

G669 5398

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



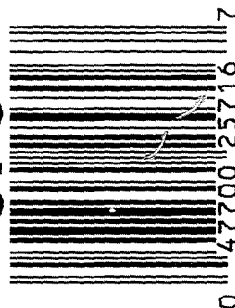
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6695398

UPC



BM FORM

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66695398

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-5-07	RTZ
600	PROOF		12-6-07	TRW
607	CHECK HEADSPACE	MAGNA - FLUX	12-6-07	TRW
610	DIS-ASSEMBLE GUN	2-2008	12-6-07	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR JB	12-10-07	JB
615	ROLLMARK CALIBER		12-7-07	CW
617	DRILL AND TAP SIGHT HOLES		12-7-07	FM
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		12/14/07	JB
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-20-07	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-20-07	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-20-07	DA
	D) OIL FIRING PIN ASSEMBLY		1-7-08	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1/8/08	RTZ

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.25</u> <u>5.25</u> <u>5.5</u>	1/8/08	mm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.0</u> <u>4.5</u>	1/8/08	mm
	H) TRIGGER PULL TEST AND RETAINABILITY		1/8/08	mm
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	1/8/08	mm
	J) ASSEMBLE STOCK		1-7-08	ETZ
	K) ASSEMBLE SWIVEL STUDS		1/8/08	mm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1/8/08	mm
	M) IRON SIGHT ALIGNMENT		1/8/08	mm
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1/8/08	mm
640	GALLERY TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	1-7/08	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-7-08	SP
655	FINAL INSPECTION A) HEADSPACE		1/8/08	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.42</u> <u>2.36</u> <u>2.54</u> <u>2.48</u>	1/8/08	mm
	C) FUNCTION		1/8/08	mm
660	PACK		1-9-08	DA

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 1-4-08

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.43	2.39		2.28	
PULL #2	2.65	2.41		2.23	
PULL #3	2.55	2.47		2.25	
PULL #4	2.58	2.45		2.23	
PULL #5	2.56	2.47		2.22	
TOTAL	12.77	12.19		11.21	
AVERAGE	2.55	2.43		2.24	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.11		
PULL #2	3.24	3.09		
PULL #3	3.23	3.02		
PULL #4	3.24	3.09		
PULL #5	3.17	3.28		
TOTAL	16.18	15.59		
AVERAGE	3.23	3.11		

	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	4.24	4.02		4.26
PULL #2	4.16	4.08		4.20
PULL #3	4.25	4.13		4.25
PULL #4	4.22	4.13		4.28
PULL #5	4.31	4.27		4.27
TOTAL	21.18	20.63		21.26
AVERAGE	4.23	4.12		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695398.___0

FILE DATE AND TIME: 01/07/2008 23:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.054
The Average Y Centroid of the Five Target Set:	-0.051
The Average Point of Impact of the Five Target Set:	0.074
The Average Mean Radius of the Five Target Set:	0.704
The Distance from POA to Centroid Target #1:	0.233
The Distance from Centroid Target #2 to Centroid Target #1:	0.386
The Distance from Centroid Target #3 to Centroid Target #1:	0.444
The Distance from Centroid Target #4 to Centroid Target #1:	0.296
The Distance from Centroid Target #5 to Centroid Target #1:	0.291

SERIAL NUMBER: G6695398.___0

TARGET NUMBER: 1

FILE DATE: 01/07/2008

FILE TIME: 23:03

POINT#	X	Y
1:	-0.319	0.601
2:	-0.761	0.030
3:	-0.365	0.042
4:	-0.065	-0.212
5:	-0.687	-0.659
6:	-0.196	-0.856
7:	0.728	-0.465
8:	0.678	0.295
9:	1.441	0.608
10:	-2.428	-0.622

X CENTROID: -0.197

Y CENTROID: -0.124

POA TO CENTROID: 0.233

HORZ SPREAD: 3.869

VERT SPREAD: 1.464

GROUP SPREAD: 4.060

MIN RADIUS: 0.159

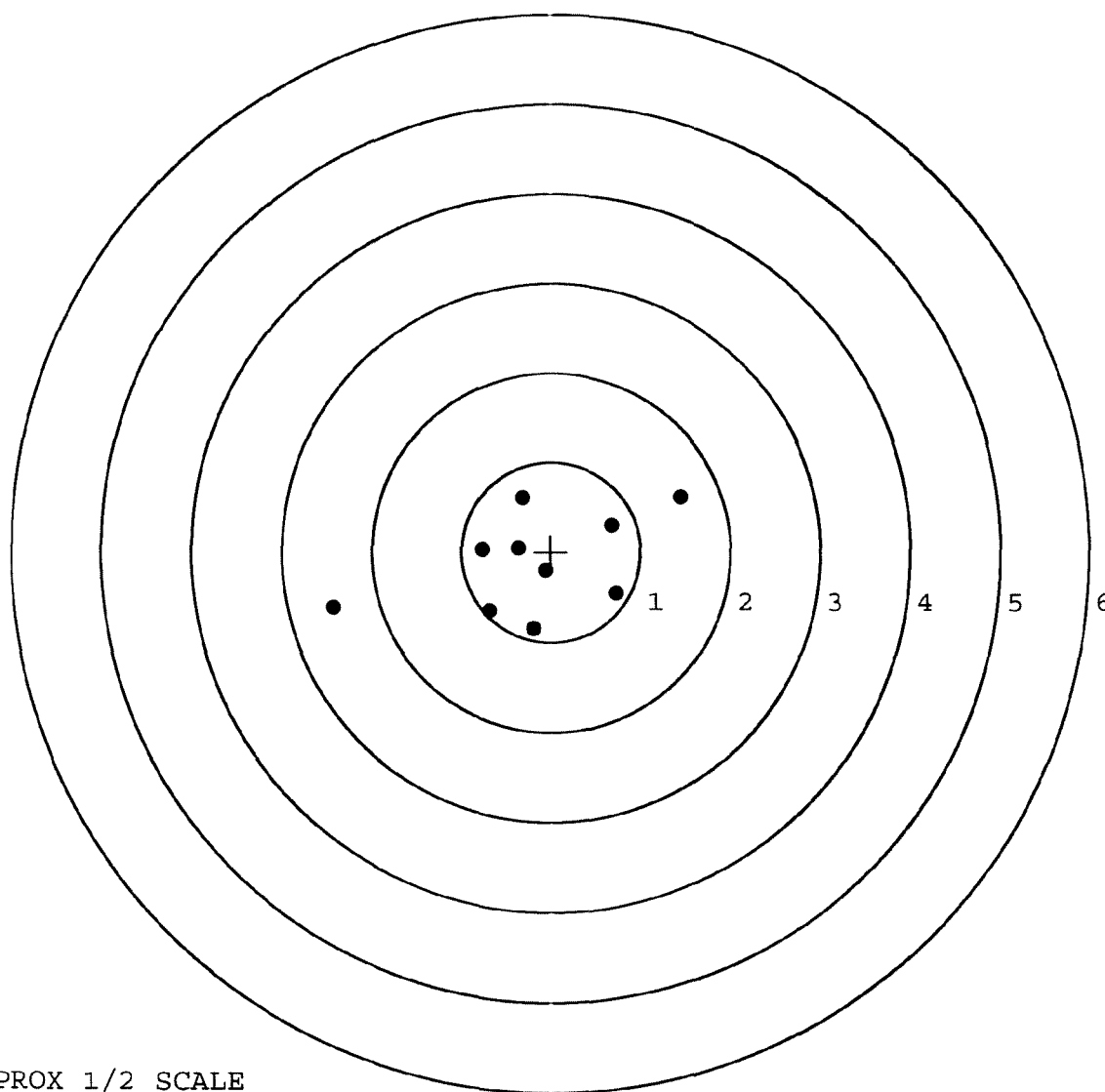
MAX RADIUS: 2.286

MEAN RADIUS: 0.921

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695398. 0

TARGET NUMBER: 2

FILE DATE: 01/07/2008

FILE TIME: 23:03

POINT#	X	Y
1:	-0.623	0.281
2:	-0.805	-0.052
3:	-1.063	-0.212
4:	-0.112	-0.286
5:	0.485	0.054
6:	0.605	-0.412
7:	0.801	-0.666
8:	1.130	-0.205
9:	0.996	0.226
10:	0.438	0.509

X CENTROID: 0.185

Y CENTROID: -0.076

POA TO CENTROID: 0.200

HORZ SPREAD: 2.193

VERT SPREAD: 1.175

GROUP SPREAD: 2.193

MIN RADIUS: 0.327

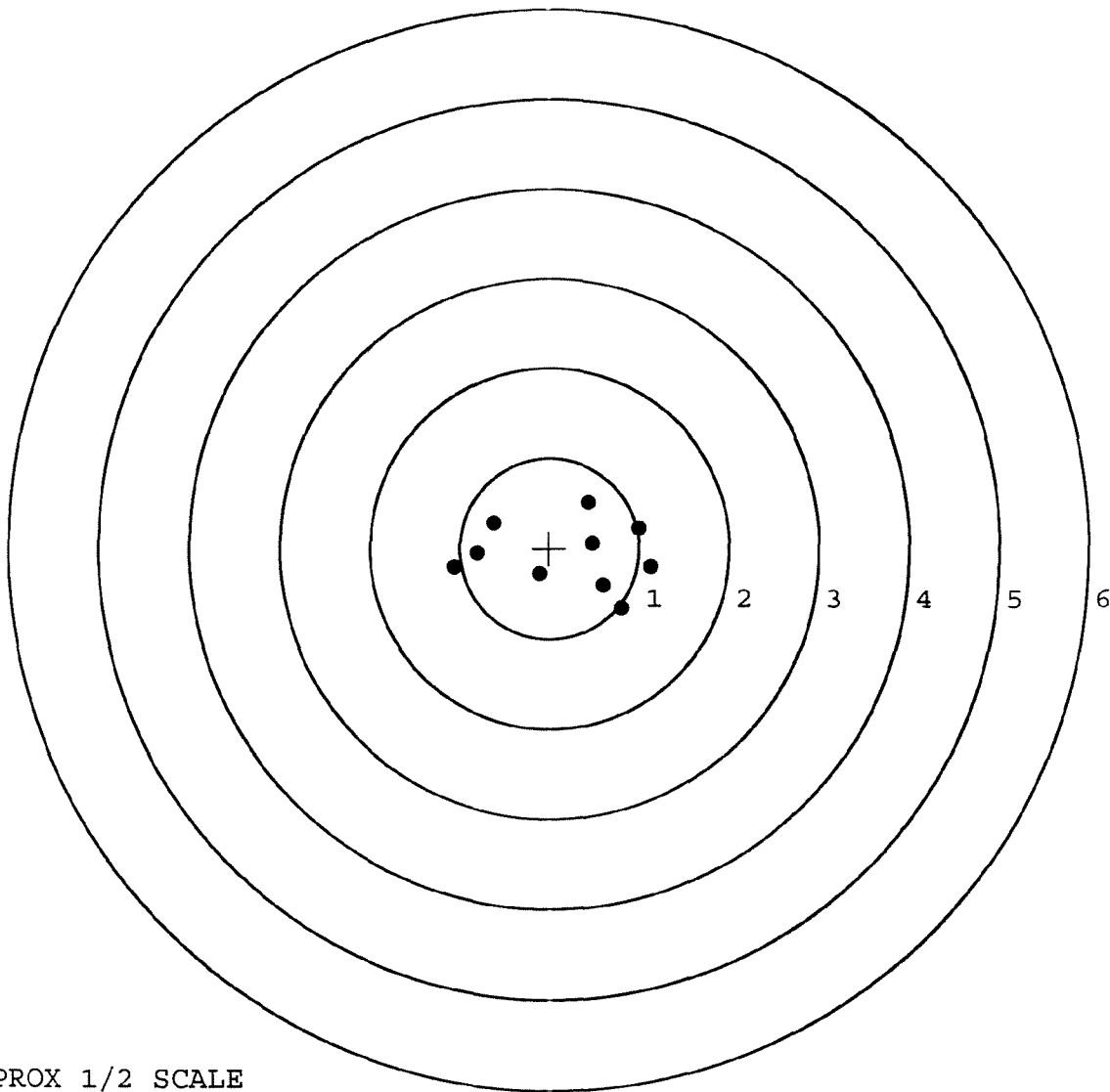
MAX RADIUS: 1.256

MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

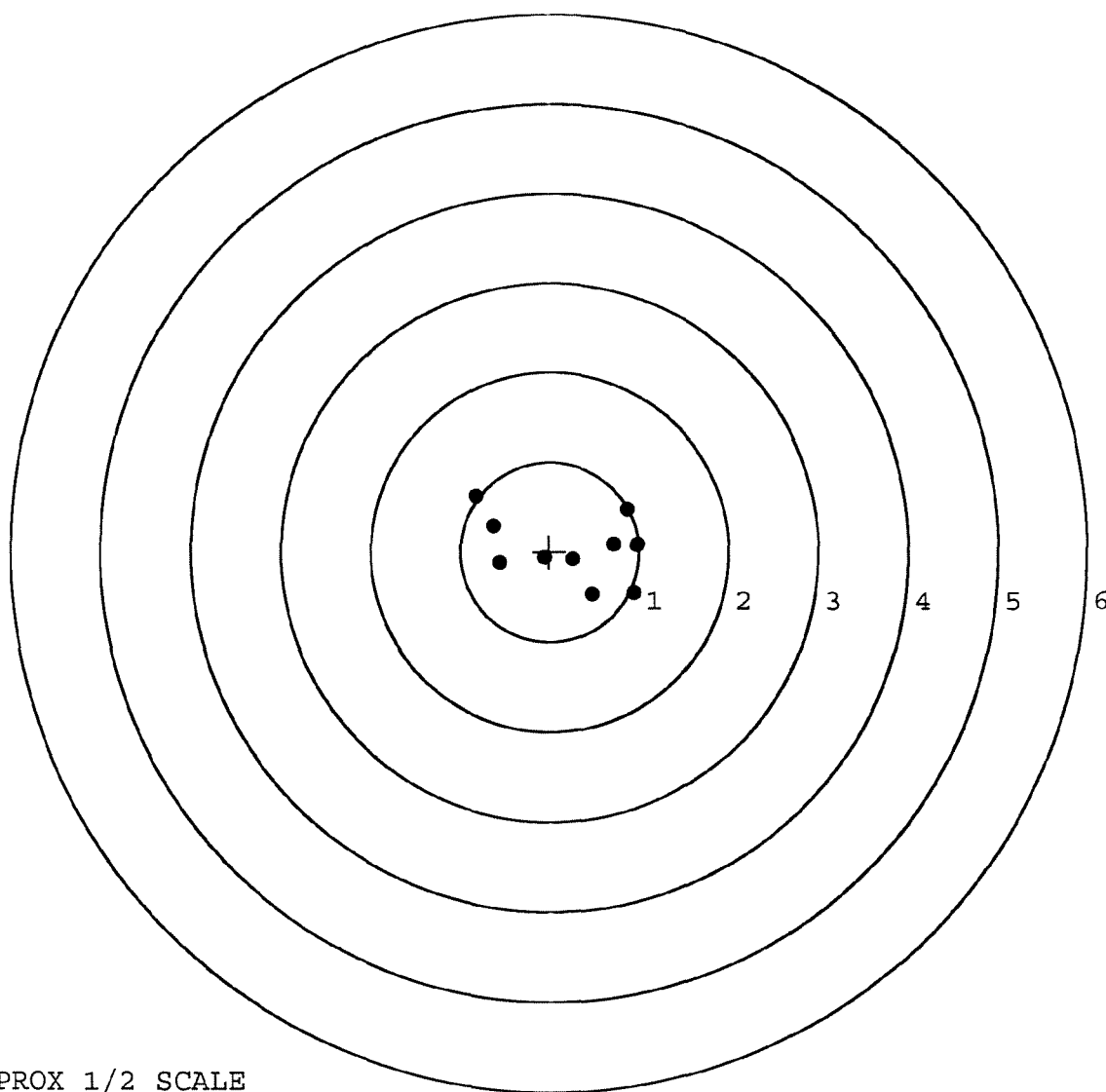


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695398. 0
TARGET NUMBER: 3
FILE DATE: 01/07/2008
FILE TIME: 23:03

POINT#	X	Y
1:	-0.824	0.621
2:	-0.629	0.293
3:	-0.560	-0.124
4:	-0.056	-0.073
5:	0.263	-0.089
6:	0.475	-0.476
7:	0.941	-0.463
8:	0.718	0.081
9:	0.986	0.077
10:	0.867	0.468

X CENTROID: 0.218
Y CENTROID: 0.031
POA TO CENTROID: 0.220
HORZ SPREAD: 1.810
VERT SPREAD: 1.097
GROUP SPREAD: 2.071
MIN RADIUS: 0.129
MAX RADIUS: 1.197
MEAN RADIUS: 0.680
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695398. 0

TARGET NUMBER: 4

FILE DATE: 01/07/2008

FILE TIME: 23:03

POINT#	X	Y
1:	-0.540	0.174
2:	-0.757	-0.279
3:	-0.001	0.483
4:	0.433	0.381
5:	0.320	-0.069
6:	0.552	-0.392
7:	0.187	-0.520
8:	0.032	-0.585
9:	-0.160	-0.260
10:	0.827	-0.927

X CENTROID: 0.089

Y CENTROID: -0.199

POA TO CENTROID: 0.218

HORZ SPREAD: 1.584

VERT SPREAD: 1.410

GROUP SPREAD: 1.755

MIN RADIUS: 0.257

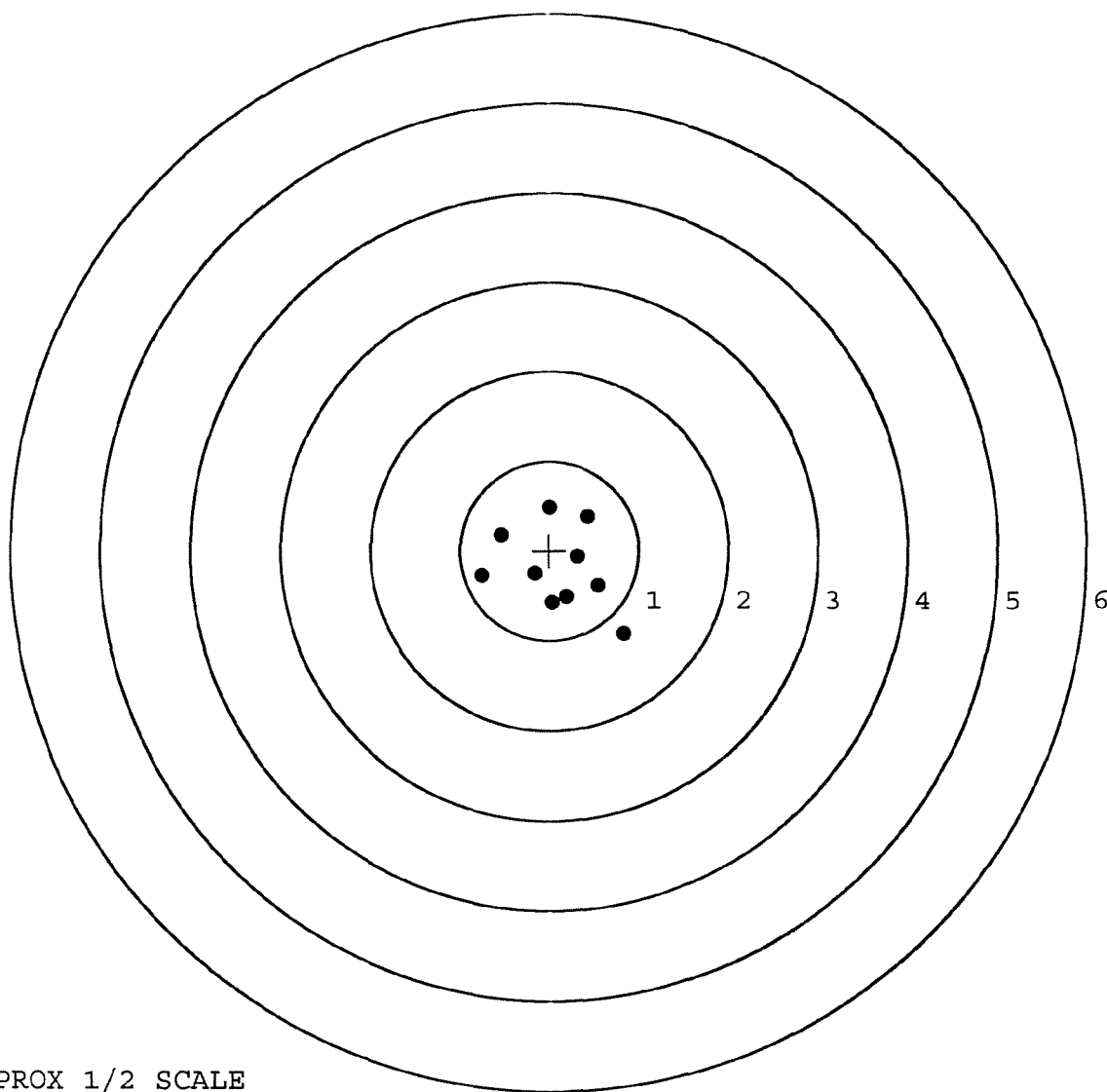
MAX RADIUS: 1.036

MEAN RADIUS: 0.573

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695398. __0

TARGET NUMBER: 5

FILE DATE: 01/07/2008

FILE TIME: 23:03

POINT#	X	Y
1:	0.332	0.900
2:	-0.920	-0.019
3:	-0.170	0.642
4:	0.305	-0.430
5:	-0.375	-0.311
6:	0.017	0.073
7:	-0.426	-0.029
8:	-0.171	0.510
9:	0.552	0.225
10:	0.581	-0.431

X CENTROID: -0.028

Y CENTROID: 0.113

POA TO CENTROID: 0.116

HORZ SPREAD: 1.501

VERT SPREAD: 1.331

GROUP SPREAD: 1.557

MIN RADIUS: 0.060

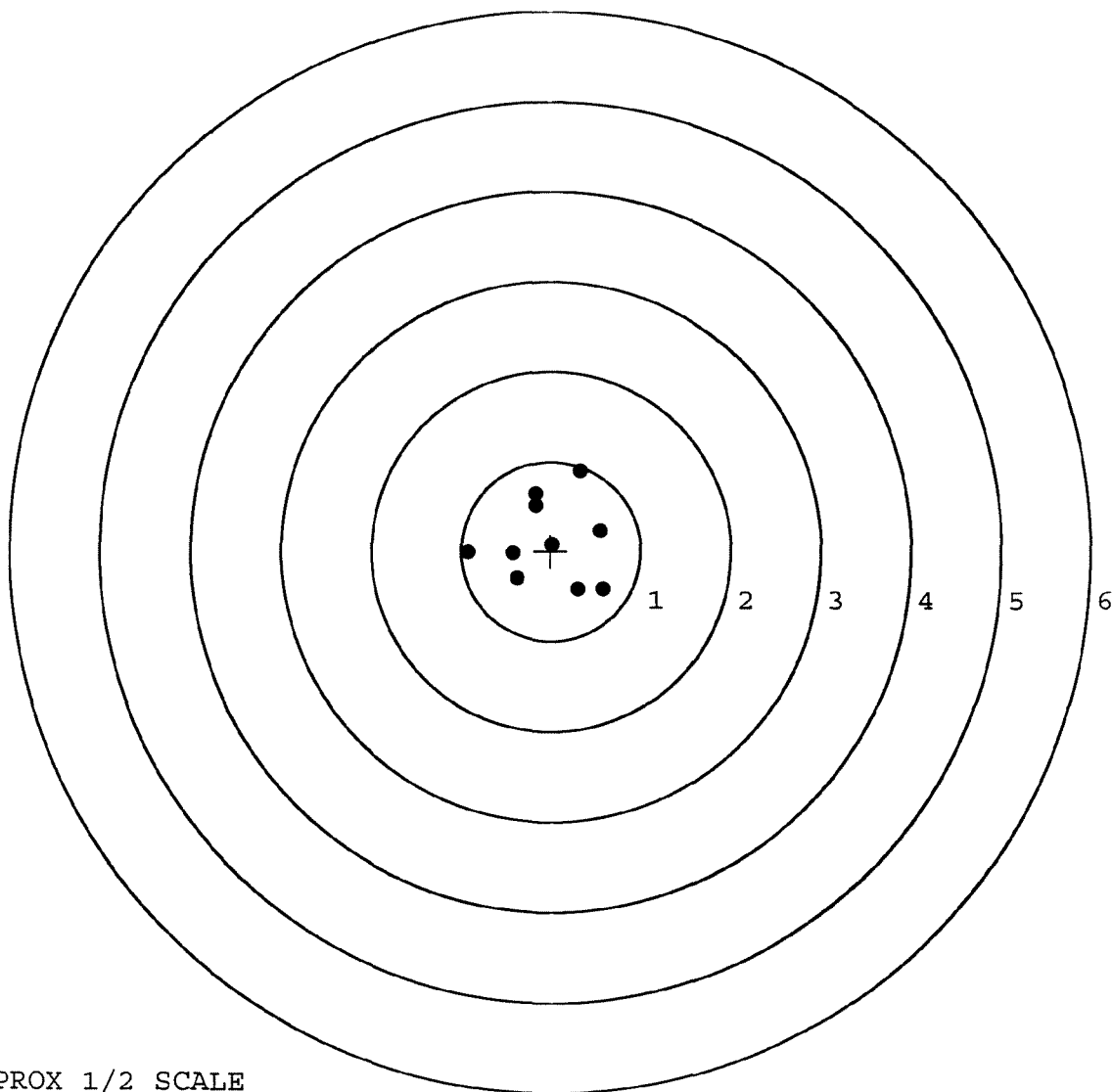
MAX RADIUS: 0.902

MEAN RADIUS: 0.581

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE