

G-659 1616

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

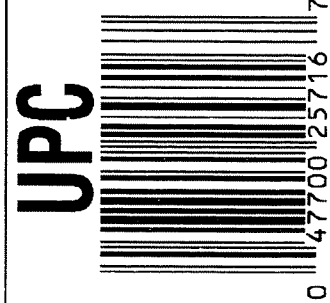


owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6591616



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



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



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6591616

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-30-06	RTZ
420	ASSEMBLE ACTION		8-30-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		8-31-06	X.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-31-06	X.P.D.
470	DIS-ASSEMBLE ACTION	SEP 05 2006	9-1-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <i>ma</i>	9/5/06	<i>ma</i>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-5-06	CW
510	DRILL AND TAP SIGHT HOLES		9-5-06	TRW
520	GOFF BLAST BBL / REC		9-6-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/13/06	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-18-06	BLC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-18-06	BLC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-18-06	BLC
	D) OIL FIRING PIN ASSEMBLY		9-18-06	BLC
	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°</u> <u>7°</u> <u>7°</u>	10-2-06	SSD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3°</u> <u>4°</u> <u>4°</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.025</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-18-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-8-06	R.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-18-06	BLG
	M) IRON SIGHT ALIGNMENT		9-18-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-18-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-19-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-19-06	BD
670	FINAL INSPECTION A) HEADSPACE		11-8-06	R.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u> <u>2.59</u> <u>2.59</u> <u>2.55</u> <u>2.60</u>	9-20-06	DA
	C) FUNCTION		11-8-06	R.P.D.
690	PACK		11/10/06	DA

F004 REV 5/2006

BARBER - M24 0168690AVERAGE 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

9-15-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	247	258		240	
PULL #2	245	258		243	
PULL #3	248	259		247	
PULL #4	245	258		248	
PULL #5	244	258		243	
TOTAL	1229	1291		1221	
AVERAGE	245	258		244	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	302	306		
PULL #2	302	299		
PULL #3	299	301		
PULL #4	303	302		
PULL #5	299	302		
TOTAL	1505	1510		
AVERAGE	301	302		

	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	402	378		401
PULL #2	400	387		406
PULL #3	397	388		407
PULL #4	401	390		409
PULL #5	400	386		407
TOTAL	2000	1929		2030
AVERAGE	400	385		406

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591616.___0
FILE DATE AND TIME: 09/20/2006 05:41

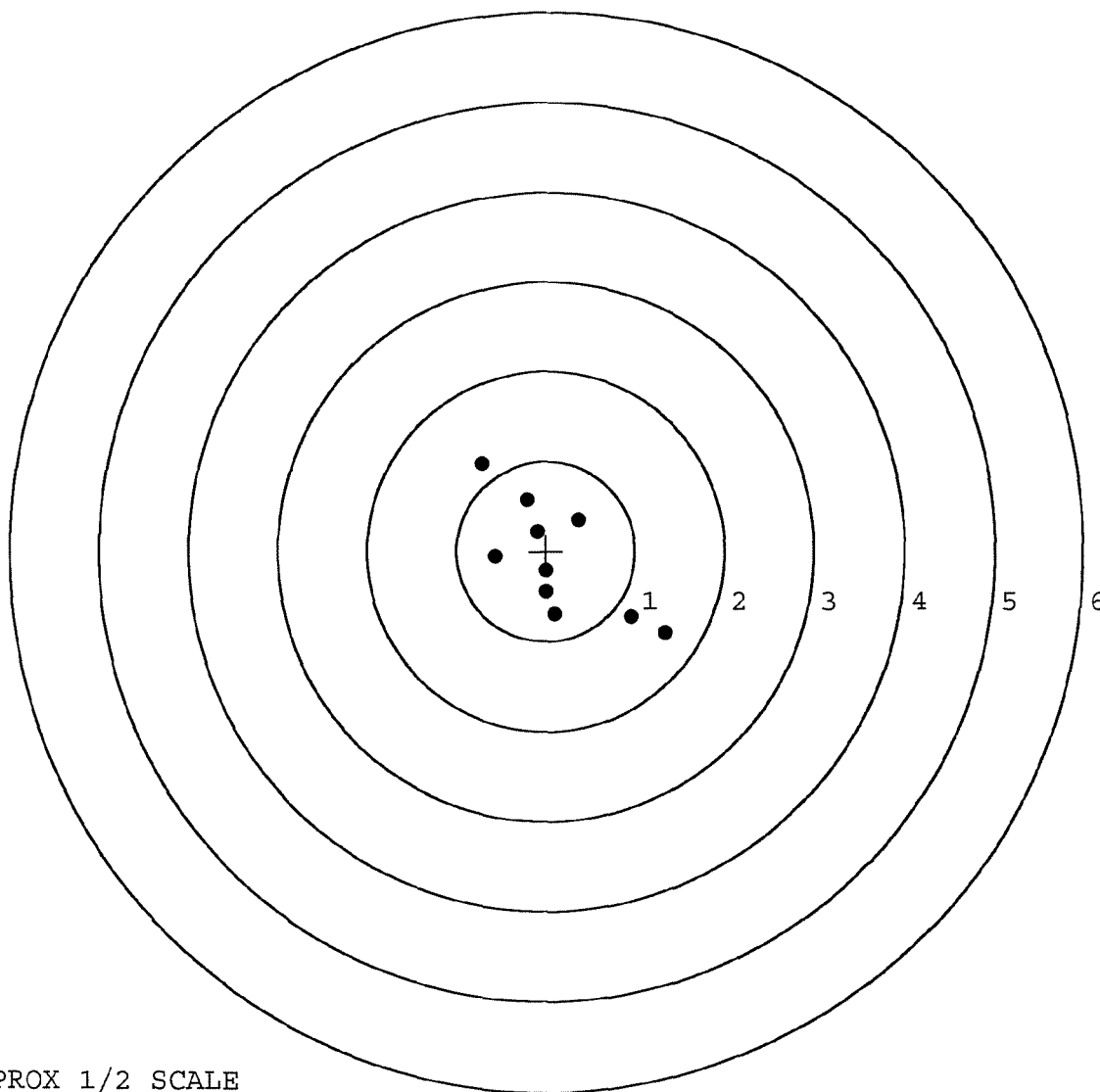
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.010
The Average Y Centroid of the Five Target Set:	-0.054
The Average Point of Impact of the Five Target Set:	0.055
The Average Mean Radius of the Five Target Set:	0.634
The Distance from POA to Centroid Target #1:	0.150
The Distance from Centroid Target #2 to Centroid Target #1:	0.342
The Distance from Centroid Target #3 to Centroid Target #1:	0.033
The Distance from Centroid Target #4 to Centroid Target #1:	0.178
The Distance from Centroid Target #5 to Centroid Target #1:	0.117

SERIAL NUMBER: G6591616. __0
 TARGET NUMBER: 1
 FILE DATE: 09/20/2006
 FILE TIME: 05:41

POINT#	X	Y
1:	-0.723	0.976
2:	-0.220	0.571
3:	-0.103	0.216
4:	0.360	0.347
5:	-0.569	-0.062
6:	-0.003	-0.215
7:	0.000	-0.452
8:	0.105	-0.703
9:	0.965	-0.729
10:	1.346	-0.907

X CENTROID: 0.116
 Y CENTROID: -0.096
 POA TO CENTROID: 0.150
 HORZ SPREAD: 2.069
 VERT SPREAD: 1.883
 GROUP SPREAD: 2.798
 MIN RADIUS: 0.168
 MAX RADIUS: 1.474
 MEAN RADIUS: 0.736
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591616. 0

TARGET NUMBER: 2

FILE DATE: 09/20/2006

FILE TIME: 05:41

X CENTROID: -0.227

Y CENTROID: -0.093

POA TO CENTROID: 0.245

HORZ SPREAD: 1.710

VERT SPREAD: 1.251

GROUP SPREAD: 1.752

MIN RADIUS: 0.306

MAX RADIUS: 1.282

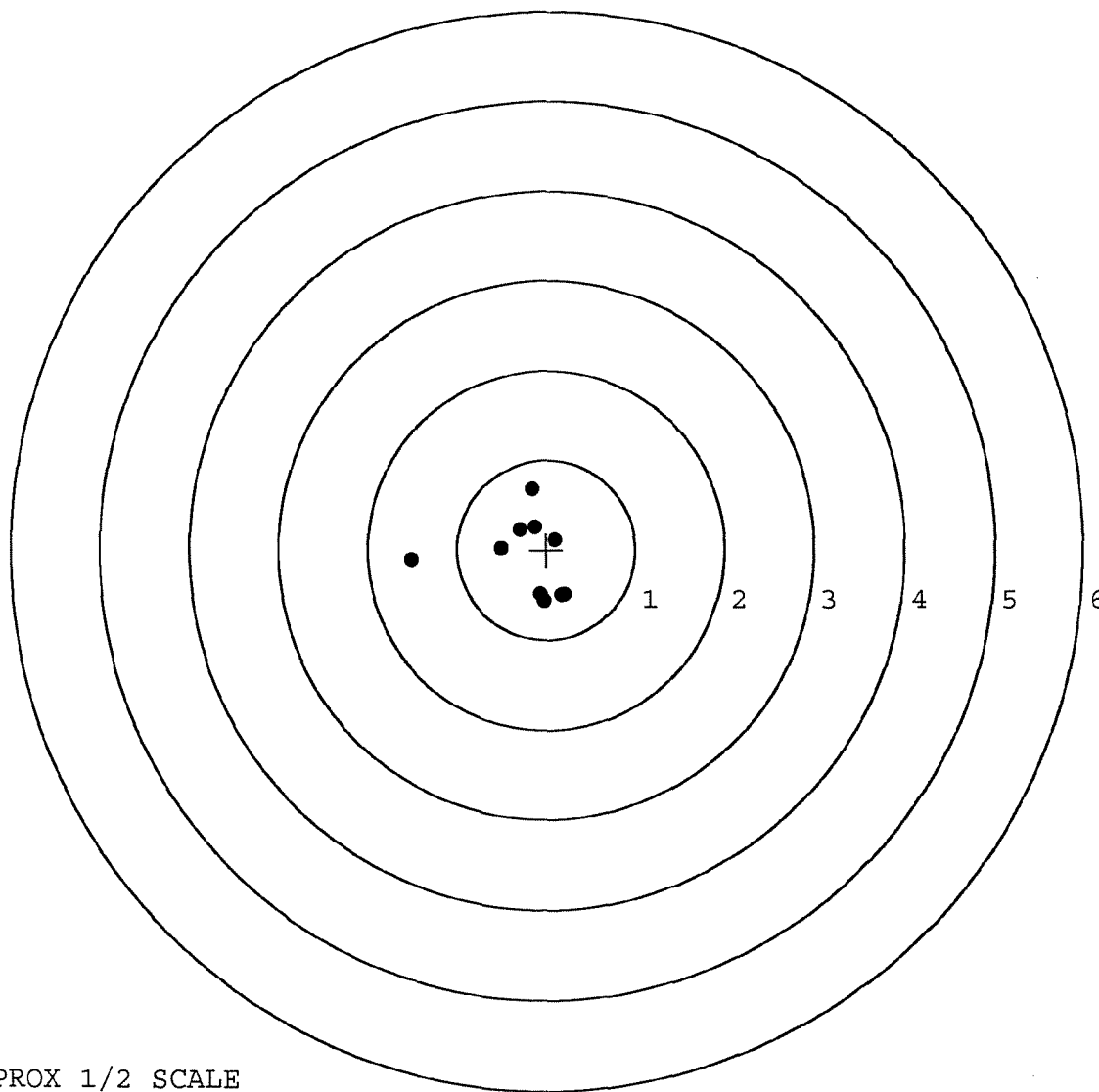
MEAN RADIUS: 0.555

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.508	-0.124
2:	-0.164	0.677
3:	0.202	-0.506
4:	-0.030	-0.574
5:	-0.512	0.018
6:	-0.305	0.225
7:	-0.135	0.251
8:	0.095	0.112
9:	0.170	-0.509
10:	-0.079	-0.500



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591616. 0

TARGET NUMBER: 3

FILE DATE: 09/20/2006

FILE TIME: 05:41

X CENTROID: 0.144

Y CENTROID: -0.079

POA TO CENTROID: 0.164

HORZ SPREAD: 1.217

VERT SPREAD: 2.570

GROUP SPREAD: 2.654

MIN RADIUS: 0.268

MAX RADIUS: 1.462

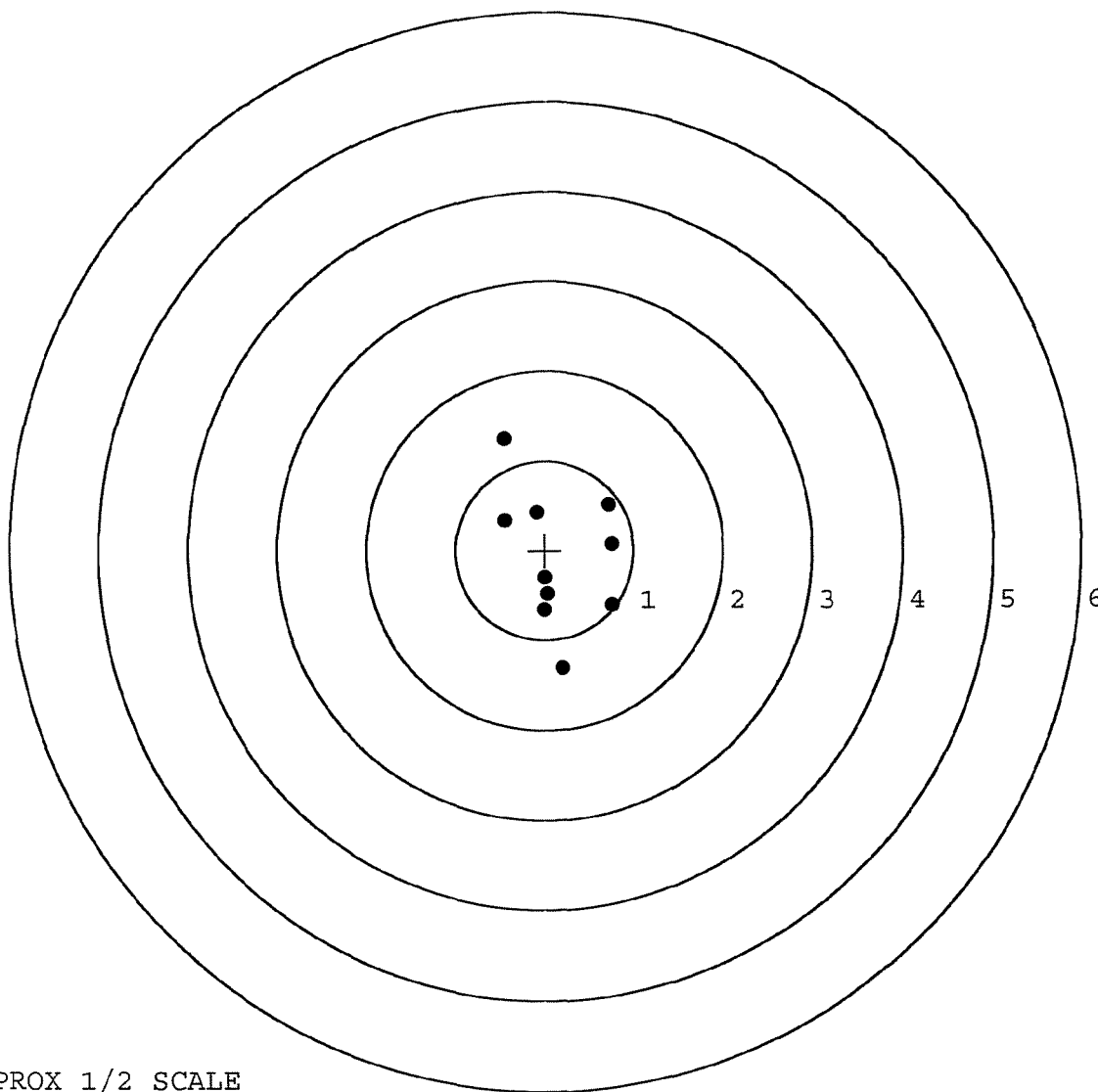
MEAN RADIUS: 0.757

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.458	1.253
2:	-0.459	0.337
3:	-0.095	0.426
4:	0.715	0.515
5:	0.754	0.075
6:	0.758	-0.611
7:	0.004	-0.308
8:	0.031	-0.491
9:	-0.013	-0.672
10:	0.204	-1.317



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591616. __0

TARGET NUMBER: 4

FILE DATE: 09/20/2006

FILE TIME: 05:41

X CENTROID: -0.037

Y CENTROID: -0.003

POA TO CENTROID: 0.037

HORZ SPREAD: 1.553

VERT SPREAD: 0.591

GROUP SPREAD: 1.562

MIN RADIUS: 0.097

MAX RADIUS: 0.970

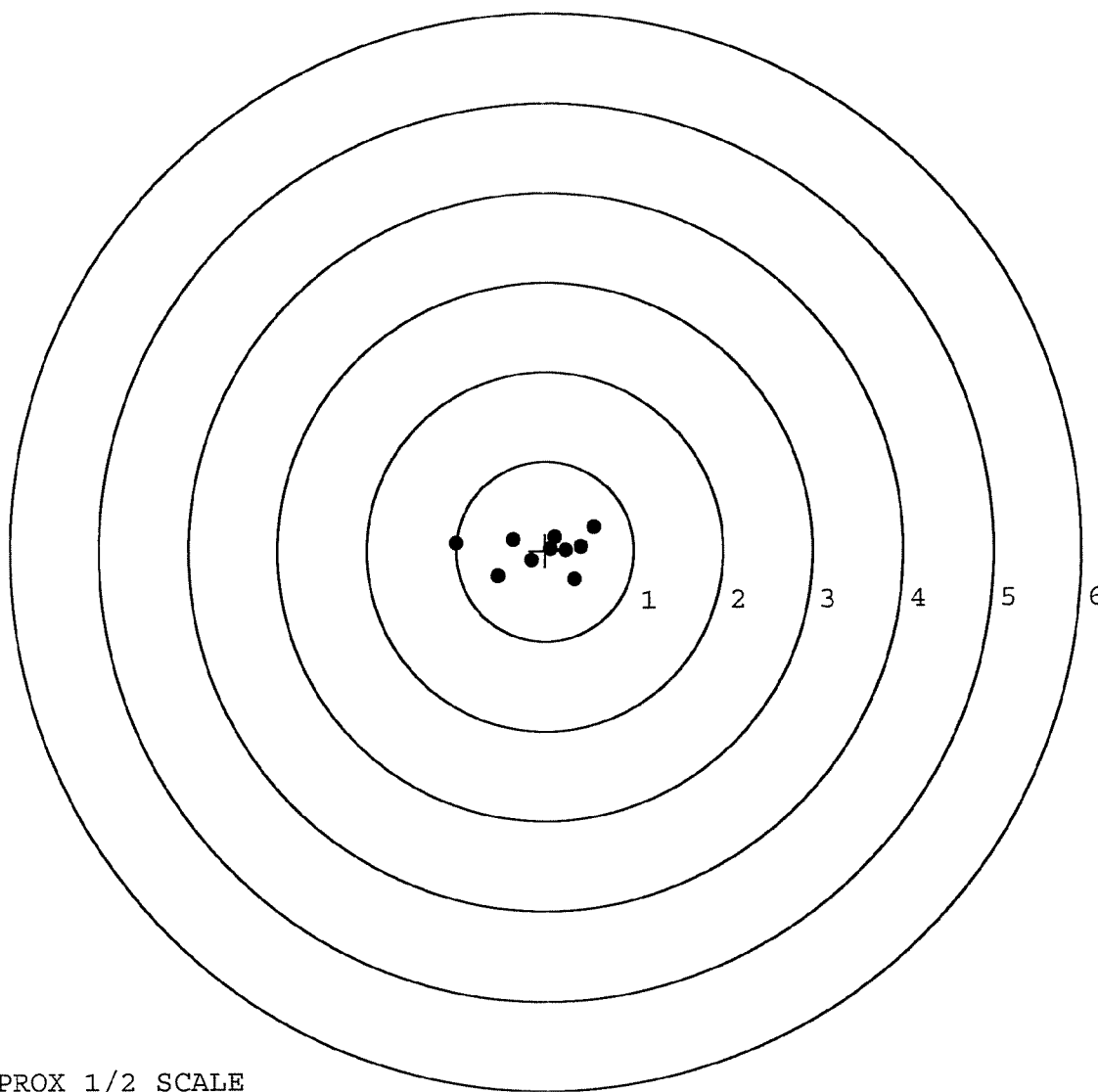
MEAN RADIUS: 0.420

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.002	0.093
2:	-0.534	-0.283
3:	-0.363	0.121
4:	-0.156	-0.107
5:	0.330	-0.326
6:	0.551	0.265
7:	0.112	0.150
8:	0.403	0.042
9:	0.233	-0.004
10:	0.058	0.017



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591616. __0

TARGET NUMBER: 5

FILE DATE: 09/20/2006

FILE TIME: 05:41

X CENTROID: 0.053

Y CENTROID: 0.003

POA TO CENTROID: 0.053

HORZ SPREAD: 1.930

VERT SPREAD: 1.538

GROUP SPREAD: 1.982

MIN RADIUS: 0.245

MAX RADIUS: 1.115

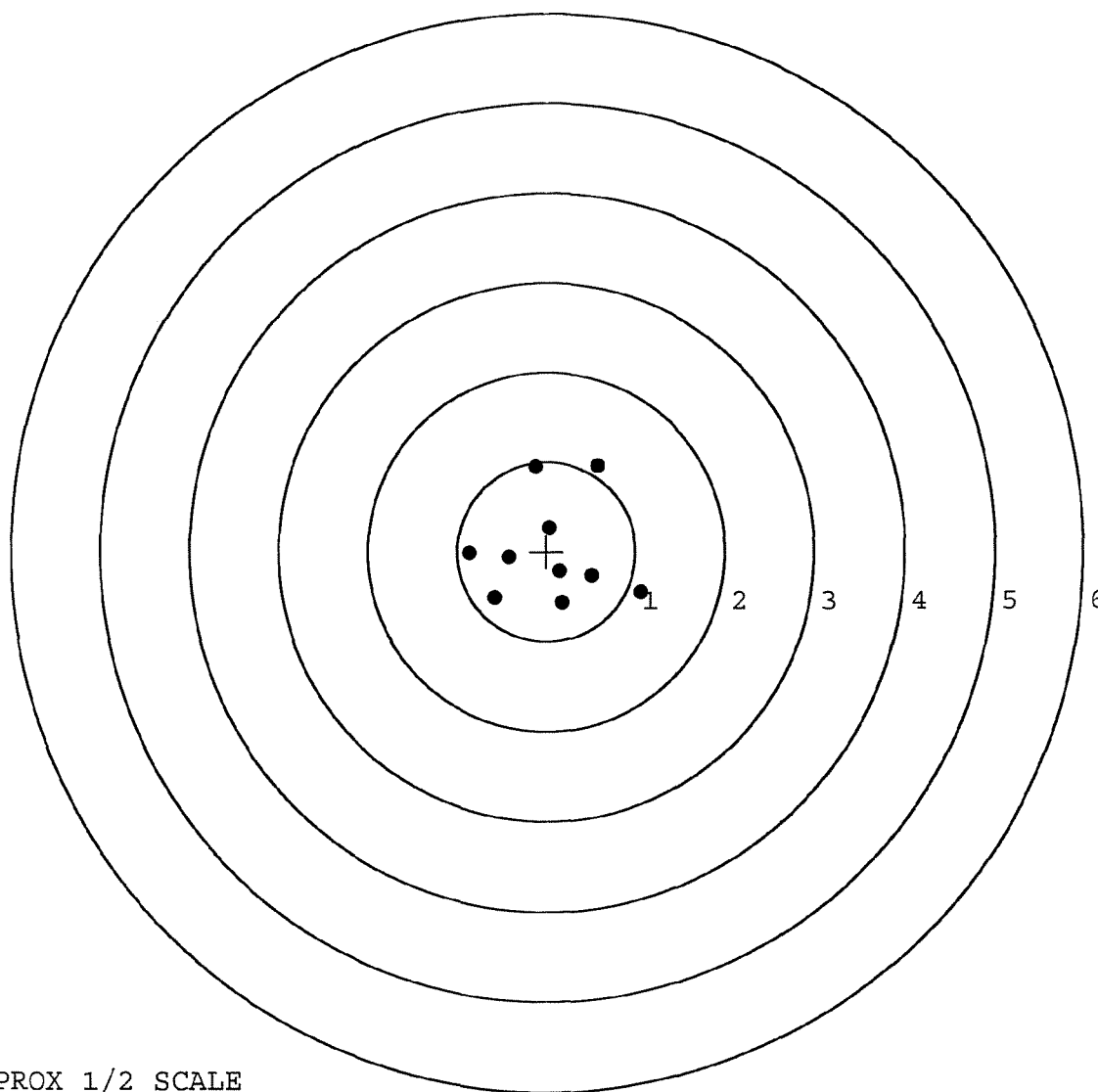
MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.578	0.958
2:	-0.122	0.942
3:	0.038	0.263
4:	-0.422	-0.064
5:	-0.865	-0.015
6:	-0.583	-0.519
7:	0.149	-0.222
8:	0.176	-0.580
9:	0.512	-0.270
10:	1.065	-0.464



TARGET APPROX 1/2 SCALE