

G 6590 2/5

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

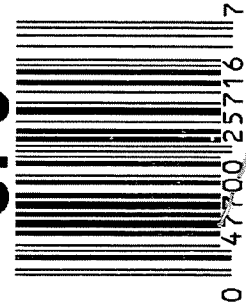
24"

CAPACITY

6

G6590215

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 # G 6590215

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	DL
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>mmms</u>	9/26/06	mmms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-26-06	CW
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	TS
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		10-4-06	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>6.5</u> <u>6.5</u> <u>6.5</u>	10/10/06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3.0</u>	10/10/06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.021</u> <u>.020</u>	10/10/06	RA
	J) ASSEMBLE STOCK		10-4-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-16-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-4-06	RTZ
	M) IRON SIGHT ALIGNMENT		10-4-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-4-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-5-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		5/10	
670	FINAL INSPECTION A) HEADSPACE		11-16-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.85</u> <u>2.88</u> <u>2.84</u> <u>2.89</u>	10-9-06	RA
	C) FUNCTION		11-16-06	L.P.D.
690	PACK		11/13/06	RA

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 10-3-06

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	246	236		248	
PULL #2	239	236		242	
PULL #3	225	242		248	
PULL #4	234	245		244	
PULL #5	228	245		247	
TOTAL	1172	1204		1229	
AVERAGE	234	240		245	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	304	302		
PULL #2	304	290		
PULL #3	303	286		
PULL #4	298	291		
PULL #5	296	291		
TOTAL	1505	1460		
AVERAGE	301	292		

	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	417	417		4.03
PULL #2	409	407		4.01
PULL #3	420	418		4.04
PULL #4	409	420		4.04
PULL #5	422	415		4.05
TOTAL	2077	2077		20.17
AVERAGE	415	415		4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590215.___0
FILE DATE AND TIME: 10/06/2006 01:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.167
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.181
The Average Mean Radius of the Five Target Set:	0.882
The Distance from POA to Centroid Target #1:	0.432
The Distance from Centroid Target #2 to Centroid Target #1:	0.463
The Distance from Centroid Target #3 to Centroid Target #1:	0.439
The Distance from Centroid Target #4 to Centroid Target #1:	0.261
The Distance from Centroid Target #5 to Centroid Target #1:	0.261

SERIAL NUMBER: G6590215. 0

TARGET NUMBER: 1

FILE DATE: 10/06/2006

FILE TIME: 01:33

POINT#	X	Y
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1:	0.651	-0.825
----	-------	--------

2:	0.276	-0.888
----	-------	--------

3:	0.068	-0.348
----	-------	--------

4:	-0.422	-0.267
----	--------	--------

5:	-1.590	-0.253
----	--------	--------

6:	-1.168	-0.051
----	--------	--------

7:	-1.139	0.233
----	--------	-------

8:	0.017	0.264
----	-------	-------

9:	0.248	0.655
----	-------	-------

10:	-1.221	0.925
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X CENTROID: -0.428

Y CENTROID: -0.055

POA TO CENTROID: 0.432

HORZ SPREAD: 2.241

VERT SPREAD: 1.813

GROUP SPREAD: 2.563

MIN RADIUS: 0.212

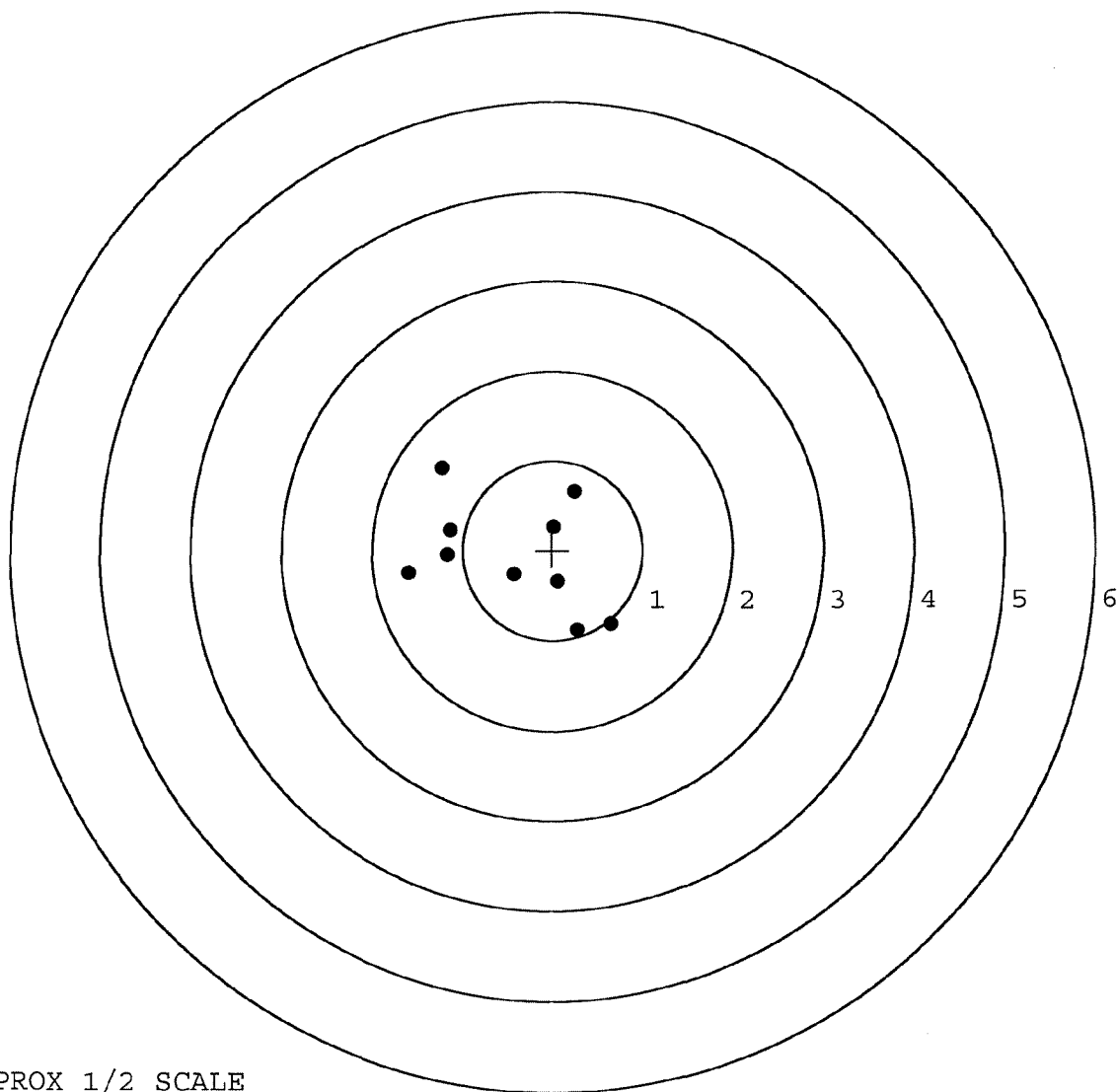
MAX RADIUS: 1.325

MEAN RADIUS: 0.868

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590215. 0

TARGET NUMBER: 2

FILE DATE: 10/06/2006

FILE TIME: 01:33

POINT#	X	Y
1:	0.167	-1.204
2:	-0.023	-0.709
3:	-0.260	-0.760
4:	1.093	-0.348
5:	0.742	-0.181
6:	0.273	-0.118
7:	-0.249	-0.310
8:	-0.819	0.051
9:	0.285	0.669
10:	-1.087	0.927

X CENTROID: 0.012

Y CENTROID: -0.198

POA TO CENTROID: 0.199

HORZ SPREAD: 2.180

VERT SPREAD: 2.131

GROUP SPREAD: 2.525

MIN RADIUS: 0.273

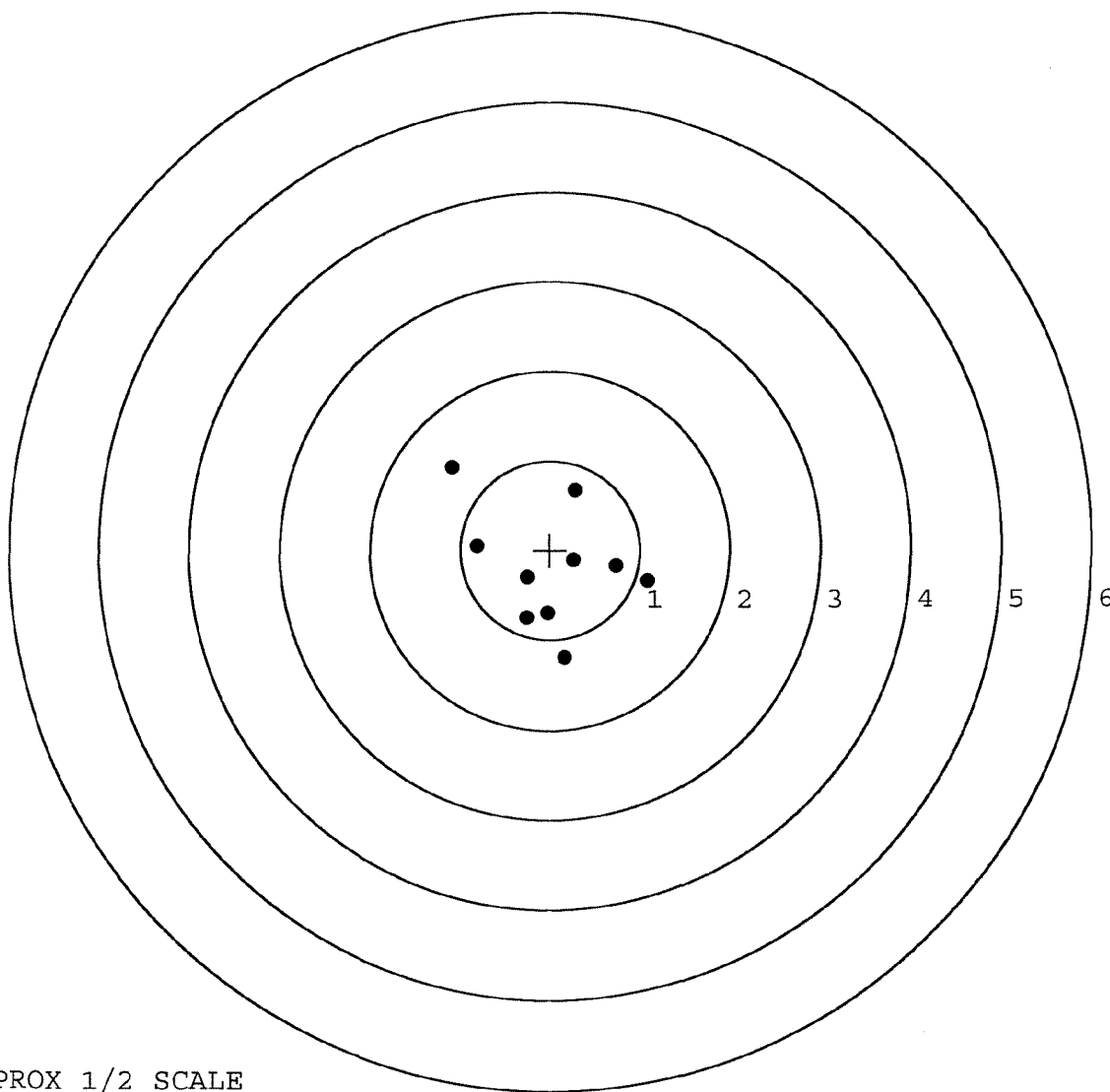
MAX RADIUS: 1.573

MEAN RADIUS: 0.788

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590215. 0

TARGET NUMBER: 3

FILE DATE: 10/06/2006

FILE TIME: 01:33

POINT#	X	Y
1:	-0.732	-0.840
2:	-0.848	-0.578
3:	-0.503	-0.268
4:	-0.155	-0.559
5:	1.149	-0.299
6:	0.701	0.767
7:	0.576	0.556
8:	0.418	0.455
9:	0.130	0.382
10:	-0.790	1.028

X CENTROID: -0.005

Y CENTROID: 0.064

POA TO CENTROID: 0.065

HORZ SPREAD: 1.997

VERT SPREAD: 1.868

GROUP SPREAD: 2.350

MIN RADIUS: 0.345

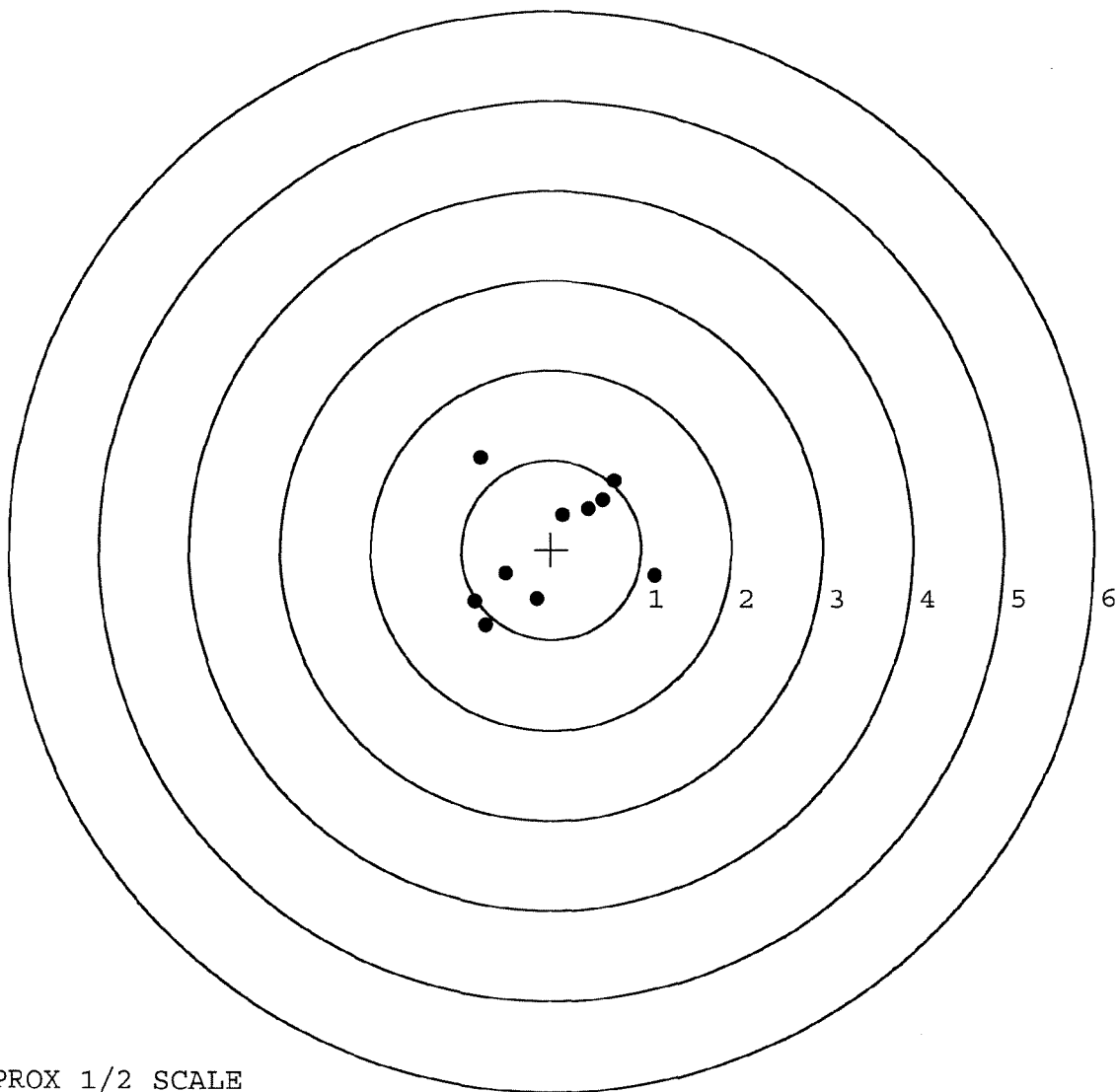
MAX RADIUS: 1.243

MEAN RADIUS: 0.859

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590215. __0

TARGET NUMBER: 4

FILE DATE: 10/06/2006

FILE TIME: 01:33

POINT#	X	Y
1:	0.477	-0.555
2:	0.708	-0.311
3:	-0.776	-0.886
4:	-0.710	-0.345
5:	-1.770	-0.125
6:	0.806	0.696
7:	0.287	0.257
8:	-0.135	0.179
9:	-0.416	0.316
10:	-0.406	1.373

X CENTROID: -0.194

Y CENTROID: 0.060

POA TO CENTROID: 0.203

HORZ SPREAD: 2.576

VERT SPREAD: 2.259

GROUP SPREAD: 2.704

MIN RADIUS: 0.133

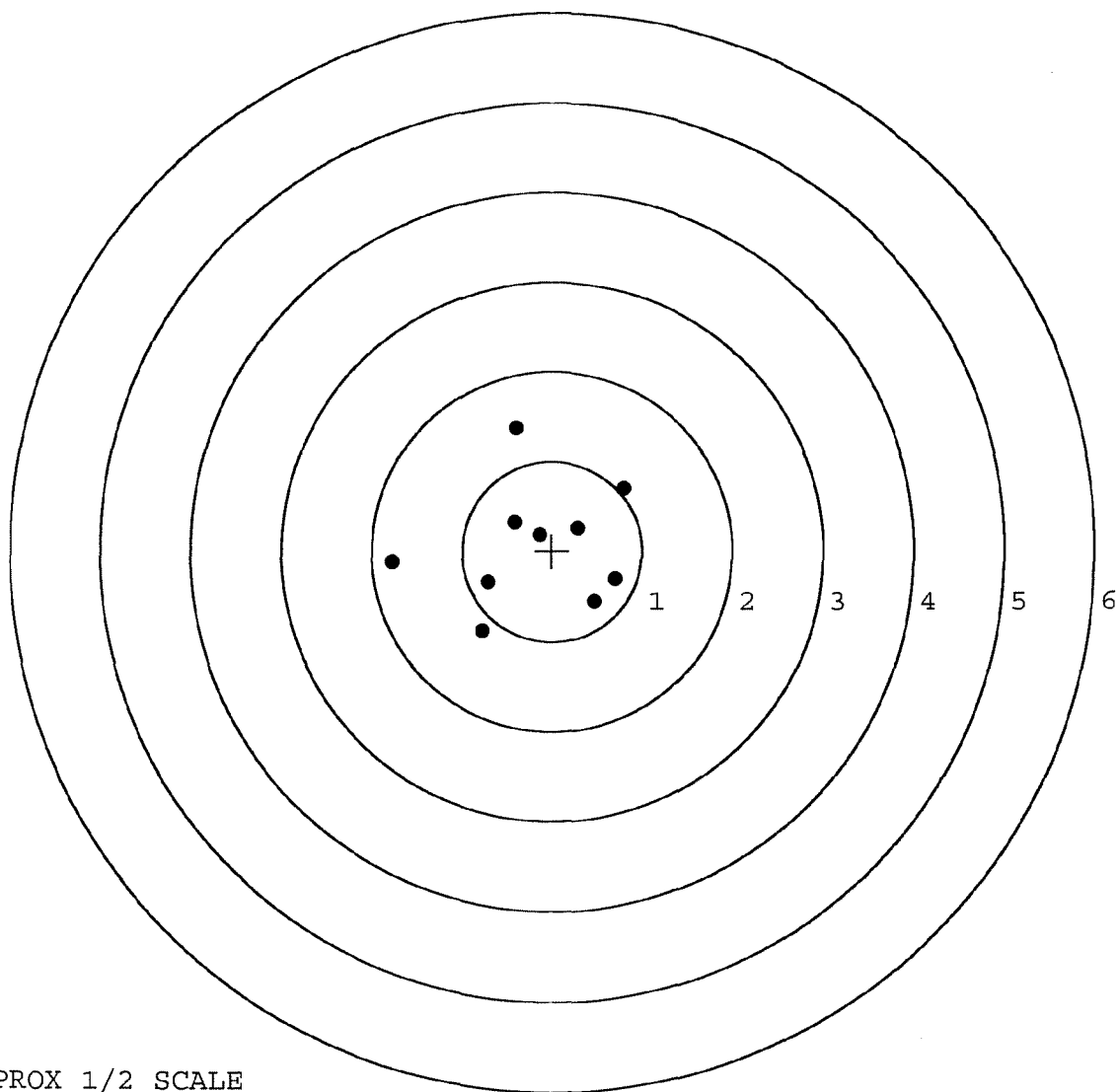
MAX RADIUS: 1.587

MEAN RADIUS: 0.875

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

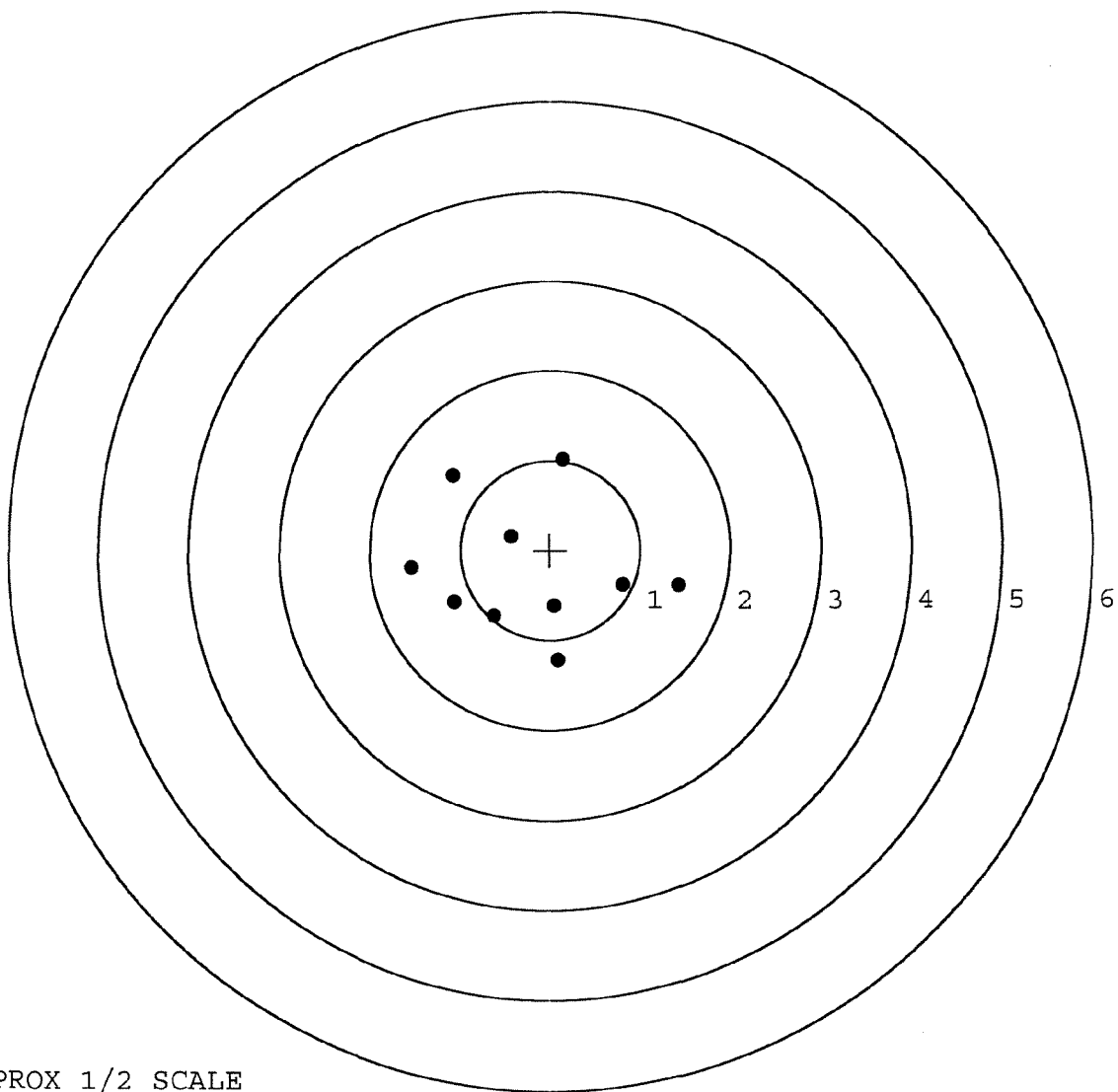


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590215. 0
TARGET NUMBER: 5
FILE DATE: 10/06/2006
FILE TIME: 01:33

POINT#	X	Y
1:	1.433	-0.399
2:	0.812	-0.391
3:	0.094	-1.232
4:	0.055	-0.624
5:	-0.434	0.157
6:	0.141	1.008
7:	-1.080	0.838
8:	-1.535	-0.192
9:	-1.064	-0.577
10:	-0.630	-0.727

X CENTROID: -0.221
Y CENTROID: -0.214
POA TO CENTROID: 0.307
HORZ SPREAD: 2.968
VERT SPREAD: 2.240
GROUP SPREAD: 2.975
MIN RADIUS: 0.428
MAX RADIUS: 1.664
MEAN RADIUS: 1.022
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE