

G6590104

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



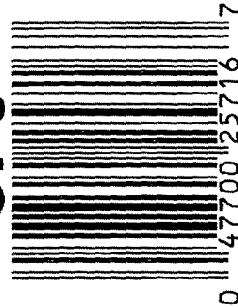
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590104

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 # G6590104

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-24-06	RTZ
420	ASSEMBLE ACTION		8-24-06	RTZ
430	ASSEMBLE TO STOCK		8-24-06	BD
440	PROOF	MAGNA-FLUX	8-24-06	TRW
460	CHECK HEADSPACE	INSPECTED	8-24-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 01 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <u>umms</u>	9/1/06	umms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-1-06	cw
510	DRILL AND TAP SIGHT HOLES		9-1-06	TRW
520	GOFF BLAST BBL / REC		9-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/11/06	BB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-11-06	AC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-11-06	AC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-11-06	AC
	D) OIL FIRING PIN ASSEMBLY		9-14-06	BLC
	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>5°</u> <u>6°</u> <u>6°</u>	10-2-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>7°</u> <u>7°</u> <u>7°</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.027</u> <u>.024</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-14-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-8-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-14-06	BLG
	M) IRON SIGHT ALIGNMENT		9-14-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-14-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-15-06	R.P.A.
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/15/06	W/D
670	FINAL INSPECTION A) HEADSPACE		11-8-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.63</u> <u>2.60</u> <u>2.52</u> <u>2.52</u>	9-18-06	WA
	C) FUNCTION		11-8-06	RTZ
690	PACK		11/9/06	WA

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 9-9-06

TESTER MTL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.52	2.73	2.23	
PULL #2	2.35	2.34	2.63	
PULL #3	2.60	2.82	2.51	
PULL #4	2.59	2.49	2.25	
PULL #5	2.39	2.28	2.88	
TOTAL	12.51	12.66	12.50	
AVERAGE	2.50	2.53	2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	2.91	2.82	
PULL #2	2.98	3.01	
PULL #3	2.88	2.95	
PULL #4	2.94	3.23	
PULL #5	2.98	3.28	
TOTAL	14.74	15.29	
AVERAGE	2.95	3.06	

	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	4.01	4.02		4.01
PULL #2	4.23	4.18		3.97
PULL #3	4.21	3.96		3.91
PULL #4	3.97	3.88		3.69
PULL #5	3.81	4.23		4.02
TOTAL	20.23	20.27		19.60
AVERAGE	4.05	4.05		3.92

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590104.___0
FILE DATE AND TIME: 09/16/2006 07:53

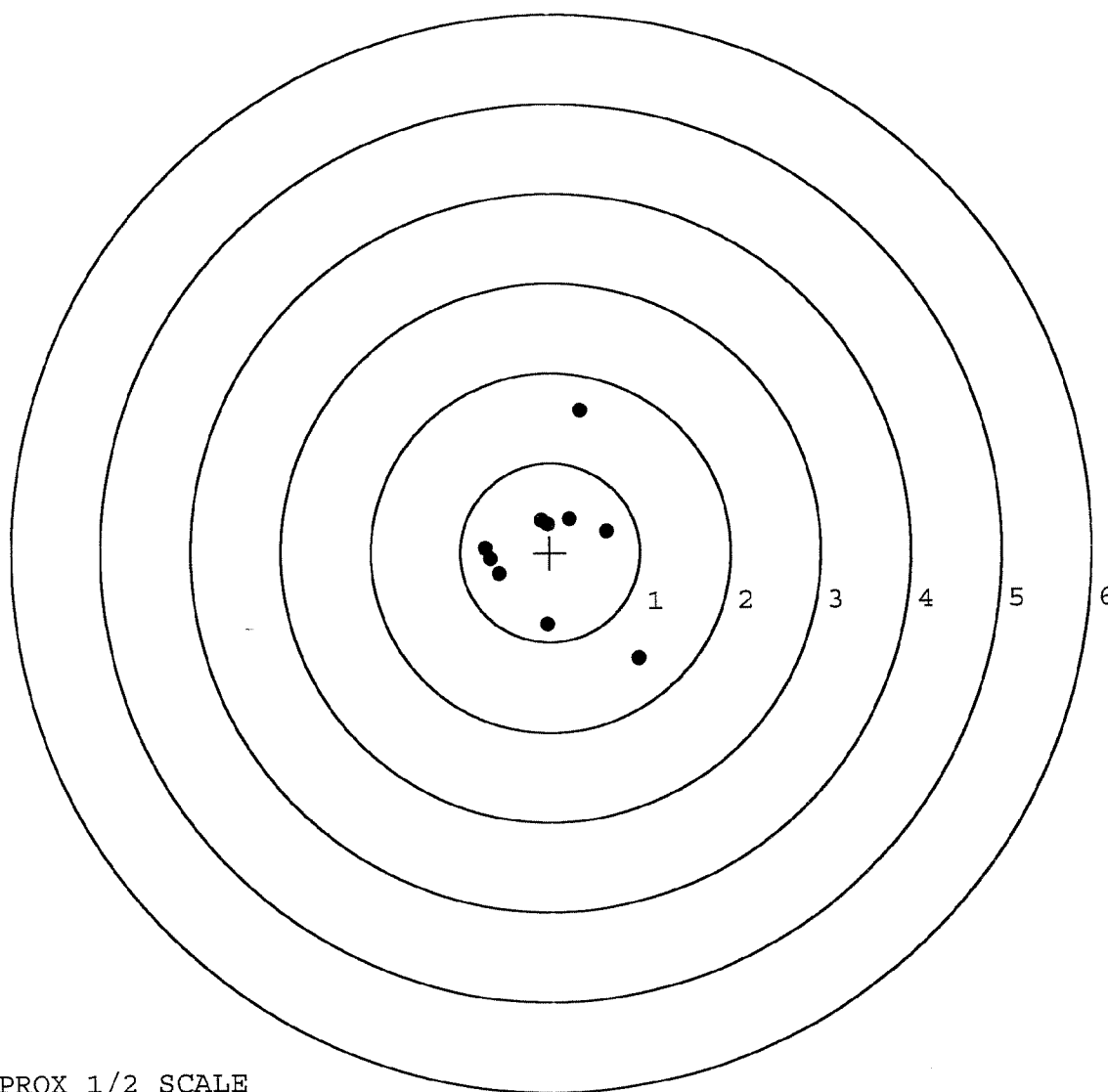
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.012
The Average Y Centroid of the Five Target Set:	0.084
The Average Point of Impact of the Five Target Set:	0.085
The Average Mean Radius of the Five Target Set:	0.638
The Distance from POA to Centroid Target #1:	0.063
The Distance from Centroid Target #2 to Centroid Target #1:	0.195
The Distance from Centroid Target #3 to Centroid Target #1:	0.107
The Distance from Centroid Target #4 to Centroid Target #1:	0.219
The Distance from Centroid Target #5 to Centroid Target #1:	0.066

SERIAL NUMBER: G6590104. __0
TARGET NUMBER: 1
FILE DATE: 09/16/2006
FILE TIME: 07:53

X CENTROID: 0.006
Y CENTROID: 0.063
POA TO CENTROID: 0.063
HORZ SPREAD: 1.708
VERT SPREAD: 2.776
GROUP SPREAD: 2.848
MIN RADIUS: 0.258
MAX RADIUS: 1.591
MEAN RADIUS: 0.769
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.345	1.583
2:	0.627	0.234
3:	0.225	0.378
4:	-0.094	0.364
5:	-0.725	0.059
6:	-0.572	-0.239
7:	-0.040	-0.808
8:	0.983	-1.193
9:	-0.661	-0.067
10:	-0.030	0.318

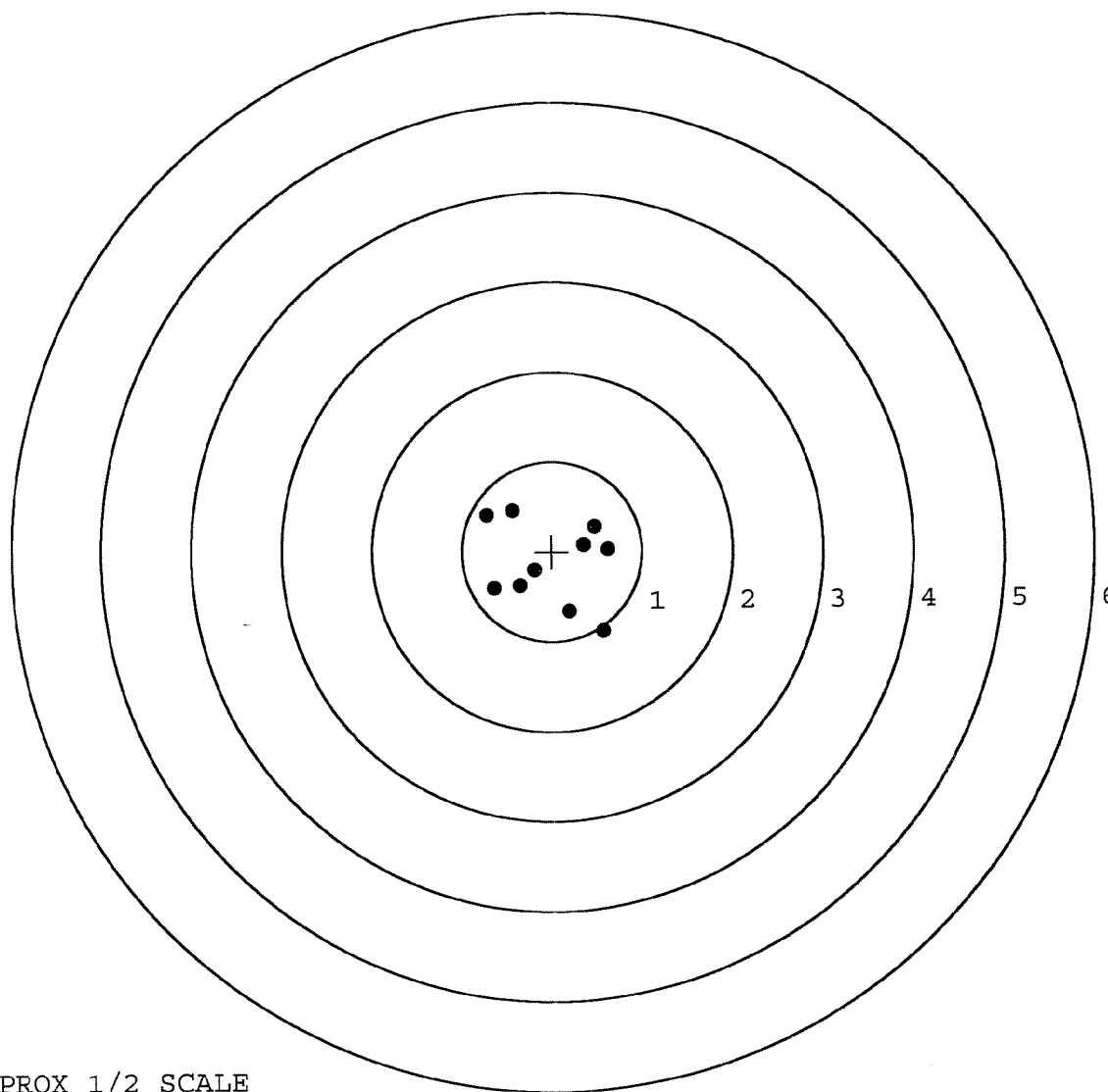


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590104.___0
TARGET NUMBER: 2
FILE DATE: 09/16/2006
FILE TIME: 07:53

X CENTROID: -0.014
Y CENTROID: -0.131
POA TO CENTROID: 0.132
HORZ SPREAD: 1.345
VERT SPREAD: 1.349
GROUP SPREAD: 1.838
MIN RADIUS: 0.200
MAX RADIUS: 0.959
MEAN RADIUS: 0.619
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.724	0.413
2:	-0.439	0.456
3:	0.477	0.275
4:	0.358	0.077
5:	0.621	0.026
6:	-0.198	-0.210
7:	-0.357	-0.382
8:	-0.645	-0.407
9:	0.195	-0.668
10:	0.569	-0.893



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590104. __0

TARGET NUMBER: 3

FILE DATE: 09/16/2006

FILE TIME: 07:53

POINT#	X	Y
1:	-0.203	0.697
2:	-0.507	0.655
3:	-0.526	0.537
4:	-0.509	-0.556
5:	0.021	0.153
6:	0.216	0.350
7:	0.593	0.265
8:	0.614	-0.546
9:	-0.491	-0.565
10:	0.189	0.486

X CENTROID: -0.060

Y CENTROID: 0.148

POA TO CENTROID: 0.159

HORZ SPREAD: 1.140

VERT SPREAD: 1.262

GROUP SPREAD: 1.643

MIN RADIUS: 0.081

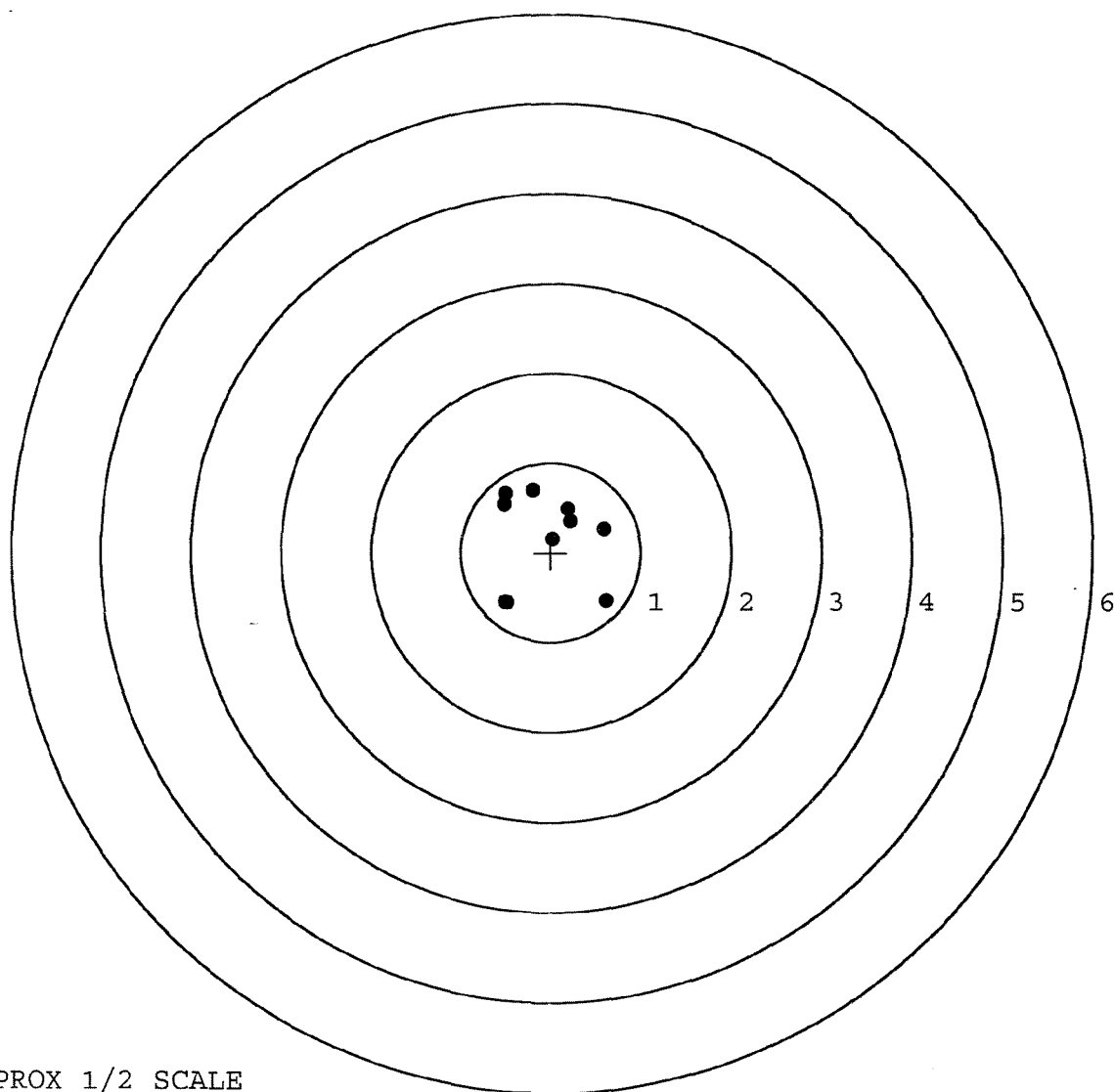
MAX RADIUS: 0.967

MEAN RADIUS: 0.599

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590104. 0

TARGET NUMBER: 4

FILE DATE: 09/16/2006

FILE TIME: 07:53

POINT#	X	Y
1:	-0.783	0.713
2:	-0.673	0.510
3:	-0.267	0.496
4:	-0.255	0.309
5:	0.067	0.274
6:	0.224	0.248
7:	0.388	0.191
8:	0.588	0.282
9:	0.617	0.745
10:	-0.506	-1.046

X CENTROID: -0.060

Y CENTROID: 0.272

POA TO CENTROID: 0.279

HORZ SPREAD: 1.400

VERT SPREAD: 1.791

GROUP SPREAD: 2.114

MIN RADIUS: 0.127

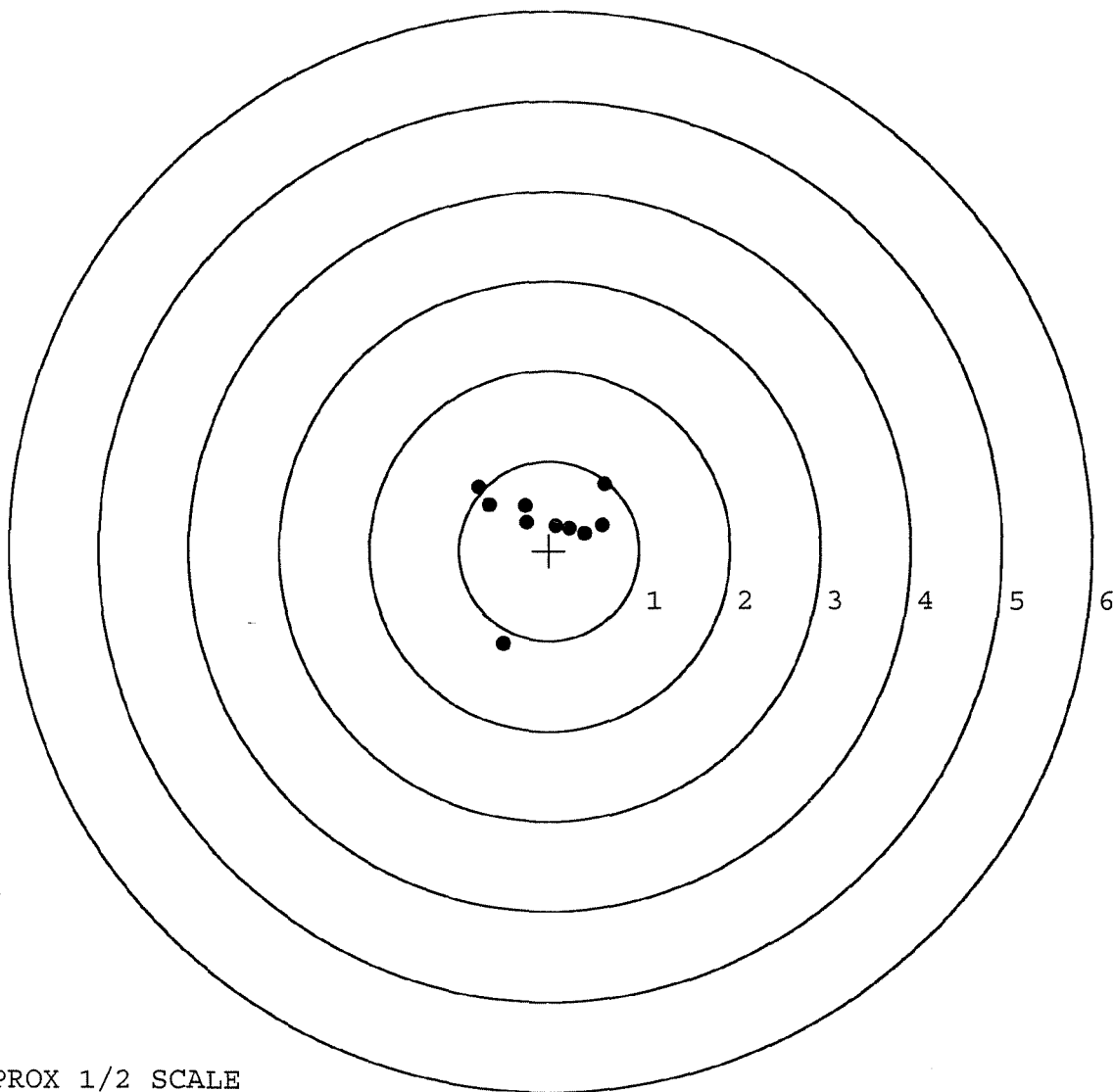
MAX RADIUS: 1.392

MEAN RADIUS: 0.574

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590104. __0

TARGET NUMBER: 5

FILE DATE: 09/16/2006

FILE TIME: 07:53

POINT#	X	Y
1:	0.233	0.725
2:	0.498	0.694
3:	0.344	0.548
4:	0.569	0.171
5:	0.395	0.124
6:	0.426	-0.028
7:	-0.191	-0.315
8:	-0.504	0.026
9:	-1.139	-0.667
10:	0.080	-0.586

X CENTROID: 0.071

Y CENTROID: 0.069

POA TO CENTROID: 0.099

HORZ SPREAD: 1.708

VERT SPREAD: 1.392

GROUP SPREAD: 2.129

MIN RADIUS: 0.329

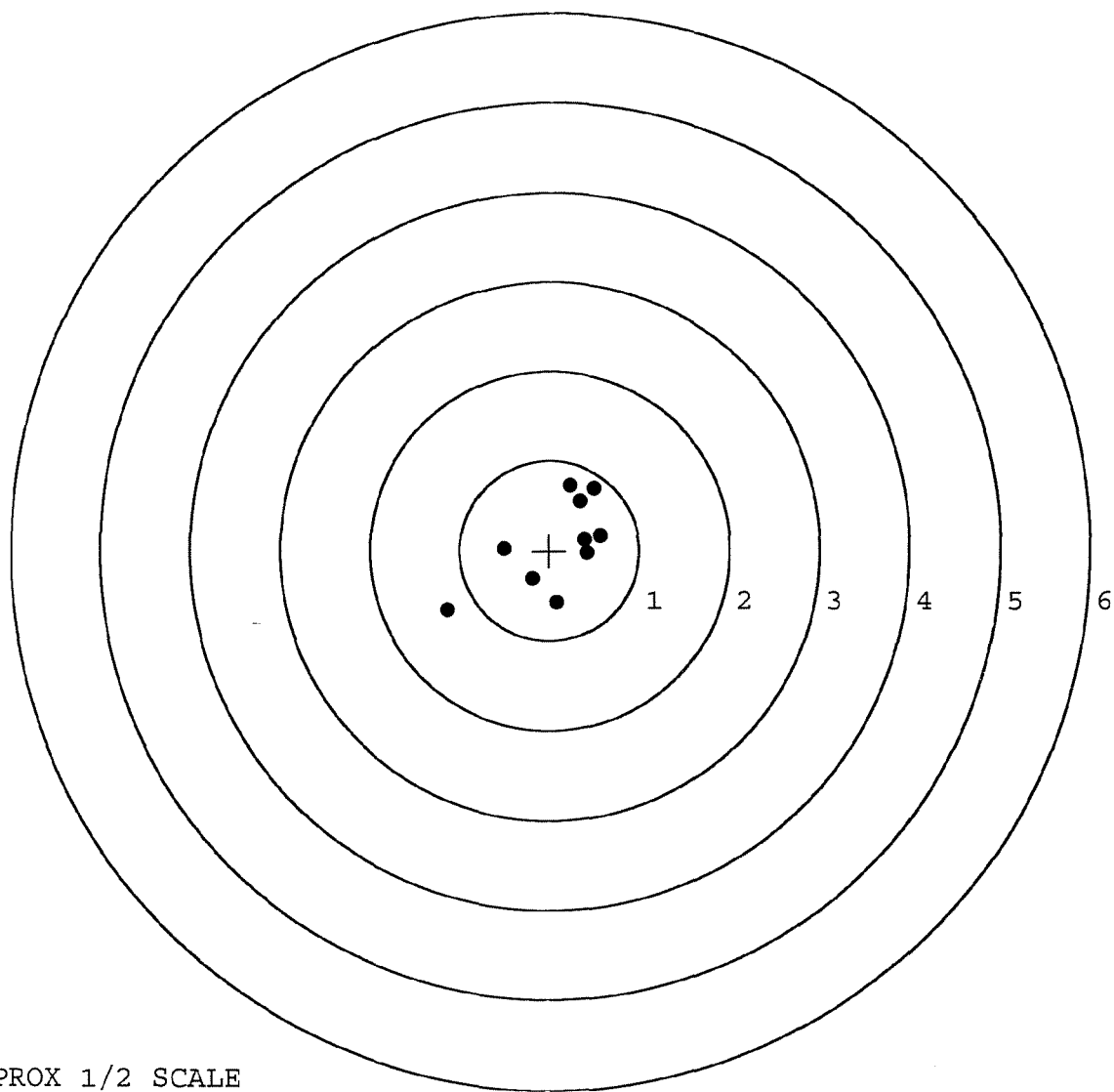
MAX RADIUS: 1.416

MEAN RADIUS: 0.630

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE