

G 641 4389

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



DD FORM

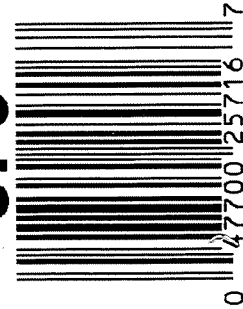
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6414389

UPC



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

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UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66414389

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTZ
600	PROOF		10-20-04	A
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		10/27/04	JB
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRW
620	APPLY COATINGS (BARREL ACTION)		10/30	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		11-5-04	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-04	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-04	RTZ
	D) OIL FIRING PIN ASSEMBLY		11-5-04	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP # OPERATION NAME		READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u>	<u>5.0</u>	<u>5.0</u>	12/2/04	DA		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u>	<u>3.0</u>	<u>2.25</u>	12/2/04	DA		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT .020 MIN	<u>.023</u>	<u>.022</u>	<u>.023</u>	12/2/04	DA		
	J) ASSEMBLE STOCK				11-5-04	RTL		
	K) ASSEMBLE SWIVEL STUDS				12-7-04	AC		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	NA						
	M) IRON SIGHT ALIGNMENT	NA						
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER	NA						
640	GALLERY TEST AND TARGET		PASS	FAIL	12-1-04	K		
	MALFUNCTION CH	CORRECTION	OK		12-3-04	TRW		
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION	NA					
	MALFUNCTION	CORRECTION						
645	INSPECT FOR LIVE AMMO				12-1-04	AC		
655	FINAL INSPECTION A) HEADSPACE				12-7-04	AC		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.92</u>	<u>2.92</u>	<u>2.89</u>	<u>2.92</u>	<u>2.91</u>	12/2/04	DA
	C) FUNCTION				12-7-04	AC		
660	PACK				12/8/04	DA		

AVERAGE PULL FORCE BETWEEN
 INITIAL & RESET - M24 0151461
 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)

SERIAL NO.

DATE

6-15-04

TESTER

TPW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.36		2.19	
PULL #2	2.30	2.37		2.13	
PULL #3	2.35	2.42		2.13	
PULL #4	2.52	2.30		2.14	
PULL #5	2.53	2.30		2.23	
TOTAL	12.10	11.75		10.82	
AVERAGE	2.42	2.35		2.16	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.15		
PULL #2	3.25	3.01		
PULL #3	3.16	3.11		
PULL #4	3.18	3.11		
PULL #5	3.14	3.13		
TOTAL	15.98	15.51		
AVERAGE	3.19	3.10		

	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	4.37	4.29		4.34
PULL #2	4.36	4.21		4.35
PULL #3	4.29	4.16		4.38
PULL #4	4.28	4.29		4.43
PULL #5	4.33	4.31		4.44
TOTAL	21.63	21.26		21.94
AVERAGE	4.32	4.25		4.38

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414389.__1
FILE DATE AND TIME: 09/14/2005 06:07

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.065
The Average Y Centroid of the Five Target Set:	-0.089
The Average Point of Impact of the Five Target Set:	0.110
The Average Mean Radius of the Five Target Set:	0.983
The Distance from POA to Centroid Target #1:	0.040
The Distance from Centroid Target #2 to Centroid Target #1:	0.097
The Distance from Centroid Target #3 to Centroid Target #1:	0.320
The Distance from Centroid Target #4 to Centroid Target #1:	0.414
The Distance from Centroid Target #5 to Centroid Target #1:	0.165

SERIAL NUMBER: G6414389. 1

TARGET NUMBER: 1

FILE DATE: 09/14/2005

FILE TIME: 06:07

POINT#	X	Y
1:	0.942	0.536
2:	0.645	0.034
3:	0.431	1.453
4:	-0.706	-0.055
5:	-0.702	0.244
6:	-0.989	0.499
7:	0.348	-0.333
8:	0.056	-0.517
9:	0.088	-0.694
10:	0.108	-0.831

X CENTROID: 0.022

Y CENTROID: 0.034

POA TO CENTROID: 0.040

HORZ SPREAD: 1.931

VERT SPREAD: 2.284

GROUP SPREAD: 2.307

MIN RADIUS: 0.491

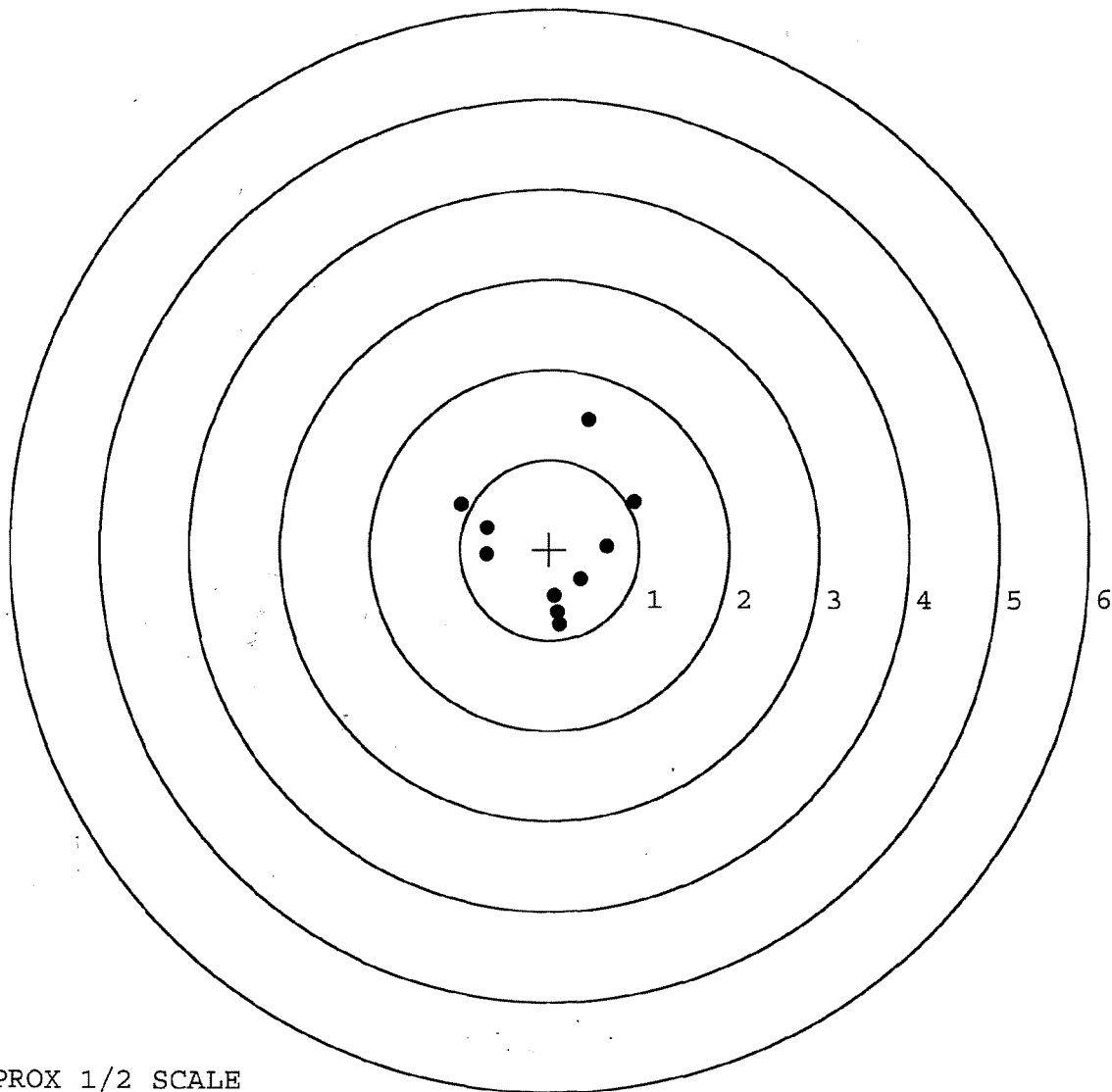
MAX RADIUS: 1.477

MEAN RADIUS: 0.839

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414389. 1

TARGET NUMBER: 2

FILE DATE: 09/14/2005

FILE TIME: 06:07

POINT#	X	Y
1:	1.408	-0.209
2:	0.596	0.468
3:	-0.011	0.297
4:	-0.498	0.539
5:	-0.905	0.864
6:	-1.328	0.759
7:	-0.544	-0.664
8:	-0.077	-0.495
9:	0.502	-0.228
10:	0.255	-0.491

X CENTROID: -0.060

Y CENTROID: 0.084

POA TO CENTROID: 0.103

HORZ SPREAD: 2.736

VERT SPREAD: 1.528

GROUP SPREAD: 2.902

MIN RADIUS: 0.219

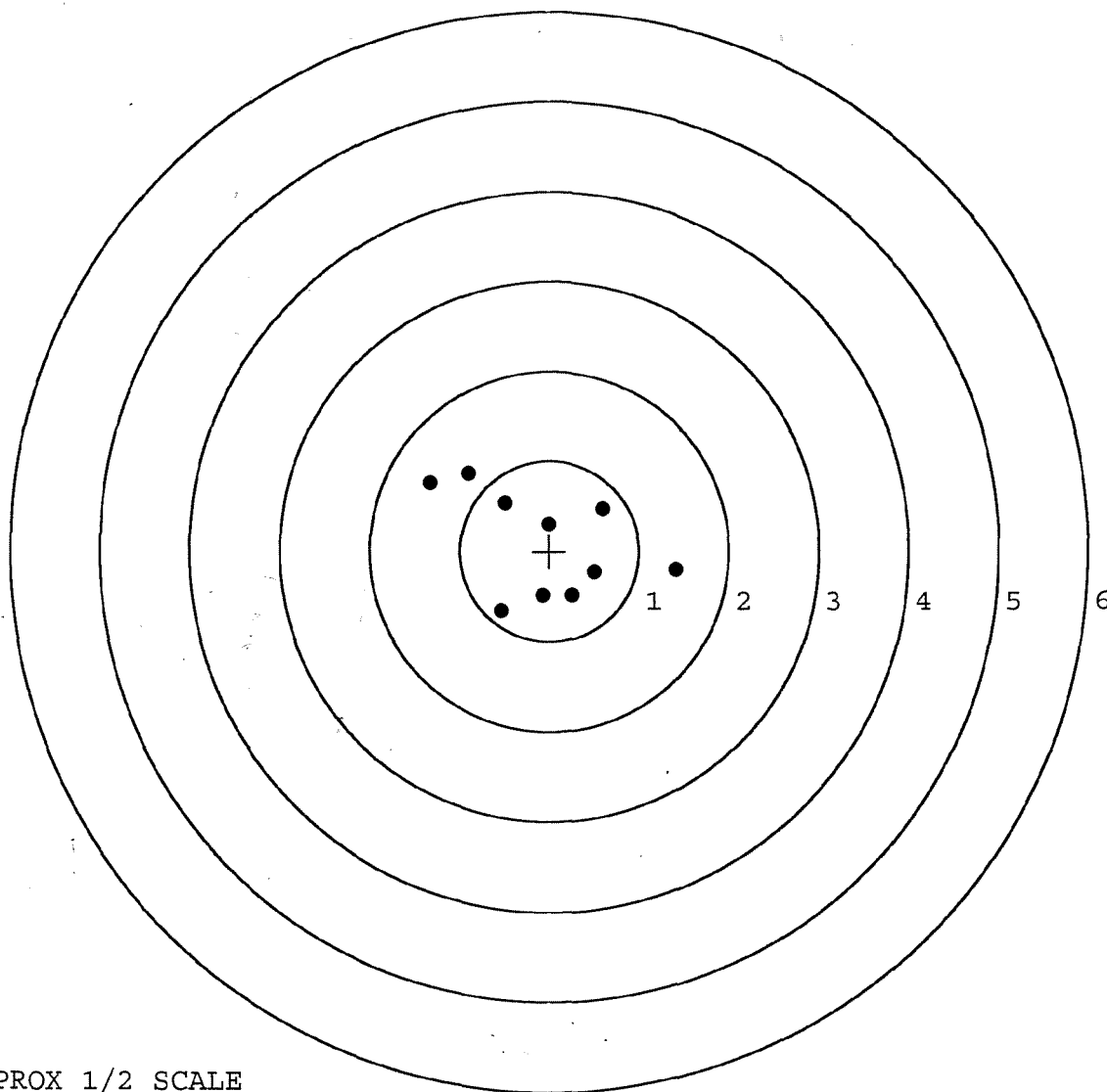
MAX RADIUS: 1.497

MEAN RADIUS: 0.846

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

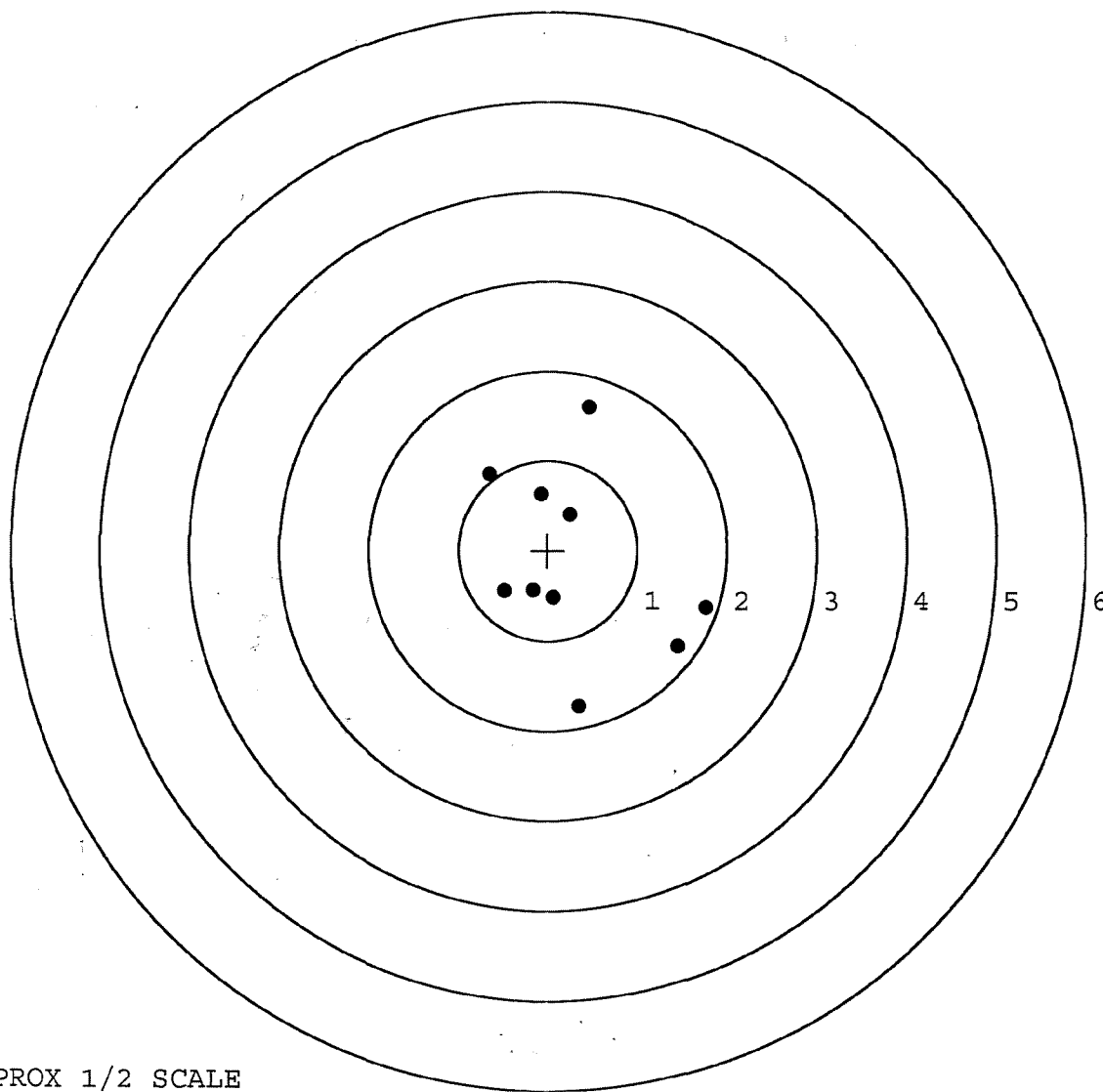


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414389: 1
 TARGET NUMBER: 3
 FILE DATE: 09/14/2005
 FILE TIME: 06:07

POINT#	X	Y
1:	1.766	-0.631
2:	1.452	-1.061
3:	0.351	-1.728
4:	0.459	1.595
5:	0.244	0.397
6:	-0.084	0.625
7:	-0.654	0.847
8:	0.062	-0.525
9:	-0.173	-0.444
10:	-0.492	-0.450

X CENTROID: 0.293
 Y CENTROID: -0.137
 POA TO CENTROID: 0.324
 HORZ SPREAD: 2.420
 VERT SPREAD: 3.323
 GROUP SPREAD: 3.325
 MIN RADIUS: 0.451
 MAX RADIUS: 1.740
 MEAN RADIUS: 1.097
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414389. __1

TARGET NUMBER: 4

FILE DATE: 09/14/2005

FILE TIME: 06:07

POINT#	X	Y
1:	1.261	-0.703
2:	0.590	-1.025
3:	0.838	0.156
4:	0.327	-0.224
5:	-0.075	-0.422
6:	-0.531	-0.652
7:	-1.309	-0.053
8:	-0.382	0.576
9:	-0.122	1.054
10:	-1.473	-2.360

X CENTROID: -0.088

Y CENTROID: -0.365

POA TO CENTROID: 0.376

HORZ SPREAD: 2.734

VERT SPREAD: 3.414

GROUP SPREAD: 3.672

MIN RADIUS: 0.058

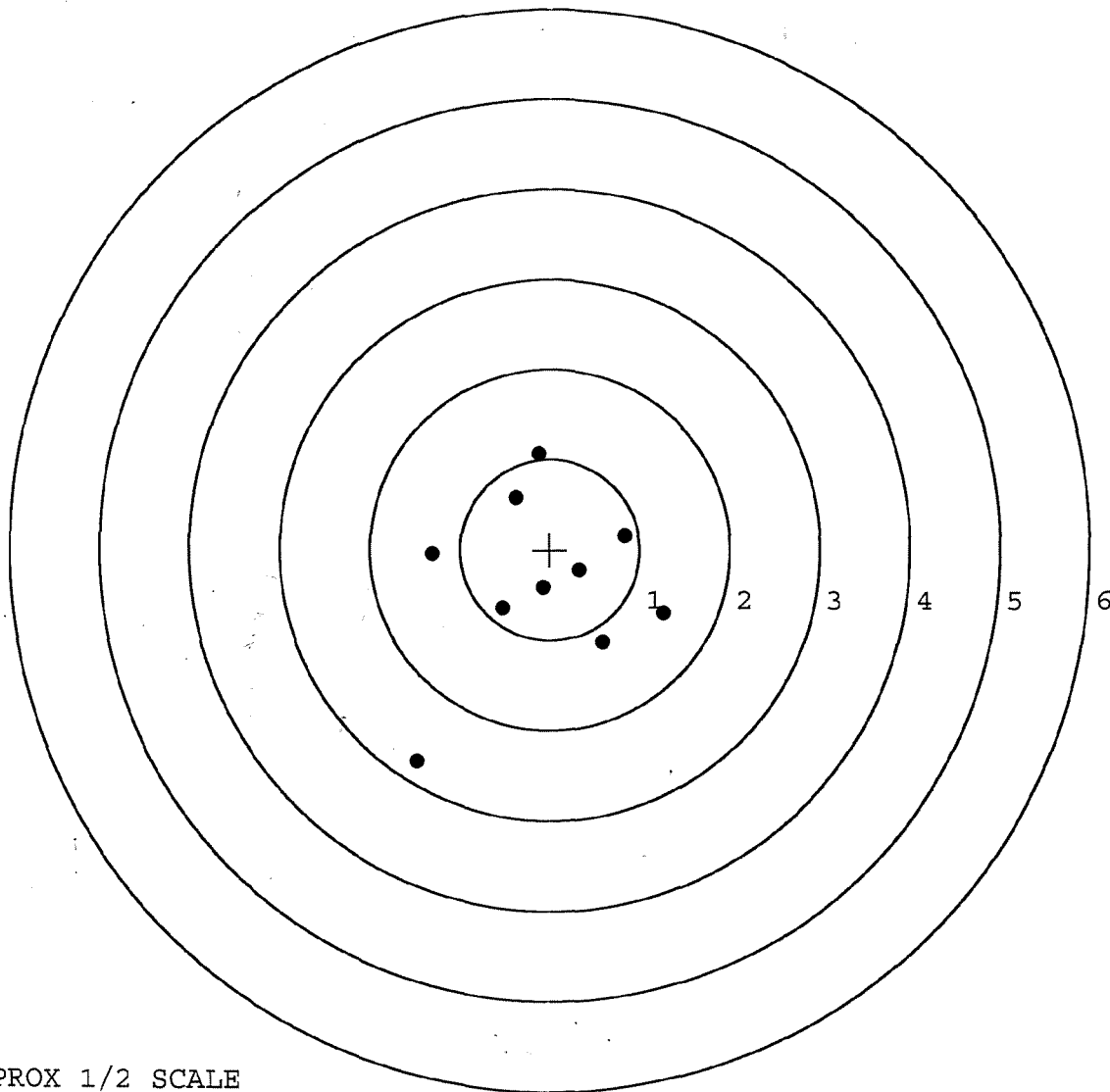
MAX RADIUS: 2.429

MEAN RADIUS: 1.052

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

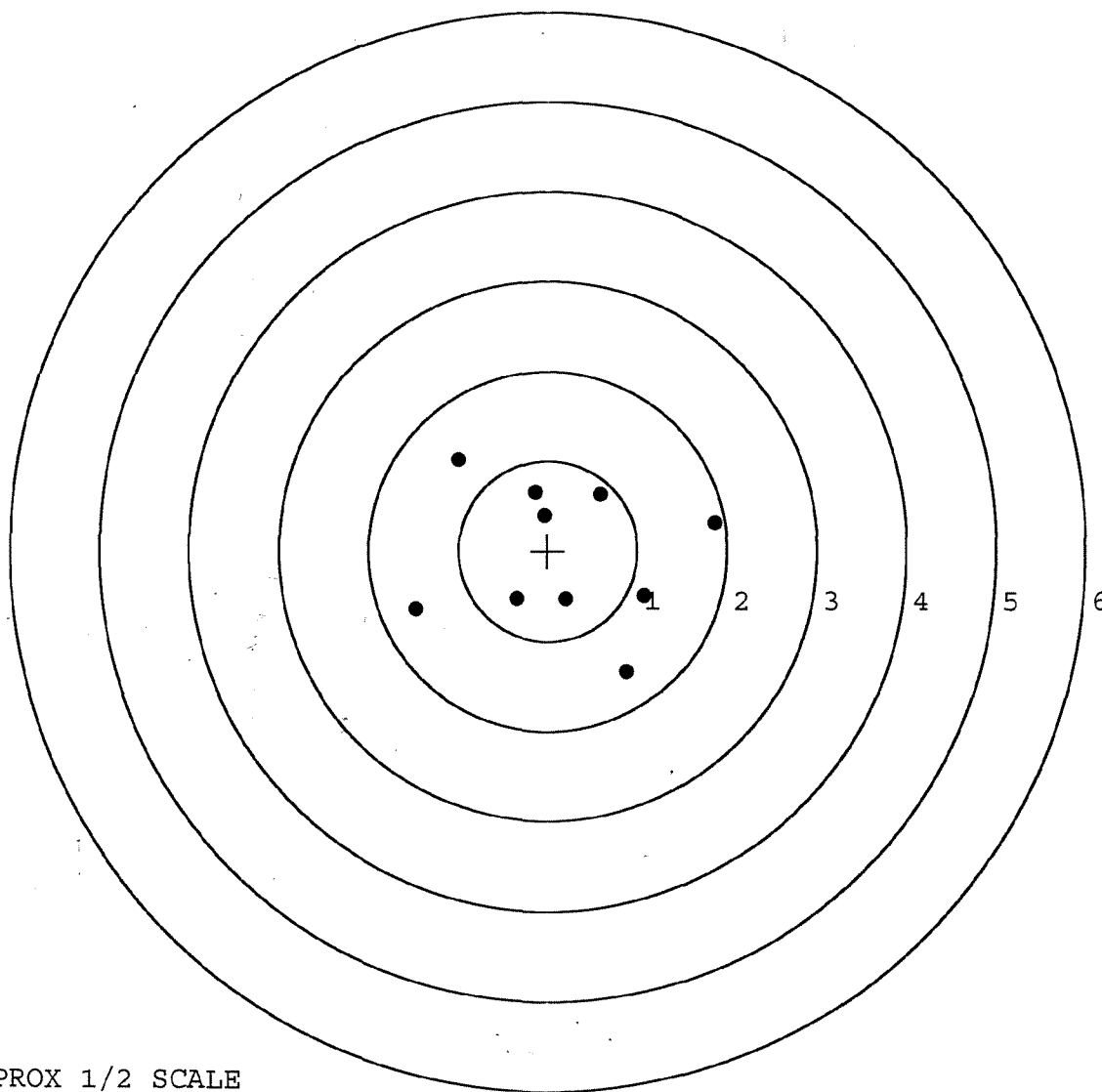


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414389. 1
 TARGET NUMBER: 5
 FILE DATE: 09/14/2005
 FILE TIME: 06:07

POINT#	X	Y
1:	1.863	0.311
2:	1.076	-0.503
3:	0.876	-1.343
4:	0.204	-0.540
5:	-0.349	-0.538
6:	-1.477	-0.649
7:	0.580	0.621
8:	-0.041	0.392
9:	-0.142	0.650
10:	-1.006	1.008

X CENTROID: 0.158
 Y CENTROID: -0.059
 POA TO CENTROID: 0.169
 HORZ SPREAD: 3.340
 VERT SPREAD: 2.351
 GROUP SPREAD: 3.475
 MIN RADIUS: 0.483
 MAX RADIUS: 1.744
 MEAN RADIUS: 1.080
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE