

G 646 1577

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



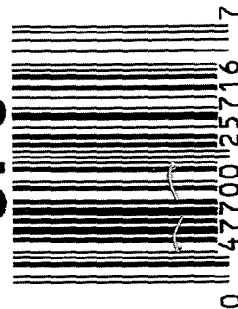
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461577

UPC



DD FORM

ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6461577

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/1/05	CD
440	PROOF		11/1/05	CD
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	11/1/05	CD
470	DIS-ASSEMBLE ACTION	JAN 15 2006	11/1/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <i>umt</i>	1/5/06	<i>umt</i>
500	ROLLMARK CALIBER		1/5/06	CW
510	DRILL AND TAP SIGHT HOLES		1-5-06	BR
520	GOFF BLAST BBL / REC		1-5-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		1/6/06	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-9-06	<i>Ac</i>
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-9-06	<i>Ac</i>
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-9-06	<i>Ac</i>
	D) OIL FIRING PIN ASSEMBLY		1-9-06	<i>Ac</i>
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1-11-06	<i>TAV</i>

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.25</u> <u>6.5</u> <u>6.5</u>	1-11-06	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	1-11-06	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY		1-20-06	Ac
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-11-06	TRW
	J) ASSEMBLE STOCK		1-10-06	BG
	K) ASSEMBLE SWIVEL STUDS		1-20-06	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1-10-06	BG
	M) IRON SIGHT ALIGNMENT		1-10-06	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1-10-06	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1-10-06	WJH
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1/10/06	mgg
670	FINAL INSPECTION A) HEADSPACE		1-20-06	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.42</u> <u>2.64</u> <u>2.67</u> <u>2.69</u>	1-11-06	TRW
	C) FUNCTION		1-20-06	Ac
690	PACK		2-3-06	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)

SERIAL NO. _____

DATE 1-9-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.55	2.53		2.34	
PULL #2	2.59	2.43		2.48	
PULL #3	2.39	2.33		2.46	
PULL #4	2.68	2.35		2.33	
PULL #5	2.58	2.48		2.49	
TOTAL	12.79	12.12		12.10	
AVERAGE	2.55	2.42		2.42	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.24		
PULL #2	2.98	3.18		
PULL #3	3.10	3.15		
PULL #4	2.84	3.10		
PULL #5	3.00	3.24		
TOTAL	14.96	15.91		
AVERAGE	2.99	3.18		

	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	4.08		4.14
PULL #2	4.32	3.87		4.08
PULL #3	4.14	3.89		3.81
PULL #4	4.17	4.19		4.06
PULL #5	3.94	4.17		4.15
TOTAL	20.73	20.20		20.24
AVERAGE	4.14	4.04		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461577.___0

FILE DATE AND TIME: 01/10/2006 23:03

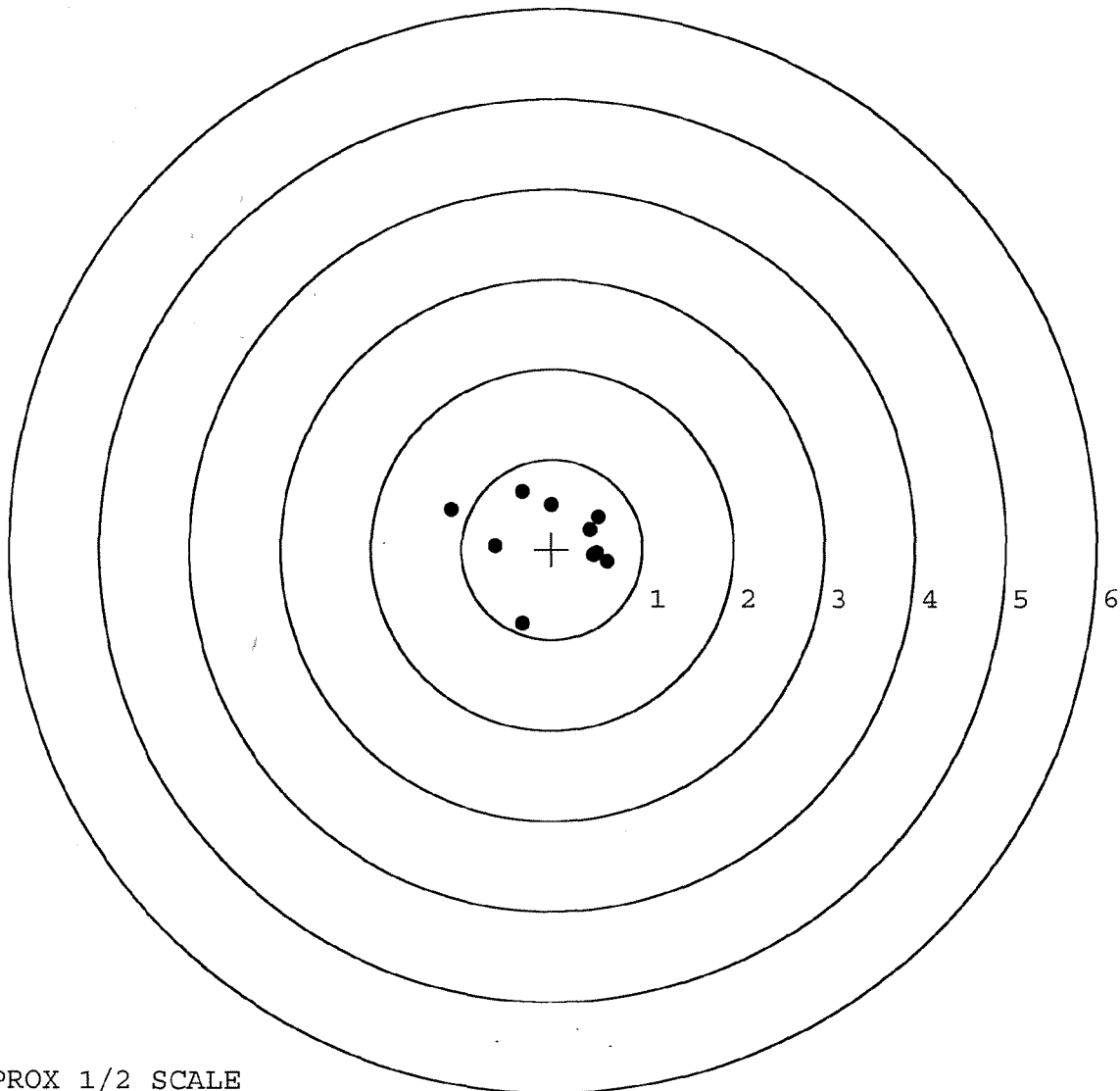
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.028
The Average Y Centroid of the Five Target Set:	0.055
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.661
The Distance from POA to Centroid Target #1:	0.115
The Distance from Centroid Target #2 to Centroid Target #1:	0.206
The Distance from Centroid Target #3 to Centroid Target #1:	0.087
The Distance from Centroid Target #4 to Centroid Target #1:	0.072
The Distance from Centroid Target #5 to Centroid Target #1:	0.195

SERIAL NUMBER: G6461577. 0
TARGET NUMBER: 1
FILE DATE: 01/10/2006
FILE TIME: 23:03

X CENTROID: 0.010
Y CENTROID: 0.115
POA TO CENTROID: 0.115
HORZ SPREAD: 1.733
VERT SPREAD: 1.473
GROUP SPREAD: 1.826
MIN RADIUS: 0.384
MAX RADIUS: 1.170
MEAN RADIUS: 0.645
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.114	0.440
2:	-0.625	0.041
3:	-0.328	0.642
4:	-0.008	0.498
5:	0.508	0.365
6:	0.463	-0.061
7:	0.619	-0.135
8:	0.496	-0.040
9:	-0.324	-0.831
10:	0.414	0.226



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461577. 0

TARGET NUMBER: 2

FILE DATE: 01/10/2006

FILE TIME: 23:03

POINT#	X	Y
1:	-0.963	-0.301
2:	-0.477	-0.130
3:	-0.078	0.052
4:	0.055	0.279
5:	0.099	-0.132
6:	0.467	-0.151
7:	0.453	-0.347
8:	0.415	-0.538
9:	1.262	0.670
10:	0.009	0.030

X CENTROID: 0.124

Y CENTROID: -0.057

POA TO CENTROID: 0.137

HORZ SPREAD: 2.225

VERT SPREAD: 1.208

GROUP SPREAD: 2.428

MIN RADIUS: 0.079

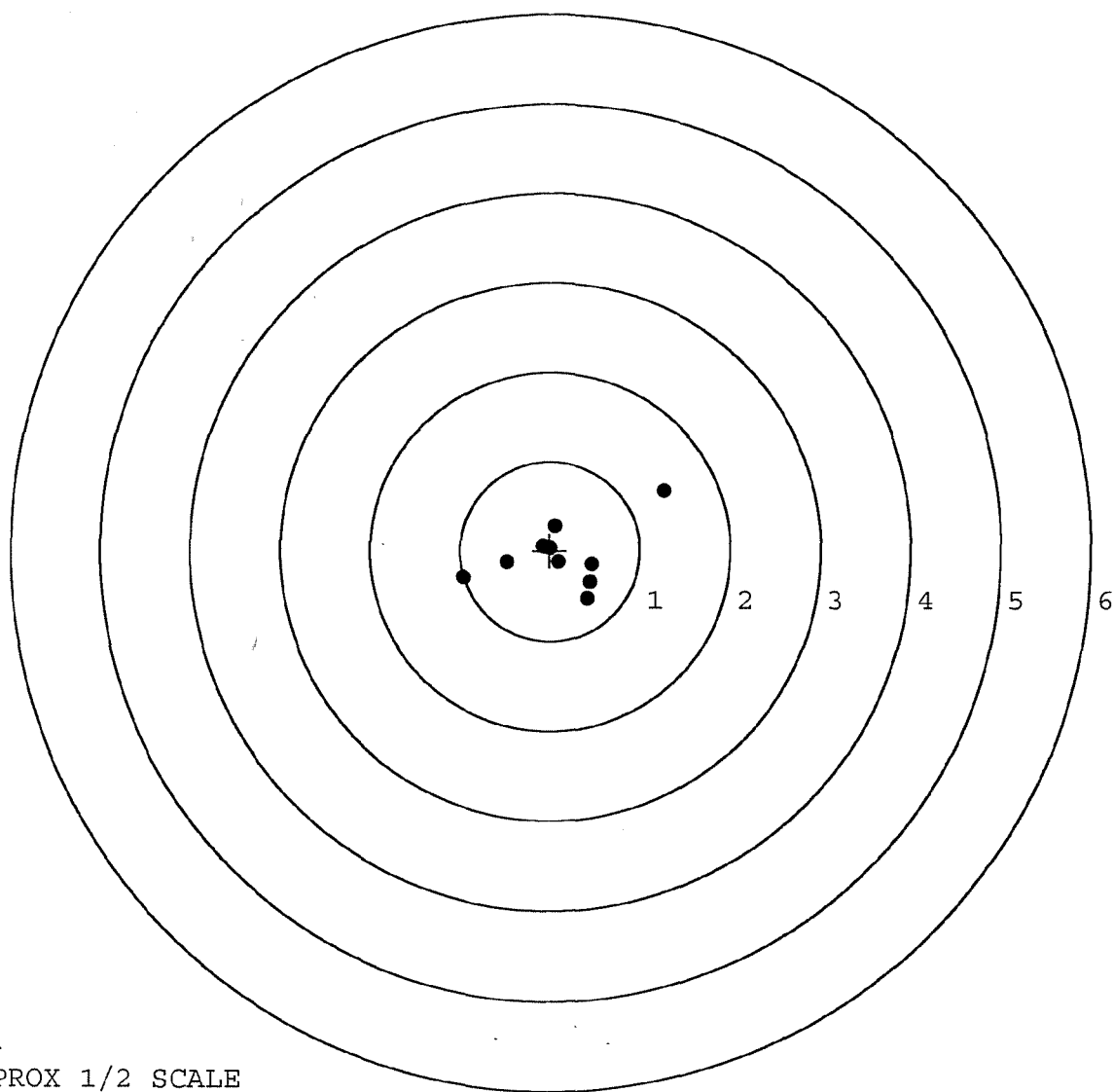
MAX RADIUS: 1.350

MEAN RADIUS: 0.522

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

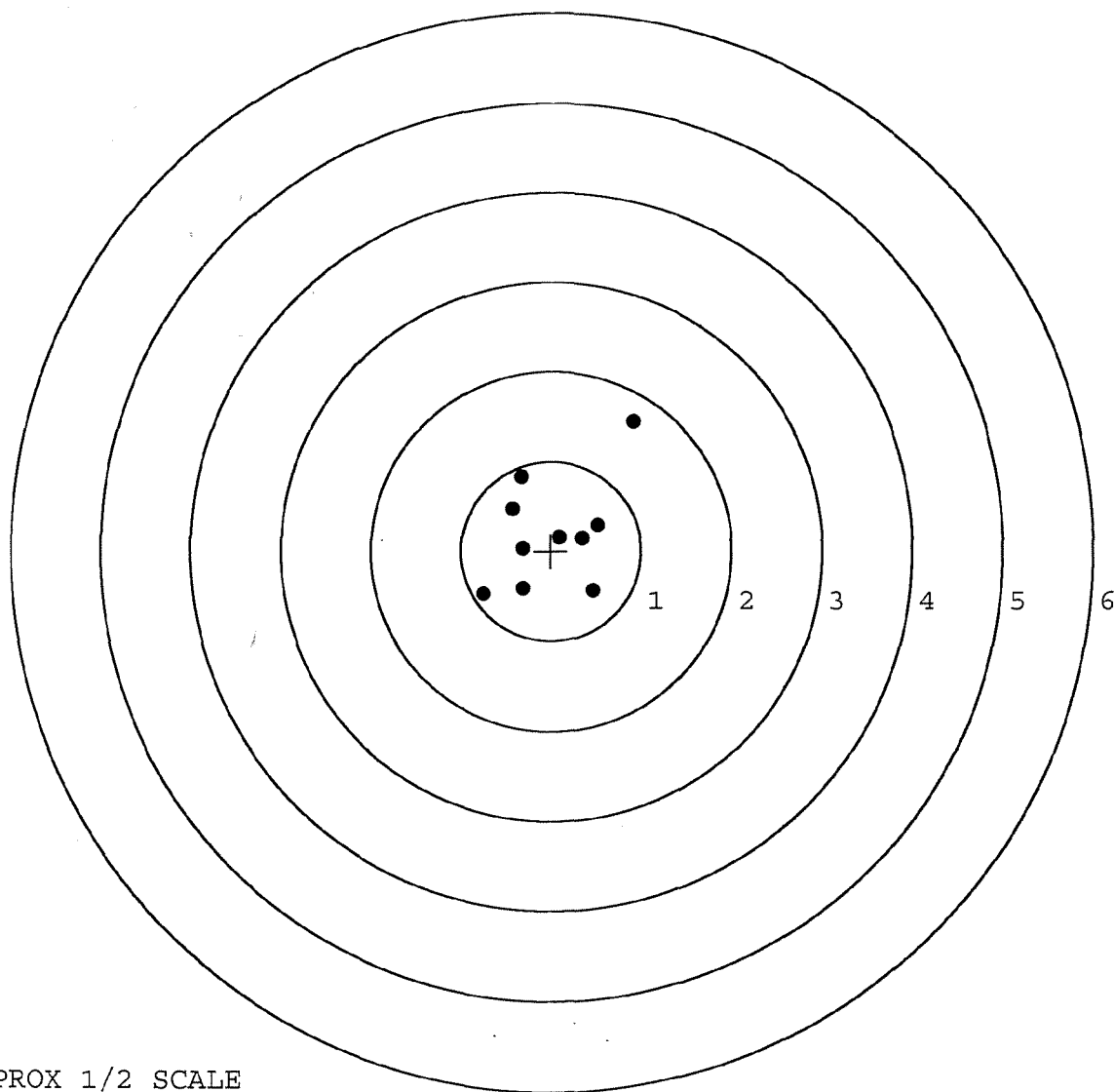


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461577. __0
TARGET NUMBER: 3
FILE DATE: 01/10/2006
FILE TIME: 23:03

POINT#	X	Y
1:	-0.331	0.830
2:	-0.429	0.470
3:	-0.310	0.030
4:	-0.312	-0.420
5:	-0.751	-0.484
6:	0.099	0.153
7:	0.353	0.142
8:	0.519	0.287
9:	0.470	-0.444
10:	0.907	1.444

X CENTROID: 0.022
Y CENTROID: 0.201
POA TO CENTROID: 0.202
HORZ SPREAD: 1.658
VERT SPREAD: 1.928
GROUP SPREAD: 2.543
MIN RADIUS: 0.091
MAX RADIUS: 1.526
MEAN RADIUS: 0.660
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461577. __0

TARGET NUMBER: 4

FILE DATE: 01/10/2006

FILE TIME: 23:03

POINT#	X	Y
1:	-0.170	-0.166
2:	0.000	-0.469
3:	0.293	-0.340
4:	-0.432	0.479
5:	-0.504	0.710
6:	-0.498	0.964
7:	0.287	1.215
8:	0.243	-1.212
9:	0.702	-1.011
10:	-0.500	0.753

X CENTROID: -0.058

Y CENTROID: 0.092

POA TO CENTROID: 0.109

HORZ SPREAD: 1.206

VERT SPREAD: 2.427

GROUP SPREAD: 2.311

MIN RADIUS: 0.282

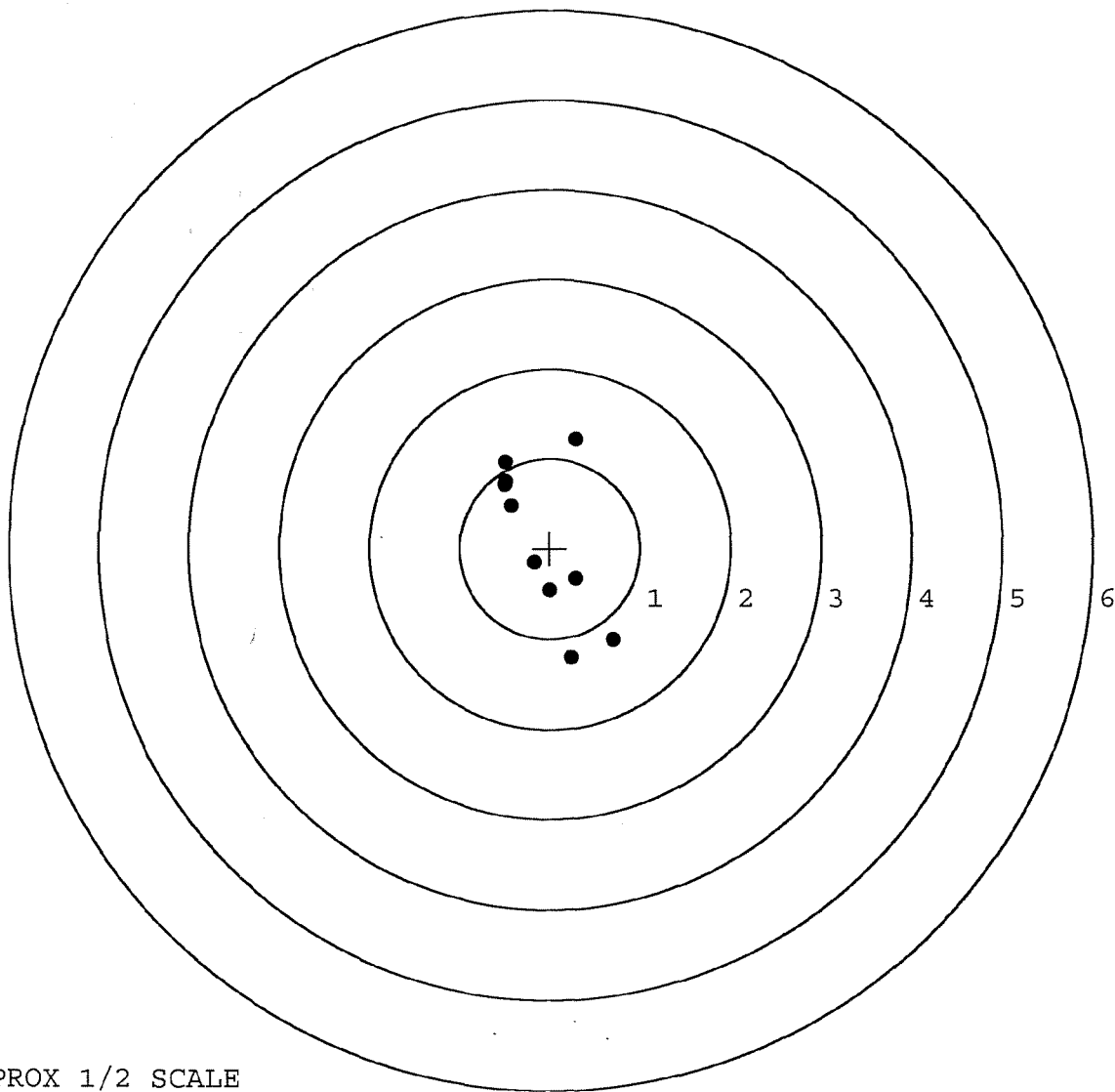
MAX RADIUS: 1.340

MEAN RADIUS: 0.833

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

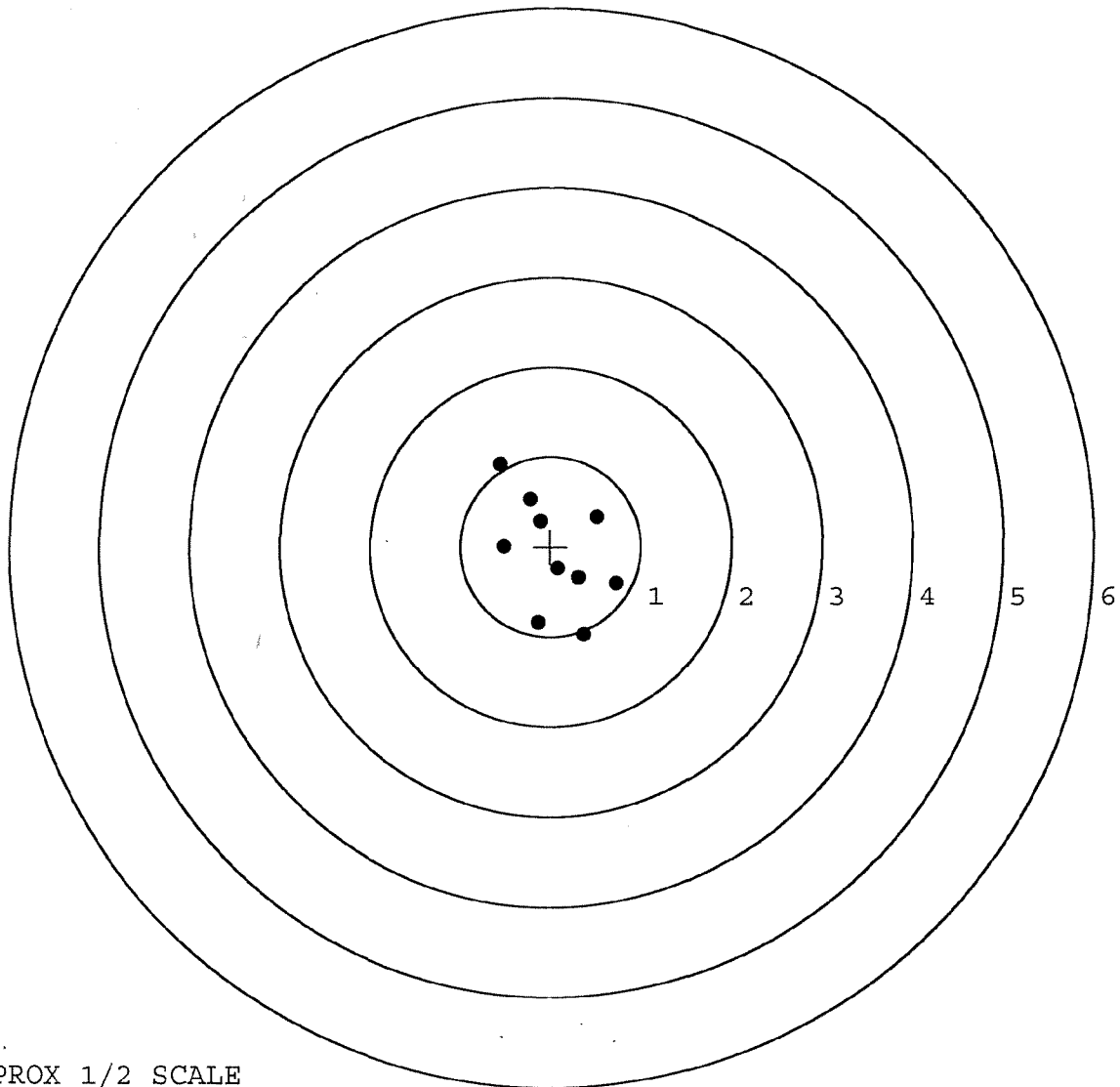


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461577. __0
TARGET NUMBER: 5
FILE DATE: 01/10/2006
FILE TIME: 23:03

POINT#	X	Y
1:	-0.560	0.916
2:	-0.231	0.525
3:	-0.116	0.282
4:	-0.515	0.013
5:	0.082	-0.244
6:	0.309	-0.346
7:	0.727	-0.412
8:	0.509	0.327
9:	0.367	-0.985
10:	-0.137	-0.853

X CENTROID: 0.044
Y CENTROID: -0.078
POA TO CENTROID: 0.089
HORZ SPREAD: 1.287
VERT SPREAD: 1.901
GROUP SPREAD: 2.115
MIN RADIUS: 0.171
MAX RADIUS: 1.163
MEAN RADIUS: 0.647
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE