

G669 5389

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

G6695389



GUN SERIAL # 66695389

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		3-5-08	RTZ
420	ASSEMBLE ACTION		3-5-08	J.P.D.
430	ASSEMBLE TO STOCK		3-5-08	TRW
440	PROOF	MAGNA - FLUX	3-5-08	TRW
460	CHECK HEADSPACE	PAR 07 2000	3-5-08	TRW
470	DIS-ASSEMBLE ACTION	OPERATOR <u>unus</u>	3-6-08	J.P.D.
480	MAGNAFLUX BBL ACTION		3/7/08	B.W.G.
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	J.P.D.
	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>7%</u> <u>7%</u> <u>6%</u>	3-25-08	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4%</u> <u>4%</u> <u>4%</u>	3-25-08	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.022</u> <u>.023</u>	3-25-08	SD
	J) ASSEMBLE STOCK		3-18-08	J.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-2-08	Fm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-8-08	J.P.D.
	M) IRON SIGHT ALIGNMENT		4-8-08	J.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-8-08	J.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	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u> <u>2.47</u> <u>2.53</u> <u>2.47</u> <u>2.56</u>	3-25-08	SD
	C) FUNCTION			
690	PACK		4/9/08	Fm

F004 REV 5/2006

BARBER - M24 0180240
**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	2.46	2.60		2.47	
PULL #2	2.67	2.51		2.51	
PULL #3	2.64	2.52		2.40	
PULL #4	2.63	2.62		2.40	
PULL #5	2.46	2.55		2.41	
TOTAL	12.86	12.80		12.19	
AVERAGE	2.57	2.56		2.43	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.03		
PULL #2	3.16	3.04		
PULL #3	3.03	3.15		
PULL #4	3.12	3.12		
PULL #5	3.09	3.12		
TOTAL	15.50	15.46		
AVERAGE	3.10	3.09		

	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	4.16	4.14		4.37
PULL #2	4.18	4.11		4.38
PULL #3	4.08	4.18		4.34
PULL #4	4.10	4.11		4.32
PULL #5	4.14	4.12		4.36
TOTAL	20.66	20.66		21.77
AVERAGE	4.13	4.13		4.35

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695389.__0

FILE DATE AND TIME: 03/25/2008 07:05

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

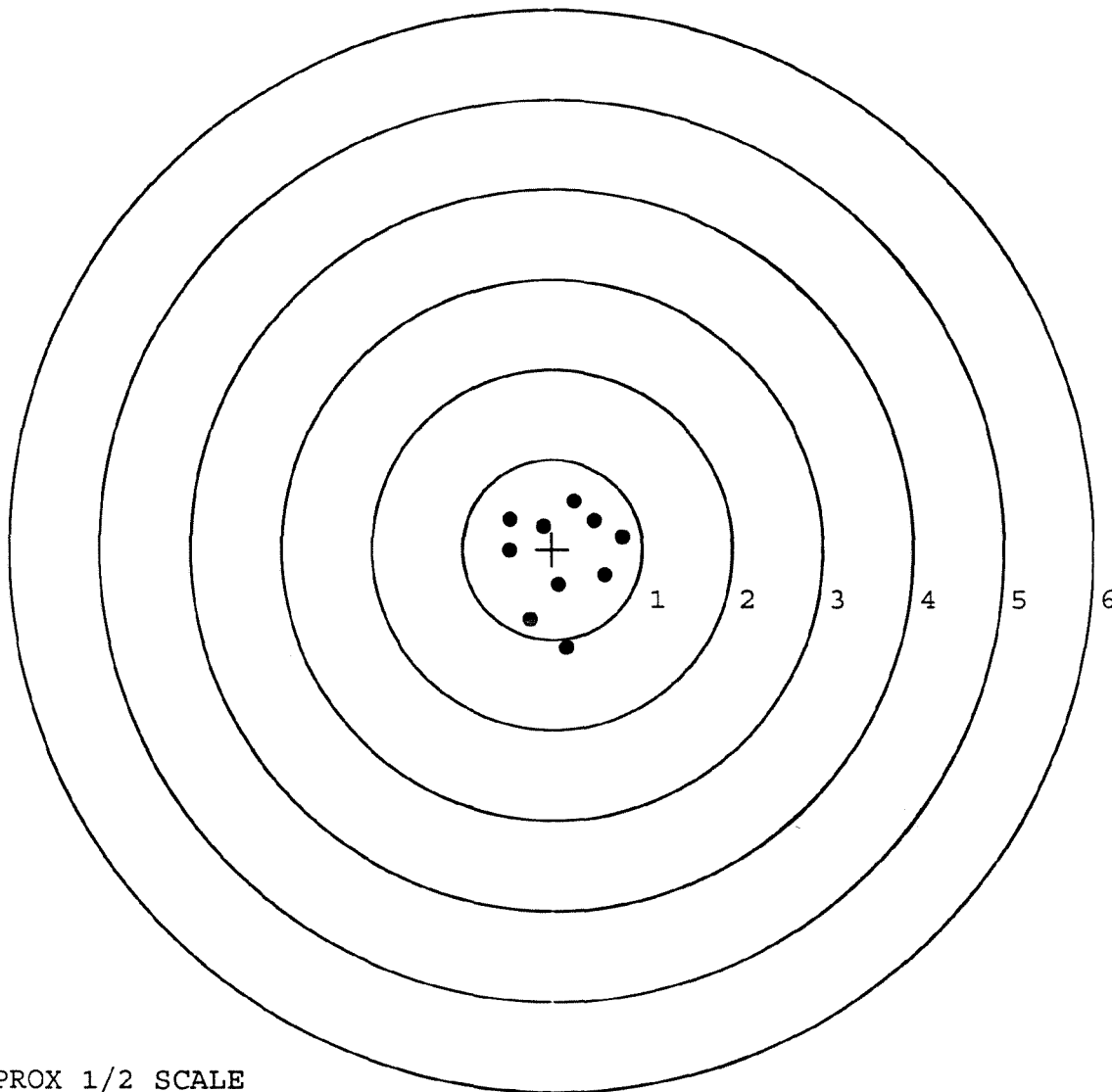
The Average X Centroid of the Five Target Set:	0.000
The Average Y Centroid of the Five Target Set:	-0.044
The Average Point of Impact of the Five Target Set:	0.044
The Average Mean Radius of the Five Target Set:	0.780
The Distance from POA to Centroid Target #1:	0.141
The Distance from Centroid Target #2 to Centroid Target #1:	0.206
The Distance from Centroid Target #3 to Centroid Target #1:	0.279
The Distance from Centroid Target #4 to Centroid Target #1:	0.087
The Distance from Centroid Target #5 to Centroid Target #1:	0.124

BARBER - M24 0180242

SERIAL NUMBER: G6695389. __0
 TARGET NUMBER: 1
 FILE DATE: 03/25/2008
 FILE TIME: 07:05

POINT#	X	Y
1:	0.154	-1.095
2:	-0.251	-0.784
3:	0.068	-0.394
4:	0.581	-0.286
5:	0.779	0.138
6:	0.465	0.320
7:	0.245	0.529
8:	-0.103	0.248
9:	-0.476	0.330
10:	-0.477	-0.014

X CENTROID: 0.099
 Y CENTROID: -0.101
 POA TO CENTROID: 0.141
 HORZ SPREAD: 1.256
 VERT SPREAD: 1.624
 GROUP SPREAD: 1.627
 MIN RADIUS: 0.295
 MAX RADIUS: 0.996
 MEAN RADIUS: 0.620
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0180243

SERIAL NUMBER: G6695389. __0

TARGET NUMBER: 2

FILE DATE: 03/25/2008

FILE TIME: 07:05

POINT#	X	Y
1:	0.635	0.751
2:	0.271	0.914
3:	-0.112	0.397
4:	-0.137	0.256
5:	0.586	-0.259
6:	0.057	-0.418
7:	0.157	-0.833
8:	-0.236	-1.215
9:	-0.582	-0.529
10:	-1.711	0.097

X CENTROID: -0.107

Y CENTROID: -0.084

POA TO CENTROID: 0.136

HORZ SPREAD: 2.346

VERT SPREAD: 2.129

GROUP SPREAD: 2.435

MIN RADIUS: 0.341

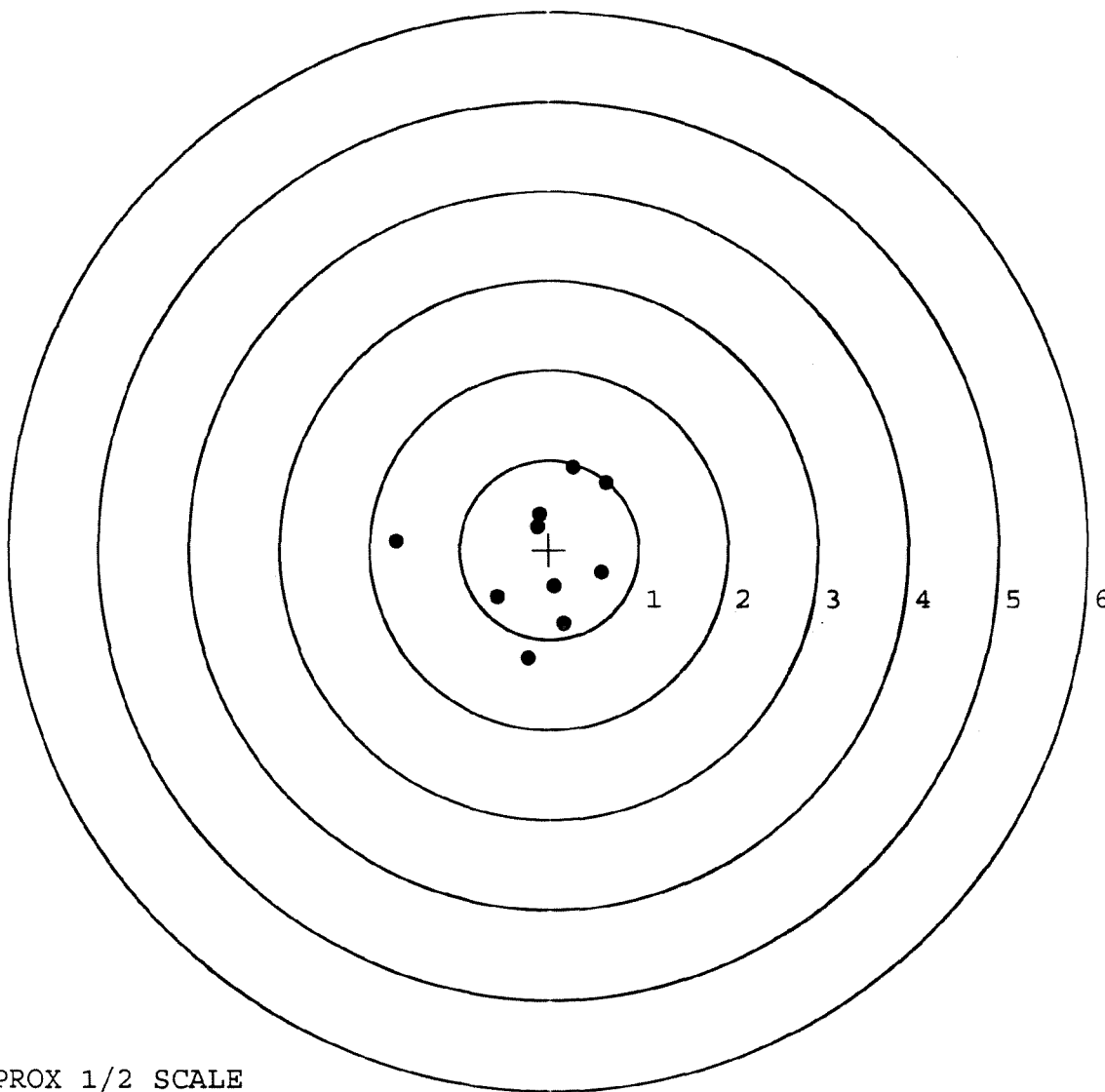
MAX RADIUS: 1.614

MEAN RADIUS: 0.829

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0180244

SERIAL NUMBER: G6695389. 0

TARGET NUMBER: 3

FILE DATE: 03/25/2008

FILE TIME: 07:05

POINT#	X	Y
1:	0.165	-1.194
2:	0.152	-0.786
3:	-0.776	-0.048
4:	-1.315	0.436
5:	0.185	1.608
6:	0.691	0.347
7:	0.527	0.349
8:	0.137	0.491
9:	0.118	0.309
10:	0.063	0.073

X CENTROID: -0.005

Y CENTROID: 0.158

POA TO CENTROID: 0.159

HORZ SPREAD: 2.006

VERT SPREAD: 2.802

GROUP SPREAD: 2.802

MIN RADIUS: 0.109

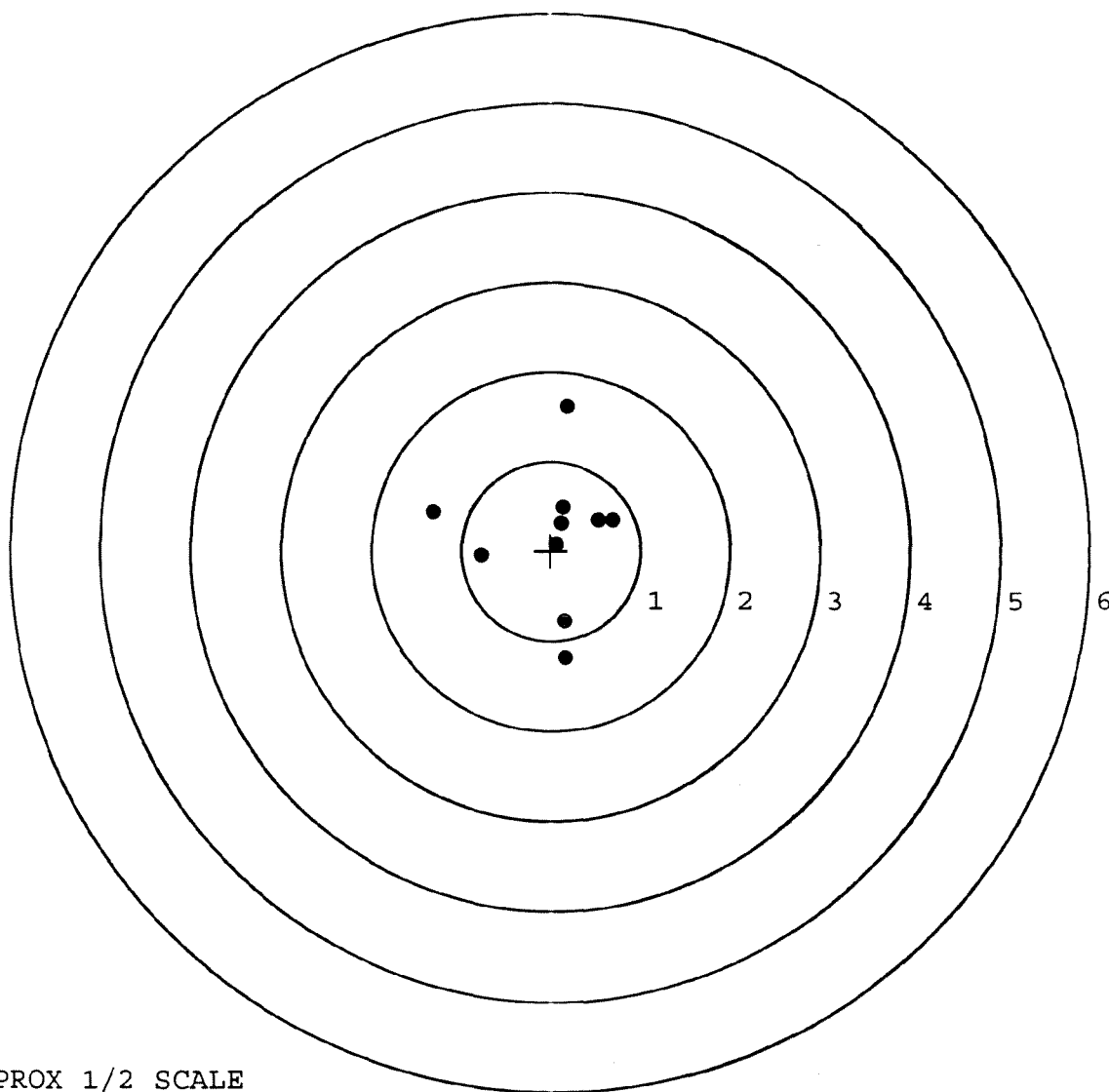
MAX RADIUS: 1.462

MEAN RADIUS: 0.787

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0180245

SERIAL NUMBER: G6695389. 0

TARGET NUMBER: 4

FILE DATE: 03/25/2008

FILE TIME: 07:05

POINT#	X	Y
1:	0.541	0.982
2:	-1.572	0.180
3:	-0.746	-0.887
4:	-0.351	-0.426
5:	0.936	-0.966
6:	0.698	-0.646
7:	0.531	-0.138
8:	0.365	0.122
9:	0.133	0.186
10:	-0.262	0.092

X CENTROID: 0.027

Y CENTROID: -0.150

POA TO CENTROID: 0.153

HORZ SPREAD: 2.508

VERT SPREAD: 1.948

GROUP SPREAD: 2.757

MIN RADIUS: 0.352

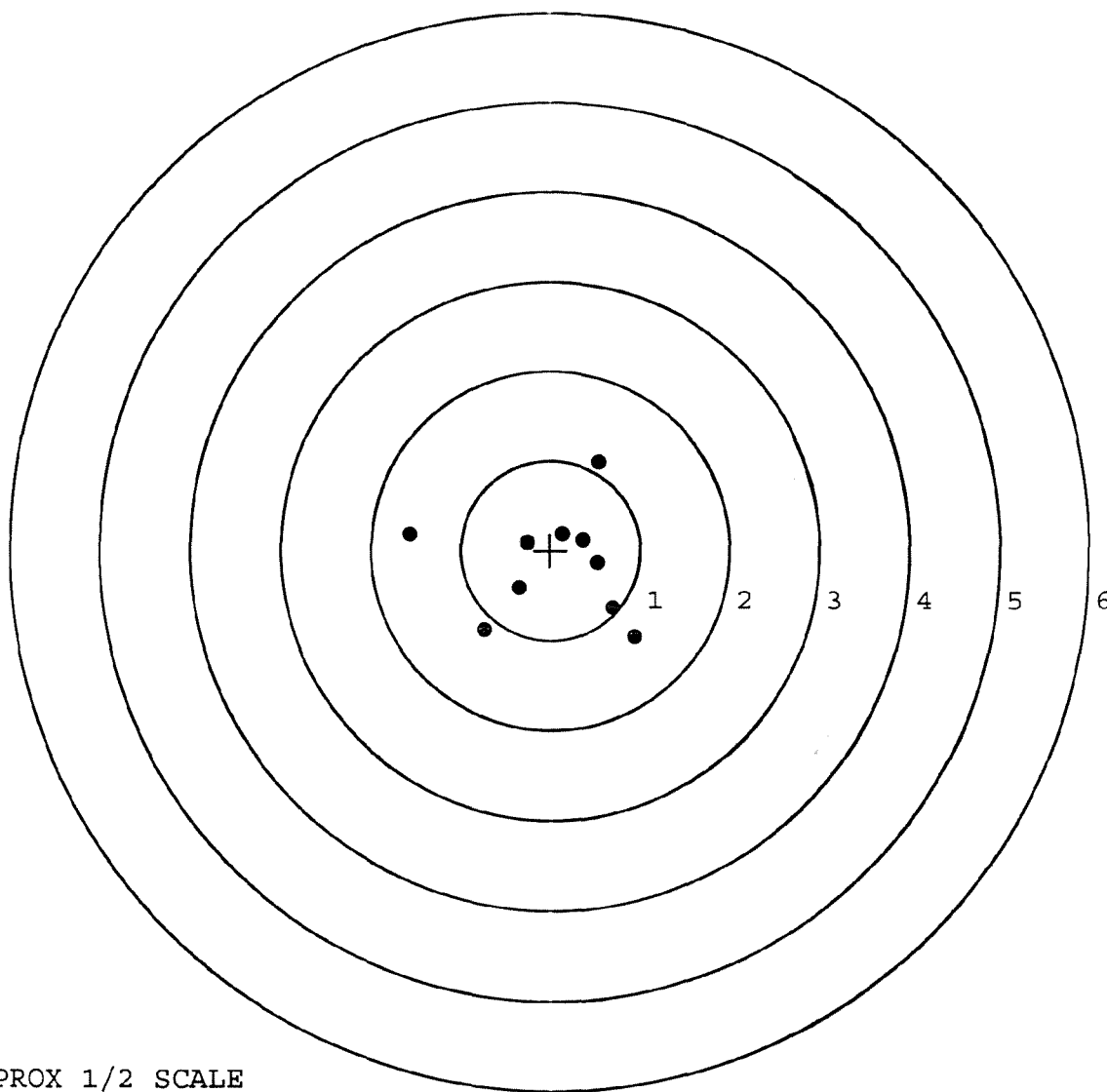
MAX RADIUS: 1.633

MEAN RADIUS: 0.814

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

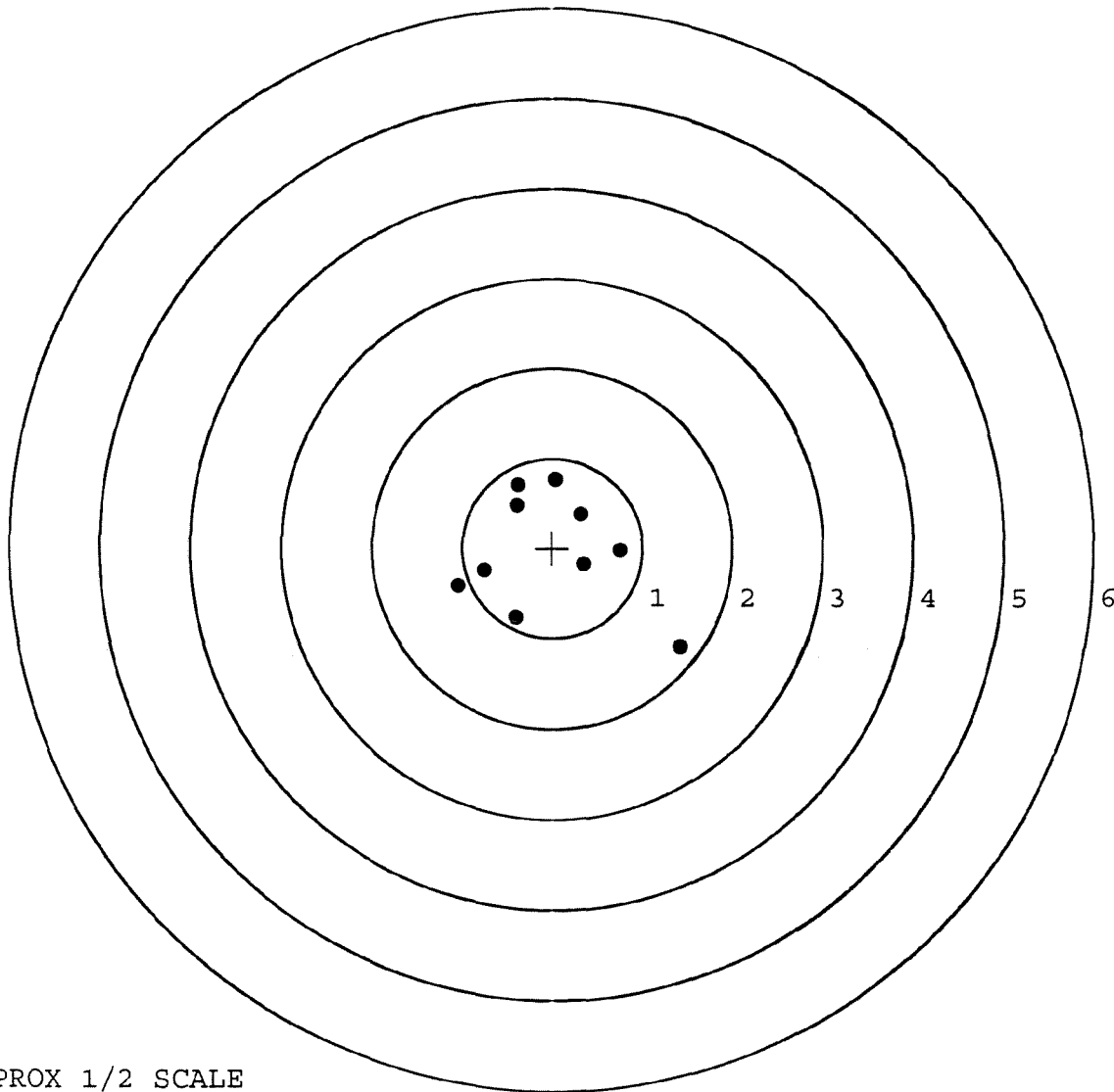


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695389. __0
 TARGET NUMBER: 5
 FILE DATE: 03/25/2008
 FILE TIME: 07:05

POINT#	X	Y
1:	1.425	-1.101
2:	-0.412	-0.779
3:	-0.757	-0.249
4:	-1.051	-0.429
5:	0.348	-0.184
6:	0.756	-0.021
7:	0.320	0.377
8:	0.036	0.762
9:	-0.397	0.479
10:	-0.386	0.701

X CENTROID: -0.012
 Y CENTROID: -0.044
 POA TO CENTROID: 0.046
 HORZ SPREAD: 2.476
 VERT SPREAD: 1.863
 GROUP SPREAD: 2.566
 MIN RADIUS: 0.386
 MAX RADIUS: 1.783
 MEAN RADIUS: 0.848
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE