

G6590154

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



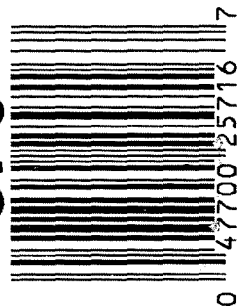
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590154

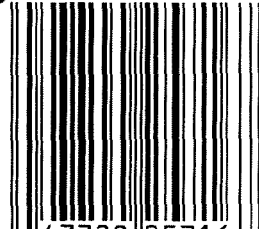
UPC



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

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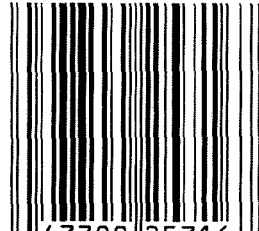


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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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SERIAL NO.



66590154

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590154

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		8-24-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 01 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <i>unn</i>	9/1/06	<i>unn</i>
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)		9/8/06	<i>CB</i>
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-11-06	BLG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-11-06	BLG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-11-06	BLG
	D) OIL FIRING PIN ASSEMBLY		9-13-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/11/06	<i>unn</i>

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.0</u> <u>7.0</u> <u>7.0</u>	9-14-06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	9-14-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	nm
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	9-14-06	DA
	J) ASSEMBLE STOCK		9-13-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/11/06	nm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-13-06	BLG
	M) IRON SIGHT ALIGNMENT		9-13-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-13-06	BLG
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	9-13-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-13-06	BD
670	FINAL INSPECTION A) HEADSPACE		10/11/06	nm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.46</u> <u>2.56</u> <u>2.33</u> <u>2.48</u>	9-14-06	DA
	C) FUNCTION		10/11/06	nm
690	PACK		11/7/06	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 9-9-06

TESTER MTM

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.41	2.83	2.60	
PULL #2	2.62	2.76	2.36	
PULL #3	2.35	2.60	2.64	
PULL #4	2.58	2.79	2.39	
PULL #5	2.73	2.79	2.46	
TOTAL	12.69	13.77	12.45	
AVERAGE	2.54	2.75	2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	2.93	2.90	
PULL #2	2.80	3.17	
PULL #3	3.03	3.26	
PULL #4	2.93	3.17	
PULL #5	2.97	2.58	
TOTAL	14.66	15.08	
AVERAGE	2.93	3.02	

	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	4.22	4.06		4.21
PULL #2	4.24	4.31		4.29
PULL #3	4.17	4.28		4.01
PULL #4	4.14	3.89		4.13
PULL #5	4.05	3.63		4.26
TOTAL	20.82	20.17		20.90
AVERAGE	4.16	4.03		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590154.__0

FILE DATE AND TIME: 09/14/2006 01:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.040
The Average Y Centroid of the Five Target Set:	-0.130
The Average Point of Impact of the Five Target Set:	0.136
The Average Mean Radius of the Five Target Set:	0.705
The Distance from POA to Centroid Target #1:	0.175
The Distance from Centroid Target #2 to Centroid Target #1:	0.342
The Distance from Centroid Target #3 to Centroid Target #1:	0.398
The Distance from Centroid Target #4 to Centroid Target #1:	0.458
The Distance from Centroid Target #5 to Centroid Target #1:	0.376

SERIAL NUMBER: G6590154. __0

TARGET NUMBER: 1

FILE DATE: 09/14/2006

FILE TIME: 01:47

POINT#	X	Y
1:	-0.910	1.843
2:	0.417	1.593
3:	0.625	1.042
4:	0.345	0.075
5:	0.403	-0.216
6:	0.454	-0.420
7:	0.483	-0.713
8:	-0.027	-0.780
9:	-0.514	-0.675
10:	-0.720	-0.094

X CENTROID: 0.056

Y CENTROID: 0.166

POA TO CENTROID: 0.175

HORZ SPREAD: 1.535

VERT SPREAD: 2.623

GROUP SPREAD: 2.911

MIN RADIUS: 0.303

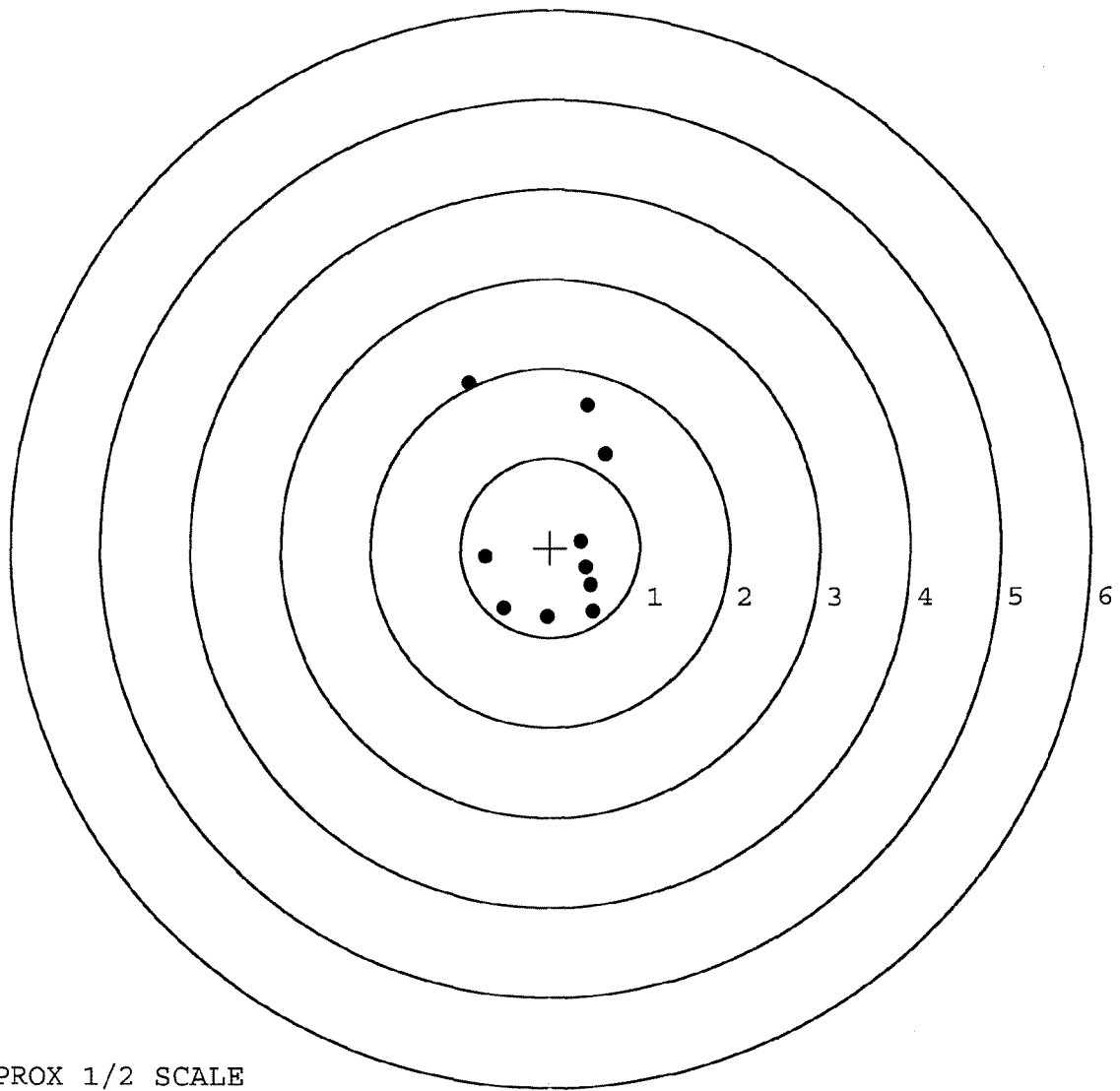
MAX RADIUS: 1.936

MEAN RADIUS: 0.974

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

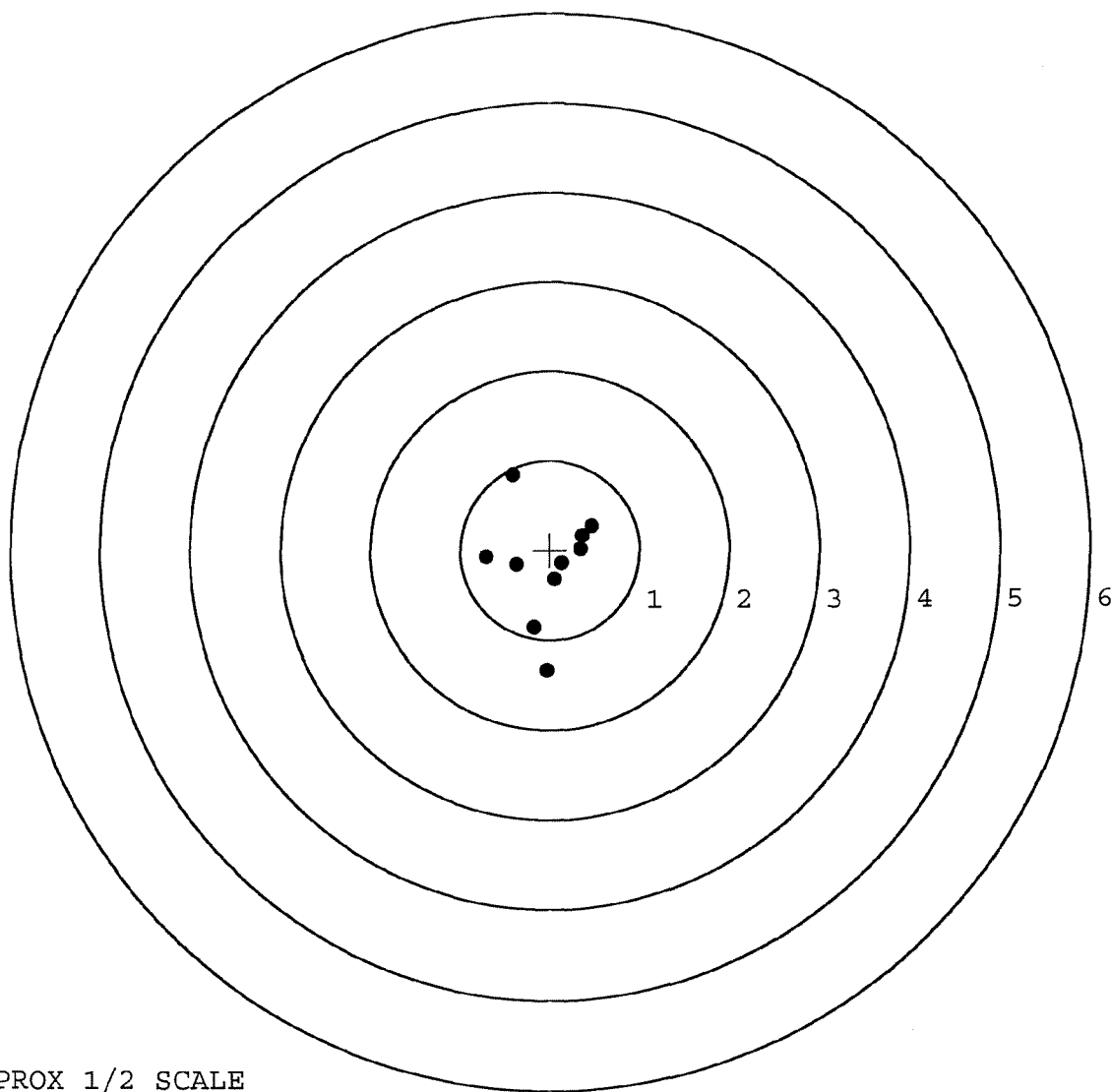
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590154. __0
TARGET NUMBER: 2
FILE DATE: 09/14/2006
FILE TIME: 01:47

	POINT#	X	Y
	1:	-0.408	0.844
	2:	0.467	0.269
	3:	0.341	0.014
	4:	0.055	-0.329
	5:	-0.710	-0.077
	6:	-0.368	-0.165
	7:	-0.174	-0.871
	8:	-0.030	-1.348
	9:	0.139	-0.148
	10:	0.362	0.164
X CENTROID:		-0.033	
Y CENTROID:		-0.165	
POA TO CENTROID:		0.168	
HORZ SPREAD:		1.177	
VERT SPREAD:		2.192	
GROUP SPREAD:		2.224	
MIN RADIUS:		0.172	
MAX RADIUS:		1.183	
MEAN RADIUS:		0.595	
# IN 1 IN DIAMETER:		4	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		10	

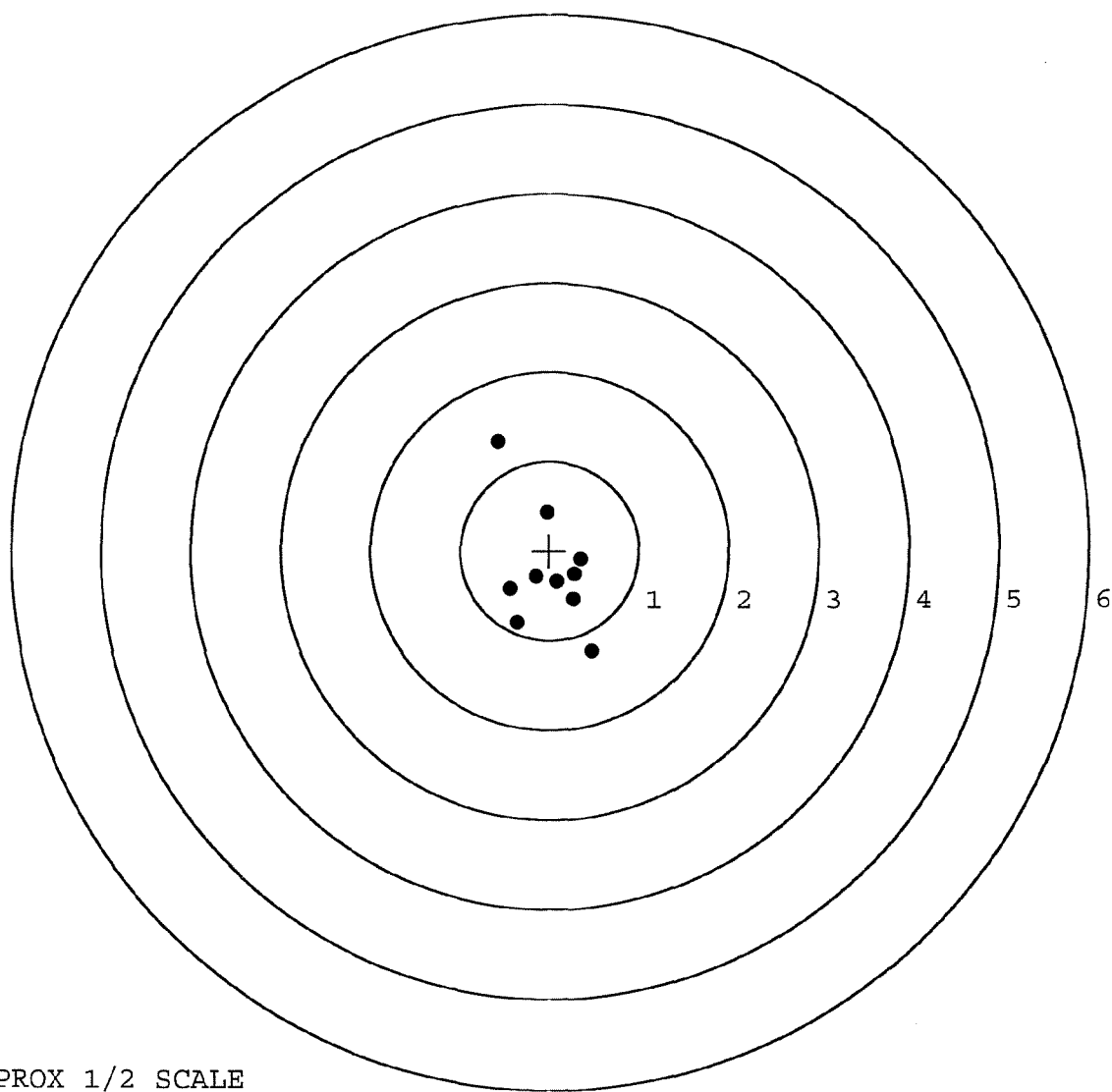


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590154. __0
TARGET NUMBER: 3
FILE DATE: 09/14/2006
FILE TIME: 01:47

X CENTROID: -0.010
Y CENTROID: -0.227
POA TO CENTROID: 0.227
HORZ SPREAD: 1.046
VERT SPREAD: 2.335
GROUP SPREAD: 2.559
MIN RADIUS: 0.154
MAX RADIUS: 1.548
MEAN RADIUS: 0.580
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

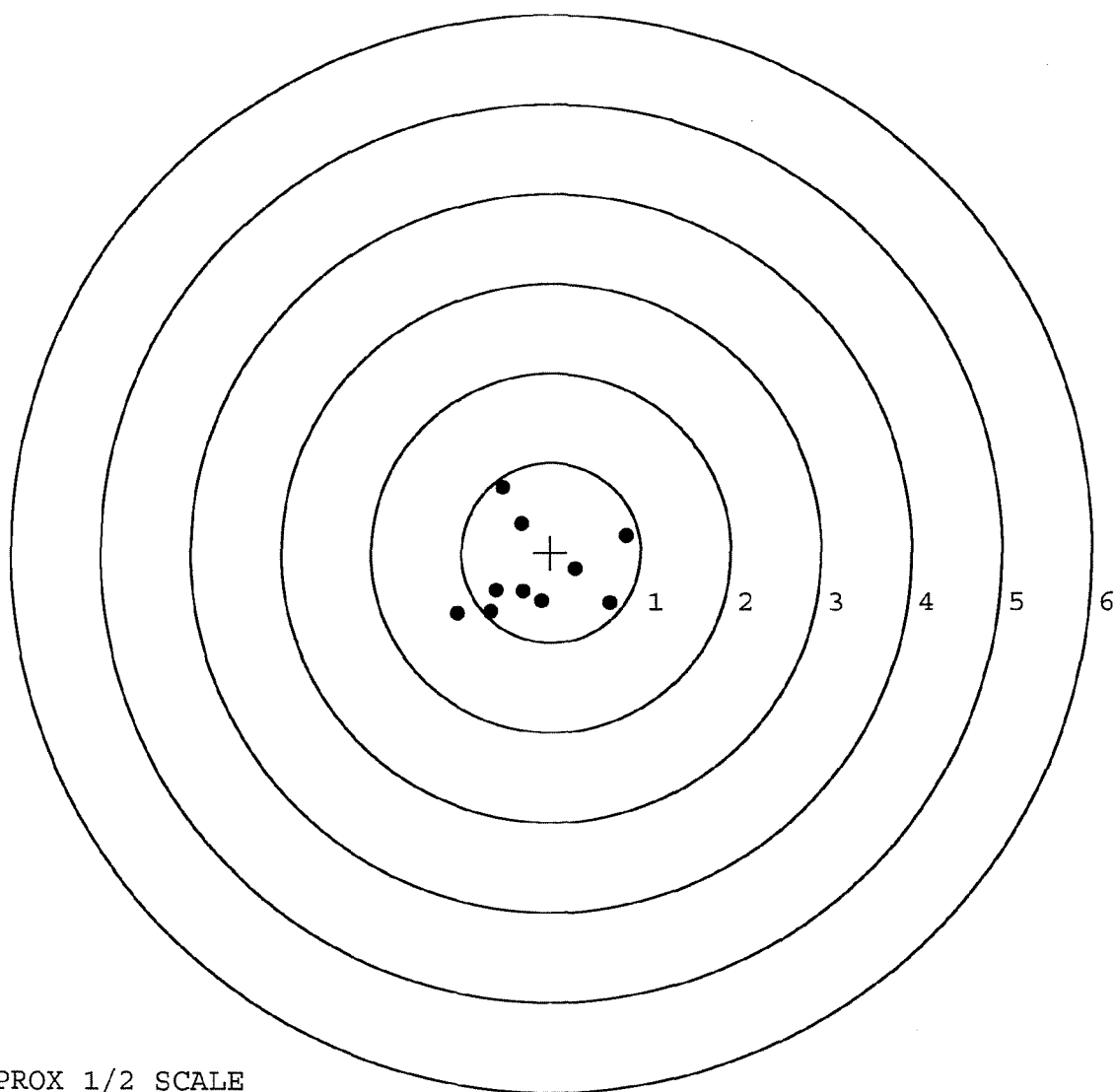
POINT#	X	Y
1:	-0.575	1.214
2:	-0.029	0.431
3:	0.471	-1.121
4:	-0.363	-0.813
5:	-0.445	-0.431
6:	-0.148	-0.297
7:	0.086	-0.347
8:	0.272	-0.543
9:	0.284	-0.266
10:	0.349	-0.094



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590154. __0
TARGET NUMBER: 4
FILE DATE: 09/14/2006
FILE TIME: 01:47

	POINT#	X	Y
	1:	-0.534	0.725
	2:	-0.333	0.319
	3:	-1.044	-0.682
	4:	-0.670	-0.655
X CENTROID:	5:	-0.611	-0.423
Y CENTROID:	6:	-0.310	-0.436
POA TO CENTROID:	7:	-0.102	-0.541
HORZ SPREAD:	8:	0.276	-0.182
VERT SPREAD:	9:	0.839	0.185
GROUP SPREAD:	10:	0.662	-0.565
MIN RADIUS:		0.246	
MAX RADIUS:		1.101	
MEAN RADIUS:		0.672	
# IN 1 IN DIAMETER:		4	
# IN 2 IN DIAMETER:		8	
# in 3 IN DIAMETER:		10	

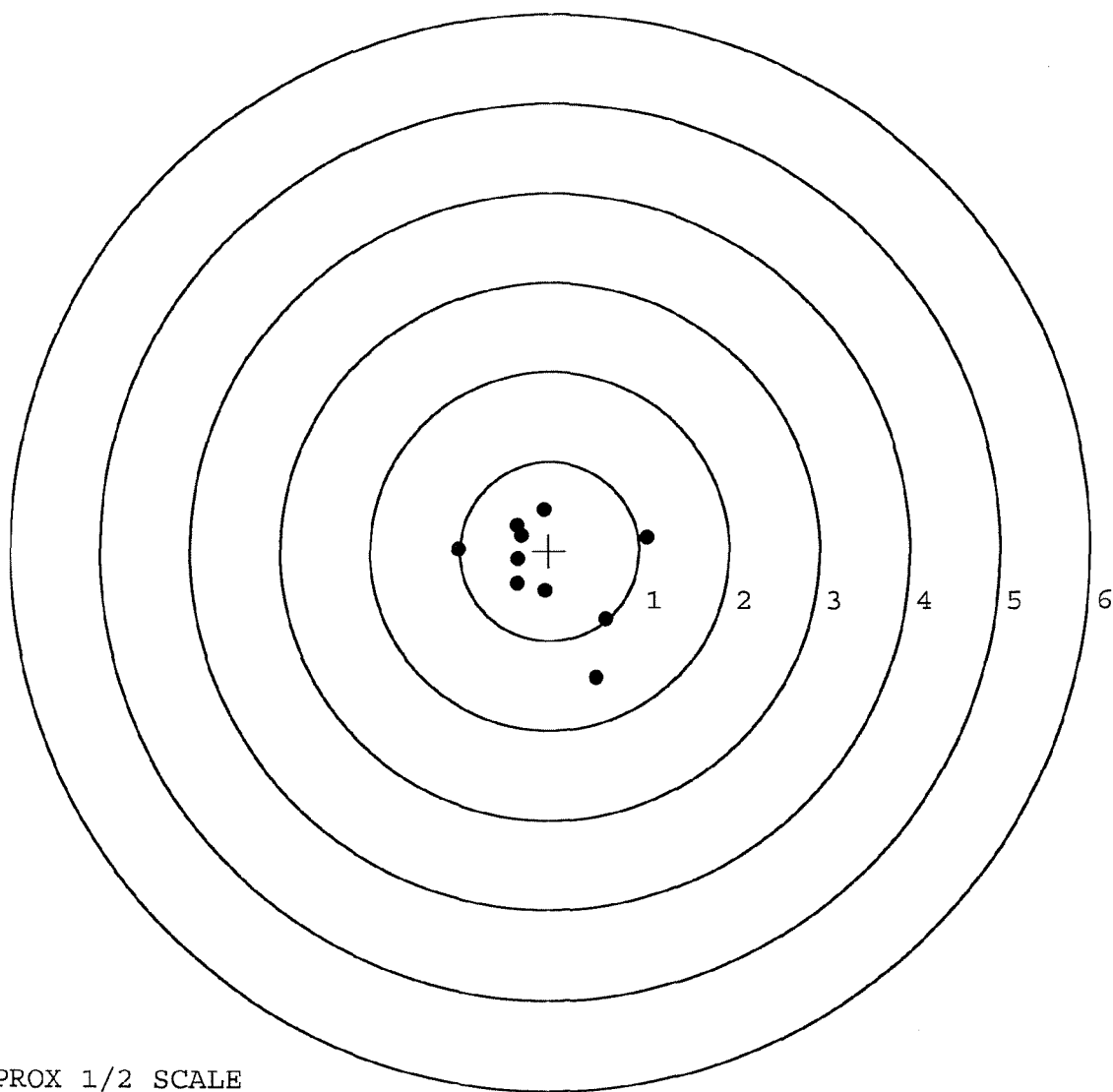


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590154. __0
TARGET NUMBER: 5
FILE DATE: 09/14/2006
FILE TIME: 01:47

POINT#	X	Y
1:	1.084	0.150
2:	0.631	-0.762
3:	0.528	-1.419
4:	-0.053	-0.447
5:	-0.358	-0.372
6:	-0.352	-0.096
7:	-0.318	0.170
8:	-0.365	0.281
9:	-0.065	0.465
10:	-1.016	0.020

X CENTROID: -0.028
Y CENTROID: -0.201
POA TO CENTROID: 0.203
HORZ SPREAD: 2.100
VERT SPREAD: 1.884
GROUP SPREAD: 2.111
MIN RADIUS: 0.247
MAX RADIUS: 1.339
MEAN RADIUS: 0.707
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE