

G 659 16 14

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



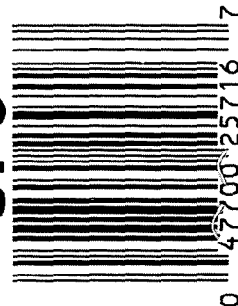
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591614

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 # G 6591614

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-12-06	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	RP
	(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	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/10/06	MM

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7°</u> <u>7°</u> <u>6°</u>	10-2-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>5°</u> <u>6°</u> <u>5°</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/10/06	nom
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.025</u> <u>.027</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-26-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10/10/06	nom
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-26-06	BLC
	M) IRON SIGHT ALIGNMENT		9-26-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-26-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-26-06	L.P.D.
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/26/06	M/L
670	FINAL INSPECTION A) HEADSPACE		10/10/06	nom
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.47</u> <u>2.47</u> <u>2.50</u> <u>2.52</u>	9-27-06	DA
	C) FUNCTION		10/10/06	nom
690	PACK		11/1/06	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 9-26-06
TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	242	252		243	
PULL #2	251	254		243	
PULL #3	261	252		239	
PULL #4	262	254		244	
PULL #5	261	255		253	
TOTAL	1277	1267		1222	
AVERAGE	255	253		244	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	305	306		
PULL #2	302	290		
PULL #3	296	291		
PULL #4	295	291		
PULL #5	296	288		
TOTAL	1494	1466		
AVERAGE	298	293		

	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	410	427		429
PULL #2	402	415		422
PULL #3	408	410		417
PULL #4	406	411		417
PULL #5	403	422		419
TOTAL	2029	2085		2104
AVERAGE	405	417		420

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591614.__0
FILE DATE AND TIME: 09/27/2006 05:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.096
The Average Y Centroid of the Five Target Set:	-0.011
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.770
The Distance from POA to Centroid Target #1:	0.199
The Distance from Centroid Target #2 to Centroid Target #1:	0.321
The Distance from Centroid Target #3 to Centroid Target #1:	0.204
The Distance from Centroid Target #4 to Centroid Target #1:	0.173
The Distance from Centroid Target #5 to Centroid Target #1:	0.108

SERIAL NUMBER: G6591614. 0

TARGET NUMBER: 1

FILE DATE: 09/27/2006

FILE TIME: 05:23

X CENTROID: -0.139

Y CENTROID: -0.142

POA TO CENTROID: 0.199

HORZ SPREAD: 1.669

VERT SPREAD: 2.213

GROUP SPREAD: 2.422

MIN RADIUS: 0.053

MAX RADIUS: 1.347

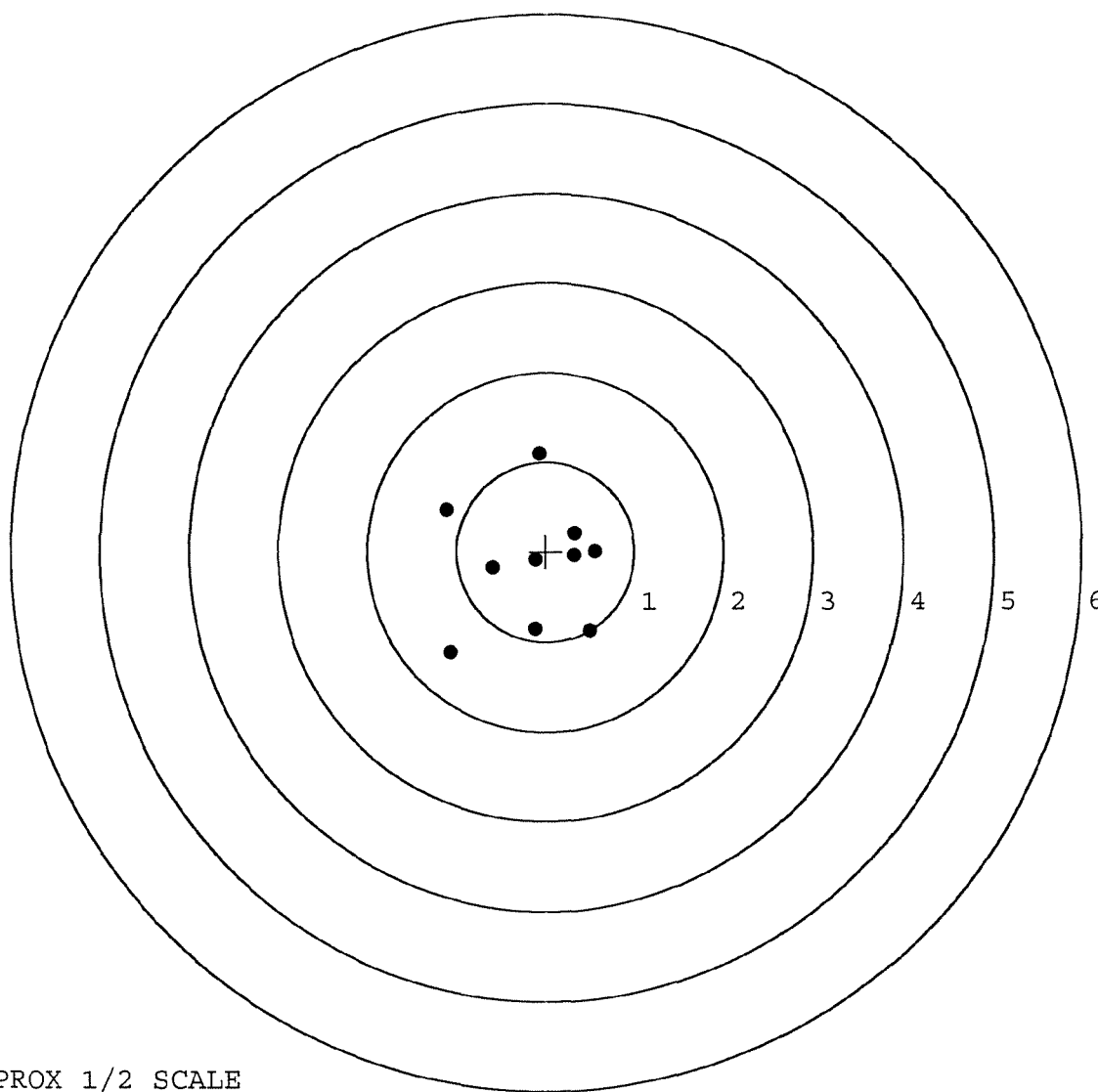
MEAN RADIUS: 0.769

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.061	-1.124
2:	-0.122	-0.865
3:	0.499	-0.877
4:	-1.115	0.461
5:	-0.076	1.089
6:	-0.595	-0.180
7:	-0.114	-0.095
8:	0.322	0.207
9:	0.554	0.006
10:	0.322	-0.043

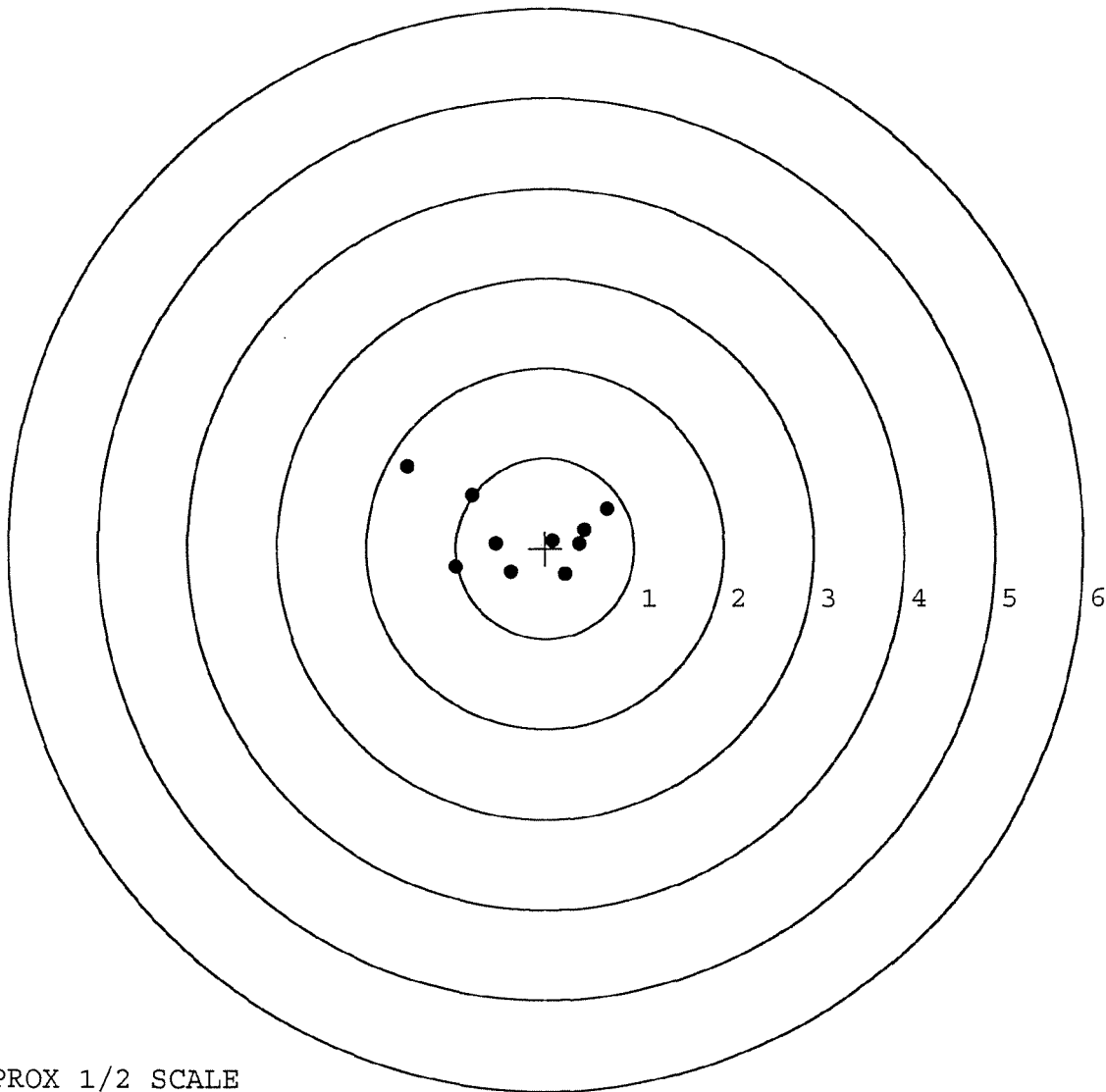


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591614. 0
TARGET NUMBER: 2
FILE DATE: 09/27/2006
FILE TIME: 05:23

X CENTROID: -0.250
Y CENTROID: 0.159
POA TO CENTROID: 0.296
HORZ SPREAD: 2.232
VERT SPREAD: 1.193
GROUP SPREAD: 2.280
MIN RADIUS: 0.321
MAX RADIUS: 1.494
MEAN RADIUS: 0.713
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.544	0.906
2:	-0.826	0.593
3:	-1.003	-0.209
4:	-0.554	0.057
5:	-0.391	-0.264
6:	0.688	0.439
7:	0.445	0.211
8:	0.222	-0.287
9:	0.084	0.084
10:	0.381	0.058



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591614. __0

TARGET NUMBER: 3

FILE DATE: 09/27/2006

FILE TIME: 05:23

POINT#	X	Y
1:	-0.534	0.577
2:	-0.806	0.210
3:	-0.849	-0.204
4:	-0.380	-0.291
5:	0.461	0.699
6:	0.412	0.481
7:	0.843	-0.373
8:	0.521	-0.181
9:	0.382	-0.455
10:	0.107	-0.553

X CENTROID: 0.016

Y CENTROID: -0.009

POA TO CENTROID: 0.018

HORZ SPREAD: 1.692

VERT SPREAD: 1.252

GROUP SPREAD: 1.749

MIN RADIUS: 0.486

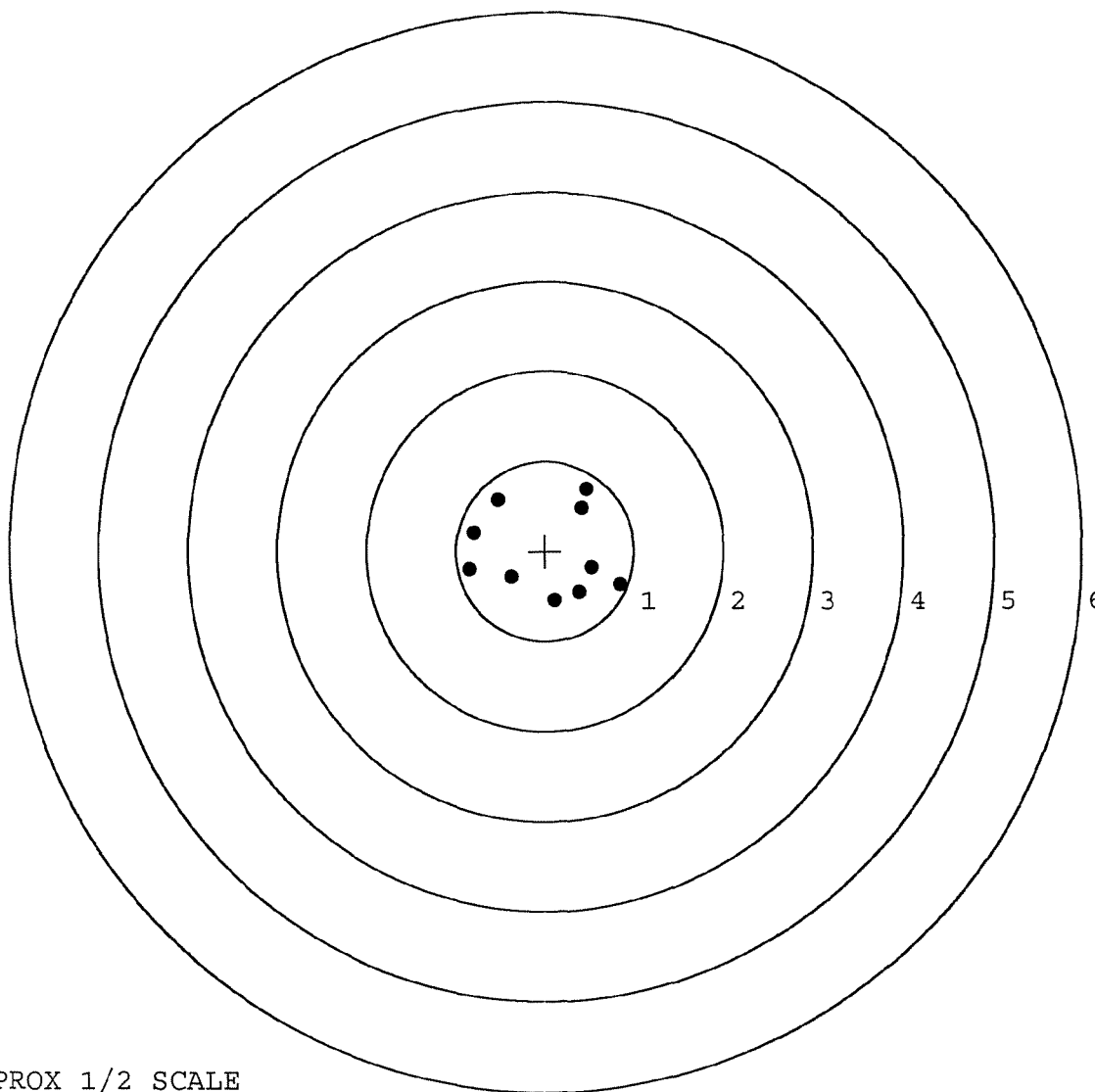
MAX RADIUS: 0.904

MEAN RADIUS: 0.706

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

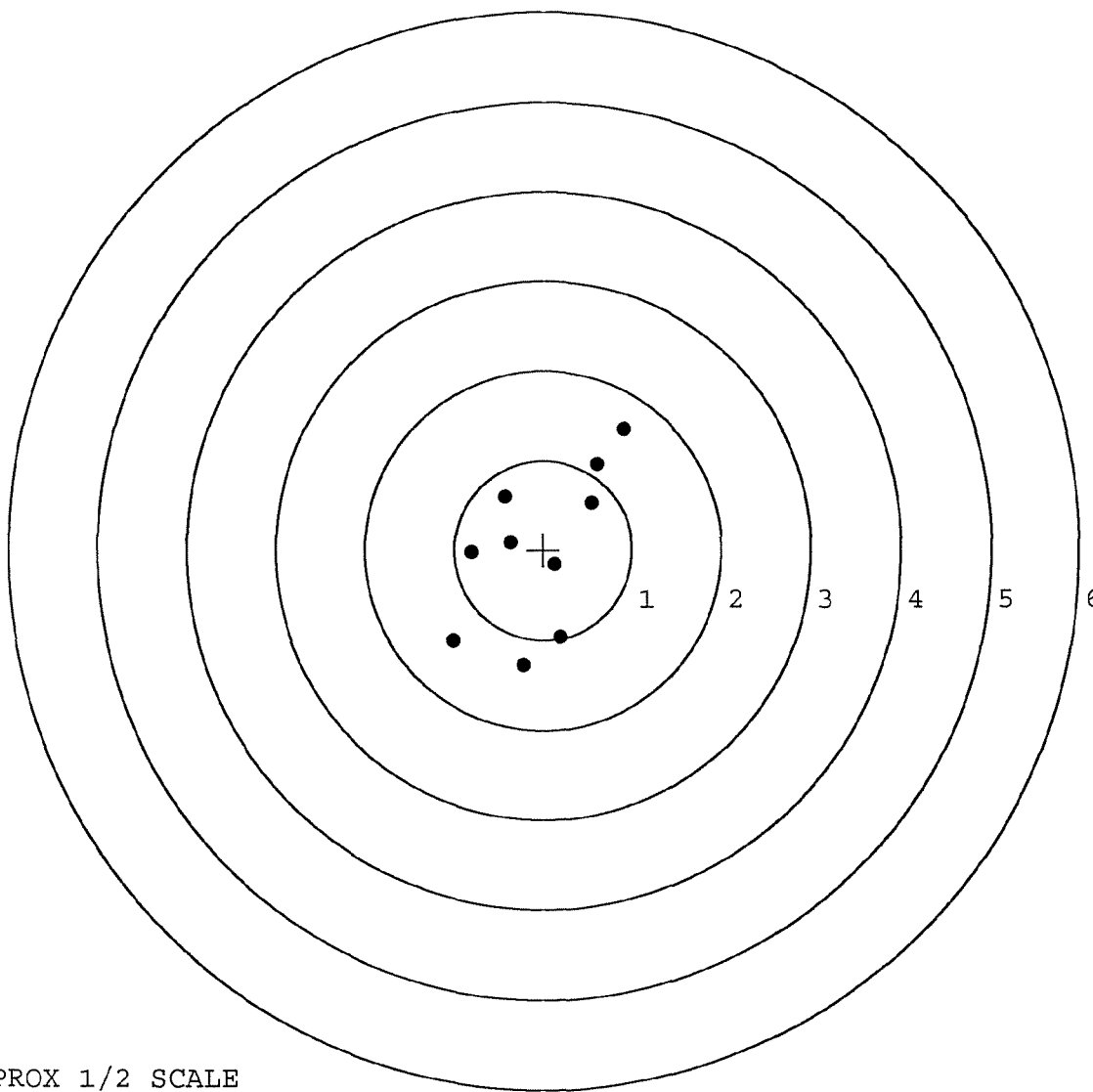


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591614. 0
TARGET NUMBER: 4
FILE DATE: 09/27/2006
FILE TIME: 05:23

X CENTROID: -0.048
Y CENTROID: 0.006
POA TO CENTROID: 0.049
HORZ SPREAD: 1.921
VERT SPREAD: 2.628
GROUP SPREAD: 3.040
MIN RADIUS: 0.247
MAX RADIUS: 1.643
MEAN RADIUS: 0.934
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.020	-1.009
2:	-0.220	-1.281
3:	0.190	-0.973
4:	0.128	-0.167
5:	-0.805	-0.027
6:	-0.368	0.081
7:	-0.438	0.594
8:	0.901	1.347
9:	0.607	0.962
10:	0.542	0.530



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591614. 0

TARGET NUMBER: 5

FILE DATE: 09/27/2006

FILE TIME: 05:23

POINT#	X	Y
1:	0.989	-0.797
2:	0.956	-0.049
3:	0.288	-0.148
4:	0.096	-0.453
5:	-0.839	-0.583
6:	-0.434	-0.334
7:	-0.256	-0.050
8:	-0.033	0.734
9:	-0.267	0.658
10:	-1.070	0.314

X CENTROID: -0.057

Y CENTROID: -0.071

POA TO CENTROID: 0.091

HORZ SPREAD: 2.059

VERT SPREAD: 1.531

GROUP SPREAD: 2.340

MIN RADIUS: 0.200

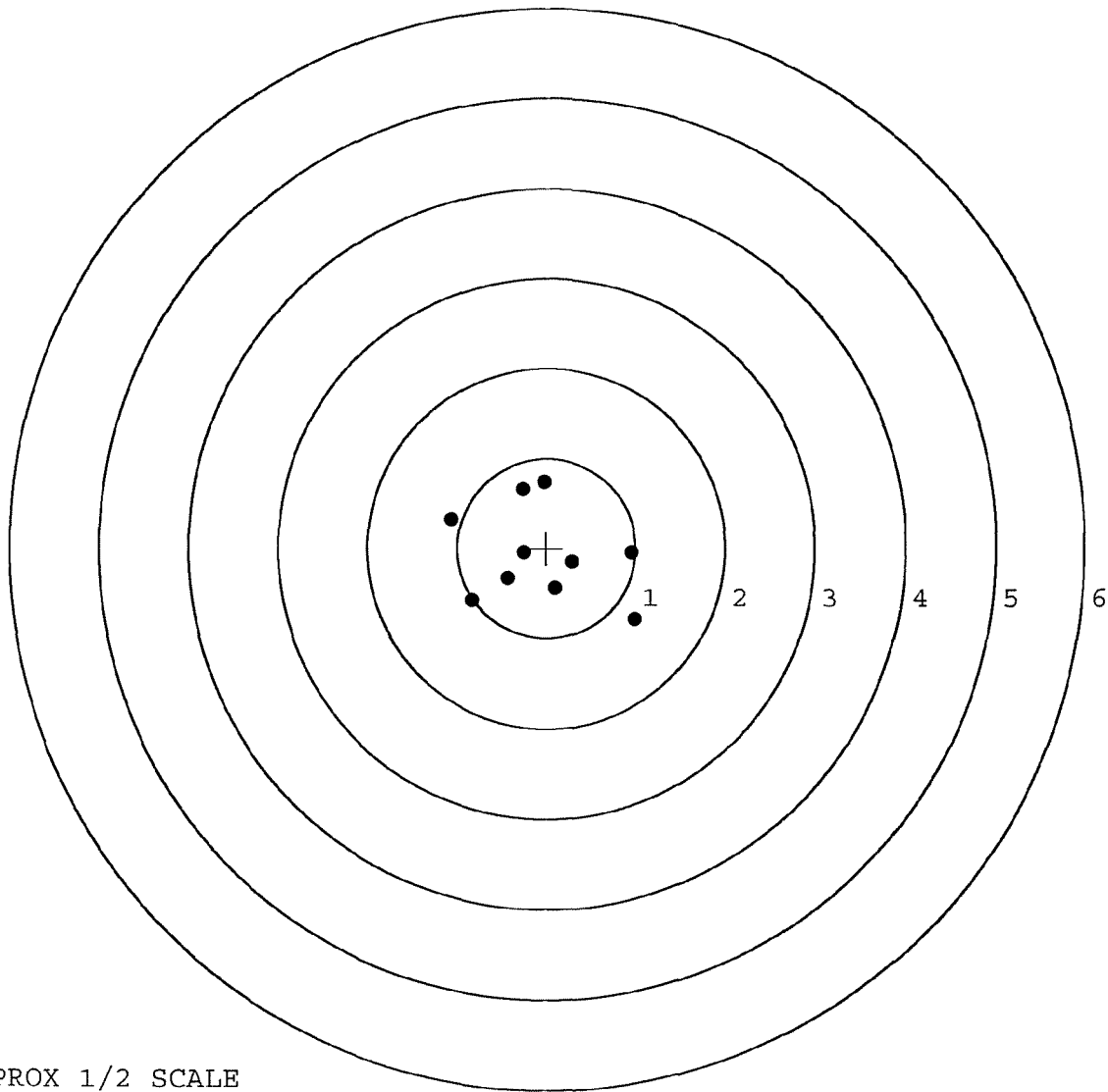
MAX RADIUS: 1.273

MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE