

G6590173

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



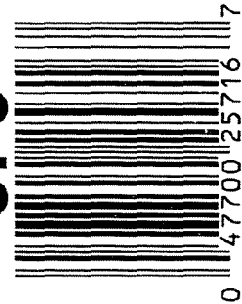
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590173

UPC



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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 # G6590173

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-6-06	RTL
420	ASSEMBLE ACTION		9-7-06	RTL
430	ASSEMBLE TO STOCK		9-7-06	ED
440	PROOF		9-7-06	TRW
460	CHECK HEADSPACE		9-7-06	TRW
470	DIS-ASSEMBLE ACTION		9-7-06	RTL
480	MAGNAFLUX BBL ACTION		9/11/06	unsub
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-11-06	CW
510	DRILL AND TAP SIGHT HOLES		9-11-06	TRW
520	GOFF BLAST BBL / REC		9-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/14/06	TRW
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-18-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-18-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-18-06	DA
	D) OIL FIRING PIN ASSEMBLY		9-19-06	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>7⁵</u> <u>7⁵</u> <u>7⁵</u>	10-2-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3⁵</u> <u>3⁵</u> <u>4⁰</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.027</u> <u>.026</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-19-06	BLC
	K) ASSEMBLE SWIVEL STUDS		11-8-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-19-06	BLC
	M) IRON SIGHT ALIGNMENT		9-19-06	BhG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-19-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-19-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-19-06	SD
670	FINAL INSPECTION A) HEADSPACE		11-8-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.24</u> <u>2.23</u> <u>2.20</u> <u>2.23</u>	9-20-06	DTA
	C) FUNCTION		11-8-06	L.P.D.
690	PACK		11-16-06	BLC

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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 9-18-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	255	253		231	
PULL #2	255	244		244	
PULL #3	241	245		241	
PULL #4	239	244		237	
PULL #5	262	238		231	
TOTAL	1252	1224		1184	
AVERAGE	250	244		236	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	303	308		
PULL #2	301	302		
PULL #3	303	302		
PULL #4	307	303		
PULL #5	293	303		
TOTAL	1507	1518		
AVERAGE	301	303		

	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	410	413		415
PULL #2	413	411		425
PULL #3	416	403		417
PULL #4	411	408		417
PULL #5	410	408		421
TOTAL	2060	2043		2095
AVERAGE	412	408		419

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590173.___0
FILE DATE AND TIME: 09/20/2006 06:00

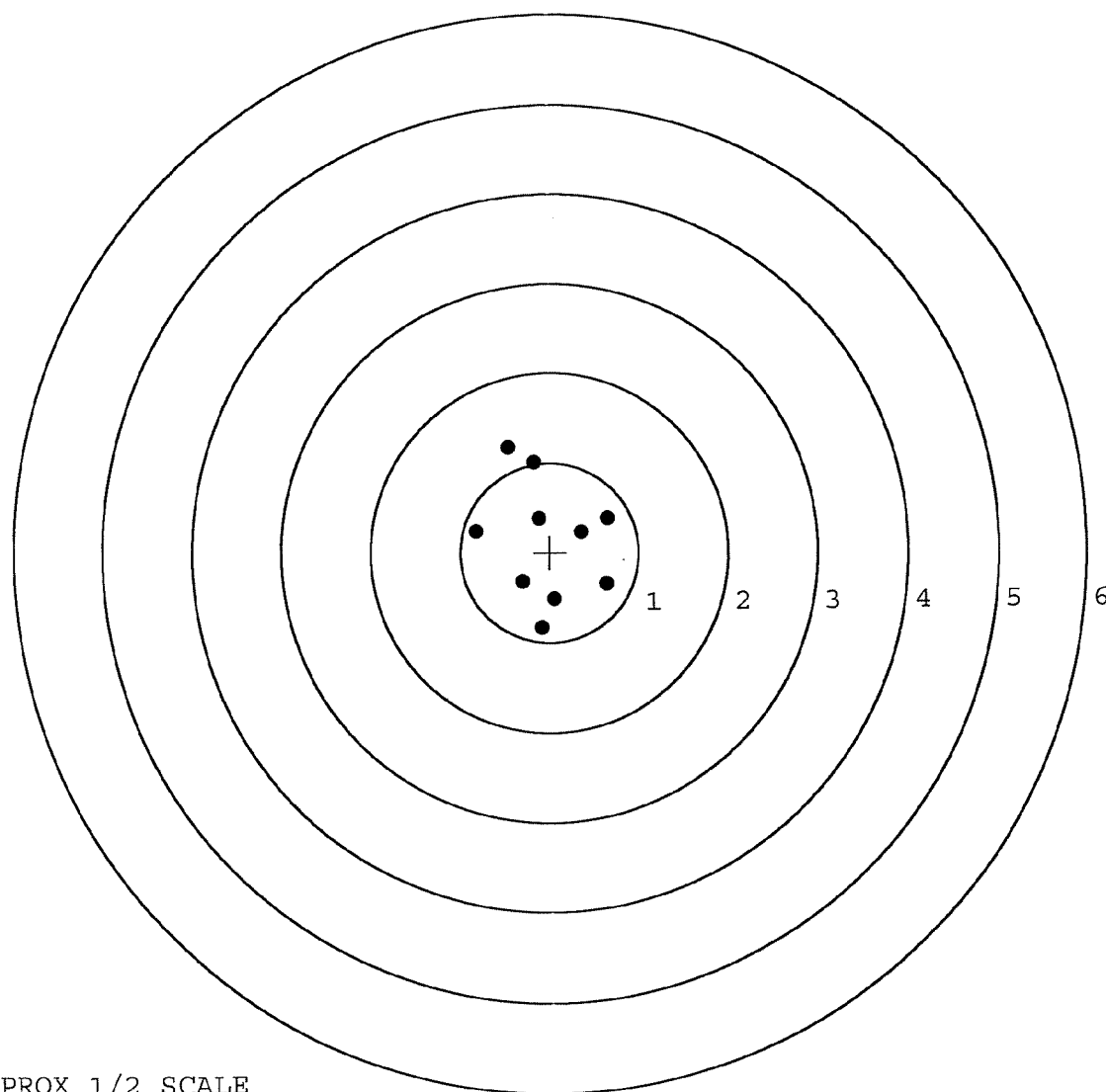
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.062
The Average Y Centroid of the Five Target Set:	-0.028
The Average Point of Impact of the Five Target Set:	0.068
The Average Mean Radius of the Five Target Set:	0.613
The Distance from POA to Centroid Target #1:	0.140
The Distance from Centroid Target #2 to Centroid Target #1:	0.262
The Distance from Centroid Target #3 to Centroid Target #1:	0.137
The Distance from Centroid Target #4 to Centroid Target #1:	0.243
The Distance from Centroid Target #5 to Centroid Target #1:	0.210

SERIAL NUMBER: G6590173. __0
TARGET NUMBER: 1
FILE DATE: 09/20/2006
FILE TIME: 06:00

X CENTROID: -0.029
Y CENTROID: 0.137
POA TO CENTROID: 0.140
HORZ SPREAD: 1.479
VERT SPREAD: 2.020
GROUP SPREAD: 2.052
MIN RADIUS: 0.261
MAX RADIUS: 1.123
MEAN RADIUS: 0.722
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.461	1.174
2:	-0.177	1.011
3:	-0.826	0.243
4:	-0.120	0.381
5:	0.360	0.229
6:	0.653	0.385
7:	0.637	-0.359
8:	-0.099	-0.846
9:	0.052	-0.520
10:	-0.309	-0.329

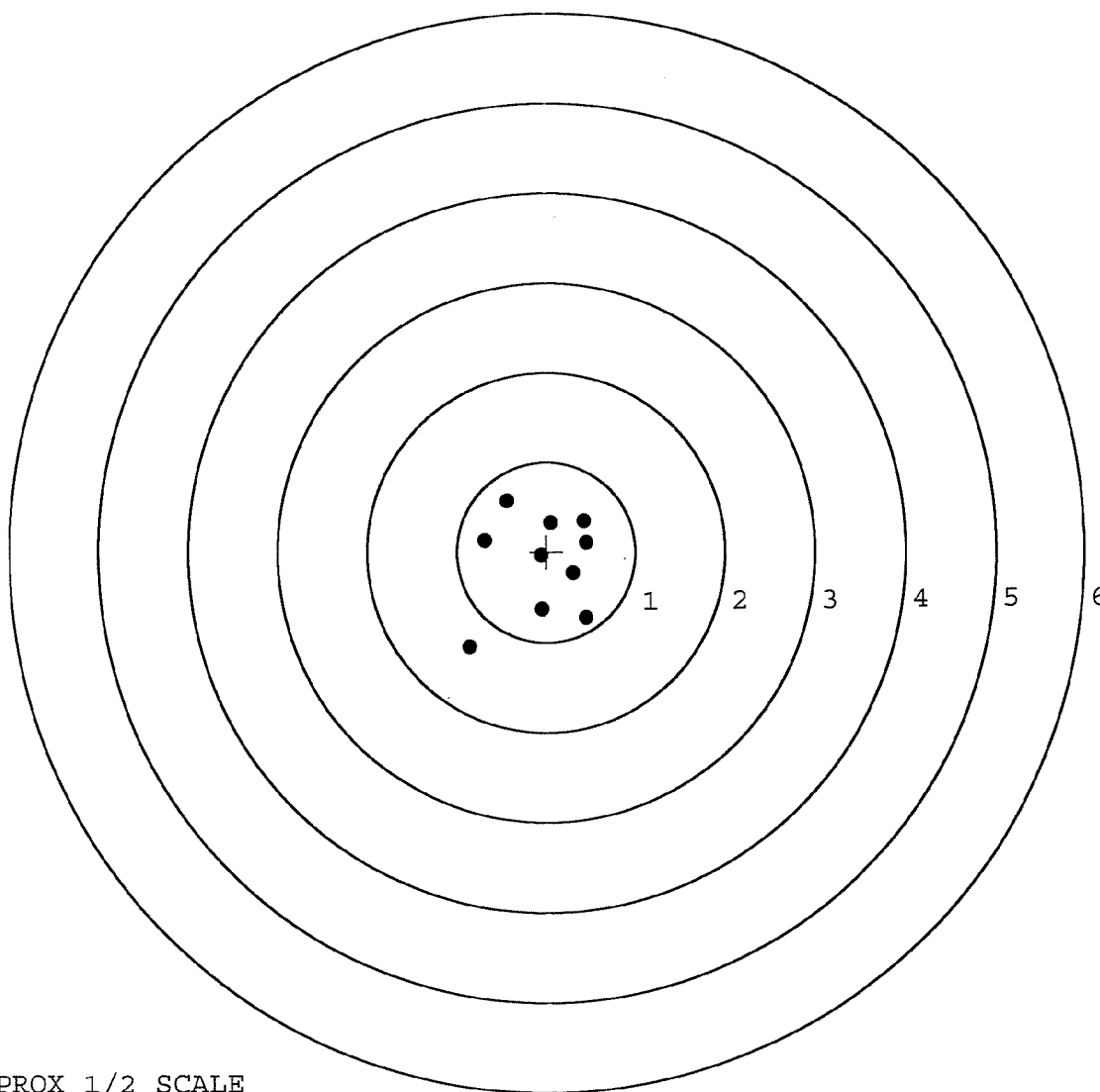


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590173. __0
TARGET NUMBER: 2
FILE DATE: 09/20/2006
FILE TIME: 06:00

X CENTROID: -0.046
Y CENTROID: -0.125
POA TO CENTROID: 0.133
HORZ SPREAD: 1.313
VERT SPREAD: 1.623
GROUP SPREAD: 1.897
MIN RADIUS: 0.085
MAX RADIUS: 1.235
MEAN RADIUS: 0.614
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.862	-1.052
2:	-0.058	-0.640
3:	0.441	-0.738
4:	-0.691	0.127
5:	-0.442	0.571
6:	-0.066	-0.042
7:	0.297	-0.241
8:	0.451	0.103
9:	0.425	0.341
10:	0.048	0.321

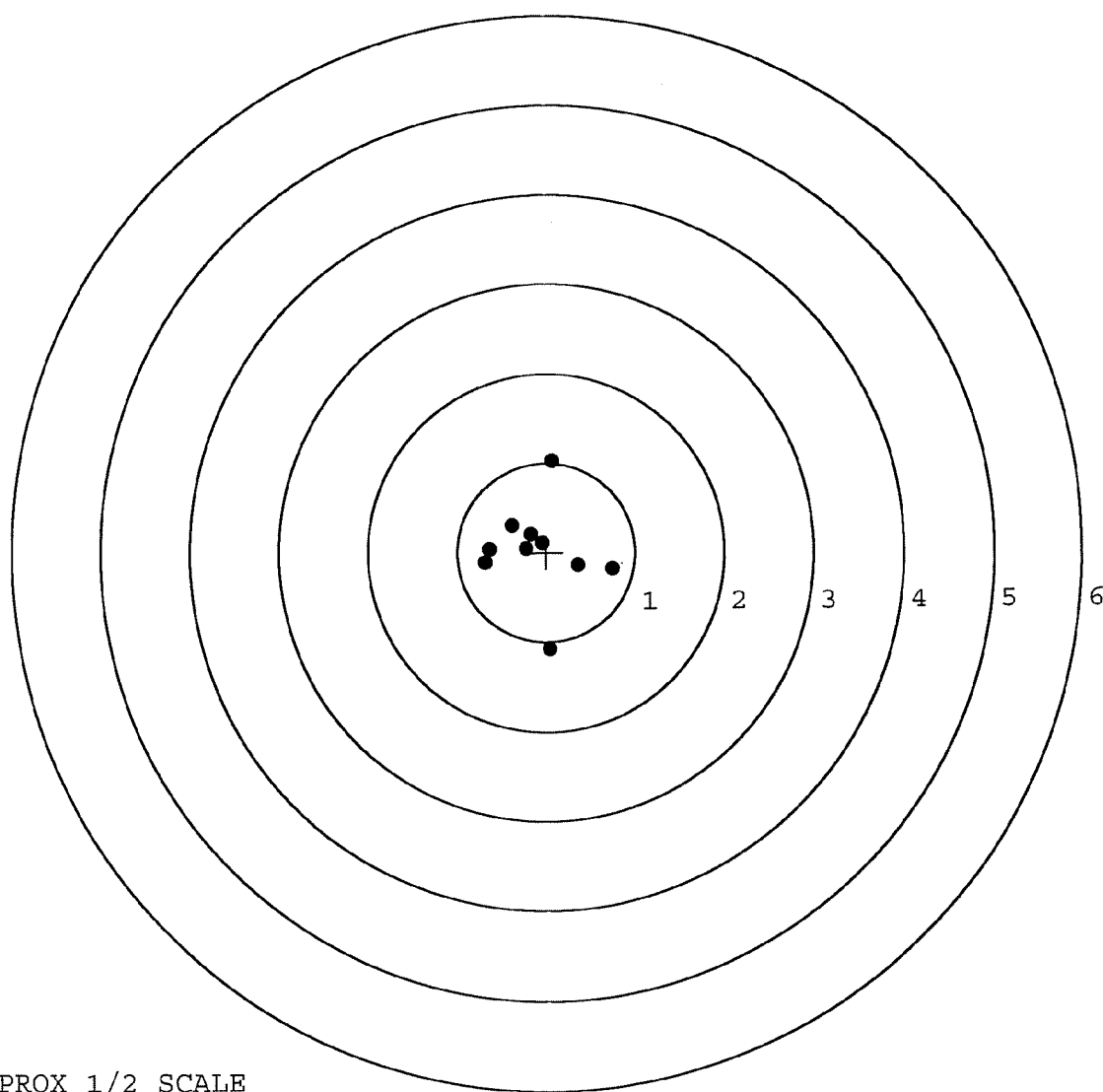


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590173. __0
TARGET NUMBER: 3
FILE DATE: 09/20/2006
FILE TIME: 06:00

X CENTROID: -0.097
Y CENTROID: 0.018
POA TO CENTROID: 0.099
HORZ SPREAD: 1.434
VERT SPREAD: 2.101
GROUP SPREAD: 2.101
MIN RADIUS: 0.099
MAX RADIUS: 1.107
MEAN RADIUS: 0.547
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.039	-1.080
2:	0.744	-0.193
3:	0.355	-0.149
4:	0.071	1.021
5:	-0.690	-0.116
6:	-0.644	0.036
7:	-0.052	0.106
8:	-0.229	0.045
9:	-0.387	0.305
10:	-0.179	0.206



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590173. __0

TARGET NUMBER: 4

FILE DATE: 09/20/2006

FILE TIME: 06:00

X CENTROID: -0.073

Y CENTROID: -0.102

POA TO CENTROID: 0.126

HORZ SPREAD: 1.941

VERT SPREAD: 1.588

GROUP SPREAD: 2.113

MIN RADIUS: 0.162

MAX RADIUS: 1.247

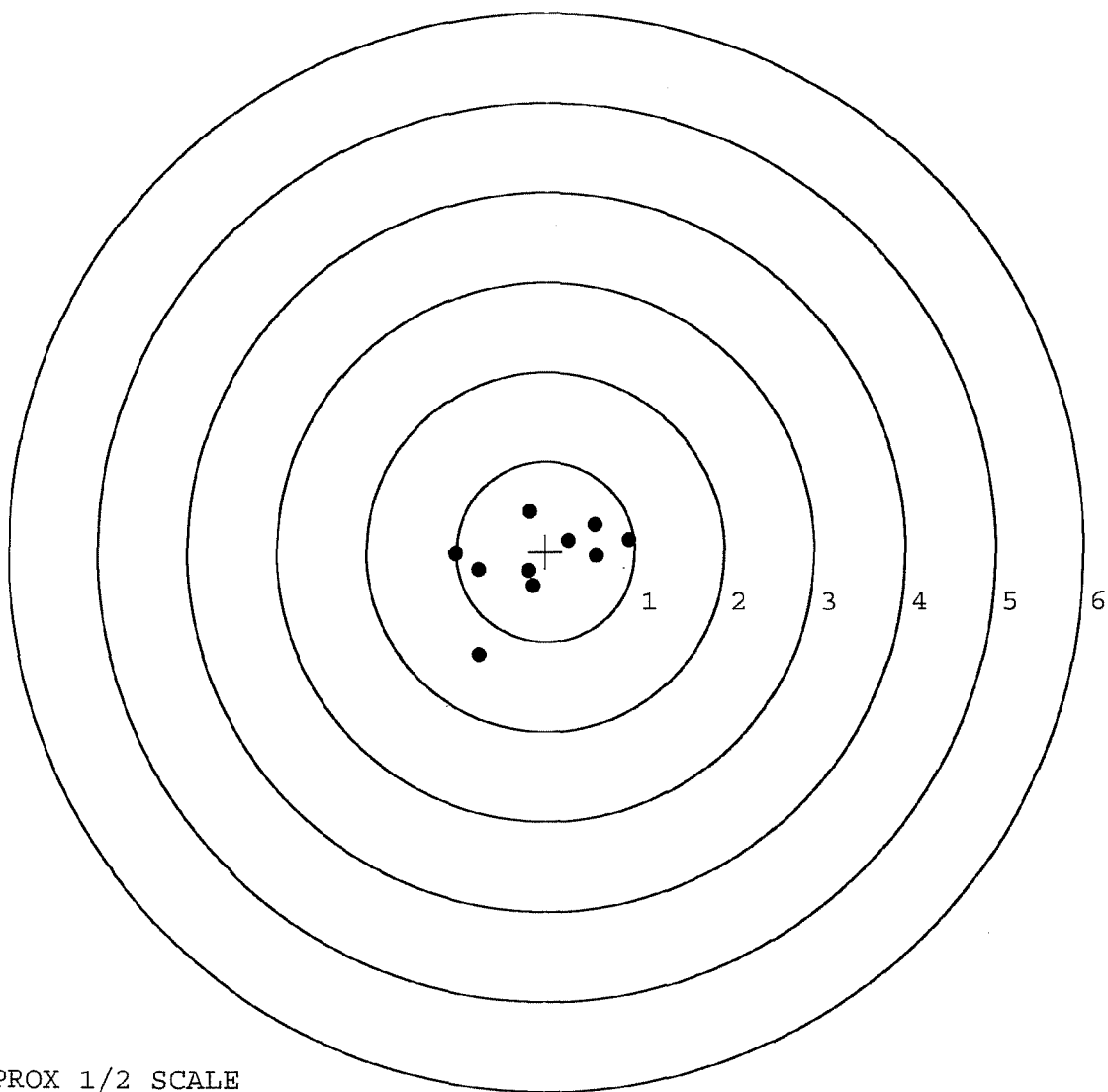
MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.753	-1.148
2:	-0.753	-0.200
3:	-1.013	-0.025
4:	-0.141	-0.385
5:	-0.189	-0.215
6:	-0.185	0.440
7:	0.928	0.132
8:	0.571	-0.044
9:	0.251	0.123
10:	0.552	0.299



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590173. __ 0

TARGET NUMBER: 5

FILE DATE: 09/20/2006

FILE TIME: 06:00

X CENTROID: -0.065

Y CENTROID: -0.070

POA TO CENTROID: 0.095

HORZ SPREAD: 1.131

VERT SPREAD: 1.801

GROUP SPREAD: 1.897

MIN RADIUS: 0.101

MAX RADIUS: 0.969

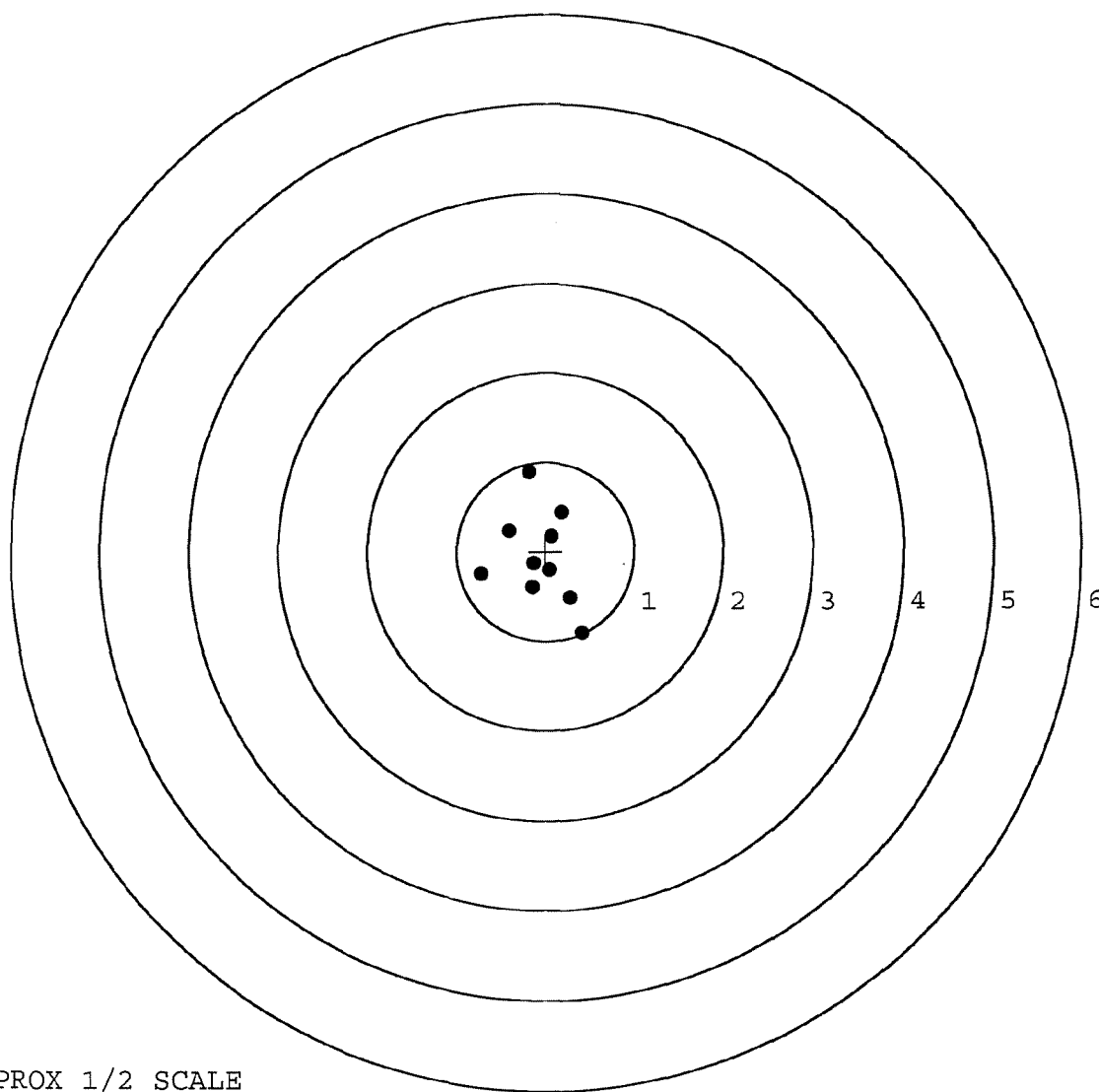
MEAN RADIUS: 0.510

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.408	-0.910
2:	-0.723	-0.248
3:	-0.417	0.227
4:	-0.189	0.891
5:	0.180	0.442
6:	0.069	0.169
7:	-0.139	-0.138
8:	-0.152	-0.406
9:	0.274	-0.516
10:	0.043	-0.207



TARGET APPROX 1/2 SCALE