

G 646 1611

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

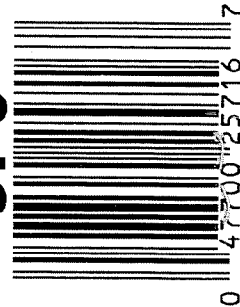
24"

CAPACITY

6

G6461611

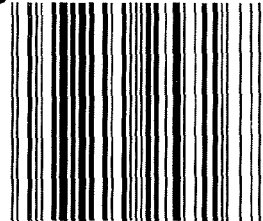
UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

UPC

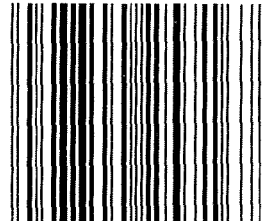


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M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

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0 47700 25716 7

SERIAL NO.



66461611

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G64606011

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			LD
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-12-05	W7
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	mtm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	mtm
	D) OIL FIRING PIN ASSEMBLY		10-10-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.2</u>	10/18/05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.0</u>	10/18/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	10/18/05	DA
	J) ASSEMBLE STOCK		10-10-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-19-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-13-05	AC
	M) IRON SIGHT ALIGNMENT		10-13-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-13-05	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/17/05	MGB
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/17/05	SGF
670	FINAL INSPECTION A) HEADSPACE		10-19-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.95</u> <u>2.79</u> <u>2.92</u> <u>2.95</u>	10-18-05	TRW
	C) FUNCTION		10-19-05	BC
690	PACK		10/27/05	DA

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)

SERIAL NO. _____

DATE 10-4-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.63	2.33		2.84	
PULL #2	2.68	2.27		2.84	
PULL #3	2.58	2.79		2.85	
PULL #4	2.58	2.69		2.87	
PULL #5	2.28	2.76		2.89	
TOTAL	12.75	12.84		14.29	
AVERAGE	2.55	2.56		2.85	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.36		
PULL #2	3.24	3.52		
PULL #3	3.35	3.44		
PULL #4	3.24	3.48		
PULL #5	3.13	3.52		
TOTAL	16.24	17.32		
AVERAGE	3.24	3.46		

	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	4.41	4.41		4.24
PULL #2	4.41	4.29		4.28
PULL #3	4.32	4.16		4.21
PULL #4	4.38	4.06		4.25
PULL #5	4.23	4.12		4.24
TOTAL	21.75	21.04		21.22
AVERAGE	4.35	4.20		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461611.__0
FILE DATE AND TIME: 10/17/2005 18:33

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:	-0.193
The Average Point of Impact of the Five Target Set:	0.206
The Average Mean Radius of the Five Target Set:	0.611
The Distance from POA to Centroid Target #1:	0.322
The Distance from Centroid Target #2 to Centroid Target #1:	0.495
The Distance from Centroid Target #3 to Centroid Target #1:	0.283
The Distance from Centroid Target #4 to Centroid Target #1:	0.283
The Distance from Centroid Target #5 to Centroid Target #1:	1.297

SERIAL NUMBER: G6461611. 0

TARGET NUMBER: 1

FILE DATE: 10/17/2005

FILE TIME: 18:33

X CENTROID: -0.313

Y CENTROID: 0.074

POA TO CENTROID: 0.322

HORZ SPREAD: 1.373

VERT SPREAD: 2.505

GROUP SPREAD: 2.505

MIN RADIUS: 0.096

MAX RADIUS: 1.328

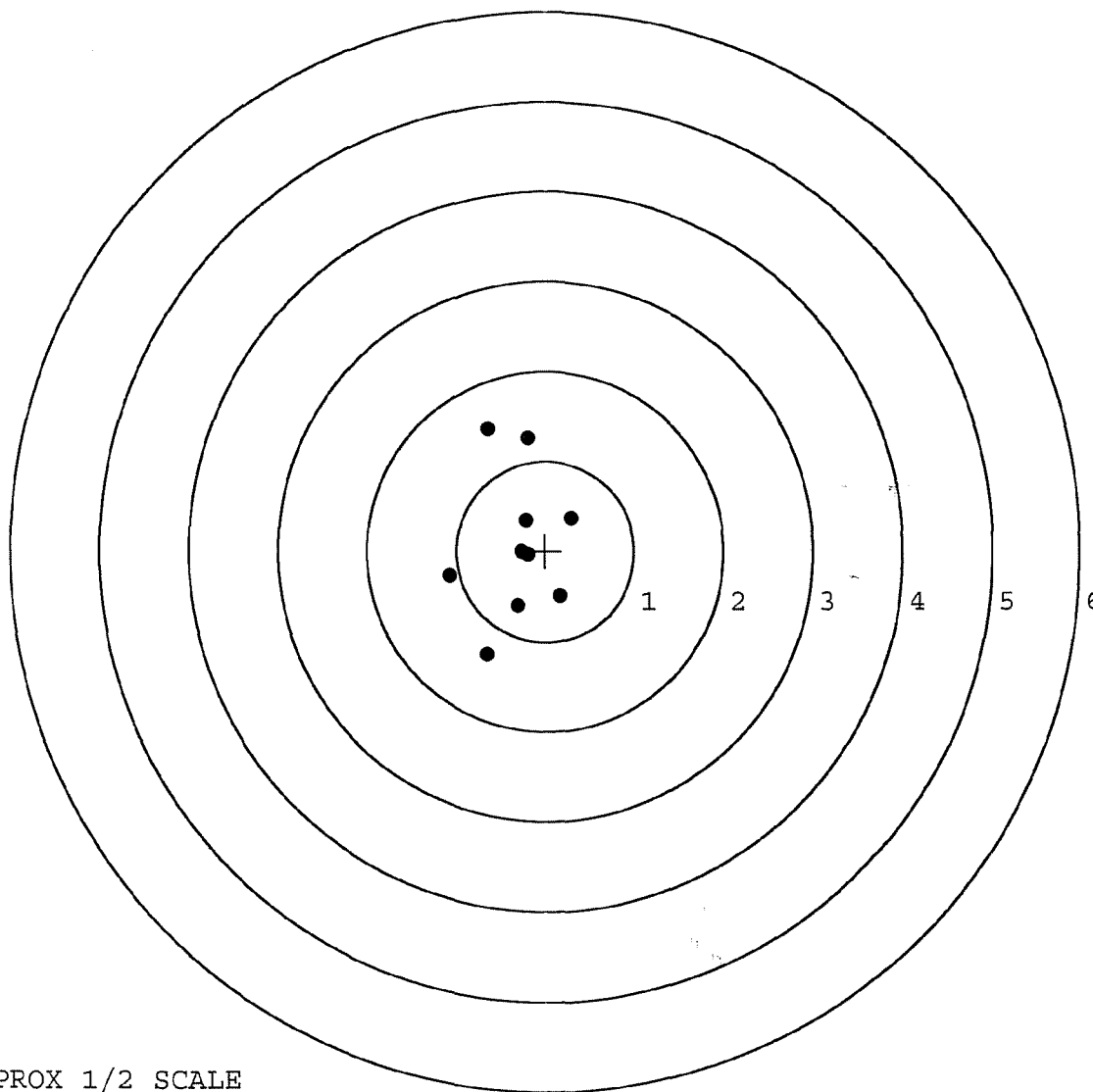
MEAN RADIUS: 0.725

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.293	0.364
2:	-0.196	1.255
3:	-0.645	1.360
4:	0.165	-0.498
5:	-0.320	-0.604
6:	-0.655	-1.145
7:	-1.080	-0.274
8:	-0.268	-0.011
9:	-0.200	-0.041
10:	-0.225	0.335



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461611. 0

TARGET NUMBER: 2

FILE DATE: 10/17/2005

FILE TIME: 18:33

X CENTROID: 0.135

Y CENTROID: -0.137

POA TO CENTROID: 0.192

HORZ SPREAD: 1.047

VERT SPREAD: 1.381

GROUP SPREAD: 1.419

MIN RADIUS: 0.048

MAX RADIUS: 0.837

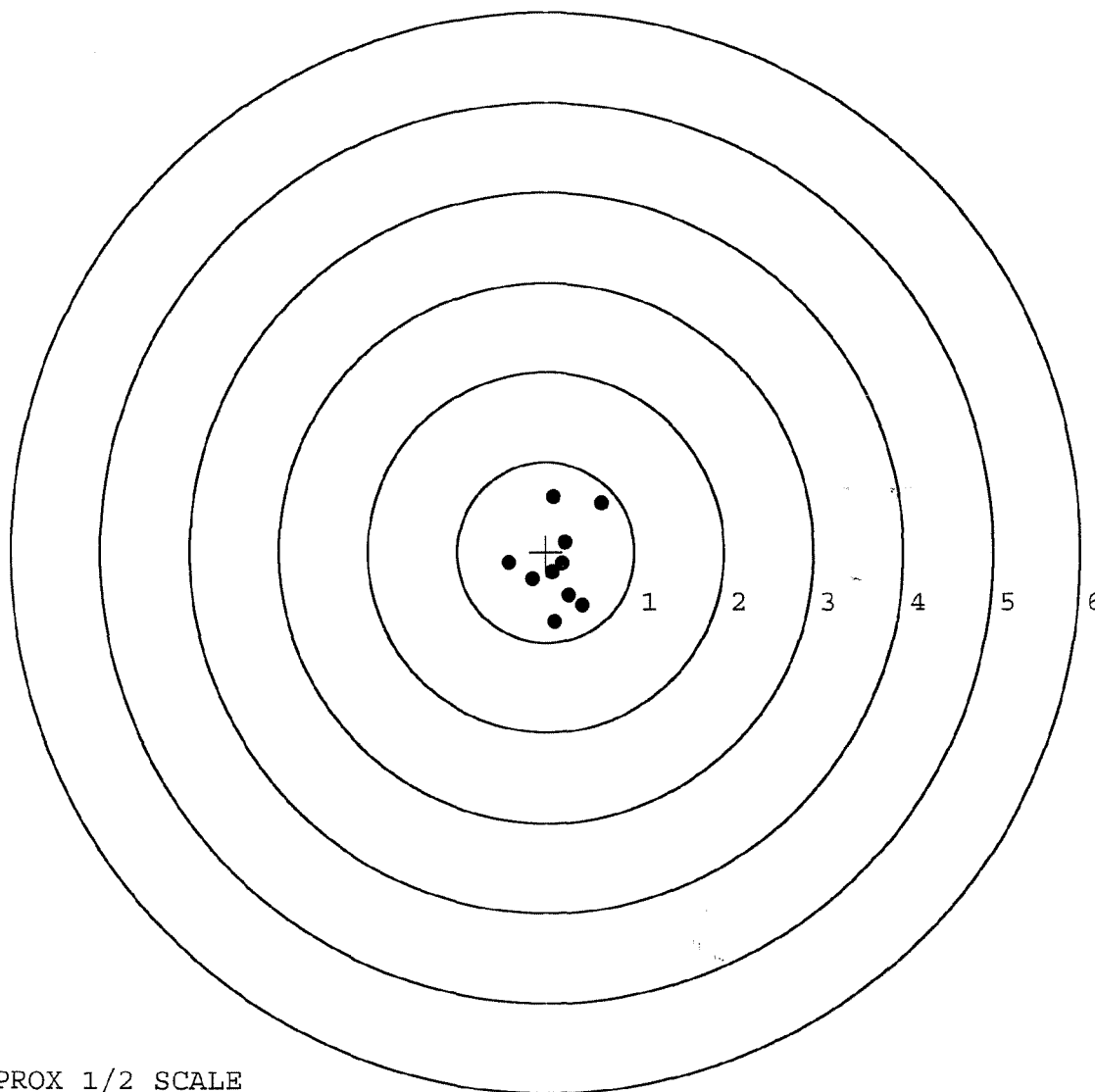
MEAN RADIUS: 0.442

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.214	0.108
2:	0.082	0.607
3:	0.621	0.545
4:	-0.426	-0.124
5:	-0.156	-0.302
6:	0.072	-0.229
7:	0.183	-0.129
8:	0.256	-0.475
9:	0.407	-0.592
10:	0.099	-0.774



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461611. 0

TARGET NUMBER: 3

FILE DATE: 10/17/2005

FILE TIME: 18:33

X CENTROID: -0.119

Y CENTROID: -0.131

POA TO CENTROID: 0.177

HORZ SPREAD: 2.062

VERT SPREAD: 1.812

GROUP SPREAD: 2.181

MIN RADIUS: 0.106

MAX RADIUS: 1.280

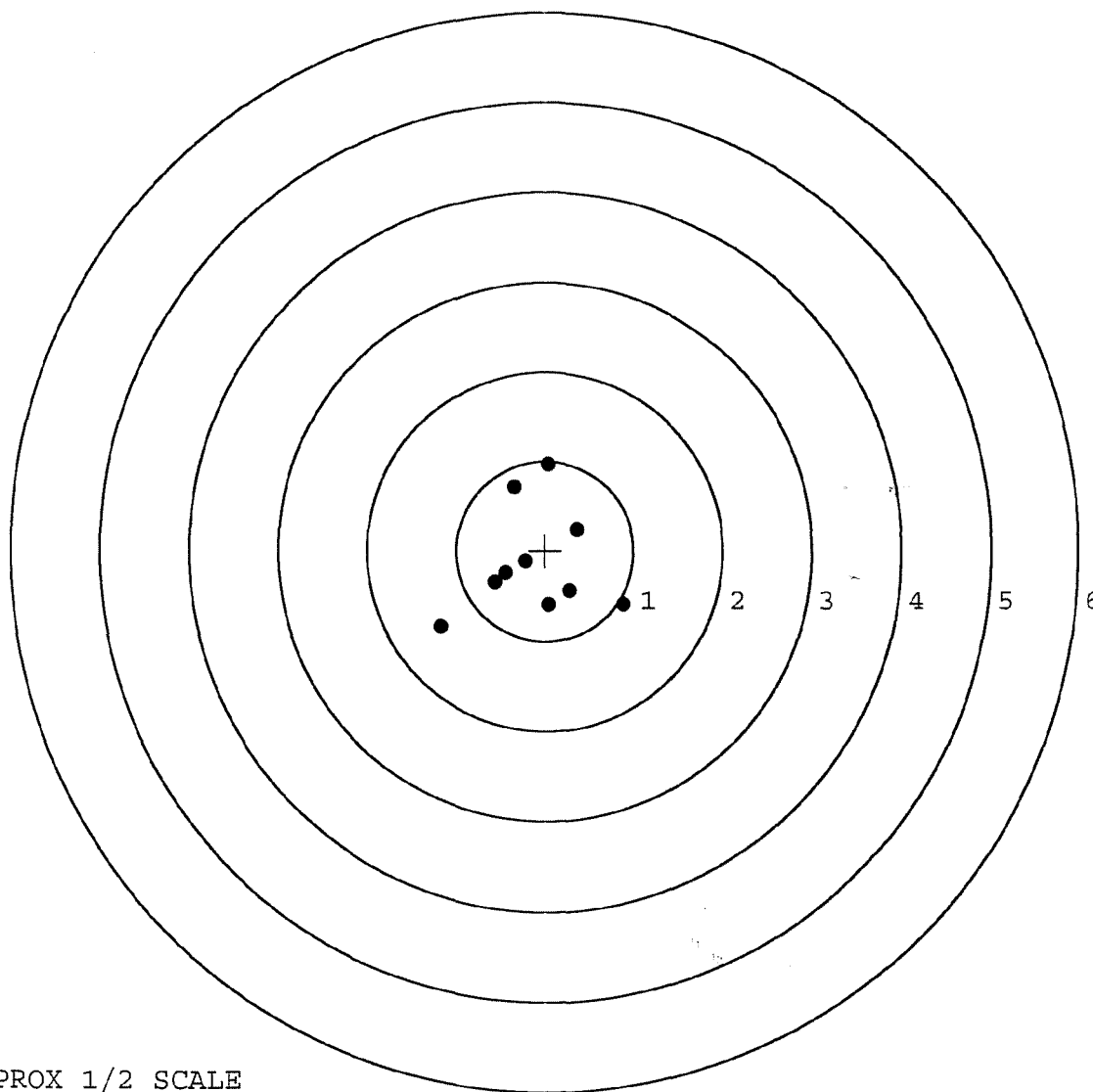
MEAN RADIUS: 0.693

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.356	0.239
2:	-0.224	-0.123
3:	-0.452	-0.251
4:	-0.569	-0.351
5:	0.036	-0.605
6:	0.278	-0.445
7:	0.883	-0.598
8:	-0.350	0.709
9:	0.035	0.964
10:	-1.179	-0.848

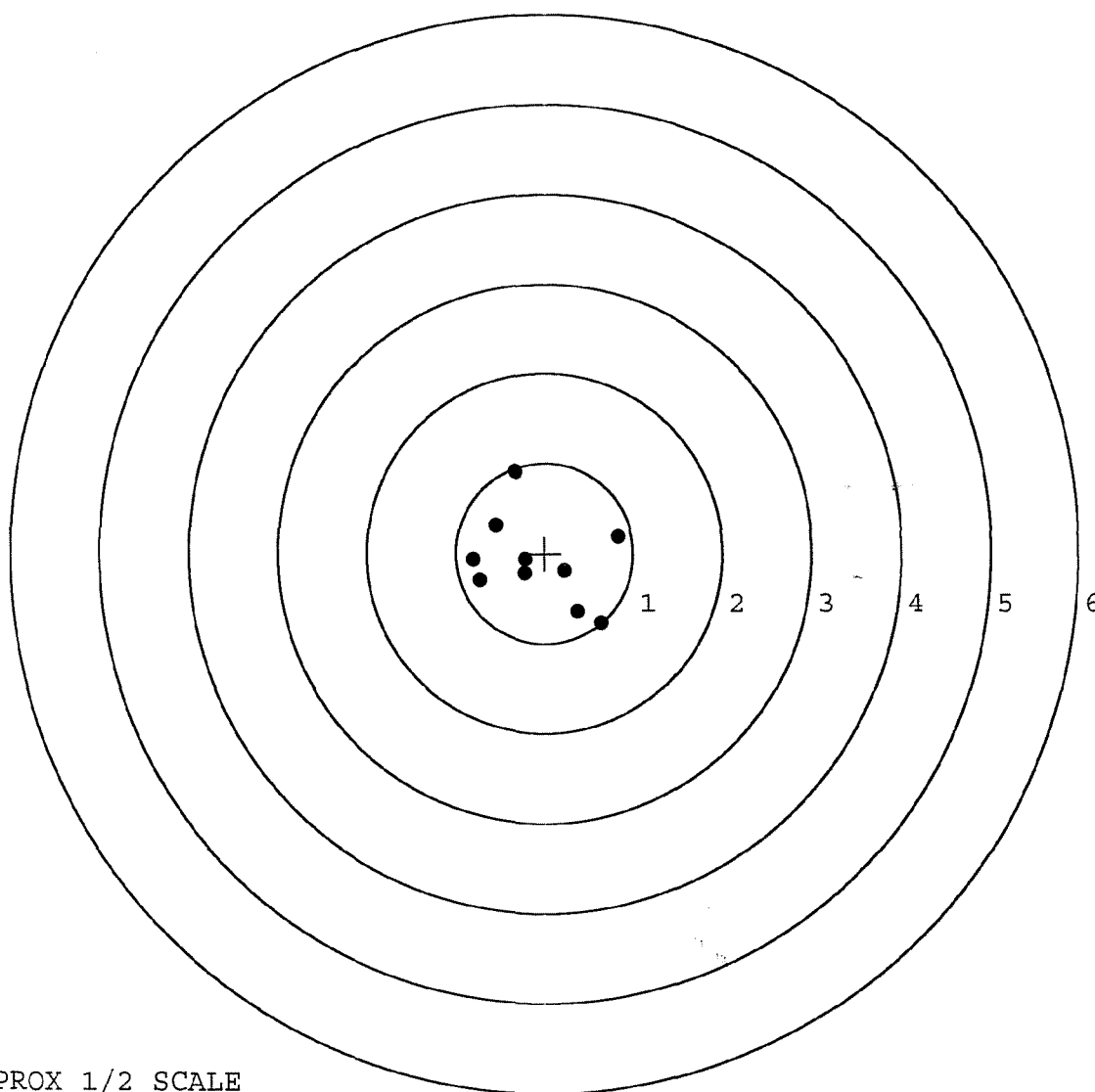


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461611. 0
TARGET NUMBER: 4
FILE DATE: 10/17/2005
FILE TIME: 18:33

X CENTROID: -0.082
Y CENTROID: -0.089
POA TO CENTROID: 0.120
HORZ SPREAD: 1.629
VERT SPREAD: 1.684
GROUP SPREAD: 1.945
MIN RADIUS: 0.140
MAX RADIUS: 1.026
MEAN RADIUS: 0.638
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.224	-0.194
2:	0.371	-0.649
3:	0.638	-0.779
4:	0.827	0.190
5:	-0.336	0.905
6:	-0.556	0.312
7:	-0.220	-0.071
8:	-0.231	-0.224
9:	-0.802	-0.074
10:	-0.731	-0.302



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461611. 0

TARGET NUMBER: 5

FILE DATE: 10/17/2005

FILE TIME: 18:33

X CENTROID: 0.739

Y CENTROID: -0.684

POA TO CENTROID: 1.007

HORZ SPREAD: 1.738

VERT SPREAD: 1.661

GROUP SPREAD: 1.832

MIN RADIUS: 0.179

MAX RADIUS: 0.987

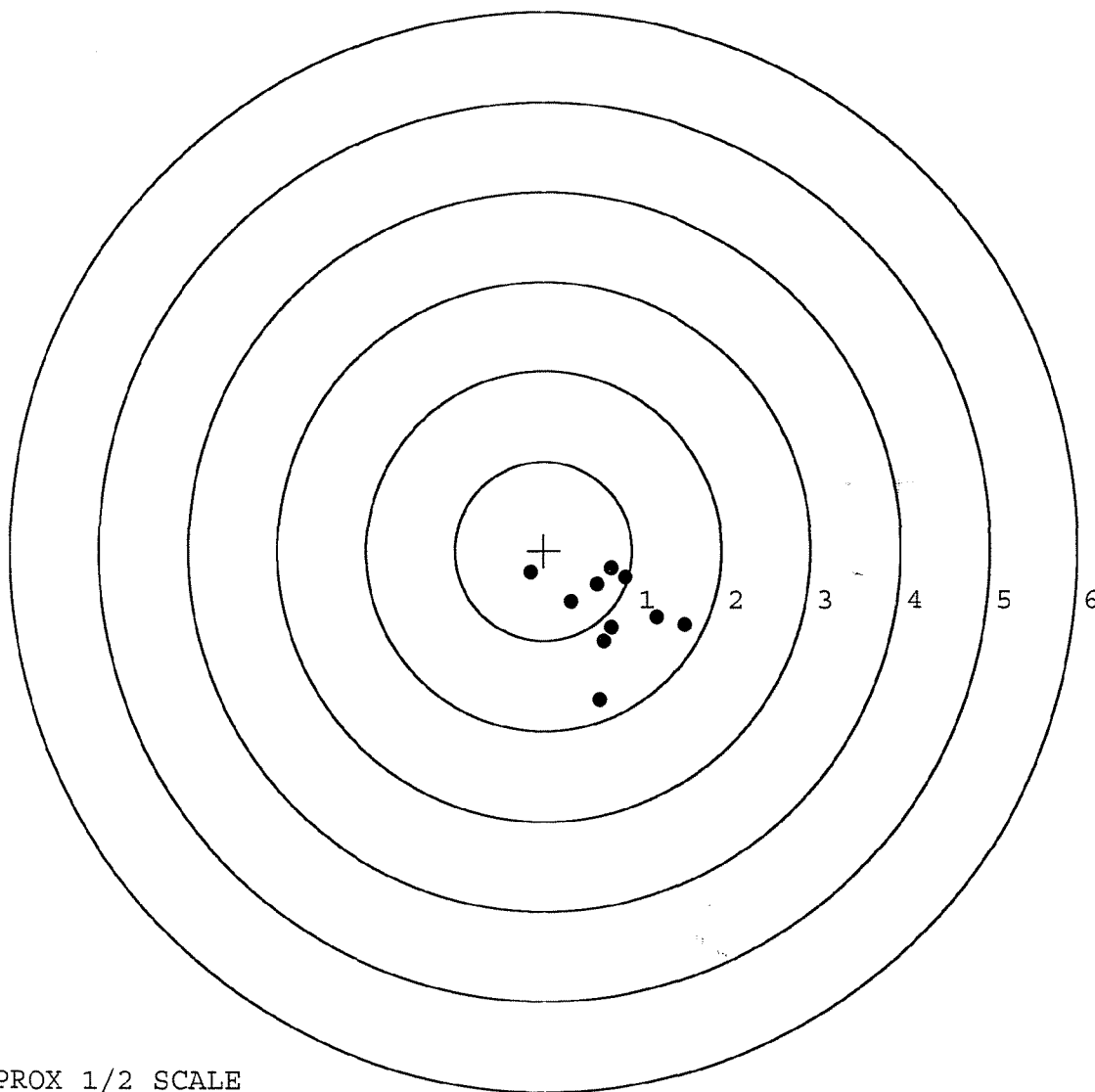
MEAN RADIUS: 0.557

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.148	-0.250
2:	0.605	-0.383
3:	0.308	-0.579
4:	0.762	-0.205
5:	0.921	-0.304
6:	1.276	-0.753
7:	1.590	-0.828
8:	0.764	-0.861
9:	0.676	-1.017
10:	0.633	-1.661



TARGET APPROX 1/2 SCALE