

G-641 4332

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



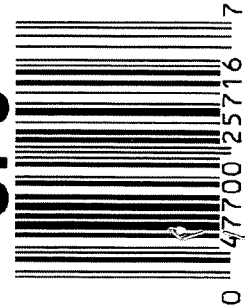
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6414332

UPC



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

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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414332

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTL
600	PROOF		12-28-04	AC
607	CHECK HEADSPACE		12-28-04	AC
610	DIS-ASSEMBLE GUN		12-28-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		DEC 28 2004	JO
615	ROLLMARK CALIBER		12/29/04	AC
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRL
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-16-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-16-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-16-05	RTL
	D) OIL FIRING PIN ASSEMBLY		3-16-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6⁰</u> <u>6⁰</u> <u>6⁰</u>	3-30-05	RTZ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	3-30-05	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY		3-30-05	RTZ
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-30-05	RTZ
	J) ASSEMBLE STOCK		3-29-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		3-30-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	3-29-05	TRW
	MALFUNCTION <i>Bolt Release Sticks</i>	CORRECTION <u>OK</u>	3-30-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		3-29-05	AC
655	FINAL INSPECTION A) HEADSPACE		3-30-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>267</u> <u>272</u> <u>268</u> <u>263</u> <u>275</u>	3-30-05	RTZ
	C) FUNCTION		3-30-05	AC
660	PACK		3-31-05	RA

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)

SERIAL NO.

G 641 4332

DATE

3-11-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.43	2.42		2.03	
PULL #2	2.37	2.17		2.03	
PULL #3	2.31	2.40		2.27	
PULL #4	2.44	2.37		2.15	
PULL #5	2.35	2.36		2.20	
TOTAL	11.90	11.72		10.68	
AVERAGE	2.38	2.34		2.13	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.22		
PULL #2	3.21	3.25		
PULL #3	3.34	3.28		
PULL #4	3.20	3.25		
PULL #5	3.31	3.29		
TOTAL	16.14	16.29		
AVERAGE	3.22	3.25		

	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	3.93	4.45		3.99
PULL #2	3.96	4.46		4.01
PULL #3	4.49	4.39		3.98
PULL #4	4.50	4.22		3.95
PULL #5	4.55	4.40		3.92
TOTAL	21.43	21.92		19.85
AVERAGE	4.28	4.38		3.97

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414332.__1
FILE DATE AND TIME: 09/12/2005 11:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.283
The Average Y Centroid of the Five Target Set:	-0.153
The Average Point of Impact of the Five Target Set:	0.322
The Average Mean Radius of the Five Target Set:	0.964
The Distance from POA to Centroid Target #1:	0.078
The Distance from Centroid Target #2 to Centroid Target #1:	0.076
The Distance from Centroid Target #3 to Centroid Target #1:	0.464
The Distance from Centroid Target #4 to Centroid Target #1:	0.647
The Distance from Centroid Target #5 to Centroid Target #1:	0.104

SERIAL NUMBER: G6414332.___1

TARGET NUMBER: 1

FILE DATE: 09/12/2005

FILE TIME: 11:31

X CENTROID: 0.074

Y CENTROID: -0.026

POA TO CENTROID: 0.078

HORZ SPREAD: 3.874

VERT SPREAD: 2.318

GROUP SPREAD: 3.879

MIN RADIUS: 0.321

MAX RADIUS: 2.105

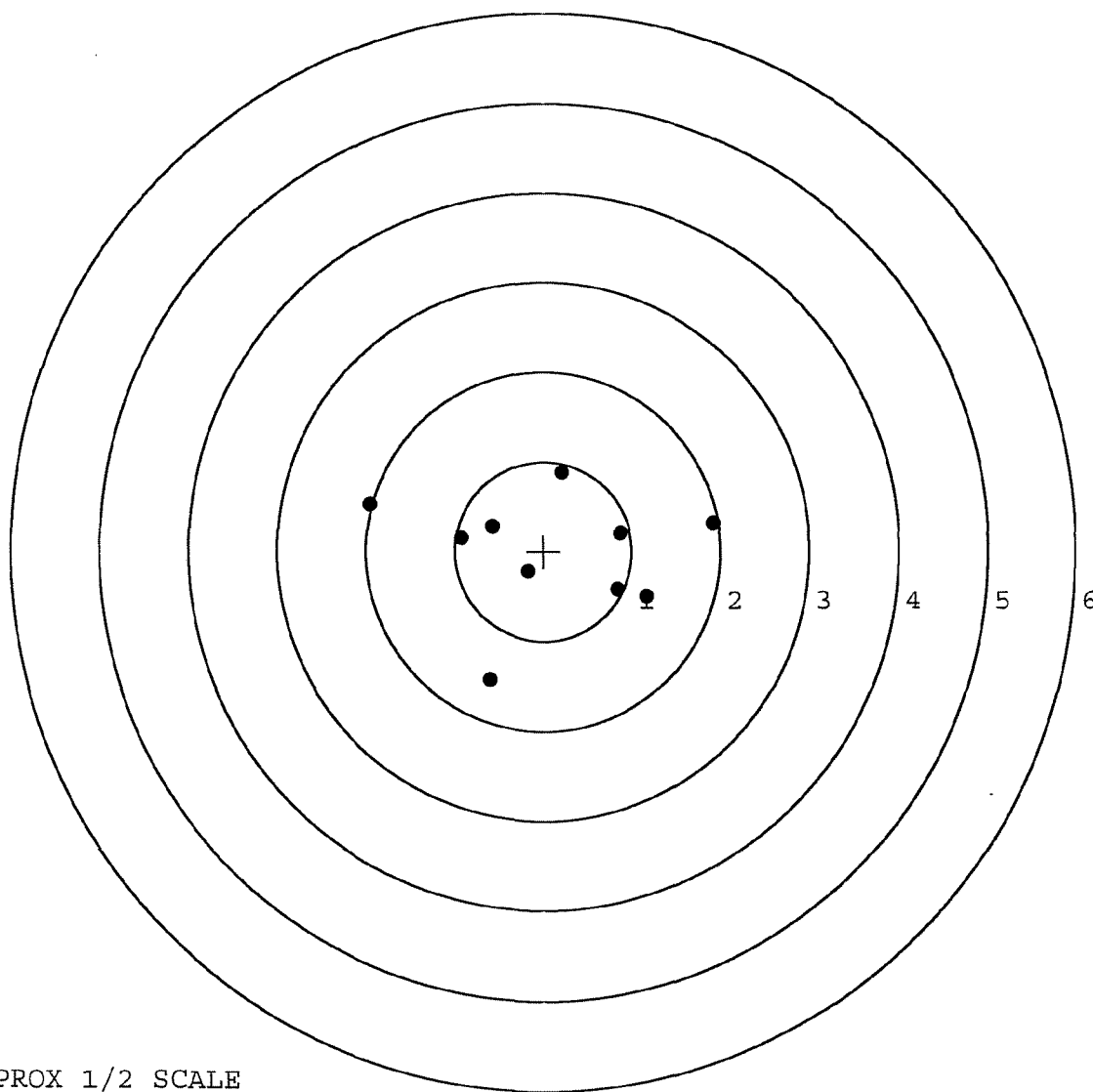
MEAN RADIUS: 1.140

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.916	0.319
2:	0.203	0.881
3:	1.169	-0.509
4:	0.835	-0.430
5:	-0.175	-0.228
6:	-0.608	-1.437
7:	-0.586	0.274
8:	-0.922	0.148
9:	-1.958	0.525
10:	0.867	0.200



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414332.___1

TARGET NUMBER: 2

FILE DATE: 09/12/2005

FILE TIME: 11:31

X CENTROID: 0.138

Y CENTROID: 0.015

POA TO CENTROID: 0.138

HORZ SPREAD: 1.915

VERT SPREAD: 1.798

GROUP SPREAD: 2.444

MIN RADIUS: 0.292

MAX RADIUS: 1.421

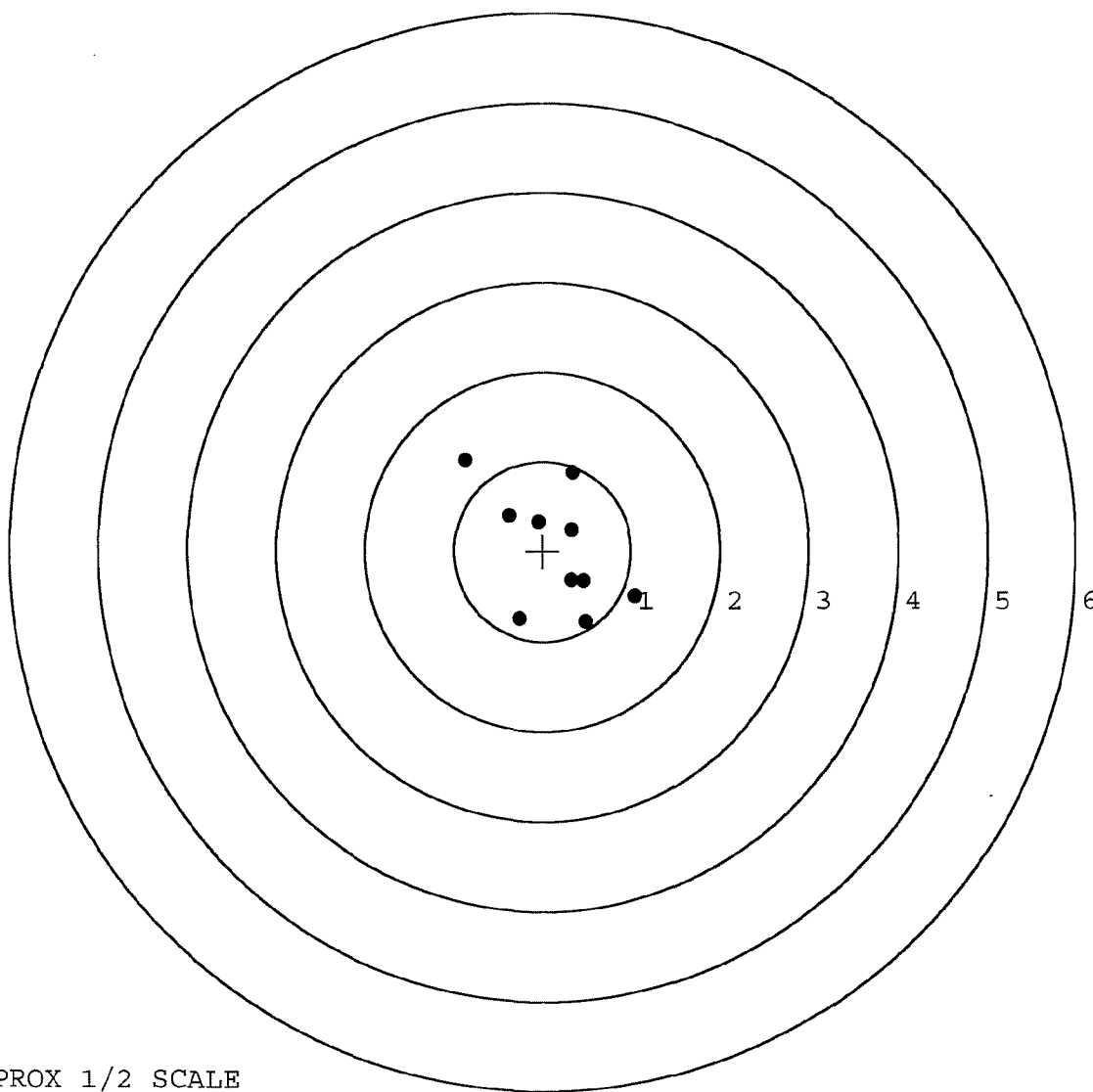
MEAN RADIUS: 0.725

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.041	-0.505
2:	0.480	-0.785
3:	0.464	-0.328
4:	0.323	-0.326
5:	-0.272	-0.748
6:	0.326	0.239
7:	0.337	0.879
8:	-0.058	0.323
9:	-0.391	0.391
10:	-0.874	1.013

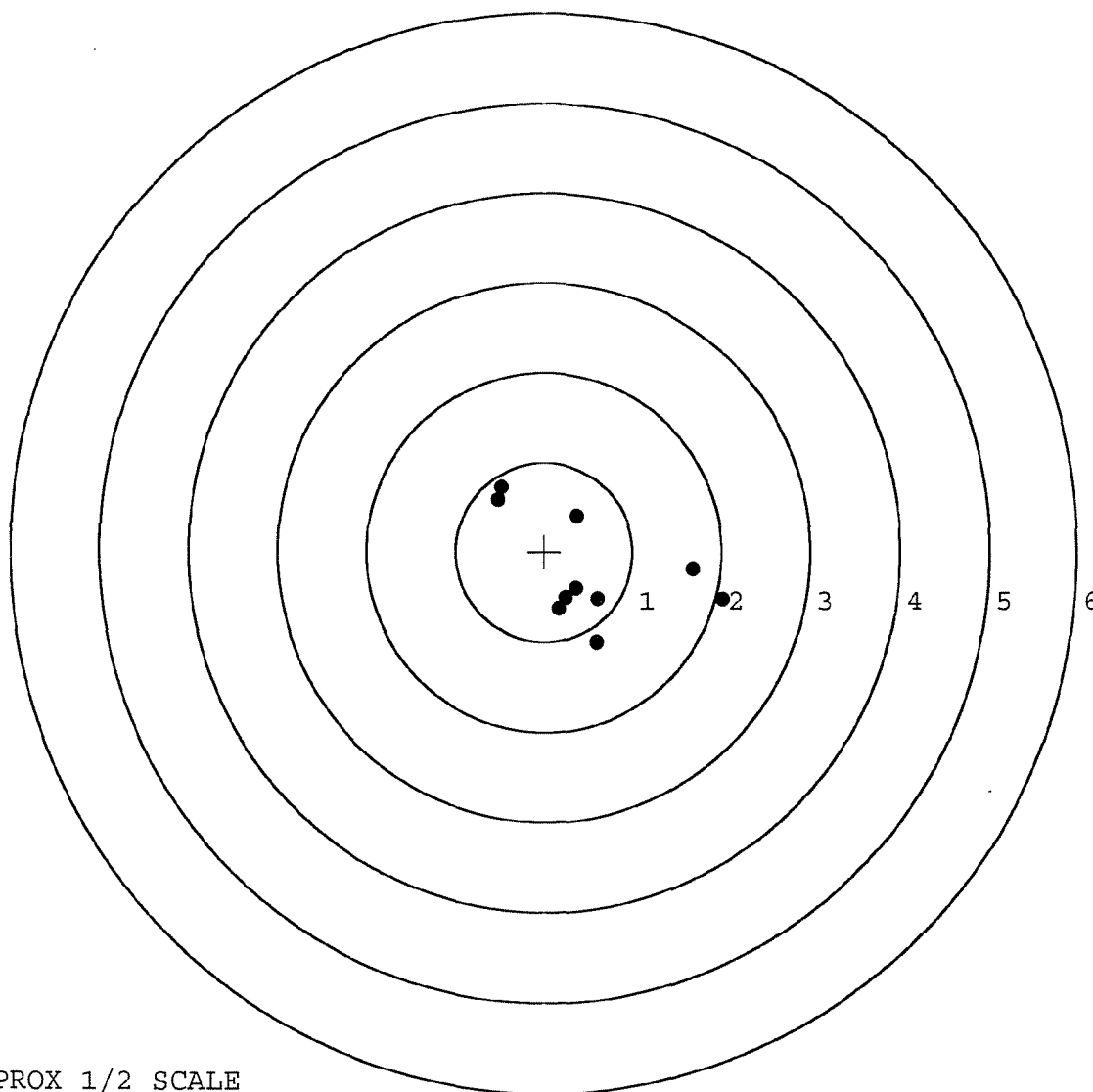


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414332. __1
TARGET NUMBER: 3
FILE DATE: 09/12/2005
FILE TIME: 11:31

X CENTROID: 0.499
Y CENTROID: -0.211
POA TO CENTROID: 0.542
HORZ SPREAD: 2.538
VERT SPREAD: 1.733
GROUP SPREAD: 2.803
MIN RADIUS: 0.242
MAX RADIUS: 1.545
MEAN RADIUS: 0.834
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.493	0.726
2:	-0.529	0.584
3:	0.361	0.405
4:	0.357	-0.407
5:	0.242	-0.515
6:	0.165	-0.638
7:	0.602	-0.528
8:	0.595	-1.007
9:	1.680	-0.195
10:	2.009	-0.537



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414332. 1

TARGET NUMBER: 4

FILE DATE: 09/12/2005

FILE TIME: 11:31

X CENTROID: 0.537

Y CENTROID: -0.478

POA TO CENTROID: 0.719

HORZ SPREAD: 2.526

VERT SPREAD: 3.274

GROUP SPREAD: 3.555

MIN RADIUS: 0.500

MAX RADIUS: 2.021

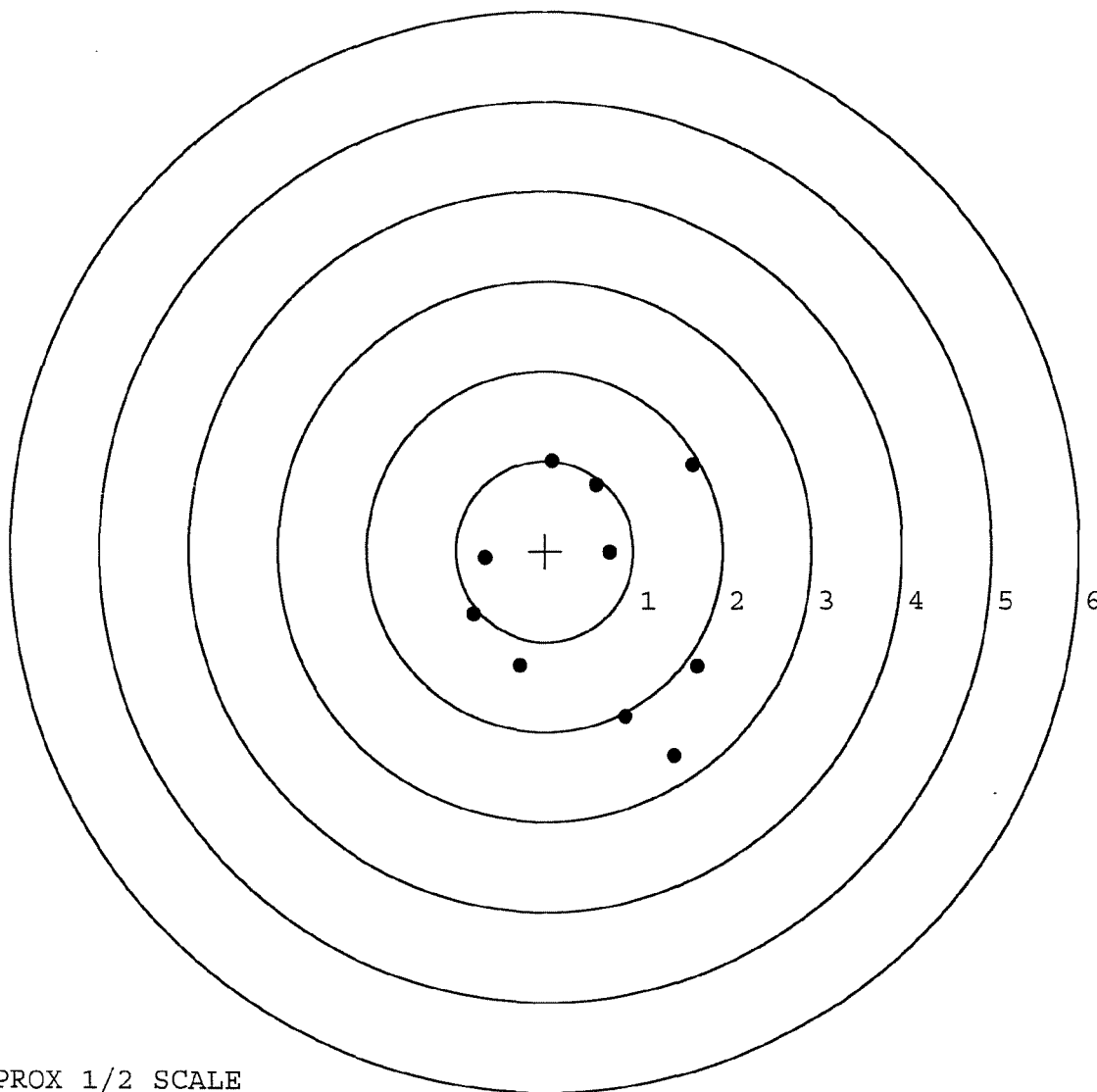
MEAN RADIUS: 1.373

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 1

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.731	-0.017
2:	0.576	0.737
3:	0.074	0.997
4:	-0.674	-0.083
5:	-0.806	-0.704
6:	-0.288	-1.271
7:	0.908	-1.840
8:	1.673	0.959
9:	1.720	-1.279
10:	1.458	-2.277

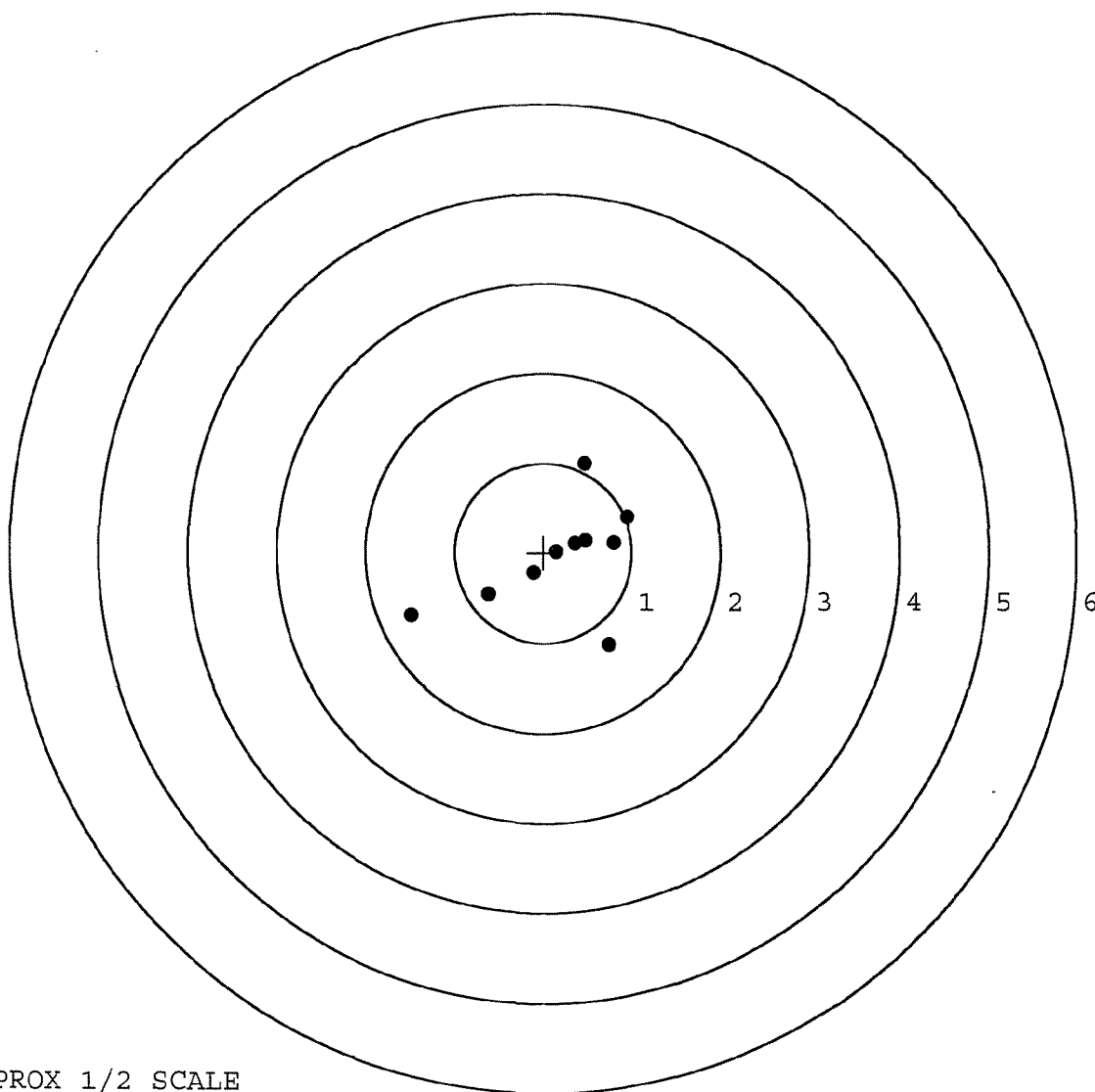


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414332. 1
TARGET NUMBER: 5
FILE DATE: 09/12/2005
FILE TIME: 11:31

X CENTROID: 0.169
Y CENTROID: -0.068
POA TO CENTROID: 0.182
HORZ SPREAD: 2.433
VERT SPREAD: 2.022
GROUP SPREAD: 2.670
MIN RADIUS: 0.082
MAX RADIUS: 1.774
MEAN RADIUS: 0.747
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.946	0.396
2:	0.797	0.110
3:	0.461	0.996
4:	0.478	0.139
5:	0.354	0.102
6:	0.144	0.010
7:	-0.114	-0.231
8:	-0.622	-0.469
9:	-1.487	-0.703
10:	0.737	-1.026



TARGET APPROX 1/2 SCALE