

G-6591566

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



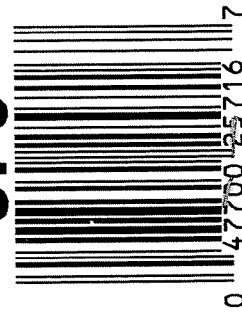
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591566

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591566

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-16-06	RTZ
420	ASSEMBLE ACTION		8-16-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF	MAGNA-FLUX	8-16-06	L.P.D.
460	CHECK HEADSPACE	INSPECTED	8-16-06	L.P.D.
470	DIS-ASSEMBLE ACTION	AUG 17 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <u>curms</u>	8/17/06	curms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-17-06	CW
510	DRILL AND TAP SIGHT HOLES		8-17-06	TRW
520	GOFF BLAST BBL / REC		8-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/24/06	TBB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-6-08	BLC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-6-08	BLC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-6-08	BLC
	D) OIL FIRING PIN ASSEMBLY		9-6-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/16/06	MMW

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>6.0</u> <u>6.5</u>	9-8-06	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>4.0</u> <u>4.0</u>	9-8-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/06	mm
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	9-8-06	DA
	J) ASSEMBLE STOCK		9-6-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/16/06	mm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-6-06	BLG
	M) IRON SIGHT ALIGNMENT		9-6-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-6-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-6-06	TRL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-6-06	BD
670	FINAL INSPECTION A) HEADSPACE		10/16/06	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.69</u> <u>2.69</u> <u>2.86</u> <u>2.75</u>	9-8-06	DA
	C) FUNCTION		10/16/06	mm
690	PACK		10/4/06	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 9-5-06

TESTER mjh

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.42	2.48		2.50	
PULL #2	2.51	2.51		2.56	
PULL #3	2.54	2.54		2.57	
PULL #4	2.50	2.75		2.44	
PULL #5	2.57	2.58		2.59	
TOTAL	12.54	13.06		12.71	
AVERAGE	2.51	2.61		2.54	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.09		
PULL #2	3.07	3.00		
PULL #3	3.11	2.85		
PULL #4	3.12	2.89		
PULL #5	3.09	3.09		
TOTAL	15.51	15.00		
AVERAGE	3.10	3.00		

	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	3.99		3.81
PULL #2	4.01	3.99		4.11
PULL #3	4.02	3.84		4.07
PULL #4	3.94	4.04		4.14
PULL #5	3.86	3.97		3.98
TOTAL	19.92	19.83		20.11
AVERAGE	3.98	3.97 ^{mjh} 3.97		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591566.___0
FILE DATE AND TIME: 09/06/2006 01:48

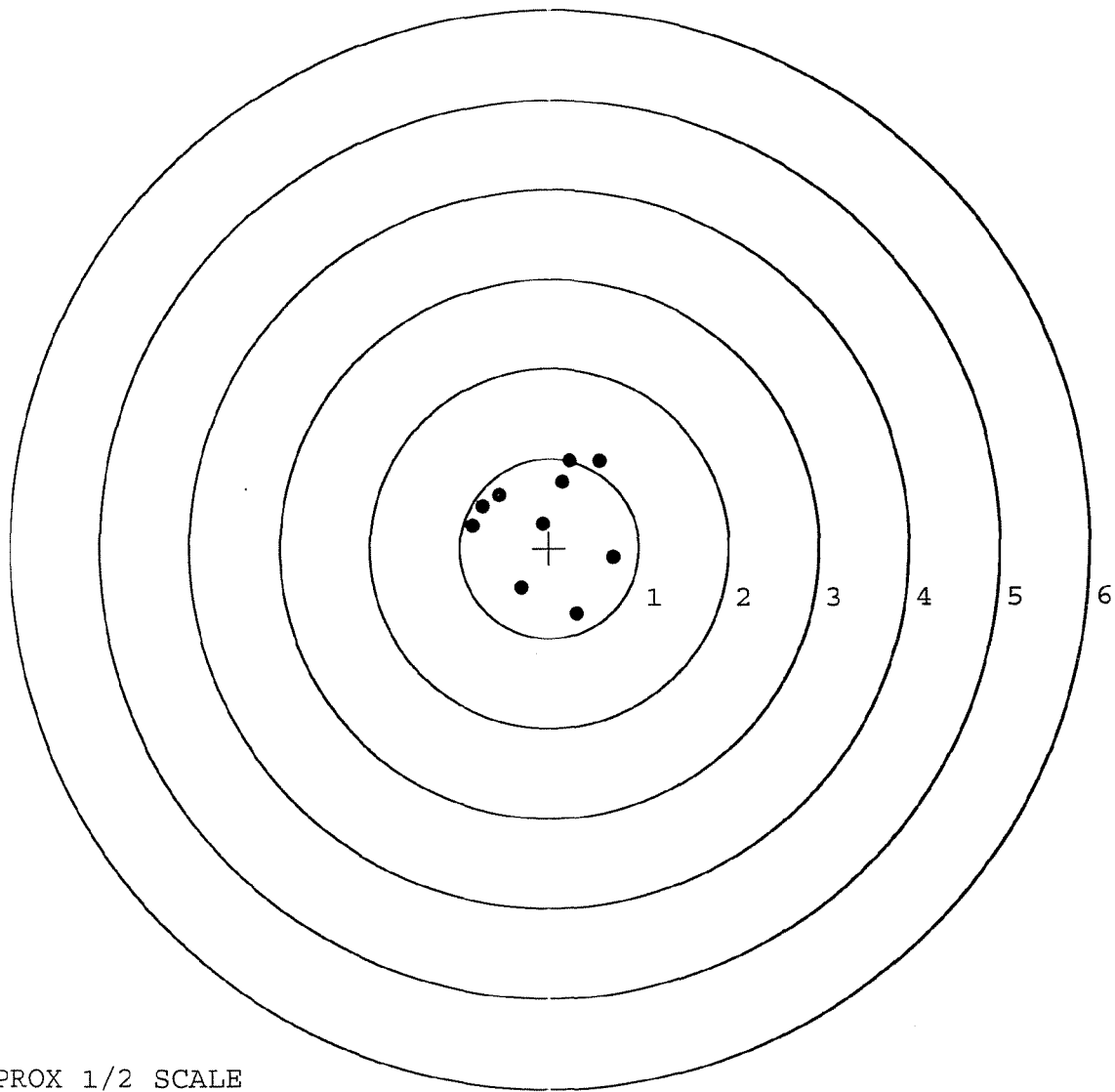
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.019
The Average Y Centroid of the Five Target Set:	-0.042
The Average Point of Impact of the Five Target Set:	0.046
The Average Mean Radius of the Five Target Set:	0.848
The Distance from POA to Centroid Target #1:	0.307
The Distance from Centroid Target #2 to Centroid Target #1:	0.486
The Distance from Centroid Target #3 to Centroid Target #1:	0.494
The Distance from Centroid Target #4 to Centroid Target #1:	0.621
The Distance from Centroid Target #5 to Centroid Target #1:	0.302

SERIAL NUMBER: G6591566. __0
TARGET NUMBER: 1
FILE DATE: 09/06/2006
FILE TIME: 01:48

X CENTROID: -0.060
Y CENTROID: 0.301
POA TO CENTROID: 0.307
HORZ SPREAD: 1.582
VERT SPREAD: 1.709
GROUP SPREAD: 1.727
MIN RADIUS: 0.033
MAX RADIUS: 1.097
MEAN RADIUS: 0.702
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.866	0.256
2:	-0.747	0.476
3:	-0.562	0.597
4:	-0.077	0.273
5:	0.149	0.735
6:	0.227	0.976
7:	0.561	0.978
8:	0.716	-0.103
9:	-0.311	-0.442
10:	0.310	-0.731



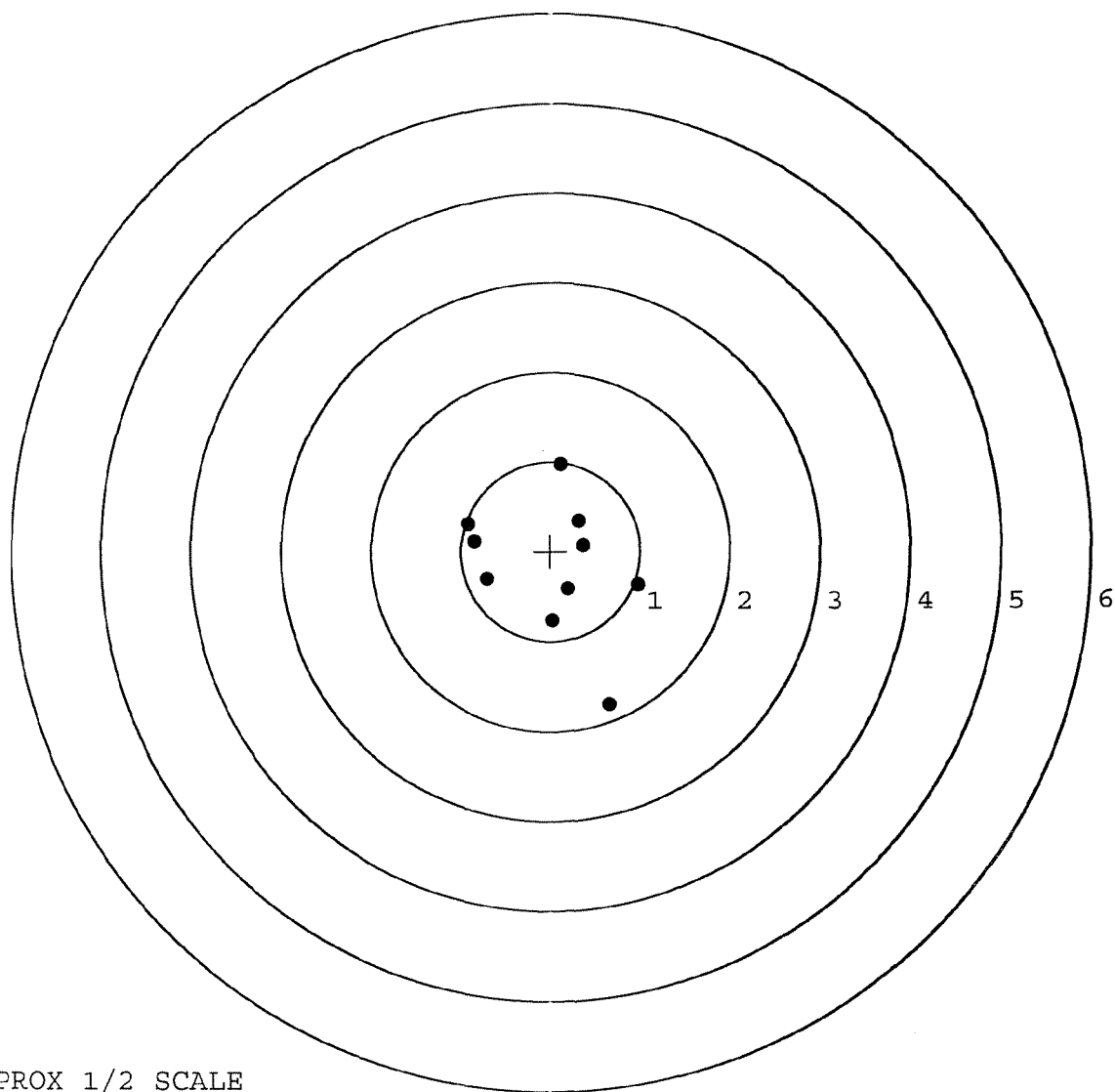
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591566. 0
TARGET NUMBER: 2
FILE DATE: 09/06/2006
FILE TIME: 01:48

X CENTROID: 0.018
Y CENTROID: -0.178
POA TO CENTROID: 0.179
HORZ SPREAD: 1.898
VERT SPREAD: 2.674
GROUP SPREAD: 2.729
MIN RADIUS: 0.304
MAX RADIUS: 1.658
MEAN RADIUS: 0.845

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.923	0.311
2:	-0.856	0.115
3:	-0.712	-0.309
4:	0.026	-0.777
5:	0.195	-0.425
6:	0.373	0.073
7:	0.318	0.342
8:	0.118	0.968
9:	0.975	-0.375
10:	0.661	-1.706



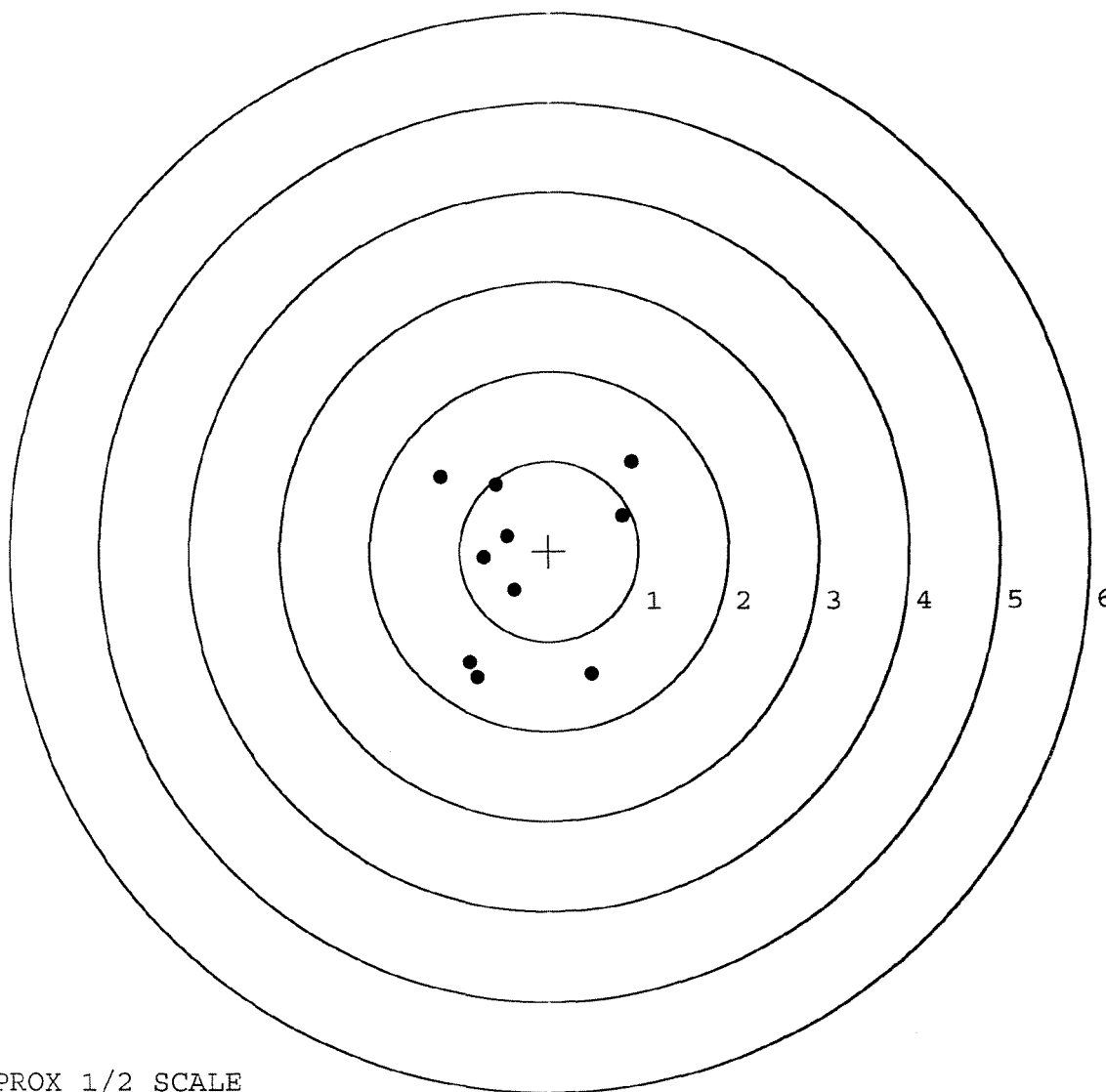
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591566. __0
TARGET NUMBER: 3
FILE DATE: 09/06/2006
FILE TIME: 01:48

POINT#	X	Y
1:	-1.208	0.821
2:	-0.599	0.746
3:	-0.477	0.171
4:	-0.731	-0.071
5:	-0.393	-0.430
6:	-0.882	-1.231
7:	-0.801	-1.397
8:	0.485	-1.365
9:	0.815	0.393
10:	0.923	0.989

X CENTROID: -0.287
Y CENTROID: -0.137
POA TO CENTROID: 0.318
HORZ SPREAD: 2.131
VERT SPREAD: 2.386
GROUP SPREAD: 2.944
MIN RADIUS: 0.311
MAX RADIUS: 1.653
MEAN RADIUS: 1.032

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9

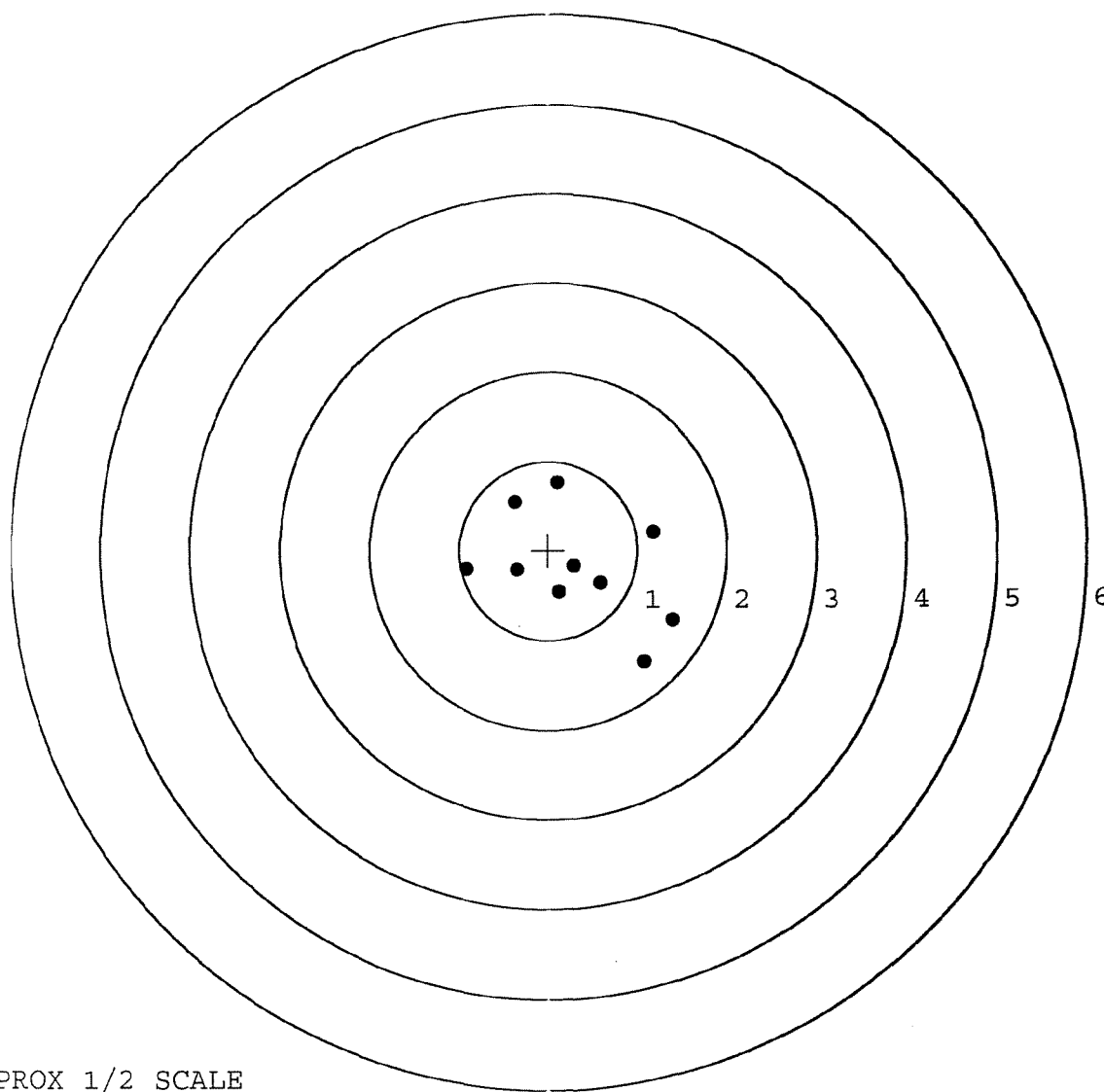


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591566. __0
TARGET NUMBER: 4
FILE DATE: 09/06/2006
FILE TIME: 01:48

X CENTROID: 0.310
Y CENTROID: -0.197
POA TO CENTROID: 0.368
HORZ SPREAD: 2.307
VERT SPREAD: 2.002
GROUP SPREAD: 2.304
MIN RADIUS: 0.029
MAX RADIUS: 1.295
MEAN RADIUS: 0.804
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.378	0.546
2:	0.103	0.762
3:	-0.915	-0.211
4:	-0.347	-0.226
5:	0.123	-0.471
6:	0.290	-0.177
7:	0.592	-0.372
8:	1.078	-1.240
9:	1.392	-0.784
10:	1.167	0.202



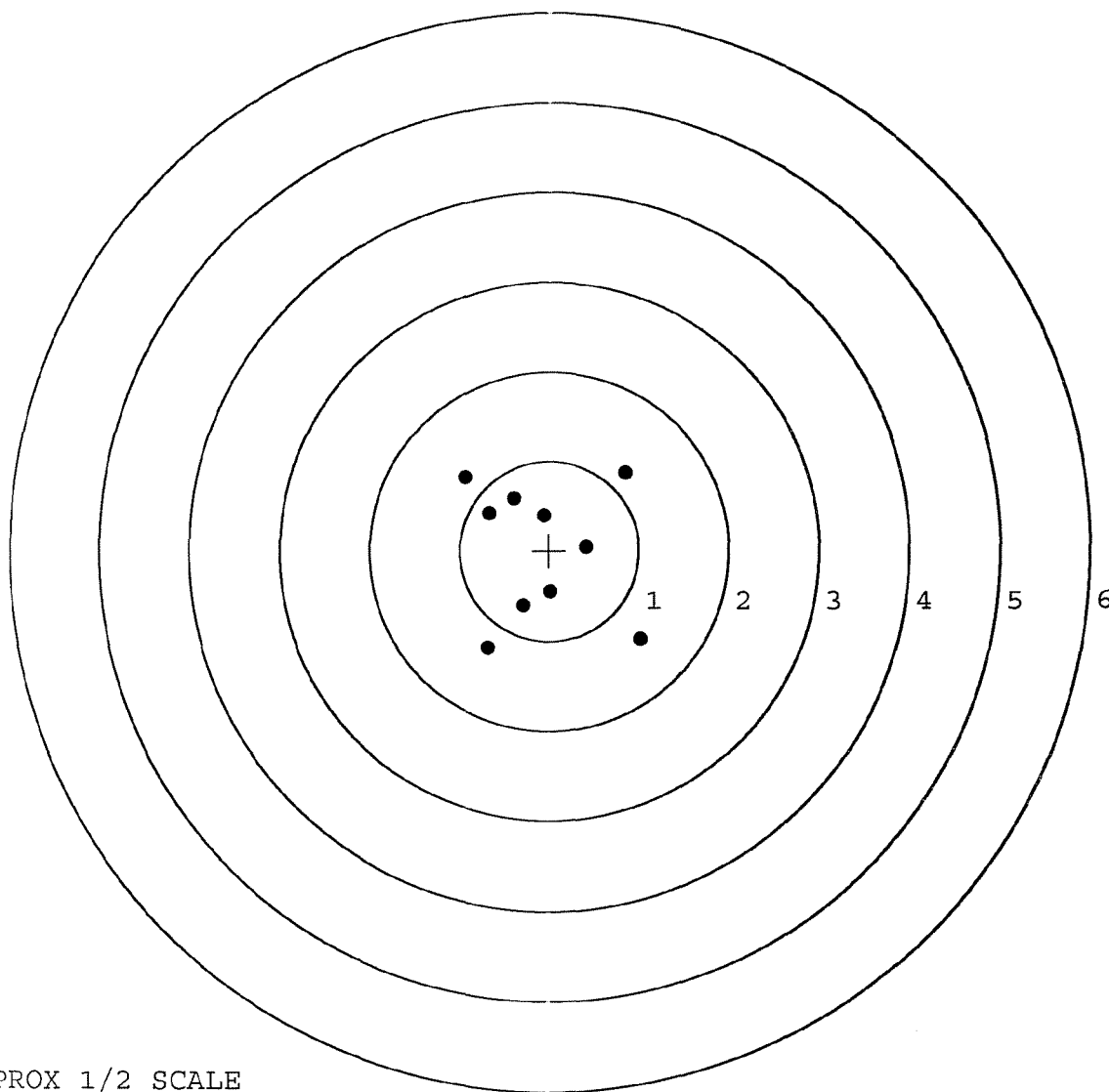
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591566. 0
TARGET NUMBER: 5
FILE DATE: 09/06/2006
FILE TIME: 01:48

X CENTROID: -0.075
Y CENTROID: 0.000
POA TO CENTROID: 0.075
HORZ SPREAD: 1.959
VERT SPREAD: 1.950
GROUP SPREAD: 2.662
MIN RADIUS: 0.389
MAX RADIUS: 1.470
MEAN RADIUS: 0.857

POINT#	X	Y
1:	-0.942	0.818
2:	-0.674	0.419
3:	-0.398	0.585
4:	-0.064	0.389
5:	0.849	0.873
6:	0.419	0.043
7:	1.017	-0.984
8:	0.019	-0.456
9:	-0.287	-0.609
10:	-0.692	-1.077

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE