

G-6414345

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

G6414345

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

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0 47700 25716 7

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0 47700 25716 7

SERIAL NO.



66414345

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66414345

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-9-04	RTL
600	PROOF		11-9-04	RTL
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	11-9-04	RTL
610	DIS-ASSEMBLE GUN	NOV 10 2004	11-10-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>RS</u>		
615	ROLLMARK CALIBER		11/11/04	JS
617	DRILL AND TAP SIGHT HOLES		11-10-04	TRL
620	APPLY COATINGS (BARREL ACTION)		11/13	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11/18/04	AC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-18-04	AC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-18-04	AC
	D) OIL FIRING PIN ASSEMBLY		12-15-04	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>55</u> <u>55</u> <u>50</u>	1-18-05	DA,
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>30</u> <u>30</u> <u>30</u>	1-18-05	DA.
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.022</u> <u>.022</u>	1-18-05	DA
	J) ASSEMBLE STOCK		12-15-04	RTZ
	K) ASSEMBLE SWIVEL STUDS		1-18-05	RTR
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	N.A		
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	12-17-04	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-17-04	TRW
655	FINAL INSPECTION A) HEADSPACE		1-18-05	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.61</u> <u>2.75</u> <u>2.76</u> <u>2.61</u>	1-18-05	DA.
	C) FUNCTION		1-18-05	RR
660	PACK		1-19-05	DA.

AVERAGE PULL FORCE BETWEEN

SERIAL NO. _____

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE 12-13-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.19		2.18	
PULL #2	2.22	2.33		2.17	
PULL #3	2.41	2.37		2.57	
PULL #4	2.46	2.27		2.19	
PULL #5	2.54	2.28		2.00	
TOTAL	11.97	11.44		11.11	
AVERAGE	2.39	2.28		2.22	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.49		
PULL #2	3.29	3.19		
PULL #3	3.23	3.23		
PULL #4	3.14	3.23		
PULL #5	3.20	3.26		
TOTAL	15.98	16.40		
AVERAGE	3.19	3.28		

	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	4.35	4.34		4.11
PULL #2	4.19	4.07		4.12
PULL #3	4.32	4.26		4.19
PULL #4	4.28	4.28		4.25
PULL #5	4.39	4.27		4.18
TOTAL	21.53	21.22		20.85
AVERAGE	4.30	4.24		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414345.__1

FILE DATE AND TIME: 10/07/2005 08:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.105
The Average Y Centroid of the Five Target Set:	-0.098
The Average Point of Impact of the Five Target Set:	0.144
The Average Mean Radius of the Five Target Set:	0.770
The Distance from POA to Centroid Target #1:	0.253
The Distance from Centroid Target #2 to Centroid Target #1:	0.377
The Distance from Centroid Target #3 to Centroid Target #1:	0.141
The Distance from Centroid Target #4 to Centroid Target #1:	0.267
The Distance from Centroid Target #5 to Centroid Target #1:	0.201

SERIAL NUMBER: G6414345. __1

TARGET NUMBER: 1

FILE DATE: 10/07/2005

FILE TIME: 08:38

X CENTROID: -0.118

Y CENTROID: -0.223

POA TO CENTROID: 0.253

HORZ SPREAD: 1.608

VERT SPREAD: 2.040

GROUP SPREAD: 2.428

MIN RADIUS: 0.153

MAX RADIUS: 1.663

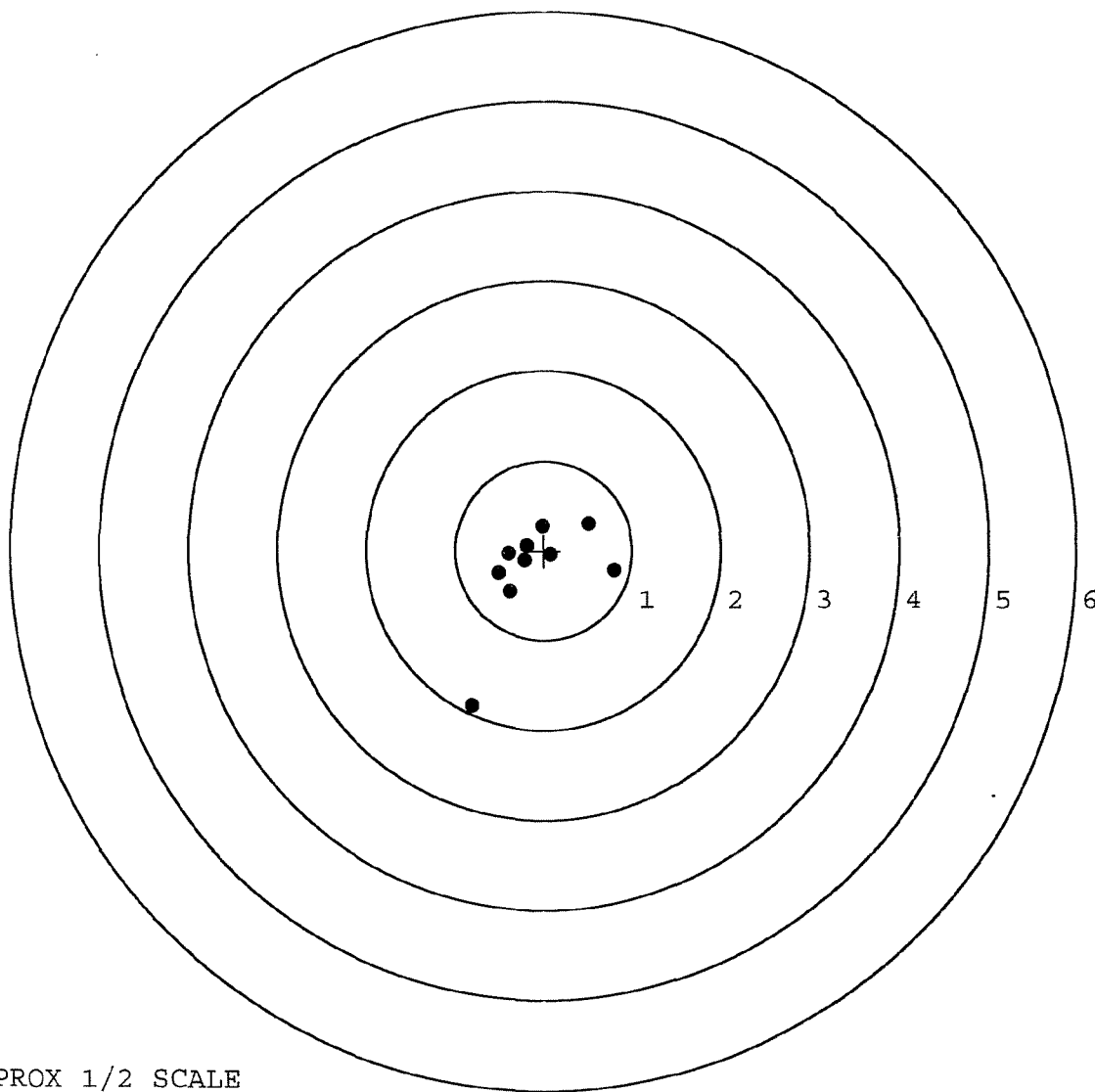
MEAN RADIUS: 0.571

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.812	-1.735
2:	-0.391	-0.461
3:	0.796	-0.224
4:	0.504	0.305
5:	-0.022	0.274
6:	0.079	-0.045
7:	-0.223	-0.112
8:	-0.198	0.055
9:	-0.400	-0.037
10:	-0.517	-0.255



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414345. __1

TARGET NUMBER: 2

FILE DATE: 10/07/2005

FILE TIME: 08:38

X CENTROID: -0.238

Y CENTROID: 0.134

POA TO CENTROID: 0.273

HORZ SPREAD: 2.391

VERT SPREAD: 3.269

GROUP SPREAD: 3.424

MIN RADIUS: 0.305

MAX RADIUS: 2.583

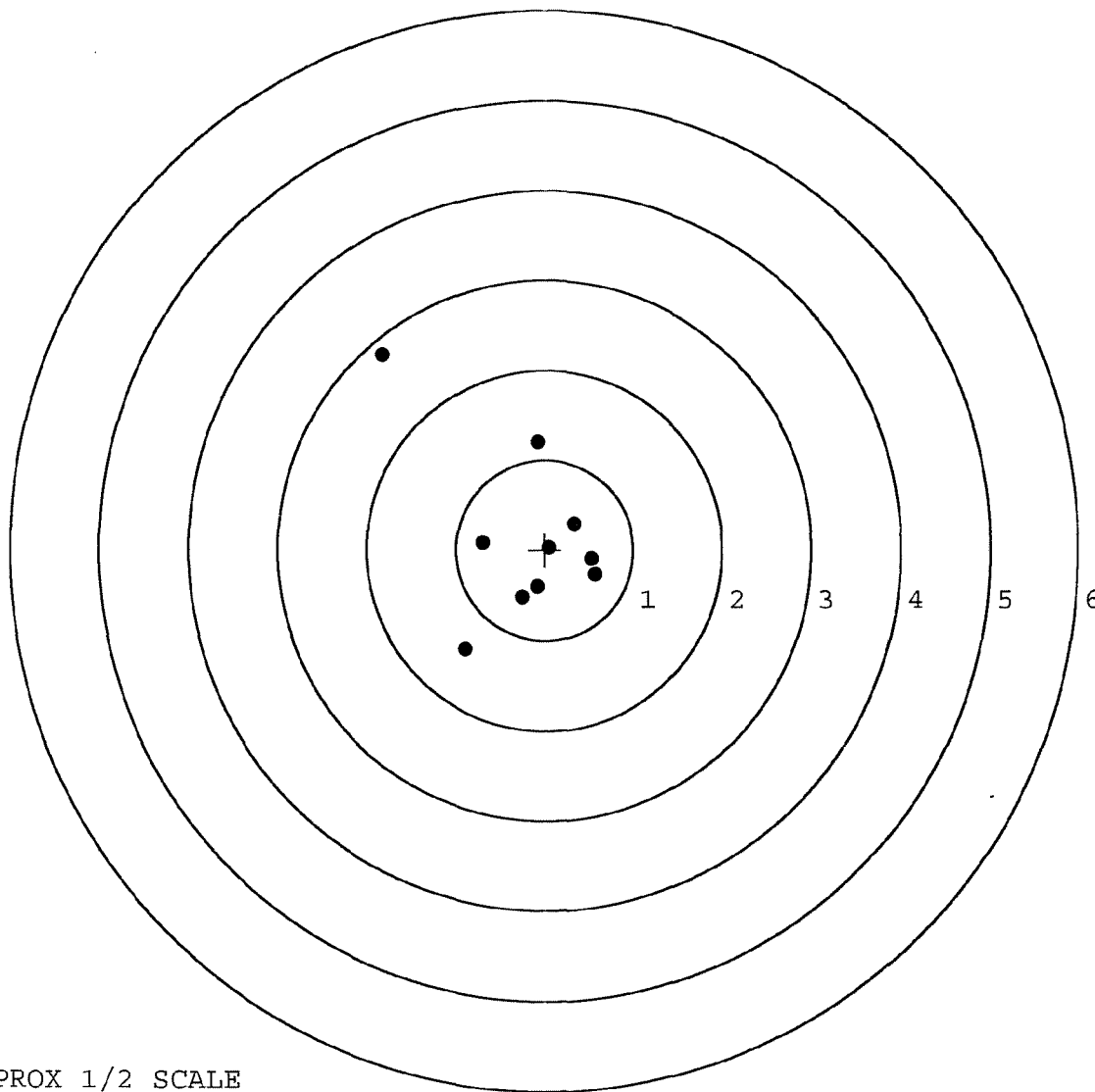
MEAN RADIUS: 0.935

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.897	-1.096
2:	-0.265	-0.529
3:	-0.089	-0.420
4:	0.568	-0.278
5:	0.530	-0.106
6:	0.327	0.291
7:	0.047	0.026
8:	-0.695	0.082
9:	-0.086	1.194
10:	-1.823	2.173



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414345. 1

TARGET NUMBER: 3

FILE DATE: 10/07/2005

FILE TIME: 08:38

X CENTROID: -0.168

Y CENTROID: -0.355

POA TO CENTROID: 0.393

HORZ SPREAD: 2.352

VERT SPREAD: 2.405

GROUP SPREAD: 2.945

MIN RADIUS: 0.035

MAX RADIUS: 1.731

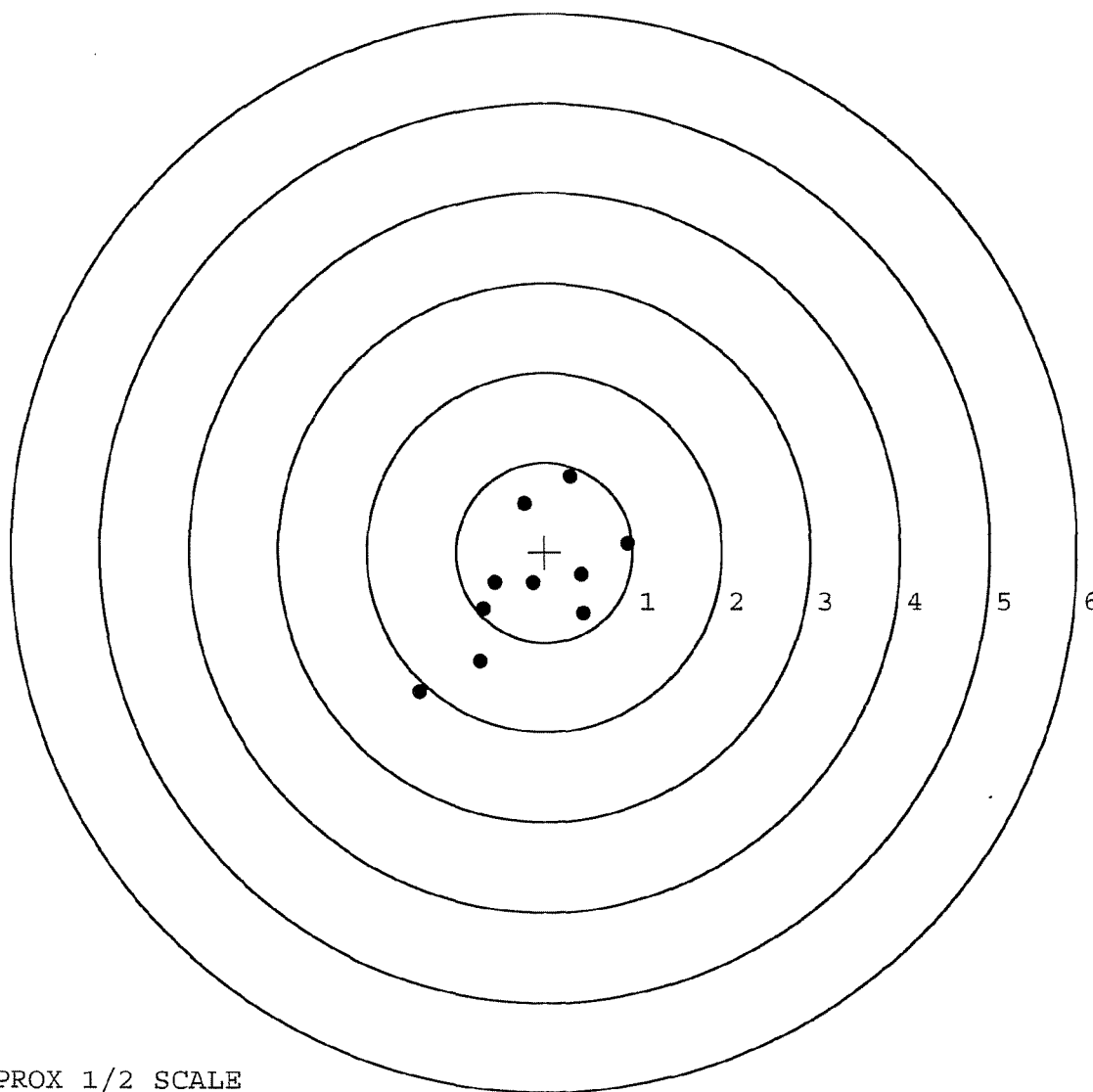
MEAN RADIUS: 0.844

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.408	-1.564
2:	-0.729	-1.219
3:	0.439	-0.677
4:	0.415	-0.253
5:	0.944	0.095
6:	-0.136	-0.343
7:	-0.569	-0.339
8:	-0.695	-0.629
9:	-0.236	0.534
10:	0.291	0.841

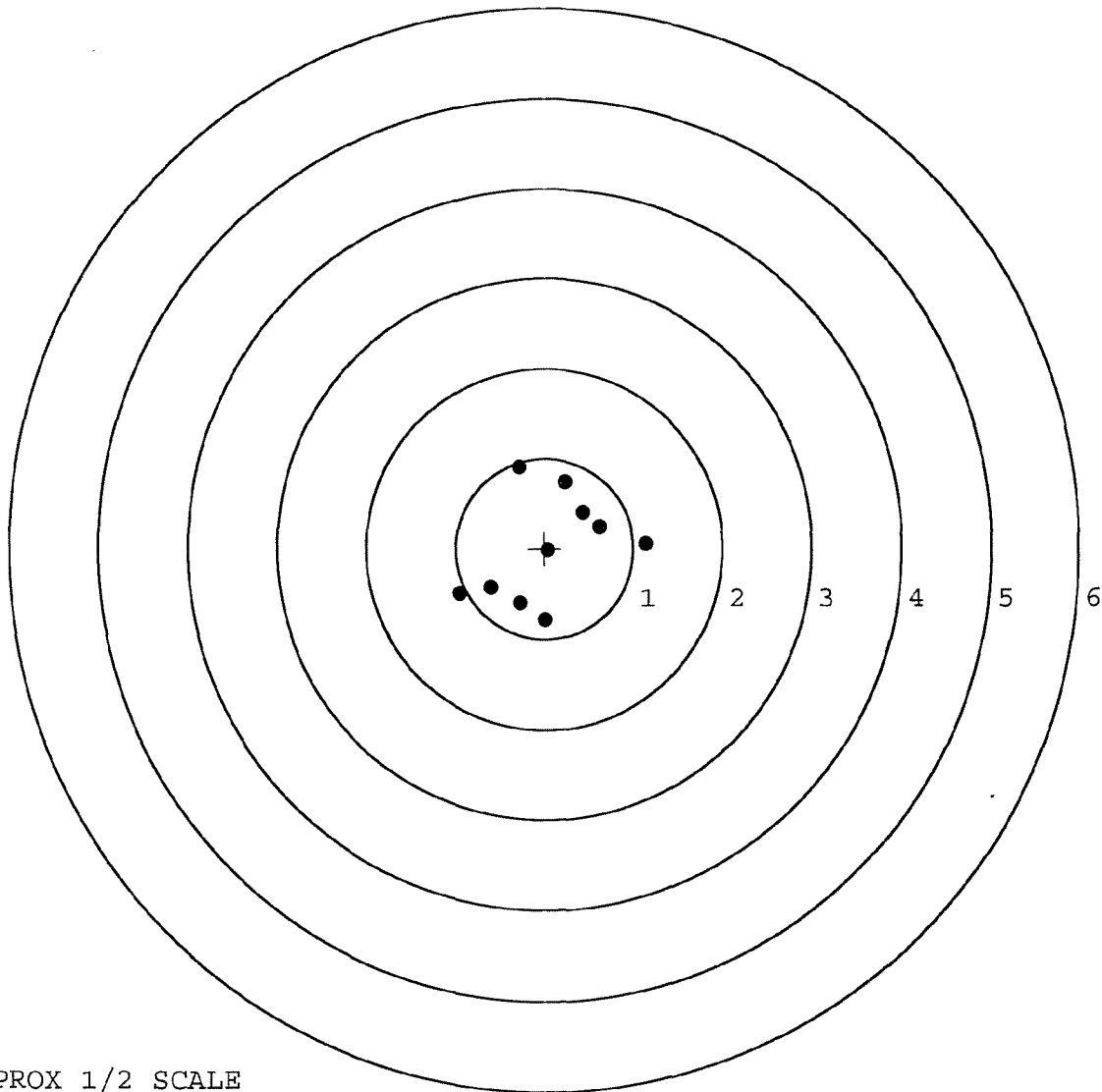


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414345. __1
TARGET NUMBER: 4
FILE DATE: 10/07/2005
FILE TIME: 08:38

X CENTROID: 0.032
Y CENTROID: -0.003
POA TO CENTROID: 0.032
HORZ SPREAD: 2.099
VERT SPREAD: 1.700
GROUP SPREAD: 2.171
MIN RADIUS: 0.023
MAX RADIUS: 1.112
MEAN RADIUS: 0.744
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.002	-0.796
2:	-0.281	-0.613
3:	-0.613	-0.436
4:	-0.956	-0.505
5:	1.143	0.051
6:	0.615	0.242
7:	0.432	0.406
8:	0.233	0.744
9:	-0.293	0.904
10:	0.038	-0.025



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414345.___1

TARGET NUMBER: 5

FILE DATE: 10/07/2005

FILE TIME: 08:38

X CENTROID: -0.031

Y CENTROID: -0.043

POA TO CENTROID: 0.053

HORZ SPREAD: 1.948

VERT SPREAD: 2.880

GROUP SPREAD: 2.937

MIN RADIUS: 0.208

MAX RADIUS: 2.053

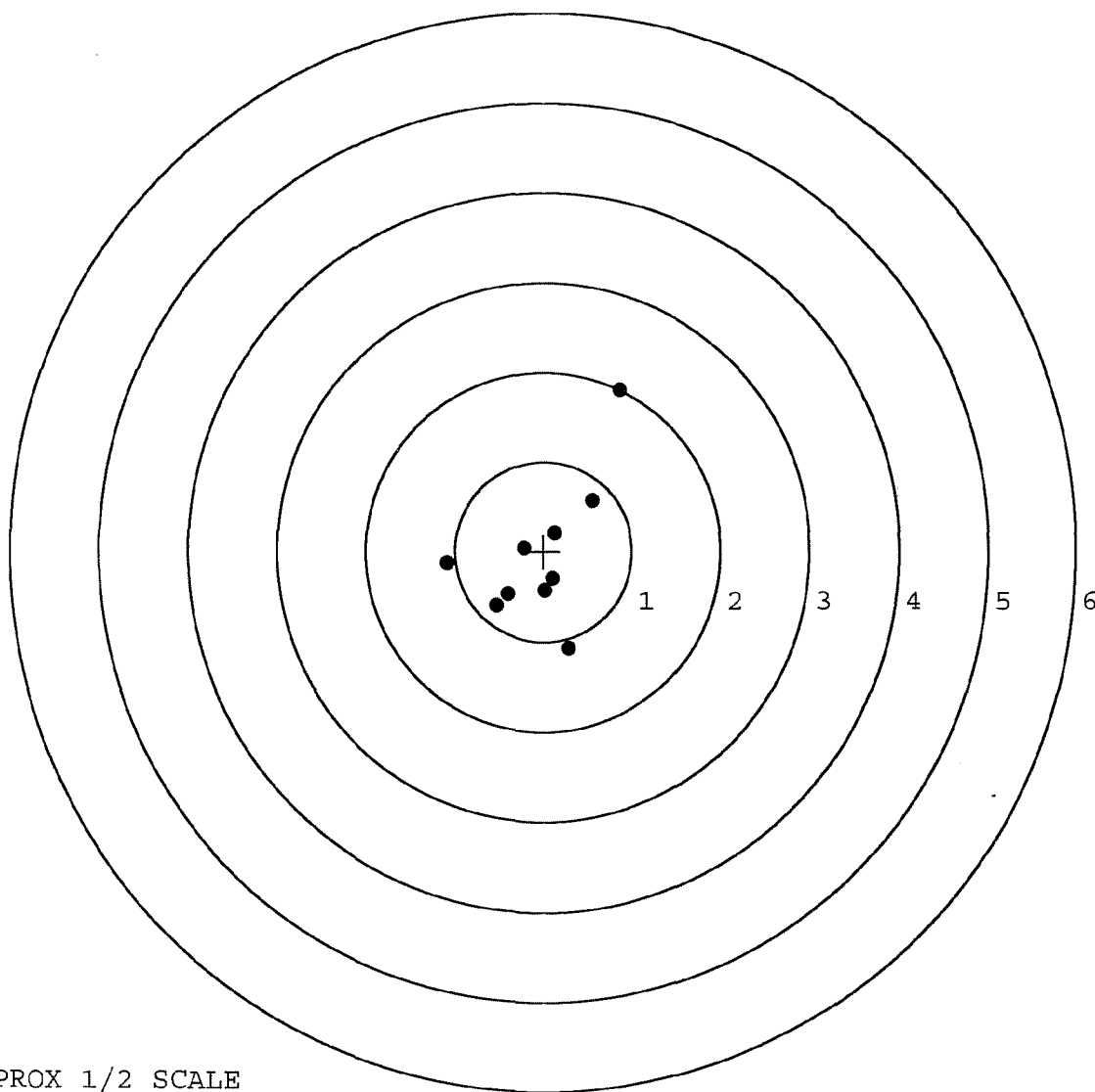
MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.285	-1.074
2:	-1.087	-0.138
3:	0.551	0.561
4:	0.129	0.200
5:	-0.224	0.034
6:	0.106	-0.302
7:	0.019	-0.439
8:	-0.411	-0.477
9:	-0.537	-0.602
10:	0.861	1.806



TARGET APPROX 1/2 SCALE