

G-646 1668

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



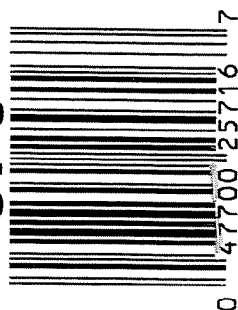
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461668

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461668

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RL
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTL
470	DIS-ASSEMBLE ACTION		9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	9/8/05	unns
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	unns
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/22/05	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/22/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/22/05	DA
	D) OIL FIRING PIN ASSEMBLY			
	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>6 1/6</u> <u>6 1/6</u> <u>6 1/6</u>	10-14-05	BC-
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 1/6</u> <u>2 1/6</u> <u>2 1/6</u>	10-14-05	BC-
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.026</u> <u>.025</u>	10-14-05	BC-
	J) ASSEMBLE STOCK		9-22-05	TR
	K) ASSEMBLE SWIVEL STUDS		10-14-05	BC-
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-3-05	TRW
	M) IRON SIGHT ALIGNMENT		10-3-05	TRW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-3-05	TRW
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-12-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-12-05	SH
670	FINAL INSPECTION A) HEADSPACE		10-14-05	BC-
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.34</u> <u>2.42</u> <u>2.45</u> <u>2.53</u>	10-12-05	BC-
	C) FUNCTION		10-15-05	BC-
690	PACK		10/31/05	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

TESTER

9/13/05

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.49		2.66	
PULL #2	2.47	2.53		2.54	
PULL #3	2.39	2.48		2.51	
PULL #4	2.48	2.52		2.62	
PULL #5	2.33	2.53		2.56	
TOTAL	12.13	12.55		12.85	
AVERAGE	2.43	2.51		2.57	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.86	2.86		
PULL #2	3.11	2.96		
PULL #3	2.97	2.92		
PULL #4	2.88	2.91		
PULL #5	2.99	2.91		
TOTAL	14.81	14.56		
AVERAGE	2.96	2.91		

	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	4.52	4.54		4.65
PULL #2	4.59	4.35		4.62
PULL #3	4.49	4.48		4.65
PULL #4	4.57	4.39		4.65
PULL #5	4.54	4.38		4.51
TOTAL	22.71	22.14		23.08
AVERAGE	4.54	4.43		4.62

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461668.__0
FILE DATE AND TIME: 10/12/2005 10:02

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.047
The Average Y Centroid of the Five Target Set:	-0.045
The Average Point of Impact of the Five Target Set:	0.065
The Average Mean Radius of the Five Target Set:	0.840
The Distance from POA to Centroid Target #1:	0.065
The Distance from Centroid Target #2 to Centroid Target #1:	0.161
The Distance from Centroid Target #3 to Centroid Target #1:	0.082
The Distance from Centroid Target #4 to Centroid Target #1:	0.041
The Distance from Centroid Target #5 to Centroid Target #1:	0.045

SERIAL NUMBER: G6461668. 0

TARGET NUMBER: 1

FILE DATE: 10/12/2005

FILE TIME: 10:02

X CENTROID: 0.027

Y CENTROID: -0.059

POA TO CENTROID: 0.065

HORZ SPREAD: 2.143

VERT SPREAD: 1.600

GROUP SPREAD: 2.511

MIN RADIUS: 0.310

MAX RADIUS: 1.507

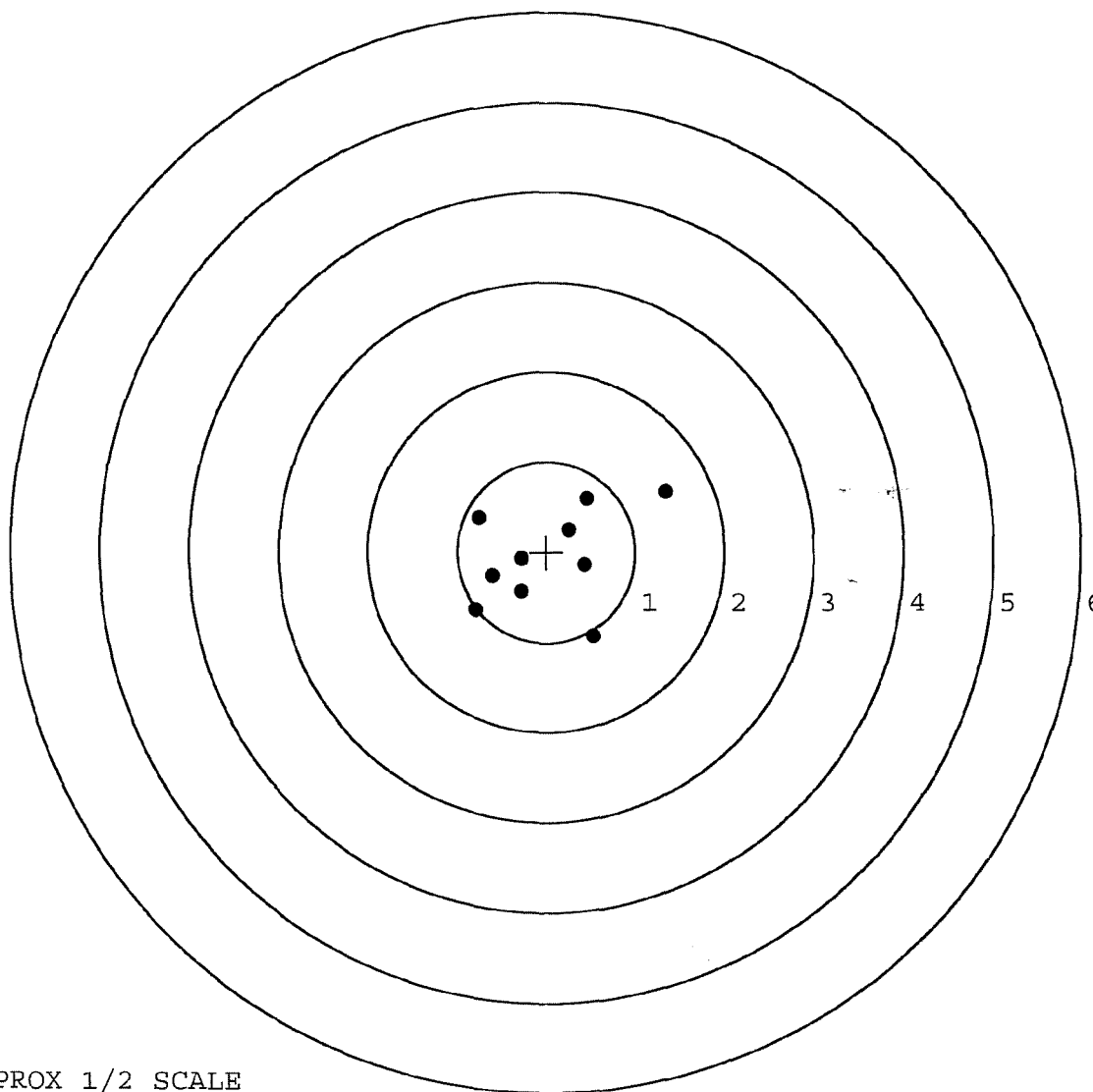
MEAN RADIUS: 0.747

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.531	-0.927
2:	0.428	-0.144
3:	1.344	0.673
4:	0.459	0.590
5:	0.252	0.246
6:	-0.283	-0.075
7:	-0.287	-0.436
8:	-0.618	-0.265
9:	-0.799	-0.635
10:	-0.761	0.380



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461668. 0

TARGET NUMBER: 2

FILE DATE: 10/12/2005

FILE TIME: 10:02

X CENTROID: 0.129

Y CENTROID: 0.065

POA TO CENTROID: 0.145

HORZ SPREAD: 1.746

VERT SPREAD: 2.422

GROUP SPREAD: 2.798

MIN RADIUS: 0.389

MAX RADIUS: 1.649

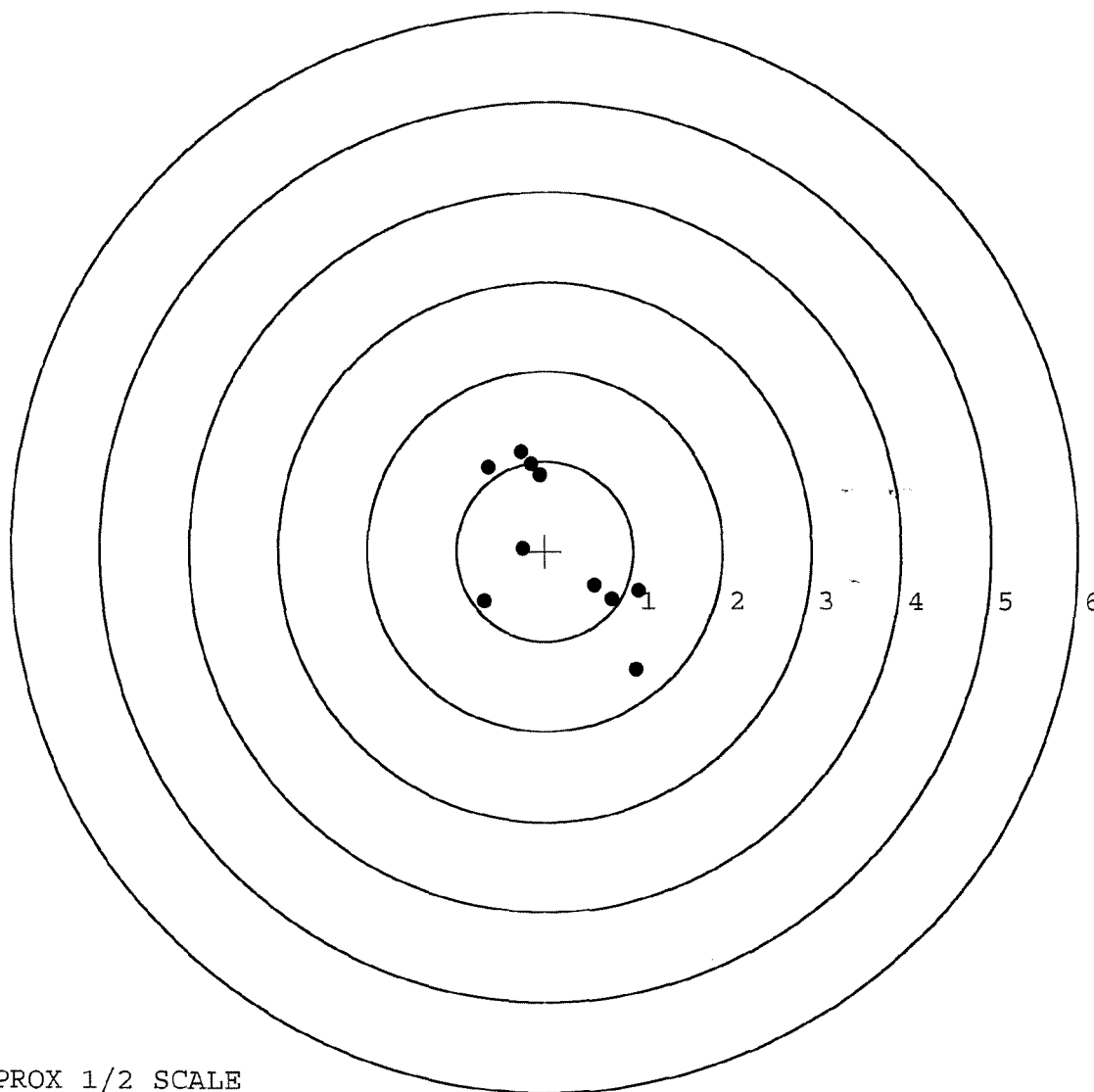
MEAN RADIUS: 0.964

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.028	-1.317
2:	1.058	-0.442
3:	0.750	-0.533
4:	0.554	-0.377
5:	-0.688	-0.563
6:	-0.258	0.027
7:	-0.064	0.851
8:	-0.281	1.105
9:	-0.641	0.929
10:	-0.166	0.972



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461668. 0

TARGET NUMBER: 3

FILE DATE: 10/12/2005

FILE TIME: 10:02

X CENTROID: -0.053

Y CENTROID: -0.077

POA TO CENTROID: 0.094

HORZ SPREAD: 1.854

VERT SPREAD: 2.890

GROUP SPREAD: 3.123

MIN RADIUS: 0.297

MAX RADIUS: 1.846

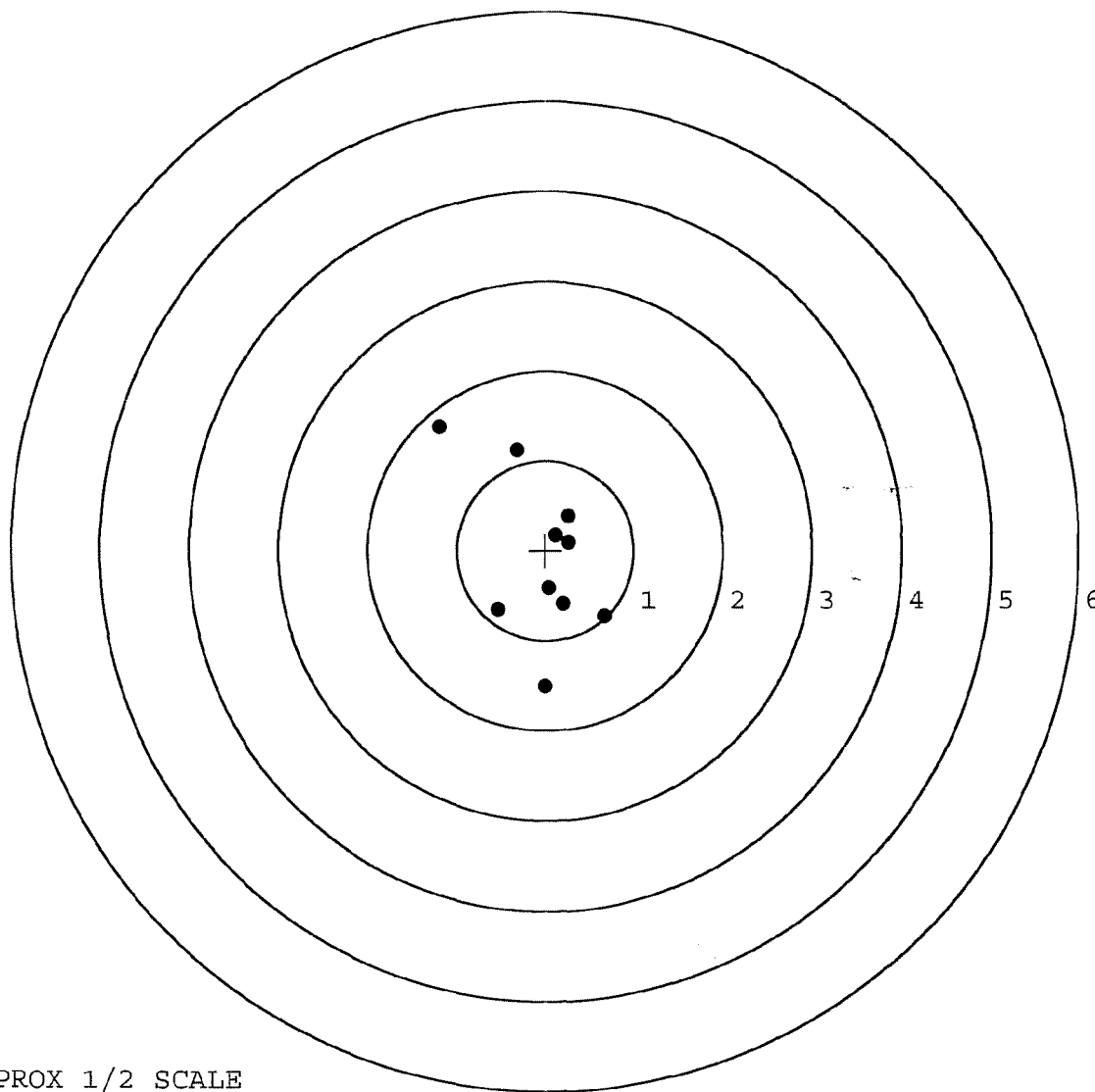
MEAN RADIUS: 0.839

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.007	-1.514
2:	-0.544	-0.655
3:	0.663	-0.730
4:	0.195	-0.598
5:	0.040	-0.423
6:	0.262	0.090
7:	0.259	0.393
8:	-0.324	1.119
9:	-1.191	1.376
10:	0.114	0.168



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461668. 0

TARGET NUMBER: 4

FILE DATE: 10/12/2005

FILE TIME: 10:02

X CENTROID: 0.063

Y CENTROID: -0.078

POA TO CENTROID: 0.100

HORZ SPREAD: 1.448

VERT SPREAD: 2.213

GROUP SPREAD: 2.309

MIN RADIUS: 0.230

MAX RADIUS: 1.418

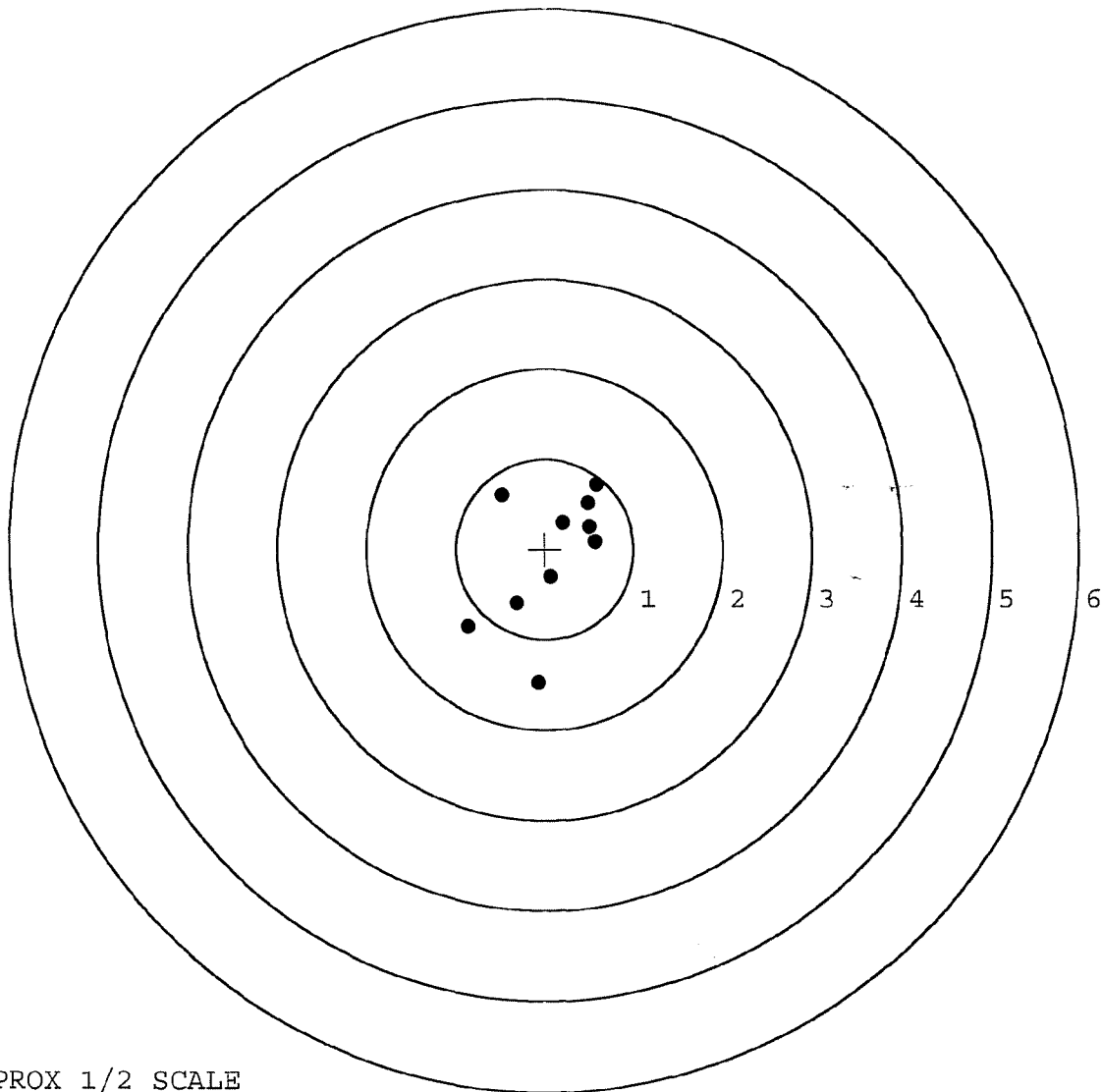
MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.079	-1.488
2:	-0.868	-0.865
3:	-0.322	-0.600
4:	0.066	-0.308
5:	-0.493	0.602
6:	0.580	0.725
7:	0.568	0.087
8:	0.496	0.257
9:	0.197	0.296
10:	0.483	0.518



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461668. 0

TARGET NUMBER: 5

FILE DATE: 10/12/2005

FILE TIME: 10:02

POINT#	X	Y
1:	1.074	-0.462
2:	1.172	0.646
3:	0.328	1.485
4:	0.211	0.494
5:	-0.810	-0.798
6:	-0.972	-1.728
7:	0.132	-0.371
8:	0.222	0.030
9:	-0.191	-0.024
10:	-0.483	-0.044

X CENTROID: 0.068

Y CENTROID: -0.077

POA TO CENTROID: 0.103

HORZ SPREAD: 2.144

VERT SPREAD: 3.213

GROUP SPREAD: 3.466

MIN RADIUS: 0.187

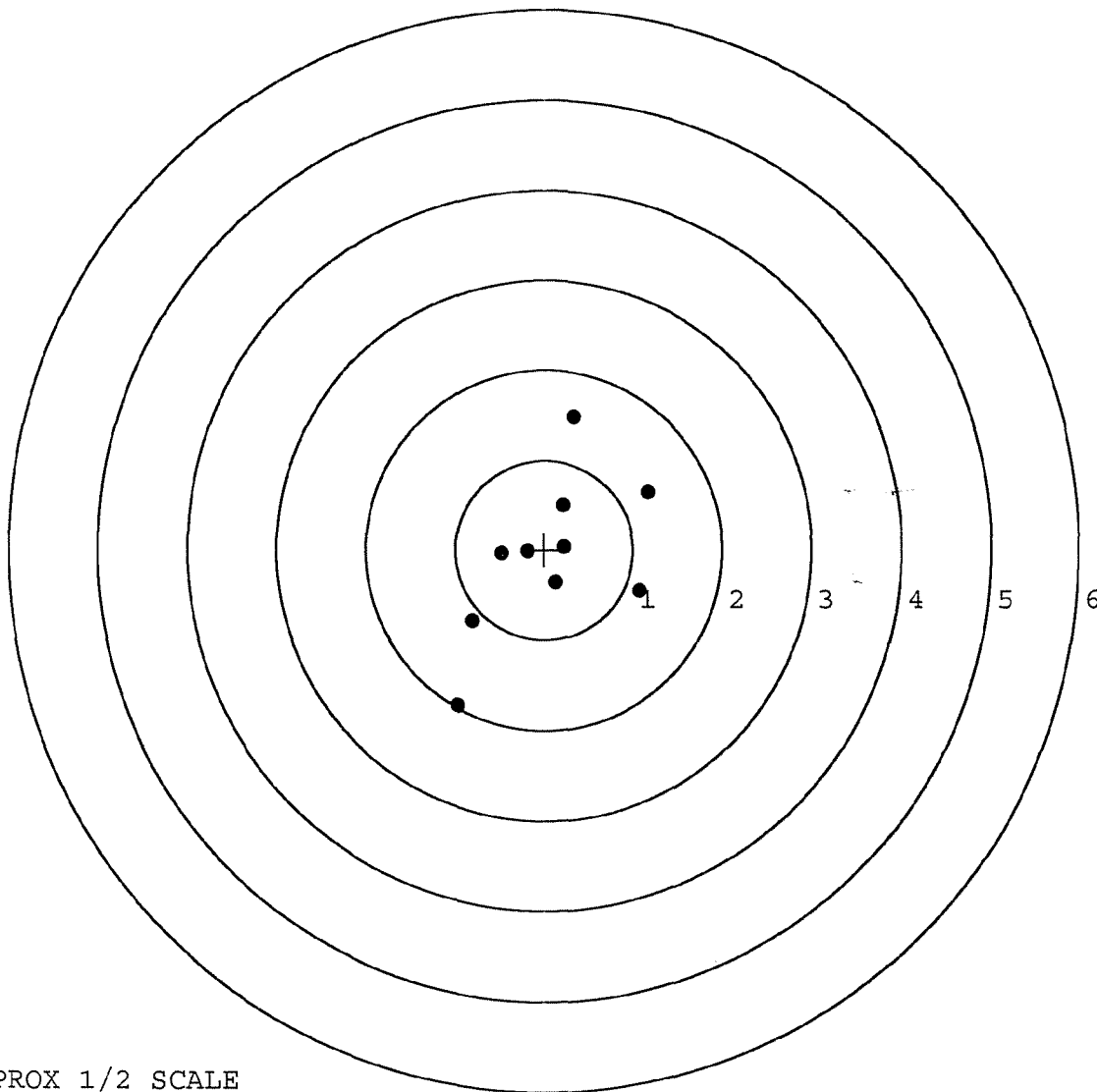
MAX RADIUS: 1.951

MEAN RADIUS: 0.896

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE