

G-659/550

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



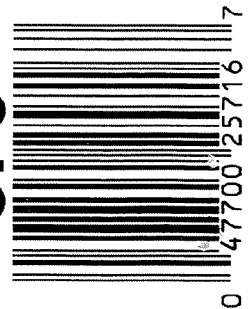
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591550

UPC



ORDER 25716

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 # G6591550

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-8-06	RIC
420	ASSEMBLE ACTION		9-14-06	RTC
430	ASSEMBLE TO STOCK		9-15-06	L.P.D.
440	PROOF		9-15-06	L.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-15-06	L.P.D.
470	DIS-ASSEMBLE ACTION	SEP 21 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	9-21-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-20-06	CW
510	DRILL AND TAP SIGHT HOLES		9-20-06	TRW
520	GOFF BLAST BBL / REC		9-21-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/28/06	nom
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/28/06	nom
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/28/06	nom
	D) OIL FIRING PIN ASSEMBLY		9-29-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/4/06	nom
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6⁵</u> <u>6⁵</u> <u>7⁹</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4⁵</u> <u>5⁵</u> <u>4⁵</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	not in
	I) FIRING PIN INDENT .020 MIN	<u>.027</u> <u>.027</u> <u>.028</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-29-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10/11/06	not in
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-29-06	BLC
	M) IRON SIGHT ALIGNMENT		9-29-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-29-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9/30/06	not in
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/30/06	DK
670	FINAL INSPECTION A) HEADSPACE		10/11/06	not in
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2352</u> <u>244</u> <u>244</u> <u>237</u> <u>237</u>	10-3-06	RA
	C) FUNCTION		10/11/06	not in
690	PACK		10-31-06	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 9-28-06
TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	242	263		247	
PULL #2	243	252		250	
PULL #3	248	259		249	
PULL #4	255	259		245	
PULL #5	257	259		247	
TOTAL	1245	1292		1238	
AVERAGE	249	258		247	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	311	323		
PULL #2	312	313		
PULL #3	309	306		
PULL #4	312	304		
PULL #5	312	303		
TOTAL	1556	1549		
AVERAGE	311	309		

	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	404	416		420
PULL #2	419	411		420
PULL #3	416	414		411
PULL #4	422	416		409
PULL #5	414	415		417
TOTAL	2075	2072		2077
AVERAGE	415	414		415

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591550.___0
FILE DATE AND TIME: 09/30/2006 10:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.098
The Average Y Centroid of the Five Target Set:	-0.046
The Average Point of Impact of the Five Target Set:	0.108
The Average Mean Radius of the Five Target Set:	0.753
The Distance from POA to Centroid Target #1:	0.256
The Distance from Centroid Target #2 to Centroid Target #1:	0.180
The Distance from Centroid Target #3 to Centroid Target #1:	0.400
The Distance from Centroid Target #4 to Centroid Target #1:	0.665
The Distance from Centroid Target #5 to Centroid Target #1:	0.073

SERIAL NUMBER: G6591550. 0

TARGET NUMBER: 1

FILE DATE: 09/30/2006

FILE TIME: 10:59

X CENTROID: 0.049

Y CENTROID: -0.252

POA TO CENTROID: 0.256

HORZ SPREAD: 1.859

VERT SPREAD: 2.295

GROUP SPREAD: 2.865

MIN RADIUS: 0.187

MAX RADIUS: 1.462

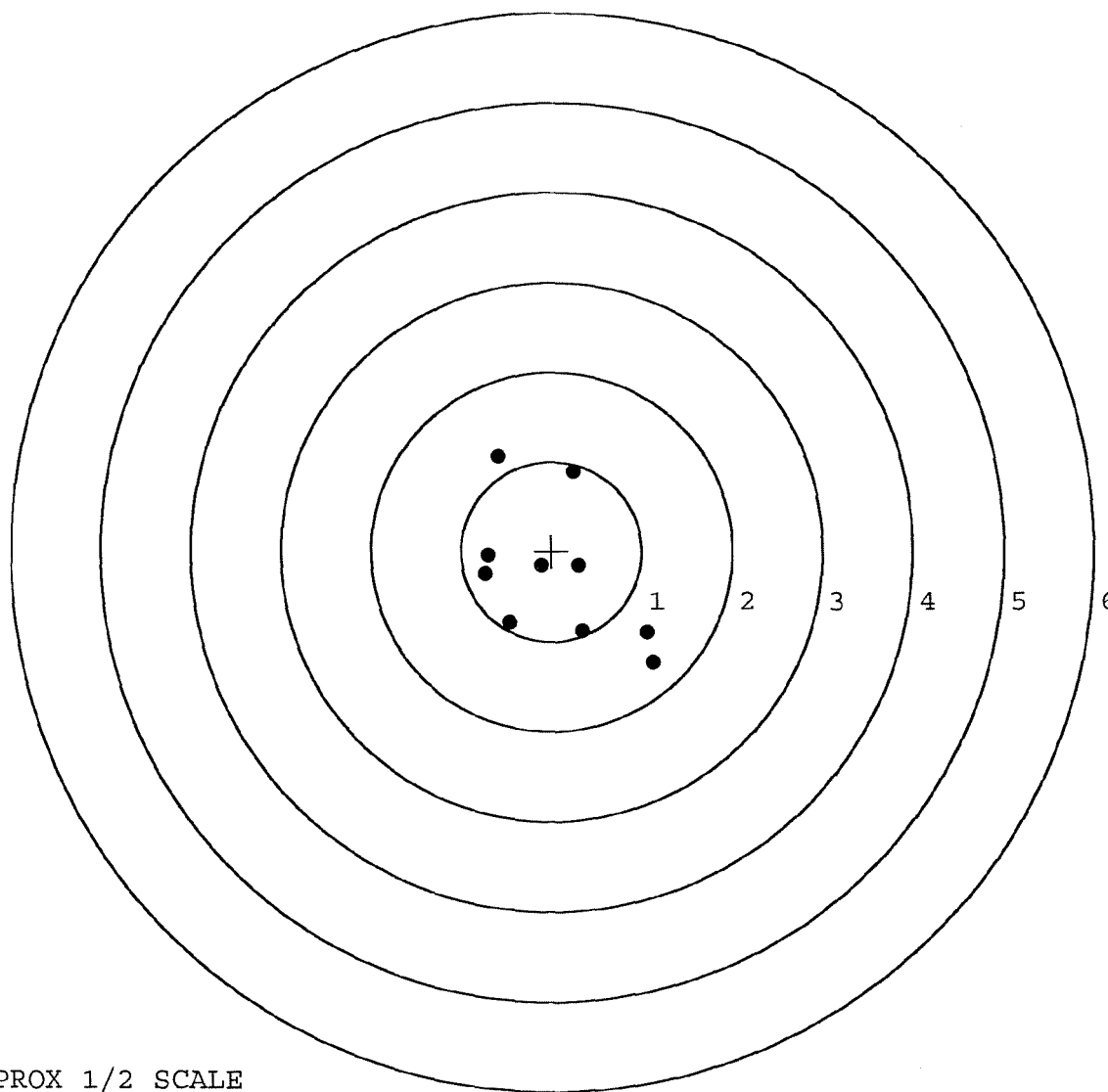
MEAN RADIUS: 0.875

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.587	1.058
2:	0.243	0.892
3:	-0.705	-0.053
4:	-0.731	-0.259
5:	-0.117	-0.165
6:	0.301	-0.161
7:	-0.459	-0.795
8:	0.348	-0.891
9:	1.066	-0.904
10:	1.128	-1.237



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591550. __0

TARGET NUMBER: 2

FILE DATE: 09/30/2006

FILE TIME: 10:59

X CENTROID: 0.061

Y CENTROID: -0.071

POA TO CENTROID: 0.094

HORZ SPREAD: 1.383

VERT SPREAD: 2.277

GROUP SPREAD: 2.301

MIN RADIUS: 0.131

MAX RADIUS: 1.254

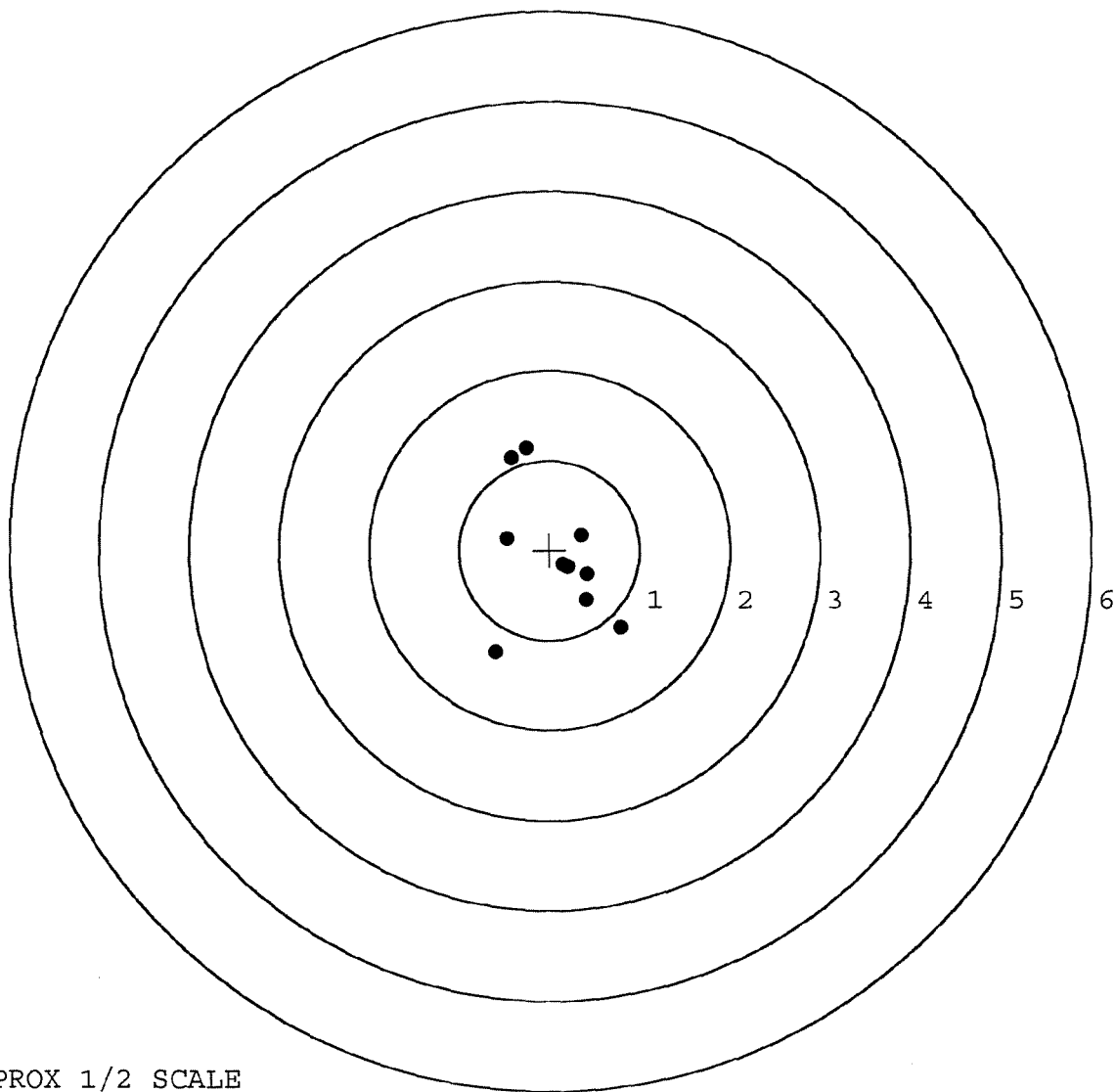
MEAN RADIUS: 0.706

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.424	1.026
2:	-0.262	1.137
3:	-0.467	0.128
4:	0.356	0.171
5:	0.157	-0.160
6:	0.422	-0.272
7:	0.419	-0.556
8:	0.788	-0.863
9:	-0.595	-1.140
10:	0.213	-0.185

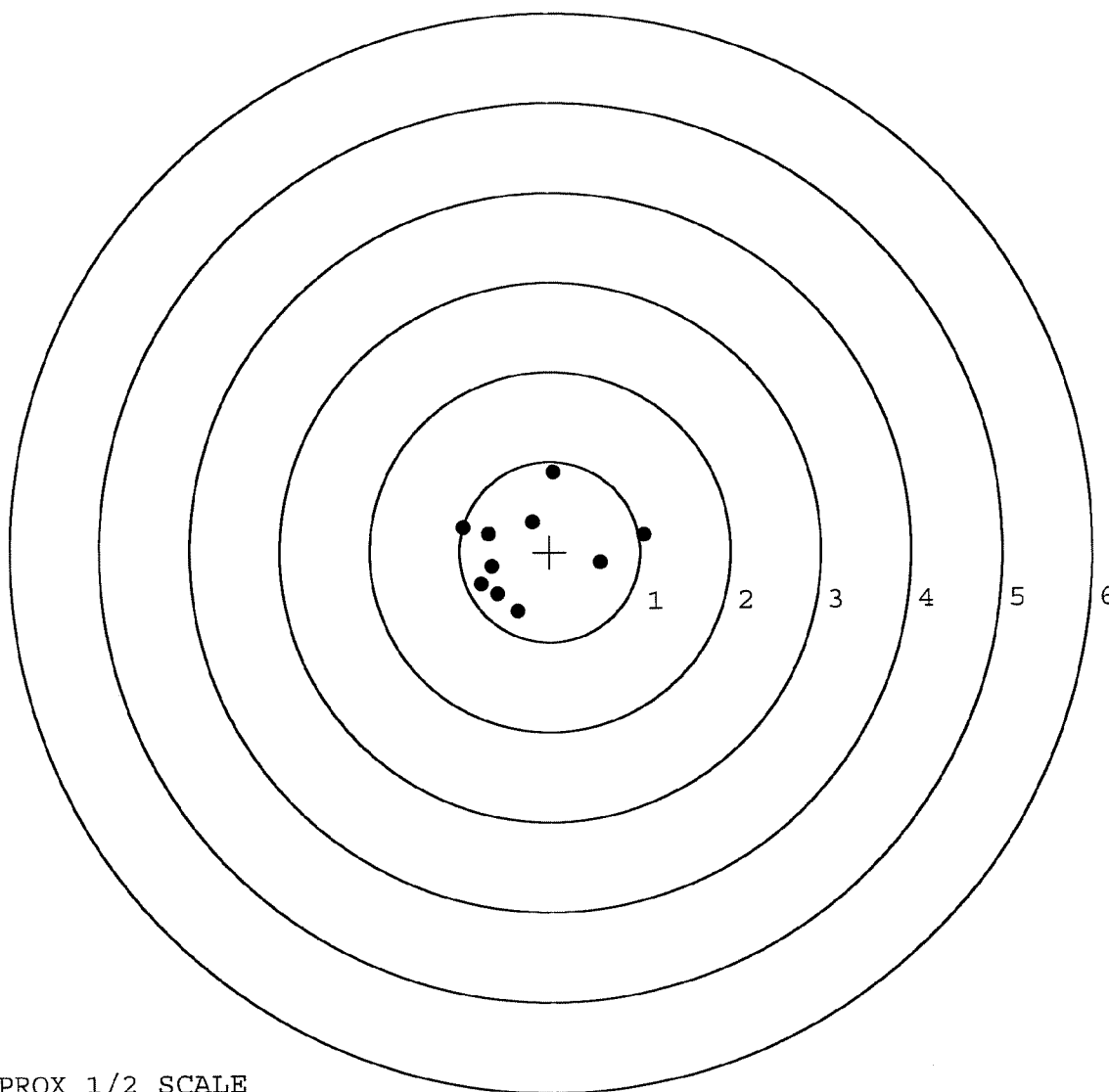


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591550.___0
TARGET NUMBER: 3
FILE DATE: 09/30/2006
FILE TIME: 10:59

X CENTROID: -0.253
Y CENTROID: 0.011
POA TO CENTROID: 0.253
HORZ SPREAD: 1.998
VERT SPREAD: 1.551
GROUP SPREAD: 2.000
MIN RADIUS: 0.328
MAX RADIUS: 1.306
MEAN RADIUS: 0.692
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.042	0.886
2:	-0.191	0.333
3:	0.560	-0.123
4:	1.042	0.185
5:	-0.674	0.203
6:	-0.956	0.279
7:	-0.642	-0.162
8:	-0.766	-0.354
9:	-0.583	-0.471
10:	-0.360	-0.665



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591550.___0

TARGET NUMBER: 4

FILE DATE: 09/30/2006

FILE TIME: 10:59

X CENTROID: -0.339

Y CENTROID: 0.289

POA TO CENTROID: 0.445

HORZ SPREAD: 1.754

VERT SPREAD: 2.224

GROUP SPREAD: 2.250

MIN RADIUS: 0.165

MAX RADIUS: 1.565

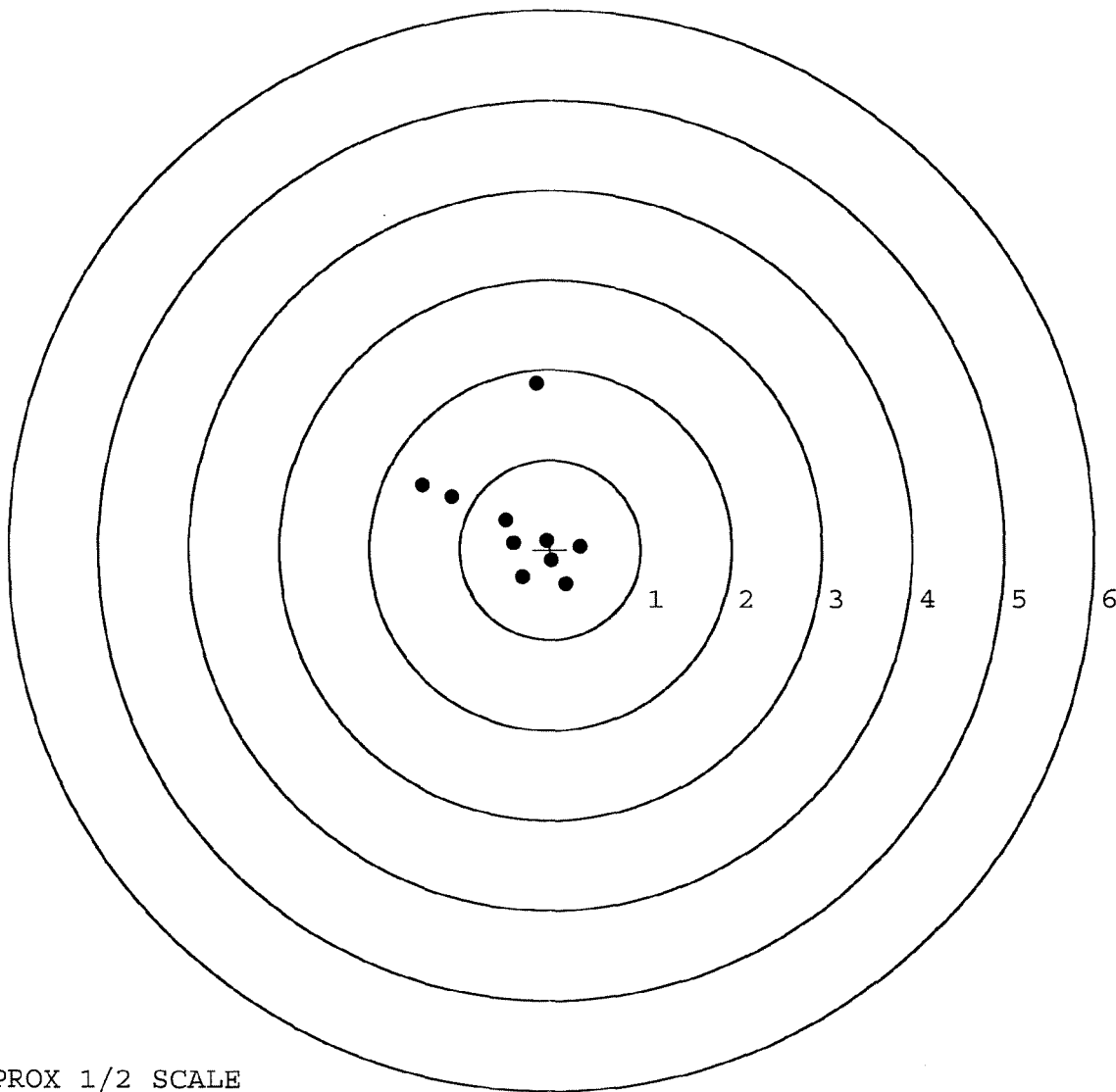
MEAN RADIUS: 0.698

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.414	0.720
2:	-1.092	0.592
3:	-0.499	0.328
4:	-0.402	0.076
5:	-0.310	-0.308
6:	0.178	-0.380
7:	-0.045	0.102
8:	0.340	0.034
9:	-0.163	1.844
10:	0.016	-0.121



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591550. 0

TARGET NUMBER: 5

FILE DATE: 09/30/2006

FILE TIME: 10:59

POINT#	X	Y
1:	-0.334	0.501
2:	0.003	0.632
3:	0.173	0.968
4:	0.736	0.174
5:	-0.290	-0.291
6:	0.072	-0.311
7:	0.018	-0.879
8:	-0.716	-0.582
9:	-0.637	-0.975
10:	0.891	-1.299

X CENTROID: -0.008

Y CENTROID: -0.206

POA TO CENTROID: 0.206

HORZ SPREAD: 1.607

VERT SPREAD: 2.267

GROUP SPREAD: 2.378

MIN RADIUS: 0.132

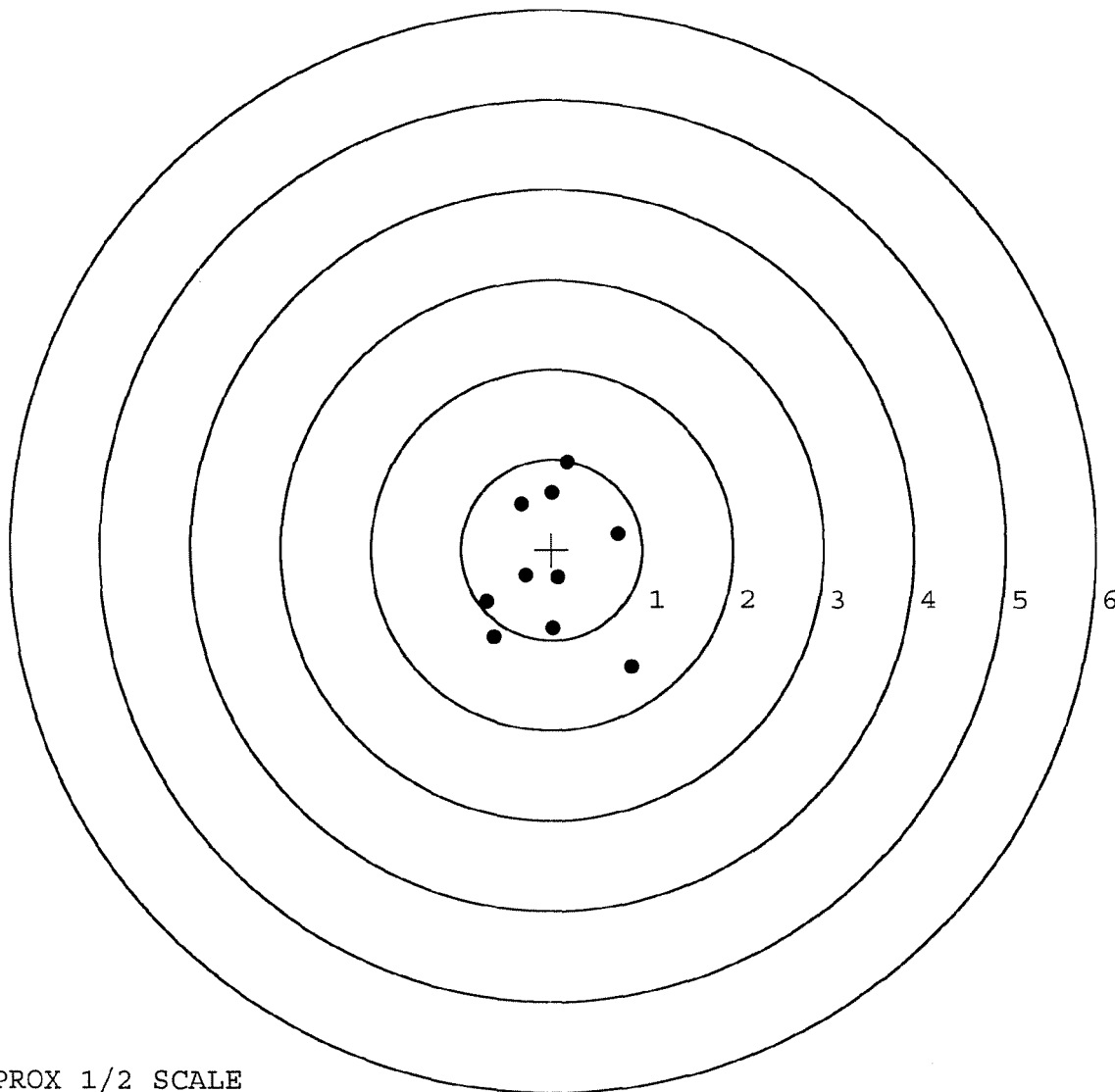
MAX RADIUS: 1.415

MEAN RADIUS: 0.795

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE