

G 6645329

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

- INSTRUCTION BOOK 3518

BM FORM

proof of purchase



owner registration sticker



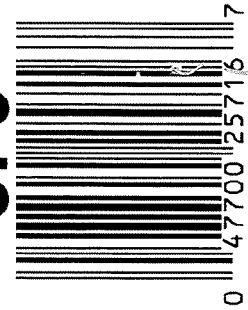
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6645329

UPC



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

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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6645329

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		7-23-07	RPJ
420	ASSEMBLE ACTION		7-16-07	SD
430	ASSEMBLE TO STOCK		7-17-07	mm
440	PROOF		7-17-07	mm
460	CHECK HEADSPACE		7-17-07	mm
470	DIS-ASSEMBLE ACTION		7-20-07	SD
480	MAGNAFLUX BBL ACTION		7-24-07	mm
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-24-07	CW
510	DRILL AND TAP SIGHT HOLES		7-23-07	SD
520	GOFF BLAST BBL / REC		7-24-07	LY
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		7-24-07	RP
560	RE-ASSEMBLE ACTION		8/2/07	RP
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8/2/07	RP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8/2/07	RP
	D) OIL FIRING PIN ASSEMBLY		8/6/07	RPJ
	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>6.25</u> <u>5.75</u> <u>5.5</u>	8/10/07	W
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.25</u>	8/10/07	W
	H) TRIGGER PULL TEST AND RETAINABILITY		8/10/07	W
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.025</u>	8/10/07	W
	J) ASSEMBLE STOCK		8/6/07	J.P.D.
	K) ASSEMBLE SWIVEL STUDS		8/10/07	W
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-7-07	TRW
	MALFUNCTION <u>OH</u>	CORRECTION <u>OK</u>	8/8/07	W
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <u>N/A</u>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-7-07	Fm
670	FINAL INSPECTION A) HEADSPACE		8/10/07	W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>249</u> <u>246</u> <u>245</u> <u>235</u> <u>251</u>	8/10/07	W
	C) FUNCTION		8/10/07	W
690	PACK		8-16-07	RA

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 7-12-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS.		COMMENTS
PULL #1	2.47	2.53		2.53	
PULL #2	2.37	2.41		2.50	
PULL #3	2.50	2.42		2.51	
PULL #4	2.44	2.40		2.48	
PULL #5	2.38	2.36		2.53	
TOTAL	12.16	12.12		12.55	
AVERAGE	2.43	2.42		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.14	3.31		
PULL #2	3.29	3.25		
PULL #3	3.28	3.28		
PULL #4	3.27	3.28		
PULL #5	3.24	3.26		
TOTAL	16.22	16.38		
AVERAGE	3.24	3.27		

	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	4.11	4.30		4.27
PULL #2	4.06	4.21		4.20
PULL #3	4.05	4.23		4.22
PULL #4	4.04	4.11		4.23
PULL #5	4.07	4.13		4.26
TOTAL	20.33	20.98		21.18
AVERAGE	4.06	4.19		4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6645329.___0

FILE DATE AND TIME: 08/07/2007 11:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.066
The Average Y Centroid of the Five Target Set:	-0.048
The Average Point of Impact of the Five Target Set:	0.082
The Average Mean Radius of the Five Target Set:	0.797
The Distance from POA to Centroid Target #1:	0.161
The Distance from Centroid Target #2 to Centroid Target #1:	0.269
The Distance from Centroid Target #3 to Centroid Target #1:	0.231
The Distance from Centroid Target #4 to Centroid Target #1:	0.235
The Distance from Centroid Target #5 to Centroid Target #1:	0.268

SERIAL NUMBER: G6645329. 0

TARGET NUMBER: 1

FILE DATE: 08/07/2007

FILE TIME: 11:01

POINT#	X	Y
1:	0.377	-1.881
2:	-0.230	-0.707
3:	0.434	-0.652
4:	0.215	0.052
5:	-0.178	0.028
6:	-1.004	-0.308
7:	-0.147	0.715
8:	0.019	1.025
9:	0.569	0.837
10:	1.223	1.862

X CENTROID: 0.128

Y CENTROID: 0.097

POA TO CENTROID: 0.161

HORZ SPREAD: 2.227

VERT SPREAD: 3.743

GROUP SPREAD: 3.837

MIN RADIUS: 0.098

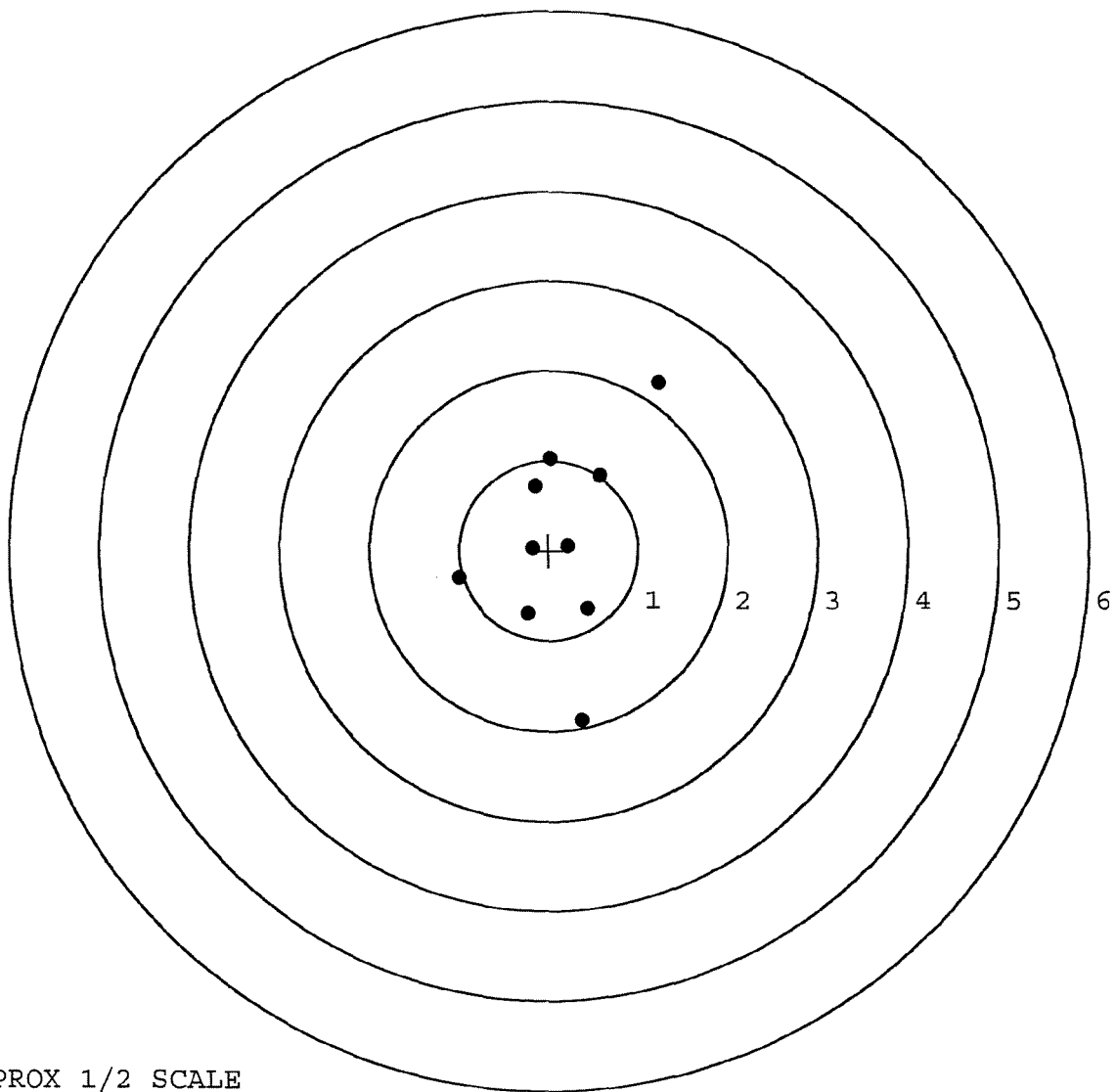
MAX RADIUS: 2.077

MEAN RADIUS: 0.985

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

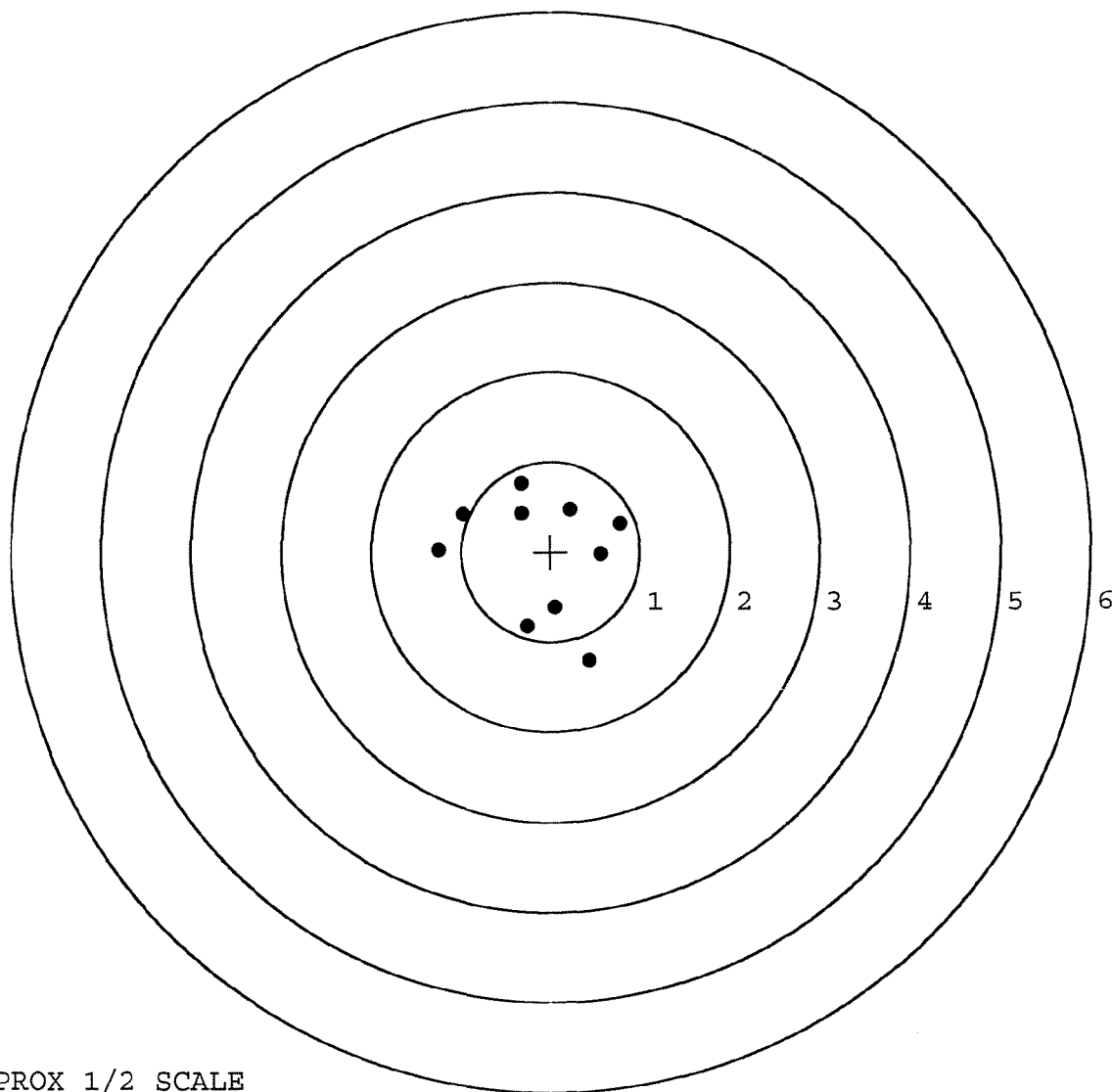


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645329. __0
TARGET NUMBER: 2
FILE DATE: 08/07/2007
FILE TIME: 11:01

X CENTROID: -0.111
Y CENTROID: -0.028
POA TO CENTROID: 0.114
HORZ SPREAD: 2.025
VERT SPREAD: 1.969
GROUP SPREAD: 2.157
MIN RADIUS: 0.508
MAX RADIUS: 1.301
MEAN RADIUS: 0.841
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.438	-1.207
2:	0.563	-0.025
3:	0.776	0.316
4:	0.218	0.467
5:	-0.330	0.762
6:	-0.328	0.432
7:	-0.985	0.414
8:	-1.249	0.023
9:	0.050	-0.623
10:	-0.261	-0.836



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645329.___0

TARGET NUMBER: 3

FILE DATE: 08/07/2007

FILE TIME: 11:01

POINT#	X	Y
1:	0.397	-0.823
2:	0.436	-0.586
3:	-0.193	-0.406
4:	-0.492	-0.239
5:	-0.826	-0.659
6:	0.307	-0.016
7:	0.511	0.473
8:	0.211	0.403
9:	0.344	0.230
10:	-0.274	0.450

X CENTROID: 0.042

Y CENTROID: -0.117

POA TO CENTROID: 0.125

HORZ SPREAD: 1.337

VERT SPREAD: 1.296

GROUP SPREAD: 1.752

MIN RADIUS: 0.284

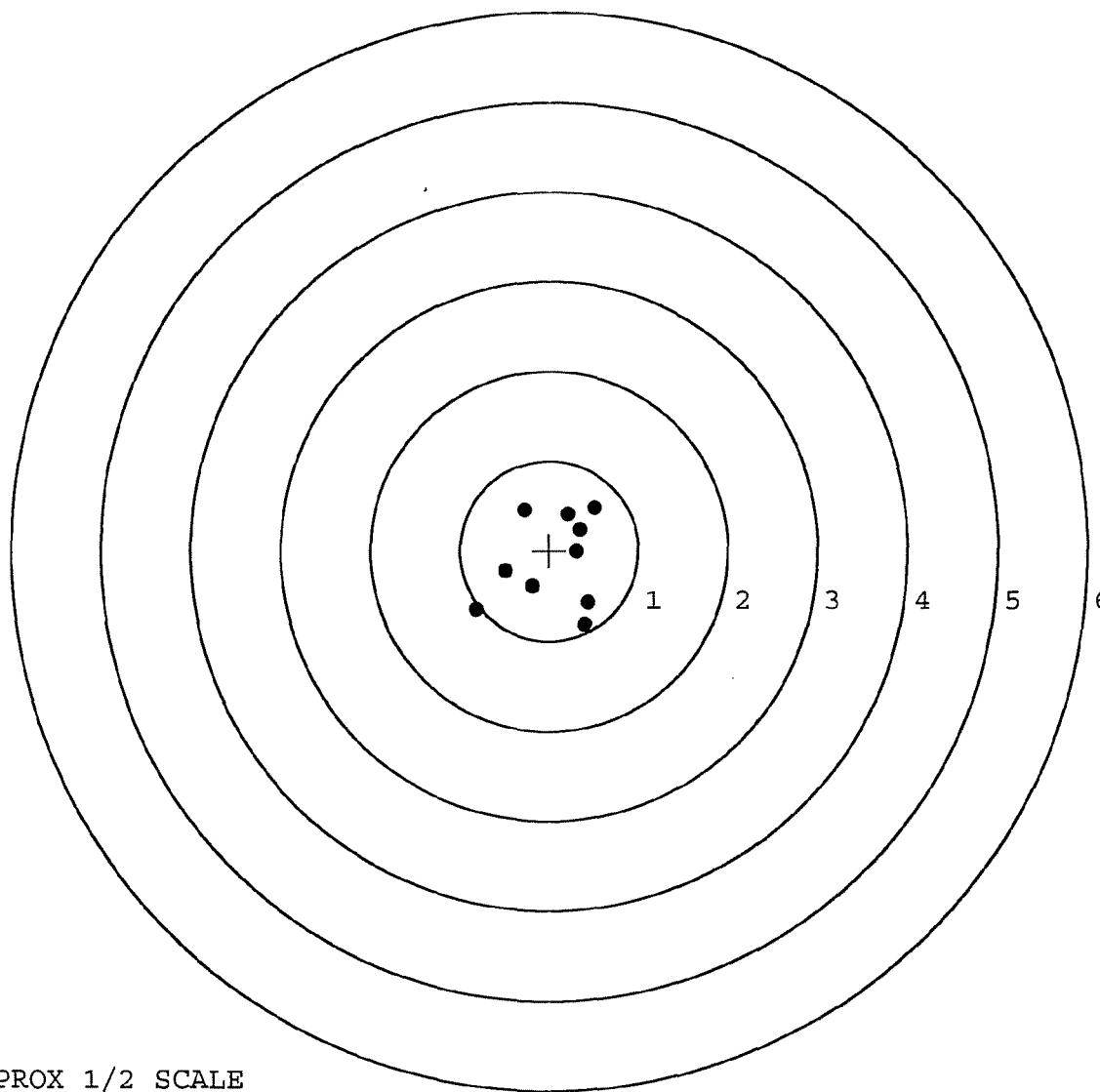
MAX RADIUS: 1.023

MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

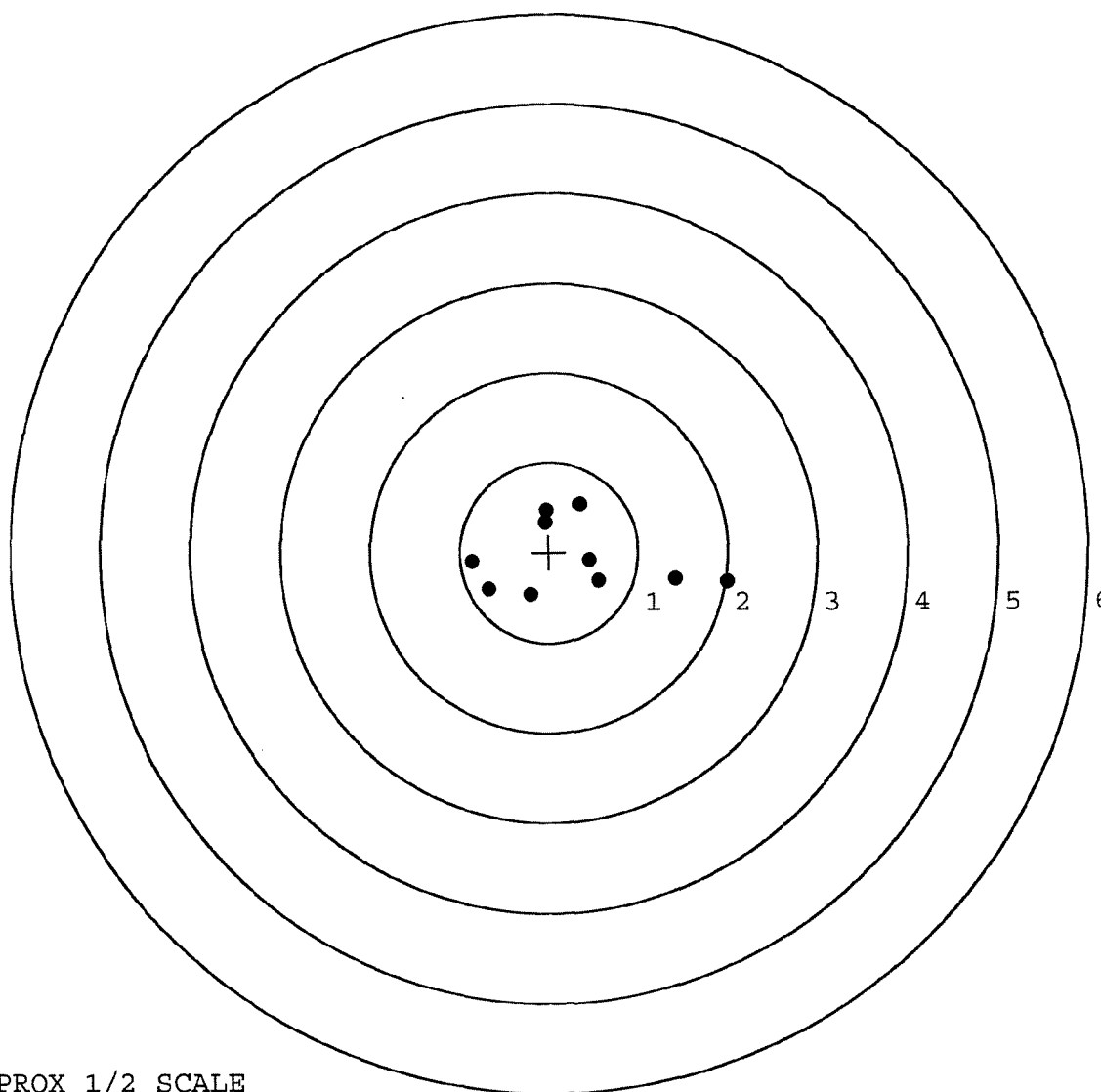


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645329. __0
TARGET NUMBER: 4
FILE DATE: 08/07/2007
FILE TIME: 11:01

POINT#	X	Y
1:	1.998	-0.331
2:	1.414	-0.300
3:	0.555	-0.317
4:	0.458	-0.088
5:	-0.210	-0.468
6:	-0.675	-0.412
7:	-0.866	-0.100
8:	-0.050	0.333
9:	-0.040	0.461
10:	0.349	0.528

X CENTROID: 0.293
Y CENTROID: -0.069
POA TO CENTROID: 0.301
HORZ SPREAD: 2.864
VERT SPREAD: 0.996
GROUP SPREAD: 2.873
MIN RADIUS: 0.166
MAX RADIUS: 1.725
MEAN RADIUS: 0.798
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6645329. 0

TARGET NUMBER: 5

FILE DATE: 08/07/2007

FILE TIME: 11:01

POINT#	X	Y
1:	1.407	-0.144
2:	0.592	0.143
3:	0.226	0.390
4:	-0.161	0.662
5:	-0.780	0.741
6:	0.046	-0.195
7:	-0.404	-0.429
8:	-0.099	-0.516
9:	-0.207	-0.843
10:	-0.858	-1.048

X CENTROID: -0.024

Y CENTROID: -0.124

POA TO CENTROID: 0.126

HORZ SPREAD: 2.265

VERT SPREAD: 1.789

GROUP SPREAD: 2.439

MIN RADIUS: 0.100

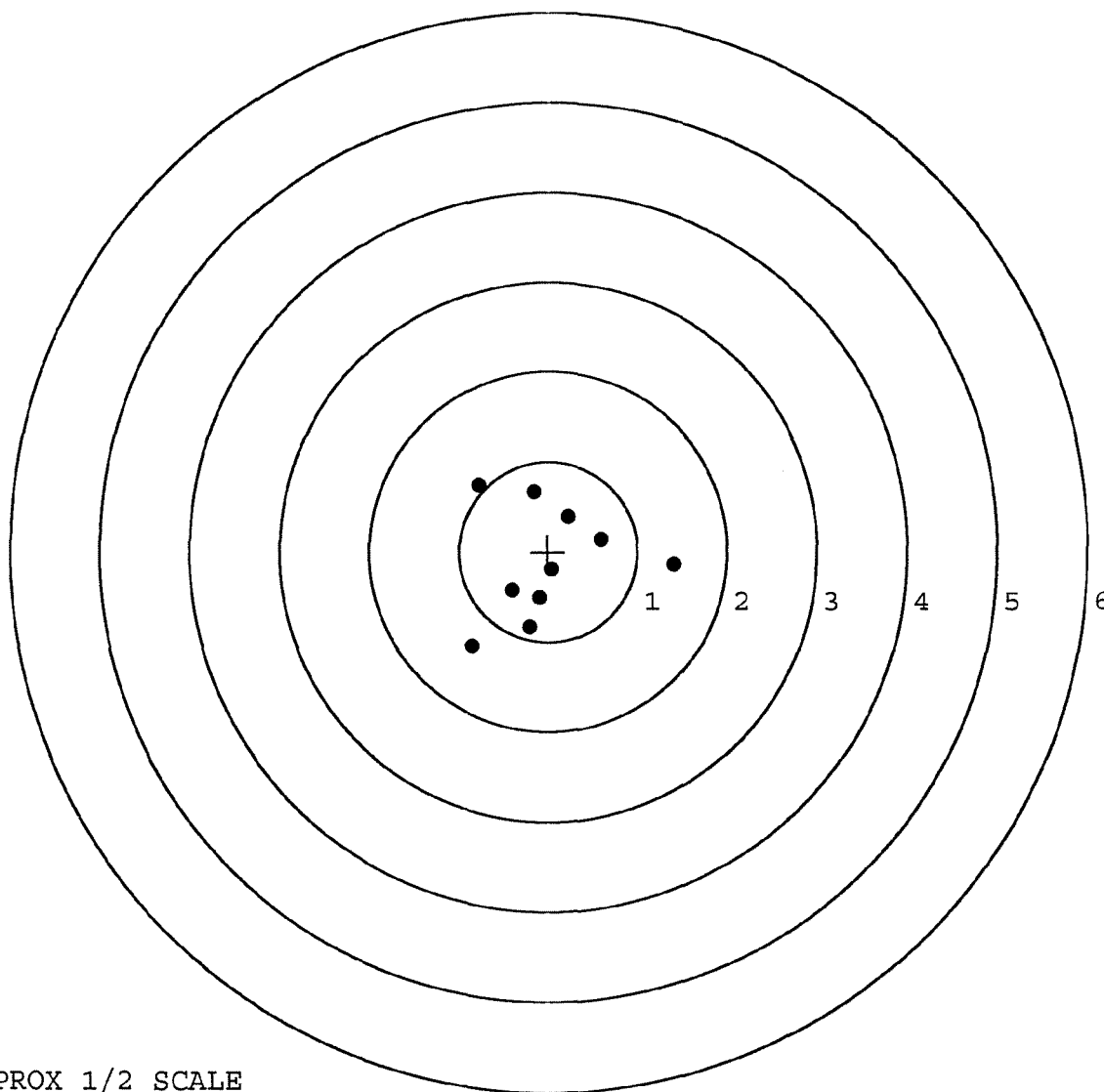
MAX RADIUS: 1.431

MEAN RADIUS: 0.759

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE