

G 653 5181

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



DD FORM

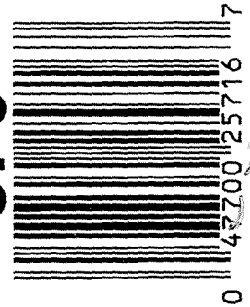
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6535181

UPC



ORDER 25716

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

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SERIAL NO.



66535181

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6535181

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-23-06	RTZ
420	ASSEMBLE ACTION		8-23-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		8-23-06	L.P.D.
460	CHECK HEADSPACE	INSPECTED	8-23-06	L.P.D.
470	DIS-ASSEMBLE ACTION	AUG 24 2006	8-24-06	RTZ
480	MAGNAFLUX BBL ACTION	INSPECTOR <i>unus</i>	8/24/06	<i>unus</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-24-06	CW
510	DRILL AND TAP SIGHT HOLES		8-24-06	TRW
520	GOFF BLAST BBL / REC		8-25-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/29/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-7-06	<i>Ac</i>
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-7-06	<i>Ac</i>
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-7-06	<i>Ac</i>
	D) OIL FIRING PIN ASSEMBLY		9-8-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/11/06	<i>unus</i>

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.2</u> <u>6.2</u> <u>6.2</u>	9/15/06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.5</u>	9-15-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	mm
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	9/15/06	DA
	J) ASSEMBLE STOCK		9-8-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/11/06	mm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-8-06	BLG
	M) IRON SIGHT ALIGNMENT		9-8-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-8-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-12-06	DA
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-12-06	mm
670	FINAL INSPECTION A) HEADSPACE		10/11/06	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.72</u> <u>2.68</u> <u>2.96</u> <u>2.97</u>	9-14-06	DA
	C) FUNCTION		10/11/06	mm
690	PACK		11/1/06	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 9-7-06
TESTER R.P

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.55		2.43	
PULL #2	2.41	2.51		2.52	
PULL #3	2.42	2.49		2.49	
PULL #4	2.40	2.51		2.55	
PULL #5	2.45	2.50		2.54	
TOTAL	12.08	12.56		12.53	
AVERAGE	2.41	2.51		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.11		
PULL #2	3.01	3.21		
PULL #3	3.02	3.04		
PULL #4	3.03	3.04		
PULL #5	3.05	3.01		
TOTAL	15.16	15.41		
AVERAGE	3.03	3.08		

	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	4.04	4.05		4.02
PULL #2	4.01	3.93		4.02
PULL #3	4.02	4.07		3.97
PULL #4	4.04	4.02		4.00
PULL #5	3.97	3.97		4.05
TOTAL	20.08	20.04		20.06
AVERAGE	4.01	4.00		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535181.___0
FILE DATE AND TIME: 09/13/2006 06:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.072
The Average Y Centroid of the Five Target Set:	0.023
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.634
The Distance from POA to Centroid Target #1:	0.170
The Distance from Centroid Target #2 to Centroid Target #1:	0.093
The Distance from Centroid Target #3 to Centroid Target #1:	0.178
The Distance from Centroid Target #4 to Centroid Target #1:	0.073
The Distance from Centroid Target #5 to Centroid Target #1:	0.172

SERIAL NUMBER: G6535181. 0

TARGET NUMBER: 1

FILE DATE: 09/13/2006

FILE TIME: 06:17

POINT#	X	Y
1:	-1.087	-0.897
2:	-0.279	-0.700
3:	0.220	-0.464
4:	0.408	0.113
5:	0.106	1.122
6:	-0.082	0.625
7:	-0.428	-0.085
8:	-0.473	0.240
9:	-0.342	0.413
10:	0.254	-0.326

X CENTROID: -0.170

Y CENTROID: 0.004

POA TO CENTROID: 0.170

HORZ SPREAD: 1.495

VERT SPREAD: 2.019

GROUP SPREAD: 2.345

MIN RADIUS: 0.273

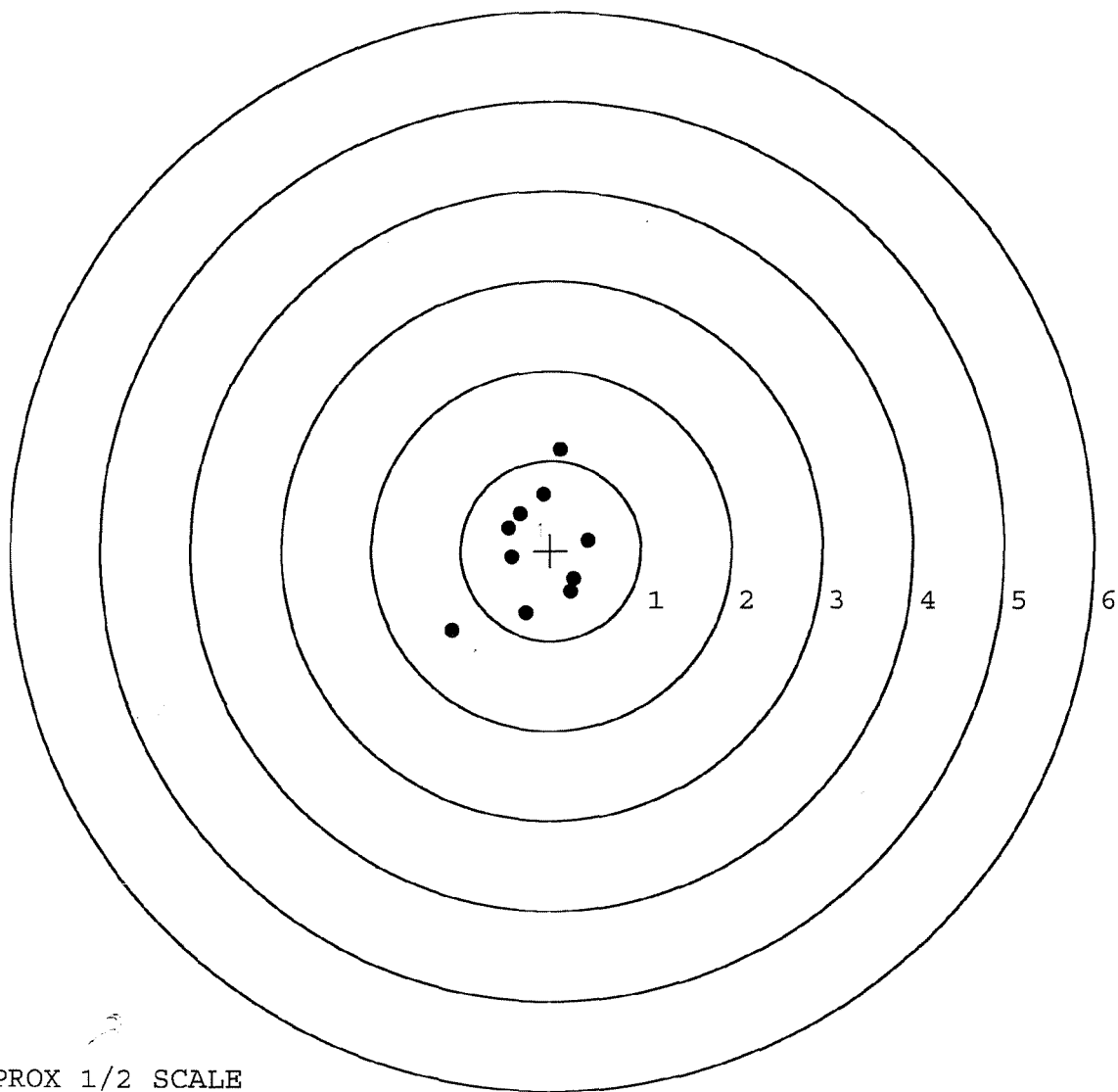
MAX RADIUS: 1.285

MEAN RADIUS: 0.661

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535181.___0

TARGET NUMBER: 2

FILE DATE: 09/13/2006

FILE TIME: 06:17

POINT#	X	Y
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1:	-0.356	1.659
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2:	-0.369	0.856
----	--------	-------

3:	-0.332	0.276
----	--------	-------

4:	0.028	0.180
----	-------	-------

5:	0.913	0.290
----	-------	-------

6:	0.362	-0.159
----	-------	--------

7:	0.155	-0.412
----	-------	--------

8:	0.057	-1.616
----	-------	--------

9:	-0.676	-0.576
----	--------	--------

10:	-0.551	-0.473
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X CENTROID: -0.077

Y CENTROID: 0.003

POA TO CENTROID: 0.077

HORZ SPREAD: 1.589

VERT SPREAD: 3.275

GROUP SPREAD: 3.301

MIN RADIUS: 0.206

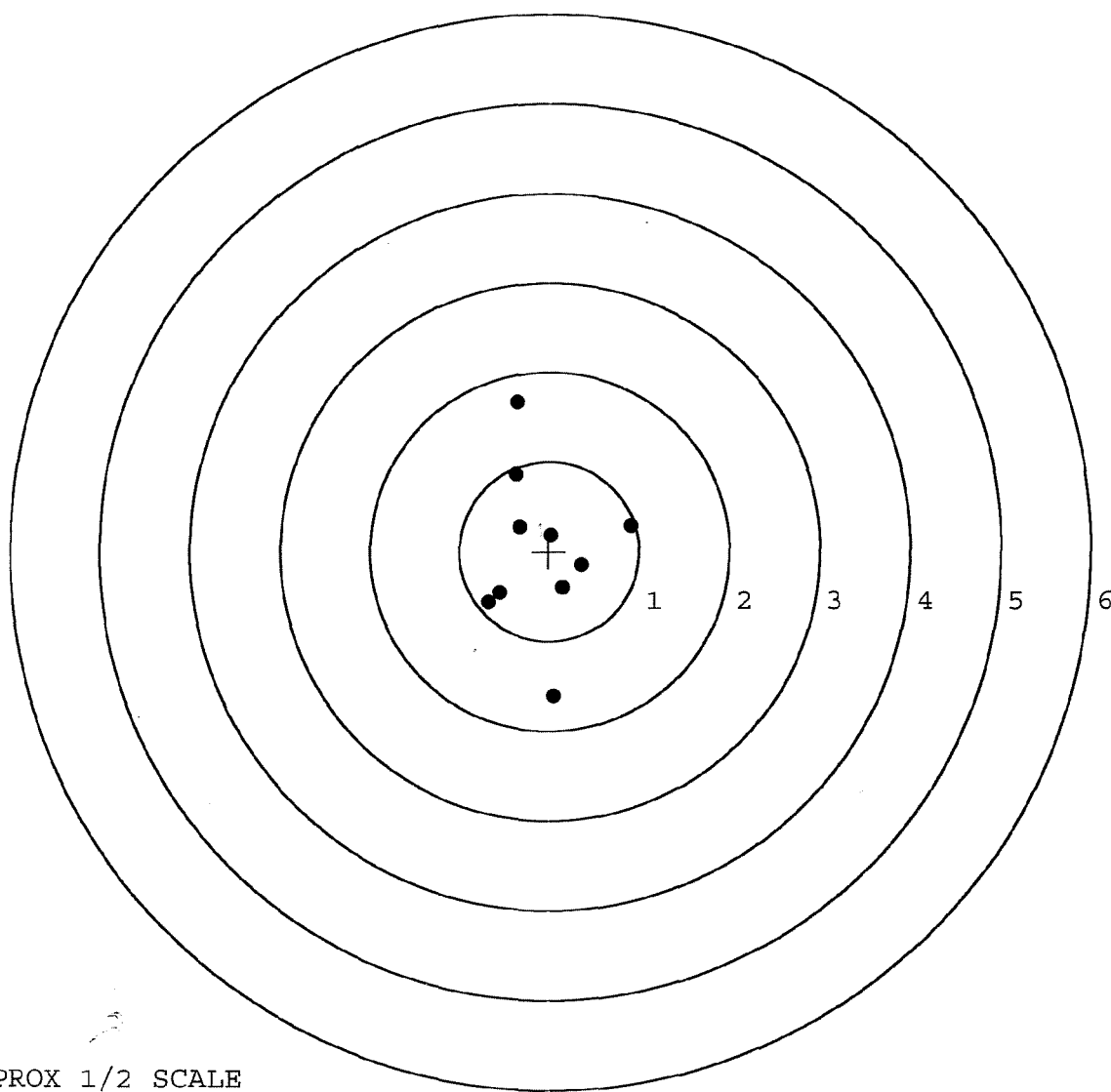
MAX RADIUS: 1.680

MEAN RADIUS: 0.826

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



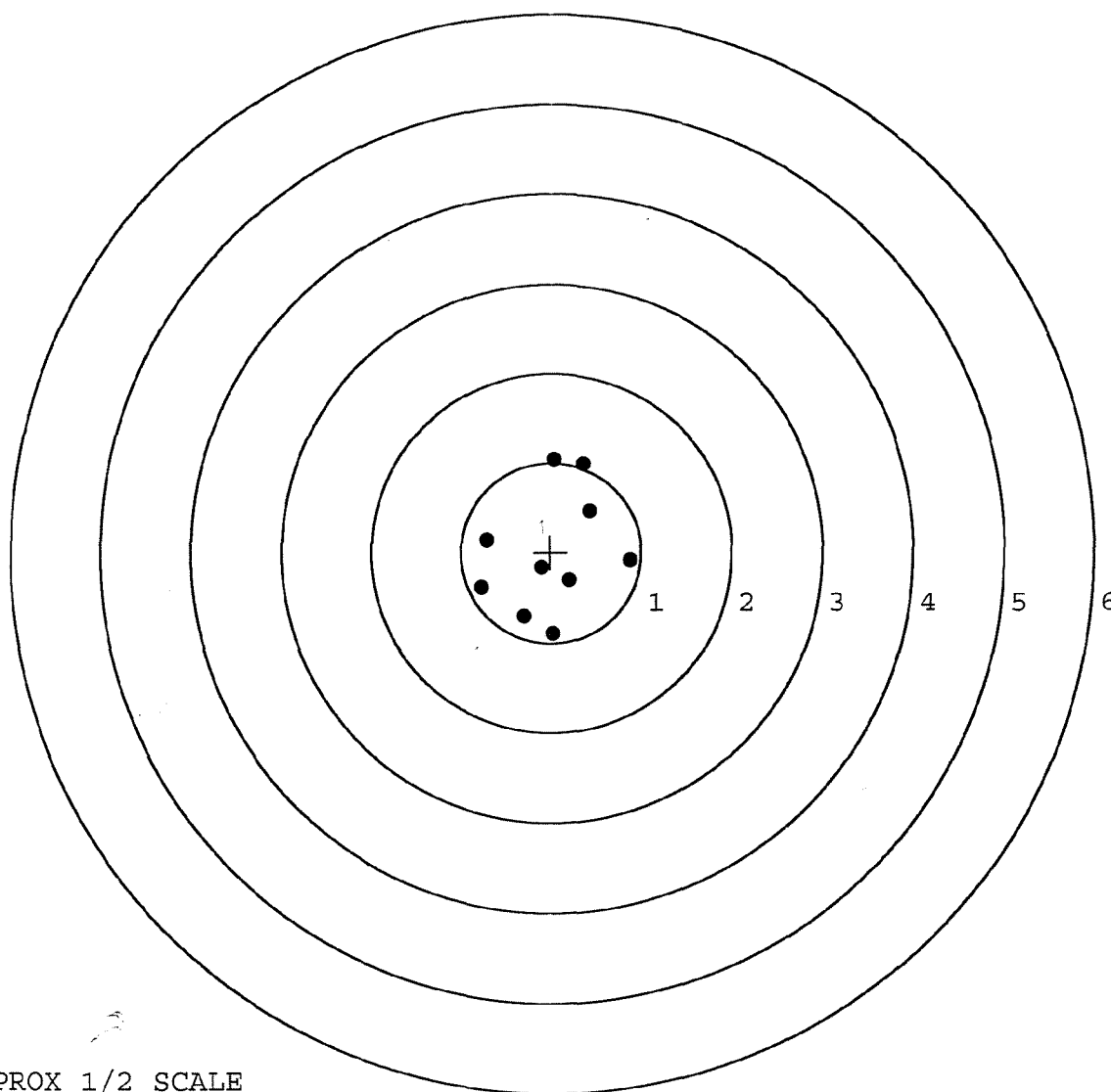
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535181. __0
TARGET NUMBER: 3
FILE DATE: 09/13/2006
FILE TIME: 06:17

X CENTROID: 0.008
Y CENTROID: 0.005
POA TO CENTROID: 0.009
HORZ SPREAD: 1.650
VERT SPREAD: 1.941
GROUP SPREAD: 1.926
MIN RADIUS: 0.205
MAX RADIUS: 1.050
MEAN RADIUS: 0.746

POINT#	X	Y
1:	0.041	1.036
2:	0.366	0.992
3:	0.428	0.463
4:	0.883	-0.092
5:	0.031	-0.905
6:	0.212	-0.308
7:	-0.297	-0.711
8:	-0.101	-0.169
9:	-0.767	-0.391
10:	-0.718	0.138

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535181. 0

TARGET NUMBER: 4

FILE DATE: 09/13/2006

FILE TIME: 06:17

POINT#	X	Y
1:	0.066	0.786
2:	-0.141	0.744
3:	-0.513	0.382
4:	-1.105	-0.501
5:	0.477	-0.525
6:	0.424	0.031
7:	-0.396	-0.142
8:	-0.152	0.034
9:	0.141	-0.099
10:	0.017	-0.161

X CENTROID: -0.118

Y CENTROID: 0.055

POA TO CENTROID: 0.130

HORZ SPREAD: 1.582

VERT SPREAD: 1.311

GROUP SPREAD: 1.740

MIN RADIUS: 0.040

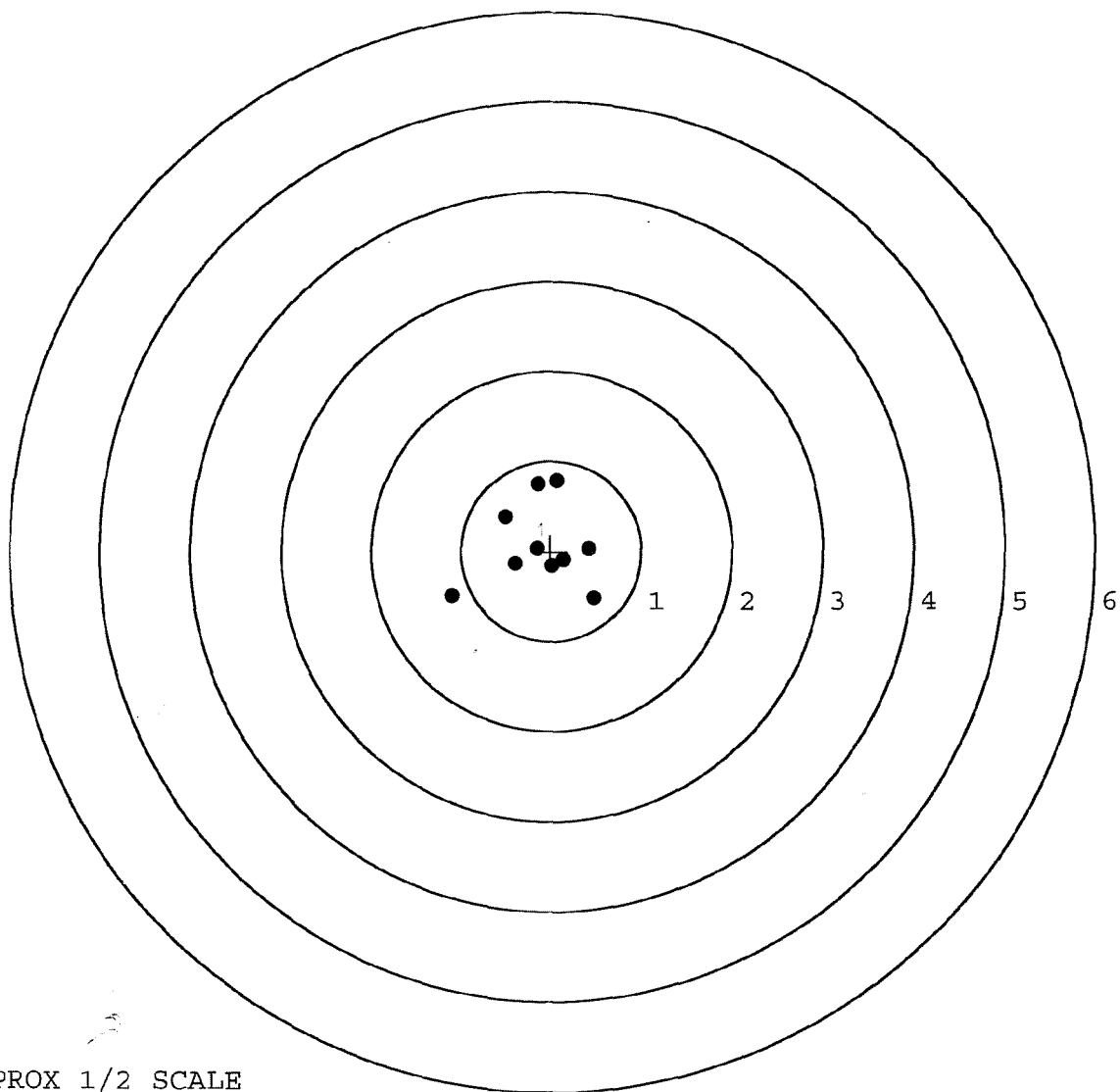
MAX RADIUS: 1.133

MEAN RADIUS: 0.540

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535181.___0

TARGET NUMBER: 5

FILE DATE: 09/13/2006

FILE TIME: 06:17

POINT#	X	Y
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1:	0.087	0.870
----	-------	-------

2:	0.642	0.040
----	-------	-------

3:	-0.124	0.308
----	--------	-------

4:	-0.566	0.059
----	--------	-------

5:	-0.272	-0.504
----	--------	--------

6:	0.170	-0.311
----	-------	--------

7:	0.247	0.092
----	-------	-------

8:	0.025	0.053
----	-------	-------

9:	-0.214	-0.043
----	--------	--------

10:	-0.037	-0.076
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X CENTROID: -0.004

Y CENTROID: 0.049

POA TO CENTROID: 0.049

HORZ SPREAD: 1.208

VERT SPREAD: 1.374

GROUP SPREAD: 1.420

MIN RADIUS: 0.030

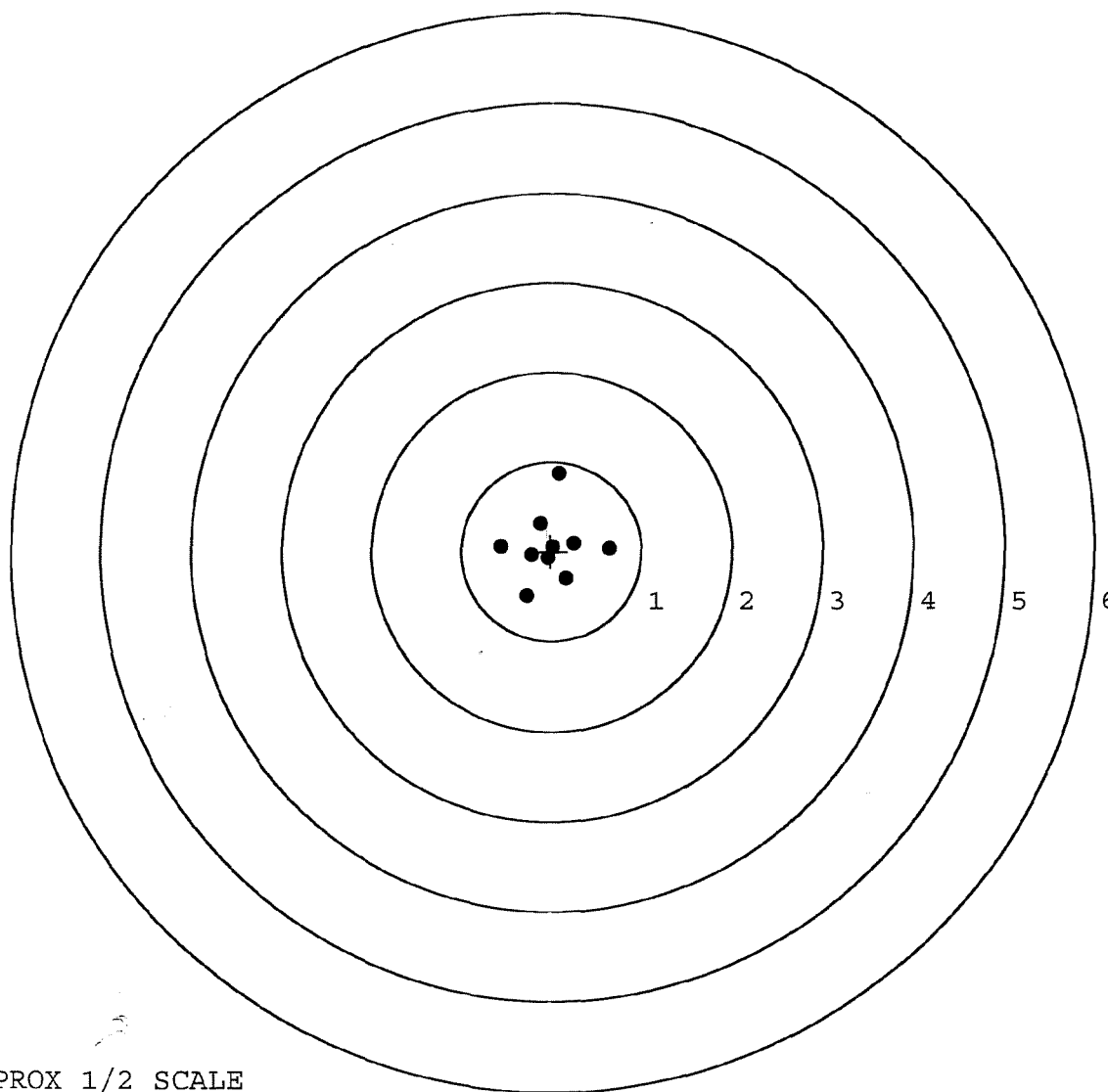
MAX RADIUS: 0.826

MEAN RADIUS: 0.398

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE