

G- 659 1557

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

- INSTRUCTION BOOK 3518

ED FORM

proof of purchase



owner registration sticker



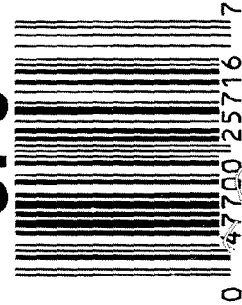
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6591557

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66591557

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-8-06	RJC
420	ASSEMBLE ACTION		9-14-06	RJC
430	ASSEMBLE TO STOCK		9-15-06	X.P.D.
440	PROOF		9-15-06	X.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-15-06	X.P.D.
470	DIS-ASSEMBLE ACTION	SEP 21 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	9-21-06	A.P.D.
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)		9/26	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/28/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/28/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/28/06	DA
	D) OIL FIRING PIN ASSEMBLY		9-29-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/11/06	MTJ

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁵</u> <u>8²</u> <u>7⁵</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5²</u> <u>6²</u> <u>6²</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	mtm
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-29-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/11/06	mtm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-29-06	BLG
	M) IRON SIGHT ALIGNMENT		9-29-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-29-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9/30/06	mtm
	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	mtm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.13</u> <u>2.76</u> <u>2.67</u> <u>2.83</u> <u>2.68</u>	10-3-06	DA
	C) FUNCTION		10/11/06	mtm
690	PACK		10-3-06	DA

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	233	255		244	
PULL #2	227	256		249	
PULL #3	223	254		250	
PULL #4	257	250		248	
PULL #5	254	245		245	
TOTAL	1194	1260		1236	
AVERAGE	238	252		247	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	299	290		
PULL #2	301	307		
PULL #3	308	301		
PULL #4	306	306		
PULL #5	309	307		
TOTAL	1523	1511		
AVERAGE	304	302		

	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	4.07	4.13		4.05
PULL #2	4.00	4.19		4.08
PULL #3	3.95	4.20		4.04
PULL #4	4.00	4.24		3.99
PULL #5	4.00	4.24		4.04
TOTAL	20.02	21.00		20.20
AVERAGE	4.00	4.20		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591557. __0
FILE DATE AND TIME: 09/30/2006 10:46

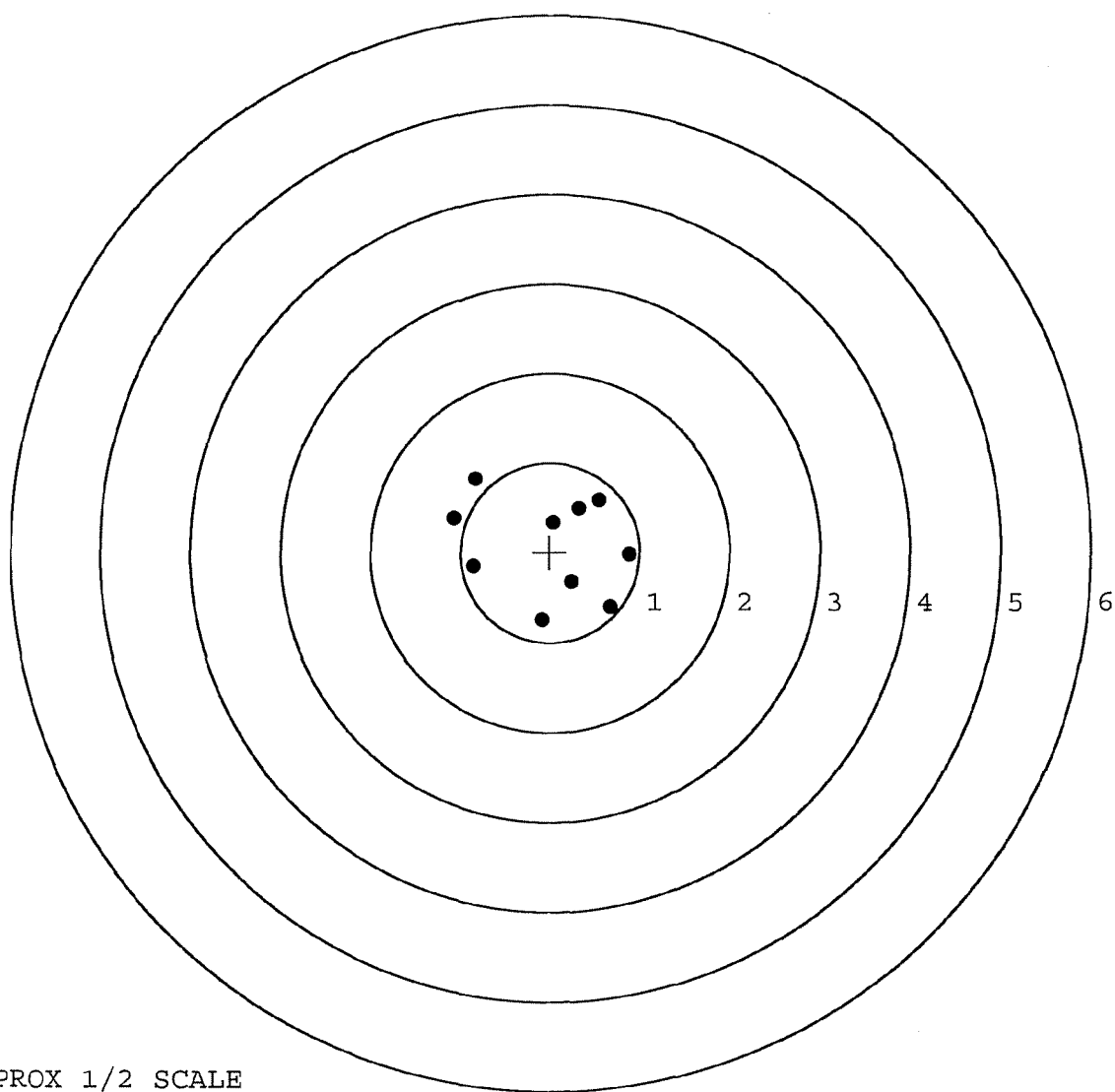
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.233
The Average Y Centroid of the Five Target Set:	0.017
The Average Point of Impact of the Five Target Set:	0.234
The Average Mean Radius of the Five Target Set:	0.743
The Distance from POA to Centroid Target #1:	0.074
The Distance from Centroid Target #2 to Centroid Target #1:	0.418
The Distance from Centroid Target #3 to Centroid Target #1:	0.165
The Distance from Centroid Target #4 to Centroid Target #1:	0.414
The Distance from Centroid Target #5 to Centroid Target #1:	0.339

SERIAL NUMBER: G6591557. __0
TARGET NUMBER: 1
FILE DATE: 09/30/2006
FILE TIME: 10:46

X CENTROID: -0.013
Y CENTROID: 0.073
POA TO CENTROID: 0.074
HORZ SPREAD: 1.962
VERT SPREAD: 1.580
GROUP SPREAD: 2.089
MIN RADIUS: 0.259
MAX RADIUS: 1.115
MEAN RADIUS: 0.784
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.836	0.825
2:	-1.074	0.379
3:	-0.854	-0.156
4:	0.550	0.584
5:	0.324	0.493
6:	0.038	0.327
7:	0.888	-0.028
8:	0.242	-0.328
9:	0.679	-0.613
10:	-0.089	-0.755

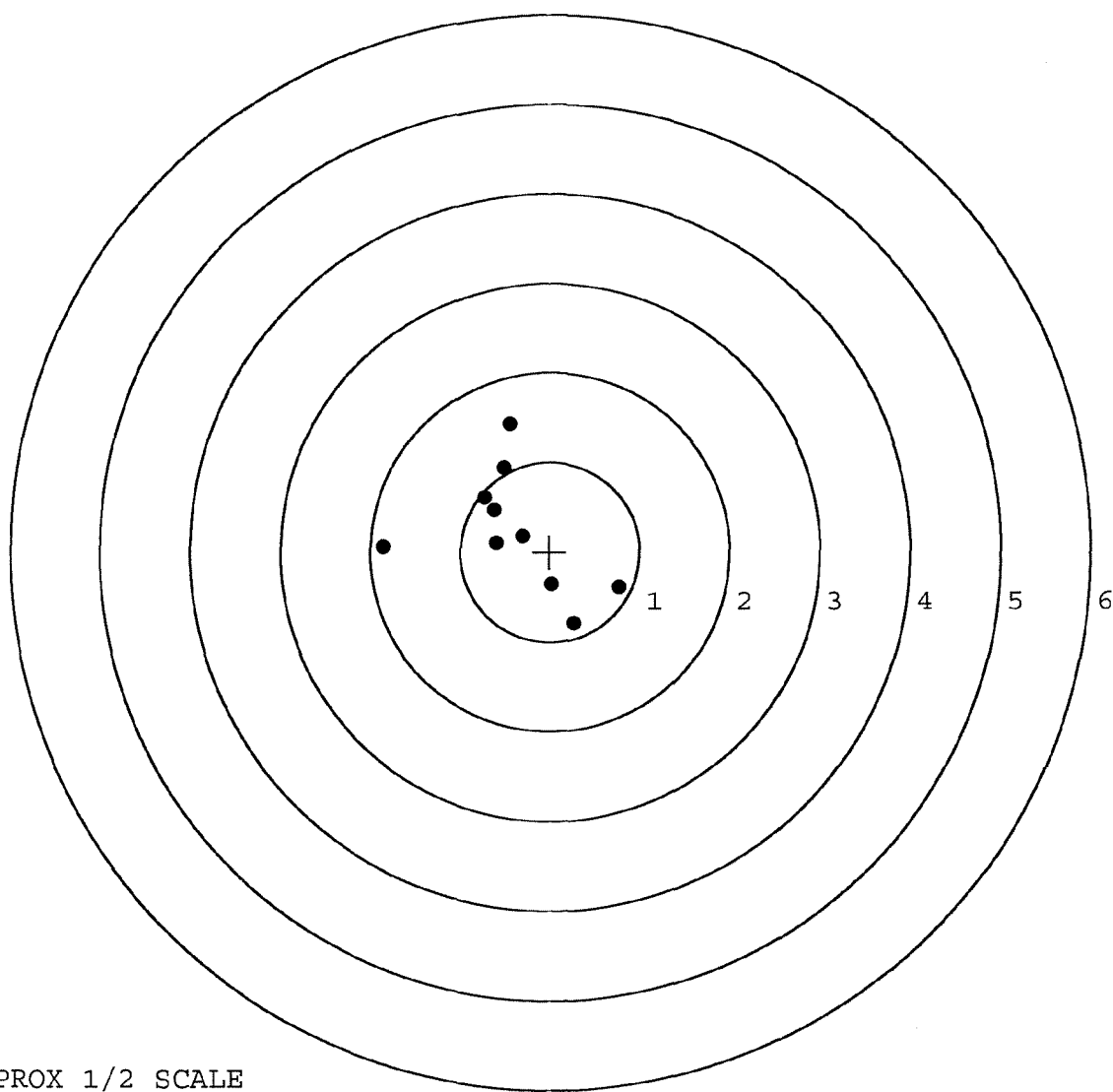


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591557. __0
TARGET NUMBER: 2
FILE DATE: 09/30/2006
FILE TIME: 10:46

X CENTROID: -0.403
Y CENTROID: 0.223
POA TO CENTROID: 0.460
HORZ SPREAD: 2.642
VERT SPREAD: 2.219
GROUP SPREAD: 2.682
MIN RADIUS: 0.105
MAX RADIUS: 1.472
MEAN RADIUS: 0.785
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.453	1.425
2:	-0.513	0.939
3:	-0.729	0.610
4:	-1.866	0.065
5:	-0.603	0.101
6:	-0.309	0.175
7:	0.021	-0.362
8:	0.270	-0.794
9:	0.776	-0.399
10:	-0.622	0.469

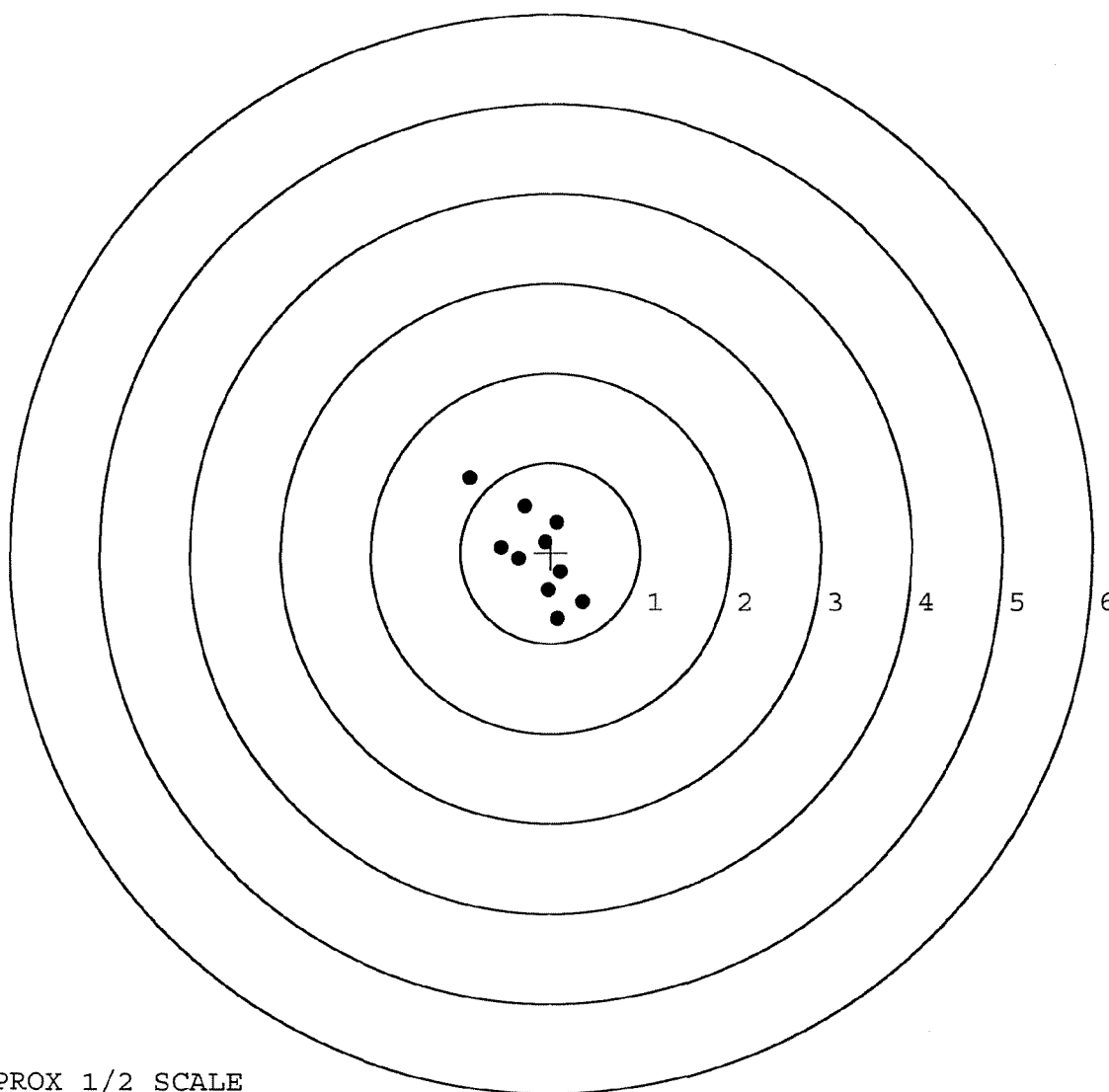


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591557. 0
TARGET NUMBER: 3
FILE DATE: 09/30/2006
FILE TIME: 10:46

POINT#	X	Y
1:	-0.901	0.838
2:	-0.293	0.517
3:	0.072	0.337
4:	-0.066	0.120
5:	0.120	-0.216
6:	-0.026	-0.415
7:	0.086	-0.735
8:	0.365	-0.547
9:	-0.359	-0.068
10:	-0.556	0.060

X CENTROID: -0.156
Y CENTROID: -0.011
POA TO CENTROID: 0.156
HORZ SPREAD: 1.266
VERT SPREAD: 1.573
GROUP SPREAD: 1.876
MIN RADIUS: 0.159
MAX RADIUS: 1.130
MEAN RADIUS: 0.515
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591557. __0

TARGET NUMBER: 4

FILE DATE: 09/30/2006

FILE TIME: 10:46

POINT#	X	Y
1:	-1.644	0.664
2:	-1.198	0.875
3:	-0.316	0.792
4:	0.030	0.535
5:	0.257	0.577
6:	-0.366	-0.113
7:	0.143	-0.500
8:	-0.433	-0.597
9:	-0.258	-0.730
10:	-0.466	-1.195

X CENTROID: -0.425

Y CENTROID: 0.031

POA TO CENTROID: 0.426

HORZ SPREAD: 1.901

VERT SPREAD: 2.070

GROUP SPREAD: 2.201

MIN RADIUS: 0.155

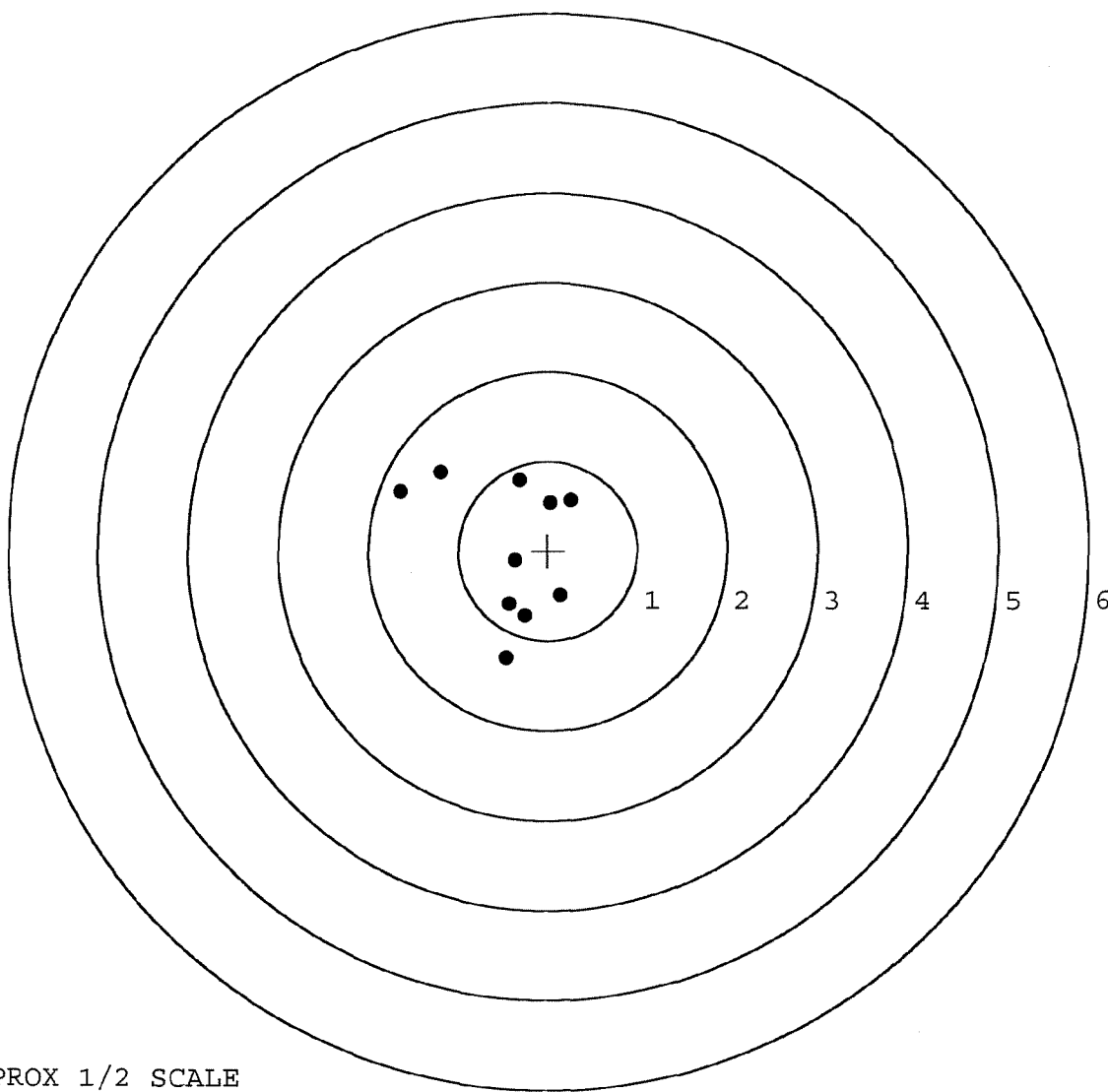
MAX RADIUS: 1.374

MEAN RADIUS: 0.841

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

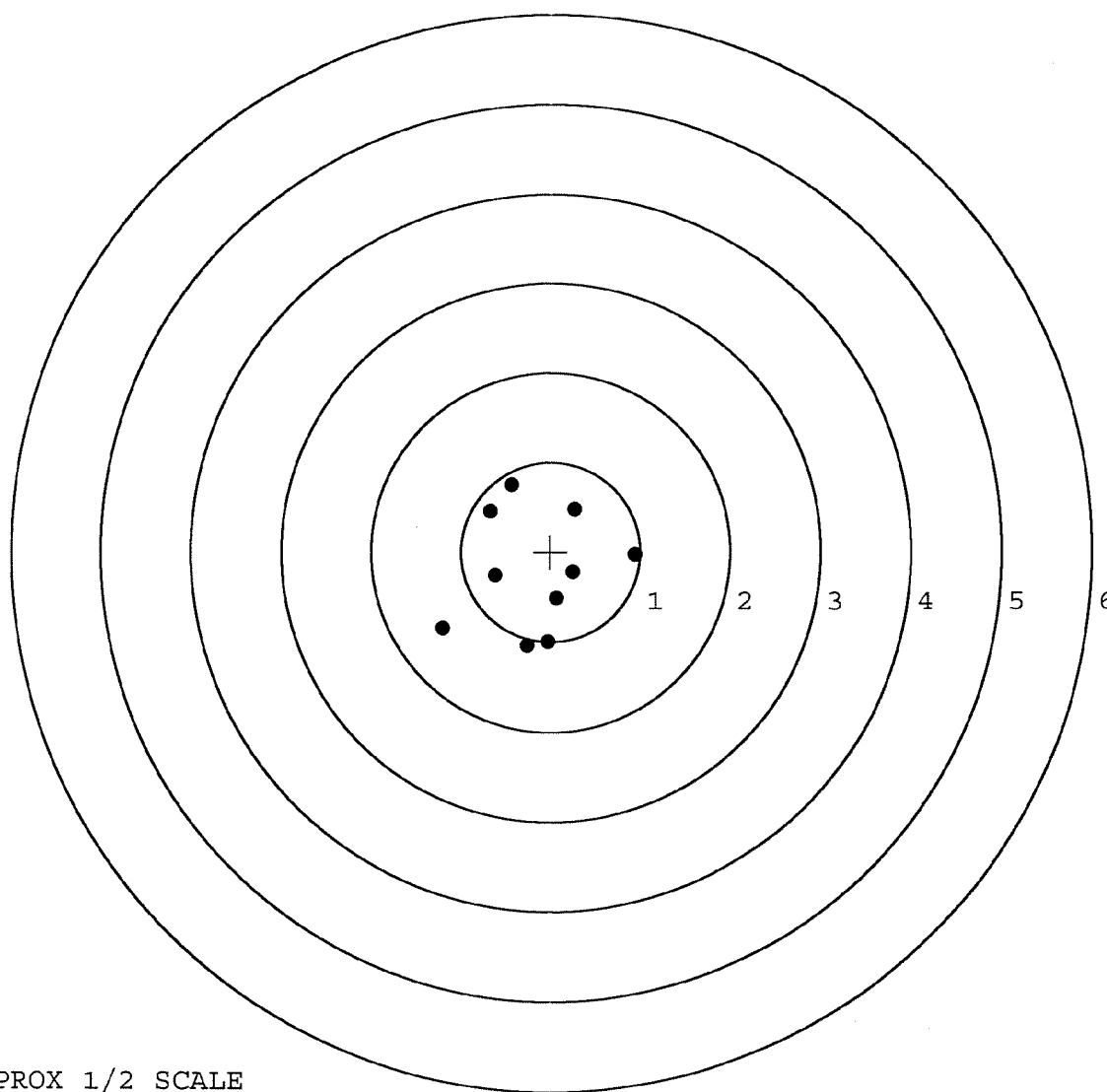


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591557.____0
TARGET NUMBER: 5
FILE DATE: 09/30/2006
FILE TIME: 10:46

POINT#	X	Y
1:	-0.678	0.455
2:	-0.438	0.748
3:	0.273	0.478
4:	0.942	-0.035
5:	0.253	-0.227
6:	0.067	-0.524
7:	-0.029	-1.009
8:	-0.262	-1.050
9:	-0.620	-0.265
10:	-1.205	-0.855

X CENTROID: -0.170
Y CENTROID: -0.228
POA TO CENTROID: 0.285
HORZ SPREAD: 2.147
VERT SPREAD: 1.798
GROUP SPREAD: 2.298
MIN RADIUS: 0.379
MAX RADIUS: 1.210
MEAN RADIUS: 0.791
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE