

66699813

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



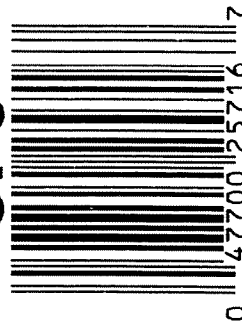
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6699813

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66699813

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-3-08	RTZ
420	ASSEMBLE ACTION		3-3-08	RTZ
430	ASSEMBLE TO STOCK		3-4-08	TRW
440	PROOF	MAGNA-FLUX	3-4-08	TRW
460	CHECK HEADSPACE	DATE 03-04-2008	3-4-08	TRW
470	DIS-ASSEMBLE ACTION		3-5-08	P.P.D.
480	MAGNAFLUX BBL ACTION	OPERATOR <u>WMS</u>	3/6/08	WMS
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-5-08	CW
510	DRILL AND TAP SIGHT HOLES		3-5-08	TRW
520	GOFF BLAST BBL / REC		3-7-08	DG
530 & 540	APPLY COATINGS (BARREL ACTION)		3-7-08	WMS
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-18-08	FM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-18-08	FM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-18-08	FM
	D) OIL FIRING PIN ASSEMBLY		3-19-08	P.P.D.
	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>8.75</u> <u>9.0</u> <u>9.25</u>	4-14-08	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	4-14-08	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022⁵</u> <u>.023</u>	4-14-08	TRW
	J) ASSEMBLE STOCK		3-19-08	L.P.N.
	K) ASSEMBLE SWIVEL STUDS		4-14-08	TRW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-15-08	RT
	M) IRON SIGHT ALIGNMENT		4-15-08	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-15-08	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-11-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-11-08	SD
670	FINAL INSPECTION A) HEADSPACE		4-14-08	TRW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.68</u> <u>2.77</u> <u>2.73</u> <u>2.73</u>	4-14-08	TRW
	C) FUNCTION		4-14-08	TRW
690	PACK		4-16-08	Fm

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 1-21-08

TESTER TRLW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.30	2.20		2.31	
PULL #2	2.49	2.16		2.39	
PULL #3	2.57	2.14		2.39	
PULL #4	2.43	2.18		2.35	
PULL #5	2.54	2.14		2.42	
TOTAL	12.33	10.82		11.86	
AVERAGE	2.46	2.16		2.37	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.11		
PULL #2	3.20	3.40		
PULL #3	3.21	3.26		
PULL #4	3.29	3.39		
PULL #5	3.30	3.19		
TOTAL	16.16	16.35		
AVERAGE	3.23	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	4.60	4.26		4.52
PULL #2	4.60	4.36		4.60
PULL #3	4.59	4.44		4.75
PULL #4	4.57	4.40		4.78
PULL #5	4.59	4.35		4.82
TOTAL	22.95	21.81		23.47
AVERAGE	4.59	4.36		4.69

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6699813.___0
FILE DATE AND TIME: 04/14/2008 04:38

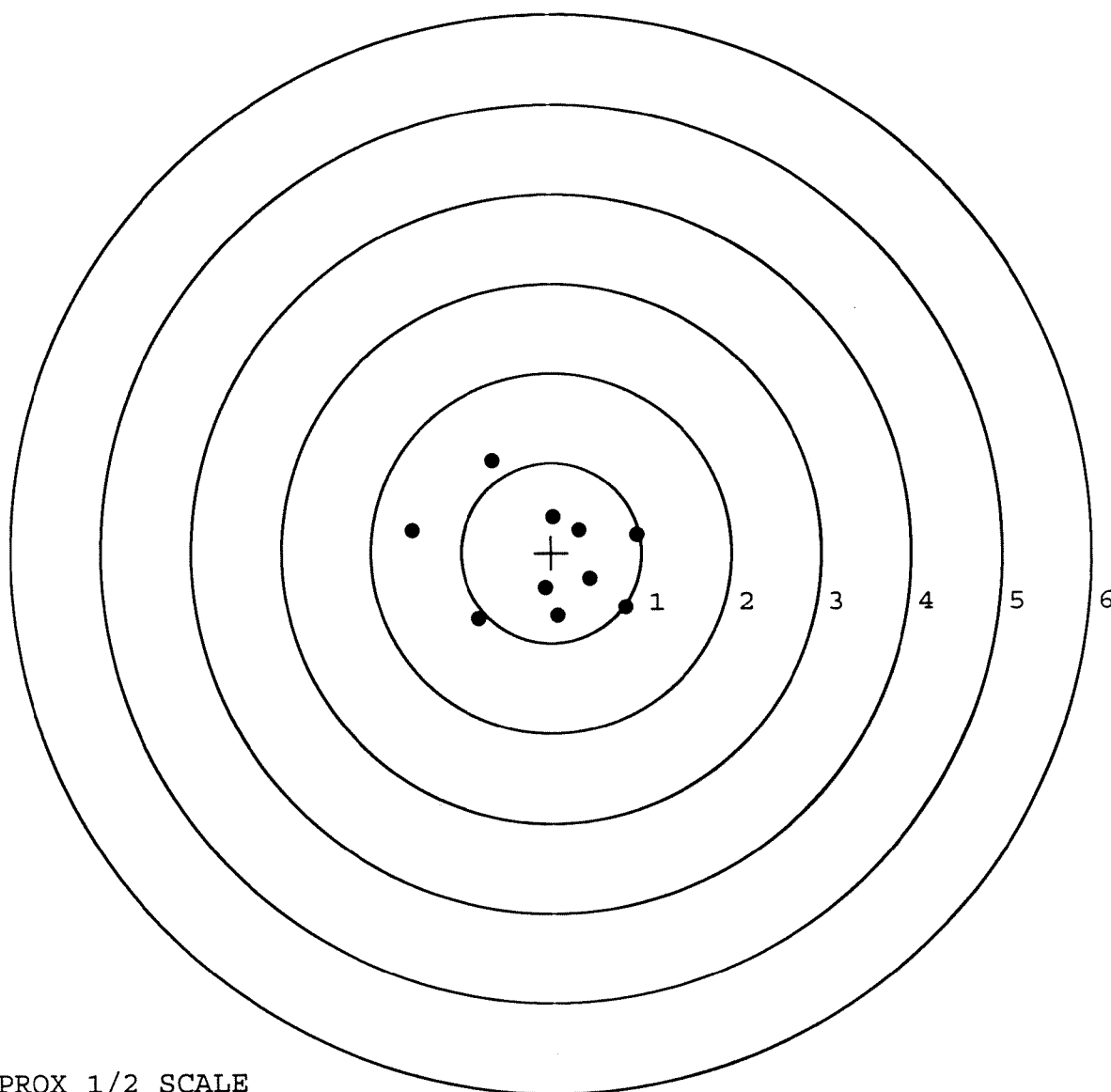
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.012
The Average Y Centroid of the Five Target Set:	-0.079
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.657
The Distance from POA to Centroid Target #1:	0.077
The Distance from Centroid Target #2 to Centroid Target #1:	0.175
The Distance from Centroid Target #3 to Centroid Target #1:	0.135
The Distance from Centroid Target #4 to Centroid Target #1:	0.149
The Distance from Centroid Target #5 to Centroid Target #1:	0.227

SERIAL NUMBER: G6699813. __0
 TARGET NUMBER: 1
 FILE DATE: 04/14/2008
 FILE TIME: 04:38

X CENTROID: -0.047
 Y CENTROID: -0.061
 POA TO CENTROID: 0.077
 HORZ SPREAD: 2.493
 VERT SPREAD: 1.759
 GROUP SPREAD: 2.521
 MIN RADIUS: 0.329
 MAX RADIUS: 1.531
 MEAN RADIUS: 0.829
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.823	-0.612
2:	0.431	-0.289
3:	0.069	-0.700
4:	-0.068	-0.389
5:	-0.810	-0.738
6:	0.947	0.195
7:	0.311	0.253
8:	0.025	0.397
9:	-0.650	1.021
10:	-1.546	0.251



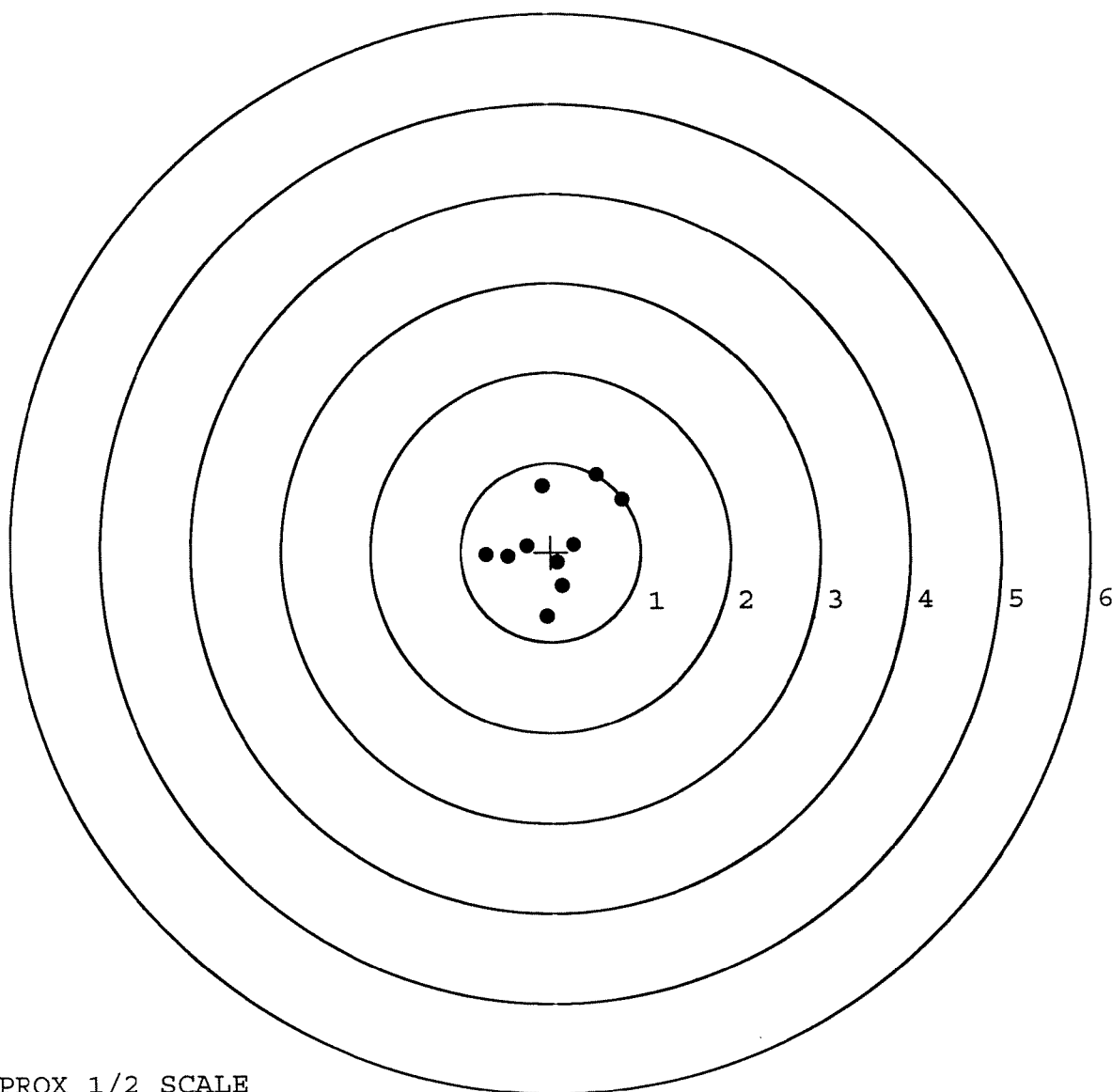
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699813. __0
TARGET NUMBER: 2
FILE DATE: 04/14/2008
FILE TIME: 04:38

X CENTROID: 0.017
Y CENTROID: 0.103
POA TO CENTROID: 0.104
HORZ SPREAD: 1.513
VERT SPREAD: 1.586
GROUP SPREAD: 1.634
MIN RADIUS: 0.226
MAX RADIUS: 0.916
MEAN RADIUS: 0.579

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.796	0.583
2:	0.516	0.861
3:	-0.091	0.734
4:	-0.717	-0.033
5:	-0.474	-0.051
6:	-0.264	0.068
7:	0.256	0.081
8:	0.069	-0.117
9:	0.123	-0.376
10:	-0.048	-0.725

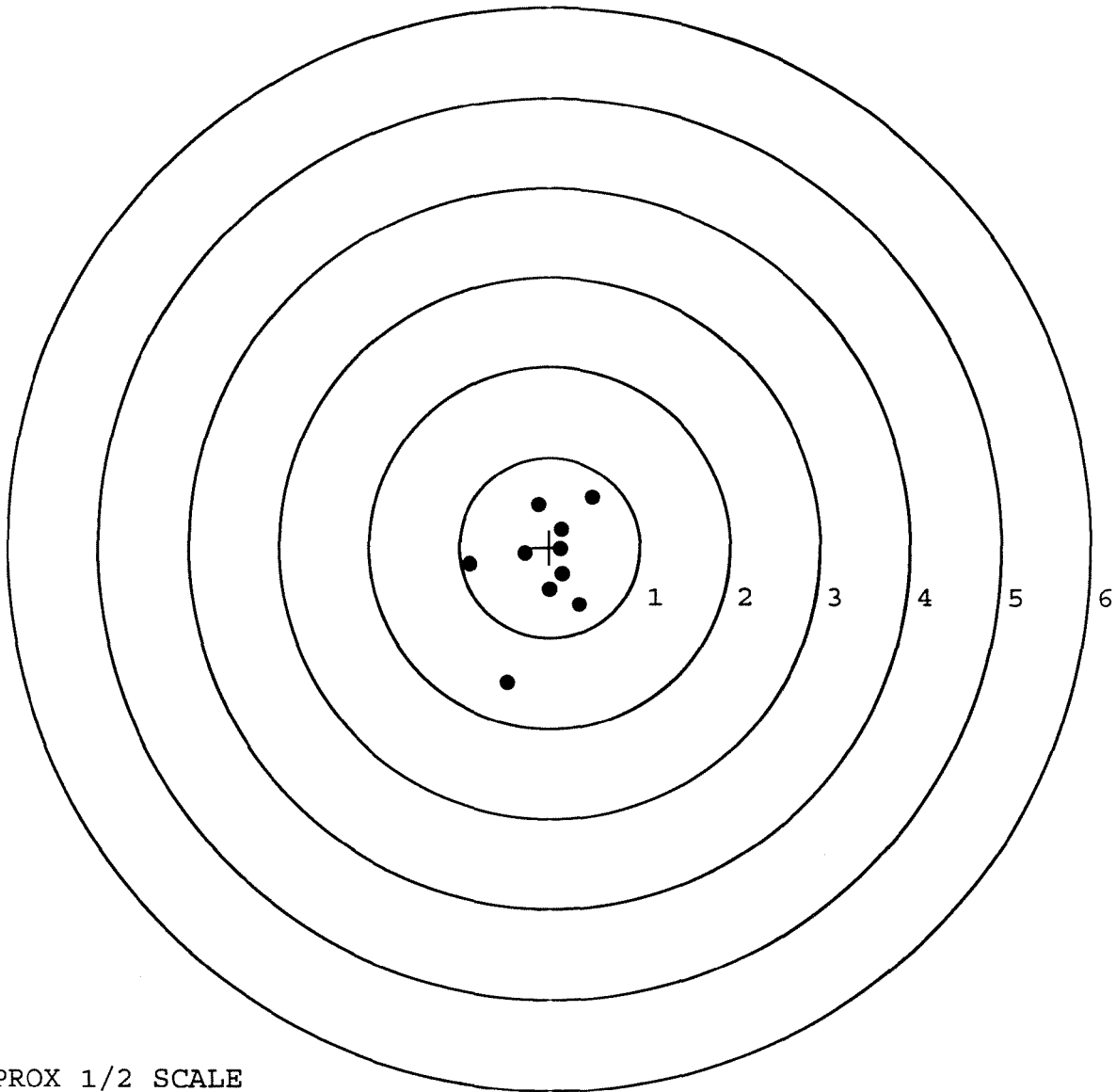


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699813. __0
TARGET NUMBER: 3
FILE DATE: 04/14/2008
FILE TIME: 04:38

X CENTROID: -0.053
Y CENTROID: -0.196
POA TO CENTROID: 0.203
HORZ SPREAD: 1.359
VERT SPREAD: 2.053
GROUP SPREAD: 2.263
MIN RADIUS: 0.220
MAX RADIUS: 1.368
MEAN RADIUS: 0.580
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.479	0.555
2:	-0.123	0.468
3:	0.130	0.198
4:	0.126	-0.023
5:	-0.269	-0.067
6:	-0.880	-0.192
7:	0.332	-0.635
8:	0.006	-0.473
9:	-0.472	-1.498
10:	0.144	-0.294



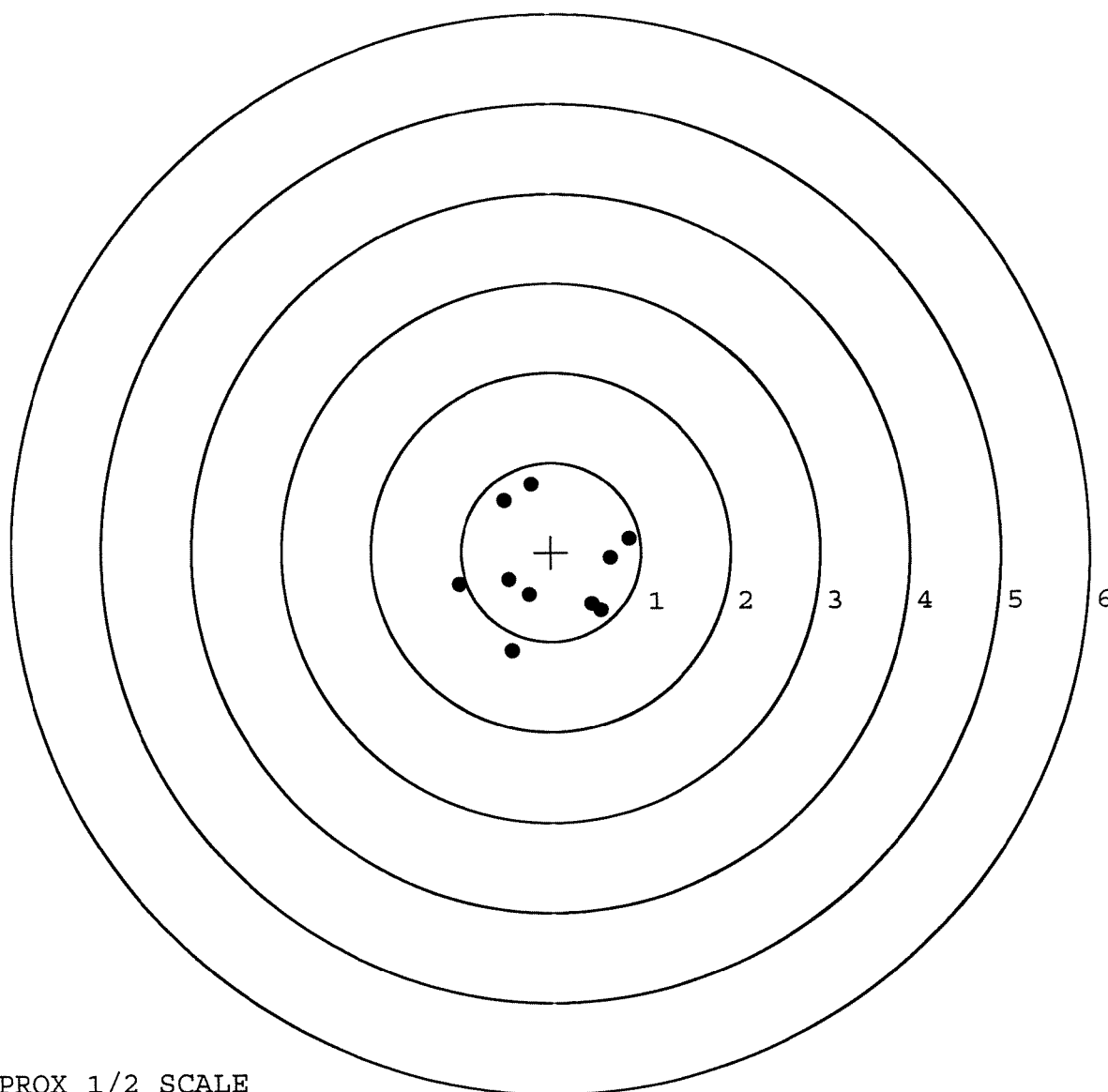
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699813. __0
TARGET NUMBER: 4
FILE DATE: 04/14/2008
FILE TIME: 04:38

X CENTROID: -0.035
Y CENTROID: -0.210
POA TO CENTROID: 0.213
HORZ SPREAD: 1.892
VERT SPREAD: 1.866
GROUP SPREAD: 1.962
MIN RADIUS: 0.342
MAX RADIUS: 0.998
MEAN RADIUS: 0.773

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

POINT#	X	Y
1:	0.871	0.152
2:	0.666	-0.069
3:	0.457	-0.586
4:	0.560	-0.657
5:	-0.245	-0.480
6:	-0.472	-0.309
7:	-0.436	-1.112
8:	-1.021	-0.366
9:	-0.516	0.576
10:	-0.215	0.754

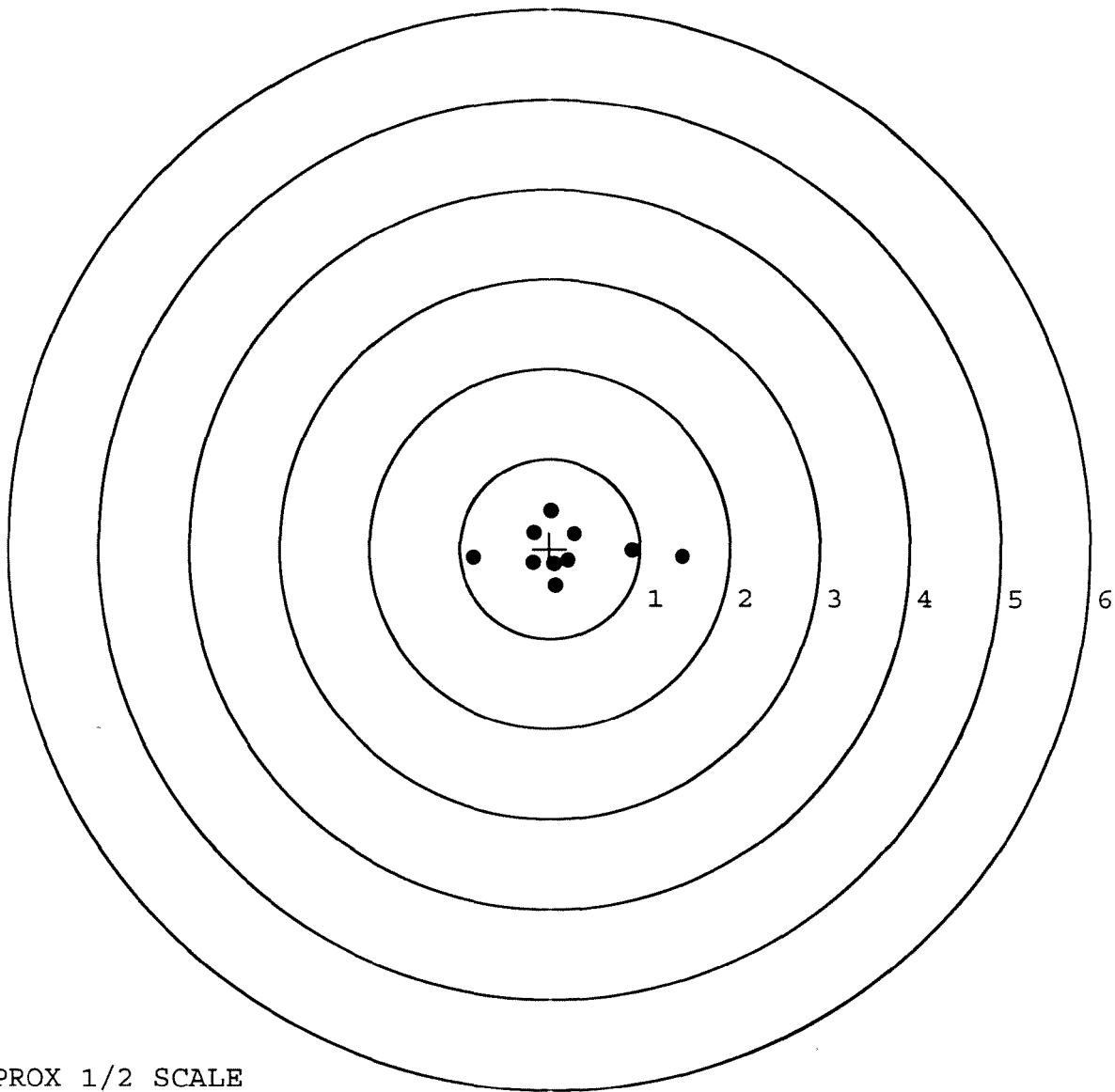


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699813. __0
TARGET NUMBER: 5
FILE DATE: 04/14/2008
FILE TIME: 04:38

X CENTROID: 0.178
Y CENTROID: -0.029
POA TO CENTROID: 0.181
HORZ SPREAD: 2.313
VERT SPREAD: 0.836
GROUP SPREAD: 2.313
MIN RADIUS: 0.103
MAX RADIUS: 1.292
MEAN RADIUS: 0.524
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.915	-0.015
2:	1.469	-0.086
3:	-0.844	-0.102
4:	0.017	0.425
5:	0.270	0.169
6:	-0.179	0.182
7:	0.203	-0.129
8:	-0.181	-0.156
9:	0.062	-0.411
10:	0.052	-0.168



TARGET APPROX 1/2 SCALE