

G6590080

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

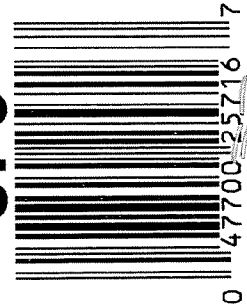
24"

CAPACITY

6

G6590080

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 # G6590080

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLC
420	ASSEMBLE ACTION		6/22/06	BLC
430	ASSEMBLE TO STOCK		6-23-06	R.P.
440	PROOF		6-23-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	6-23-06	TRW
470	DIS-ASSEMBLE ACTION	JUN 27 2006	6-26-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>OPD</u>	6-27-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-27-06	CW
510	DRILL AND TAP SIGHT HOLES		6-26-06	TRW
520	GOFF BLAST BBL / REC		6-28-06	PC
530 & 540	APPLY COATINGS (BARREL ACTION)		7/12	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-18-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-18-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-18-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		7-18-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	8-21-06	mtm

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	8-21-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.5</u> <u>3.0</u>	8-21-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-21-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.0235</u>	8-21-06	DA
	J) ASSEMBLE STOCK		7-18-06	RT
	K) ASSEMBLE SWIVEL STUDS		8-21-06	MTM
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-18-06	RT
	M) IRON SIGHT ALIGNMENT		7-18-06	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-18-06	RT
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	7-25-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-25-06	MTM
670	FINAL INSPECTION A) HEADSPACE		8-21-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.67</u> <u>2.70</u> <u>2.62</u> <u>2.55</u>	8-21-06	RP
	C) FUNCTION		8-21-06	MTM
690	PACK		11/14/06	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

7-17-04

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	245	231		256	
PULL #2	251	257		248	
PULL #3	259	255		260	
PULL #4	255	253		258	
PULL #5	231	246		261	
TOTAL	1241	1242		1283	
AVERAGE	248	248		256	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	316	296		
PULL #2	307	312		
PULL #3	302	306		
PULL #4	295	315		
PULL #5	289	308		
TOTAL	1509	1537		
AVERAGE	301	307		

	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	407	384		405
PULL #2	401	388		402
PULL #3	398	391		393
PULL #4	409	392		393
PULL #5	405	406		399
TOTAL	2020	1961		1992
AVERAGE	404	392		398

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590080.___0
FILE DATE AND TIME: 07/25/2006 05:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.035
The Average Y Centroid of the Five Target Set:	-0.041
The Average Point of Impact of the Five Target Set:	0.054
The Average Mean Radius of the Five Target Set:	0.698
The Distance from POA to Centroid Target #1:	0.356
The Distance from Centroid Target #2 to Centroid Target #1:	0.595
The Distance from Centroid Target #3 to Centroid Target #1:	0.504
The Distance from Centroid Target #4 to Centroid Target #1:	0.423
The Distance from Centroid Target #5 to Centroid Target #1:	0.317

SERIAL NUMBER: G6590080.___0

TARGET NUMBER: 1

FILE DATE: 07/25/2006

FILE TIME: 05:03

POINT#	X	Y
1:	0.091	0.654
2:	0.189	0.304
3:	0.633	0.452
4:	0.412	0.674
5:	0.343	1.139
6:	-0.574	-0.121
7:	-0.253	-0.309
8:	0.613	-0.624
9:	1.216	-0.633
10:	0.206	0.562

X CENTROID: 0.288

Y CENTROID: 0.210

POA TO CENTROID: 0.356

HORZ SPREAD: 1.790

VERT SPREAD: 1.772

GROUP SPREAD: 1.975

MIN RADIUS: 0.136

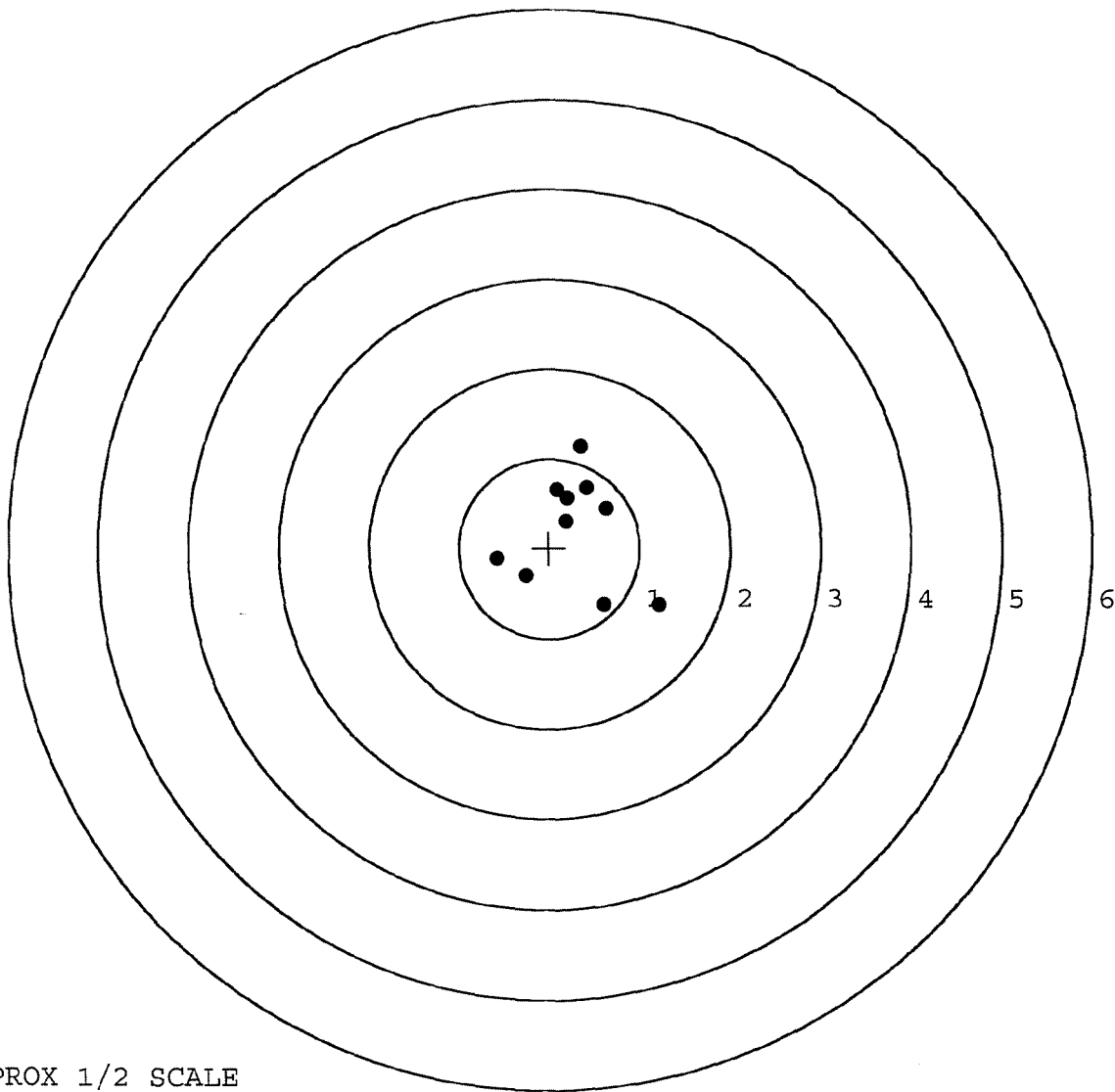
MAX RADIUS: 1.254

MEAN RADIUS: 0.664

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

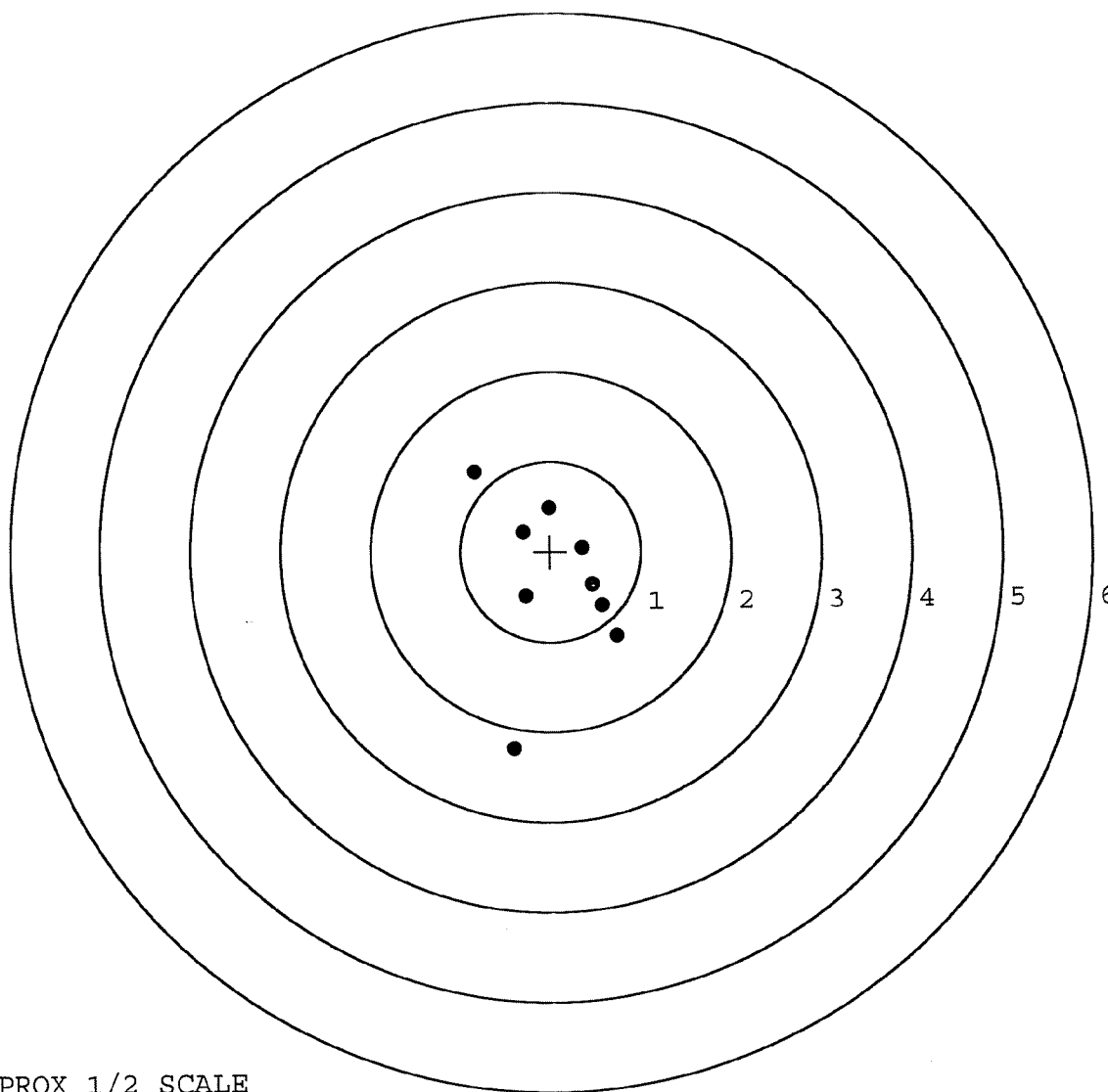


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590080. __0
TARGET NUMBER: 2
FILE DATE: 07/25/2006
FILE TIME: 05:03

POINT#	X	Y
1:	-0.839	0.891
2:	-0.301	0.214
3:	-0.280	-0.490
4:	-0.017	0.484
5:	0.354	0.043
6:	0.461	-0.362
7:	0.569	-0.597
8:	0.733	-0.934
9:	-0.414	-2.188

X CENTROID: 0.030
Y CENTROID: -0.327
POA TO CENTROID: 0.328
HORZ SPREAD: 1.572
VERT SPREAD: 3.079
GROUP SPREAD: 3.108
MIN RADIUS: 0.350
MAX RADIUS: 1.914
MEAN RADIUS: 0.851
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

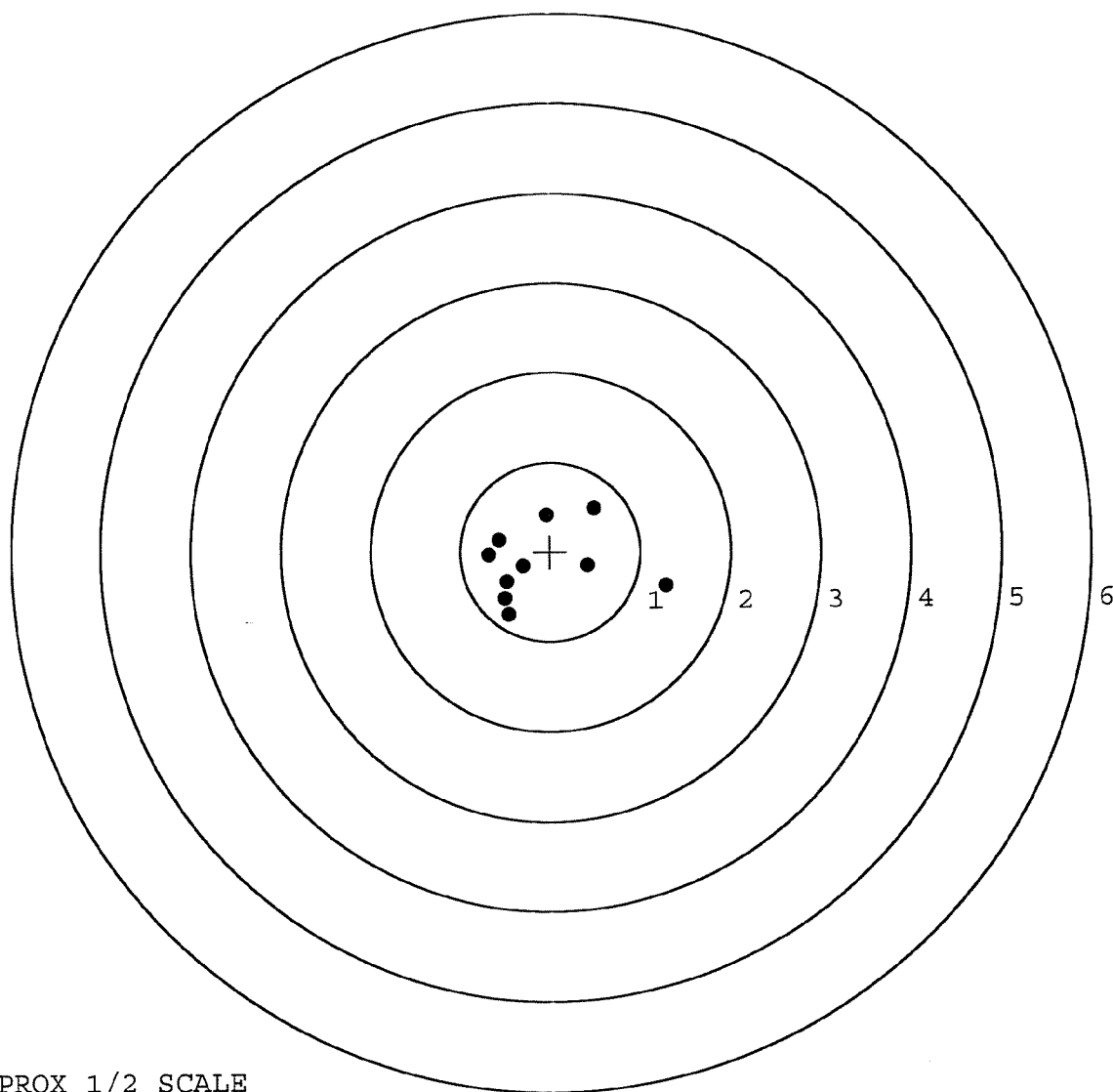


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590080. __0
TARGET NUMBER: 3
FILE DATE: 07/25/2006
FILE TIME: 05:03

X CENTROID: -0.086
Y CENTROID: -0.128
POA TO CENTROID: 0.155
HORZ SPREAD: 1.965
VERT SPREAD: 1.187
GROUP SPREAD: 1.996
MIN RADIUS: 0.219
MAX RADIUS: 1.394
MEAN RADIUS: 0.636
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.045	0.412
2:	0.490	0.483
3:	0.415	-0.160
4:	1.283	-0.390
5:	-0.572	0.137
6:	-0.682	-0.037
7:	-0.302	-0.161
8:	-0.481	-0.340
9:	-0.501	-0.525
10:	-0.464	-0.704

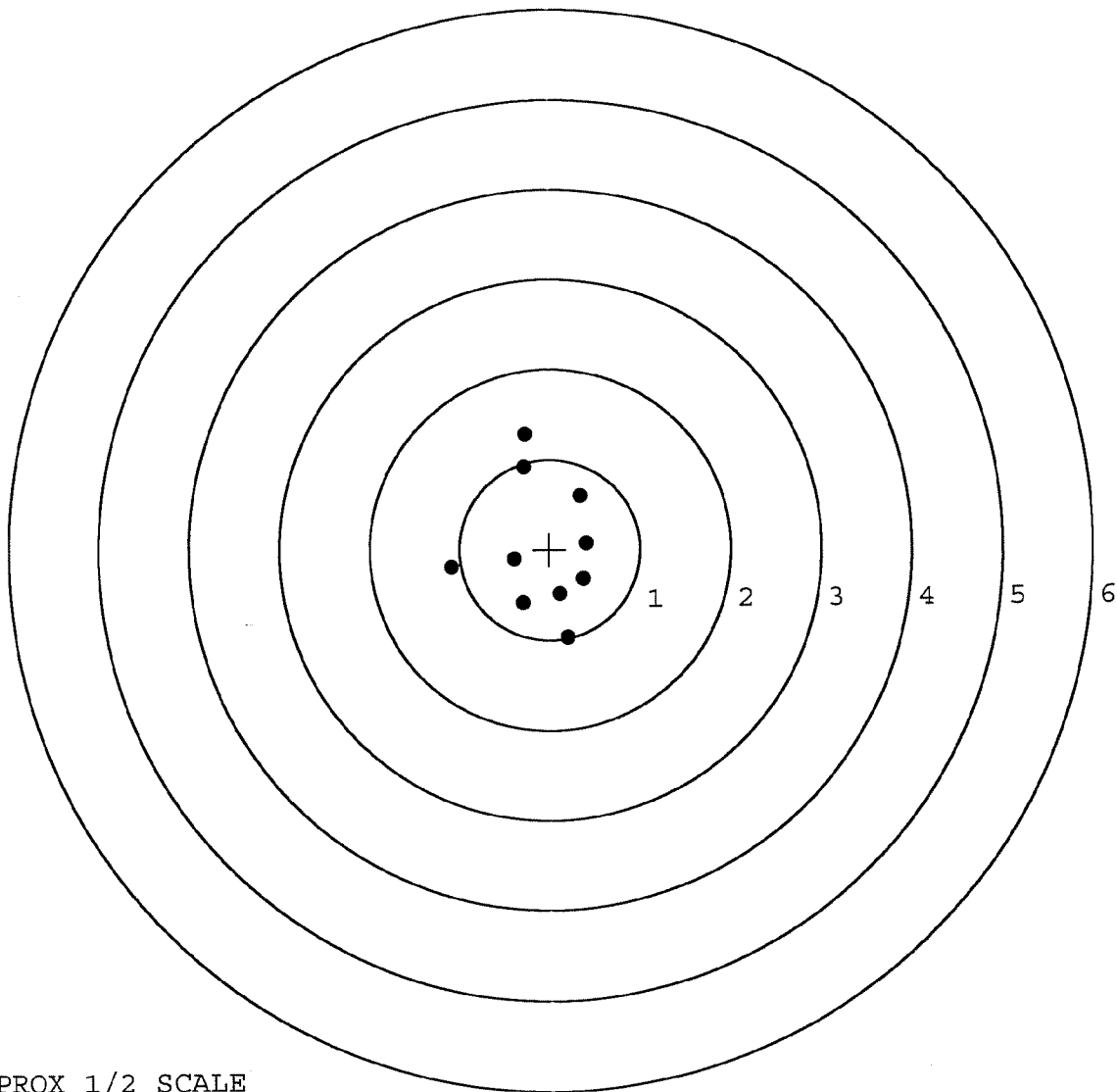


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590080. __0
TARGET NUMBER: 4
FILE DATE: 07/25/2006
FILE TIME: 05:03

X CENTROID: -0.087
Y CENTROID: 0.015
POA TO CENTROID: 0.089
HORZ SPREAD: 1.500
VERT SPREAD: 2.262
GROUP SPREAD: 2.312
MIN RADIUS: 0.328
MAX RADIUS: 1.280
MEAN RADIUS: 0.759
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.284	0.918
2:	-0.271	1.282
3:	0.340	0.595
4:	0.413	0.068
5:	0.378	-0.329
6:	0.118	-0.495
7:	0.206	-0.980
8:	-0.297	-0.599
9:	-0.391	-0.110
10:	-1.087	-0.200



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590080. __0

TARGET NUMBER: 5

FILE DATE: 07/25/2006

FILE TIME: 05:03

POINT#	X	Y
1:	0.015	1.046
2:	0.111	0.821
3:	-0.063	0.549
4:	-0.141	0.156
5:	0.020	-0.047
6:	0.437	-0.003
7:	0.396	-0.304
8:	-0.163	-1.012
9:	-0.443	-0.950
10:	0.134	-0.015

X CENTROID: 0.030

Y CENTROID: 0.024

POA TO CENTROID: 0.039

HORZ SPREAD: 0.880

VERT SPREAD: 2.058

GROUP SPREAD: 2.048

MIN RADIUS: 0.072

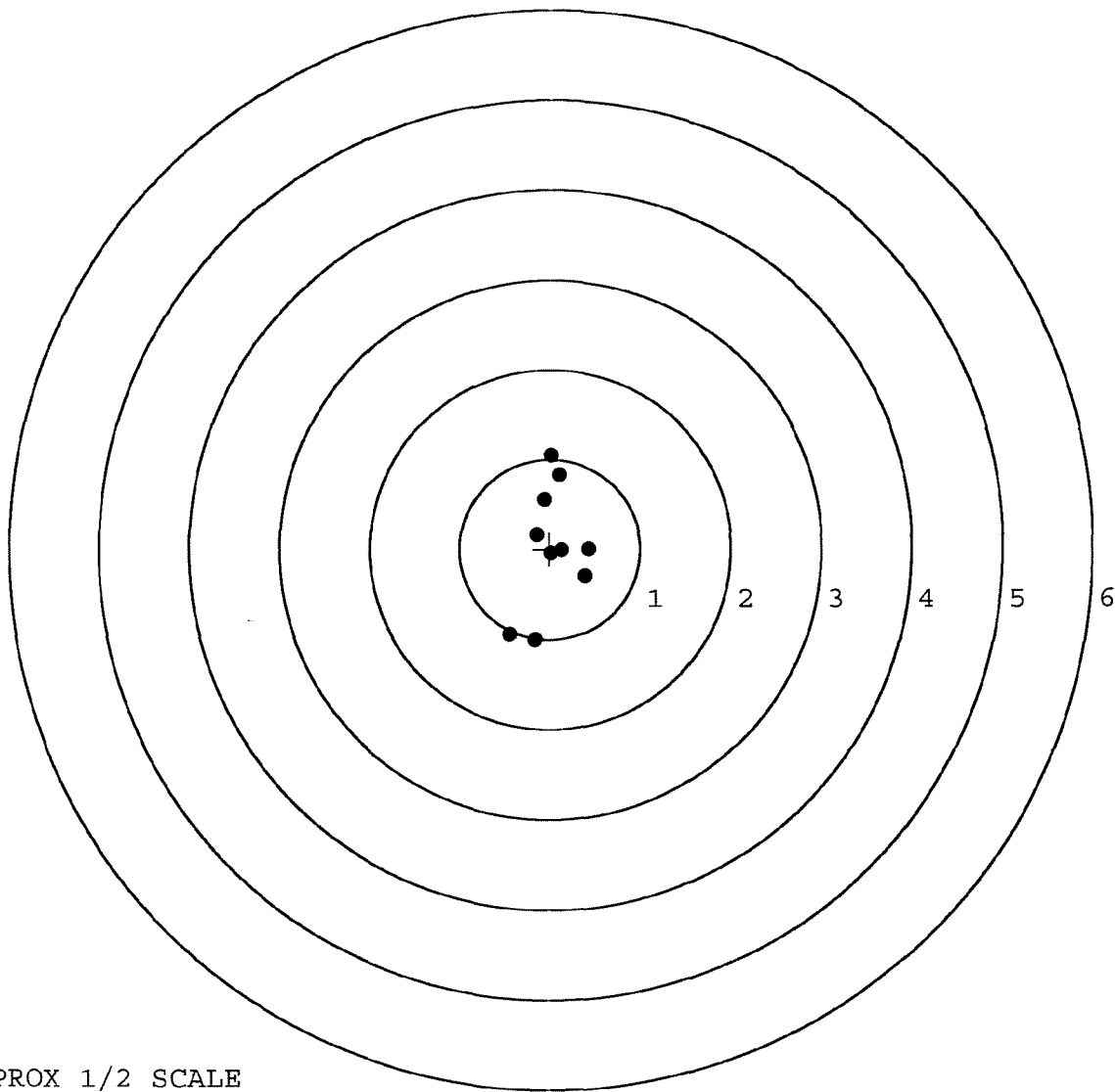
MAX RADIUS: 1.083

MEAN RADIUS: 0.579

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE