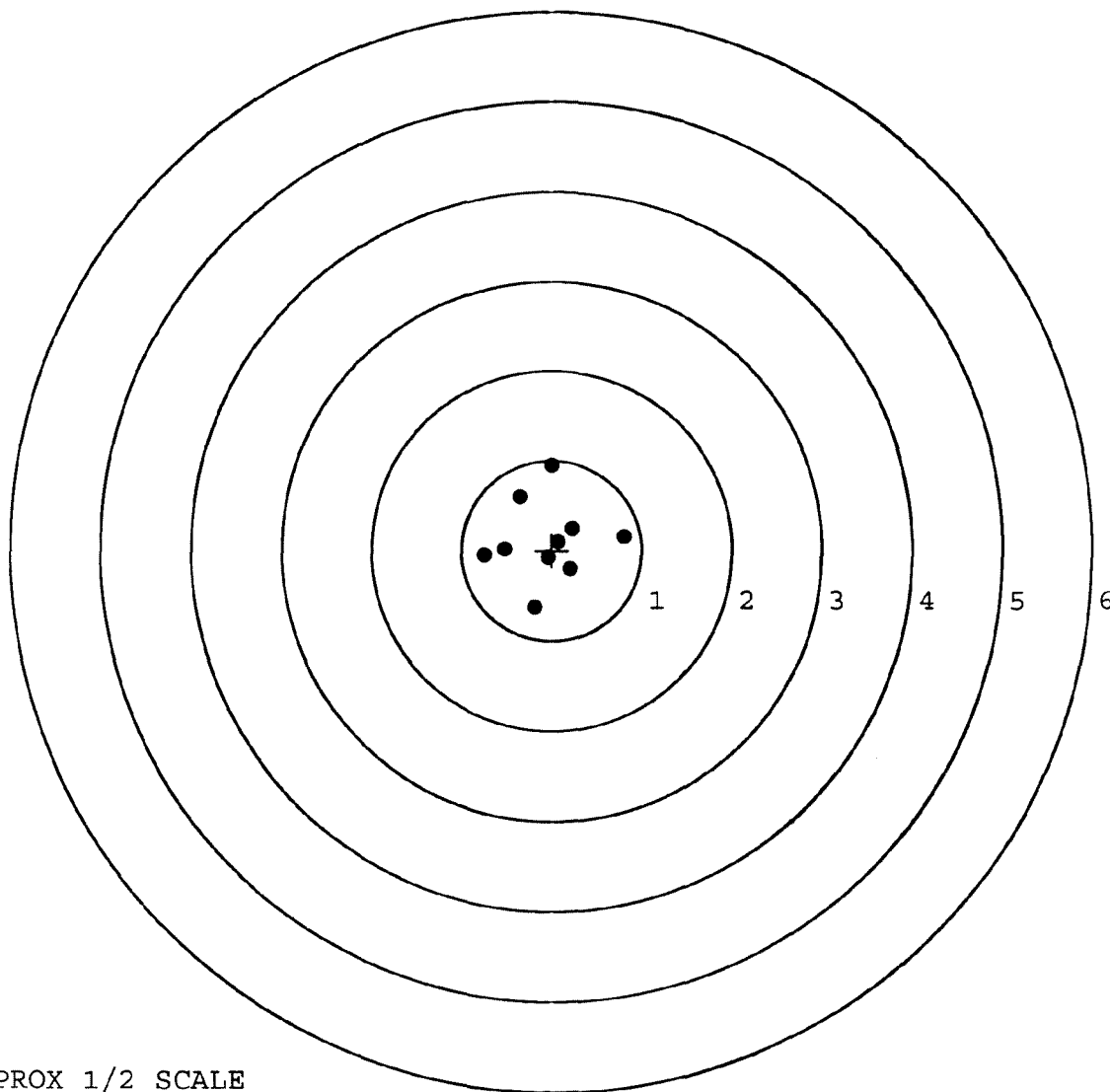
MAX RADIUS: 0.856

MEAN RADIUS: 0.526

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE