

G-659 15-5-1

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



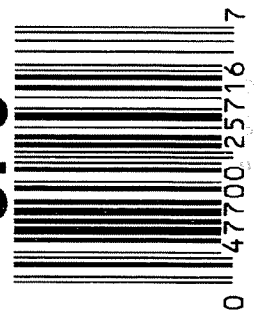
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6591551

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 6591551

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-26-06	RTZ
420	ASSEMBLE ACTION		9-28-06	RTZ
430	ASSEMBLE TO STOCK		10-2-06	SD
440	PROOF	MAGNA-FLUX	10-2-06	TRH
460	CHECK HEADSPACE	INSPECTED	10-2-06	TRH
470	DIS-ASSEMBLE ACTION	UCT 03 2006	10-2-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mmg</u>	10/3/06	<u>mmg</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/3/06	DYB
510	DRILL AND TAP SIGHT HOLES		10-3-06	SD
520	GOFF BLAST BBL / REC		10-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/6/06	RTZ
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-6-06	DTA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-06	DTA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-06	DTA
	D) OIL FIRING PIN ASSEMBLY		10-12-06	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>8.5</u> <u>7.5</u> <u>7.5</u>	11-9-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.25</u> <u>3.25</u>	11-9-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.0245</u> <u>.025</u>	11-9-06	TRW
	J) ASSEMBLE STOCK		10-12-06	BLC
	K) ASSEMBLE SWIVEL STUDS		11-13-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-12-06	BLC
	M) IRON SIGHT ALIGNMENT		10-12-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-12-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-12-06	L.P.A.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/12/06	TRW
670	FINAL INSPECTION A) HEADSPACE		11-13-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.34</u> <u>2.35</u> <u>2.45</u> <u>2.39</u> <u>2.55</u>	10-24-06	BA
	C) FUNCTION		11-13-06	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 10-10-06

TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.19		2.17	
PULL #2	2.43	2.10		2.05	
PULL #3	2.44	2.13		2.08	
PULL #4	2.35	2.16		2.05	
PULL #5	2.24	2.13		2.08	
TOTAL	1197	1071		1043	
AVERAGE	239	214		208	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	2.97		
PULL #2	3.12	3.06		
PULL #3	3.19	3.06		
PULL #4	3.14	3.06		
PULL #5	3.07	3.09		
TOTAL	1562	1524		
AVERAGE	312	304		

	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	4.24	4.35		4.09
PULL #2	4.20	4.36		4.09
PULL #3	4.13	4.45		4.10
PULL #4	4.15	4.48		4.01
PULL #5	4.20	4.47		4.03
TOTAL	2092	2211		2032
AVERAGE	418	442		406

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591551.__0
FILE DATE AND TIME: 10/13/2006 06:00

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.070
The Average Y Centroid of the Five Target Set:	0.042
The Average Point of Impact of the Five Target Set:	0.082
The Average Mean Radius of the Five Target Set:	0.664
The Distance from POA to Centroid Target #1:	0.122
The Distance from Centroid Target #2 to Centroid Target #1:	0.083
The Distance from Centroid Target #3 to Centroid Target #1:	0.191
The Distance from Centroid Target #4 to Centroid Target #1:	0.066
The Distance from Centroid Target #5 to Centroid Target #1:	0.092

SERIAL NUMBER: G6591551.___0

TARGET NUMBER: 1

FILE DATE: 10/13/2006

FILE TIME: 06:00

X CENTROID: -0.097

Y CENTROID: 0.075

POA TO CENTROID: 0.122

HORZ SPREAD: 1.830

VERT SPREAD: 0.761

GROUP SPREAD: 1.847

MIN RADIUS: 0.180

MAX RADIUS: 1.099

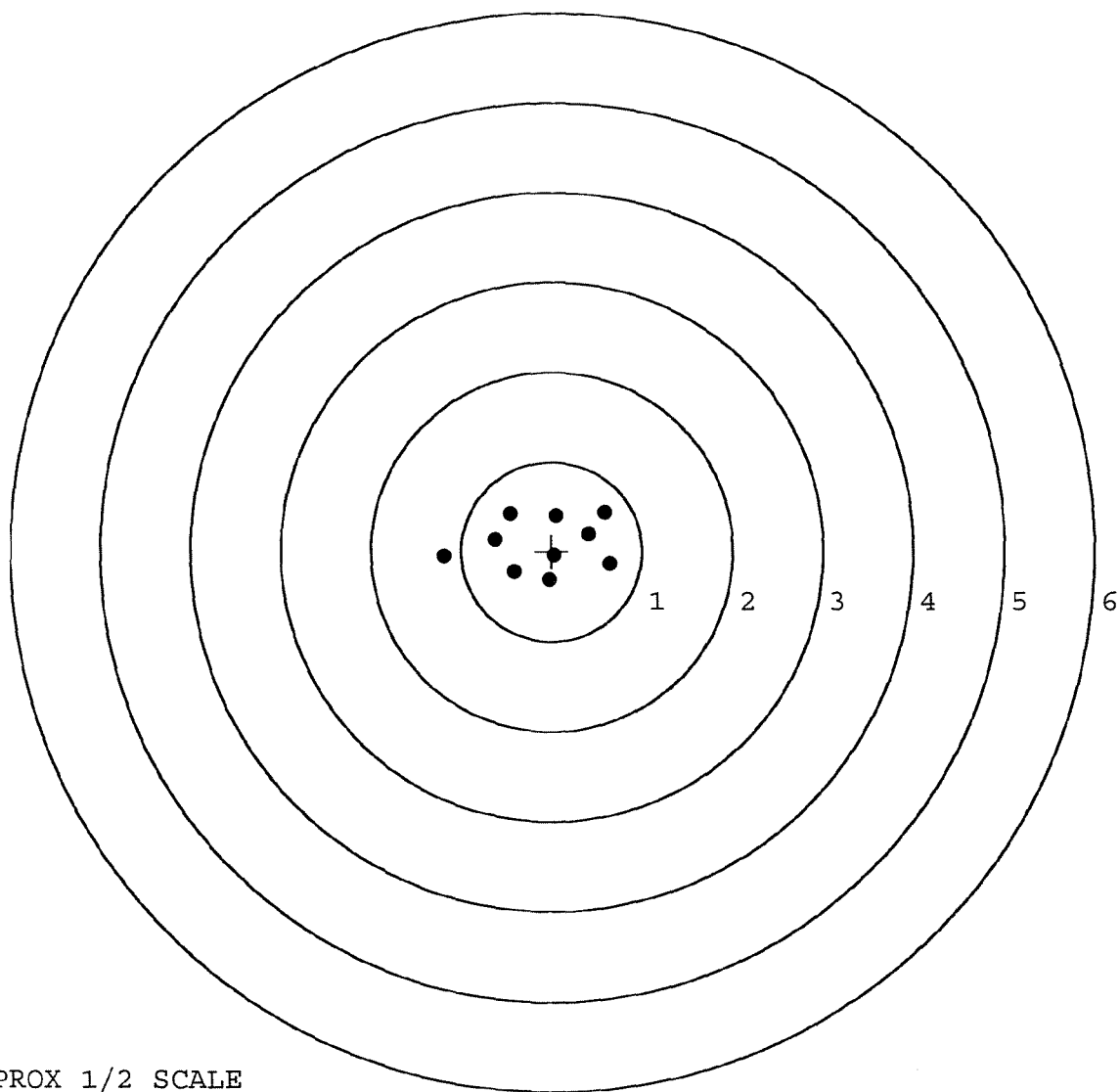
MEAN RADIUS: 0.558

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.456	0.417
2:	-0.623	0.129
3:	-1.187	-0.063
4:	0.643	-0.141
5:	0.591	0.436
6:	0.049	0.395
7:	-0.411	-0.237
8:	-0.021	-0.325
9:	0.415	0.190
10:	0.033	-0.049



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591551. __0

TARGET NUMBER: 2

FILE DATE: 10/13/2006

FILE TIME: 06:00

X CENTROID: -0.118

Y CENTROID: -0.005

POA TO CENTROID: 0.119

HORZ SPREAD: 1.614

VERT SPREAD: 1.620

GROUP SPREAD: 1.657

MIN RADIUS: 0.255

MAX RADIUS: 0.978

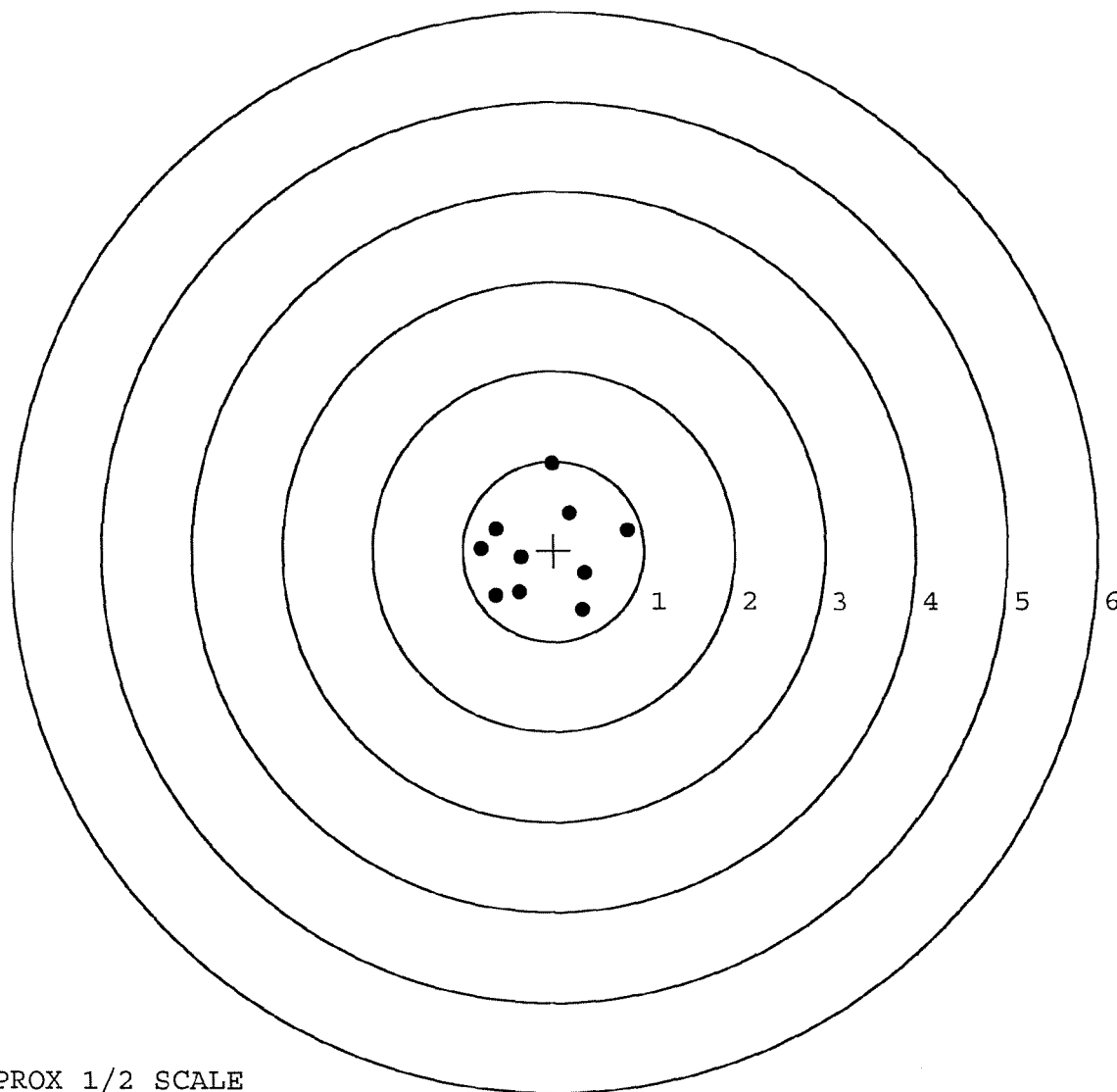
MEAN RADIUS: 0.652

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.322	-0.651
2:	0.352	-0.252
3:	0.812	0.230
4:	0.178	0.421
5:	-0.026	0.969
6:	-0.637	-0.494
7:	-0.378	-0.458
8:	-0.363	-0.076
9:	-0.802	0.024
10:	-0.642	0.236



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591551. __0

TARGET NUMBER: 3

FILE DATE: 10/13/2006

FILE TIME: 06:00

POINT#	X	Y
1:	-0.059	-1.390
2:	0.761	-0.535
3:	0.812	-0.331
4:	0.708	0.365
5:	0.033	0.471
6:	-0.173	0.959
7:	-0.840	-0.076
8:	-0.390	0.248
9:	-0.358	-0.035
10:	-0.229	-0.378

X CENTROID: 0.027

Y CENTROID: -0.070

POA TO CENTROID: 0.075

HORZ SPREAD: 1.652

VERT SPREAD: 2.349

GROUP SPREAD: 2.352

MIN RADIUS: 0.386

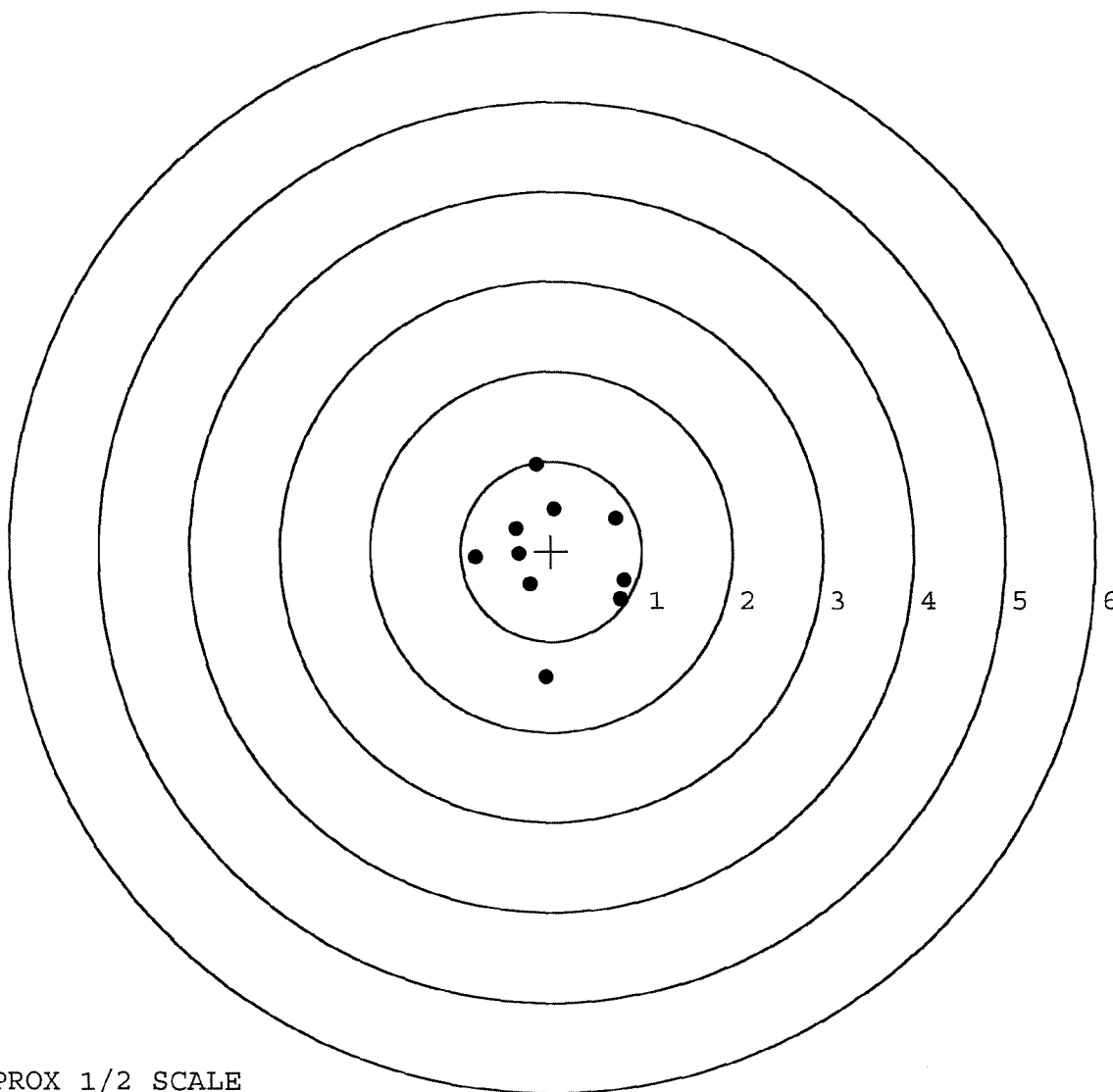
MAX RADIUS: 1.323

MEAN RADIUS: 0.759

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

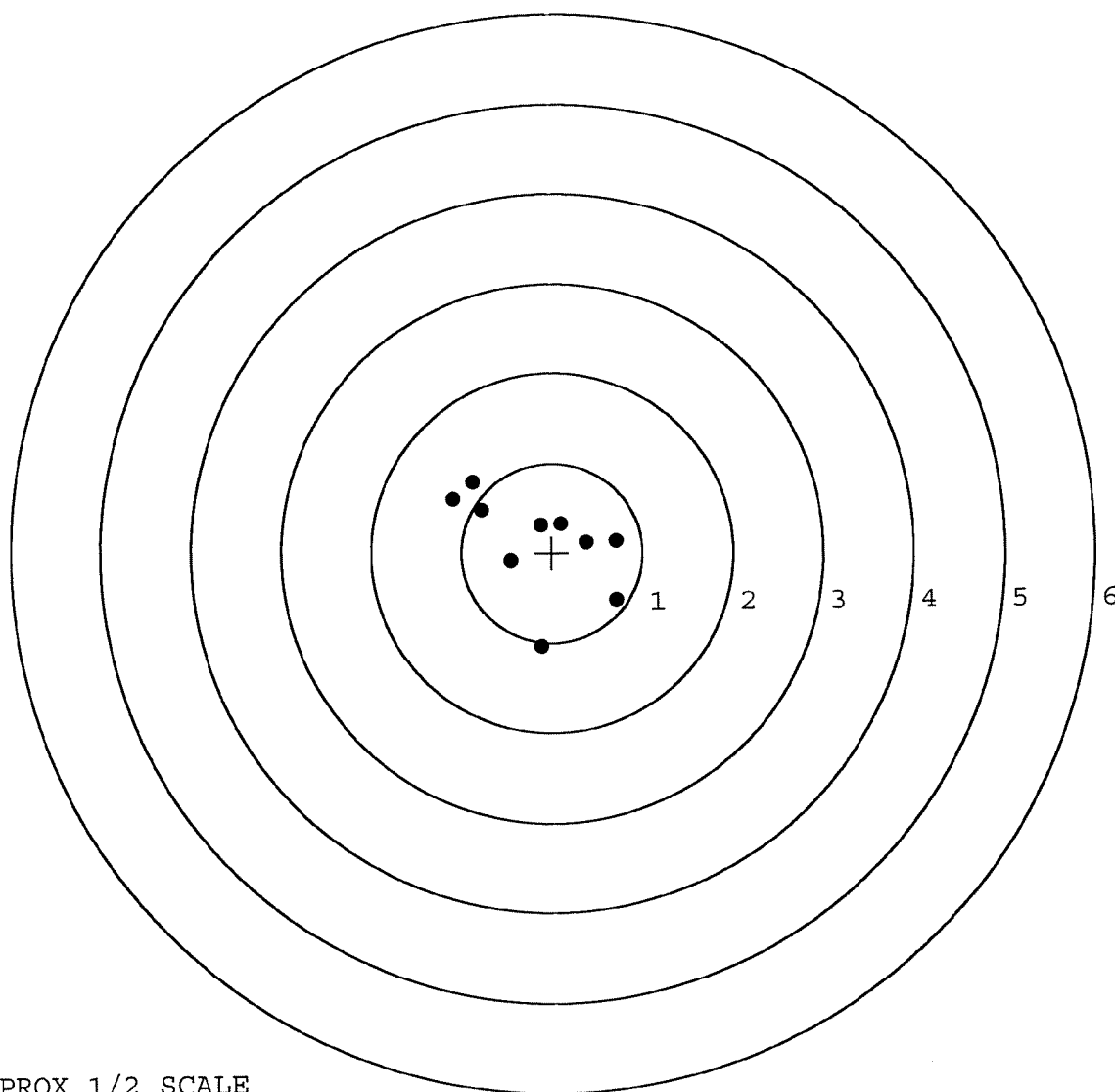


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591551. __0
TARGET NUMBER: 4
FILE DATE: 10/13/2006
FILE TIME: 06:00

POINT#	X	Y
1:	-0.125	-1.053
2:	0.712	-0.535
3:	-0.458	-0.091
4:	0.710	0.128
5:	0.386	0.114
6:	0.102	0.326
7:	-0.126	0.310
8:	-0.775	0.483
9:	-0.870	0.800
10:	-1.089	0.612

X CENTROID: -0.153
Y CENTROID: 0.109
POA TO CENTROID: 0.188
HORZ SPREAD: 1.801
VERT SPREAD: 1.853
GROUP SPREAD: 1.997
MIN RADIUS: 0.202
MAX RADIUS: 1.163
MEAN RADIUS: 0.733
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591551. __0

TARGET NUMBER: 5

FILE DATE: 10/13/2006

FILE TIME: 06:00

X CENTROID: -0.009

Y CENTROID: 0.103

POA TO CENTROID: 0.104

HORZ SPREAD: 1.225

VERT SPREAD: 1.733

GROUP SPREAD: 1.852

MIN RADIUS: 0.181

MAX RADIUS: 0.986

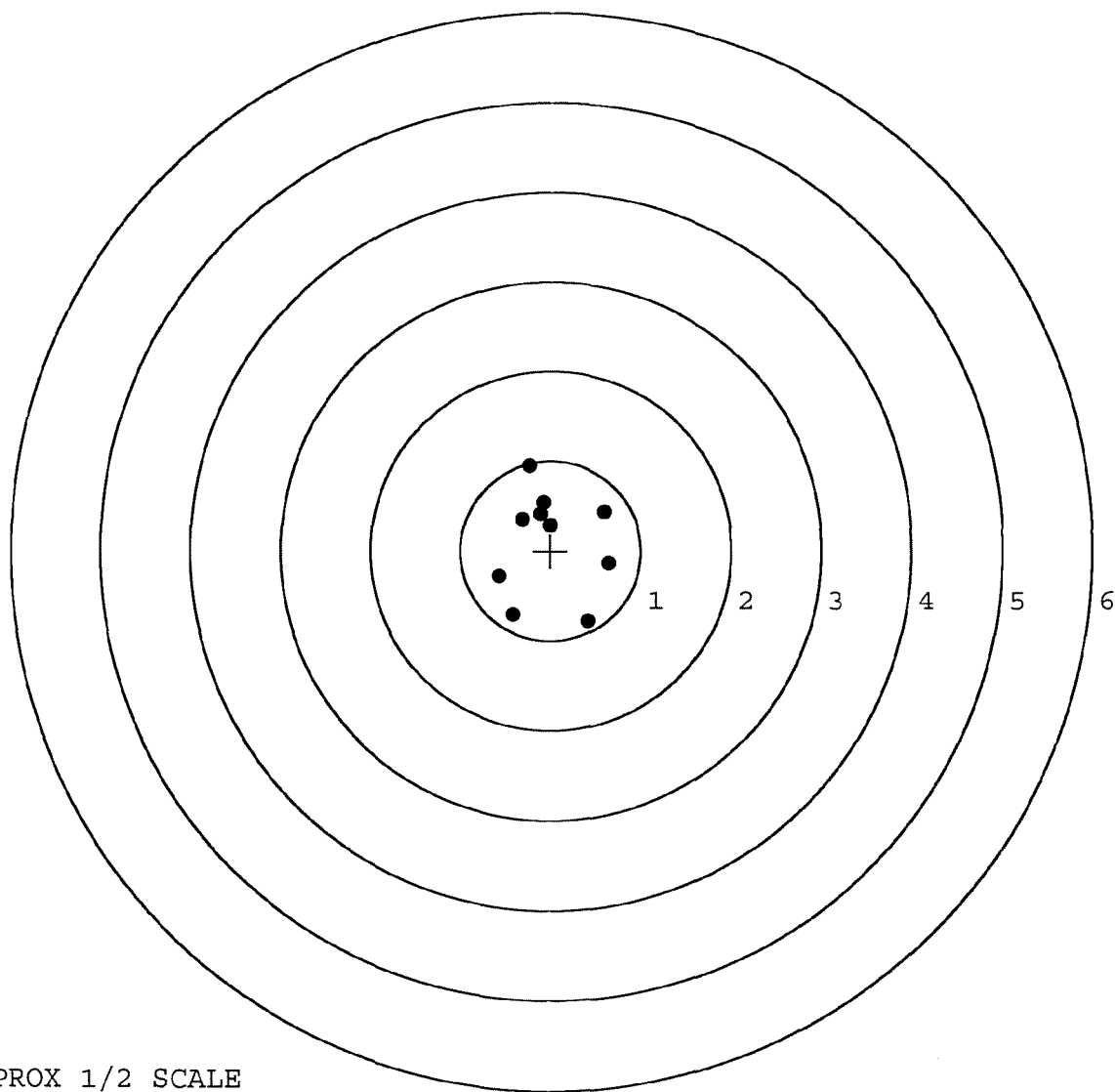
MEAN RADIUS: 0.619

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.414	-0.787
2:	-0.415	-0.718
3:	-0.573	-0.286
4:	0.652	-0.135
5:	0.594	0.437
6:	-0.238	0.946
7:	-0.081	0.535
8:	-0.011	0.284
9:	-0.318	0.348
10:	-0.115	0.407



TARGET APPROX 1/2 SCALE