

G646/554

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



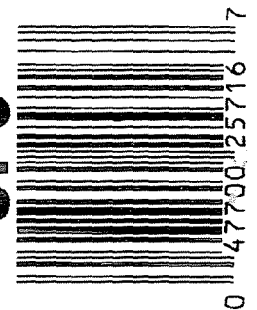
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461554

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
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SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6461554

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-4-05	RTZ
440	PROOF		10-5-05	BG
460	CHECK HEADSPACE	MAGNA-FLUX "DETECTED"	10-5-05	BG
470	DIS-ASSEMBLE ACTION		10-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>mmf</u>	10/10/05	<u>mmf</u>
500	ROLLMARK CALIBER		10-10-05	CW
510	DRILL AND TAP SIGHT HOLES		11-7-05	TRLW
520	GOFF BLAST BBL / REC		10-14-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/19/05	RB
	(BOLT)		10/19/05	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10/26/05	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/26/05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/26/05	MTM
	D) OIL FIRING PIN ASSEMBLY		10-27-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-16-05	BG
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>5.5</u> <u>5.5</u>	11/15/05	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.2</u>	11/15/05	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1024</u> <u>1024</u> <u>1022</u>	11/15/05	RA
	J) ASSEMBLE STOCK		10-27-05	RTL
	K) ASSEMBLE SWIVEL STUDS		12-16-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-13-05	A
	M) IRON SIGHT ALIGNMENT		12-15-05	A
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-15-05	A
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/28/05	MJD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/28/05	MJM
670	FINAL INSPECTION A) HEADSPACE		12-16-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.52</u> <u>2.45</u> <u>2.47</u> <u>2.42</u>	11-8-05	BG
	C) FUNCTION		12-16-05	BG
690	PACK		1-6-06	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.

DATE 10-27-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.61	2.49		2.60	
PULL #2	2.51	2.53		2.59	
PULL #3	2.53	2.64		2.42	
PULL #4	2.55	2.56		2.52	
PULL #5	2.50	2.58		2.44	
TOTAL	12.70	12.80		12.57	
AVERAGE	2.54	2.56		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.13		
PULL #2	2.97	3.14		
PULL #3	3.12	3.22		
PULL #4	3.01	3.21		
PULL #5	3.21	3.15		
TOTAL	15.32	15.85		
AVERAGE	3.06	3.17		

	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	4.18	4.19		4.17
PULL #2	4.07	4.18		4.04
PULL #3	3.90	4.10		4.07
PULL #4	4.17	4.22		4.03
PULL #5	4.12	4.20		4.03
TOTAL	20.44	20.89		20.34
AVERAGE	4.08	4.17		4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461554.___1

FILE DATE AND TIME: 10/28/2005 17:50

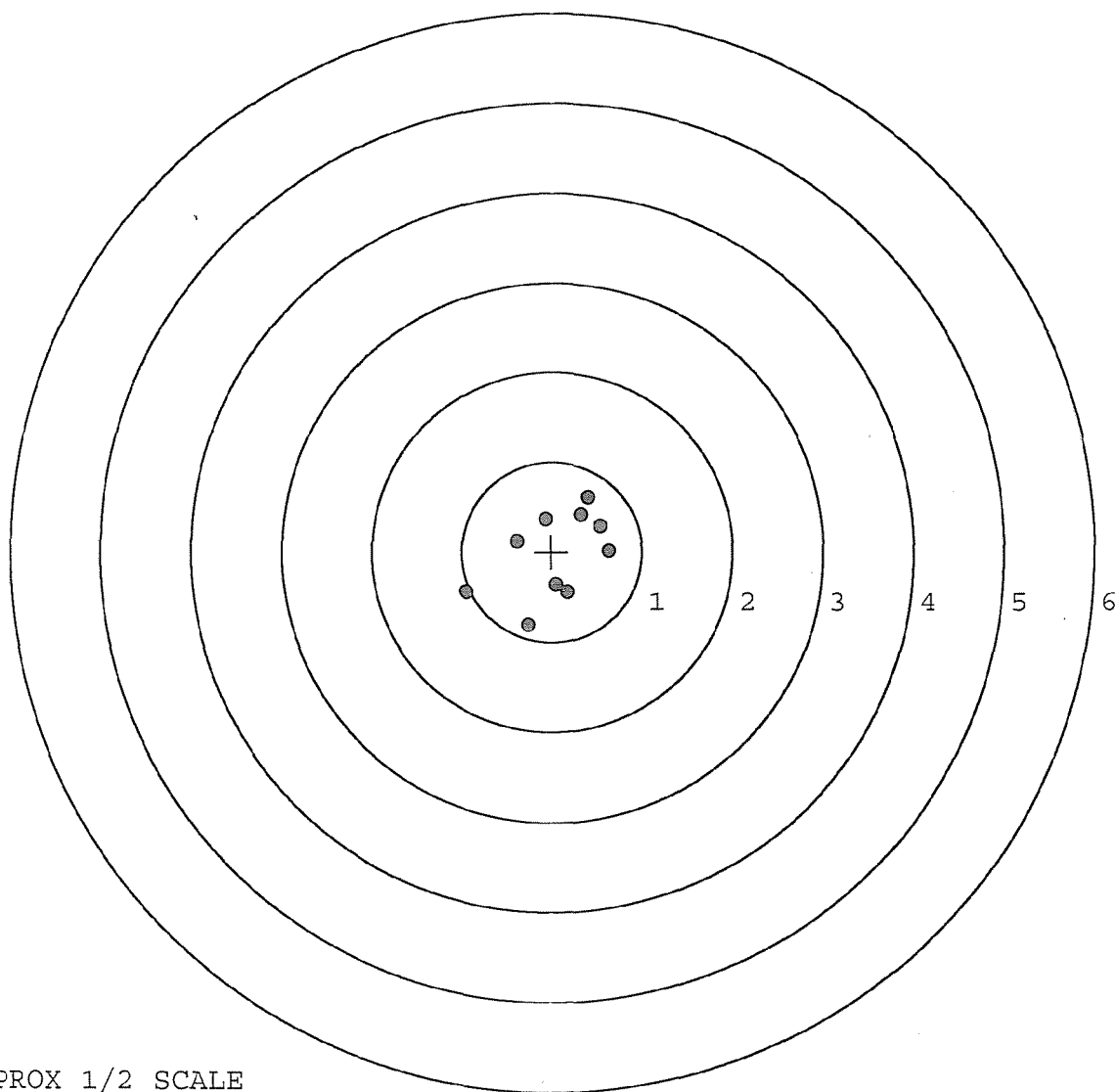
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.097
The Average Y Centroid of the Five Target Set:	-0.099
The Average Point of Impact of the Five Target Set:	0.138
The Average Mean Radius of the Five Target Set:	0.678
The Distance from POA to Centroid Target #1:	0.052
The Distance from Centroid Target #2 to Centroid Target #1:	0.292
The Distance from Centroid Target #3 to Centroid Target #1:	0.226
The Distance from Centroid Target #4 to Centroid Target #1:	0.131
The Distance from Centroid Target #5 to Centroid Target #1:	0.165

SERIAL NUMBER: G6461554. __1
TARGET NUMBER: 1
FILE DATE: 10/28/2005
FILE TIME: 17:50

POINT#	X	Y
1:	0.406	0.609
2:	0.323	0.418
3:	0.538	0.292
4:	0.637	0.016
5:	0.176	-0.452
6:	-0.072	0.365
7:	-0.387	0.117
8:	-0.953	-0.441
9:	-0.265	-0.817
10:	0.048	-0.369

X CENTROID: 0.045
Y CENTROID: -0.026
POA TO CENTROID: 0.052
HORZ SPREAD: 1.590
VERT SPREAD: 1.426
GROUP SPREAD: 1.717
MIN RADIUS: 0.343
MAX RADIUS: 1.081
MEAN RADIUS: 0.602
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

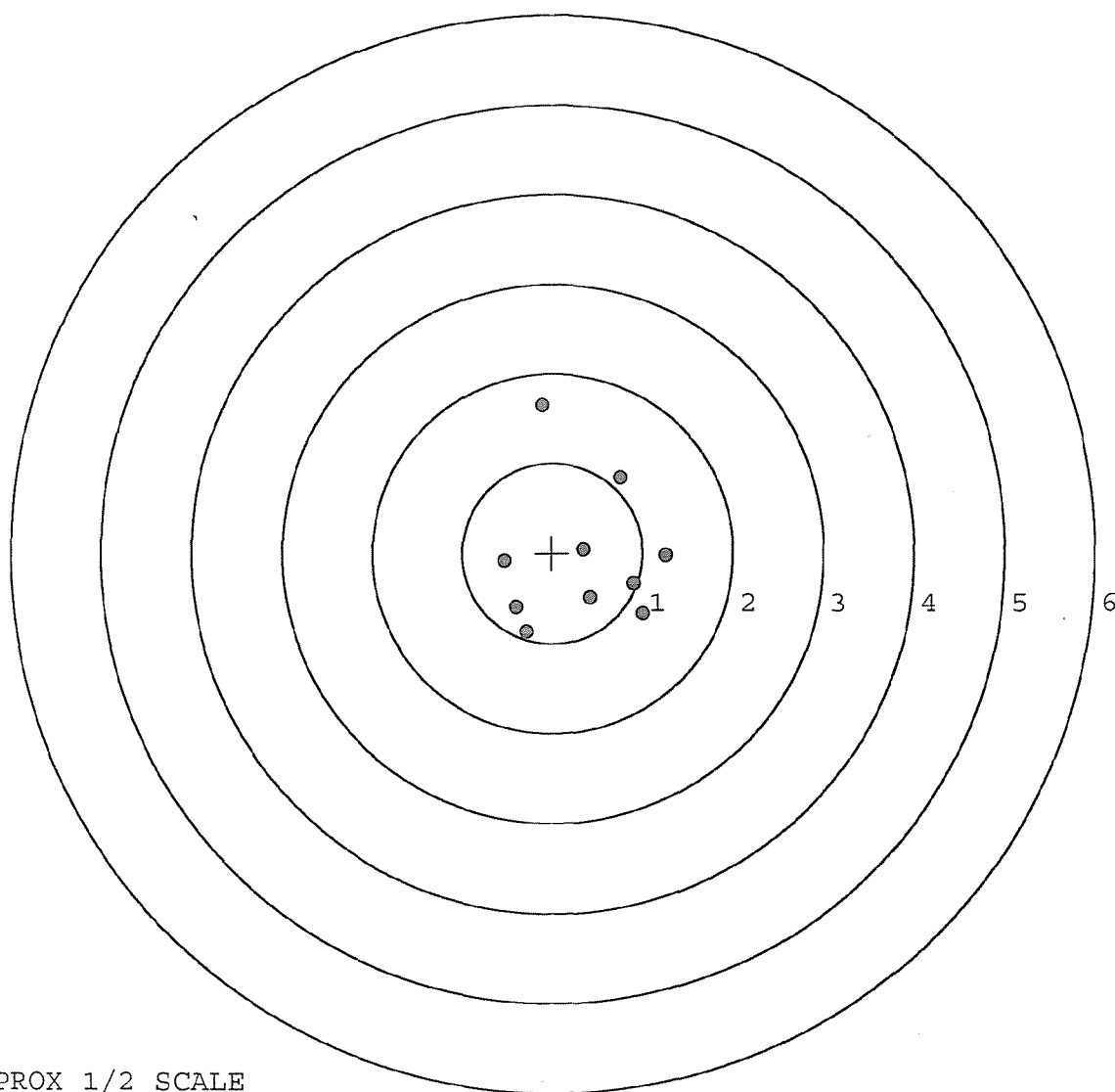


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461554. __1
TARGET NUMBER: 2
FILE DATE: 10/28/2005
FILE TIME: 17:50

POINT#	X	Y
1:	0.348	0.043
2:	0.422	-0.498
3:	0.906	-0.341
4:	1.006	-0.680
5:	1.260	-0.031
6:	0.754	0.838
7:	-0.118	1.643
8:	-0.532	-0.093
9:	-0.400	-0.603
10:	-0.293	-0.874

X CENTROID: 0.335
Y CENTROID: -0.060
POA TO CENTROID: 0.341
HORZ SPREAD: 1.792
VERT SPREAD: 2.517
GROUP SPREAD: 2.581
MIN RADIUS: 0.103
MAX RADIUS: 1.762
MEAN RADIUS: 0.859
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

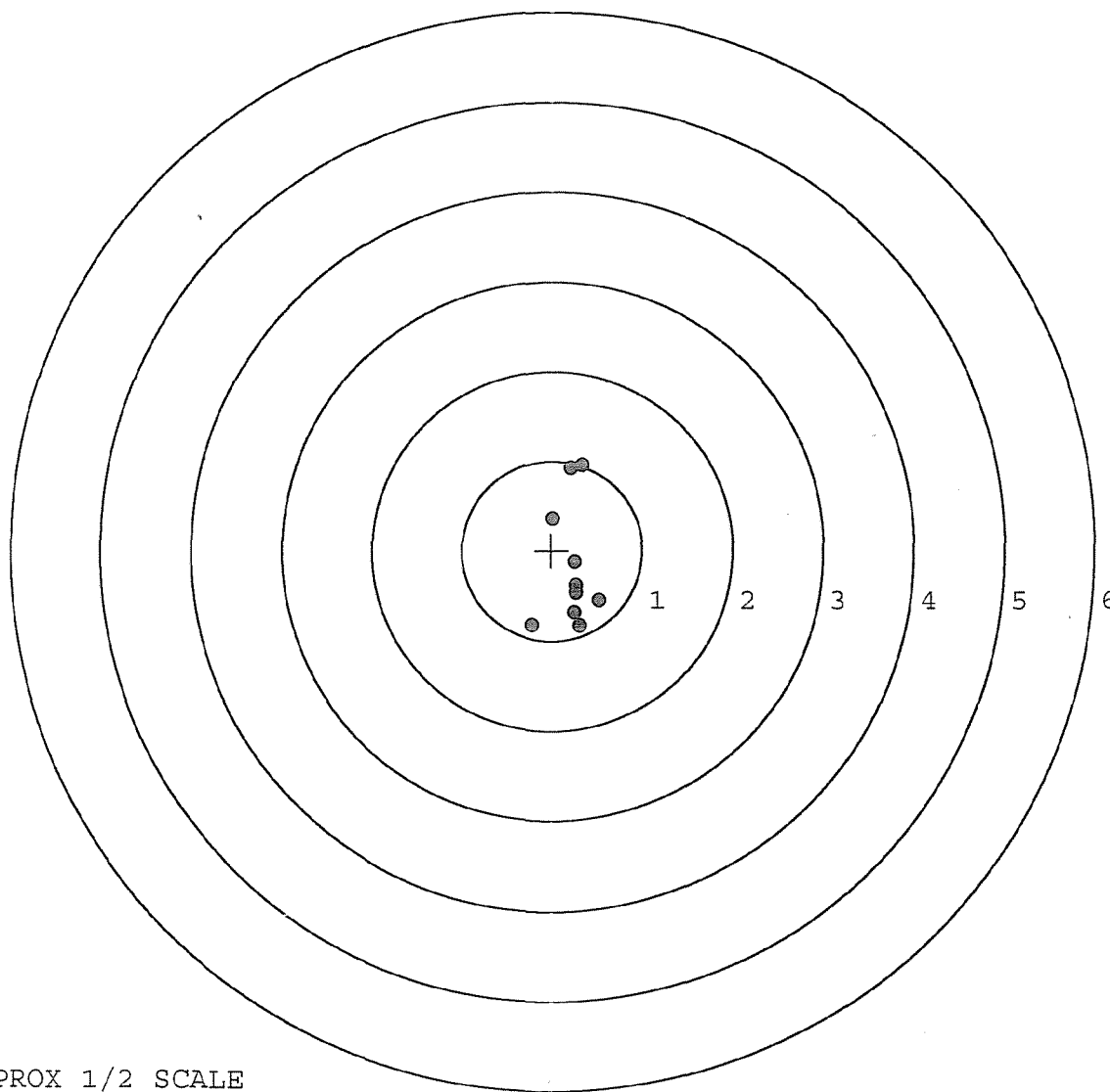


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461554. __1
TARGET NUMBER: 3
FILE DATE: 10/28/2005
FILE TIME: 17:50

POINT#	X	Y
1:	0.340	0.956
2:	0.209	0.924
3:	0.012	0.358
4:	0.260	-0.130
5:	0.268	-0.390
6:	0.251	-0.689
7:	0.526	-0.555
8:	0.310	-0.837
9:	-0.226	-0.833
10:	0.272	-0.473

X CENTROID: 0.222
Y CENTROID: -0.167
POA TO CENTROID: 0.278
HORZ SPREAD: 0.752
VERT SPREAD: 1.793
GROUP SPREAD: 1.876
MIN RADIUS: 0.053
MAX RADIUS: 1.129
MEAN RADIUS: 0.587
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461554. __1

TARGET NUMBER: 4

FILE DATE: 10/28/2005

FILE TIME: 17:50

POINT#	X	Y
1:	0.088	0.518
2:	0.143	1.227
3:	-0.503	0.188
4:	-1.038	-0.026
5:	-0.250	-0.388
6:	-0.018	-0.471
7:	0.120	-1.052
8:	0.468	-1.093
9:	0.649	-0.266
10:	0.201	-0.066

X CENTROID: -0.014

Y CENTROID: -0.143

POA TO CENTROID: 0.144

HORZ SPREAD: 1.687

VERT SPREAD: 2.320

GROUP SPREAD: 2.343

MIN RADIUS: 0.228

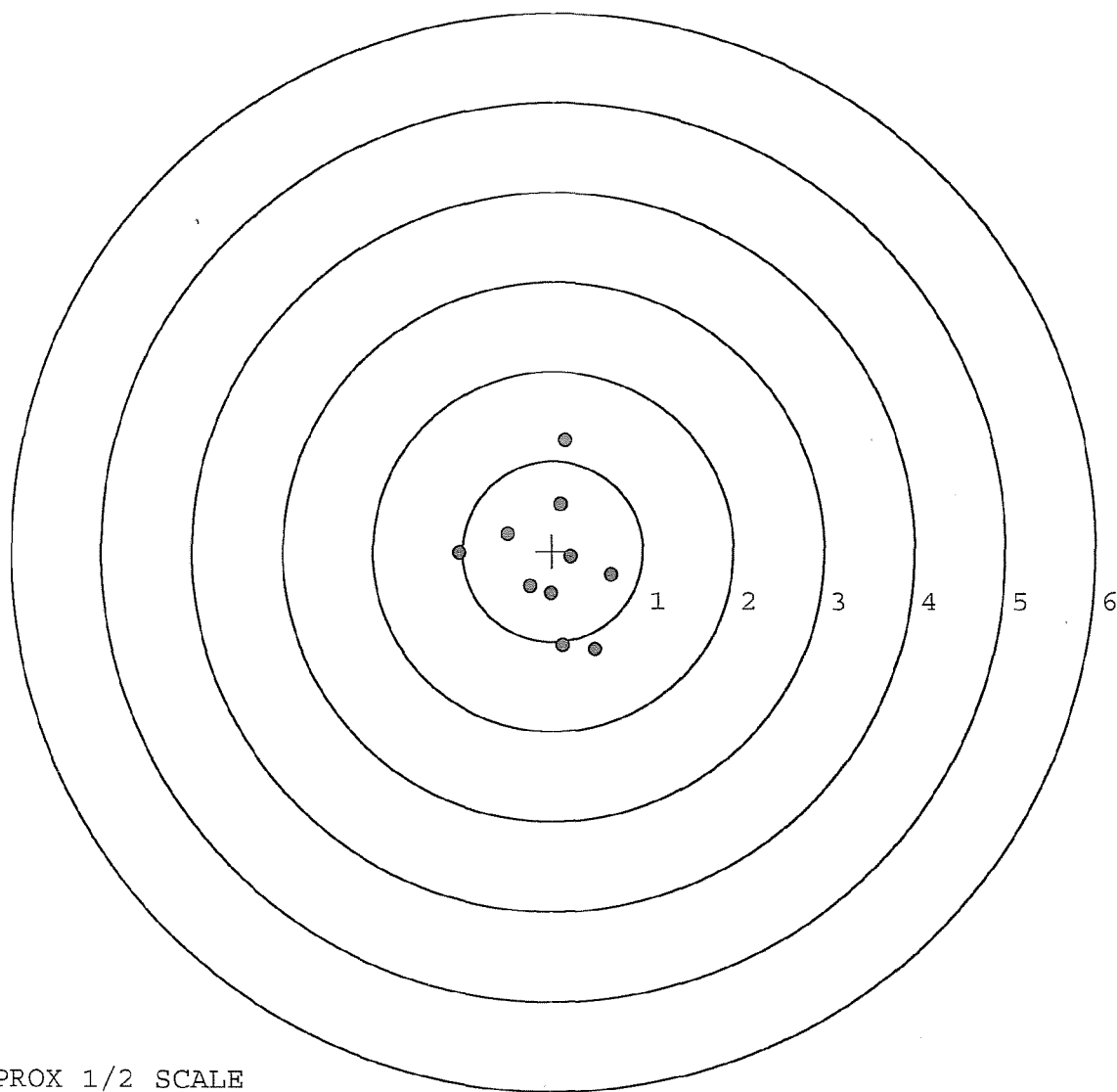
MAX RADIUS: 1.379

MEAN RADIUS: 0.722

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

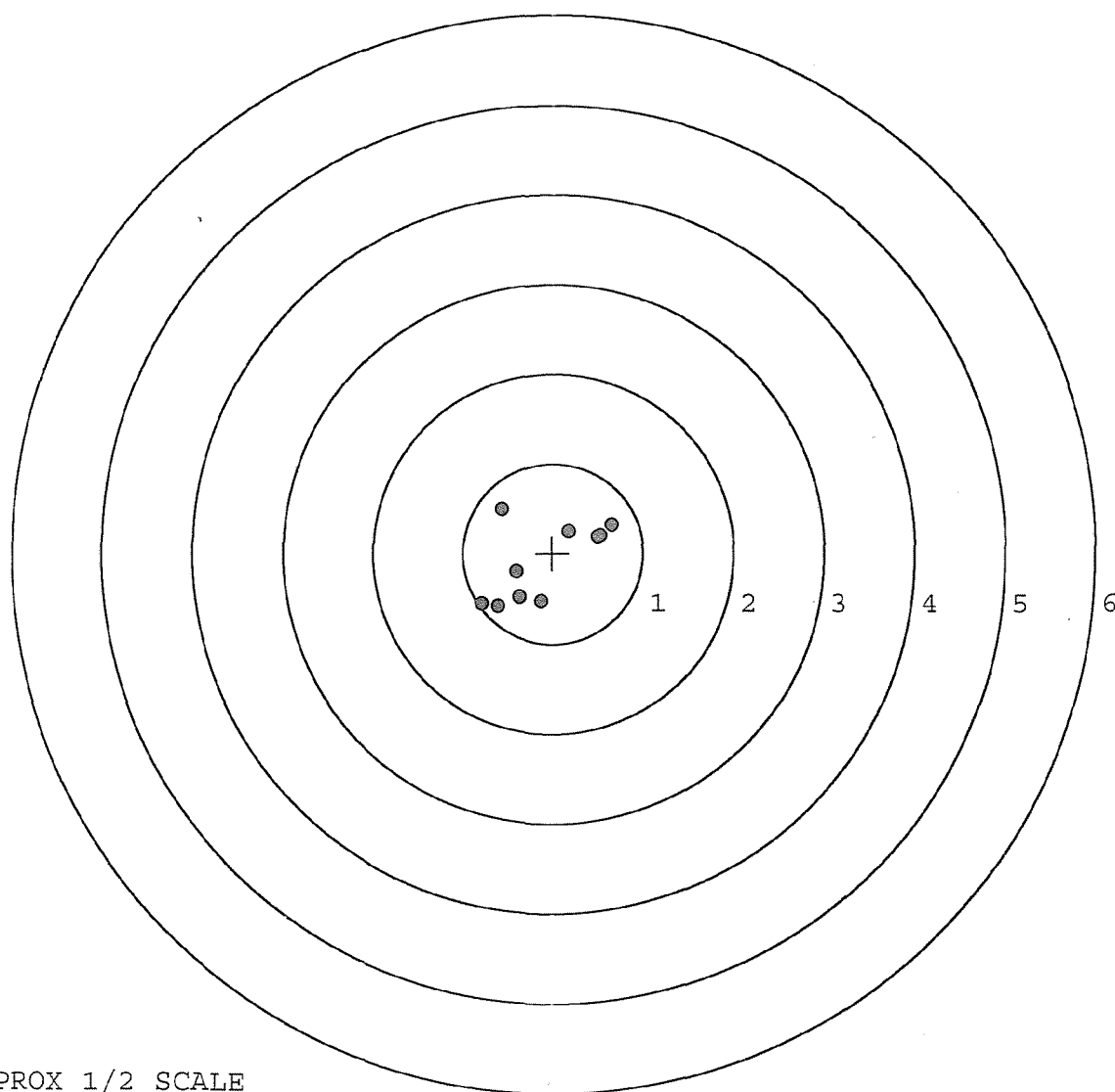


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461554. __1
TARGET NUMBER: 5
FILE DATE: 10/28/2005
FILE TIME: 17:50

POINT#	X	Y
1:	-0.403	-0.209
2:	-0.130	-0.539
3:	-0.371	-0.493
4:	-0.608	-0.592
5:	-0.790	-0.562
6:	-0.573	0.487
7:	0.174	0.245
8:	0.494	0.183
9:	0.649	0.316
10:	0.523	0.194

X CENTROID: -0.103
Y CENTROID: -0.097
POA TO CENTROID: 0.142
HORZ SPREAD: 1.439
VERT SPREAD: 1.079
GROUP SPREAD: 1.686
MIN RADIUS: 0.320
MAX RADIUS: 0.858
MEAN RADIUS: 0.618
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE