

G-6590234

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



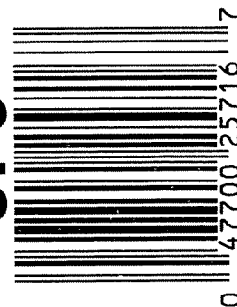
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590234

UPC



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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590234

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-1-06	BLC
420	ASSEMBLE ACTION		8-2-06	BLG
430	ASSEMBLE TO STOCK		8-2-06	BLG
440	PROOF	MAGNA-FLUX	8-2-06	BLG
460	CHECK HEADSPACE	INSPECTED	8-2-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 09 2006	8-2-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	8-9-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-9-06	CW
510	DRILL AND TAP SIGHT HOLES		8-8-06	TRL
520	GOFF BLAST BBL / REC		8-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/10/06	TB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-11-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-11-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-11-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-11-06	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>60</u> <u>55</u> <u>55</u>	8-17-06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	8-17-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1024</u> <u>1023</u>	8-17-06	DA
	J) ASSEMBLE STOCK		8-11-06	RTL
	K) ASSEMBLE SWIVEL STUDS		8-28-06	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-11-06	BLG
	M) IRON SIGHT ALIGNMENT		8-11-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-11-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-15-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-15-06	BD
670	FINAL INSPECTION A) HEADSPACE		8-28-06	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>258</u> <u>236</u> <u>235</u> <u>249</u> <u>246</u>	8/23/06	RP
	C) FUNCTION		8-28-06	RTL
690	PACK		11/13/06	DA

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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 8-11-06
TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.27		2.46	
PULL #2	2.57	2.52		2.46	
PULL #3	2.57	2.48		2.54	
PULL #4	2.58	2.51		2.54	
PULL #5	2.60	2.30		2.64	
TOTAL	12.83	12.08		12.64	
AVERAGE	2.56	2.41		2.52	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.20		
PULL #2	3.01	3.31		
PULL #3	2.96	2.93		
PULL #4	3.11	2.98		
PULL #5	2.98	2.88		
TOTAL	15.13	15.30		
AVERAGE	3.02	3.06		

	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	4.09	3.95		4.15
PULL #2	4.08	4.00		4.21
PULL #3	4.00	3.86		4.06
PULL #4	4.16	3.95		4.17
PULL #5	4.04	4.05		4.14
TOTAL	20.37	19.81		20.73
AVERAGE	4.07	3.96		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590234.___0
FILE DATE AND TIME: 08/15/2006 15:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.011
The Average Y Centroid of the Five Target Set:	0.077
The Average Point of Impact of the Five Target Set:	0.077
The Average Mean Radius of the Five Target Set:	0.791
The Distance from POA to Centroid Target #1:	0.132
The Distance from Centroid Target #2 to Centroid Target #1:	0.547
The Distance from Centroid Target #3 to Centroid Target #1:	0.481
The Distance from Centroid Target #4 to Centroid Target #1:	0.248
The Distance from Centroid Target #5 to Centroid Target #1:	0.213

SERIAL NUMBER: G6590234. 0

TARGET NUMBER: 1

FILE DATE: 08/15/2006

FILE TIME: 15:06

X CENTROID: 0.063

Y CENTROID: -0.116

POA TO CENTROID: 0.132

HORZ SPREAD: 1.652

VERT SPREAD: 1.914

GROUP SPREAD: 1.917

MIN RADIUS: 0.515

MAX RADIUS: 1.180

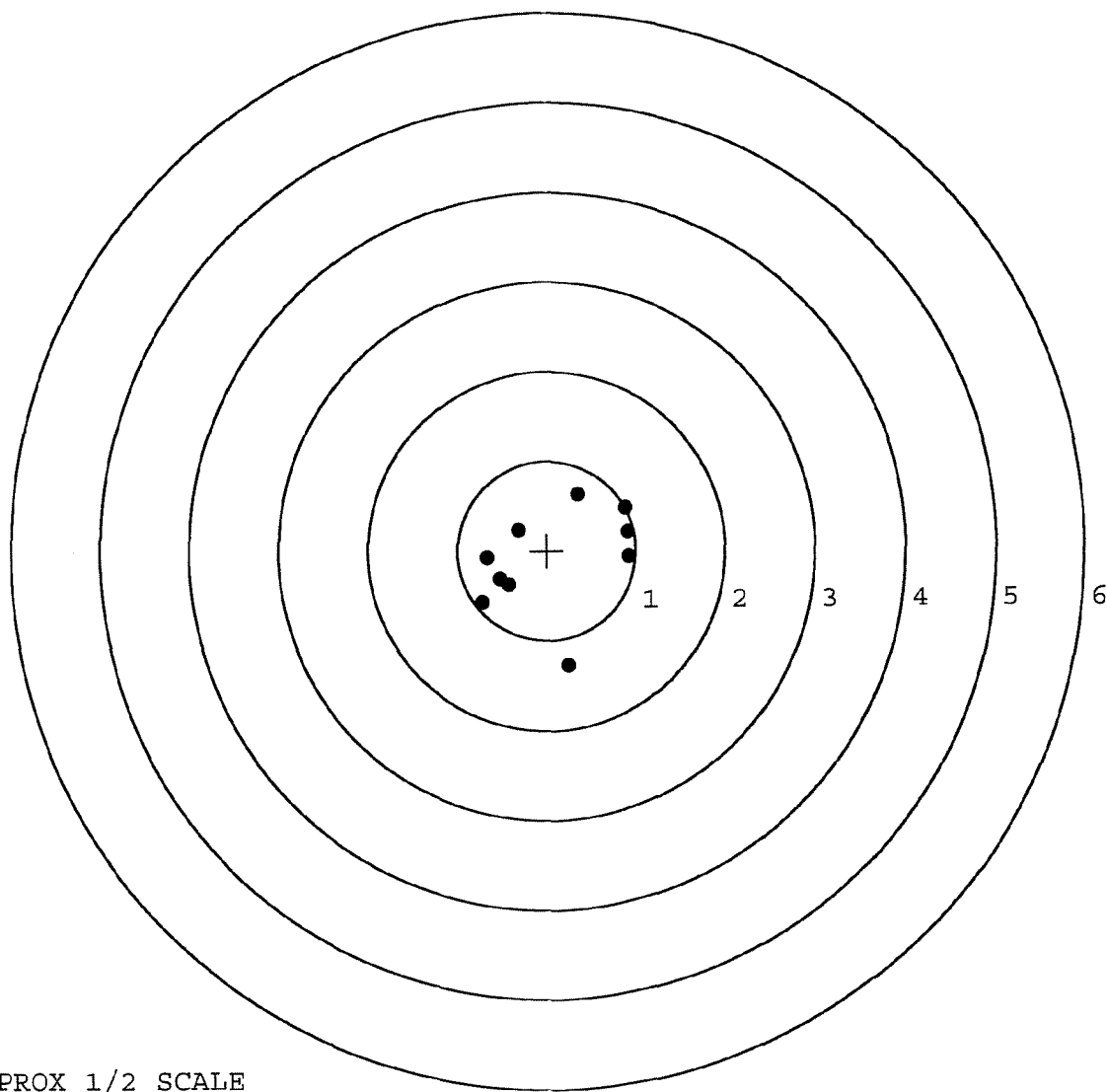
MEAN RADIUS: 0.811

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.730	-0.579
2:	-0.428	-0.382
3:	-0.527	-0.319
4:	-0.671	-0.076
5:	-0.320	0.227
6:	0.350	0.632
7:	0.882	0.480
8:	0.910	0.207
9:	0.922	-0.072
10:	0.245	-1.282



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590234. 0

TARGET NUMBER: 2

FILE DATE: 08/15/2006

FILE TIME: 15:06

X CENTROID: 0.276

Y CENTROID: 0.387

POA TO CENTROID: 0.476

HORZ SPREAD: 1.767

VERT SPREAD: 2.950

GROUP SPREAD: 2.950

MIN RADIUS: 0.160

MAX RADIUS: 1.619

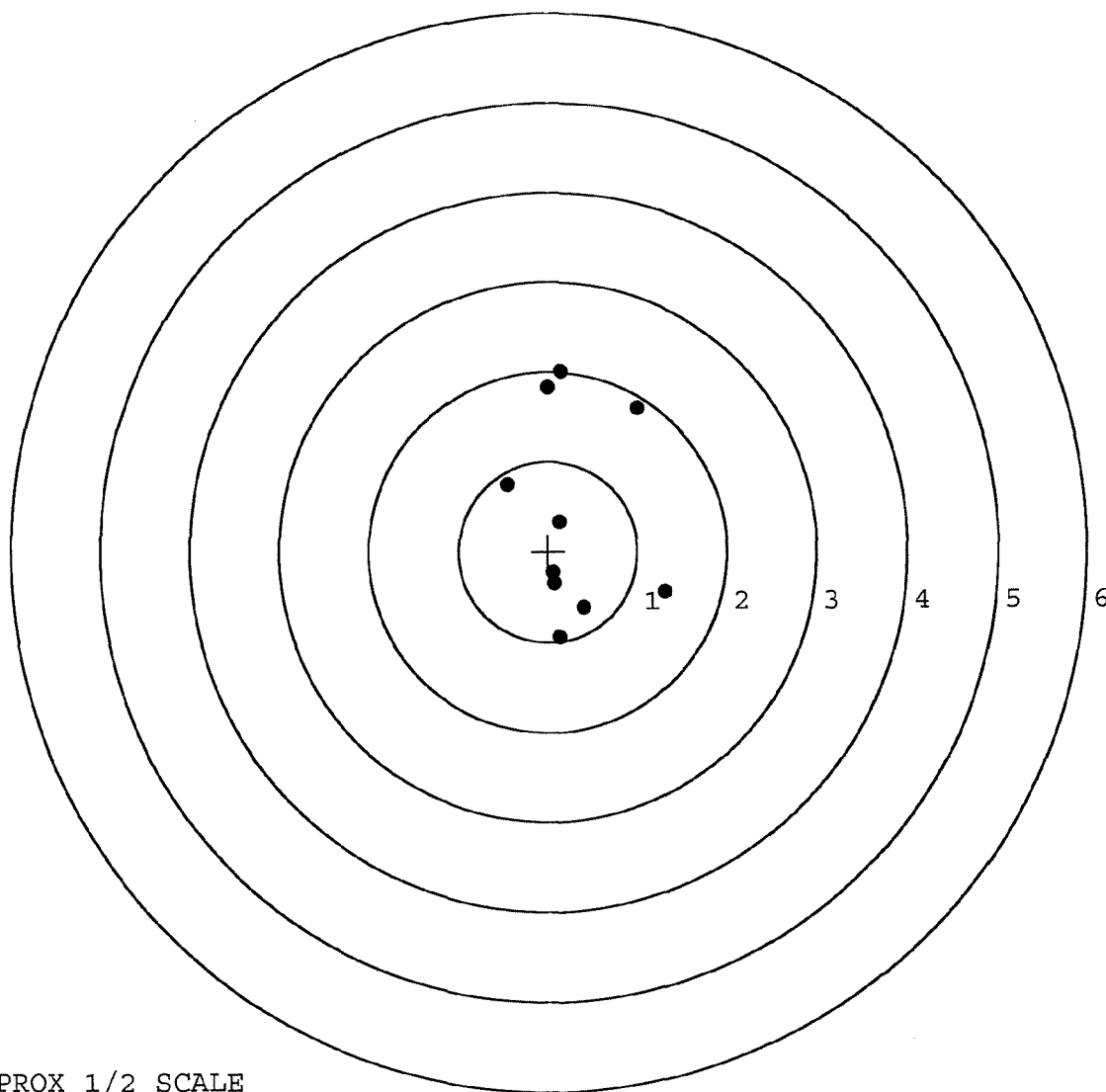
MEAN RADIUS: 1.059

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.009	1.820
2:	0.145	2.001
3:	1.005	1.588
4:	1.308	-0.449
5:	0.126	0.333
6:	-0.459	0.746
7:	0.058	-0.235
8:	0.071	-0.359
9:	0.397	-0.624
10:	0.121	-0.949

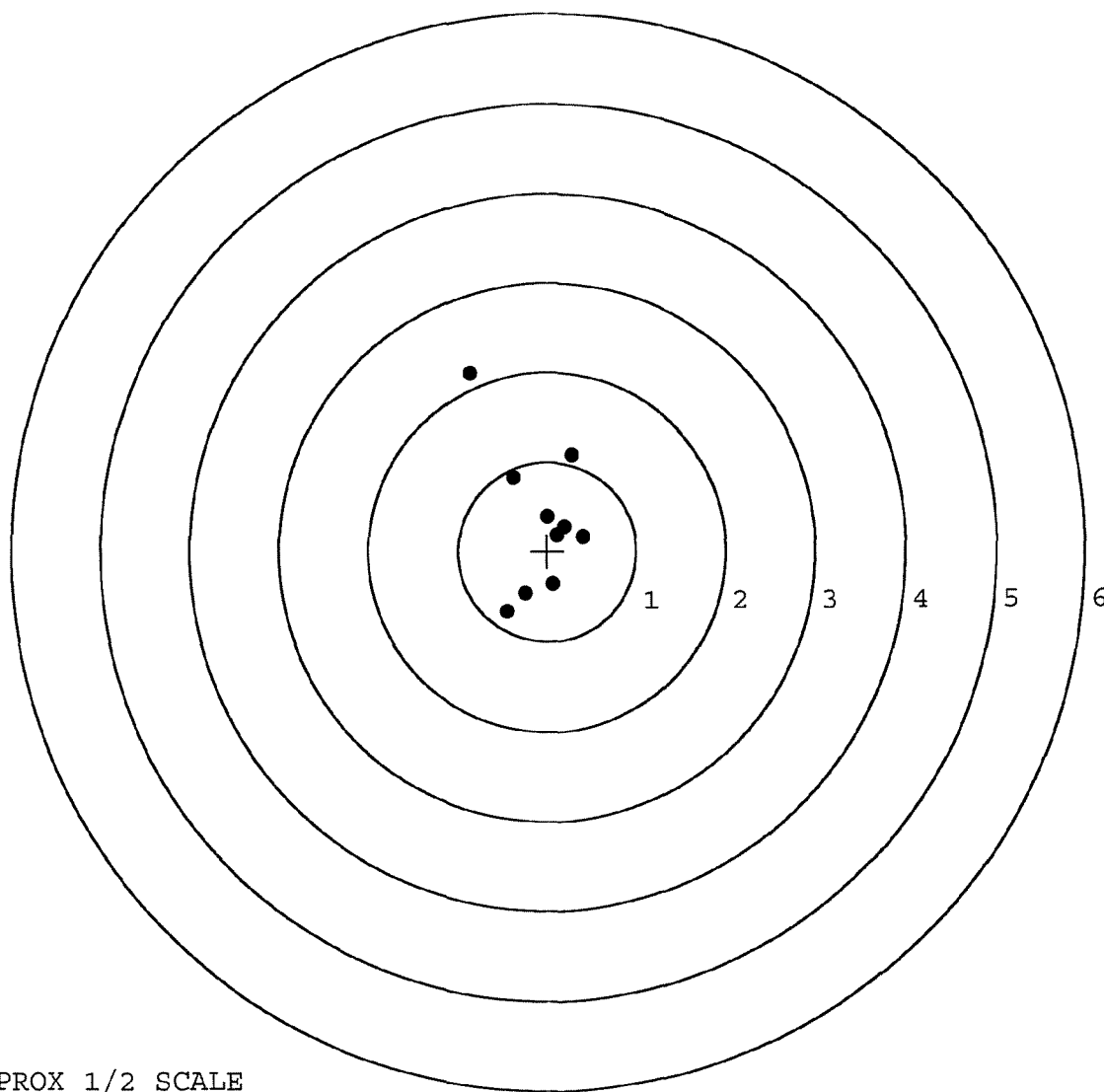


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590234. 0
TARGET NUMBER: 3
FILE DATE: 08/15/2006
FILE TIME: 15:06

X CENTROID: -0.093
Y CENTROID: 0.339
POA TO CENTROID: 0.351
HORZ SPREAD: 1.259
VERT SPREAD: 2.667
GROUP SPREAD: 2.697
MIN RADIUS: 0.095
MAX RADIUS: 1.824
MEAN RADIUS: 0.700
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.861	1.993
2:	-0.384	0.820
3:	0.279	1.078
4:	-0.013	0.390
5:	0.103	0.184
6:	0.398	0.161
7:	0.065	-0.369
8:	-0.250	-0.477
9:	-0.457	-0.674
10:	0.193	0.279

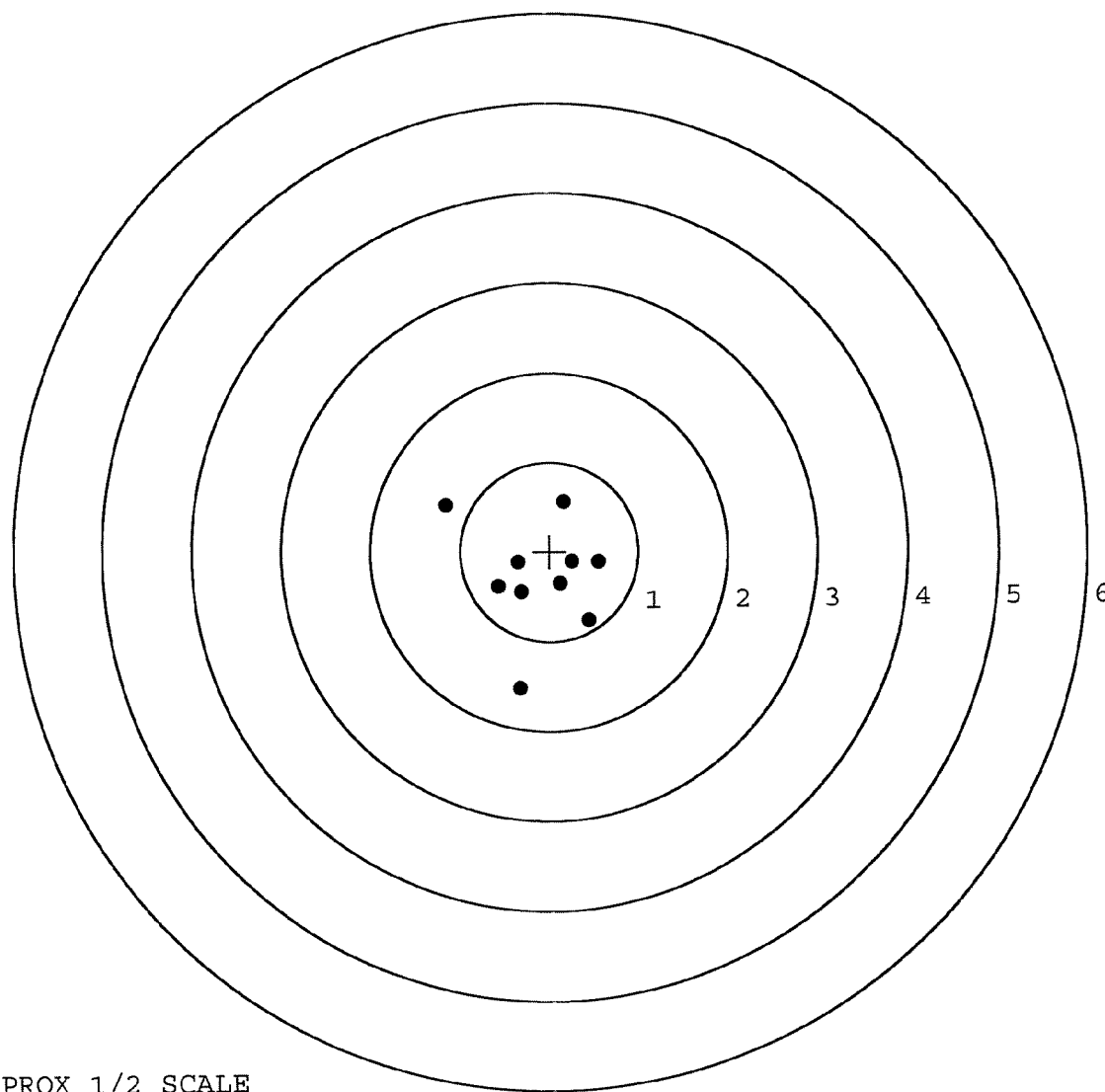


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590234. __0
TARGET NUMBER: 4
FILE DATE: 08/15/2006
FILE TIME: 15:06

X CENTROID: -0.125
Y CENTROID: -0.278
POA TO CENTROID: 0.305
HORZ SPREAD: 1.706
VERT SPREAD: 2.082
GROUP SPREAD: 2.212
MIN RADIUS: 0.259
MAX RADIUS: 1.313
MEAN RADIUS: 0.659
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.343	-1.525
2:	-1.159	0.531
3:	0.164	0.557
4:	-0.357	-0.123
5:	0.118	-0.366
6:	0.249	-0.114
7:	0.547	-0.123
8:	0.440	-0.769
9:	-0.323	-0.454
10:	-0.586	-0.391



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590234. 0

TARGET NUMBER: 5

FILE DATE: 08/15/2006

FILE TIME: 15:06

X CENTROID: -0.068

Y CENTROID: 0.052

POA TO CENTROID: 0.085

HORZ SPREAD: 1.446

VERT SPREAD: 2.044

GROUP SPREAD: 2.142

MIN RADIUS: 0.358

MAX RADIUS: 1.310

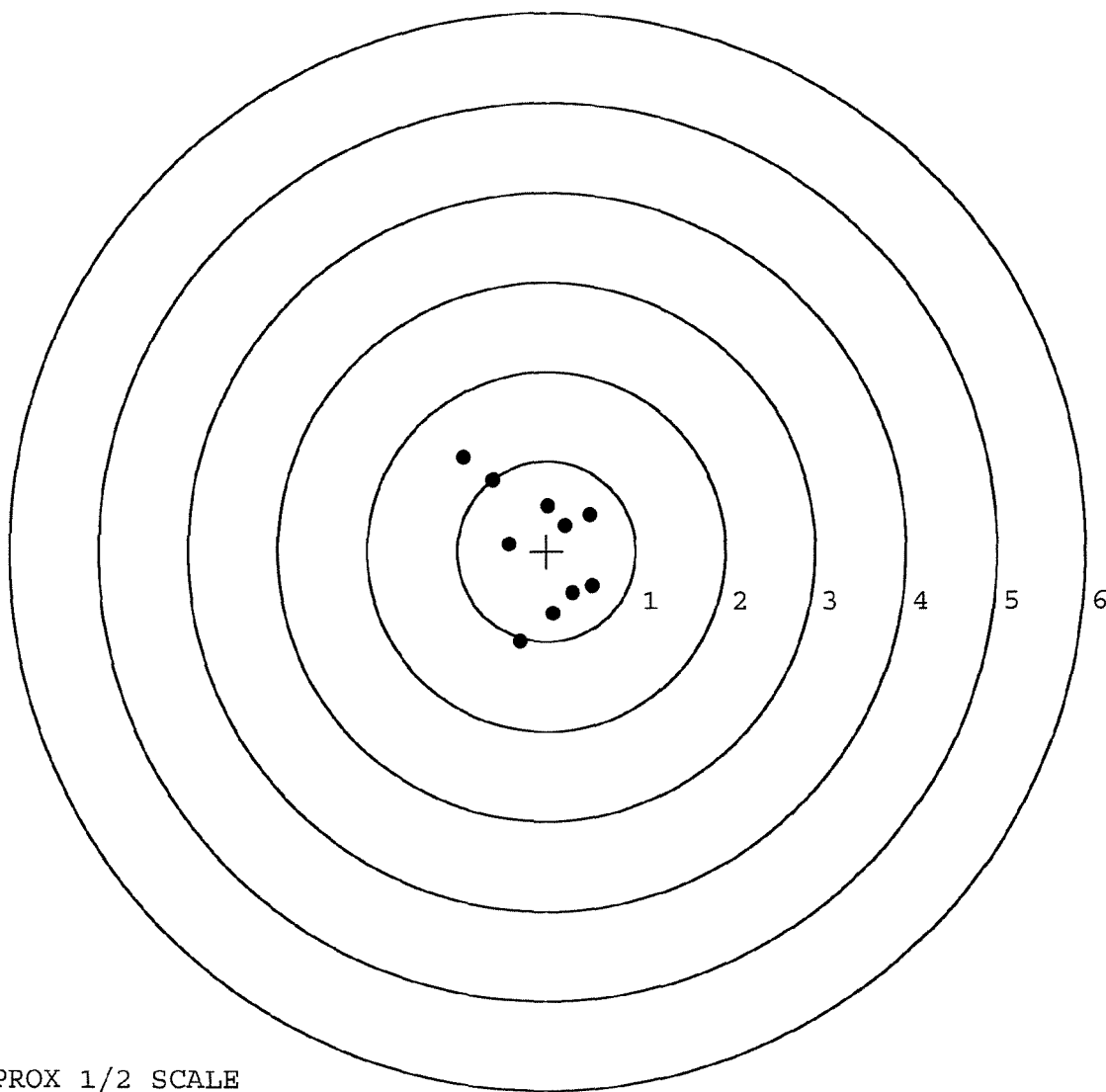
MEAN RADIUS: 0.726

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.934	1.035
2:	-0.601	0.787
3:	0.008	0.502
4:	0.206	0.283
5:	0.483	0.404
6:	-0.425	0.074
7:	0.512	-0.390
8:	0.288	-0.473
9:	0.080	-0.697
10:	-0.295	-1.009



TARGET APPROX 1/2 SCALE