

G 669 9782

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

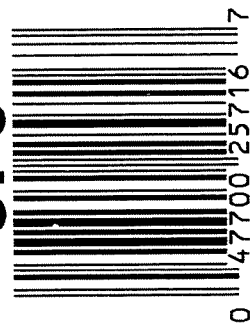
24"

CAPACITY

6

G6699782

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6699782

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-5-08	RTZ
420	ASSEMBLE ACTION		3-5-08	SPD.
430	ASSEMBLE TO STOCK		3-5-08	TRW
440	PROOF	MAGNA - FLUX MODEL 100 2000 OPERATOR <u>unms</u>	3-5-08	TRW
460	CHECK HEADSPACE		3-5-08	TRW
470	DIS-ASSEMBLE ACTION		3-6-08	SPD.
480	MAGNAFLUX BBL ACTION		3/7/08	unms
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		3-6-08	CW
510	DRILL AND TAP SIGHT HOLES		3-6-08	TRW
520	GOFF BLAST BBL / REC		3-10-08	TL
530 & 540	APPLY COATINGS (BARREL ACTION)		3/12/08	LM
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-17-08	Fm
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-17-08	Fm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-17-08	Fm
	D) OIL FIRING PIN ASSEMBLY		3-18-08	SPD.
	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°</u> <u>6°</u> <u>6°</u>	3-25-08	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4°</u> <u>4°</u> <u>5°</u>	3-25-08	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	3-25-08	SD
	J) ASSEMBLE STOCK		3-18-08	R.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-2-08	Fm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-8-08	R.P.D.
	M) IRON SIGHT ALIGNMENT		4-8-08	R.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-8-08	R.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-24-08	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-24-08	RP
670	FINAL INSPECTION A) HEADSPACE		4-2-08	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.68</u> <u>2.71</u> <u>2.56</u> <u>2.51</u>	3-25-08	SD
	C) FUNCTION		4-2-08	RTL
690	PACK		4/14/08	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 TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.49	2.40		2.50	
PULL #2	2.57	2.51		2.53	
PULL #3	2.60	2.42		2.34	
PULL #4	2.40	2.49		2.43	
PULL #5	2.58	2.51		2.42	
TOTAL	12.64	12.33		12.22	
AVERAGE	2.52	2.46		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.22		
PULL #2	3.25	3.31		
PULL #3	3.43	3.29		
PULL #4	3.33	3.26		
PULL #5	3.29	3.39		
TOTAL	16.69	16.47		
AVERAGE	3.33	3.29		

	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	4.47		4.02
PULL #2	4.08	4.54		4.03
PULL #3	4.10	4.50		4.02
PULL #4	4.01	4.49		4.02
PULL #5	4.00	4.52		4.17
TOTAL	20.28	22.52		20.26
AVERAGE	4.05	4.50		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6699782.___0
FILE DATE AND TIME: 03/25/2008 06:57

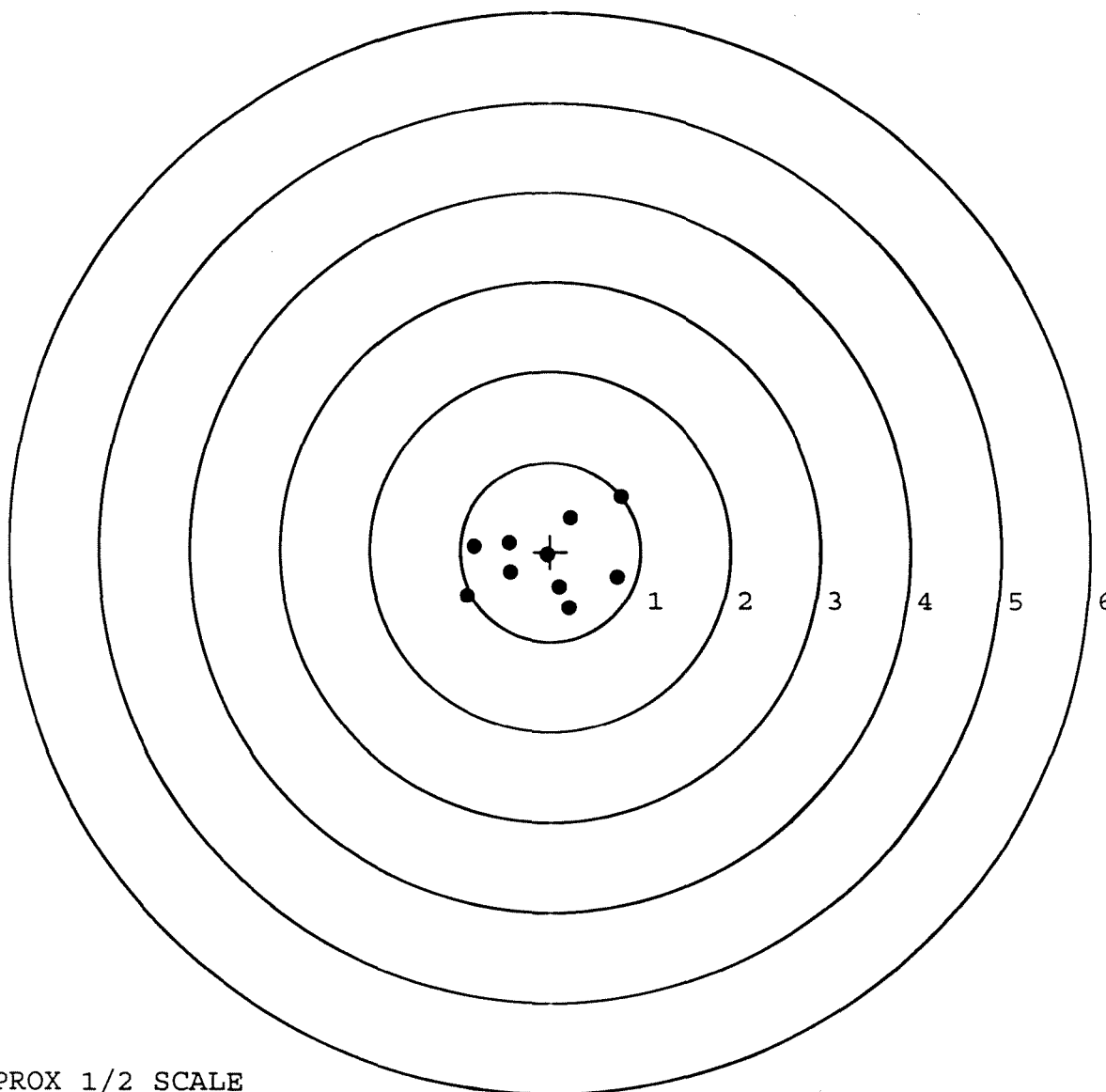
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	-0.160
The Average Point of Impact of the Five Target Set:	0.160
The Average Mean Radius of the Five Target Set:	0.674
The Distance from POA to Centroid Target #1:	0.113
The Distance from Centroid Target #2 to Centroid Target #1:	0.083
The Distance from Centroid Target #3 to Centroid Target #1:	0.108
The Distance from Centroid Target #4 to Centroid Target #1:	0.184
The Distance from Centroid Target #5 to Centroid Target #1:	0.406

SERIAL NUMBER: G6699782. __0
TARGET NUMBER: 1
FILE DATE: 03/25/2008
FILE TIME: 06:57

X CENTROID: -0.063
Y CENTROID: -0.094
POA TO CENTROID: 0.113
HORZ SPREAD: 1.714
VERT SPREAD: 1.238
GROUP SPREAD: 2.038
MIN RADIUS: 0.062
MAX RADIUS: 1.107
MEAN RADIUS: 0.608
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.745	-0.293
2:	0.793	0.608
3:	0.225	0.378
4:	0.097	-0.394
5:	-0.441	-0.234
6:	-0.458	0.097
7:	-0.844	0.057
8:	-0.921	-0.494
9:	-0.036	-0.039
10:	0.212	-0.630

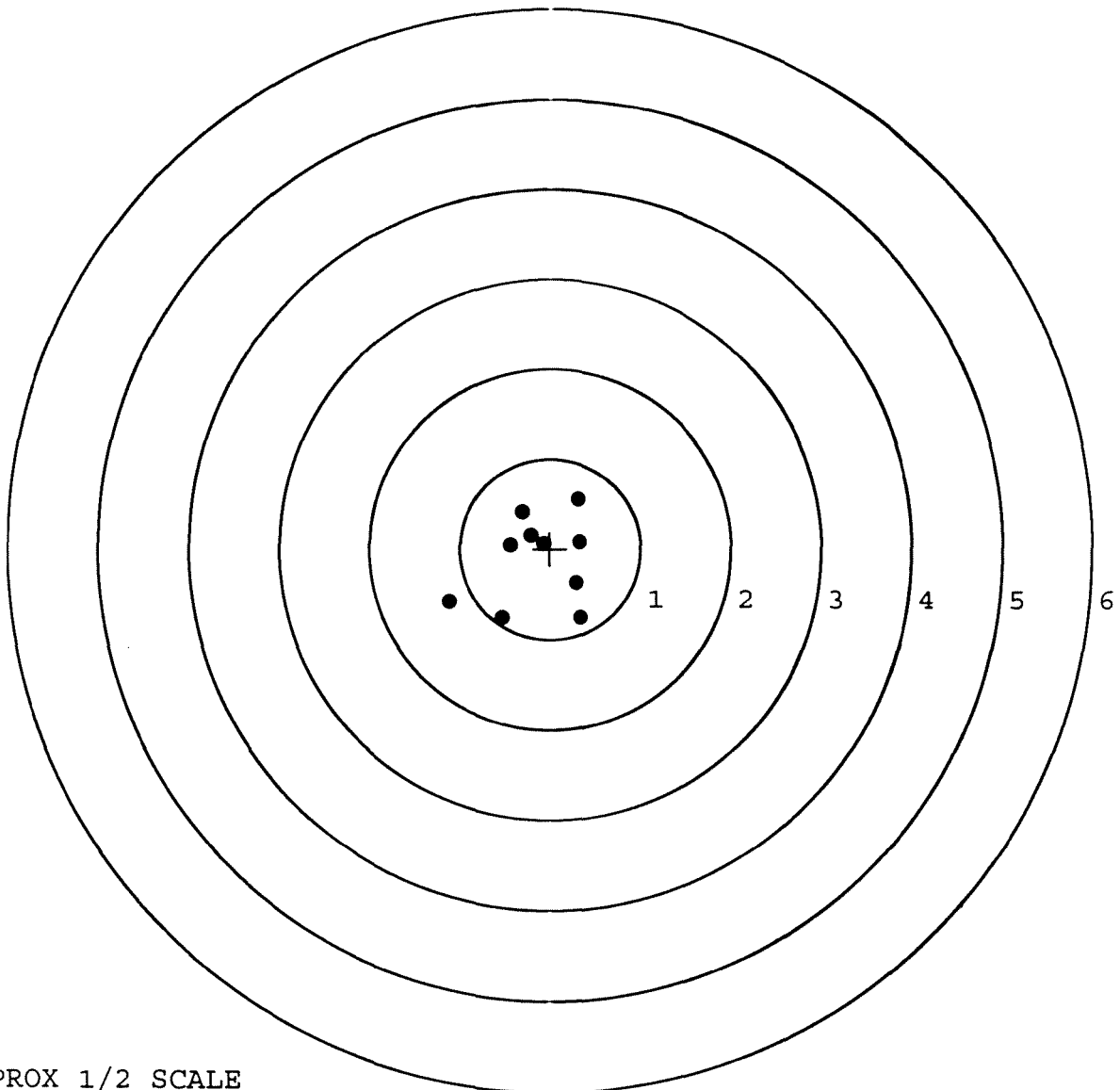


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699782. __0
TARGET NUMBER: 2
FILE DATE: 03/25/2008
FILE TIME: 06:57

POINT#	X	Y
1:	0.336	-0.755
2:	0.291	-0.377
3:	-0.533	-0.765
4:	-1.115	-0.587
5:	0.323	0.075
6:	0.307	0.551
7:	-0.071	0.056
8:	-0.437	0.041
9:	-0.309	0.407
10:	-0.213	0.152

X CENTROID: -0.142
Y CENTROID: -0.120
POA TO CENTROID: 0.186
HORZ SPREAD: 1.451
VERT SPREAD: 1.316
GROUP SPREAD: 1.821
MIN RADIUS: 0.190
MAX RADIUS: 1.079
MEAN RADIUS: 0.580
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

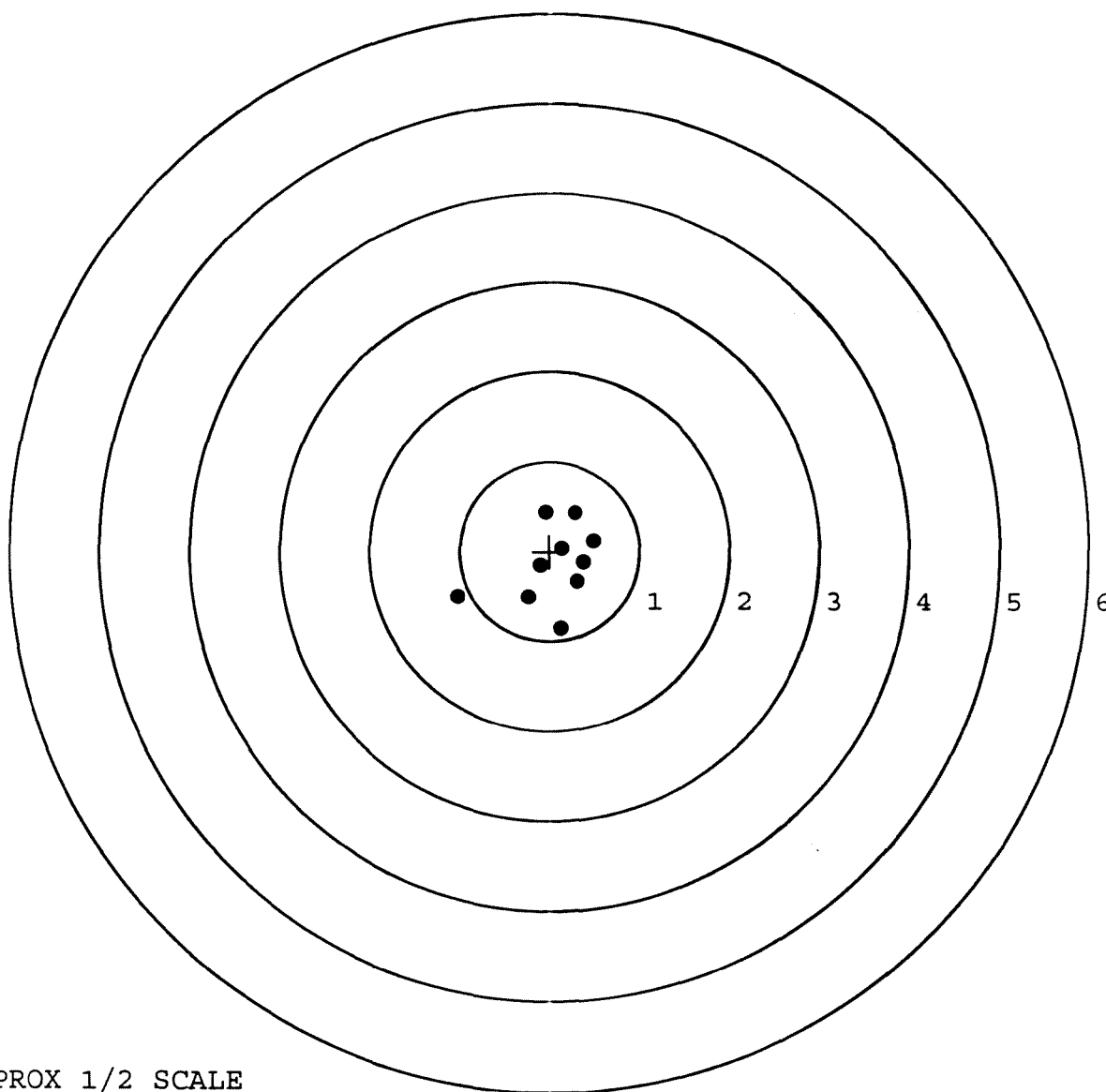


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699782. __0
TARGET NUMBER: 3
FILE DATE: 03/25/2008
FILE TIME: 06:57

POINT#	X	Y
1:	0.123	-0.863
2:	-1.022	-0.508
3:	-0.049	0.437
4:	0.282	0.432
5:	0.492	0.125
6:	0.385	-0.117
7:	0.309	-0.334
8:	-0.105	-0.157
9:	-0.237	-0.508
10:	0.139	0.035

X CENTROID: 0.032
Y CENTROID: -0.146
POA TO CENTROID: 0.149
HORZ SPREAD: 1.514
VERT SPREAD: 1.300
GROUP SPREAD: 1.641
MIN RADIUS: 0.137
MAX RADIUS: 1.114
MEAN RADIUS: 0.508
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

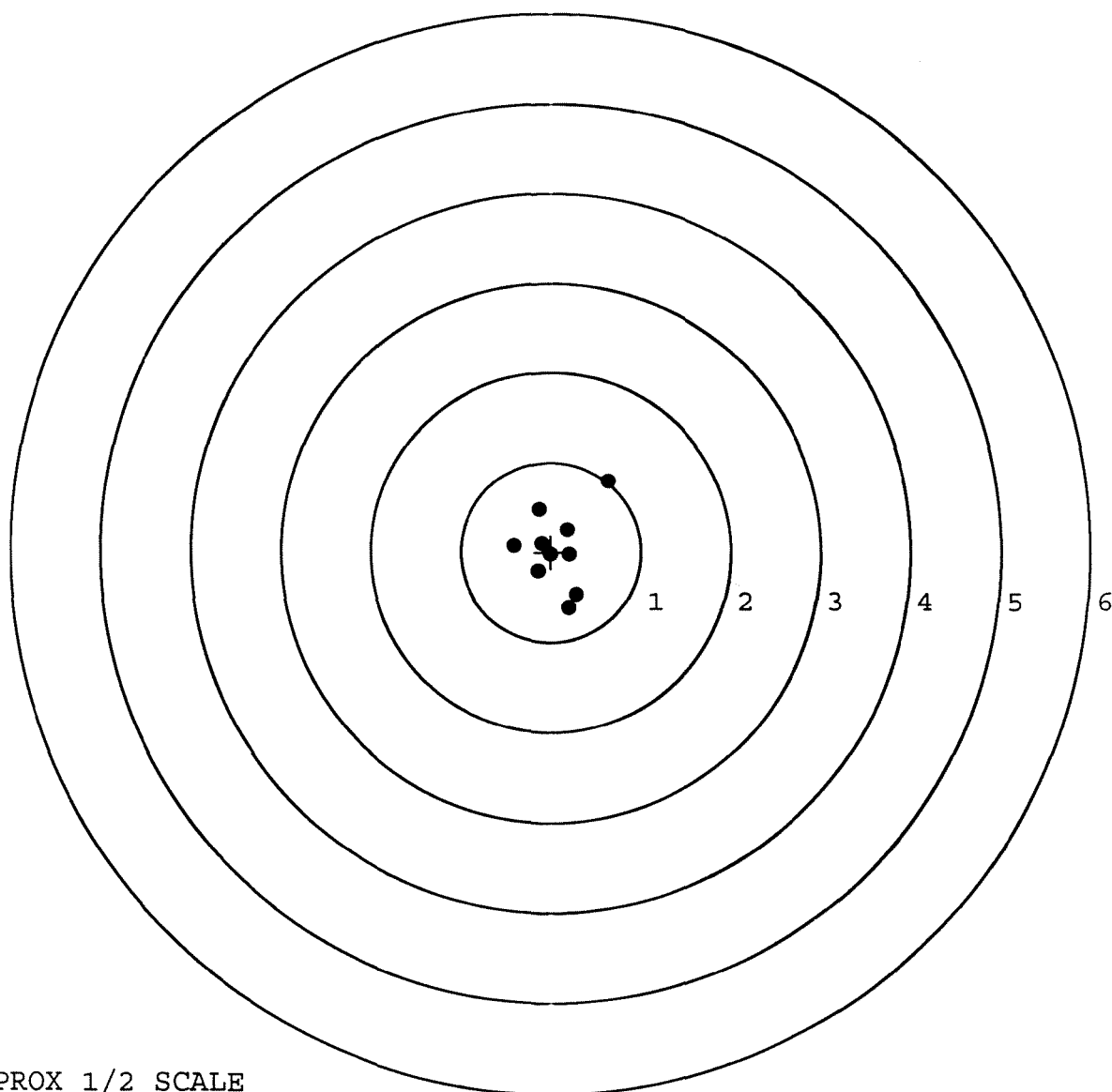


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699782. __0
TARGET NUMBER: 4
FILE DATE: 03/25/2008
FILE TIME: 06:57

X CENTROID: 0.072
Y CENTROID: 0.030
POA TO CENTROID: 0.078
HORZ SPREAD: 1.051
VERT SPREAD: 1.410
GROUP SPREAD: 1.478
MIN RADIUS: 0.102
MAX RADIUS: 0.949
MEAN RADIUS: 0.415
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.291	-0.479
2:	0.200	-0.622
3:	0.643	0.788
4:	-0.128	0.476
5:	-0.408	0.067
6:	-0.144	-0.217
7:	-0.105	0.099
8:	0.181	0.249
9:	0.204	-0.033
10:	-0.013	-0.027

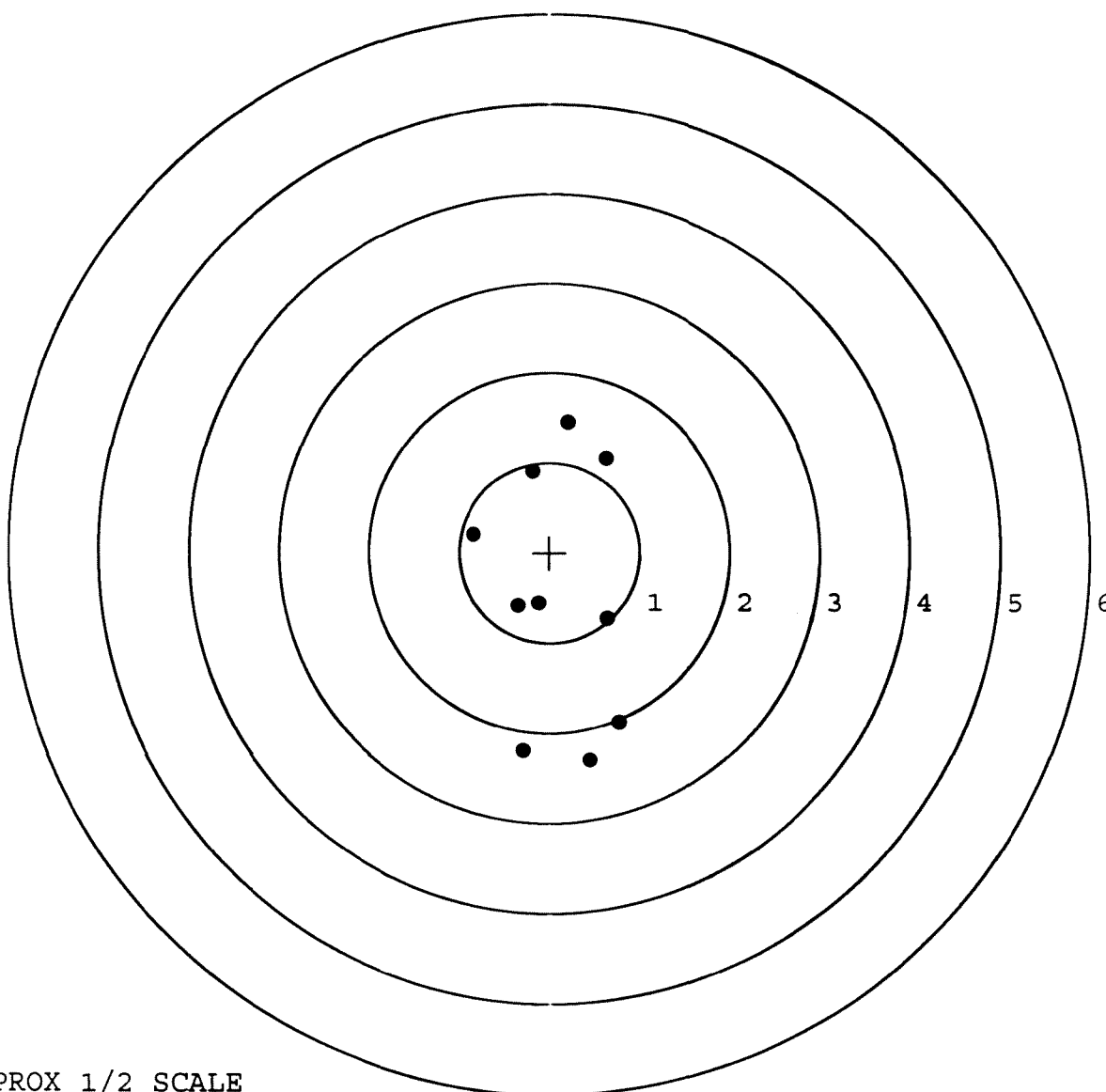


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6699782. __0
TARGET NUMBER: 5
FILE DATE: 03/25/2008
FILE TIME: 06:57

X CENTROID: 0.090
Y CENTROID: -0.471
POA TO CENTROID: 0.479
HORZ SPREAD: 1.615
VERT SPREAD: 3.754
GROUP SPREAD: 3.763
MIN RADIUS: 0.235
MAX RADIUS: 1.916
MEAN RADIUS: 1.261
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	0.634	1.046
2:	0.200	1.442
3:	-0.186	0.900
4:	-0.846	0.201
5:	-0.350	-0.592
6:	-0.126	-0.564
7:	0.646	-0.735
8:	0.769	-1.888
9:	0.456	-2.312
10:	-0.297	-2.204



TARGET APPROX 1/2 SCALE