

G 6590110

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

G6590110

UPC



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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590110

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-30-06	RTZ
420	ASSEMBLE ACTION		8-30-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		8-31-06	L.P.D.
460	CHECK HEADSPACE		8-31-06	L.P.D.
470	DIS-ASSEMBLE ACTION	SEP 03 2006	9-1-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	9/5/06	<u>mm</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-5-06	CW
510	DRILL AND TAP SIGHT HOLES		9-5-06	TRW
520	GOFF BLAST BBL / REC		9-6-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/14/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-18-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-18-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-18-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		9-18-06	RTZ
	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>8²</u> <u>8²</u> <u>8²</u>	10-2-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5²</u> <u>6²</u> <u>6²</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.026</u> <u>.025</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-18-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-8-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-18-06	RTZ
	M) IRON SIGHT ALIGNMENT		9-18-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-18-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-18-06	MSH
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/18/06	MGR
670	FINAL INSPECTION A) HEADSPACE		11-8-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.63</u> <u>2.66</u> <u>2.55</u> <u>2.64</u> <u>2.37</u>	9-19-06	DA
	C) FUNCTION		11-8-06	RTZ
690	PACK		11-8-06	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 9-15-06

TESTER MJL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.44	2.55		2.28	
PULL #2	2.40	2.52		2.34	
PULL #3	2.65	2.58		2.35	
PULL #4	2.61	2.59		2.37	
PULL #5	2.62	2.54		2.34	
TOTAL	12.72	12.78		11.68	
AVERAGE	2.54	2.56		2.34	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.11		
PULL #2	3.04	3.15		
PULL #3	2.99	3.09		
PULL #4	3.01	3.10		
PULL #5	3.00	3.12		
TOTAL	15.07	15.57		
AVERAGE	3.01	3.11		

	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	3.89	3.98		3.91
PULL #2	3.88	3.97		3.89
PULL #3	3.91	4.01		4.01
PULL #4	3.90	3.99		4.02
PULL #5	3.97	4.02		4.20
TOTAL	19.45	19.97		20.03
AVERAGE	3.89	3.99		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590110.___0
FILE DATE AND TIME: 09/19/2006 06:06

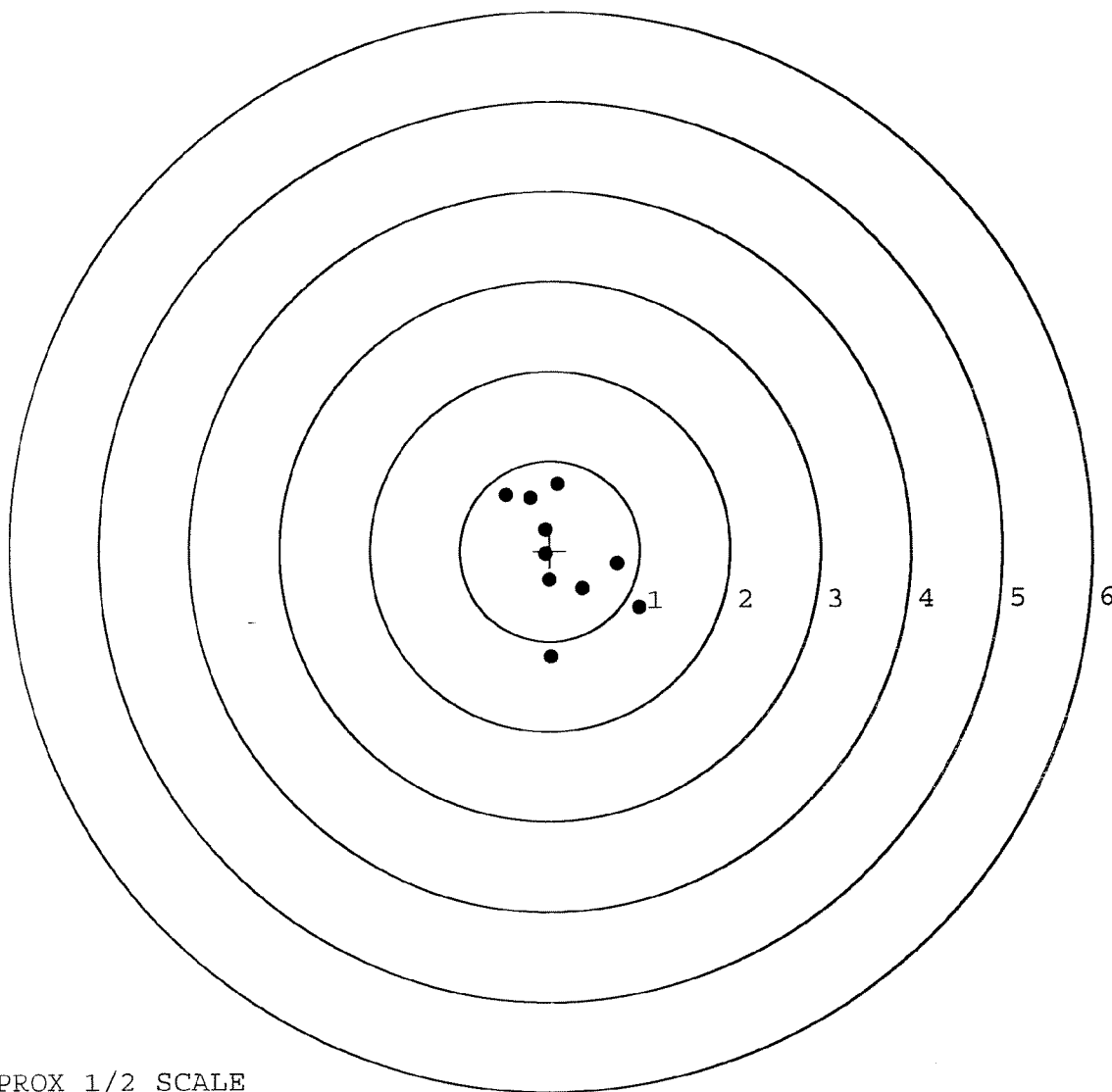
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.070
The Average Y Centroid of the Five Target Set:	-0.022
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.626
The Distance from POA to Centroid Target #1:	0.149
The Distance from Centroid Target #2 to Centroid Target #1:	0.124
The Distance from Centroid Target #3 to Centroid Target #1:	0.046
The Distance from Centroid Target #4 to Centroid Target #1:	0.176
The Distance from Centroid Target #5 to Centroid Target #1:	0.077

SERIAL NUMBER: G6590110. __0
TARGET NUMBER: 1
FILE DATE: 09/19/2006
FILE TIME: 06:06

POINT#	X	Y
1:	0.012	-1.178
2:	0.989	-0.637
3:	0.747	-0.148
4:	0.365	-0.424
5:	-0.012	-0.325
6:	0.088	0.740
7:	-0.215	0.592
8:	-0.484	0.622
9:	-0.053	-0.037
10:	-0.051	0.237

X CENTROID: 0.139
Y CENTROID: -0.056
POA TO CENTROID: 0.149
HORZ SPREAD: 1.473
VERT SPREAD: 1.918
GROUP SPREAD: 1.920
MIN RADIUS: 0.193
MAX RADIUS: 1.129
MEAN RADIUS: 0.651
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

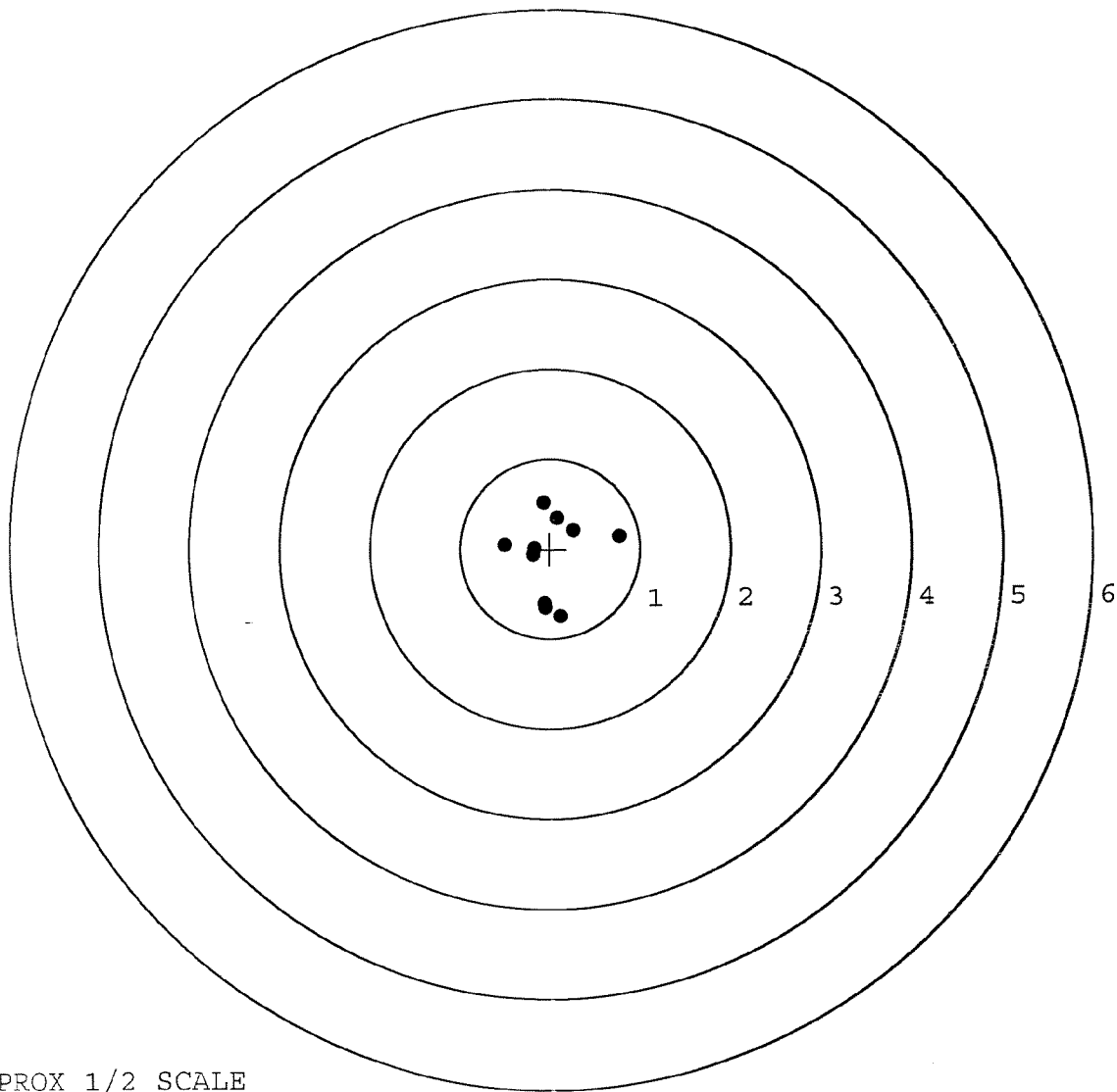


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590110.___0
TARGET NUMBER: 2
FILE DATE: 09/19/2006
FILE TIME: 06:06

X CENTROID: 0.018
Y CENTROID: -0.084
POA TO CENTROID: 0.086
HORZ SPREAD: 1.275
VERT SPREAD: 1.276
GROUP SPREAD: 1.278
MIN RADIUS: 0.206
MAX RADIUS: 0.786
MEAN RADIUS: 0.497
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.772	0.135
2:	0.118	-0.759
3:	-0.054	-0.663
4:	-0.503	0.048
5:	-0.179	0.011
6:	0.261	0.208
7:	0.083	0.344
8:	-0.073	0.517
9:	-0.061	-0.610
10:	-0.188	-0.072



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590110. __0

TARGET NUMBER: 3

FILE DATE: 09/19/2006

FILE TIME: 06:06

POINT#	X	Y
1:	-0.435	0.537
2:	0.272	0.456
3:	-0.080	0.224
4:	-0.505	0.013
5:	-0.207	-0.102
6:	0.076	-0.224
7:	0.351	-0.049
8:	0.714	-0.155
9:	0.521	-0.363
10:	0.393	-0.541

X CENTROID: 0.110

Y CENTROID: -0.020

POA TO CENTROID: 0.112

HORZ SPREAD: 1.219

VERT SPREAD: 1.078

GROUP SPREAD: 1.359

MIN RADIUS: 0.206

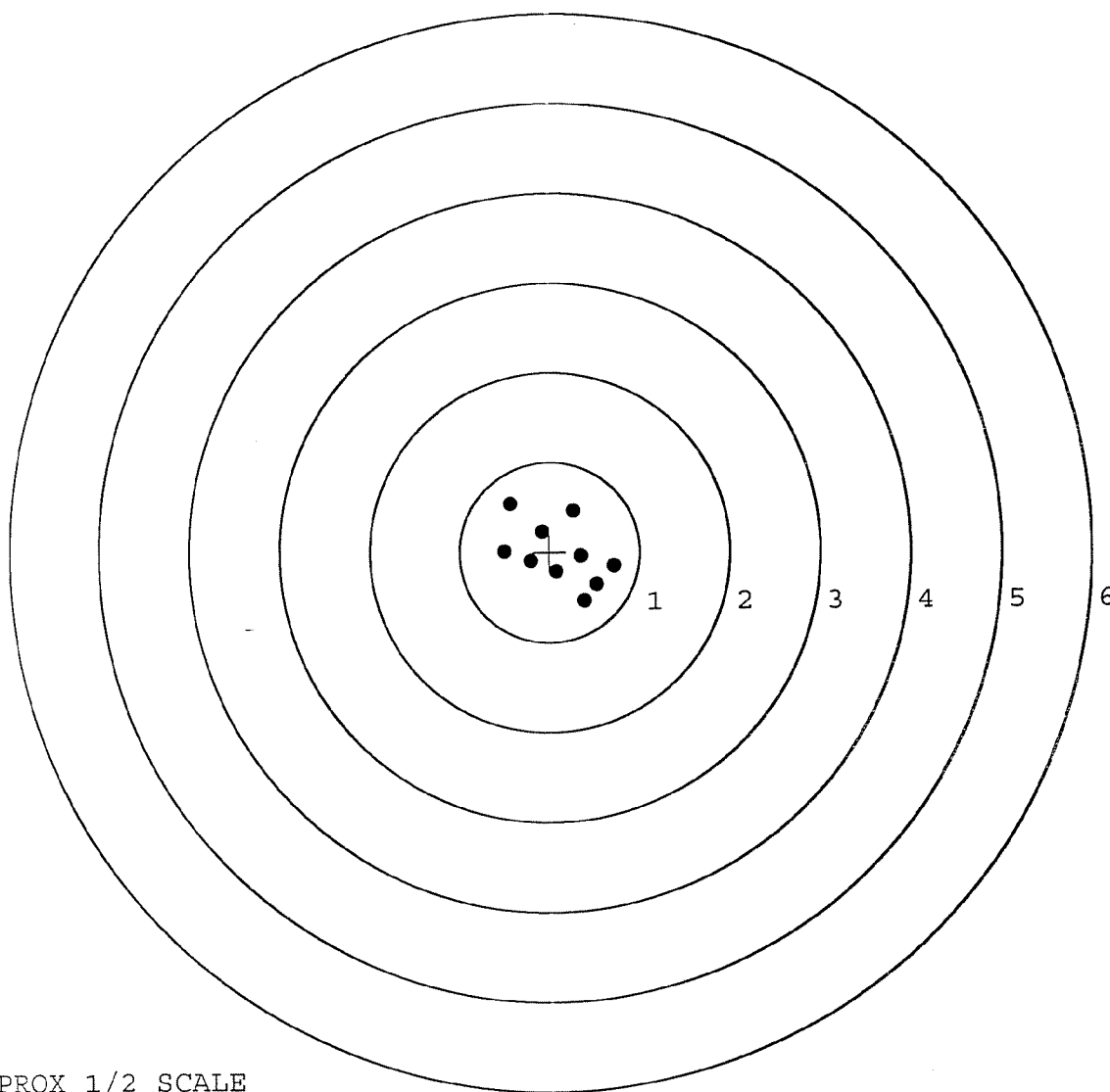
MAX RADIUS: 0.780

MEAN RADIUS: 0.473

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590110. 0

TARGET NUMBER: 4

FILE DATE: 09/19/2006

FILE TIME: 06:06

POINT#	X	Y
1:	-0.068	0.828
2:	-0.397	0.269
3:	-0.793	-0.434
4:	-0.406	-0.558
5:	0.025	-0.116
6:	0.448	-0.117
7:	0.702	-0.350
8:	1.101	-0.057
9:	1.145	0.268
10:	-1.648	0.919

X CENTROID: 0.011

Y CENTROID: 0.065

POA TO CENTROID: 0.066

HORZ SPREAD: 2.793

VERT SPREAD: 1.477

GROUP SPREAD: 2.917

MIN RADIUS: 0.182

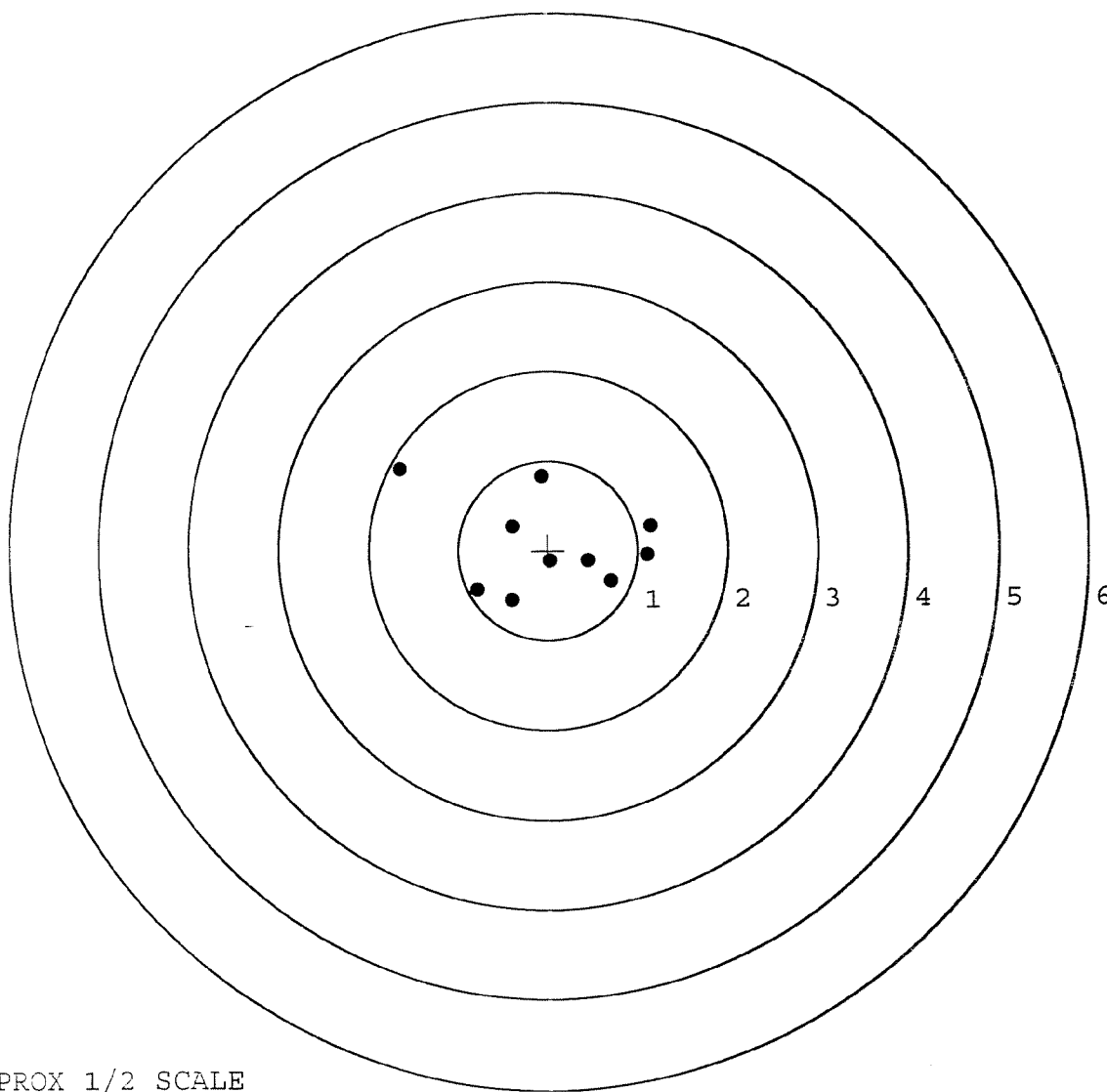
MAX RADIUS: 1.866

MEAN RADIUS: 0.850

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

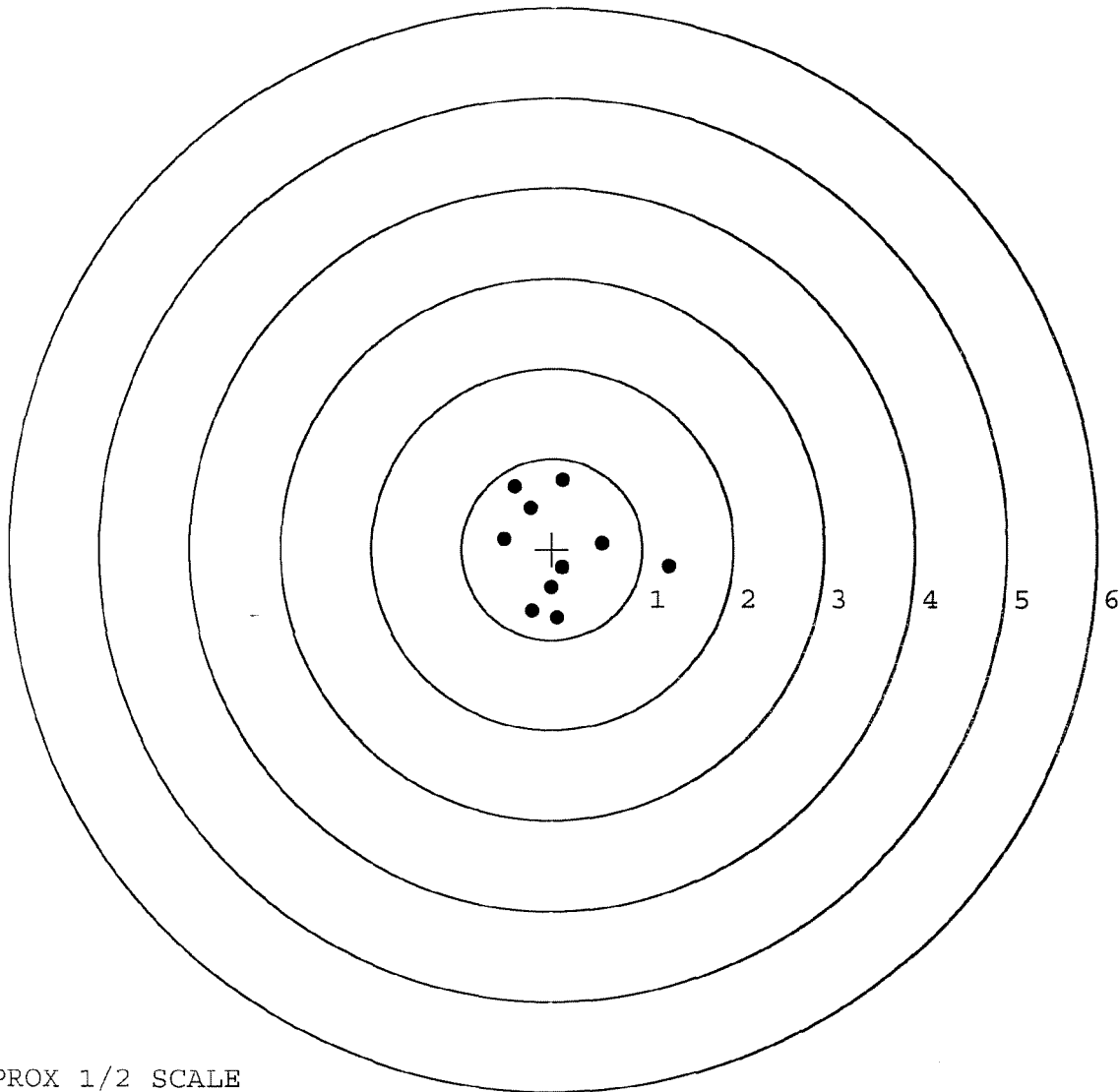


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590110. __0
TARGET NUMBER: 5
FILE DATE: 09/19/2006
FILE TIME: 06:06

X CENTROID: 0.072
Y CENTROID: -0.016
POA TO CENTROID: 0.074
HORZ SPREAD: 1.816
VERT SPREAD: 1.520
GROUP SPREAD: 1.917
MIN RADIUS: 0.191
MAX RADIUS: 1.229
MEAN RADIUS: 0.662
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.289	-0.188
2:	0.559	0.070
3:	0.116	0.766
4:	-0.415	0.690
5:	-0.243	0.454
6:	-0.527	0.117
7:	0.119	-0.201
8:	-0.008	-0.425
9:	0.056	-0.754
10:	-0.221	-0.684



TARGET APPROX 1/2 SCALE