

G 663 7645

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

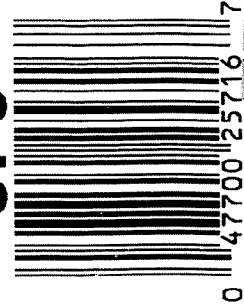
24"

CAPACITY

6

G6637645

UPC



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

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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6637645

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		4-13-07	RIC
420	ASSEMBLE ACTION		4/13/07	SPD
430	ASSEMBLE TO STOCK		4-16-07	TRW
440	PROOF		4-16-07	FM
460	CHECK HEADSPACE		4-16-07	FM
470	DIS-ASSEMBLE ACTION		4-16-07	RTZ
480	MAGNAFLUX BBL ACTION		4-19-07	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-19-07	CW
510	DRILL AND TAP SIGHT HOLES		4-17-07	SD
520	GOFF BLAST BBL / REC		4/19/07	ms
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		4/25/07	WJ
560	RE-ASSEMBLE ACTION		4-25-07	SD
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-25-07	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-25-07	SD
	D) OIL FIRING PIN ASSEMBLY		4/26/07	SPD
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		5/22/07	ms

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	5-29-07	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	5-29-07	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		6/8/07	W
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-29-07	DA
	J) ASSEMBLE STOCK		4/26/07	PPD
	K) ASSEMBLE SWIVEL STUDS		6-8-07	SD
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6/8/07	W
	M) IRON SIGHT ALIGNMENT		4/8/07	W
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6/8/07	W
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-27-07	NEW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-27-07	CHS
670	FINAL INSPECTION A) HEADSPACE		6/8/07	W
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.58</u> <u>2.67</u> <u>2.67</u> <u>2.45</u>	5/22/07	W
	C) FUNCTION		6/8/07	W
690	PACK		6/26/07	DA

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 4-26-07

TESTER SD

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.63	2.11		2.69	
PULL #2	2.66	2.10		2.70	
PULL #3	2.71	2.02		2.67	
PULL #4	2.67	2.04		2.75	
PULL #5	2.57	2.07		2.68	
TOTAL	1319	1034		1349	
AVERAGE	263	206		269	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.33		
PULL #2	3.29	3.43		
PULL #3	3.31	3.42		
PULL #4	3.32	3.41		
PULL #5	3.44	3.42		
TOTAL	1666	1701		
AVERAGE	333	340		

	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	4.29		4.32
PULL #2	4.11	4.19		4.33
PULL #3	4.16	4.24		4.37
PULL #4	4.20	4.22		4.33
PULL #5	4.24	4.20		4.32
TOTAL	2087	2114		2167
AVERAGE	417	422		433

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6637645.___0

FILE DATE AND TIME: 04/27/2007 10:42

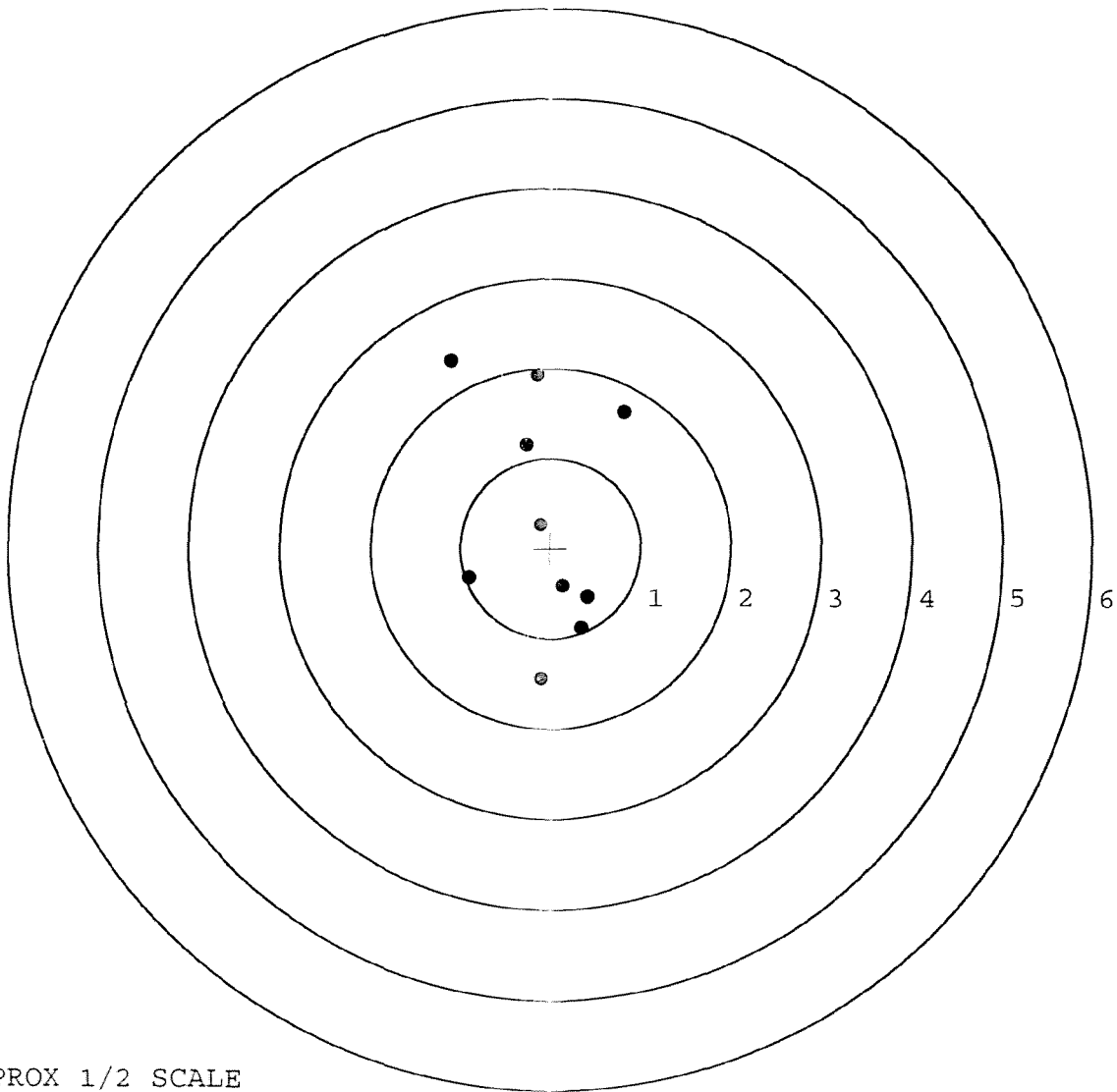
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.077
The Average Y Centroid of the Five Target Set:	0.010
The Average Point of Impact of the Five Target Set:	0.077
The Average Mean Radius of the Five Target Set:	0.669
The Distance from POA to Centroid Target #1:	0.341
The Distance from Centroid Target #2 to Centroid Target #1:	0.424
The Distance from Centroid Target #3 to Centroid Target #1:	0.298
The Distance from Centroid Target #4 to Centroid Target #1:	0.511
The Distance from Centroid Target #5 to Centroid Target #1:	0.389

SERIAL NUMBER: G6637645. 0
TARGET NUMBER: 1
FILE DATE: 04/27/2007
FILE TIME: 10:42

POINT#	X	Y
1:	0.814	1.508
2:	-0.270	1.148
3:	-0.149	1.926
4:	-1.110	2.074
5:	-0.119	0.257
6:	-0.903	-0.335
7:	0.135	-0.425
8:	0.418	-0.541
9:	0.340	-0.892
10:	-0.109	-1.447

X CENTROID: -0.095
Y CENTROID: 0.327
POA TO CENTROID: 0.341
HORZ SPREAD: 1.924
VERT SPREAD: 3.521
GROUP SPREAD: 3.661
MIN RADIUS: 0.074
MAX RADIUS: 2.020
MEAN RADIUS: 1.193
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 7

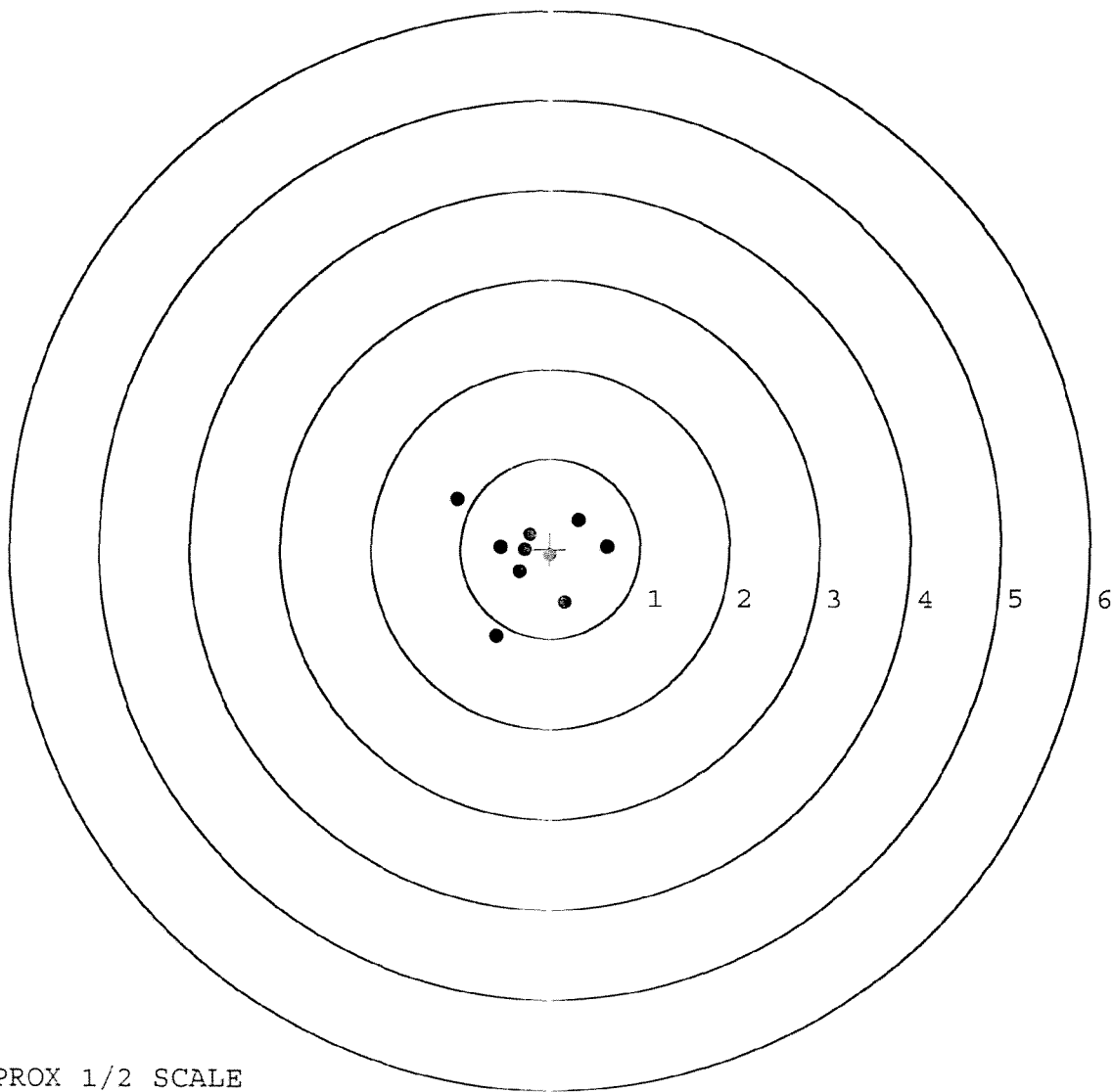


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637645. 0
TARGET NUMBER: 2
FILE DATE: 04/27/2007
FILE TIME: 10:42

POINT#	X	Y
1:	0.165	-0.597
2:	0.636	0.018
3:	0.314	0.318
4:	-0.604	-0.979
5:	0.003	-0.071
6:	-1.038	0.552
7:	-0.229	0.156
8:	-0.339	-0.255
9:	-0.550	0.014
10:	-0.285	-0.014

X CENTROID: -0.193
Y CENTROID: -0.086
POA TO CENTROID: 0.211
HORZ SPREAD: 1.674
VERT SPREAD: 1.531
GROUP SPREAD: 1.757
MIN RADIUS: 0.117
MAX RADIUS: 1.059
MEAN RADIUS: 0.530
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637645. __0

TARGET NUMBER: 3

FILE DATE: 04/27/2007

FILE TIME: 10:42

POINT#	X	Y
1:	0.913	0.376
2:	-0.351	0.428
3:	-0.436	0.304
4:	-0.177	0.331
5:	0.088	0.139
6:	-0.114	0.046
7:	0.210	-0.273
8:	-0.298	-0.250
9:	0.014	-0.570
10:	-0.028	-0.136

X CENTROID: -0.018

Y CENTROID: 0.040

POA TO CENTROID: 0.043

HORZ SPREAD: 1.349

VERT SPREAD: 0.998

GROUP SPREAD: 1.363

MIN RADIUS: 0.096

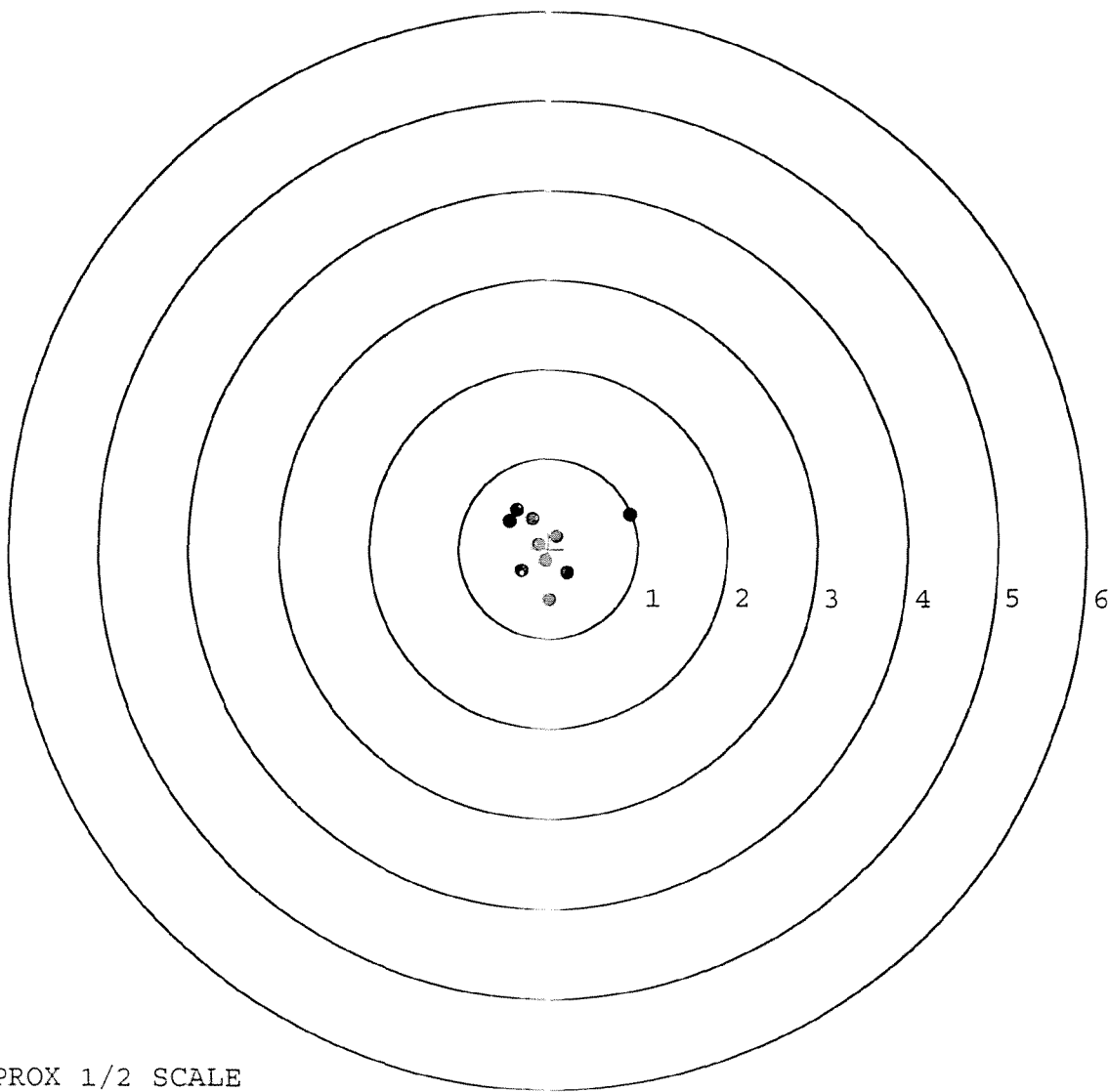
MAX RADIUS: 0.990

MEAN RADIUS: 0.415

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

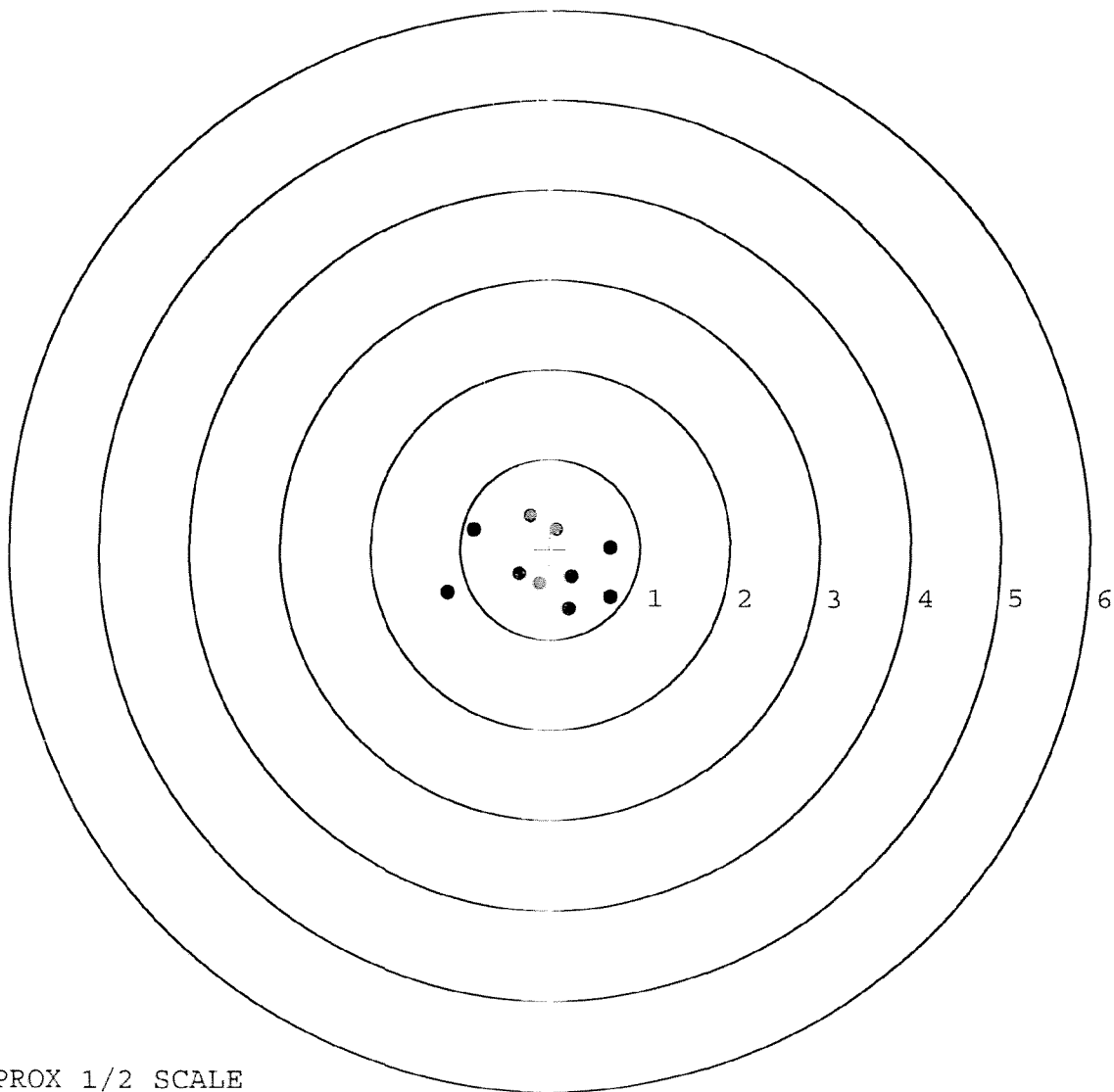


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637645. 0
TARGET NUMBER: 4
FILE DATE: 04/27/2007
FILE TIME: 10:42

POINT#	X	Y
1:	0.667	-0.534
2:	0.670	0.009
3:	0.213	-0.661
4:	0.240	-0.311
5:	-0.115	-0.384
6:	-0.339	-0.280
7:	-1.145	-0.484
8:	0.068	0.219
9:	-0.223	0.369
10:	-0.858	0.217

X CENTROID: -0.082
Y CENTROID: -0.184
POA TO CENTROID: 0.202
HORZ SPREAD: 1.815
VERT SPREAD: 1.030
GROUP SPREAD: 1.881
MIN RADIUS: 0.203
MAX RADIUS: 1.104
MEAN RADIUS: 0.597
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6637645. 0

TARGET NUMBER: 5

FILE DATE: 04/27/2007

FILE TIME: 10:42

POINT#	X	Y
1:	0.445	-0.845
2:	0.395	-0.442
3:	-0.800	-0.942
4:	0.309	0.700
5:	0.247	0.945
6:	0.232	0.094
7:	-0.105	-0.347
8:	-0.002	-0.121
9:	-0.189	0.306
10:	-0.492	0.161

X CENTROID: 0.004

Y CENTROID: -0.049

POA TO CENTROID: 0.049

HORZ SPREAD: 1.245

VERT SPREAD: 1.887

GROUP SPREAD: 2.158

MIN RADIUS: 0.072

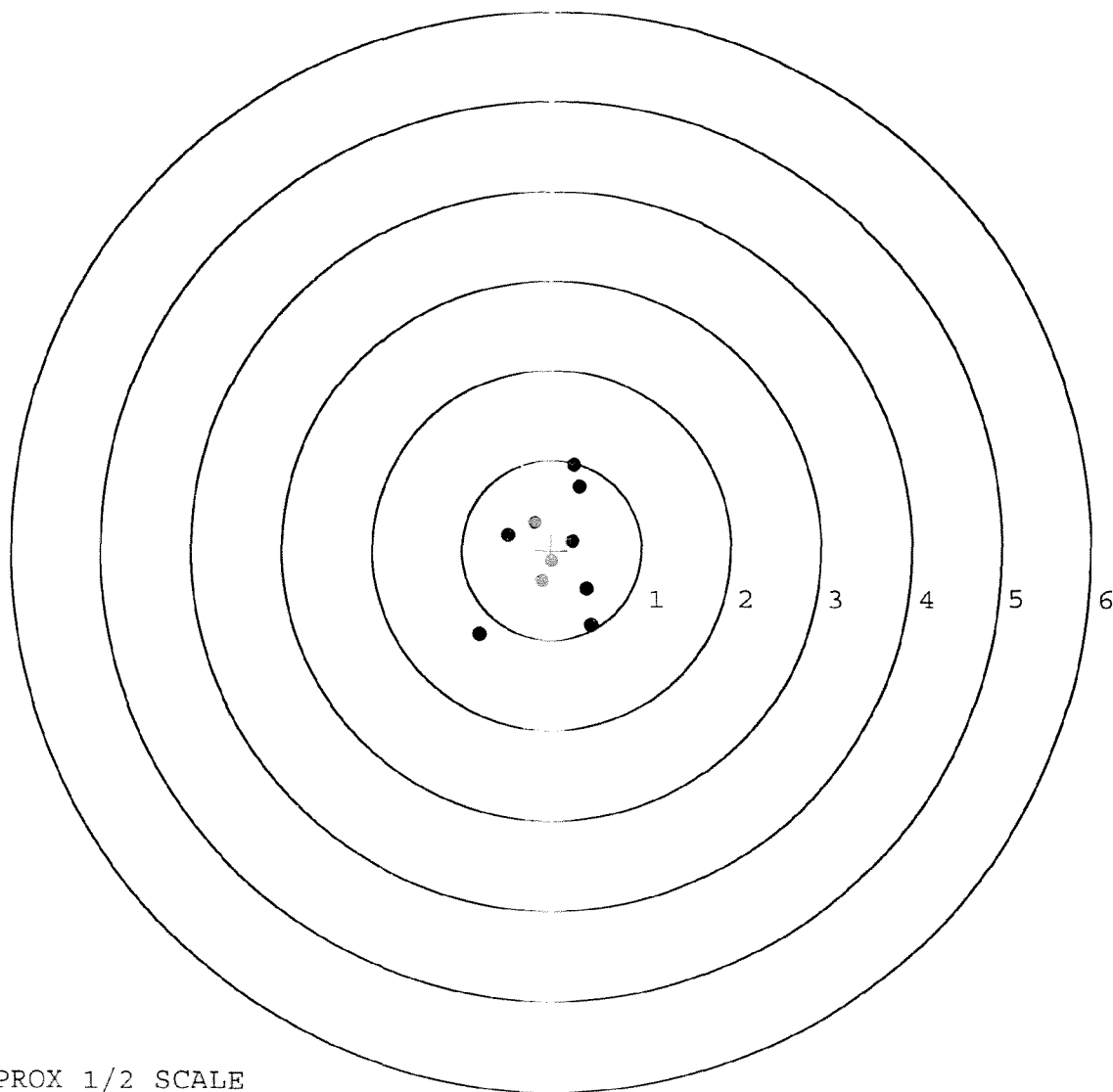
MAX RADIUS: 1.202

MEAN RADIUS: 0.610

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE