

G659 0083

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



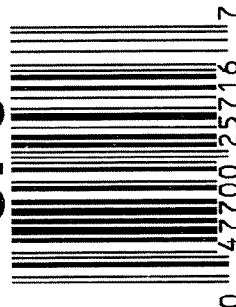
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590083

UPC



DD FORM

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590083

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	RLG
420	ASSEMBLE ACTION		6/22/06	RLG
430	ASSEMBLE TO STOCK		6-23-06	R.P.
440	PROOF		6-23-06	TRLW
460	CHECK HEADSPACE	MAGNA-FLUX	6-23-06	TRLW
470	DIS-ASSEMBLE ACTION	INSPECTED	6-26-06	RLG
480	MAGNAFLUX BBL ACTION	JUN 27 2006		
490	MAGNAFLUX BOLT	OPERATOR <u>CPD</u>	6-27-06	APD
500	ROLLMARK CALIBER		6-27-06	CLW
510	DRILL AND TAP SIGHT HOLES		6-26-06	TRLW
520	GOFF BLAST BBL / REC		6-28-06	RLG
530 & 540	APPLY COATINGS (BARREL ACTION)		7/12	RLG
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-19-06	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-19-06	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-19-06	RTL
	D) OIL FIRING PIN ASSEMBLY		7-19-06	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>6.5</u> <u>6.0</u>	8-22-06	NA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>4.5</u>	8-22-06	NA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	8-22-06	NA
	J) ASSEMBLE STOCK		7-16-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-31-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-19-06	BLG
	M) IRON SIGHT ALIGNMENT		7-19-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-19-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	7-21-06	Wm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-21-06	Wm
670	FINAL INSPECTION A) HEADSPACE		8-31-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.77</u> <u>2.77</u> <u>2.84</u> <u>2.81</u>	8-22-06	RP
	C) FUNCTION		8-31-06	RTZ
690	PACK		11/15/06	NA

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 7-18-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.59		2.38	
PULL #2	2.40	2.54		2.44	
PULL #3	2.42	2.39		2.51	
PULL #4	2.42	2.35		2.62	
PULL #5	2.36	2.45		2.50	
TOTAL	12.11	12.32		12.45	
AVERAGE	2.42	2.46		2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	2.90		
PULL #2	3.16	2.81		
PULL #3	3.07	3.23		
PULL #4	3.14	3.21		
PULL #5	2.97	3.11		
TOTAL	15.52	15.26		
AVERAGE	3.10	3.05		

	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	4.03	4.03		4.02
PULL #2	4.00	3.97		4.13
PULL #3	4.01	4.17		4.09
PULL #4	4.10	4.14		4.27
PULL #5	4.07	3.94		4.09
TOTAL	20.21	20.25		20.60
AVERAGE	4.04	4.05		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590083.__0
FILE DATE AND TIME: 07/21/2006 16:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.026
The Average Y Centroid of the Five Target Set:	0.013
The Average Point of Impact of the Five Target Set:	0.029
The Average Mean Radius of the Five Target Set:	0.784
The Distance from POA to Centroid Target #1:	0.257
The Distance from Centroid Target #2 to Centroid Target #1:	0.309
The Distance from Centroid Target #3 to Centroid Target #1:	0.831
The Distance from Centroid Target #4 to Centroid Target #1:	0.187
The Distance from Centroid Target #5 to Centroid Target #1:	0.188

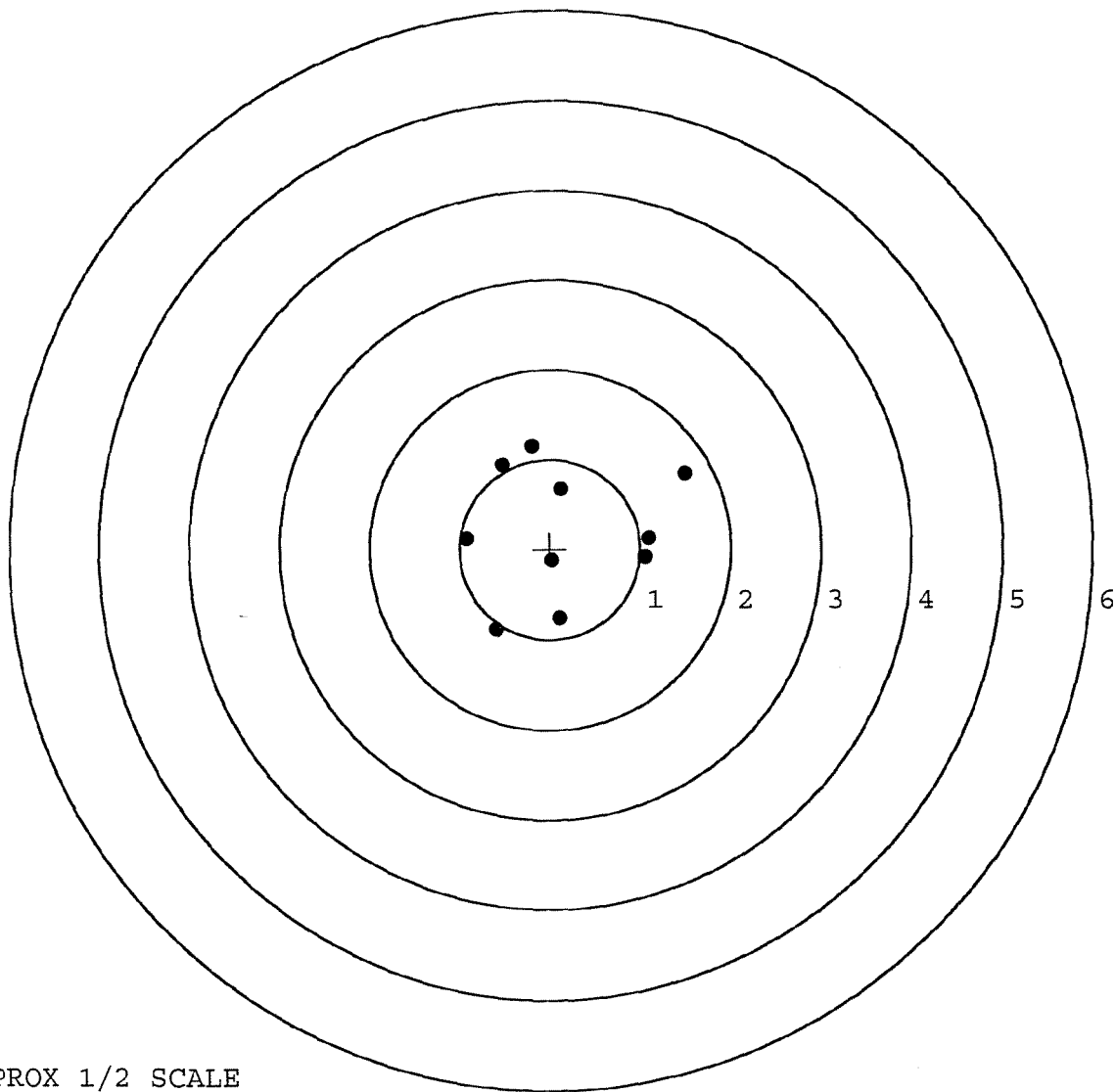
SERIAL NUMBER: G6590083. __0

TARGET NUMBER: 1

FILE DATE: 07/21/2006

FILE TIME: 16:55

		POINT#	X	Y
X CENTROID:	0.165	1:	-0.529	0.939
Y CENTROID:	0.197	2:	-0.211	1.151
POA TO CENTROID:	0.257	3:	0.115	0.671
HORZ SPREAD:	2.418	4:	-0.926	0.118
VERT SPREAD:	2.051	5:	1.492	0.851
GROUP SPREAD:	2.718	6:	1.095	0.129
MIN RADIUS:	0.359	7:	1.058	-0.084
MAX RADIUS:	1.479	8:	0.023	-0.133
MEAN RADIUS:	0.962	9:	0.119	-0.770
# IN 1 IN DIAMETER:	2	10:	-0.587	-0.900
# IN 2 IN DIAMETER:	5			
# in 3 IN DIAMETER:	10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590083.___0

TARGET NUMBER: 2

FILE DATE: 07/21/2006

FILE TIME: 16:55

POINT#	X	Y
1:	-0.484	-0.281
2:	-0.815	-0.217
3:	-0.880	0.148
4:	-1.244	0.262
5:	0.541	0.323
6:	0.865	-0.125
7:	1.292	0.713
8:	-0.076	1.066
9:	-0.409	1.220
10:	-0.029	-0.038

X CENTROID: -0.124

Y CENTROID: 0.307

POA TO CENTROID: 0.331

HORZ SPREAD: 2.536

VERT SPREAD: 1.501

GROUP SPREAD: 2.576

MIN RADIUS: 0.358

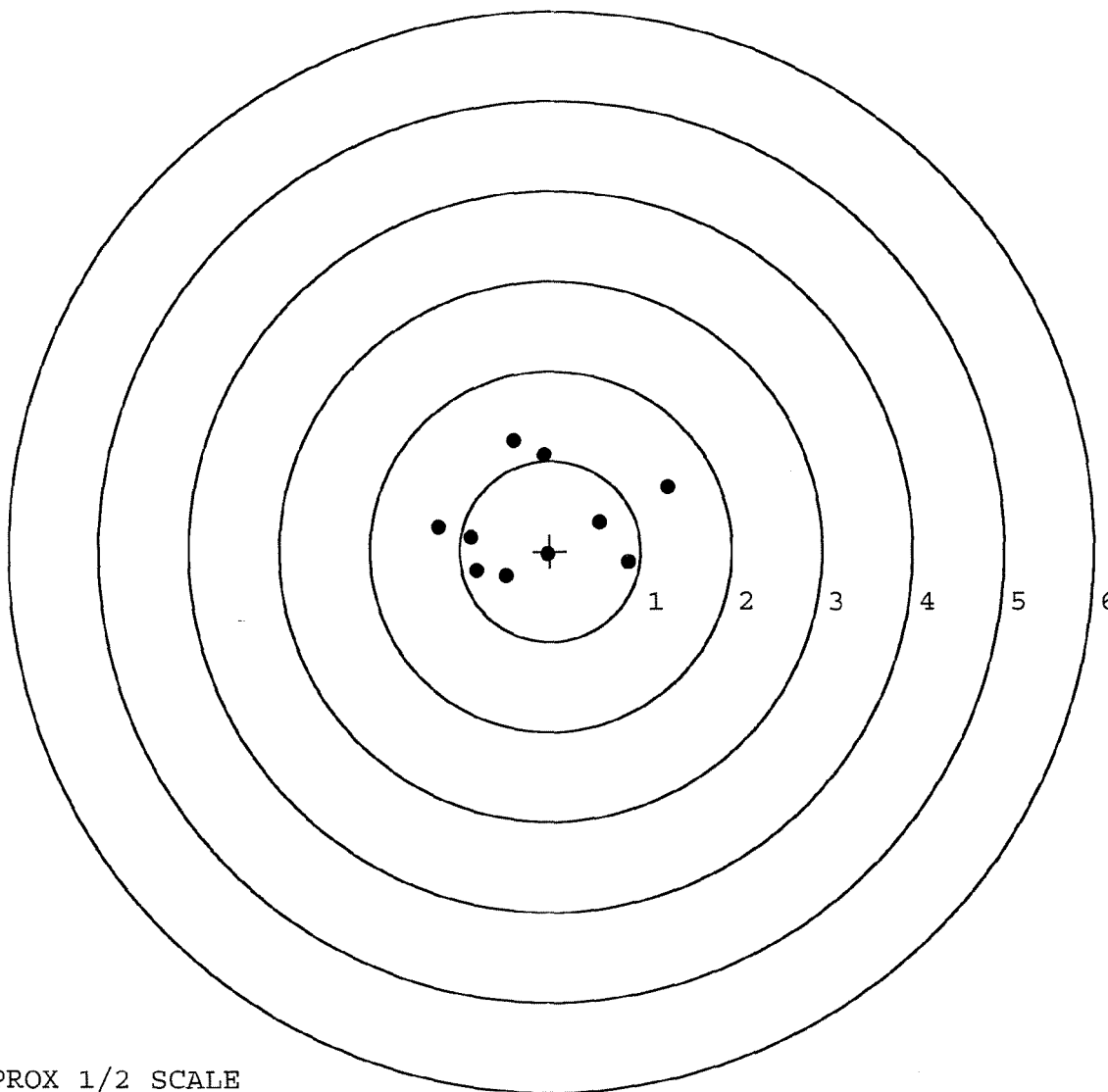
MAX RADIUS: 1.473

MEAN RADIUS: 0.874

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

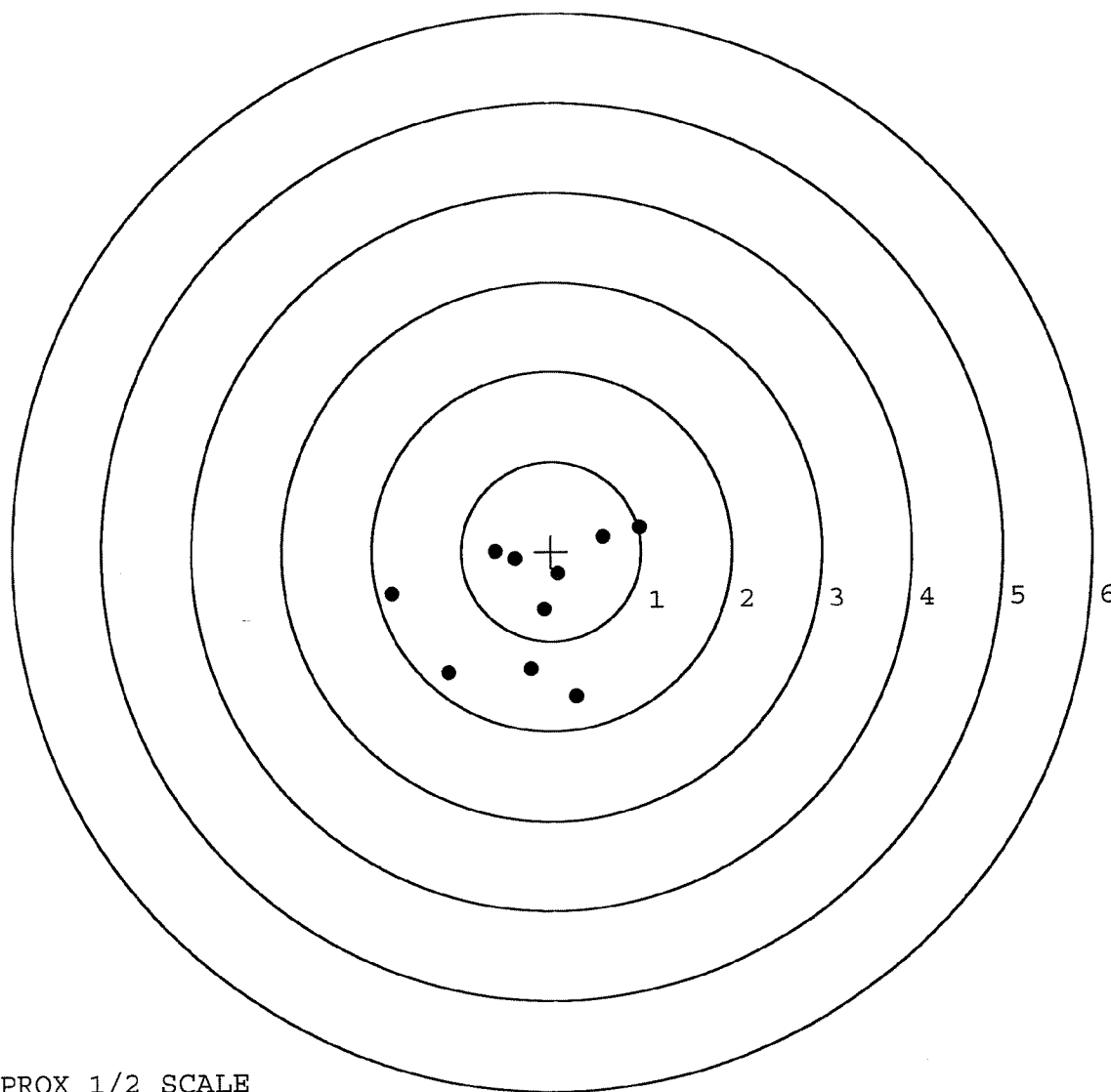


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590083. __0
TARGET NUMBER: 3
FILE DATE: 07/21/2006
FILE TIME: 16:55

X CENTROID: -0.237
Y CENTROID: -0.530
POA TO CENTROID: 0.581
HORZ SPREAD: 2.756
VERT SPREAD: 1.888
GROUP SPREAD: 2.850
MIN RADIUS: 0.193
MAX RADIUS: 1.540
MEAN RADIUS: 0.904
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.776	-0.463
2:	-1.152	-1.353
3:	-0.236	-1.319
4:	0.270	-1.624
5:	-0.084	-0.647
6:	0.076	-0.250
7:	-0.403	-0.081
8:	-0.622	0.008
9:	0.576	0.163
10:	0.980	0.264



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590083. __0

TARGET NUMBER: 4

FILE DATE: 07/21/2006

FILE TIME: 16:55

X CENTROID: 0.272

Y CENTROID: 0.044

POA TO CENTROID: 0.276

HORZ SPREAD: 2.088

VERT SPREAD: 1.679

GROUP SPREAD: 2.290

MIN RADIUS: 0.252

MAX RADIUS: 1.208

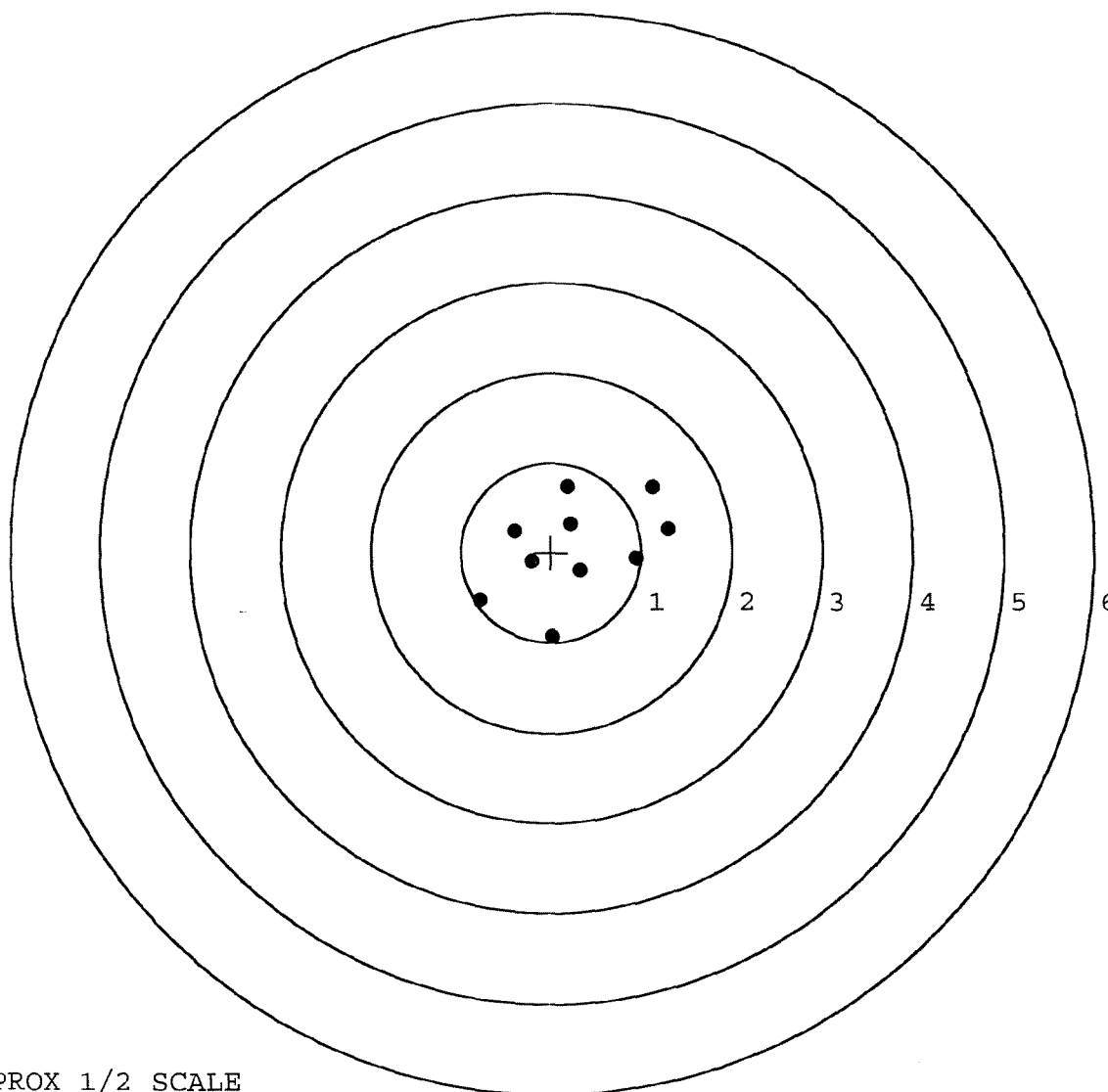
MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.215	-0.102
2:	-0.789	-0.534
3:	0.024	-0.944
4:	0.331	-0.201
5:	0.944	-0.073
6:	1.299	0.266
7:	1.119	0.733
8:	0.189	0.735
9:	-0.400	0.238
10:	0.218	0.324



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590083. __0

TARGET NUMBER: 5

FILE DATE: 07/21/2006

FILE TIME: 16:55

POINT#	X	Y
1:	-0.127	0.126
2:	0.211	-0.025
3:	0.181	-0.242
4:	-0.076	-0.468
5:	-0.195	-0.232
6:	-0.150	0.137
7:	0.448	0.406
8:	-0.062	0.607
9:	-0.511	0.267
10:	0.802	-0.109

X CENTROID: 0.052

Y CENTROID: 0.047

POA TO CENTROID: 0.070

HORZ SPREAD: 1.313

VERT SPREAD: 1.075

GROUP SPREAD: 1.366

MIN RADIUS: 0.174

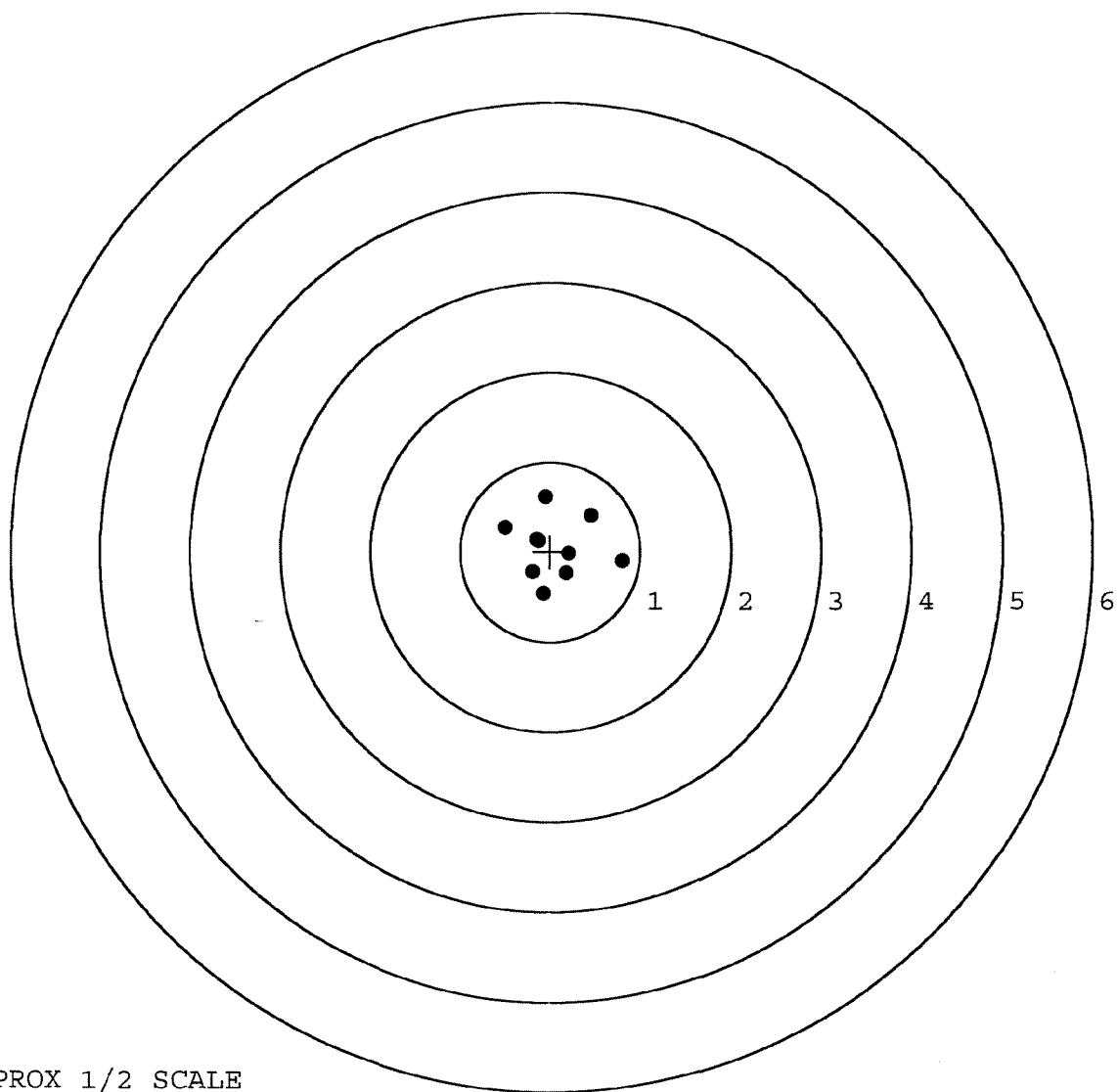
MAX RADIUS: 0.766

MEAN RADIUS: 0.429

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE