

G-6590114

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



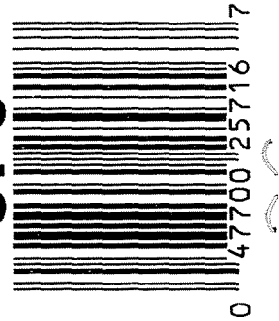
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6590114

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590 114

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	BLC
420	ASSEMBLE ACTION		10-7-06	BLC
430	ASSEMBLE TO STOCK		10-7-06	W.P
440	PROOF		10-7-06	TRW
460	CHECK HEADSPACE		10-7-06	TRW
470	DIS-ASSEMBLE ACTION		10-9-06	RTZ
480	MAGNAFLUX BBL ACTION		10/12/06	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10-10-06	CW
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-13-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/16	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		10-21-06	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-21-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-21-06	SD
	D) OIL FIRING PIN ASSEMBLY		10-24-06	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>7.5</u> <u>6.5</u> <u>6.5</u>	<u>11/13/06</u>	<u>MTM</u>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	<u>11/13/06</u>	<u>MTM</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	<u>11/13/06</u>	<u>MTM</u>
	J) ASSEMBLE STOCK		<u>10-24-06</u>	<u>BLC</u>
	K) ASSEMBLE SWIVEL STUDS		<u>11-15-06</u>	<u>L.P.D.</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>10-24-06</u>	<u>BLC</u>
	M) IRON SIGHT ALIGNMENT		<u>10-24-06</u>	<u>BLC</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>10-24-06</u>	<u>BLC</u>
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	<u>10-25-06</u>	<u>TRW</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		<u>10/25/06</u>	<u>WR</u>
670	FINAL INSPECTION A) HEADSPACE		<u>11-15-06</u>	<u>L.P.D.</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.44</u> <u>2.63</u> <u>2.27</u> <u>2.21</u> <u>2.50</u>	<u>11/10/06</u>	<u>MTM</u>
	C) FUNCTION		<u>11-15-06</u>	<u>L.P.D.</u>
690	PACK		<u>12-2-06</u>	<u>PA</u>

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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 10-16-06

TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.44	2.13		2.25	
PULL #2	2.54	2.20		2.23	
PULL #3	2.46	2.18		2.31	
PULL #4	2.59	2.17		2.29	
PULL #5	2.41	2.20		2.23	
TOTAL	1244	1088		1131	
AVERAGE	248	217		226	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.14		
PULL #2	3.15	3.17		
PULL #3	3.18	3.11		
PULL #4	3.18	3.15		
PULL #5	3.11	3.11		
TOTAL	1573	1568		
AVERAGE	314	313		

	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	4.14	4.19		4.13
PULL #2	4.11	4.22		4.11
PULL #3	4.10	4.11		4.14
PULL #4	4.06	4.18		4.09
PULL #5	4.08	4.11		4.11
TOTAL	2049	2081		2058
AVERAGE	409	416		411

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590114.___0

FILE DATE AND TIME: 10/26/2006 06:15

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

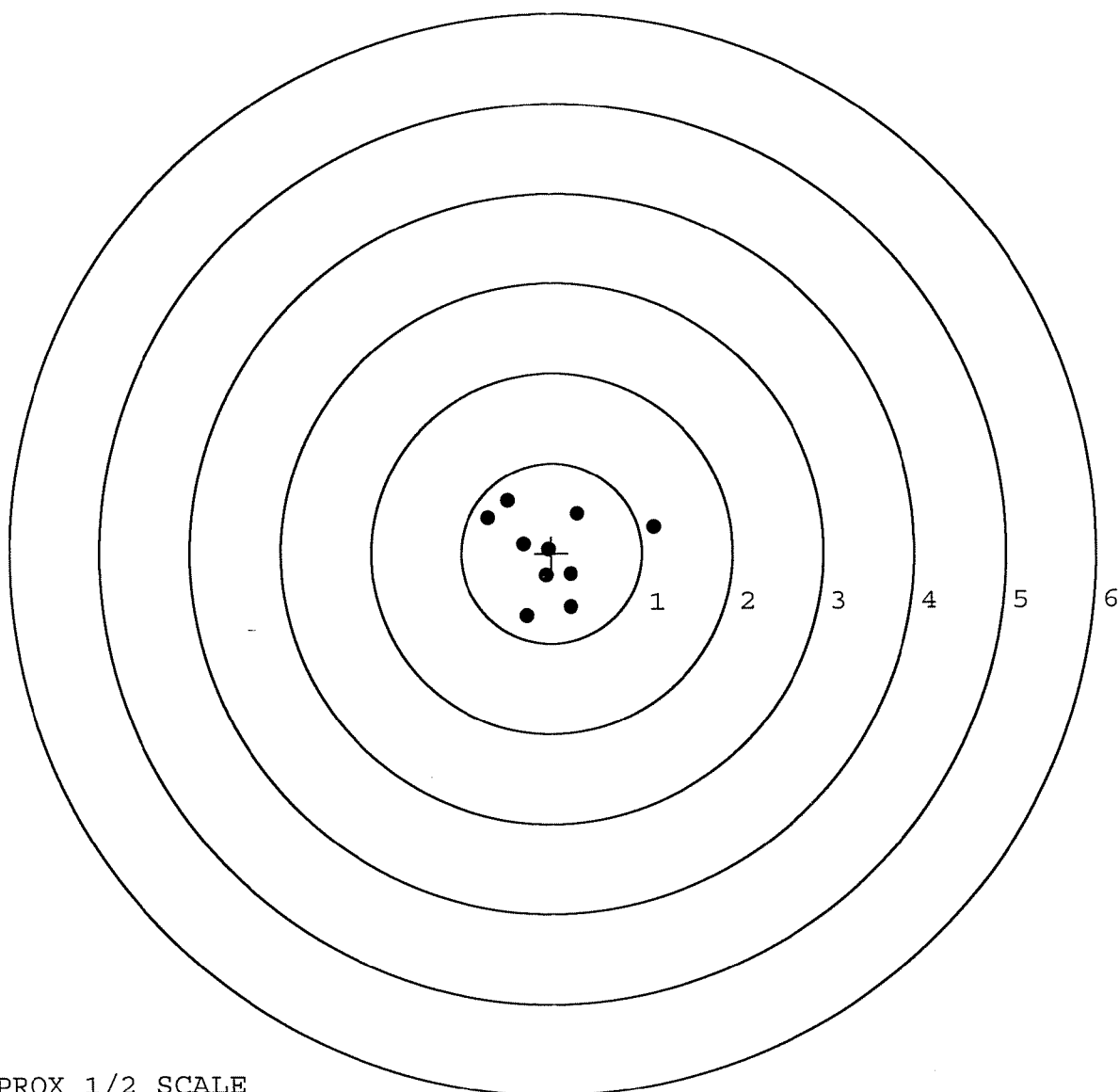
The Average X Centroid of the Five Target Set:	0.002
The Average Y Centroid of the Five Target Set:	-0.084
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.743
The Distance from POA to Centroid Target #1:	0.006
The Distance from Centroid Target #2 to Centroid Target #1:	0.327
The Distance from Centroid Target #3 to Centroid Target #1:	0.124
The Distance from Centroid Target #4 to Centroid Target #1:	0.295
The Distance from Centroid Target #5 to Centroid Target #1:	0.097

SERIAL NUMBER: G6590114. __0
TARGET NUMBER: 1
FILE DATE: 10/26/2006
FILE TIME: 06:15

X CENTROID: -0.001
Y CENTROID: 0.006
POA TO CENTROID: 0.006
HORZ SPREAD: 1.835
VERT SPREAD: 1.294
GROUP SPREAD: 1.839
MIN RADIUS: 0.053
MAX RADIUS: 1.167
MEAN RADIUS: 0.562

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.133	0.283
2:	0.288	0.440
3:	-0.481	0.588
4:	-0.702	0.398
5:	-0.308	0.105
6:	-0.036	0.046
7:	-0.061	-0.248
8:	0.218	-0.238
9:	0.217	-0.607
10:	-0.275	-0.706

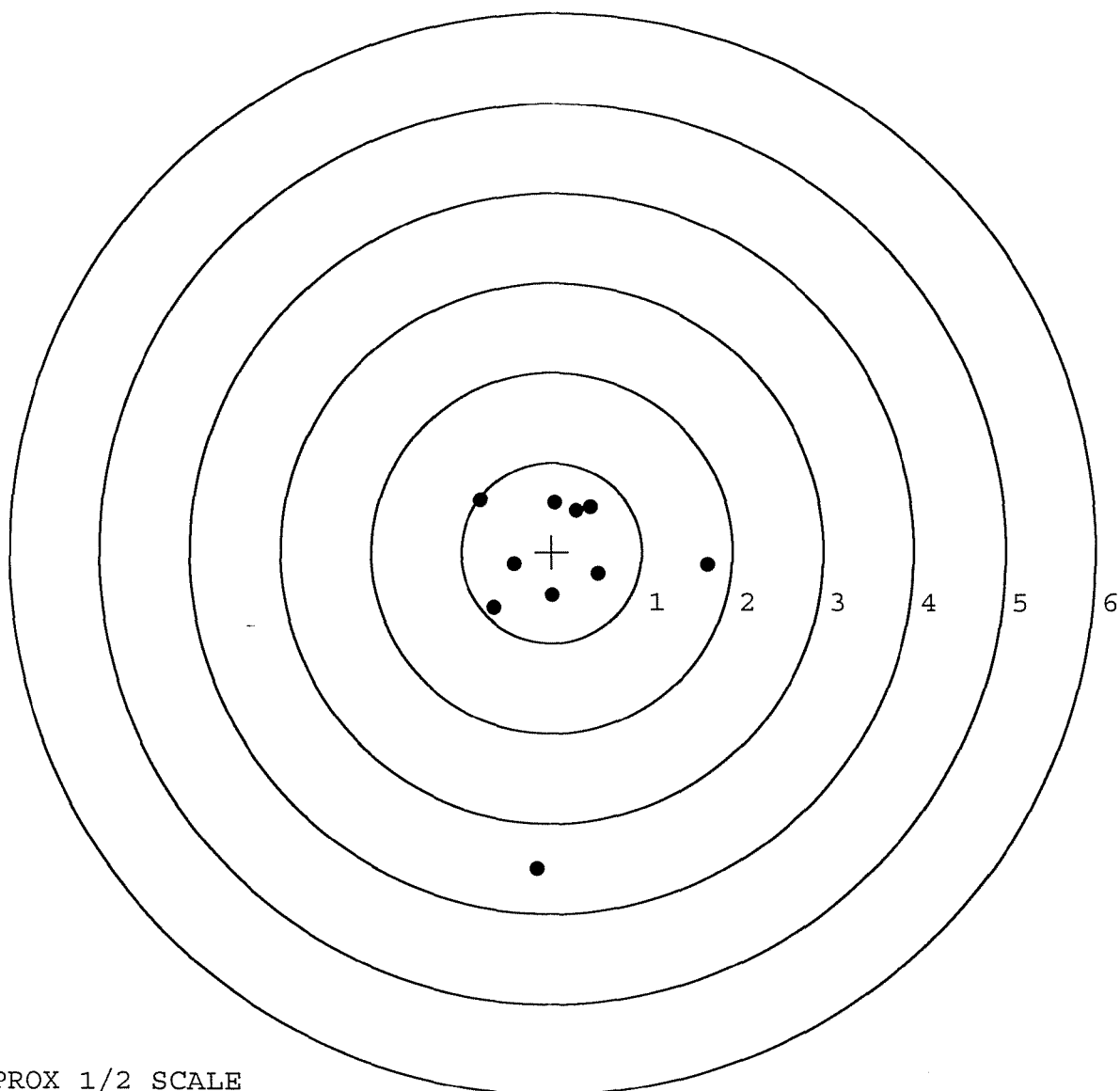


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590114. __0
TARGET NUMBER: 2
FILE DATE: 10/26/2006
FILE TIME: 06:15

POINT#	X	Y
1:	1.733	-0.142
2:	0.523	-0.243
3:	0.011	-0.481
4:	-0.634	-0.620
5:	-0.408	-0.140
6:	0.440	0.505
7:	0.277	0.466
8:	0.034	0.552
9:	-0.789	0.578
10:	-0.153	-3.519

X CENTROID: 0.103
Y CENTROID: -0.304
POA TO CENTROID: 0.321
HORZ SPREAD: 2.522
VERT SPREAD: 4.097
GROUP SPREAD: 4.146
MIN RADIUS: 0.199
MAX RADIUS: 3.225
MEAN RADIUS: 1.061
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

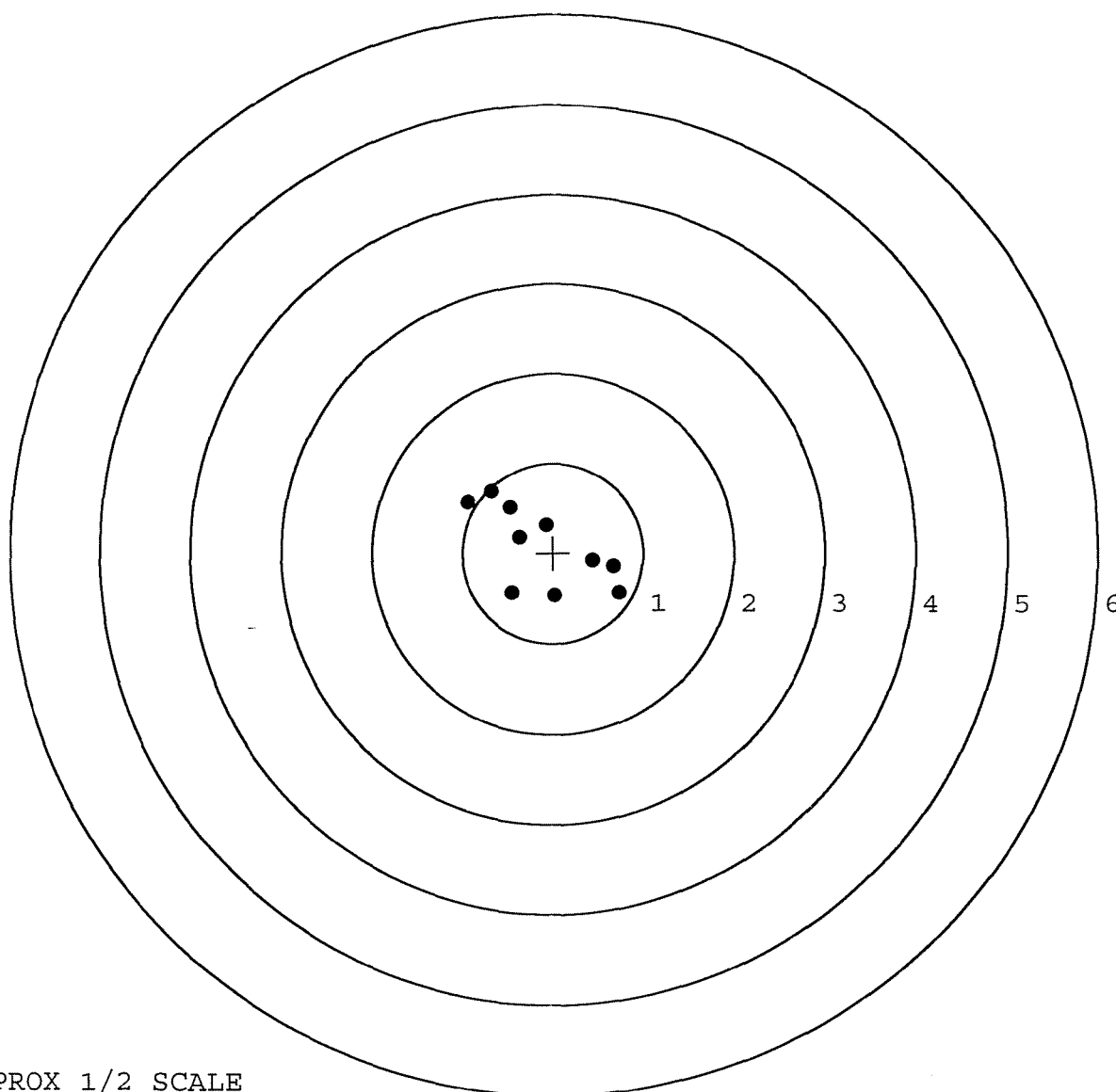


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590114. __0
TARGET NUMBER: 3
FILE DATE: 10/26/2006
FILE TIME: 06:15

POINT#	X	Y
1:	-0.452	-0.441
2:	0.023	-0.476
3:	0.739	-0.443
4:	0.680	-0.149
5:	0.446	-0.081
6:	-0.075	0.310
7:	-0.372	0.177
8:	-0.469	0.511
9:	-0.680	0.681
10:	-0.943	0.562

X CENTROID: -0.110
Y CENTROID: 0.065
POA TO CENTROID: 0.128
HORZ SPREAD: 1.682
VERT SPREAD: 1.157
GROUP SPREAD: 1.959
MIN RADIUS: 0.247
MAX RADIUS: 0.990
MEAN RADIUS: 0.646
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



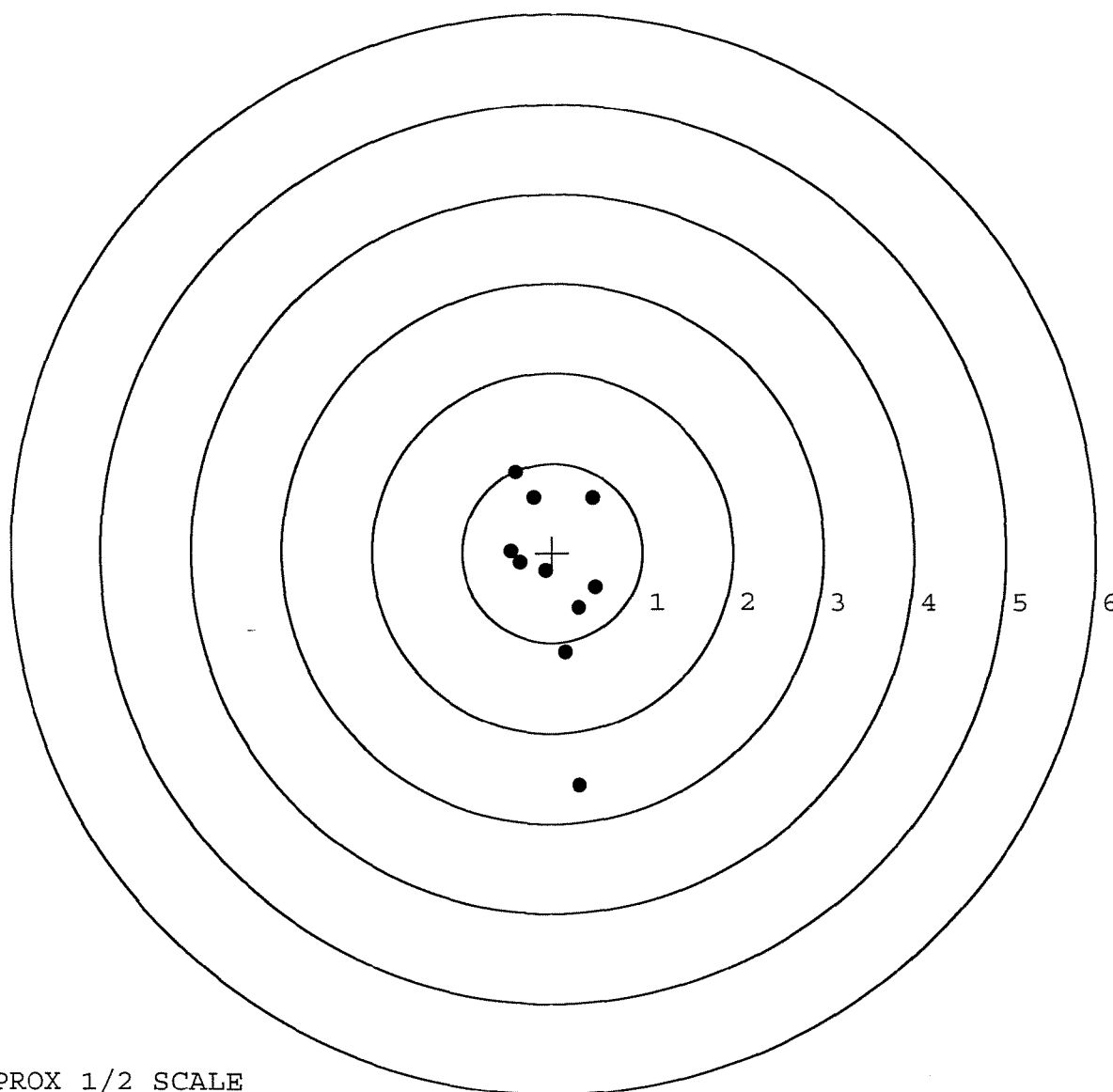
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590114.___0
 TARGET NUMBER: 4
 FILE DATE: 10/26/2006
 FILE TIME: 06:15

X CENTROID: 0.019
 Y CENTROID: -0.288
 POA TO CENTROID: 0.289
 HORZ SPREAD: 0.946
 VERT SPREAD: 3.476
 GROUP SPREAD: 3.552
 MIN RADIUS: 0.125
 MAX RADIUS: 2.313
 MEAN RADIUS: 0.836

IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.412	0.894
2:	-0.212	0.615
3:	0.450	0.611
4:	-0.460	0.019
5:	-0.358	-0.114
6:	-0.076	-0.206
7:	0.486	-0.391
8:	0.300	-0.623
9:	0.151	-1.107
10:	0.317	-2.582



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590114. __0
TARGET NUMBER: 5
FILE DATE: 10/26/2006
FILE TIME: 06:15

POINT#	X	Y
1:	-0.730	0.711
2:	-0.447	0.697
3:	0.952	0.654
4:	0.577	0.135
5:	0.393	-1.033
6:	0.194	-0.168
7:	-0.033	-0.127
8:	-0.036	0.098
9:	-0.407	-0.103
10:	-0.472	0.170

X CENTROID: -0.001
Y CENTROID: 0.103
POA TO CENTROID: 0.103
HORZ SPREAD: 1.682
VERT SPREAD: 1.744
GROUP SPREAD: 2.074
MIN RADIUS: 0.036
MAX RADIUS: 1.203
MEAN RADIUS: 0.611
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

