

G 659 1568

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



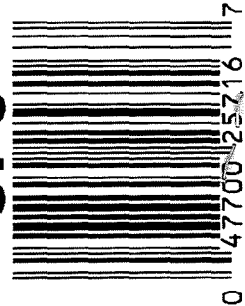
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6591568

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST~~EM~~)

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M/24 7.62 NATO S.W.S. (COMPLETE SYST~~EM~~)

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591568

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-22-06	RTZ
420	ASSEMBLE ACTION		9-20-06	RTZ
430	ASSEMBLE TO STOCK		9-21-06	RP
440	PROOF		9-21-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-21-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 22 2006	9-21-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	9-22-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-22-06	CW
510	DRILL AND TAP SIGHT HOLES		9-21-06	TRW
520	GOFF BLAST BBL / REC		9-22-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/25	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/26/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/26/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/26/06	DA
	D) OIL FIRING PIN ASSEMBLY		9-26-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/16/06	mm

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>6²</u> <u>7²</u>	10-3-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>6²</u> <u>5⁵</u> <u>6²</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/16/06	nmh
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-26-06	BLG
	K) ASSEMBLE SWIVEL STUDS		10/16/06	nmh
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-26-06	BLG
	M) IRON SIGHT ALIGNMENT		9-26-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-26-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-26-06	DA
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-26-06	nmh
670	FINAL INSPECTION A) HEADSPACE		10/16/06	nmh
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.72</u> <u>2.76</u> <u>2.54</u> <u>2.51</u> <u>2.78</u>	9/28/06	DA
	C) FUNCTION		10/16/06	nmh
690	PACK		11/7/06	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 9-25-06
TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	254	240		252	
PULL #2	255	249		253	
PULL #3	262	252		253	
PULL #4	263	251		244	
PULL #5	260	255		252	
TOTAL	1294	1247		1254	
AVERAGE	258	249		250	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	302	298		
PULL #2	306	303		
PULL #3	305	301		
PULL #4	304	302		
PULL #5	306	302		
TOTAL	1523	1506		
AVERAGE	304	301		

	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	403	406		4.17
PULL #2	402	413		4.14
PULL #3	403	407		4.12
PULL #4	403	406		4.09
PULL #5	404	401		4.09
TOTAL	2015	2033		20.61
AVERAGE	403	406		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591568.___0

FILE DATE AND TIME: 09/27/2006 05:46

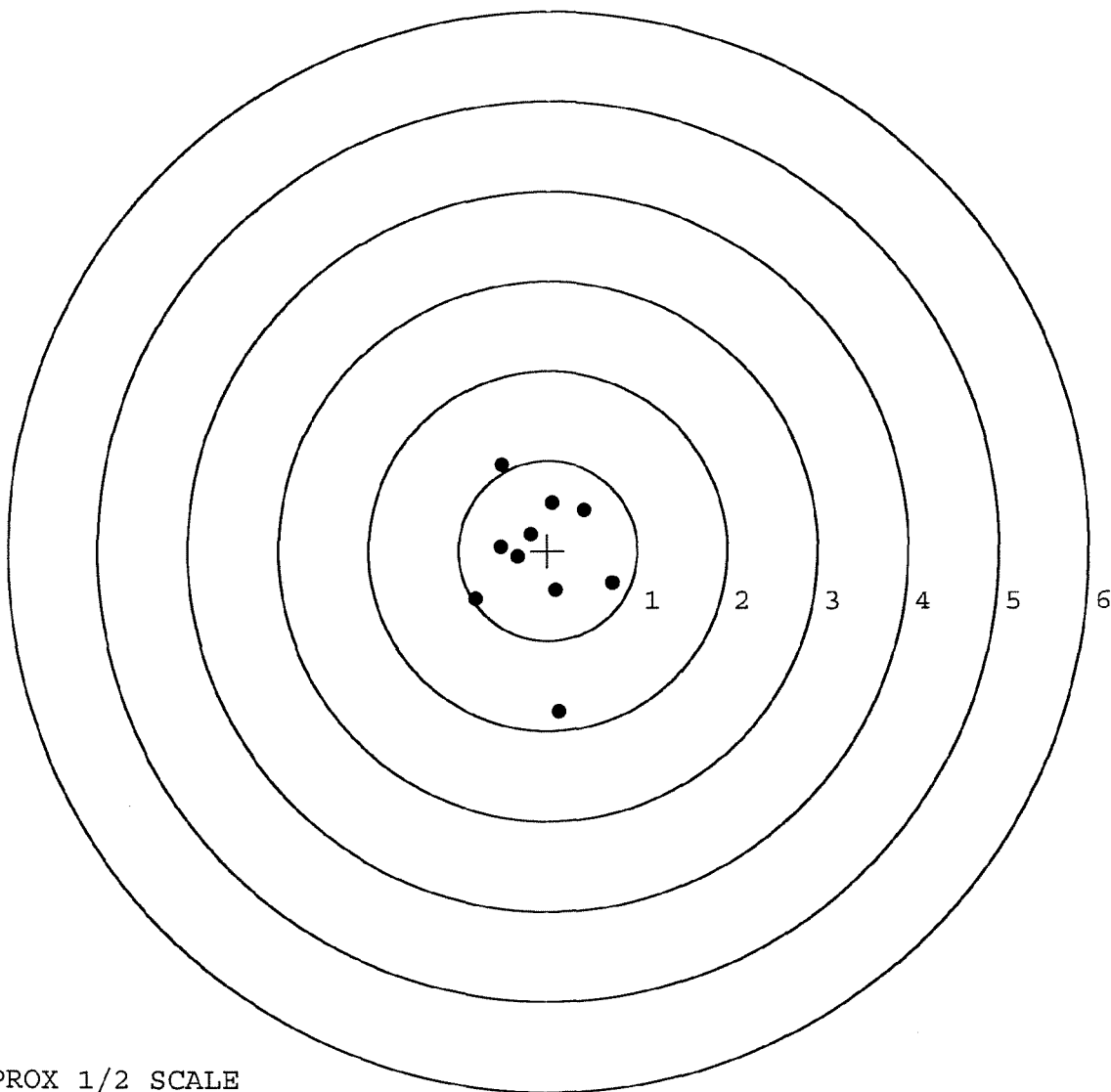
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	-0.008
The Average Point of Impact of the Five Target Set:	0.008
The Average Mean Radius of the Five Target Set:	0.610
The Distance from POA to Centroid Target #1:	0.143
The Distance from Centroid Target #2 to Centroid Target #1:	0.141
The Distance from Centroid Target #3 to Centroid Target #1:	0.246
The Distance from Centroid Target #4 to Centroid Target #1:	0.121
The Distance from Centroid Target #5 to Centroid Target #1:	0.196

SERIAL NUMBER: G6591568. __0
TARGET NUMBER: 1
FILE DATE: 09/27/2006
FILE TIME: 05:46

POINT#	X	Y
1:	0.130	-1.794
2:	-0.809	-0.546
3:	0.093	-0.442
4:	0.721	-0.357
5:	0.405	0.458
6:	0.053	0.530
7:	-0.519	0.950
8:	-0.194	0.185
9:	-0.338	-0.067
10:	-0.522	0.045

X CENTROID: -0.098
Y CENTROID: -0.104
POA TO CENTROID: 0.143
HORZ SPREAD: 1.530
VERT SPREAD: 2.744
GROUP SPREAD: 2.820
MIN RADIUS: 0.243
MAX RADIUS: 1.706
MEAN RADIUS: 0.733
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



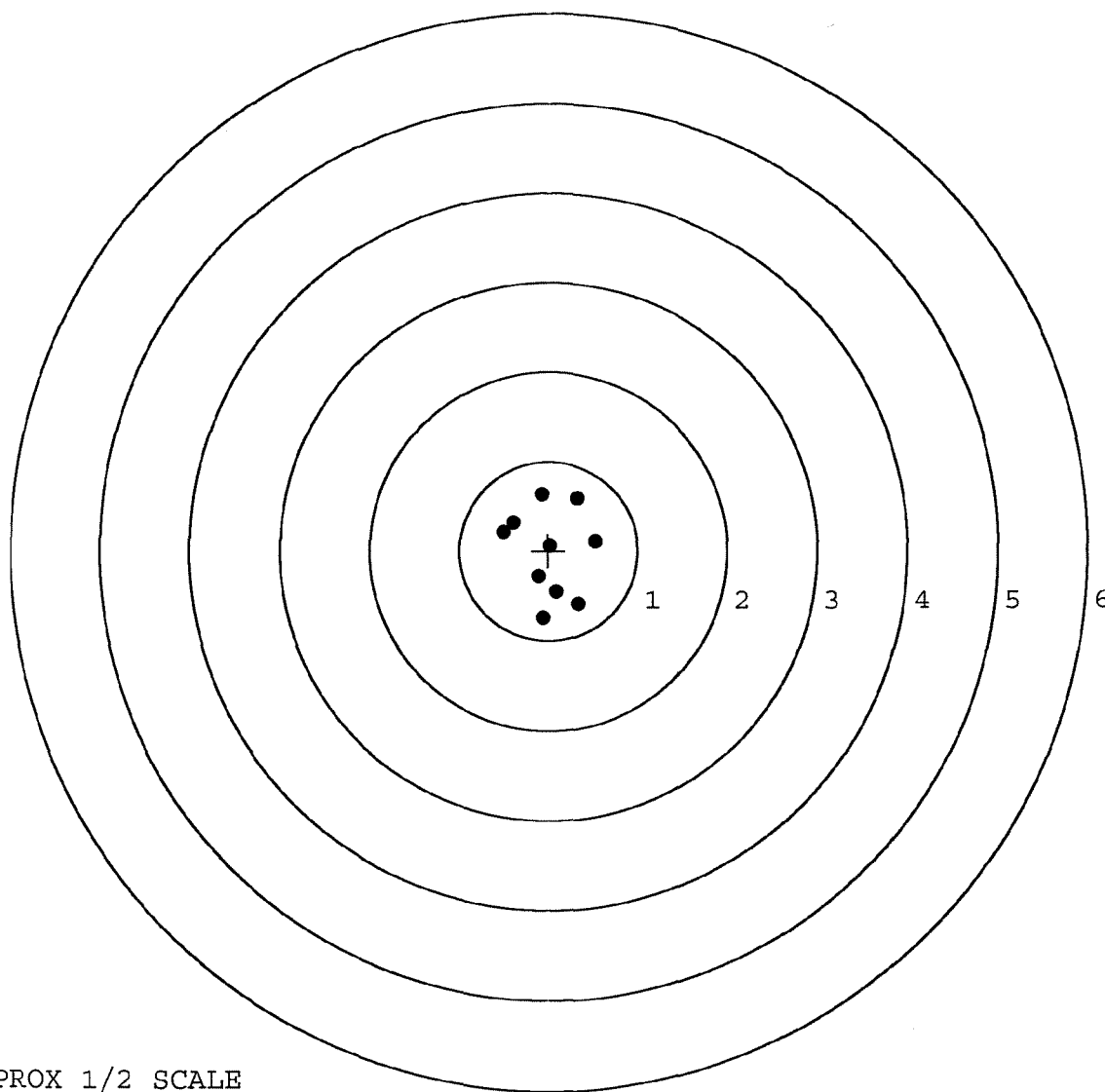
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591568. 0
TARGET NUMBER: 2
FILE DATE: 09/27/2006
FILE TIME: 05:46

X CENTROID: 0.015
Y CENTROID: -0.019
POA TO CENTROID: 0.024
HORZ SPREAD: 1.042
VERT SPREAD: 1.388
GROUP SPREAD: 1.403
MIN RADIUS: 0.076
MAX RADIUS: 0.742
MEAN RADIUS: 0.521

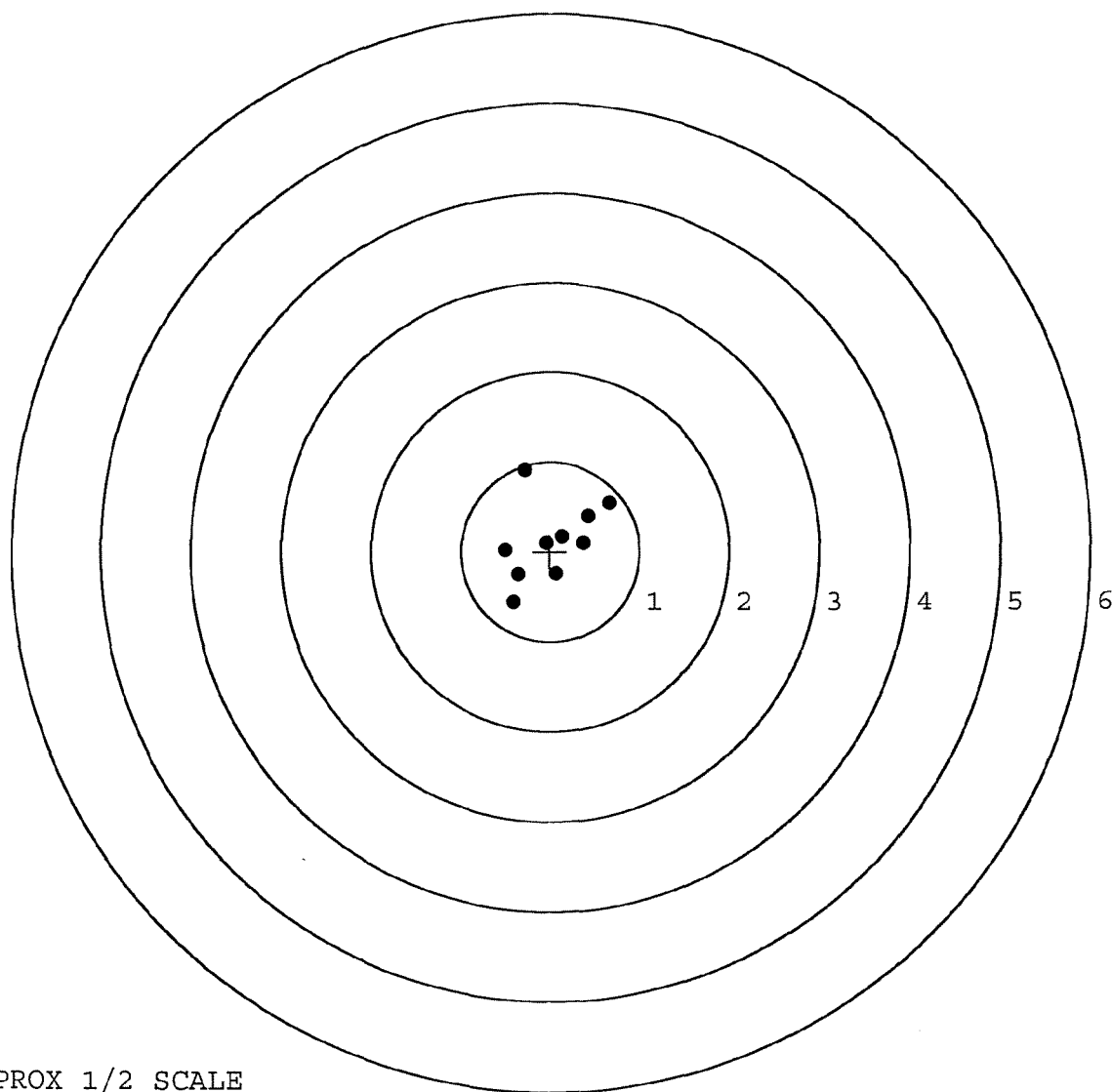
POINT#	X	Y
1:	-0.075	0.632
2:	0.324	0.592
3:	0.530	0.109
4:	-0.399	0.318
5:	-0.512	0.212
6:	-0.065	-0.756
7:	0.337	-0.596
8:	0.089	-0.462
9:	-0.109	-0.291
10:	0.026	0.057

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



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591568. __0	POINT#	X	Y
TARGET NUMBER: 3	1:	-0.286	0.910
FILE DATE: 09/27/2006	2:	0.661	0.553
FILE TIME: 05:46	3:	0.425	0.401
	4:	0.375	0.106
X CENTROID: 0.006	5:	0.071	-0.249
Y CENTROID: 0.119	6:	-0.408	-0.564
POA TO CENTROID: 0.119	7:	-0.355	-0.254
HORZ SPREAD: 1.165	8:	-0.504	0.023
VERT SPREAD: 1.474	9:	-0.045	0.096
GROUP SPREAD: 1.479	10:	0.130	0.170
MIN RADIUS: 0.056			
MAX RADIUS: 0.843			
MEAN RADIUS: 0.490			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 10			
# in 3 IN DIAMETER: 10			



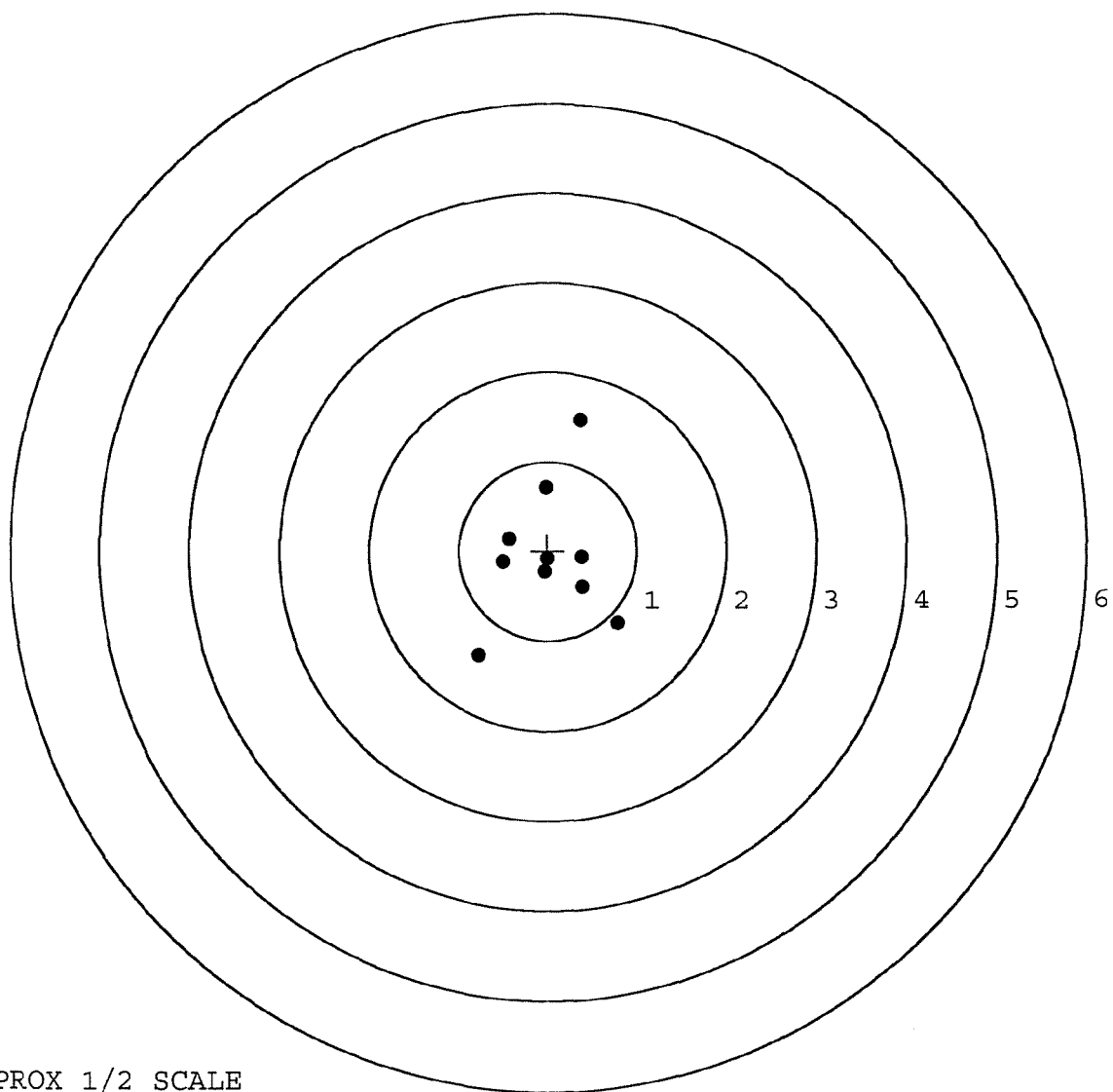
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591568. 0
TARGET NUMBER: 4
FILE DATE: 09/27/2006
FILE TIME: 05:46

X CENTROID: 0.015
Y CENTROID: -0.059
POA TO CENTROID: 0.060
HORZ SPREAD: 1.562
VERT SPREAD: 2.628
GROUP SPREAD: 2.863
MIN RADIUS: 0.039
MAX RADIUS: 1.562
MEAN RADIUS: 0.688

POINT#	X	Y
1:	-0.776	-1.163
2:	0.786	-0.811
3:	0.360	1.465
4:	-0.023	0.707
5:	0.391	-0.401
6:	0.386	-0.072
7:	-0.035	-0.237
8:	-0.006	-0.092
9:	-0.504	-0.121
10:	-0.434	0.140

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591568. __0

TARGET NUMBER: 5

FILE DATE: 09/27/2006

FILE TIME: 05:46

POINT#	X	Y
1:	-0.940	-0.307
2:	-0.703	-0.168
3:	0.671	-0.726
4:	0.805	-0.199
5:	0.378	-0.250
6:	0.491	0.202
7:	0.093	0.194
8:	0.020	0.563
9:	-0.281	0.543
10:	-0.017	0.370

X CENTROID: 0.052

Y CENTROID: 0.022

POA TO CENTROID: 0.056

HORZ SPREAD: 1.745

VERT SPREAD: 1.289

GROUP SPREAD: 1.748

MIN RADIUS: 0.177

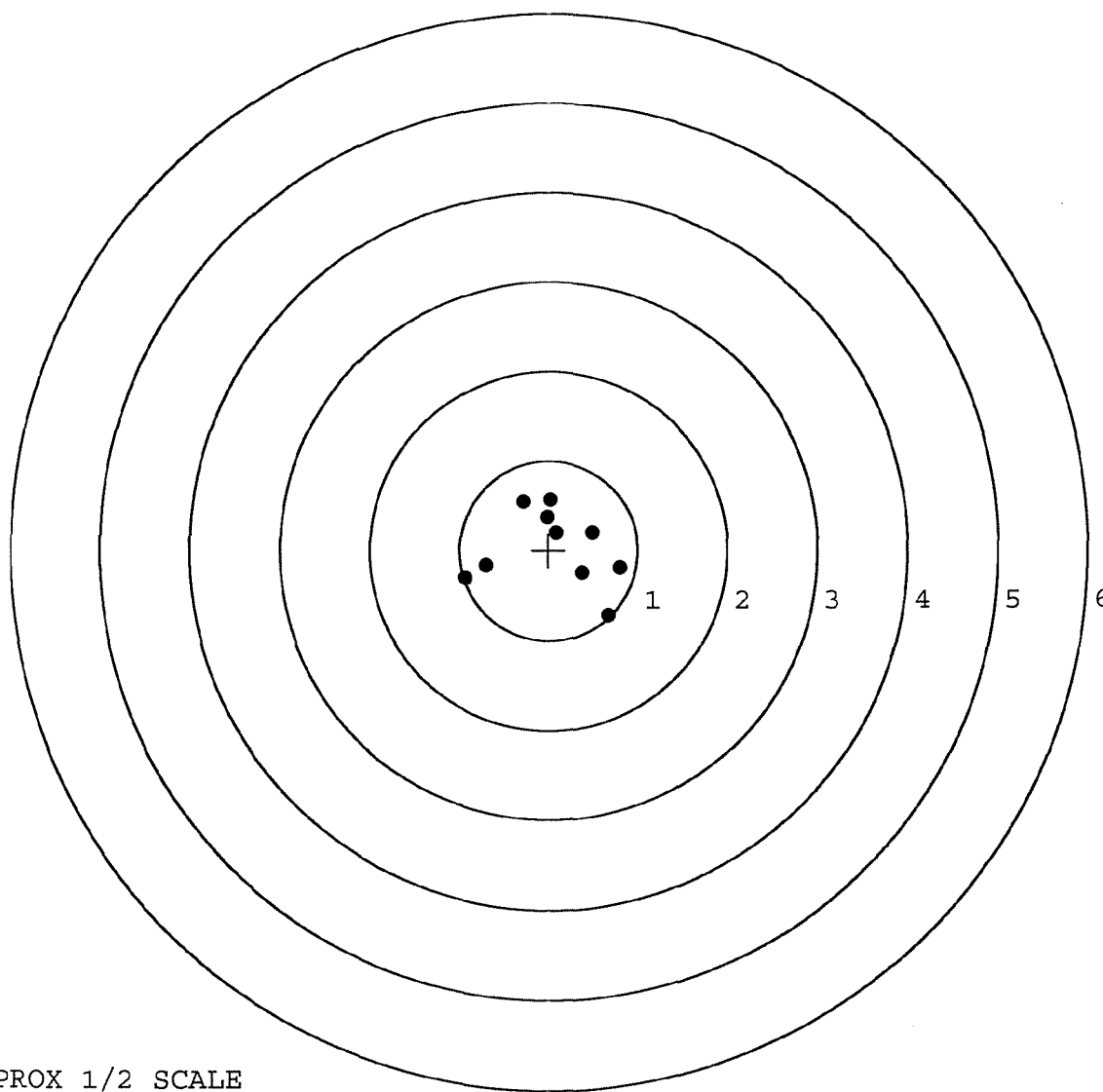
MAX RADIUS: 1.045

MEAN RADIUS: 0.617

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE