

G-659 1613

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

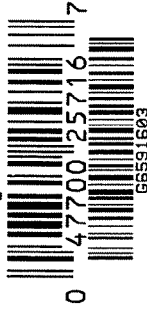
- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



ORDER NO.

25716

BARREL LENGTH

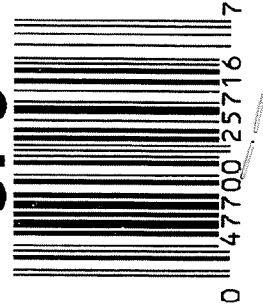
24"

CAPACITY

6

G6591603

UPC



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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.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591603

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-12-06	RTZ
420	ASSEMBLE ACTION		9-20-06	RTZ
430	ASSEMBLE TO STOCK		9-21-06	RP
440	PROOF		9-21-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-21-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 22 2006	9-21-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	9-22-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-22-06	CW
510	DRILL AND TAP SIGHT HOLES		9-21-06	TRW
520	GOFF BLAST BBL / REC		9-22-06	CB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/25	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/27	DK
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/27	DK
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/27	DK
	D) OIL FIRING PIN ASSEMBLY		9-27-06	BLC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	DESCRIPTION	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6°</u> <u>6°</u> <u>7°</u>	10-3-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4°</u> <u>4°</u> <u>4°</u>	10-3-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	10-3-06	SD
	J) ASSEMBLE STOCK		9-27-06	BLC
	K) ASSEMBLE SWIVEL STUDS		11-7-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-27-06	BLC
	M) IRON SIGHT ALIGNMENT		9-27-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-27-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-28-06	MMH
	MALFUNCTION <u>RTZ</u>	CORRECTION <u>OK</u>	9/30/06	MMH
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-28-06	BD
670	FINAL INSPECTION A) HEADSPACE		11-7-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>228</u> <u>228</u> <u>227</u> <u>235</u> <u>224</u>	10-3-06	DA
	C) FUNCTION		11-7-06	RTZ
690	PACK		11/9/06	DA

F004 REV 5/2006

BARBER - M24 0168513**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 8-26-06TESTER mjlw

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.56	2.67		2.48	
PULL #2	2.38	2.43		2.44	
PULL #3	2.48	2.41		2.43	
PULL #4	2.54	2.23		2.46	
PULL #5	2.52	2.31		2.45	
TOTAL	12.48	12.05		12.26	
AVERAGE	2.50	2.41		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	2.95		
PULL #2	3.18	2.90		
PULL #3	3.12	2.87		
PULL #4	3.09	2.84		
PULL #5	3.12	2.85		
TOTAL	15.71	14.41		
AVERAGE	3.14	2.88		

	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	4.27	3.93		4.02
PULL #2	4.16	3.94		3.98
PULL #3	4.17	3.97		4.01
PULL #4	4.12	3.92		4.04
PULL #5	4.19	3.97		4.05
TOTAL	20.91	19.73		20.10
AVERAGE	4.18	3.95		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591603.__0
FILE DATE AND TIME: 09/28/2006 23:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.165
The Average Y Centroid of the Five Target Set:	-0.022
The Average Point of Impact of the Five Target Set:	0.167
The Average Mean Radius of the Five Target Set:	0.785
The Distance from POA to Centroid Target #1:	0.032
The Distance from Centroid Target #2 to Centroid Target #1:	0.086
The Distance from Centroid Target #3 to Centroid Target #1:	0.324
The Distance from Centroid Target #4 to Centroid Target #1:	0.234
The Distance from Centroid Target #5 to Centroid Target #1:	0.152

SERIAL NUMBER: G6591603. 0

TARGET NUMBER: 1

FILE DATE: 09/28/2006

FILE TIME: 23:54

POINT#	X	Y
1:	0.740	-1.052
2:	0.802	-0.523
3:	0.071	-0.578
4:	0.233	-0.289
5:	0.246	0.131
6:	-0.328	0.043
7:	-0.591	0.250
8:	-1.419	0.223
9:	-0.291	0.630
10:	0.272	0.984

X CENTROID: -0.026

Y CENTROID: -0.018

POA TO CENTROID: 0.032

HORZ SPREAD: 2.221

VERT SPREAD: 2.036

GROUP SPREAD: 2.507

MIN RADIUS: 0.308

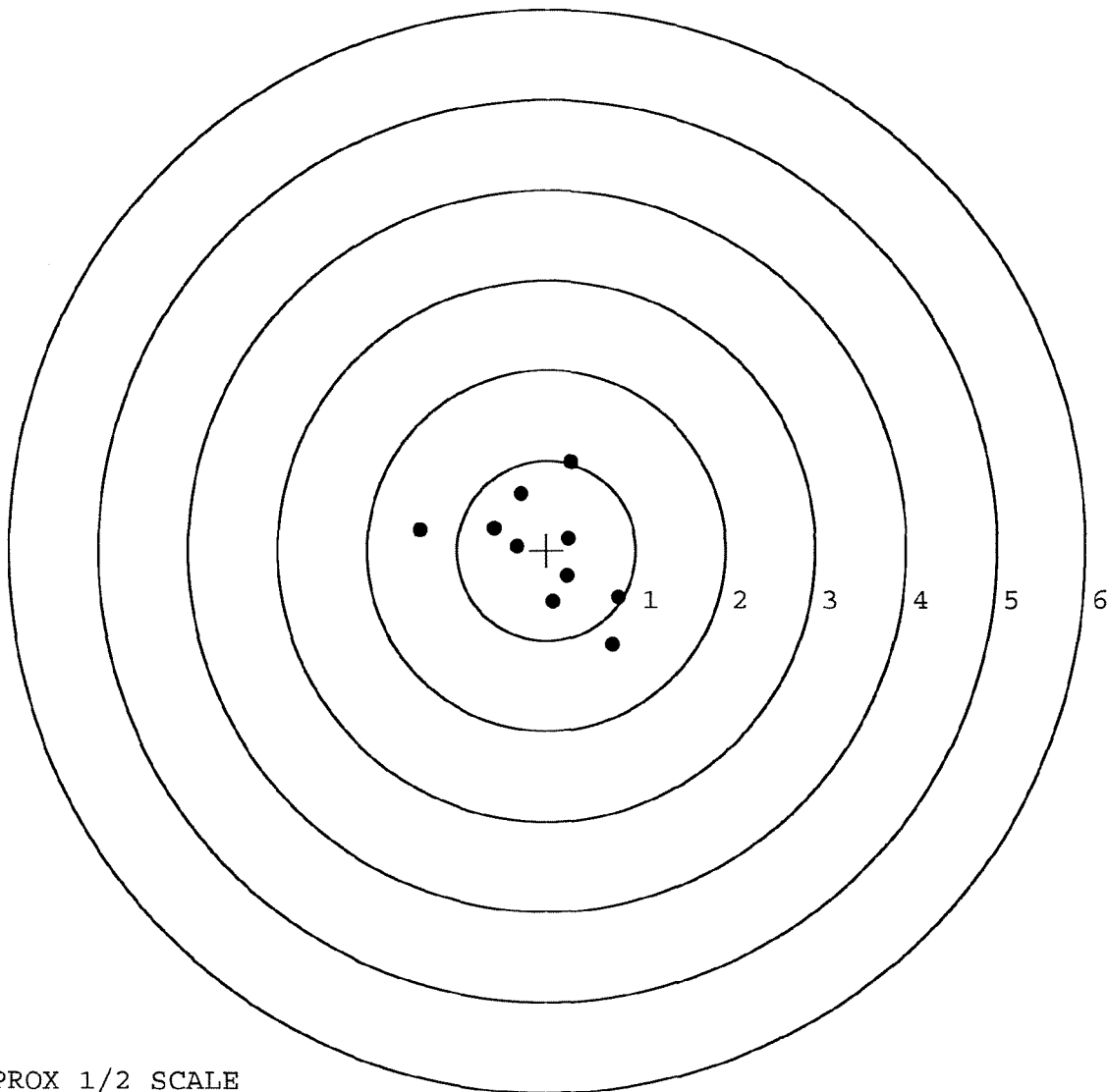
MAX RADIUS: 1.413

MEAN RADIUS: 0.760

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591603. 0

TARGET NUMBER: 2

FILE DATE: 09/28/2006

FILE TIME: 23:54

X CENTROID: -0.030

Y CENTROID: -0.104

POA TO CENTROID: 0.108

HORZ SPREAD: 1.609

VERT SPREAD: 2.373

GROUP SPREAD: 2.622

MIN RADIUS: 0.284

MAX RADIUS: 1.461

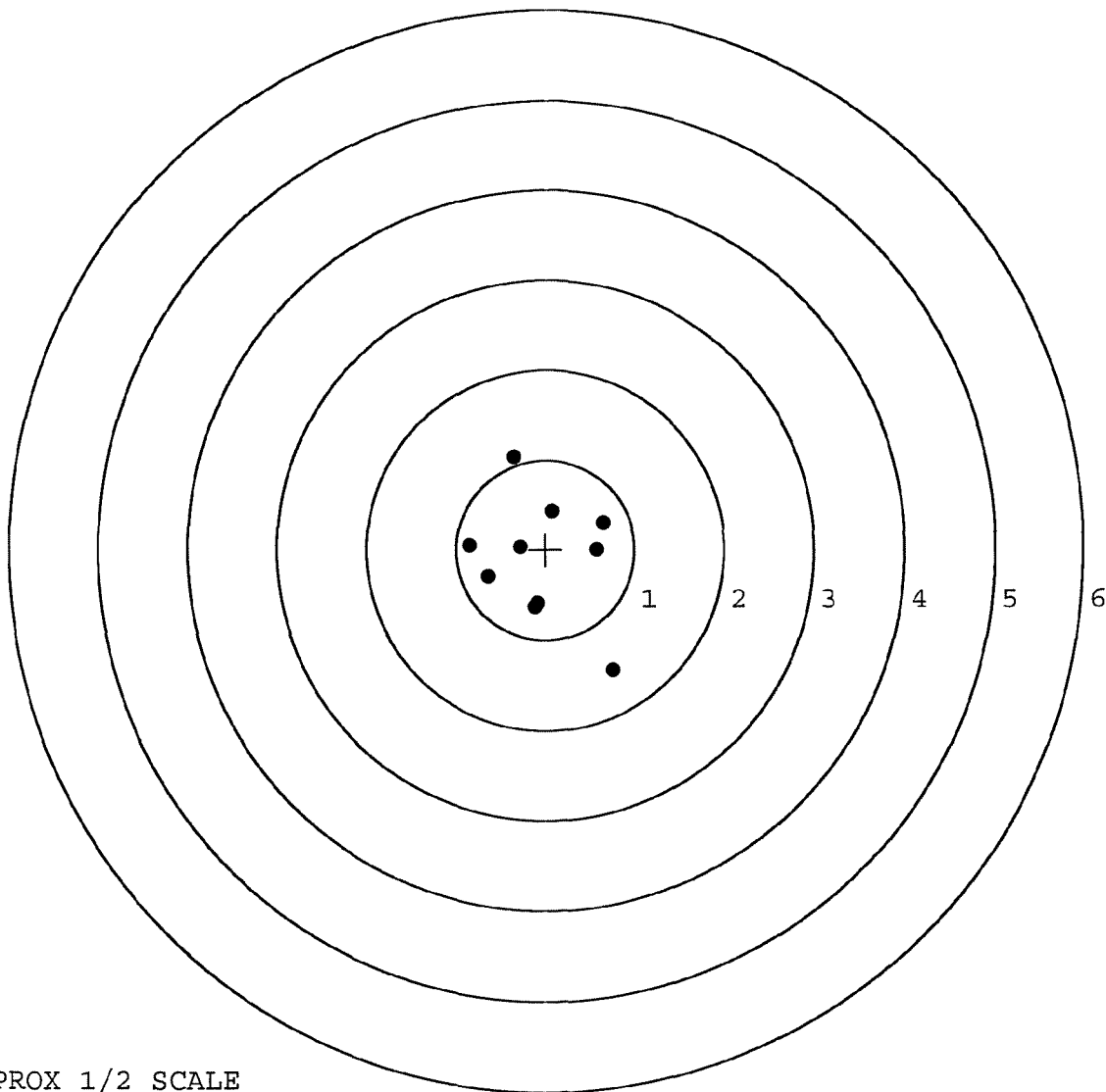
MEAN RADIUS: 0.742

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.757	-1.336
2:	-0.120	-0.644
3:	0.580	0.004
4:	0.646	0.300
5:	0.073	0.427
6:	-0.358	1.037
7:	-0.281	0.028
8:	-0.097	-0.605
9:	-0.645	-0.306
10:	-0.852	0.052



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591603. 0

TARGET NUMBER: 3

FILE DATE: 09/28/2006

FILE TIME: 23:54

POINT#	X	Y
1:	0.740	0.730
2:	0.655	-0.376
3:	-0.512	-1.299
4:	-0.437	-0.302
5:	-1.614	-0.434
6:	-1.599	-0.075
7:	-0.331	0.798
8:	-0.364	0.514
9:	0.008	0.749
10:	0.102	0.489

X CENTROID: -0.335

Y CENTROID: 0.079

POA TO CENTROID: 0.344

HORZ SPREAD: 2.354

VERT SPREAD: 2.097

GROUP SPREAD: 2.384

MIN RADIUS: 0.395

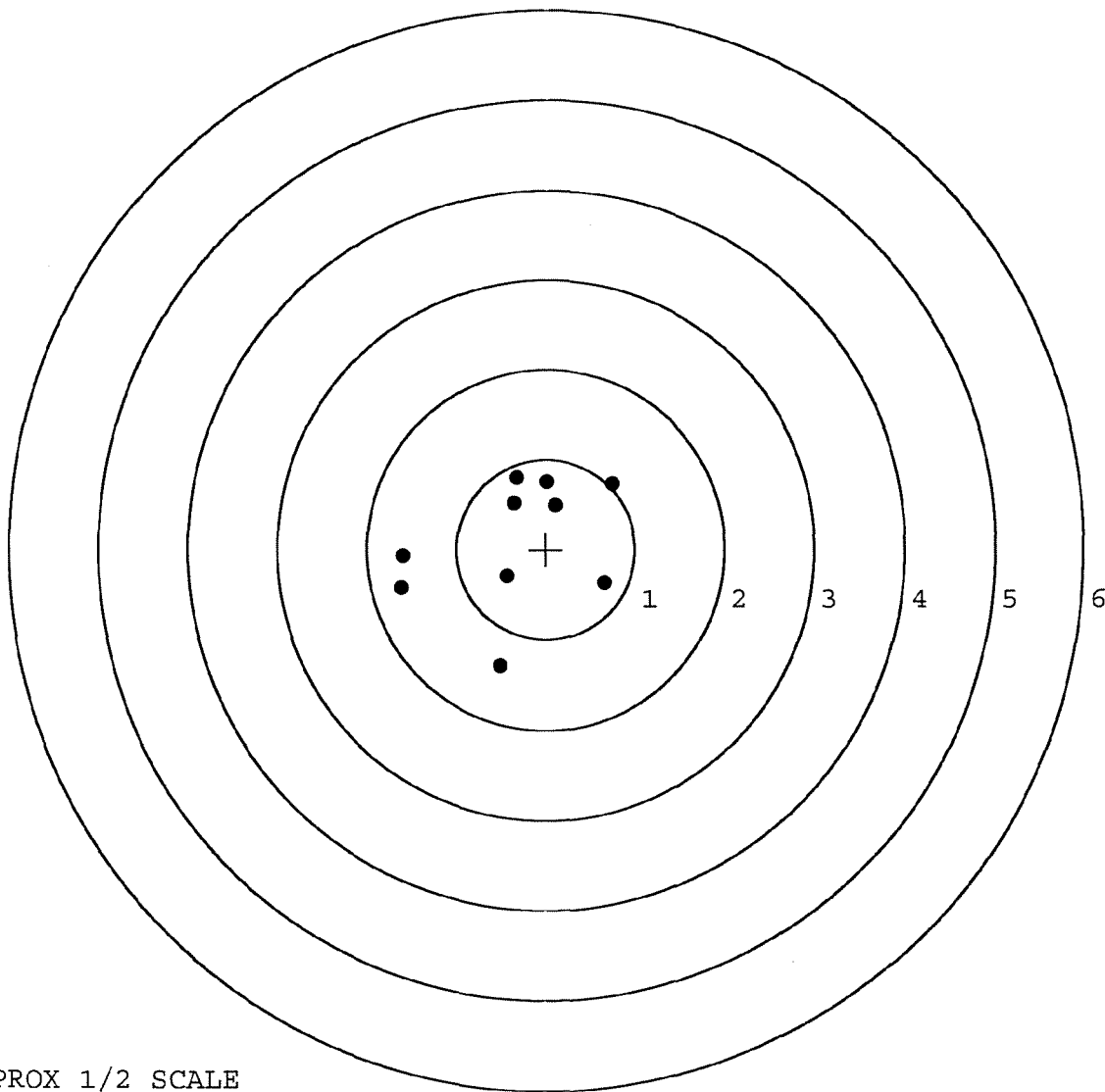
MAX RADIUS: 1.390

MEAN RADIUS: 0.929

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591603. __0

TARGET NUMBER: 4

FILE DATE: 09/28/2006

FILE TIME: 23:54

X CENTROID: -0.260

Y CENTROID: -0.010

POA TO CENTROID: 0.261

HORZ SPREAD: 1.791

VERT SPREAD: 1.549

GROUP SPREAD: 2.040

MIN RADIUS: 0.040

MAX RADIUS: 1.241

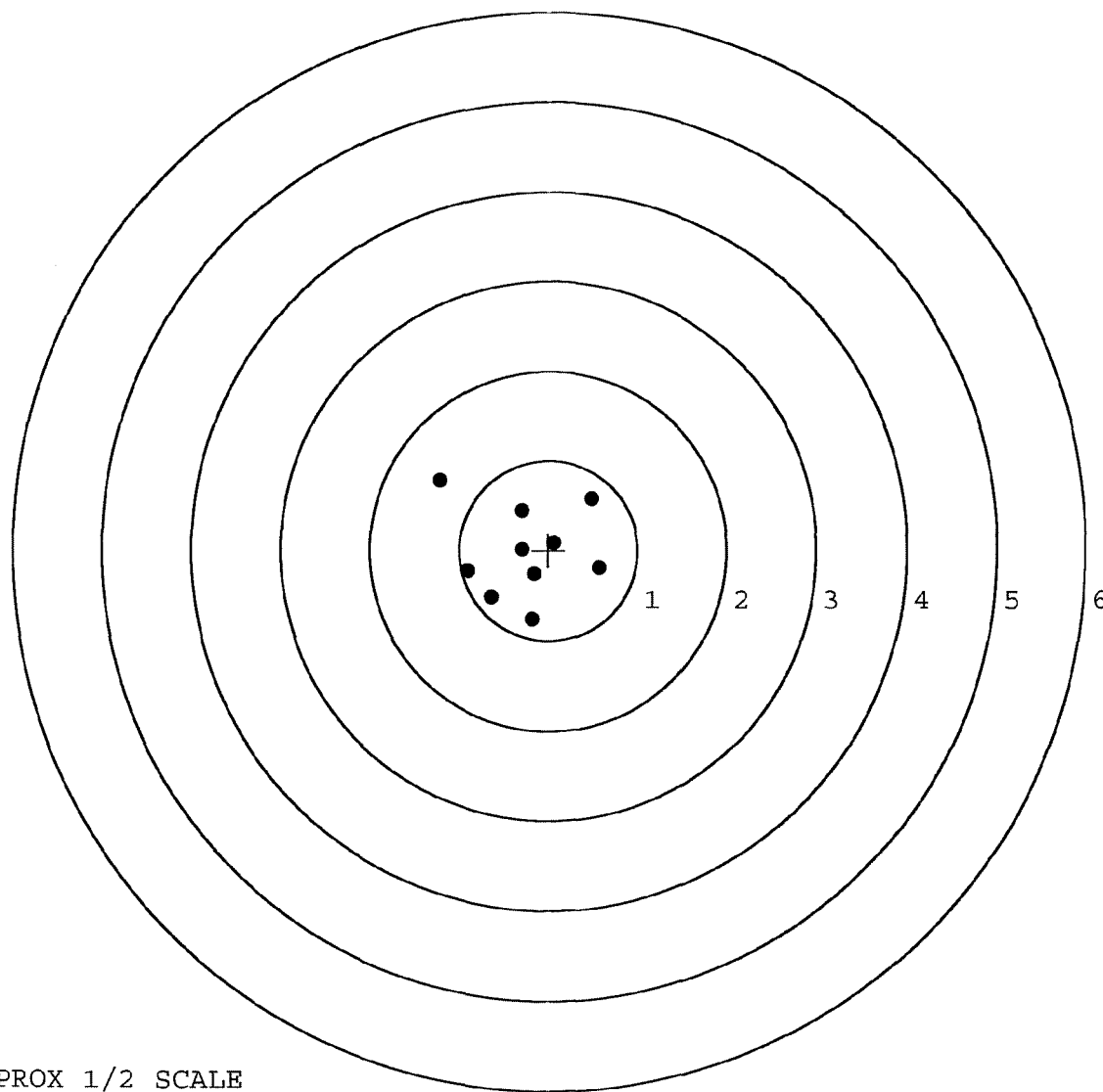
MEAN RADIUS: 0.623

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.192	-0.769
2:	-0.645	-0.521
3:	-0.906	-0.233
4:	0.573	-0.197
5:	-0.163	-0.267
6:	-0.295	0.011
7:	-0.303	0.441
8:	0.482	0.574
9:	-1.218	0.780
10:	0.063	0.086



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591603. 0

TARGET NUMBER: 5

FILE DATE: 09/28/2006

FILE TIME: 23:54

X CENTROID: -0.173

Y CENTROID: -0.058

POA TO CENTROID: 0.183

HORZ SPREAD: 2.082

VERT SPREAD: 2.626

GROUP SPREAD: 2.716

MIN RADIUS: 0.420

MAX RADIUS: 1.840

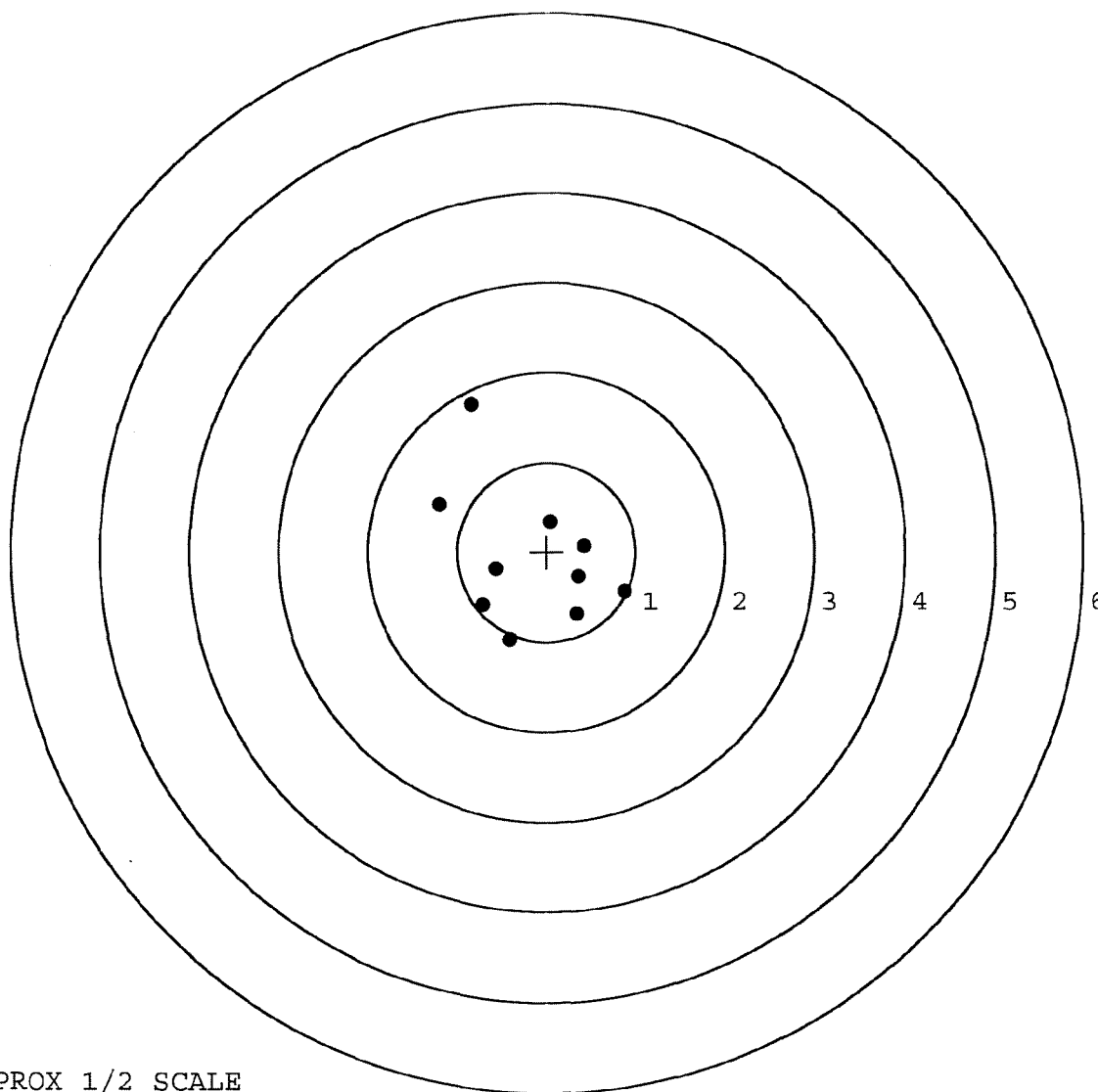
MEAN RADIUS: 0.872

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.853	1.652
2:	-1.205	0.527
3:	-0.720	-0.589
4:	-0.571	-0.193
5:	0.037	0.339
6:	0.422	0.069
7:	0.877	-0.442
8:	0.359	-0.277
9:	0.335	-0.692
10:	-0.416	-0.974



TARGET APPROX 1/2 SCALE