

G 653 5424

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



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SERIAL NO.



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



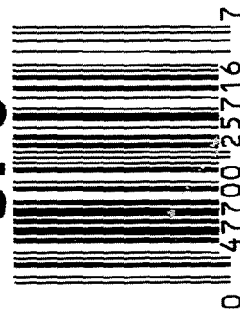
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6535424

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5424

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-27-06	RTZ
440	PROOF		2/27/06	MPD
460	CHECK HEADSPACE		2/27/06	MPD
470	DIS-ASSEMBLE ACTION		2-28-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OD H 480 MAR 01 2006 CPD	3-1-06	APD
500	ROLLMARK CALIBER		3-1-06	CW
510	DRILL AND TAP SIGHT HOLES		2-28-06	TRW
520	GOFF BLAST BBL / REC		3-2-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		3/1	MPD
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-21-06	MPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-21-06	MPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-21-06	MPD
	D) OIL FIRING PIN ASSEMBLY		3-21-06	AC
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-21-06	AC

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.25</u> <u>5.5</u> <u>5.0</u>	4-5-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.0</u> <u>2.25</u>	4-5-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0215</u> <u>.0215</u> <u>.0215</u>	4-5-06	TRW
	J) ASSEMBLE STOCK		3-21-06	A
	K) ASSEMBLE SWIVEL STUDS		4-10-06	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-21-06	A
	M) IRON SIGHT ALIGNMENT		3-21-06	A
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-21-06	A
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	3-30-06	MM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		3-30-06	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		4-10-06	A
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.45</u> <u>2.33</u> <u>2.38</u> <u>2.40</u>	3-31-06	A
	C) FUNCTION		4-10-06	A
690	PACK		4-11-06	DA

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 3-14-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	251	248		244	
PULL #2	246	255		240	
PULL #3	240	251		240	
PULL #4	244	252		246	
PULL #5	233	250		250	
TOTAL	1214	1256		1220	
AVERAGE	242	251		244	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	307	299		
PULL #2	308	311		
PULL #3	305	306		
PULL #4	312	310		
PULL #5	306	308		
TOTAL	1538	1534		
AVERAGE	307	306		

	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	4.09	4.11		4.06
PULL #2	4.14	4.06		4.03
PULL #3	4.11	4.01		4.07
PULL #4	4.10	4.01		4.07
PULL #5	4.09	4.01		4.03
TOTAL	20.53	20.20		20.26
AVERAGE	4.10	4.04		4.05

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535424.__0
FILE DATE AND TIME: 03/30/2006 17:49

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.077
The Average Y Centroid of the Five Target Set:	0.033
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.672
The Distance from POA to Centroid Target #1:	0.100
The Distance from Centroid Target #2 to Centroid Target #1:	0.154
The Distance from Centroid Target #3 to Centroid Target #1:	0.206
The Distance from Centroid Target #4 to Centroid Target #1:	0.306
The Distance from Centroid Target #5 to Centroid Target #1:	0.311

SERIAL NUMBER: G6535424. 0

TARGET NUMBER: 1

FILE DATE: 03/30/2006

FILE TIME: 17:49

POINT#	X	Y
1:	-0.357	-0.642
2:	-0.412	-0.387
3:	-0.456	0.159
4:	-0.922	0.251
5:	-0.464	0.702
6:	0.416	0.730
7:	0.285	0.185
8:	0.941	0.100
9:	0.647	0.057
10:	0.776	-0.266

X CENTROID: 0.045

Y CENTROID: 0.089

POA TO CENTROID: 0.100

HORZ SPREAD: 1.863

VERT SPREAD: 1.372

GROUP SPREAD: 1.869

MIN RADIUS: 0.258

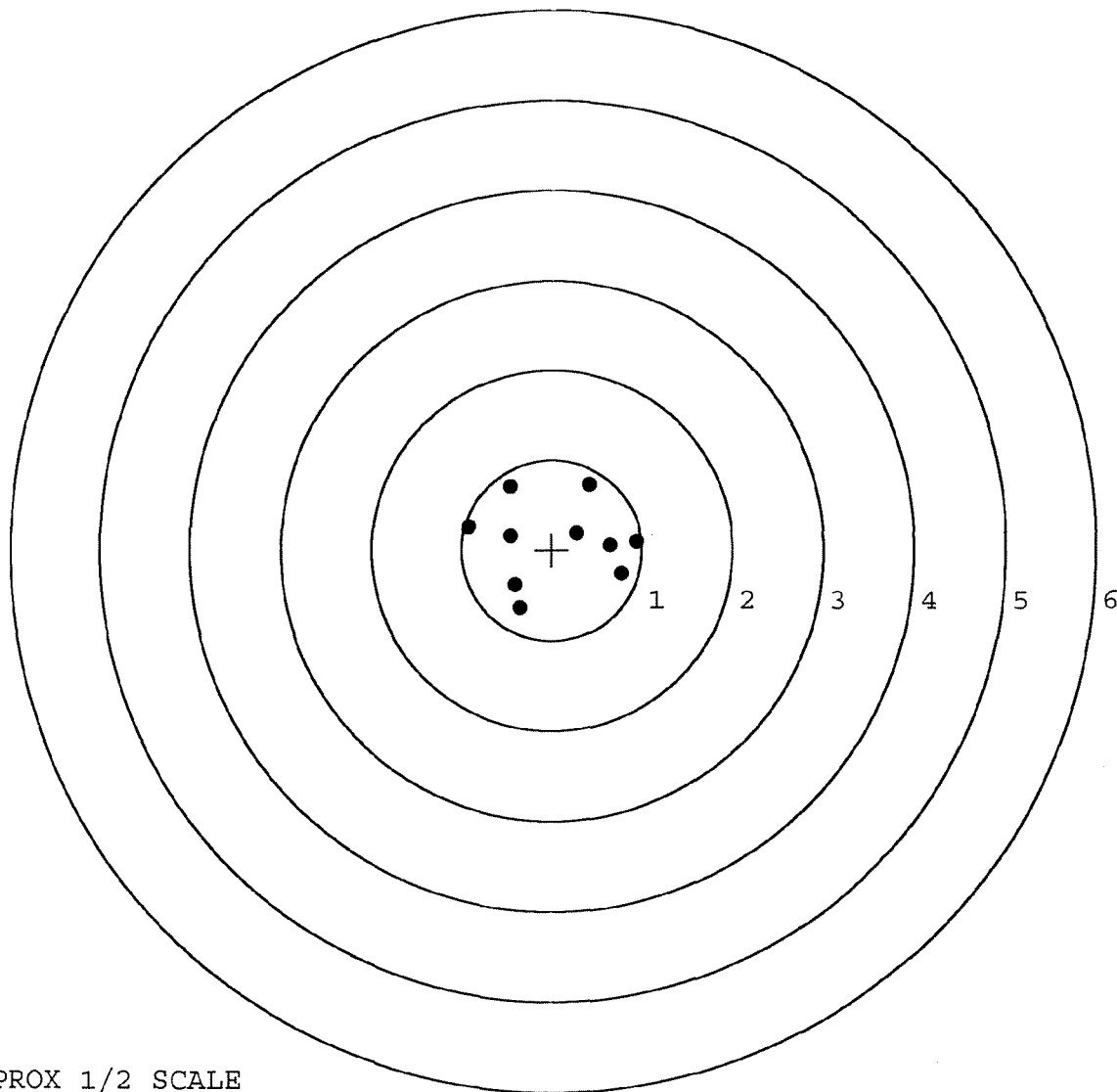
MAX RADIUS: 0.981

MEAN RADIUS: 0.709

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535424. __0

TARGET NUMBER: 2

FILE DATE: 03/30/2006

FILE TIME: 17:49

POINT#	X	Y
1:	0.895	-0.777
2:	0.367	-0.614
3:	0.064	-0.615
4:	0.002	-0.173
5:	0.698	-0.032
6:	0.364	0.184
7:	0.250	0.751
8:	-0.756	0.729
9:	-0.718	-0.134
10:	0.346	0.456

X CENTROID: 0.151

Y CENTROID: -0.023

POA TO CENTROID: 0.153

HORZ SPREAD: 1.651

VERT SPREAD: 1.528

GROUP SPREAD: 2.235

MIN RADIUS: 0.212

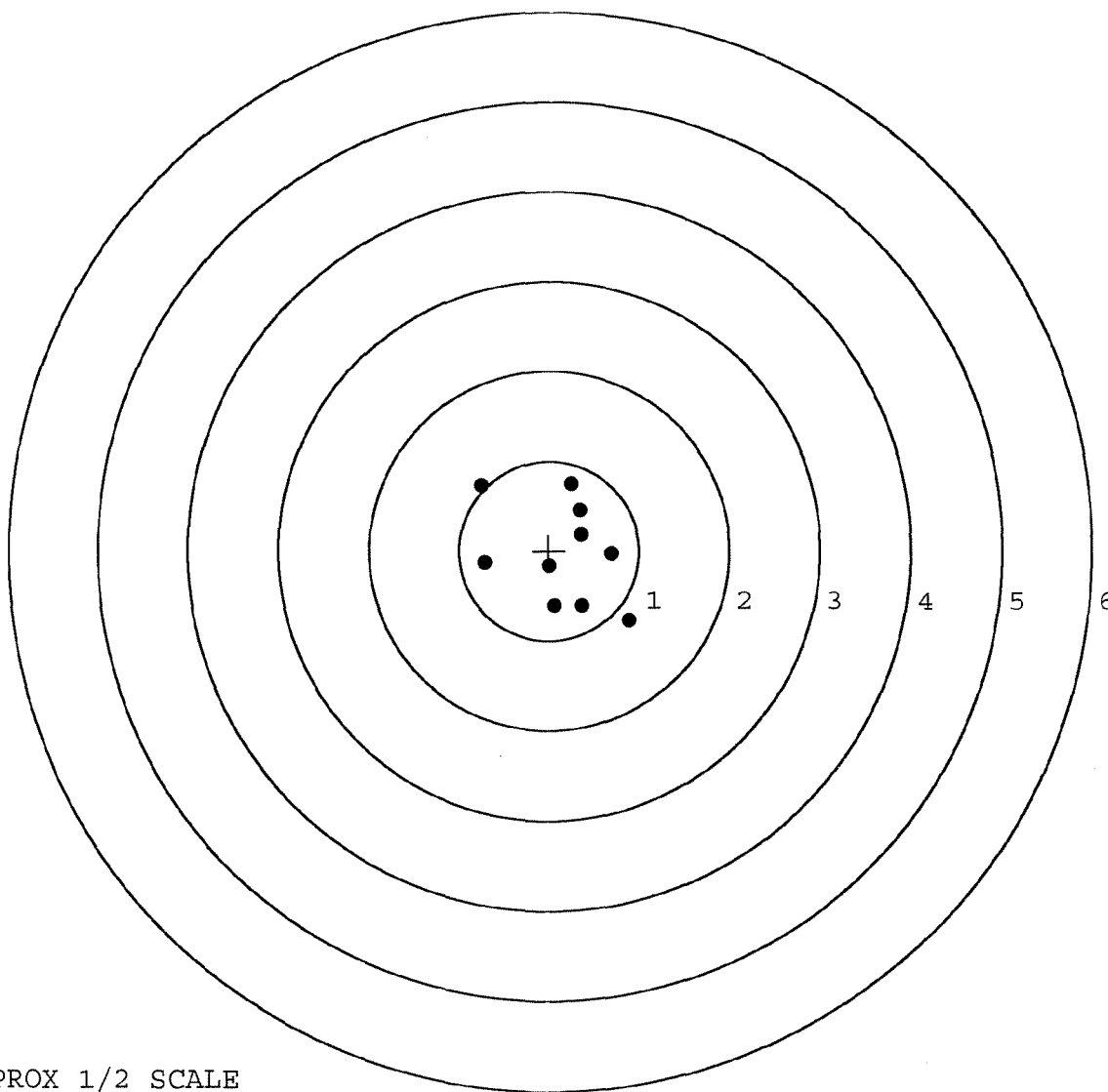
MAX RADIUS: 1.178

MEAN RADIUS: 0.669

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535424. 0

TARGET NUMBER: 3

FILE DATE: 03/30/2006

FILE TIME: 17:49

POINT#	X	Y
1:	-0.809	0.489
2:	-0.542	0.650
3:	-0.363	0.420
4:	-0.751	-0.392
5:	0.360	-1.165
6:	0.495	0.874
7:	0.319	0.624
8:	0.115	0.280
9:	-0.103	0.195
10:	0.037	0.078

X CENTROID: -0.124

Y CENTROID: 0.205

POA TO CENTROID: 0.240

HORZ SPREAD: 1.304

VERT SPREAD: 2.039

GROUP SPREAD: 2.043

MIN RADIUS: 0.024

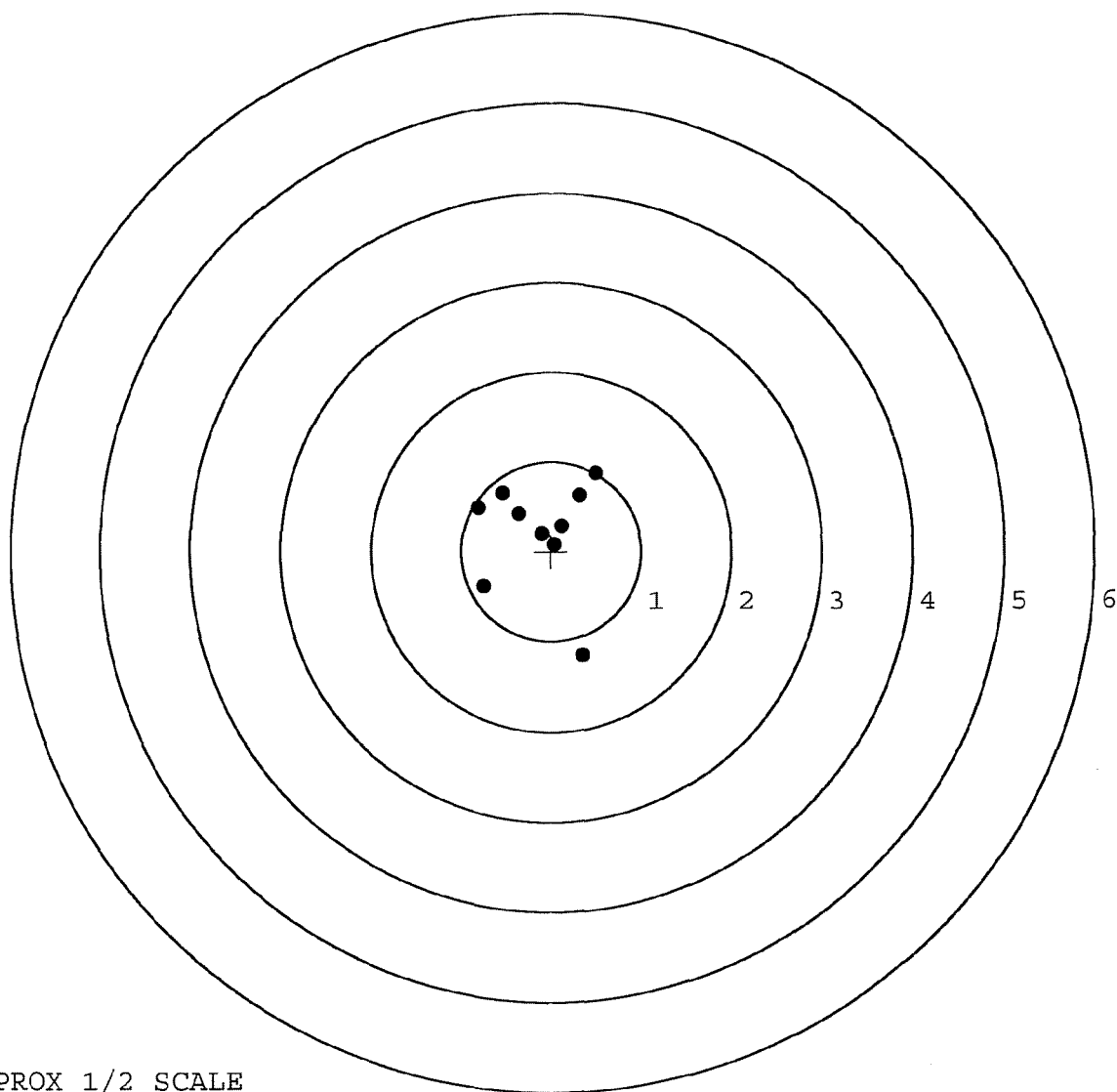
MAX RADIUS: 1.453

MEAN RADIUS: 0.599

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

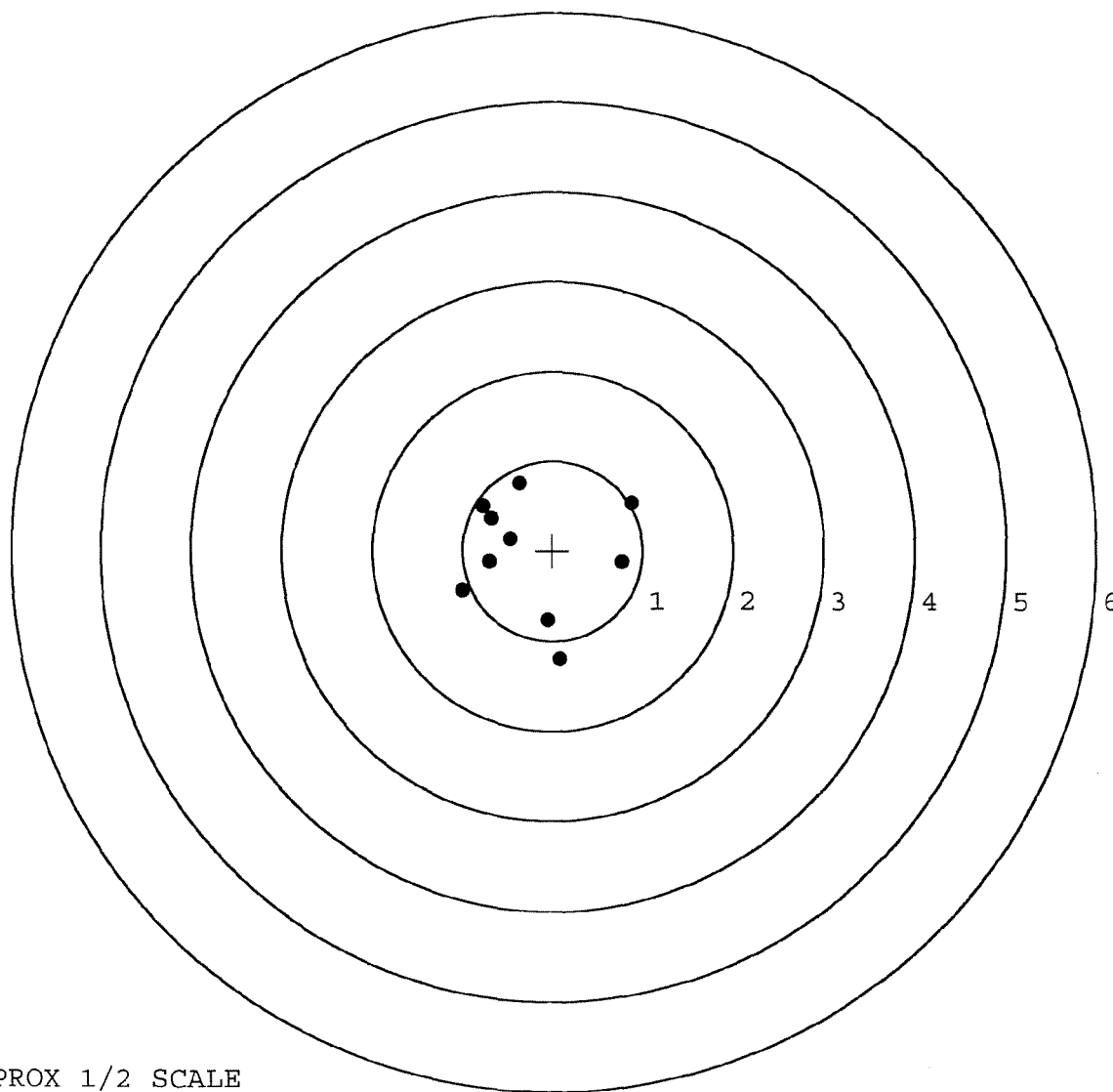


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535424. __ 0
TARGET NUMBER: 4
FILE DATE: 03/30/2006
FILE TIME: 17:49

X CENTROID: -0.231
Y CENTROID: -0.043
POA TO CENTROID: 0.235
HORZ SPREAD: 1.877
VERT SPREAD: 1.948
GROUP SPREAD: 2.119
MIN RADIUS: 0.294
MAX RADIUS: 1.249
MEAN RADIUS: 0.802
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.000	-0.450
2:	-0.703	-0.133
3:	-0.467	0.132
4:	-0.774	0.491
5:	-0.369	0.748
6:	0.877	0.534
7:	0.767	-0.129
8:	-0.047	-0.777
9:	0.088	-1.200
10:	-0.682	0.354



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535424. 0

TARGET NUMBER: 5

FILE DATE: 03/30/2006

FILE TIME: 17:49

POINT#	X	Y
1:	-0.212	-0.733
2:	-0.535	-0.569
3:	0.706	0.509
4:	0.320	-0.074
5:	0.154	-0.228
6:	-0.166	-0.321
7:	-0.205	-0.020
8:	-0.589	-0.004
9:	-1.047	0.008
10:	-0.686	0.810

X CENTROID: -0.226

Y CENTROID: -0.062

POA TO CENTROID: 0.234

HORZ SPREAD: 1.753

VERT SPREAD: 1.543

GROUP SPREAD: 1.823

MIN RADIUS: 0.047

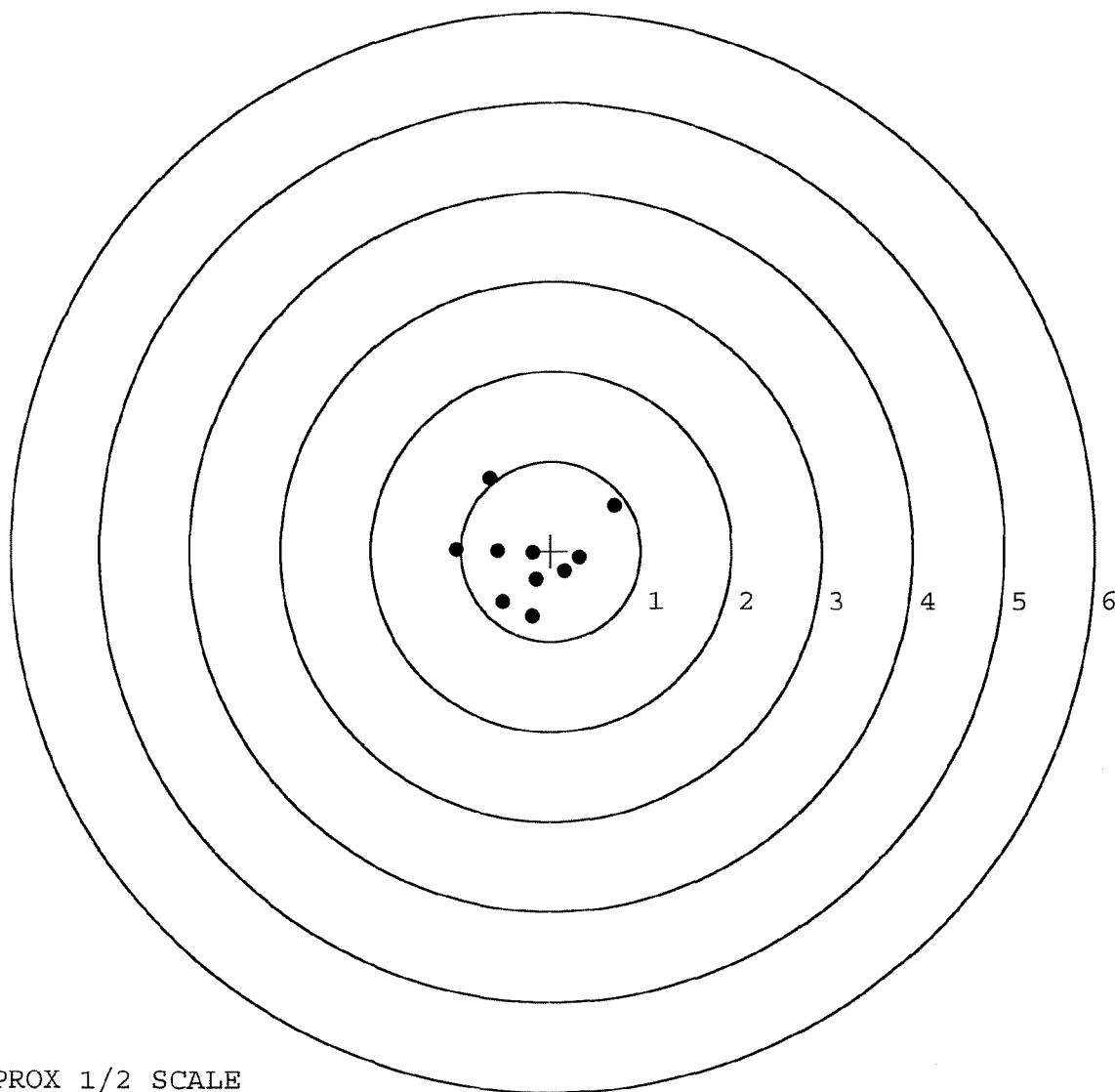
MAX RADIUS: 1.093

MEAN RADIUS: 0.581

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE