

G-659 0200

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



DD FORM

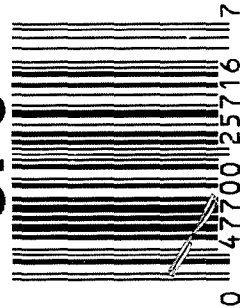
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590206

UPC



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



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590206

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-20-06	RTZ
420	ASSEMBLE ACTION		9-25-06	RTZ
430	ASSEMBLE TO STOCK		9-25-06	DC
440	PROOF		9-25-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-25-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 26 2006	9-25-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>unms</u>	9/26/06	unms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-27-06	OW
510	DRILL AND TAP SIGHT HOLES		9-26-06	TRW
520	GOFF BLAST BBL / REC		9-28-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/29/06	PS
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-2-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-2-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-2-06	DA
	D) OIL FIRING PIN ASSEMBLY		10-3-06	RLC
	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>69</u> <u>73</u> <u>79</u>	10-4-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>45</u> <u>49</u> <u>45</u>	10-4-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.025</u> <u>.027</u>	10-4-06	SP
	J) ASSEMBLE STOCK		10-3-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-6-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-3-06	BLG
	M) IRON SIGHT ALIGNMENT		10-3-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-3-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-3-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/3	CL
670	FINAL INSPECTION A) HEADSPACE		11-6-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.21</u> <u>2.25</u> <u>2.26</u> <u>2.27</u> <u>2.26</u>	10-4-06	SP
	C) FUNCTION		11-6-06	RTZ
690	PACK			

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 8-29-06

TESTER MJH

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.65		2.43	
PULL #2	2.54	2.54		2.59	
PULL #3	2.56	2.54		2.49	
PULL #4	2.62	2.45		2.55	
PULL #5	2.64	2.44		2.63	
TOTAL	12.82	12.65		12.69	
AVERAGE	2.56	2.53		2.54	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.13		
PULL #2	3.08	3.08		
PULL #3	3.07	3.15		
PULL #4	3.13	3.10		
PULL #5	3.10	3.20		
TOTAL	15.50	15.72		
AVERAGE	3.10	3.14		

	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	3.87		3.98
PULL #2	3.96	3.95		4.07
PULL #3	3.99	3.99		4.04
PULL #4	4.05	4.04		3.94
PULL #5	4.12	3.96		3.96
TOTAL	20.13	19.81		19.99
AVERAGE	4.03	3.96		4.00

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590206.__0
FILE DATE AND TIME: 10/04/2006 05:50

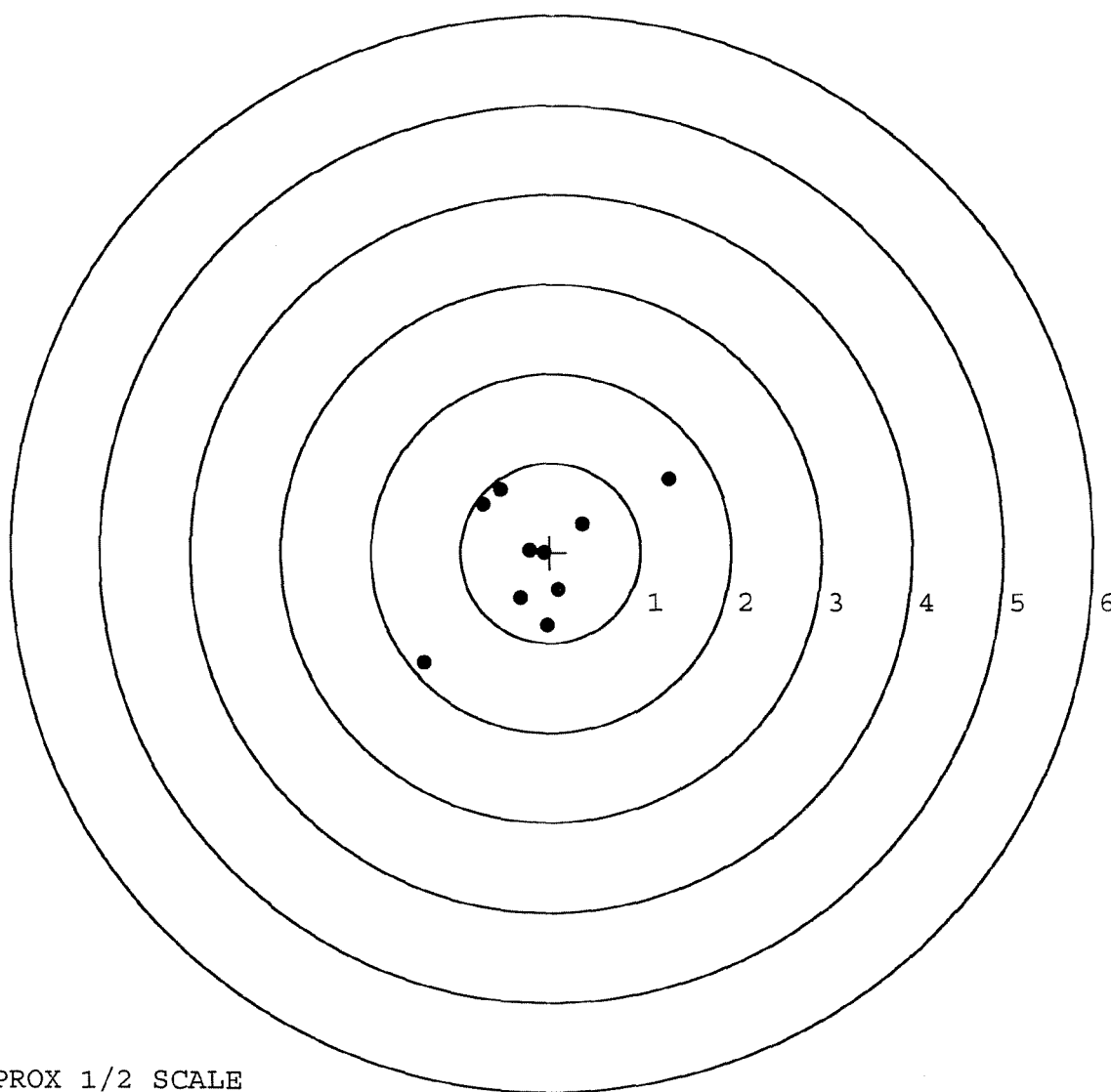
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.072
The Average Y Centroid of the Five Target Set:	0.035
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.716
The Distance from POA to Centroid Target #1:	0.171
The Distance from Centroid Target #2 to Centroid Target #1:	0.221
The Distance from Centroid Target #3 to Centroid Target #1:	0.197
The Distance from Centroid Target #4 to Centroid Target #1:	0.162
The Distance from Centroid Target #5 to Centroid Target #1:	0.146

SERIAL NUMBER: G6590206. __0
TARGET NUMBER: 1
FILE DATE: 10/04/2006
FILE TIME: 05:50

POINT#	X	Y
1:	-1.403	-1.223
2:	-0.038	-0.812
3:	-0.330	-0.507
4:	0.099	-0.414
5:	-0.073	0.005
6:	-0.227	0.031
7:	0.355	0.319
8:	-0.564	0.704
9:	-0.751	0.535
10:	1.309	0.817

X CENTROID: -0.162
Y CENTROID: -0.055
POA TO CENTROID: 0.171
HORZ SPREAD: 2.712
VERT SPREAD: 2.040
GROUP SPREAD: 3.394
MIN RADIUS: 0.107
MAX RADIUS: 1.710
MEAN RADIUS: 0.765
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 8

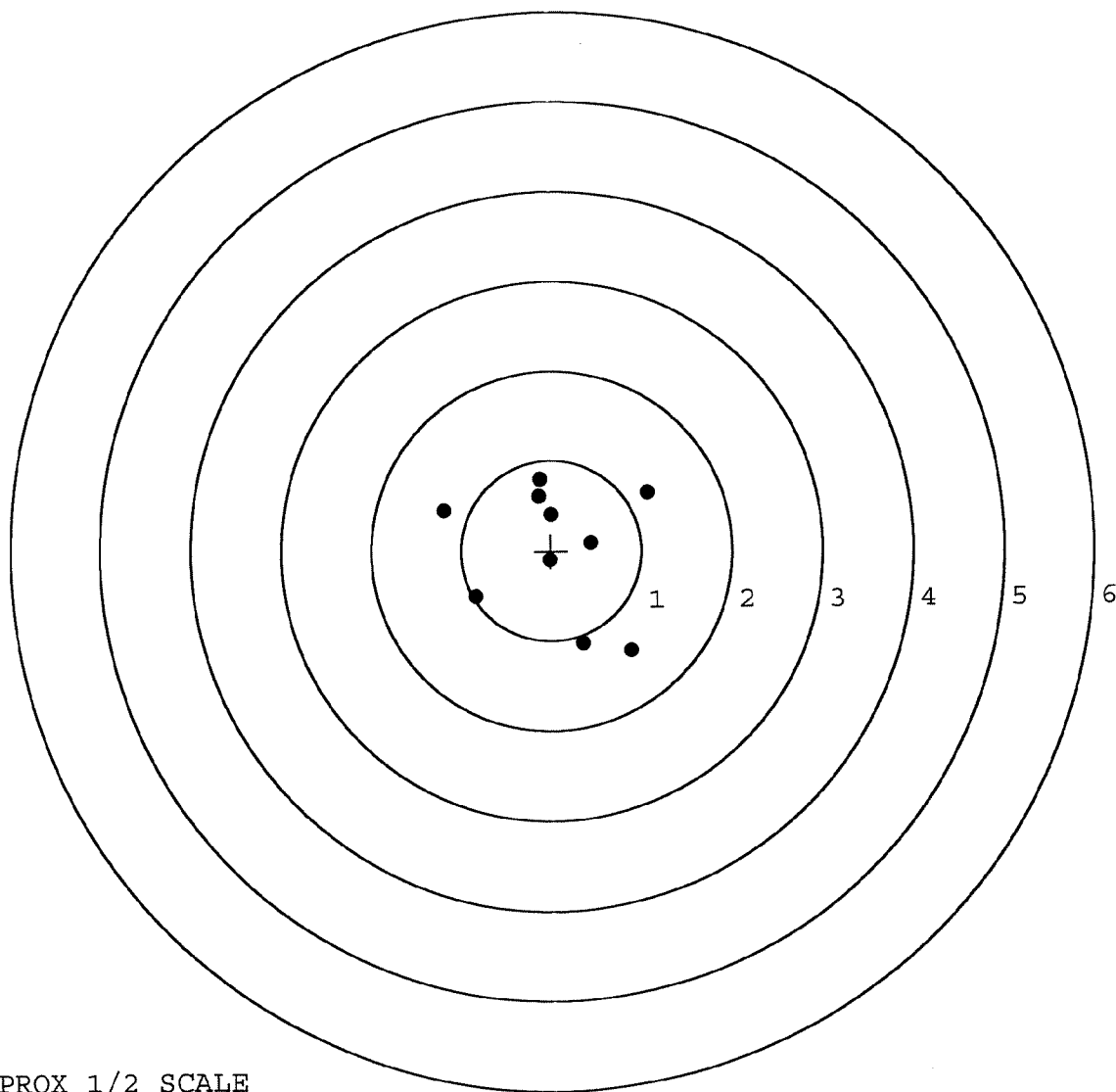


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590206. __0
TARGET NUMBER: 2
FILE DATE: 10/04/2006
FILE TIME: 05:50

X CENTROID: 0.046
Y CENTROID: 0.021
POA TO CENTROID: 0.050
HORZ SPREAD: 2.261
VERT SPREAD: 1.908
GROUP SPREAD: 2.604
MIN RADIUS: 0.137
MAX RADIUS: 1.414
MEAN RADIUS: 0.837
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.881	-1.120
2:	0.356	-1.037
3:	-0.837	-0.504
4:	-0.017	-0.101
5:	0.446	0.090
6:	1.071	0.634
7:	-1.190	0.458
8:	-0.124	0.788
9:	-0.134	0.601
10:	0.004	0.401

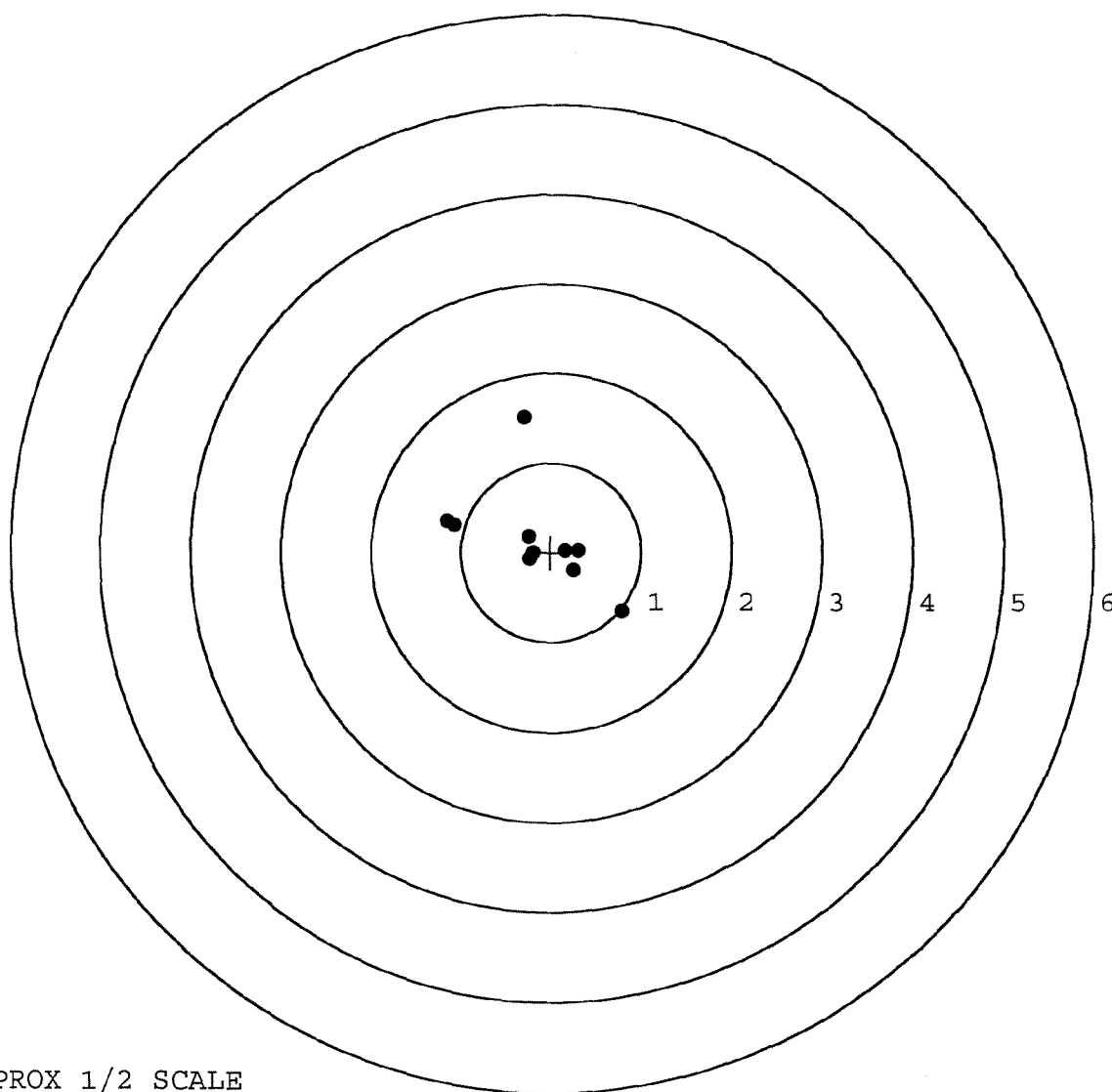


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590206. __0
TARGET NUMBER: 3
FILE DATE: 10/04/2006
FILE TIME: 05:50

POINT#	X	Y
1:	-0.301	1.506
2:	-1.159	0.348
3:	0.793	-0.661
4:	0.309	0.021
5:	0.258	-0.206
6:	-0.251	0.178
7:	-0.236	-0.078
8:	0.165	0.023
9:	-0.198	-0.007
10:	-1.075	0.304

X CENTROID: -0.170
Y CENTROID: 0.143
POA TO CENTROID: 0.222
HORZ SPREAD: 1.952
VERT SPREAD: 2.167
GROUP SPREAD: 2.427
MIN RADIUS: 0.089
MAX RADIUS: 1.370
MEAN RADIUS: 0.643
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

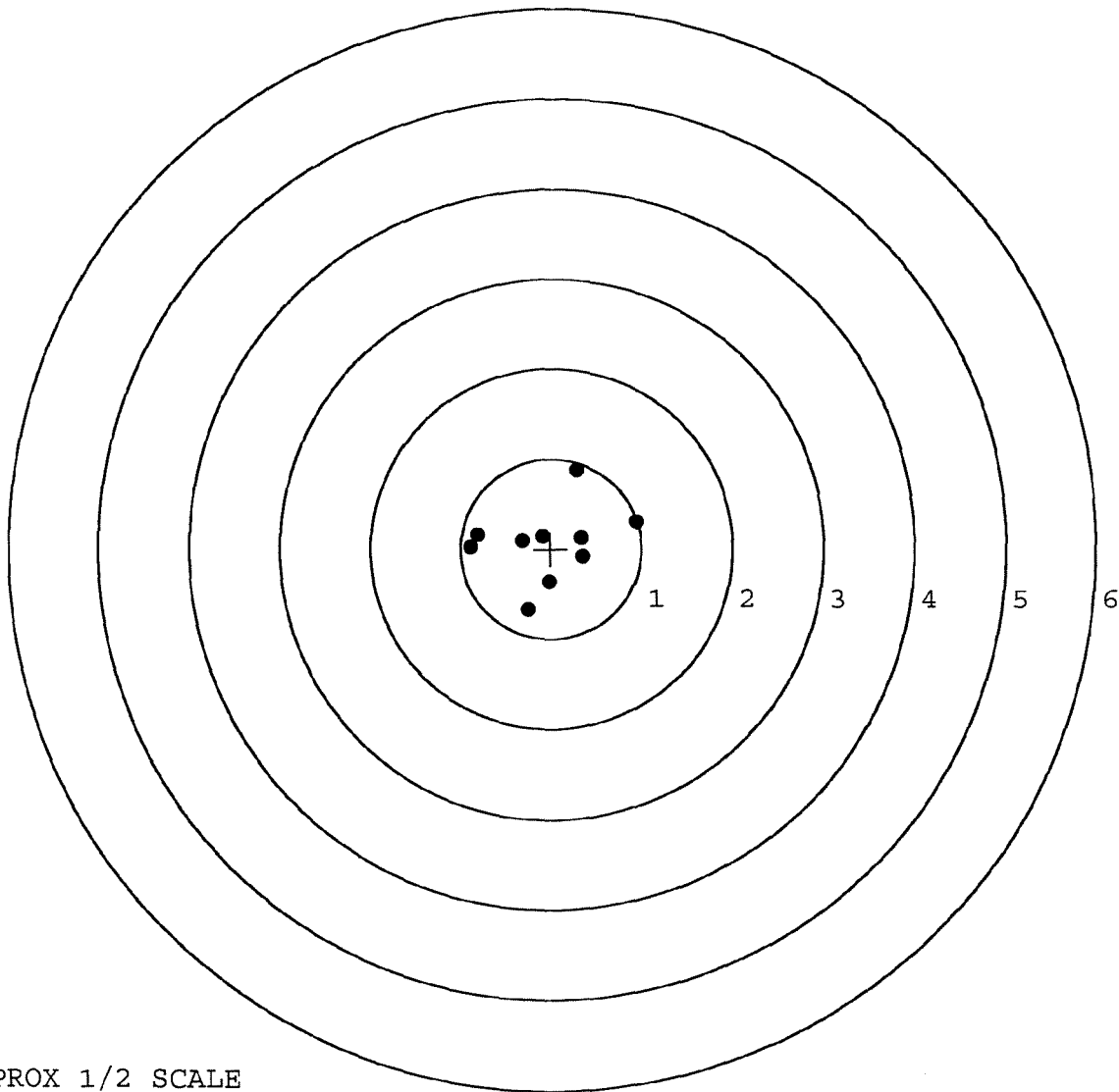


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590206. __0
TARGET NUMBER: 4
FILE DATE: 10/04/2006
FILE TIME: 05:50

X CENTROID: -0.045
Y CENTROID: 0.057
POA TO CENTROID: 0.072
HORZ SPREAD: 1.832
VERT SPREAD: 1.561
GROUP SPREAD: 1.853
MIN RADIUS: 0.098
MAX RADIUS: 1.016
MEAN RADIUS: 0.590
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.284	0.875
2:	0.942	0.300
3:	0.357	-0.091
4:	0.346	0.126
5:	-0.248	-0.686
6:	-0.022	-0.367
7:	-0.092	0.142
8:	-0.316	0.092
9:	-0.808	0.155
10:	-0.890	0.021

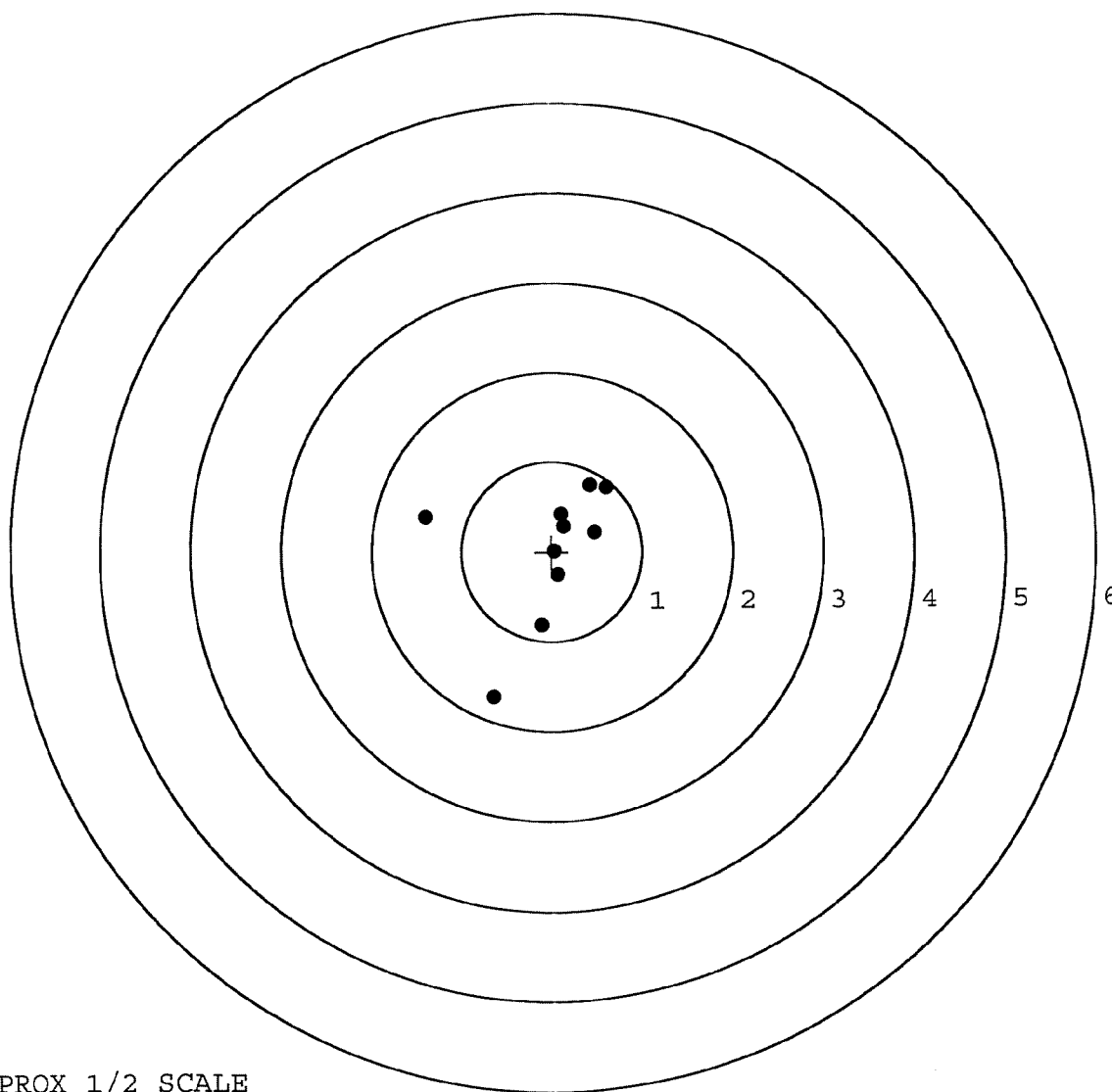


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590206. __ 0
TARGET NUMBER: 5
FILE DATE: 10/04/2006
FILE TIME: 05:50

X CENTROID: -0.031
Y CENTROID: 0.009
POA TO CENTROID: 0.032
HORZ SPREAD: 2.008
VERT SPREAD: 2.354
GROUP SPREAD: 2.645
MIN RADIUS: 0.060
MAX RADIUS: 1.737
MEAN RADIUS: 0.746
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.651	-1.614
2:	-1.399	0.394
3:	0.609	0.712
4:	0.429	0.740
5:	0.474	0.217
6:	0.113	0.420
7:	0.134	0.286
8:	0.029	0.012
9:	0.069	-0.254
10:	-0.117	-0.826



TARGET APPROX 1/2 SCALE