

G 463 5783

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

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



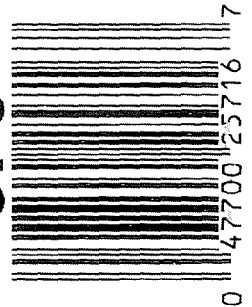
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6635183

UPC



ORDER 25716

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

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SERIAL NO.



66535183

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6635183

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE			
420	ASSEMBLE ACTION		3-12-07	SPD
430	ASSEMBLE TO STOCK		3-14-07	TRW
440	PROOF		3-14-07	FM
460	CHECK HEADSPACE	INSPECTED	3-14-07	FM
470	DIS-ASSEMBLE ACTION	MAR 16 2007	3-15-07	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <i>unm</i>	3/16/07	<i>unm</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-15-07	CW
510	DRILL AND TAP SIGHT HOLES		3-16-07	TRW
520	GOFF BLAST BBL / REC		3-19-07	UB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		3-29-07	W7
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4/2/07	SPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4/2/07	SPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4/2/07	SPD
	D) OIL FIRING PIN ASSEMBLY		4/2/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4/10/07	<i>nm</i>
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.25</u> <u>7.75</u> <u>7.25</u>	4-10-07	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.25</u>	4-10-07	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		4/10/07	non
	I) FIRING PIN INDENT .020 MIN	<u>.0245</u> <u>.025</u> <u>.025</u>	4-10-07	TRW
	J) ASSEMBLE STOCK		4/2/07	SP.17
	K) ASSEMBLE SWIVEL STUDS		4/10/07	non
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4/10/07	non
	M) IRON SIGHT ALIGNMENT		4/10/07	non
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4/10/07	non
640 &	FUNCTION TEST AND	PASS FAIL		
650	TARGET	PASS FAIL	4-3-07	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4/3/07	W.R
670	FINAL INSPECTION A) HEADSPACE		4/10/07	non
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.25</u> <u>2.25</u> <u>2.58</u> <u>2.60</u>	4-10-07	TRW
	C) FUNCTION		4/10/07	non
690	PACK		4/12/07	RA

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 3-30-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.66	2.26		2.67	
PULL #2	2.54	2.34		2.75	
PULL #3	2.62	2.34		2.71	
PULL #4	2.68	2.47		2.67	
PULL #5	2.39	2.58		2.68	
TOTAL	12.89	11.99		13.48	
AVERAGE	2.57	2.39		2.69	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.26		
PULL #2	3.30	3.41		
PULL #3	3.35	3.25		
PULL #4	3.29	3.36		
PULL #5	3.29	3.33		
TOTAL	16.54	16.61		
AVERAGE	3.30	3.32		

	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	4.37	4.22		4.36
PULL #2	4.25	4.29		4.12
PULL #3	4.31	4.18		4.04
PULL #4	4.28	4.10		4.16
PULL #5	4.27	4.15		4.14
TOTAL	21.48	20.94		20.82
AVERAGE	4.29	4.18		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

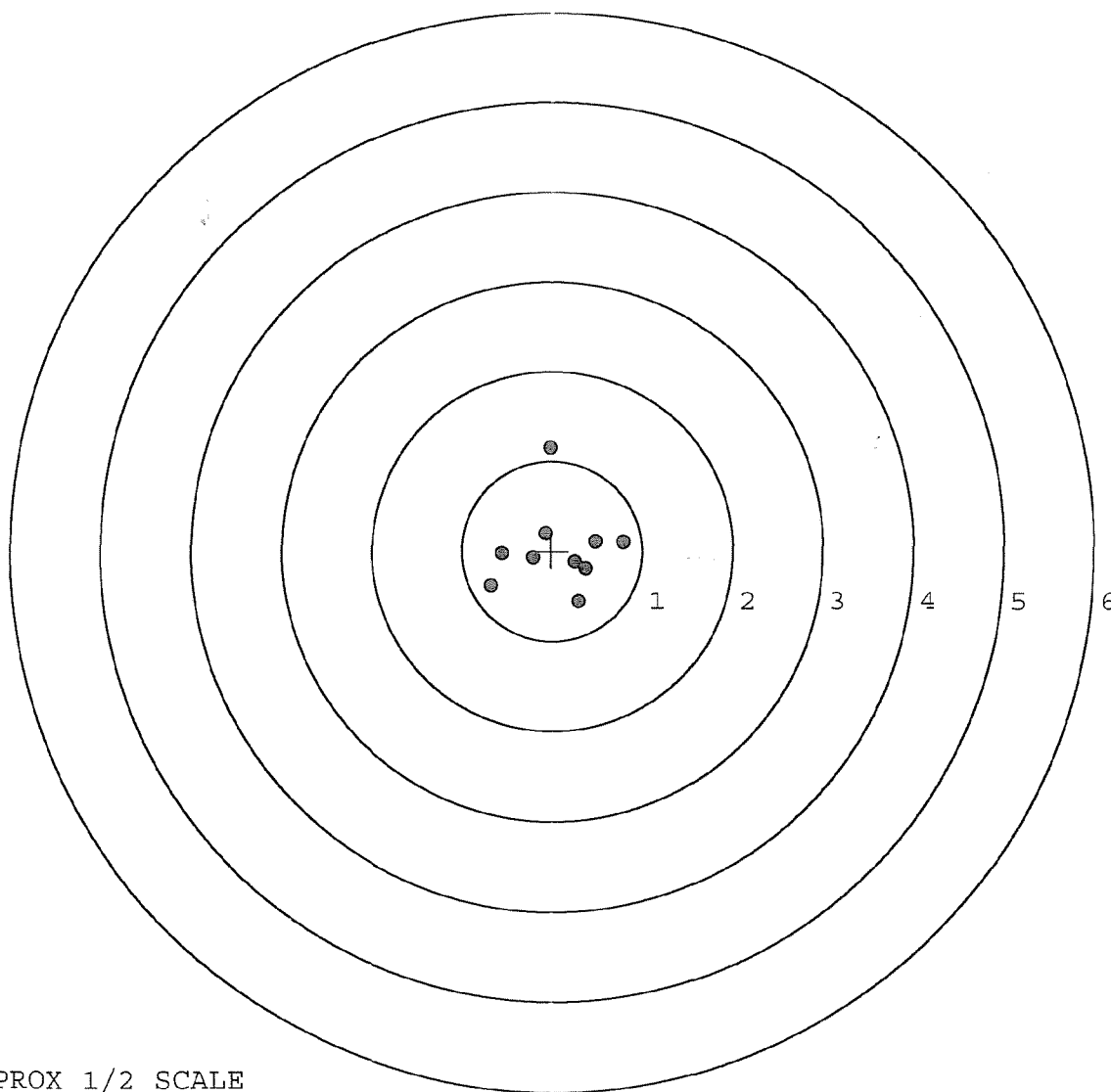
FIREARM SERIAL NUMBER / DATASET NAME: G6635183.___0

FILE DATE AND TIME: 04/03/2007 15:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.031
The Average Y Centroid of the Five Target Set:	-0.134
The Average Point of Impact of the Five Target Set:	0.137
The Average Mean Radius of the Five Target Set:	0.618
The Distance from POA to Centroid Target #1:	0.069
The Distance from Centroid Target #2 to Centroid Target #1:	0.103
The Distance from Centroid Target #3 to Centroid Target #1:	0.349
The Distance from Centroid Target #4 to Centroid Target #1:	0.185
The Distance from Centroid Target #5 to Centroid Target #1:	0.233

SERIAL NUMBER: G6635183. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	-0.020	1.145
FILE DATE: 04/03/2007	2:	0.782	0.103
FILE TIME: 15:10	3:	0.300	-0.564
	4:	0.257	-0.121
X CENTROID: 0.066	5:	-0.069	0.194
Y CENTROID: 0.017	6:	-0.210	-0.078
POA TO CENTROID: 0.069	7:	-0.558	-0.031
HORZ SPREAD: 1.456	8:	-0.674	-0.393
VERT SPREAD: 1.709	9:	0.380	-0.195
GROUP SPREAD: 1.739	10:	0.477	0.112
MIN RADIUS: 0.223			
MAX RADIUS: 1.131			
MEAN RADIUS: 0.550			
# IN 1 IN DIAMETER: 5			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			

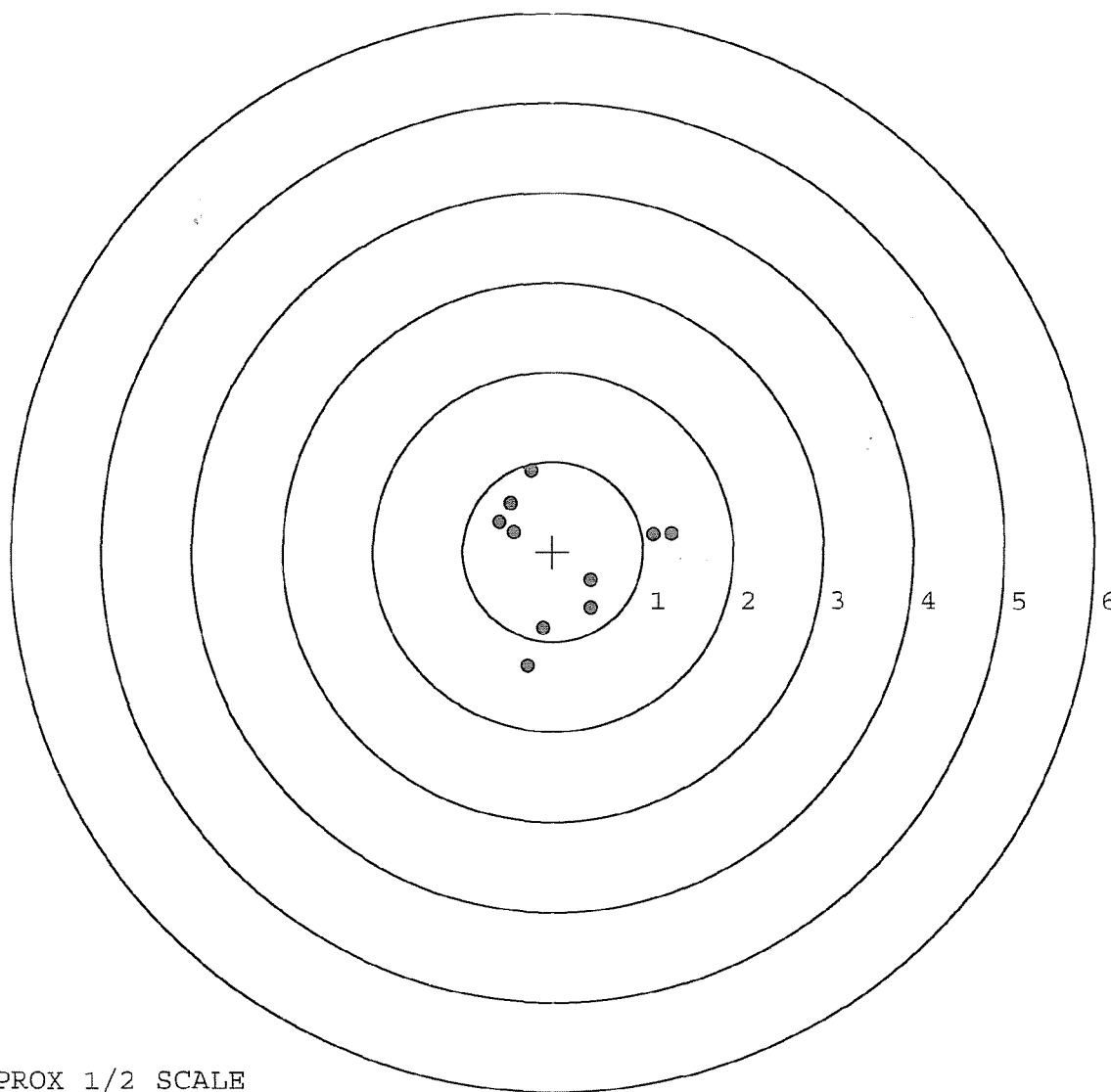


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635183. 0
TARGET NUMBER: 2
FILE DATE: 04/03/2007
FILE TIME: 15:10

POINT#	X	Y
1:	1.313	0.197
2:	1.111	0.187
3:	-0.241	0.896
4:	0.424	-0.320
5:	0.422	-0.632
6:	-0.107	-0.858
7:	-0.282	-1.274
8:	-0.437	0.213
9:	-0.594	0.321
10:	-0.467	0.532

X CENTROID: 0.114
Y CENTROID: -0.074
POA TO CENTROID: 0.136
HORZ SPREAD: 1.907
VERT SPREAD: 2.170
GROUP SPREAD: 2.170
MIN RADIUS: 0.396
MAX RADIUS: 1.264
MEAN RADIUS: 0.868
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635183. __0

TARGET NUMBER: 3

FILE DATE: 04/03/2007

FILE TIME: 15:10

POINT#	X	Y
1:	0.677	-0.930
2:	0.730	-0.745
3:	0.837	-0.506
4:	0.101	-0.573
5:	-0.081	-0.369
6:	-0.744	-0.869
7:	-0.843	-0.126
8:	-0.091	0.142
9:	0.264	0.163
10:	0.131	0.508

X CENTROID: 0.098

Y CENTROID: -0.330

POA TO CENTROID: 0.345

HORZ SPREAD: 1.680

VERT SPREAD: 1.438

GROUP SPREAD: 1.631

MIN RADIUS: 0.183

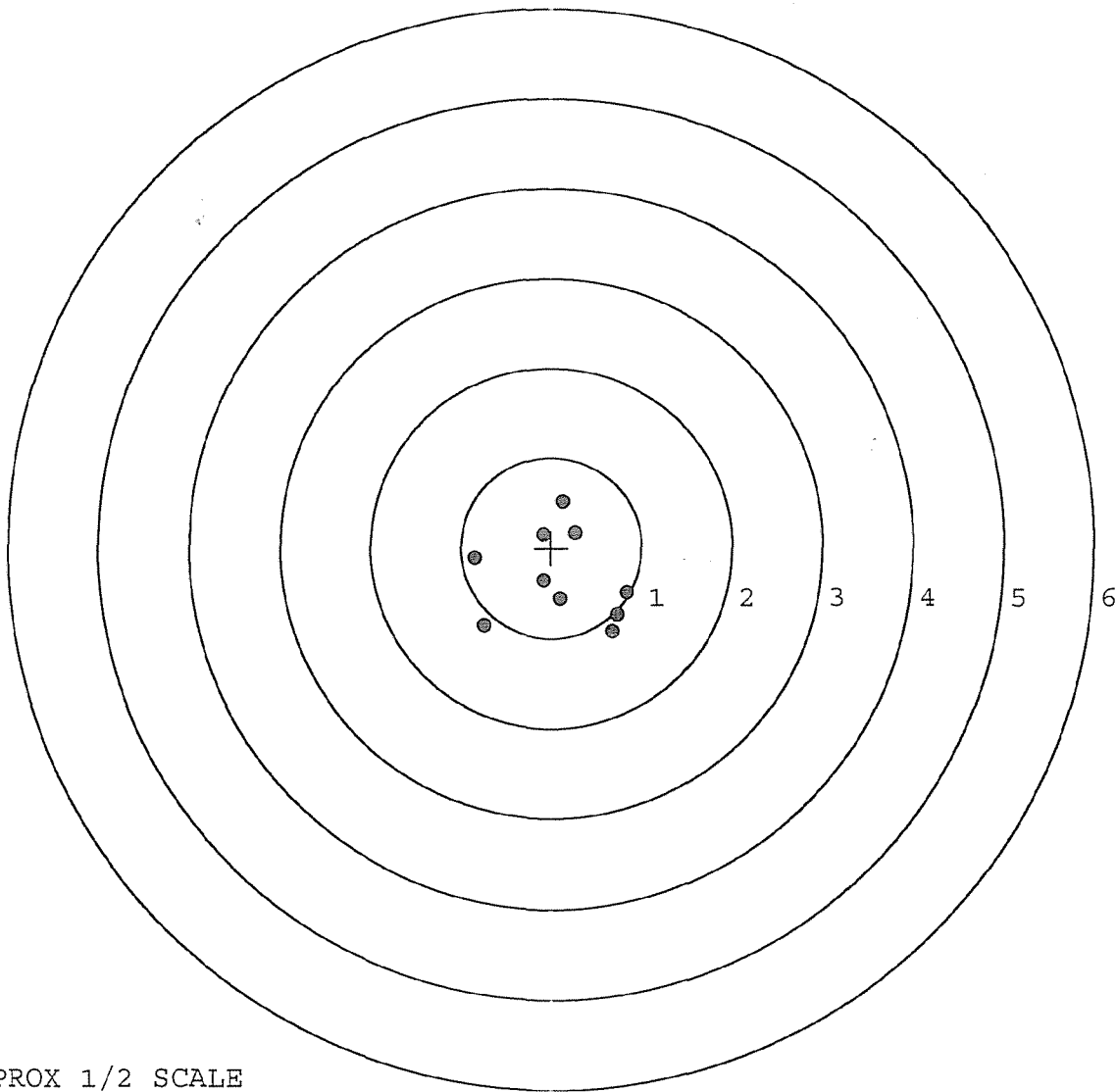
MAX RADIUS: 1.000

MEAN RADIUS: 0.661

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635183. __0

TARGET NUMBER: 4

FILE DATE: 04/03/2007

FILE TIME: 15:10

POINT#	X	Y
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1:	0.256	-0.751
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2:	0.677	0.061
----	-------	-------

3:	0.336	0.362
----	-------	-------

4:	-0.137	0.362
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5:	-0.396	-0.163
----	--------	--------

6:	-0.456	-0.431
----	--------	--------

7:	-0.947	0.035
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8:	0.098	-0.323
----	-------	--------

9:	-0.001	-0.102
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10:	-0.236	0.003
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X CENTROID: -0.081

Y CENTROID: -0.095

POA TO CENTROID: 0.124

HORZ SPREAD: 1.624

VERT SPREAD: 1.113

GROUP SPREAD: 1.624

MIN RADIUS: 0.080

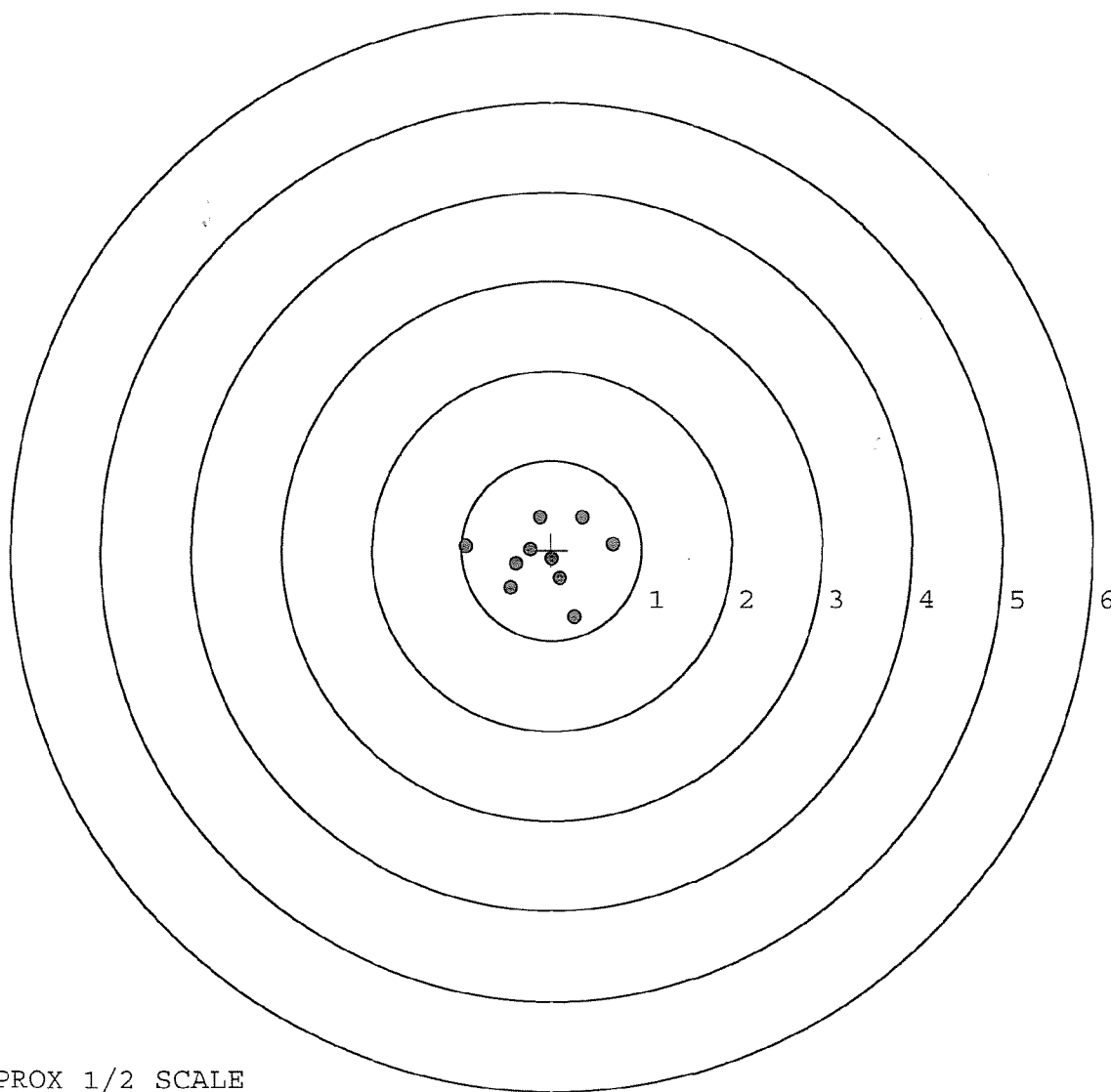
MAX RADIUS: 0.876

MEAN RADIUS: 0.485

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6635183. __0

TARGET NUMBER: 5

FILE DATE: 04/03/2007

FILE TIME: 15:10

POINT#	X	Y
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1:	0.488	-0.643
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2:	0.368	-0.774
----	-------	--------

3:	0.013	-0.533
----	-------	--------

4:	-0.228	-0.537
----	--------	--------

5:	0.145	-0.229
----	-------	--------

6:	0.307	0.277
----	-------	-------

7:	-0.113	0.427
----	--------	-------

8:	-0.074	0.065
----	--------	-------

9:	-0.313	0.159
----	--------	-------

10:	-1.046	-0.080
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X CENTROID: -0.045

Y CENTROID: -0.187

POA TO CENTROID: 0.192

HORZ SPREAD: 1.534

VERT SPREAD: 1.201

GROUP SPREAD: 1.634

MIN RADIUS: 0.195

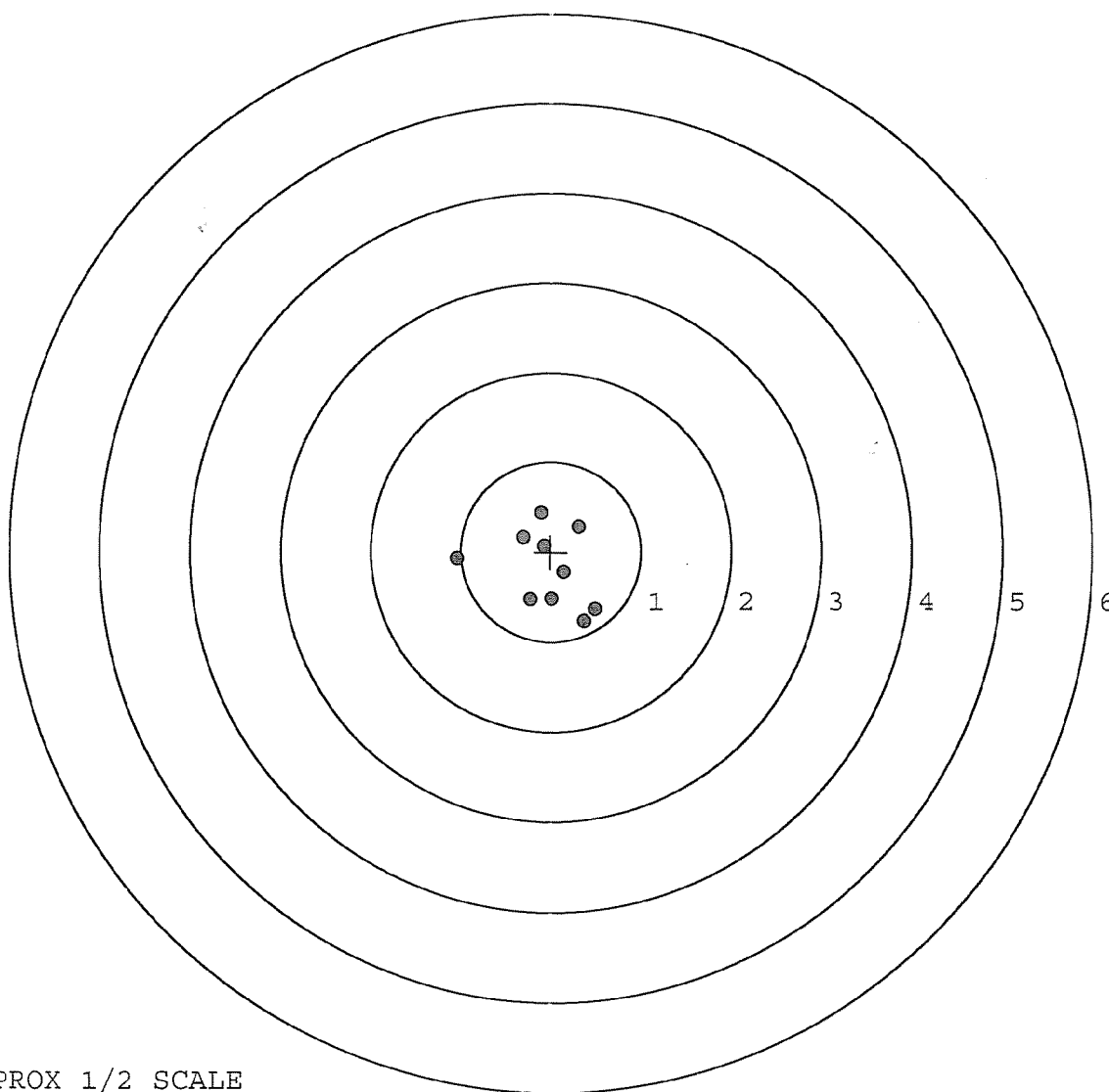
MAX RADIUS: 1.006

MEAN RADIUS: 0.526

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE