

G6590085

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



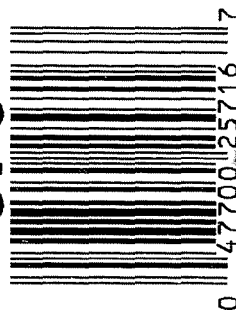
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590085

UPC



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

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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590085

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLG
420	ASSEMBLE ACTION		6/22/06	BLG
430	ASSEMBLE TO STOCK		6-23-06	R.P
440	PROOF	MAGNA-FLUX	6-23-06	TRW
460	CHECK HEADSPACE	INSPECTED	6-23-06	TRW
470	DIS-ASSEMBLE ACTION	JUN 27 2006	6-26-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</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	(X)
530 & 540	APPLY COATINGS (BARREL ACTION)		7/12	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-21-06	BLG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-21-06	BLG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-21-06	BLG
	D) OIL FIRING PIN ASSEMBLY		7-31-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-17-06	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>6.0</u> <u>6.2</u>	8-15-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	8-15-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-17-06	mom
	I) FIRING PIN INDENT .020 MIN	<u>10235</u> <u>0235</u> <u>023</u>	8-15-06	RA
	J) ASSEMBLE STOCK		7-31-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-17-06	mom
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-31-06	BLC
	M) IRON SIGHT ALIGNMENT		7-31-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-31-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-1-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/1/06	mom
670	FINAL INSPECTION A) HEADSPACE		8-17-06	mom
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.91</u> <u>2.76</u> <u>2.71</u> <u>2.65</u>	8-11-06	AC
	C) FUNCTION		8-17-06	mom
690	PACK		11/13/06	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 7-28-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.62	2.59	2.61	
PULL #2	2.63	2.50	2.55	
PULL #3	2.61	2.46	2.60	
PULL #4	2.49	2.50	2.63	
PULL #5	2.36	2.47	2.63	
TOTAL	12.71	12.52	13.02	
AVERAGE	2.54	2.50	2.60	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.02	2.81	
PULL #2	3.05	3.04	
PULL #3	2.95	3.04	
PULL #4	2.98	3.06	
PULL #5	3.01	2.92	
TOTAL	15.01	14.87	
AVERAGE	3.00	2.97	

	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	4.20	4.02		4.11
PULL #2	4.16	4.05		4.11
PULL #3	4.03	4.18		4.23
PULL #4	4.01	4.07		4.13
PULL #5	3.93	4.20		4.07
TOTAL	20.33	20.52		20.65
AVERAGE	4.06	4.10		4.13

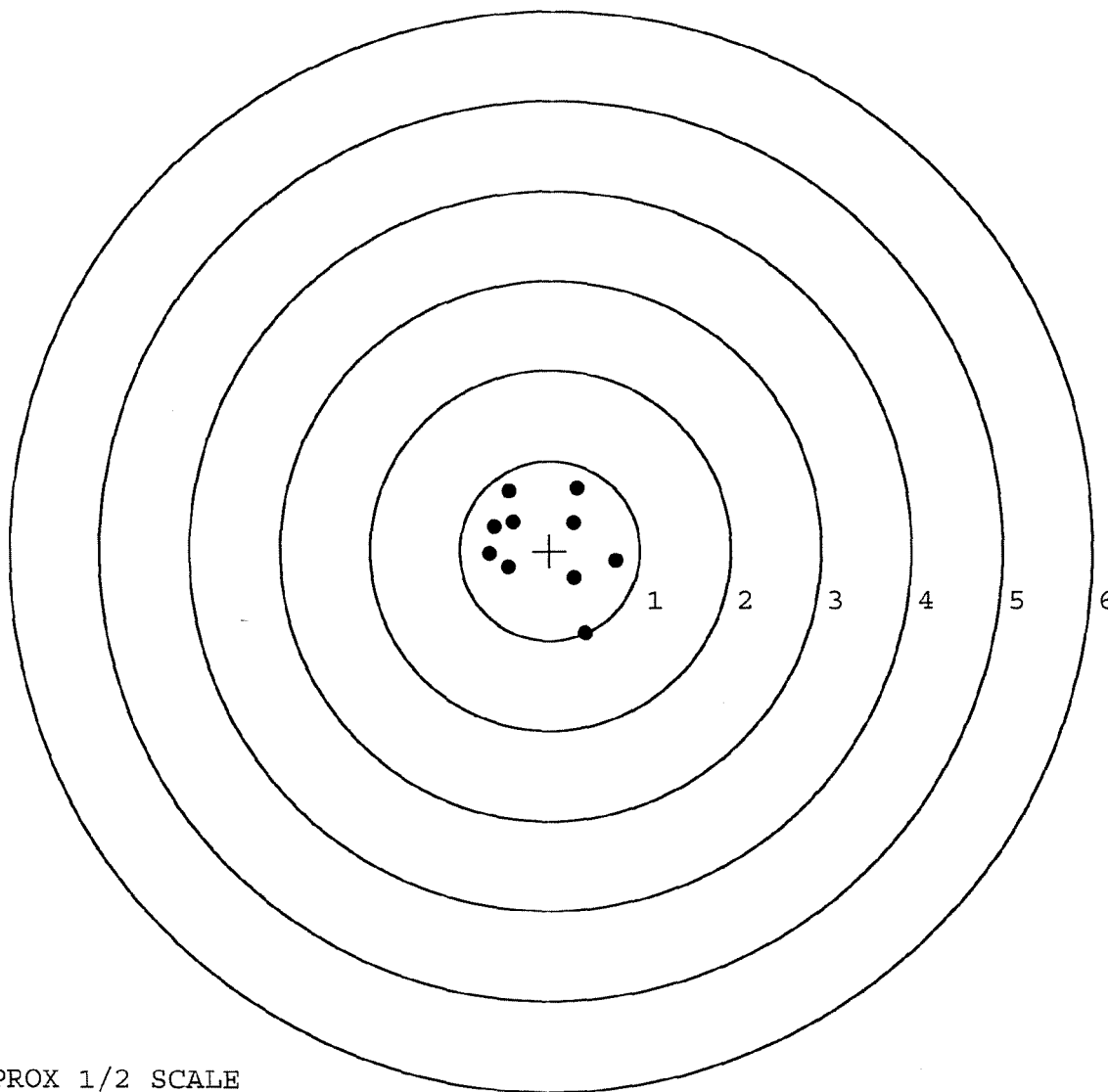
SERIAL NUMBER: G6590085. __0

TARGET NUMBER: 1

FILE DATE: 08/01/2006

FILE TIME: 08:05

	POINT#	X	Y
X CENTROID:	1:	0.301	0.696
Y CENTROID:	2:	0.265	0.313
POA TO CENTROID:	3:	0.728	-0.115
HORZ SPREAD:	4:	0.267	-0.310
VERT SPREAD:	5:	0.405	-0.923
GROUP SPREAD:	6:	-0.461	-0.189
MIN RADIUS:	7:	-0.670	-0.046
MAX RADIUS:	8:	-0.625	0.270
MEAN RADIUS:	9:	-0.457	0.665
# IN 1 IN DIAMETER:	10:	-0.412	0.318
# IN 2 IN DIAMETER:			
# in 3 IN DIAMETER:			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590085. __0

TARGET NUMBER: 2

FILE DATE: 08/01/2006

FILE TIME: 08:05

POINT#	X	Y
1:	0.615	-0.956
2:	0.408	0.002
3:	0.108	-0.216
4:	-0.255	-0.194
5:	-0.466	-0.506
6:	-0.878	-0.146
7:	-1.091	0.212
8:	-0.585	0.534
9:	-0.598	0.773
10:	0.075	0.599

X CENTROID: -0.267

Y CENTROID: 0.010

POA TO CENTROID: 0.267

HORZ SPREAD: 1.706

VERT SPREAD: 1.729

GROUP SPREAD: 2.112

MIN RADIUS: 0.205

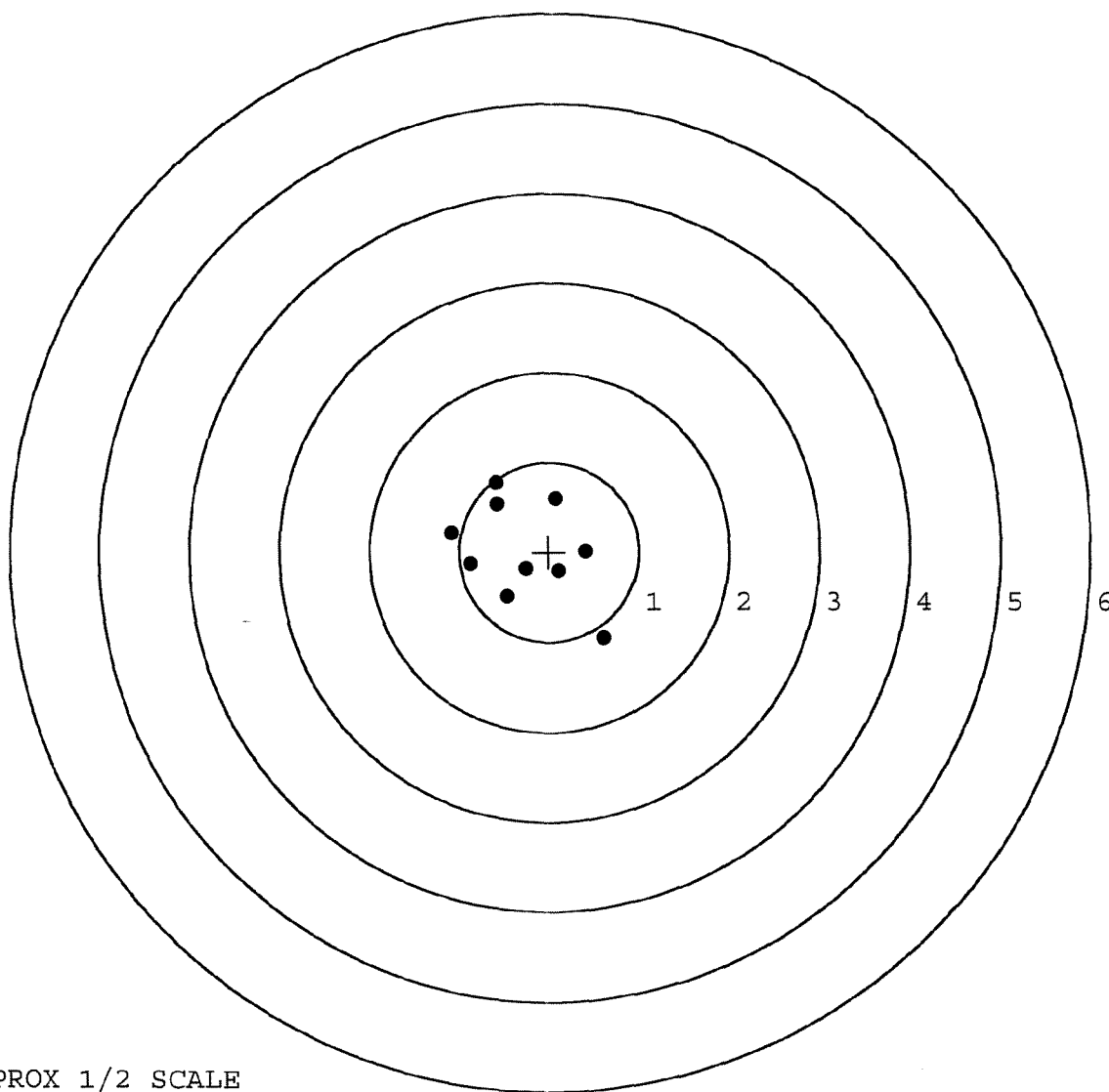
MAX RADIUS: 1.308

MEAN RADIUS: 0.678

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

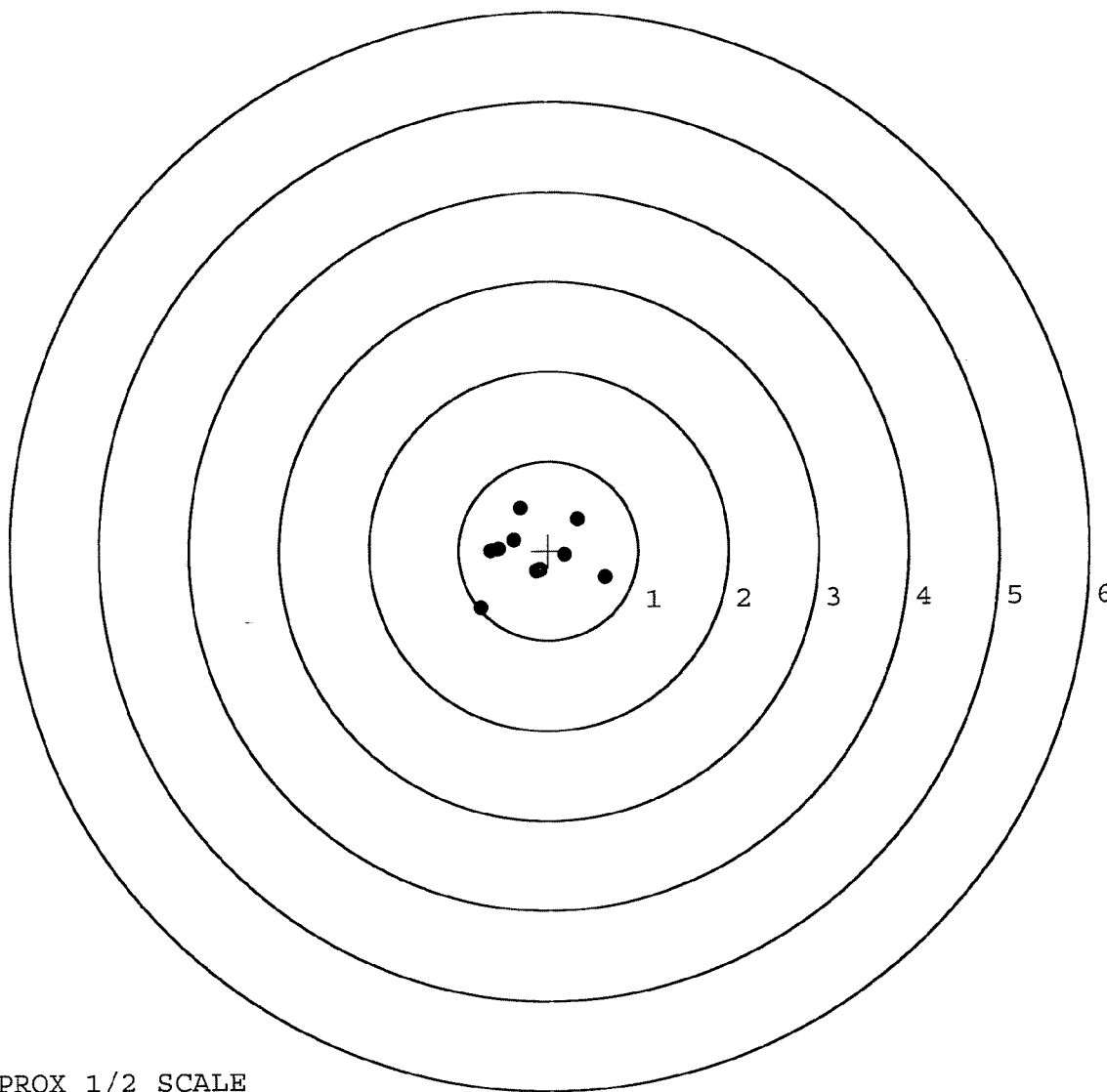


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590085.___0
TARGET NUMBER: 3
FILE DATE: 08/01/2006
FILE TIME: 08:05

X CENTROID: -0.174
Y CENTROID: -0.045
POA TO CENTROID: 0.180
HORZ SPREAD: 1.390
VERT SPREAD: 1.114
GROUP SPREAD: 1.430
MIN RADIUS: 0.185
MAX RADIUS: 0.845
MEAN RADIUS: 0.471
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.759	-0.636
2:	-0.554	0.025
3:	-0.382	0.124
4:	-0.312	0.478
5:	-0.139	-0.231
6:	0.182	-0.047
7:	0.332	0.350
8:	0.631	-0.302
9:	-0.641	0.005
10:	-0.099	-0.214



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590085. __0

TARGET NUMBER: 4

FILE DATE: 08/01/2006

FILE TIME: 08:05

POINT#	X	Y
1:	-0.766	-0.859
2:	-0.136	-0.163
3:	0.752	0.226
4:	0.485	0.089
5:	-0.744	0.498
6:	0.110	0.630
7:	-0.276	0.577
8:	0.129	0.357
9:	-0.235	0.307
10:	0.000	0.309

X CENTROID: -0.068

Y CENTROID: 0.197

POA TO CENTROID: 0.209

HORZ SPREAD: 1.518

VERT SPREAD: 1.489

GROUP SPREAD: 1.866

MIN RADIUS: 0.131

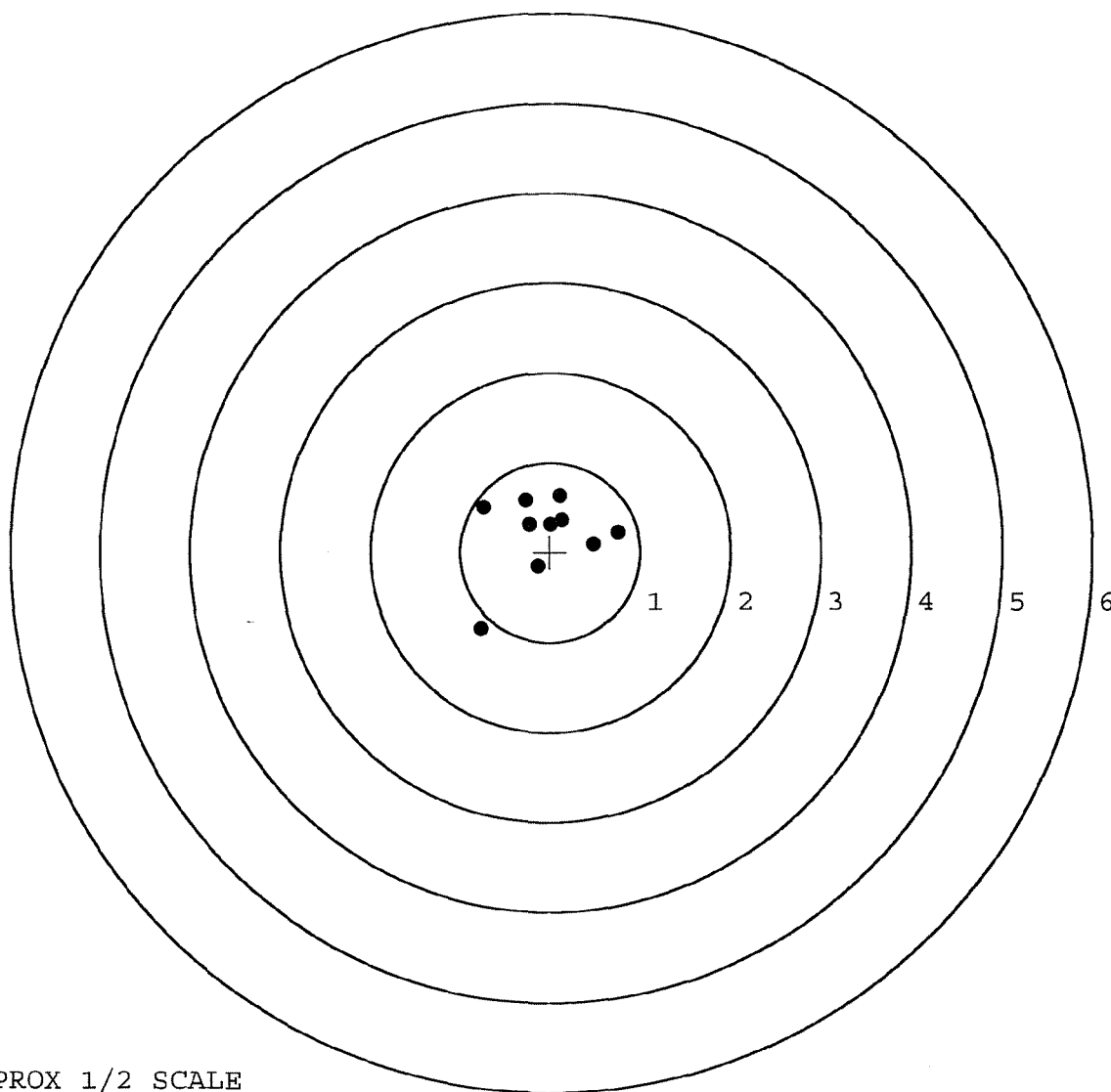
MAX RADIUS: 1.266

MEAN RADIUS: 0.524

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

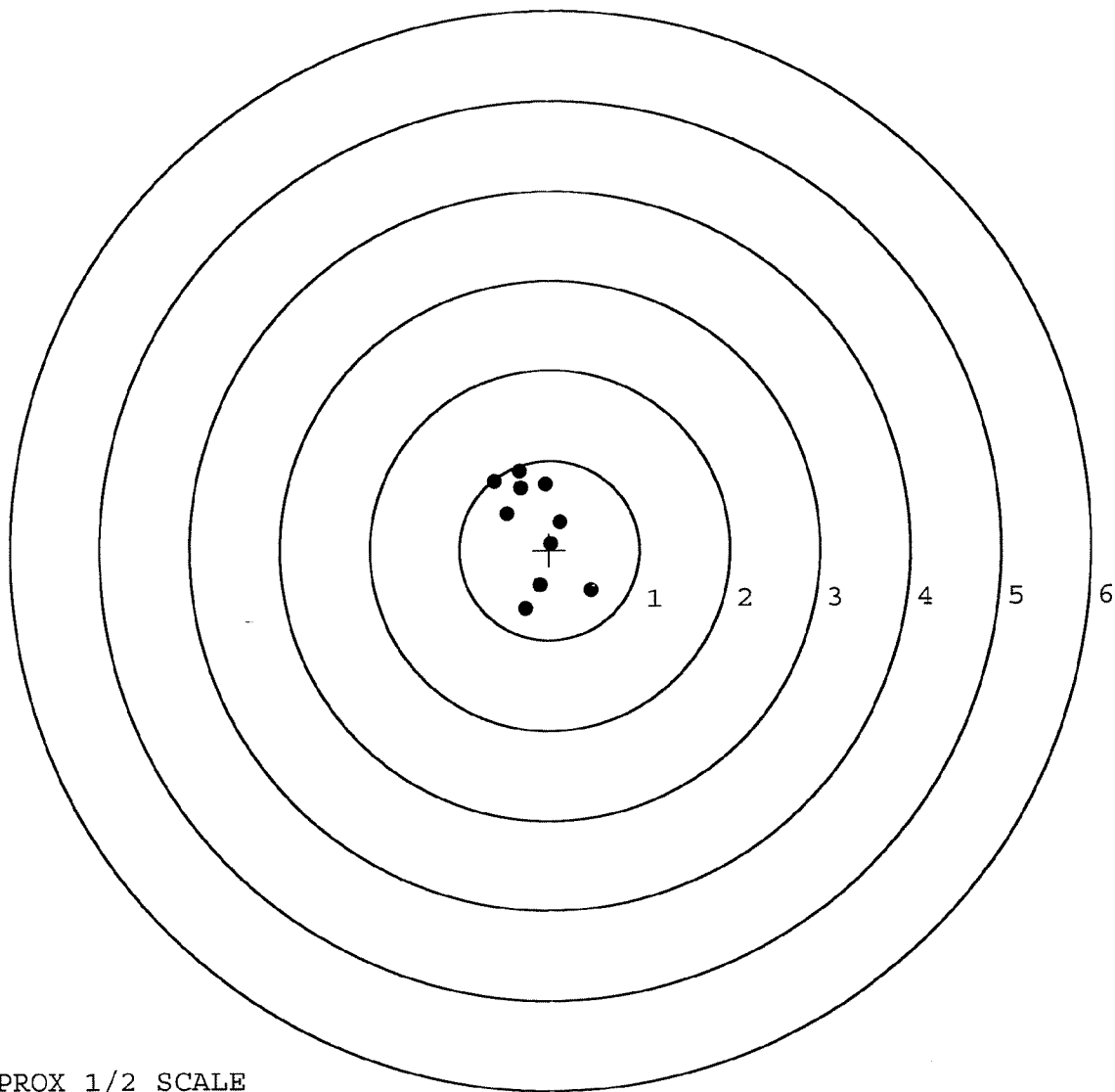


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590085.___0
TARGET NUMBER: 5
FILE DATE: 08/01/2006
FILE TIME: 08:05

X CENTROID: -0.154
Y CENTROID: 0.238
POA TO CENTROID: 0.284
HORZ SPREAD: 1.079
VERT SPREAD: 1.543
GROUP SPREAD: 1.633
MIN RADIUS: 0.240
MAX RADIUS: 0.929
MEAN RADIUS: 0.573
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.268	-0.657
2:	-0.110	-0.396
3:	0.466	-0.454
4:	0.019	0.072
5:	0.126	0.313
6:	-0.045	0.738
7:	-0.329	0.886
8:	-0.613	0.772
9:	-0.471	0.410
10:	-0.314	0.698



TARGET APPROX 1/2 SCALE