

G657 7239

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



G6577239

owner registration sticker



G6577239

ORDER NO.

25716

BARREL LENGTH

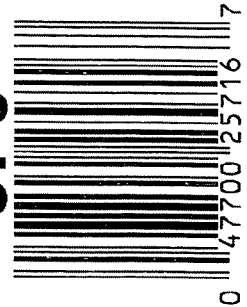
24"

CAPACITY

6

G6577239

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.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6577239

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/31/06	BLG
420	ASSEMBLE ACTION		7-10-06	RTZ
430	ASSEMBLE TO STOCK		7-10-06	RTZ
440	PROOF		7-11-06	TRW
460	CHECK HEADSPACE	MAGNA FLUX INSPECTED	7-11-06	TRW
470	DIS-ASSEMBLE ACTION	JUL 13 2006	7-11-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	7-13-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		7-12-06	CW
510	DRILL AND TAP SIGHT HOLES		7-12-06	TRW
520	GOFF BLAST BBL / REC		7-13-06	UB
530 & 540	APPLY COATINGS (BARREL ACTION)		7/14	LP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-24-06	AC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-24-06	AC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-24-06	AC
	D) OIL FIRING PIN ASSEMBLY		7-25-06	AC
	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>65</u> <u>60</u> <u>60</u>	8-21-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>2.5</u> <u>2.5</u>	8-21-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.025</u>	8-21-06	RA
	J) ASSEMBLE STOCK		7-25-06	AC
	K) ASSEMBLE SWIVEL STUDS		8-31-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-25-06	AC
	M) IRON SIGHT ALIGNMENT		7-25-06	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-25-06	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	7-27-06	MM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-27-06	TRW
670	FINAL INSPECTION A) HEADSPACE		8-31-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>249</u> <u>249</u> <u>238</u> <u>262</u> <u>254</u>	8/22/06	RP
	C) FUNCTION		8-31-06	RTZ
690	PACK		11/15/06	RA

F004 REV 5/2006

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 4-12-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.63	2.43		2.66	
PULL #2	2.59	2.55		2.64	
PULL #3	2.54	2.49		2.49	
PULL #4	2.58	2.53		2.57	
PULL #5	2.58	2.53		2.49	
TOTAL	12.92	12.53		12.85	
AVERAGE	2.58	2.50		2.57 2.57	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.00		
PULL #2	3.19	2.88		
PULL #3	3.02	2.88		
PULL #4	3.22	2.91		
PULL #5	3.16	2.97		
TOTAL	15.74	14.64		
AVERAGE	3.14	2.92		

	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		4.00
PULL #2	4.06	4.15		4.04
PULL #3	4.02	4.11		4.01
PULL #4	4.15	4.04		4.02
PULL #5	4.07	4.10		4.04
TOTAL	20.46	20.54		20.11
AVERAGE	4.09	4.10		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6577239.___0
FILE DATE AND TIME: 07/27/2006 07:55

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.075
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.102
The Average Mean Radius of the Five Target Set:	0.833
The Distance from POA to Centroid Target #1:	0.288
The Distance from Centroid Target #2 to Centroid Target #1:	0.665
The Distance from Centroid Target #3 to Centroid Target #1:	0.097
The Distance from Centroid Target #4 to Centroid Target #1:	0.282
The Distance from Centroid Target #5 to Centroid Target #1:	0.205

SERIAL NUMBER: G6577239. 0

TARGET NUMBER: 1

FILE DATE: 07/27/2006

FILE TIME: 07:55

X CENTROID: -0.271

Y CENTROID: -0.095

POA TO CENTROID: 0.288

HORZ SPREAD: 2.228

VERT SPREAD: 2.242

GROUP SPREAD: 2.599

MIN RADIUS: 0.110

MAX RADIUS: 1.737

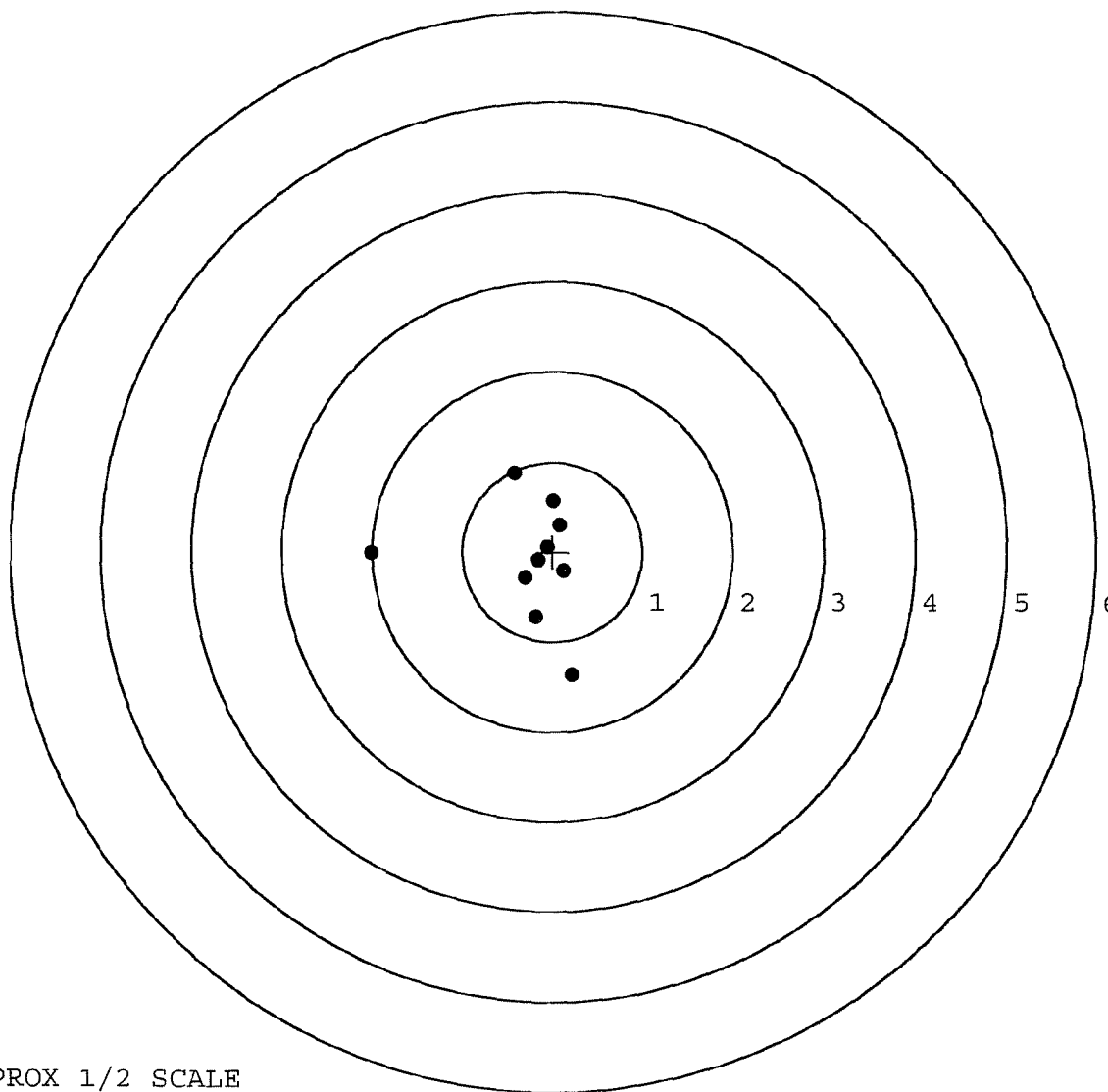
MEAN RADIUS: 0.695

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-2.007	-0.030
2:	-0.430	0.874
3:	0.010	0.568
4:	0.074	0.294
5:	-0.064	0.050
6:	0.131	-0.217
7:	-0.161	-0.099
8:	-0.303	-0.297
9:	-0.185	-0.729
10:	0.221	-1.368



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577239. 0

TARGET NUMBER: 2

FILE DATE: 07/27/2006

FILE TIME: 07:55

X CENTROID: 0.341

Y CENTROID: -0.354

POA TO CENTROID: 0.491

HORZ SPREAD: 2.759

VERT SPREAD: 3.536

GROUP SPREAD: 4.119

MIN RADIUS: 0.279

MAX RADIUS: 2.885

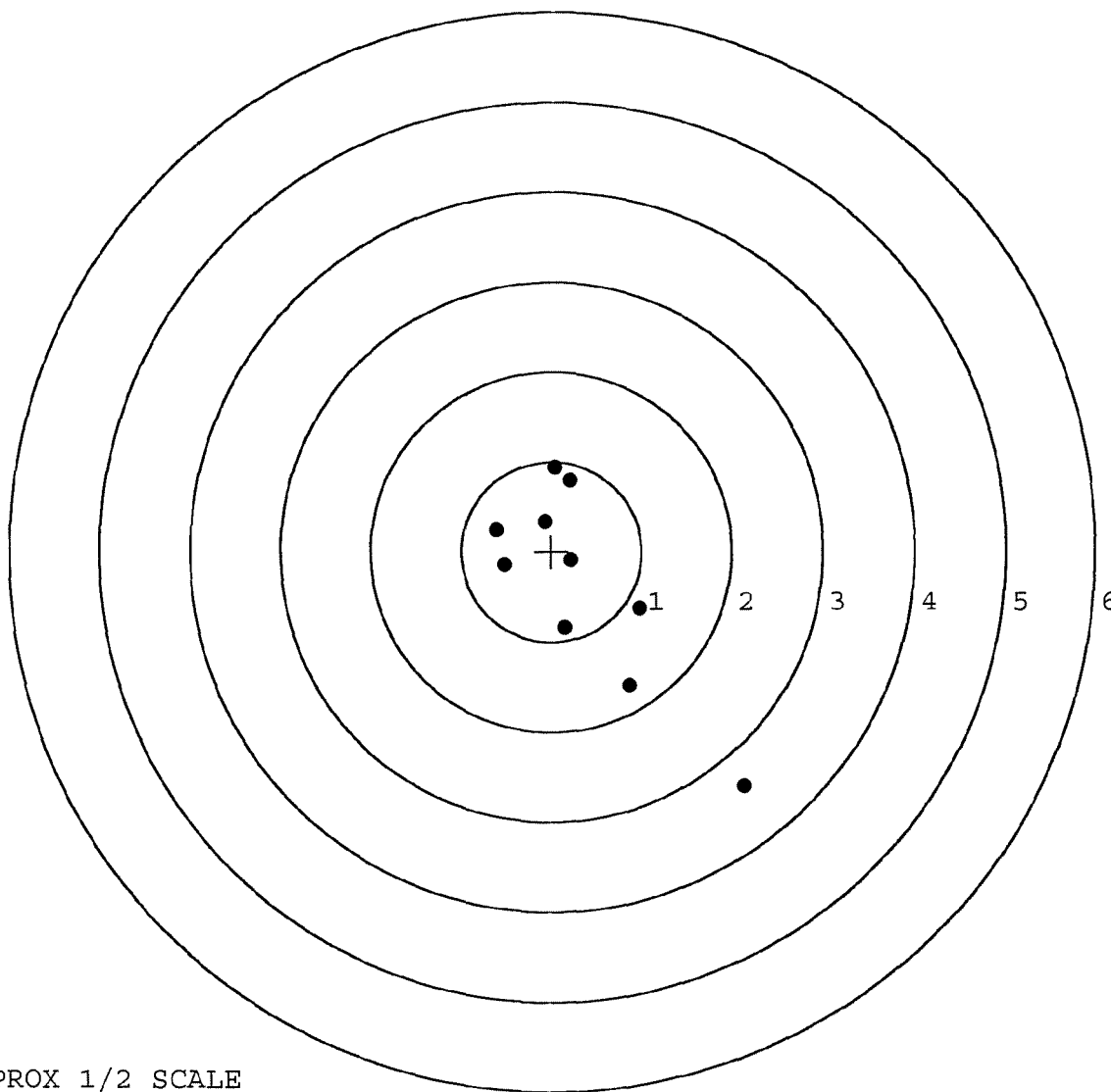
MEAN RADIUS: 1.092

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.522	-0.156
2:	-0.609	0.234
3:	-0.076	0.329
4:	0.038	0.935
5:	0.207	0.790
6:	0.220	-0.102
7:	0.150	-0.853
8:	0.984	-0.630
9:	0.867	-1.485
10:	2.150	-2.601

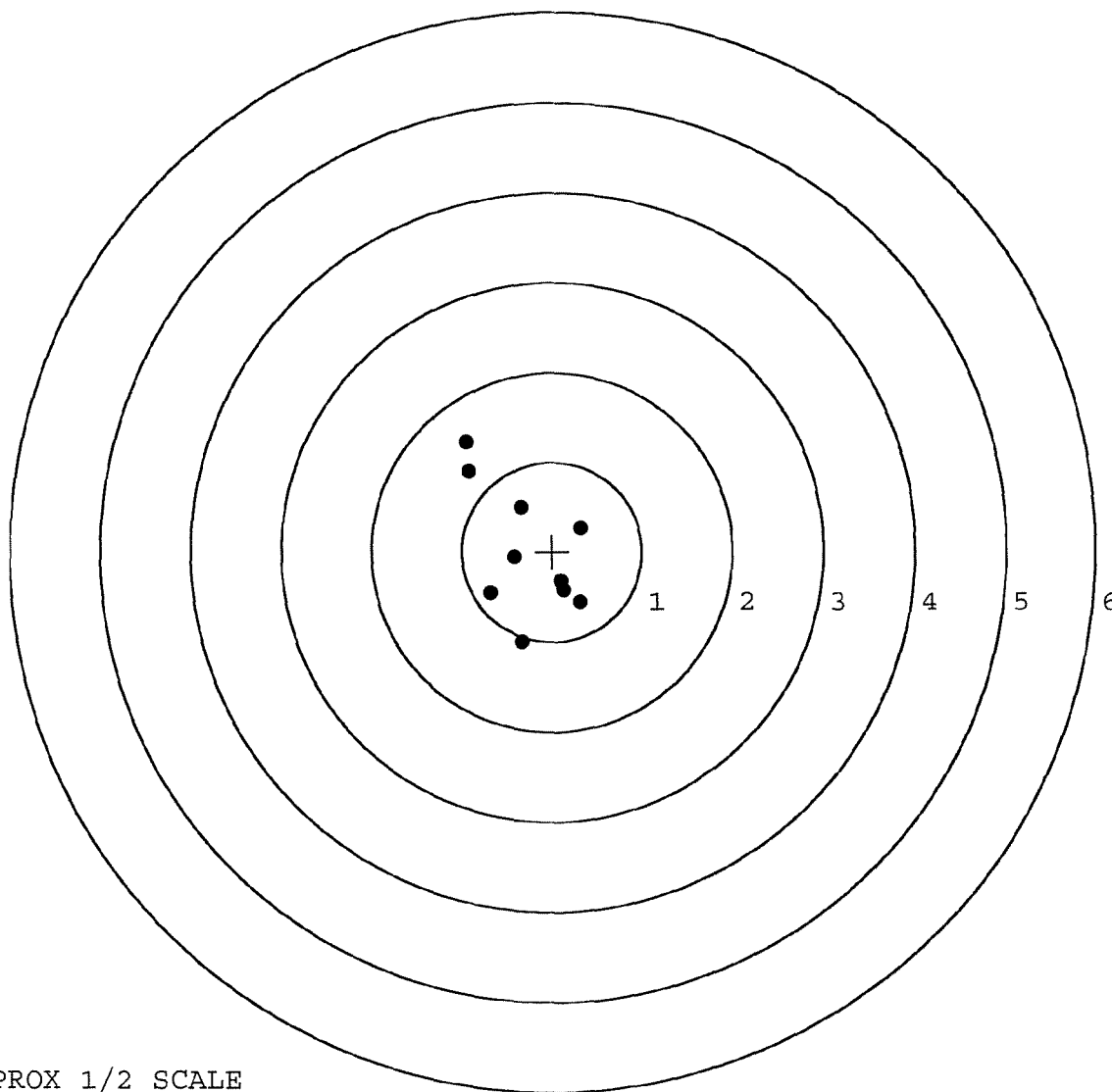


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577239. __0
TARGET NUMBER: 3
FILE DATE: 07/27/2006
FILE TIME: 07:55

X CENTROID: -0.280
Y CENTROID: 0.001
POA TO CENTROID: 0.280
HORZ SPREAD: 1.285
VERT SPREAD: 2.228
GROUP SPREAD: 2.315
MIN RADIUS: 0.159
MAX RADIUS: 1.394
MEAN RADIUS: 0.737
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.961	1.217
2:	-0.931	0.891
3:	-0.353	0.498
4:	0.324	0.262
5:	0.105	-0.330
6:	0.318	-0.560
7:	-0.424	-0.066
8:	-0.683	-0.464
9:	-0.331	-1.011
10:	0.139	-0.428



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577239. __0

TARGET NUMBER: 4

FILE DATE: 07/27/2006

FILE TIME: 07:55

X CENTROID: -0.023

Y CENTROID: 0.037

POA TO CENTROID: 0.044

HORZ SPREAD: 1.714

VERT SPREAD: 1.985

GROUP SPREAD: 2.427

MIN RADIUS: 0.294

MAX RADIUS: 1.232

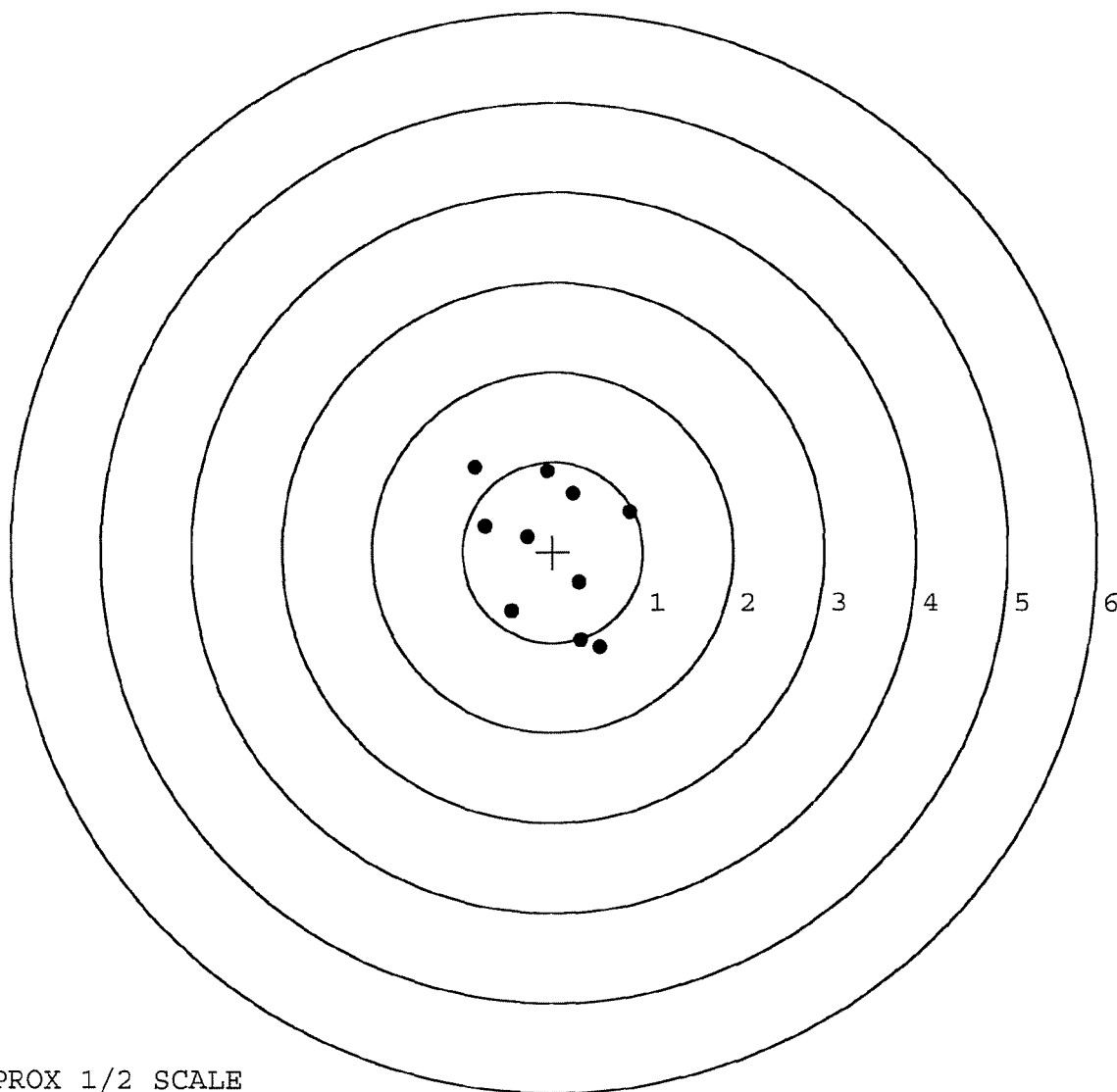
MEAN RADIUS: 0.836

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.867	0.935
2:	-0.071	0.896
3:	0.226	0.643
4:	0.847	0.451
5:	-0.755	0.285
6:	-0.285	0.170
7:	-0.459	-0.654
8:	0.291	-0.331
9:	0.315	-0.973
10:	0.530	-1.050

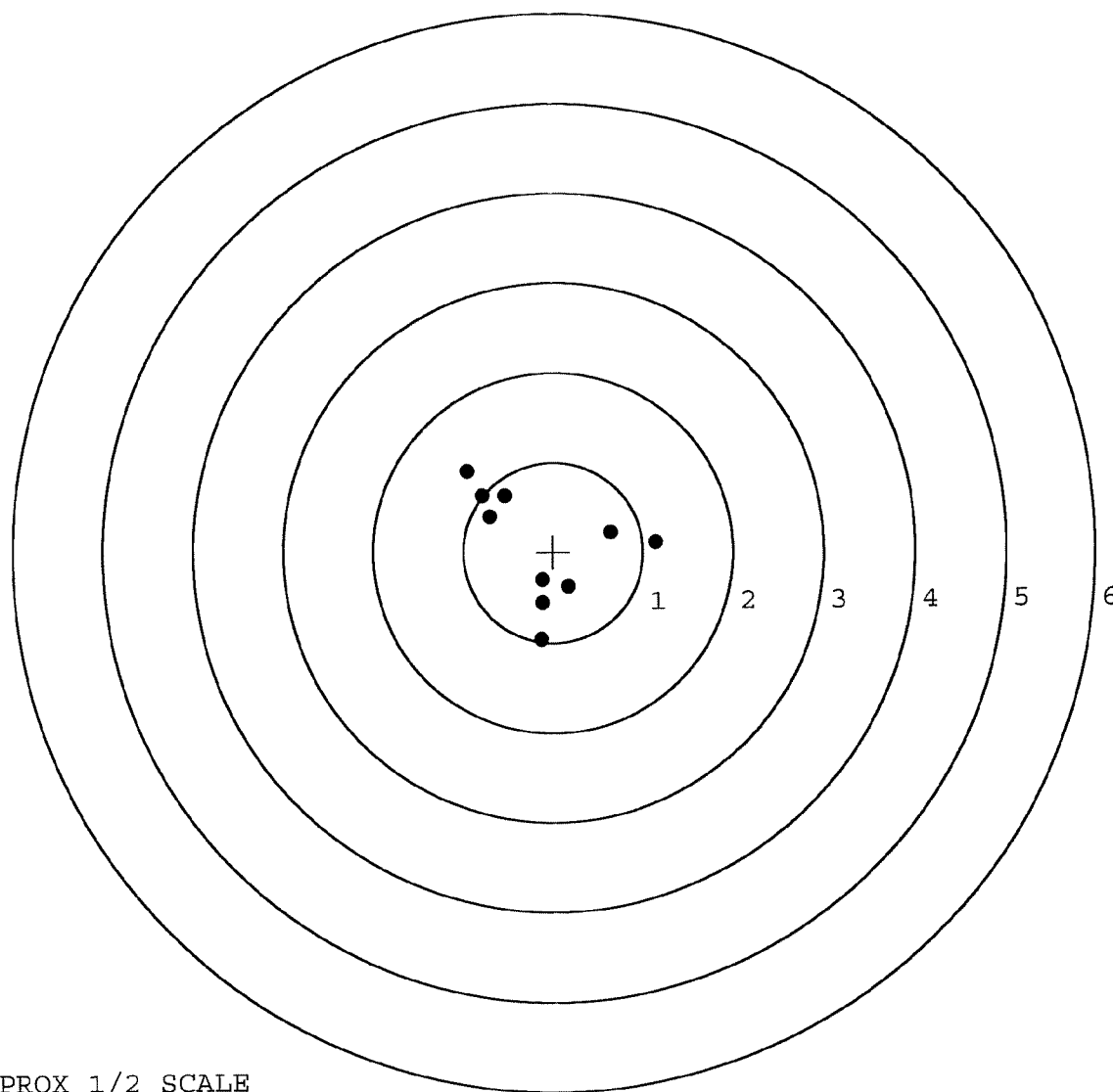


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6577239. __0
TARGET NUMBER: 5
FILE DATE: 07/27/2006
FILE TIME: 07:55

X CENTROID: -0.141
Y CENTROID: 0.064
POA TO CENTROID: 0.155
HORZ SPREAD: 2.100
VERT SPREAD: 1.870
GROUP SPREAD: 2.246
MIN RADIUS: 0.378
MAX RADIUS: 1.288
MEAN RADIUS: 0.805
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.706	0.396
2:	-0.538	0.631
3:	-0.954	0.902
4:	0.641	0.215
5:	1.146	0.105
6:	-0.125	-0.314
7:	0.171	-0.389
8:	-0.126	-0.572
9:	-0.136	-0.968
10:	-0.787	0.631



TARGET APPROX 1/2 SCALE