

G 646 1582

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



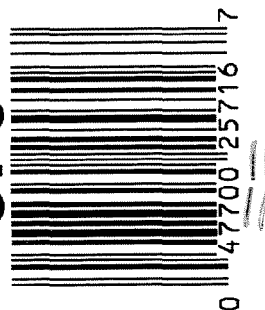
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461582

UPC



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

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SERIAL NO.



G6461582

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6461582

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10/14/05	CD
440	PROOF		10/14/05	CD
460	CHECK HEADSPACE		10/14/05	CD
470	DIS-ASSEMBLE ACTION		10/14/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 <i>uns</i>	10/18/05	<i>uns</i>
500	ROLLMARK CALIBER		10/18/05	CW
510	DRILL AND TAP SIGHT HOLES		10/17/05	BR
520	GOFF BLAST BBL / REC		10-21-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		11/1/05	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		11/2/05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/2/05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/2/05	MTM
	D) OIL FIRING PIN ASSEMBLY		11-7-05	RJR
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5 lb</u> <u>5 lb</u> <u>5 lb</u>	11-16-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lb</u> <u>2 lb</u> <u>2 lb</u>	11-16-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	11-16-05	BC
	J) ASSEMBLE STOCK		11-7-05	RJL
	K) ASSEMBLE SWIVEL STUDS		11-16-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-16-05	BC
	M) IRON SIGHT ALIGNMENT		11-16-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-16-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11/8/05	mjh
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/8/05	mtm
670	FINAL INSPECTION A) HEADSPACE		11-16-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.83</u> <u>2.52</u> <u>2.98</u> <u>2.74</u>	11-9-05	BC
	C) FUNCTION		11-16-05	BC
690	PACK		11/30/05	DA

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

10-30-05

TESTER

S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.53	2.49		2.40	
PULL #2	2.59	2.45		2.42	
PULL #3	2.53	2.42		2.39	
PULL #4	2.61	2.49		2.40	
PULL #5	2.47	2.46		2.41	
TOTAL	12.75	12.31		12.02	
AVERAGE	2.55	2.46		2.40	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	2.99		
PULL #2	3.25	3.03		
PULL #3	3.14	3.02		
PULL #4	3.28	2.98		
PULL #5	3.15	3.05		
TOTAL	16.05	15.07		
AVERAGE	3.21	3.01		

	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	4.08	4.17		4.10
PULL #2	4.13	4.14		4.18
PULL #3	4.08	4.04		4.16
PULL #4	4.07	4.16		4.10
PULL #5	4.15	4.15		4.11
TOTAL	20.51	20.66		20.65
AVERAGE	4.10	4.13		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461582.__0

FILE DATE AND TIME: 11/08/2005 19:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.010
The Average Y Centroid of the Five Target Set:	0.055
The Average Point of Impact of the Five Target Set:	0.056
The Average Mean Radius of the Five Target Set:	0.830
The Distance from POA to Centroid Target #1:	0.221
The Distance from Centroid Target #2 to Centroid Target #1:	0.401
The Distance from Centroid Target #3 to Centroid Target #1:	0.269
The Distance from Centroid Target #4 to Centroid Target #1:	0.542
The Distance from Centroid Target #5 to Centroid Target #1:	0.246

SERIAL NUMBER: G6461582. 0

TARGET NUMBER: 1

FILE DATE: 11/08/2005

FILE TIME: 19:23

POINT#	X	Y
1:	0.884	0.584
2:	0.784	0.421
3:	0.720	0.246
4:	0.348	-0.117
5:	-0.264	-0.416
6:	-0.093	-0.585
7:	-1.044	-0.642
8:	-0.856	0.116
9:	-0.474	0.806
10:	-2.092	-1.125

X CENTROID: -0.209

Y CENTROID: -0.071

POA TO CENTROID: 0.221

HORZ SPREAD: 2.976

VERT SPREAD: 1.931

GROUP SPREAD: 3.432

MIN RADIUS: 0.349

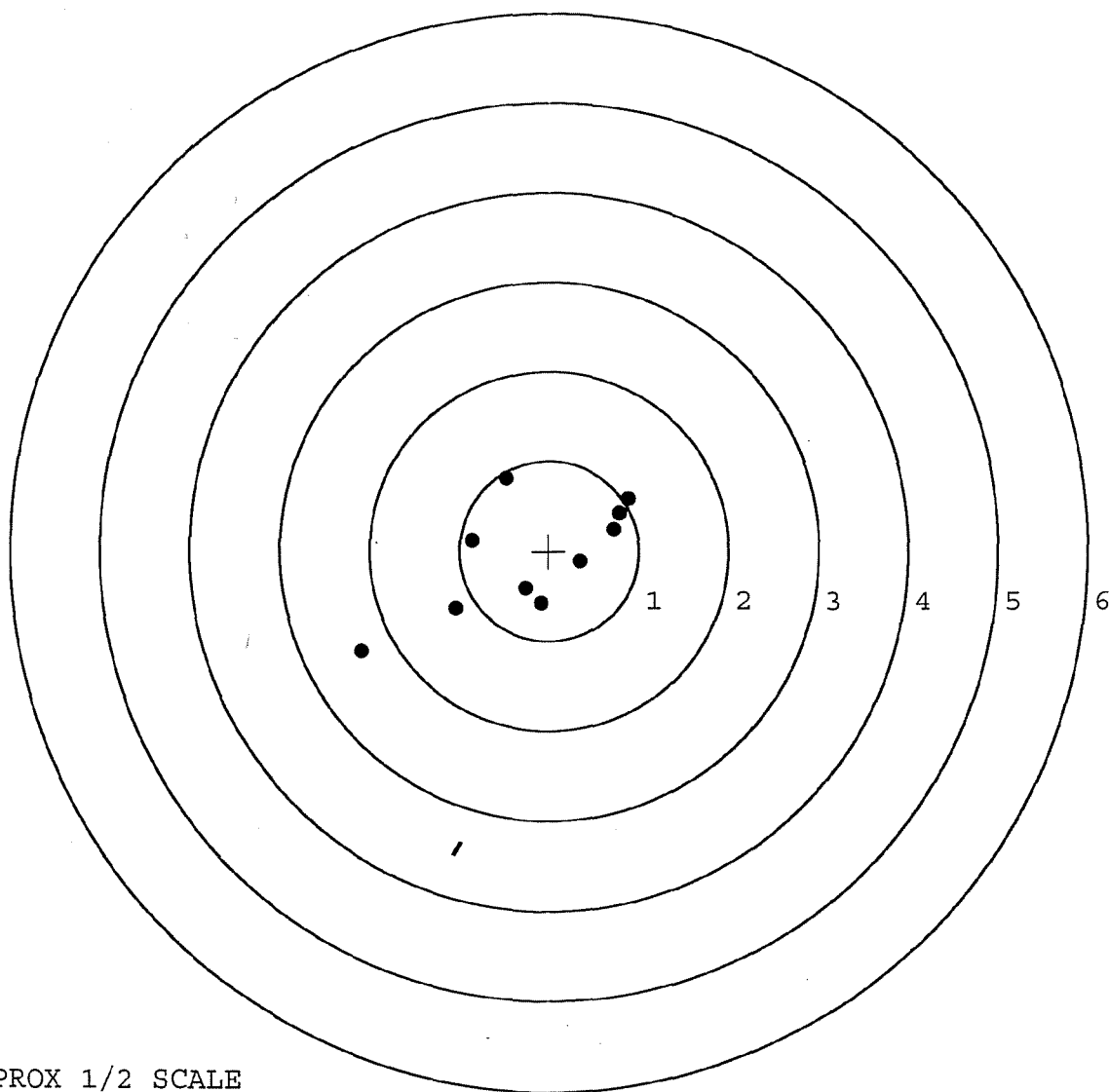
MAX RADIUS: 2.158

MEAN RADIUS: 0.956

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461582. 0

TARGET NUMBER: 2

FILE DATE: 11/08/2005

FILE TIME: 19:23

POINT#	X	Y
1:	0.052	0.221
2:	0.297	-0.150
3:	-0.101	0.497
4:	-0.665	0.383
5:	-1.095	0.850
6:	-0.386	-0.452
7:	0.006	-0.944
8:	1.111	0.382
9:	1.133	0.124
10:	1.363	-0.363

X CENTROID: 0.171

Y CENTROID: 0.055

POA TO CENTROID: 0.180

HORZ SPREAD: 2.458

VERT SPREAD: 1.794

GROUP SPREAD: 2.741

MIN RADIUS: 0.205

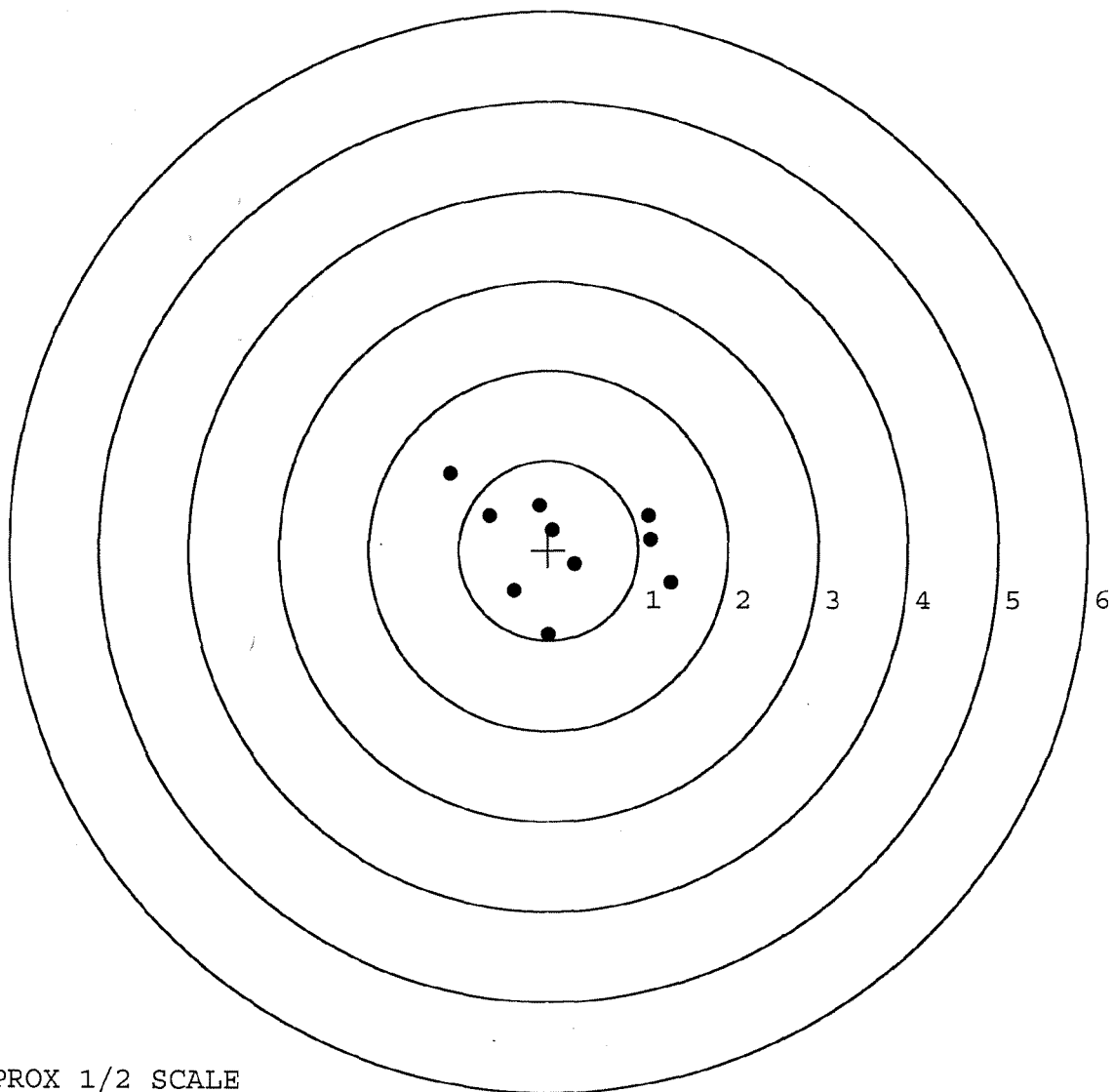
MAX RADIUS: 1.495

MEAN RADIUS: 0.835

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461582. __0

TARGET NUMBER: 3

FILE DATE: 11/08/2005

FILE TIME: 19:23

POINT#	X	Y
1:	0.099	0.404
2:	0.264	0.829
3:	0.004	0.811
4:	-0.257	0.151
5:	-0.412	0.161
6:	-0.856	-0.188
7:	0.809	0.168
8:	-0.081	-0.915
9:	-0.414	-0.804
10:	-0.789	1.318

X CENTROID: -0.163

Y CENTROID: 0.194

POA TO CENTROID: 0.253

HORZ SPREAD: 1.665

VERT SPREAD: 2.233

GROUP SPREAD: 2.343

MIN RADIUS: 0.103

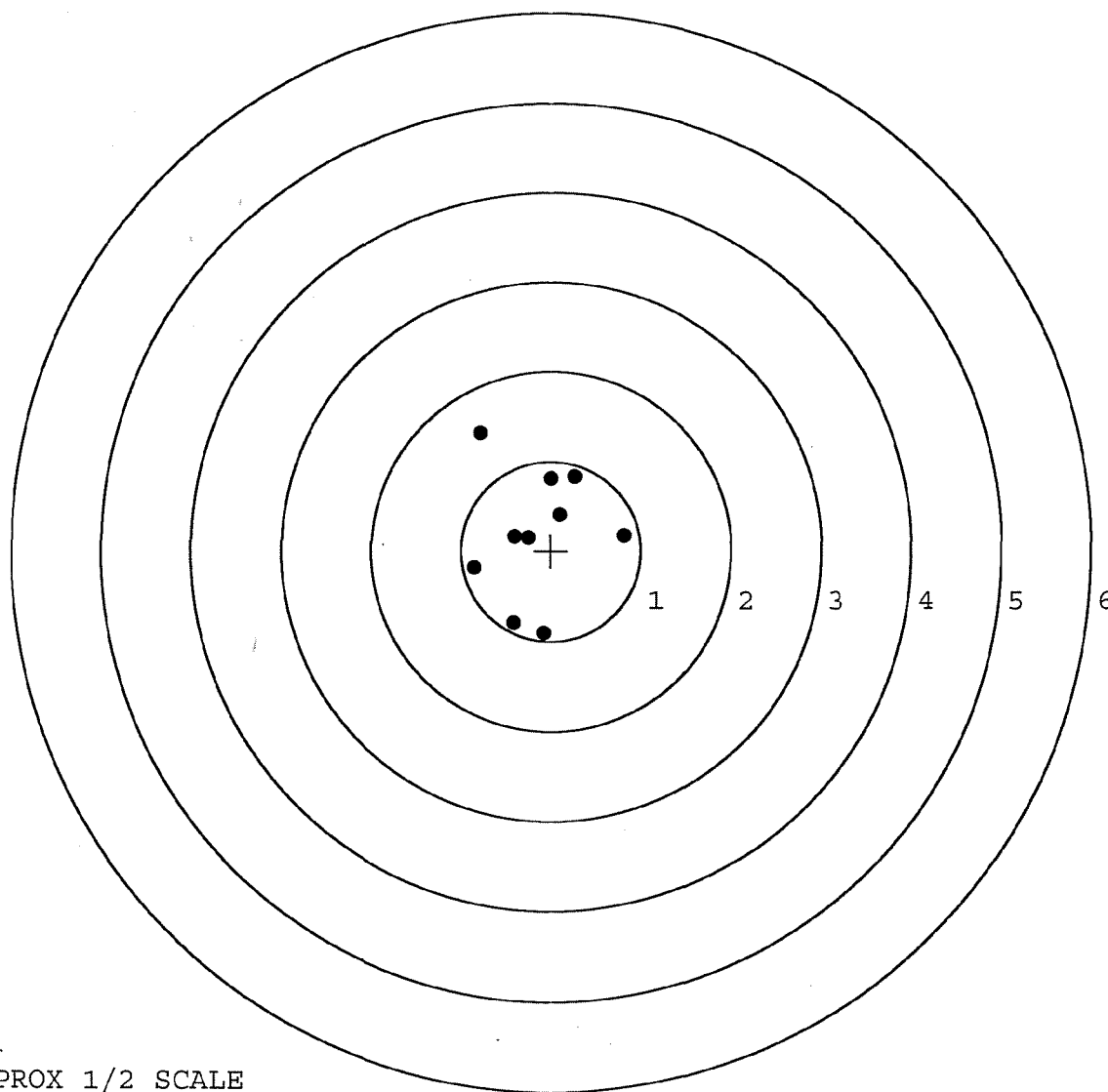
MAX RADIUS: 1.287

MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

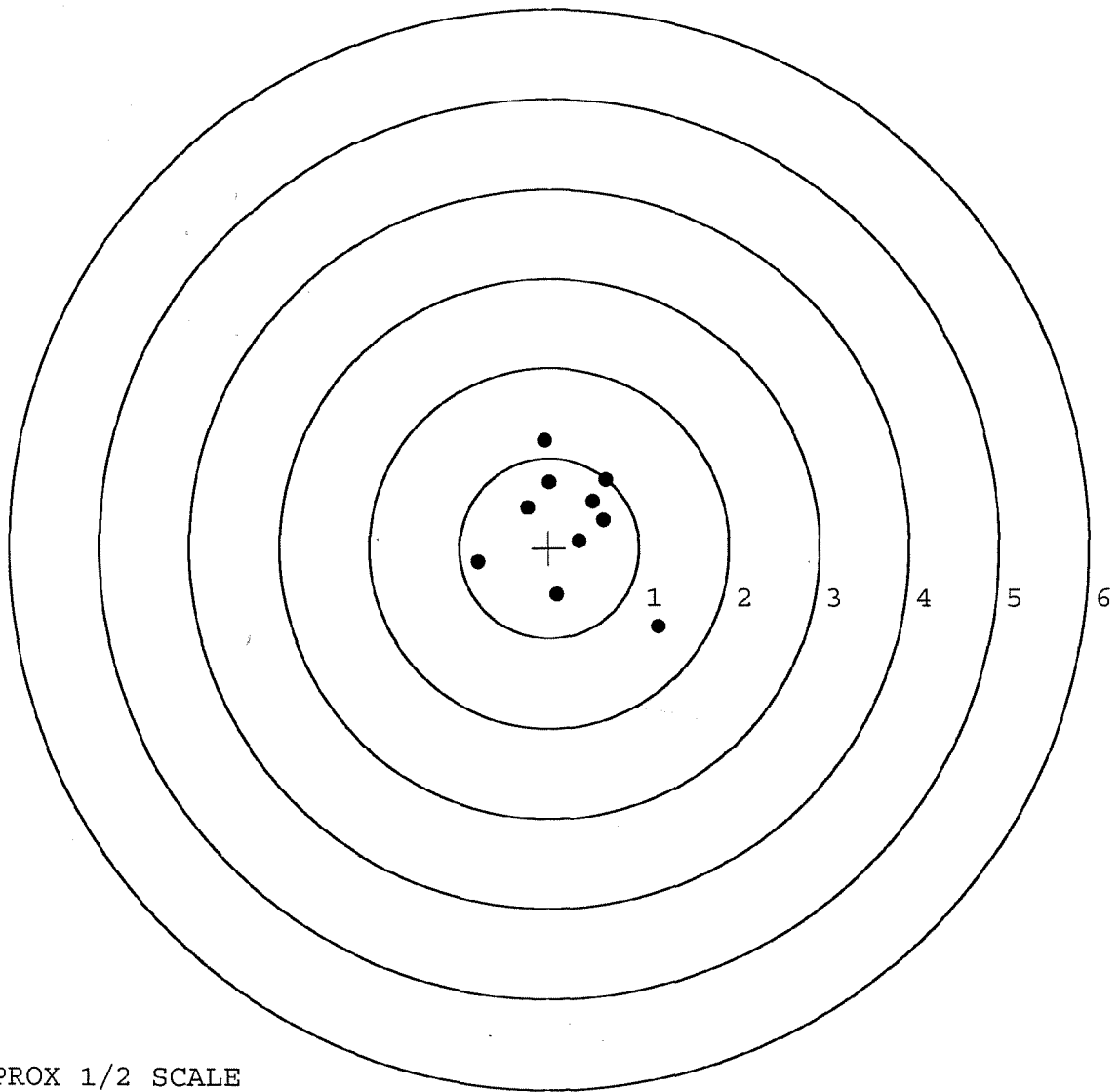
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461582. 0
TARGET NUMBER: 4
FILE DATE: 11/08/2005
FILE TIME: 19:23

	POINT#	X	Y
	1:	0.340	0.081
	2:	0.602	0.318
	3:	0.483	0.523
	4:	0.632	0.765
X CENTROID:	5:	0.000	0.732
Y CENTROID:	6:	-0.241	0.450
POA TO CENTROID:	7:	-0.051	1.190
HORZ SPREAD:	8:	-0.790	-0.159
VERT SPREAD:	9:	0.092	-0.526
GROUP SPREAD:	10:	1.209	-0.878
MIN RADIUS:			0.203
MAX RADIUS:			1.495
MEAN RADIUS:			0.702
# IN 1 IN DIAMETER:			3
# IN 2 IN DIAMETER:			8
# in 3 IN DIAMETER:			10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461582. __0

TARGET NUMBER: 5

FILE DATE: 11/08/2005

FILE TIME: 19:23

POINT#	X	Y
1:	-0.012	0.331
2:	0.308	0.253
3:	0.414	0.211
4:	0.780	0.869
5:	-0.049	1.053
6:	-0.790	0.204
7:	-0.293	-0.566
8:	-0.735	-0.979
9:	-0.138	-1.119
10:	0.746	-1.794

X CENTROID: 0.023

Y CENTROID: -0.154

POA TO CENTROID: 0.155

HORZ SPREAD: 1.570

VERT SPREAD: 2.847

GROUP SPREAD: 2.956

MIN RADIUS: 0.486

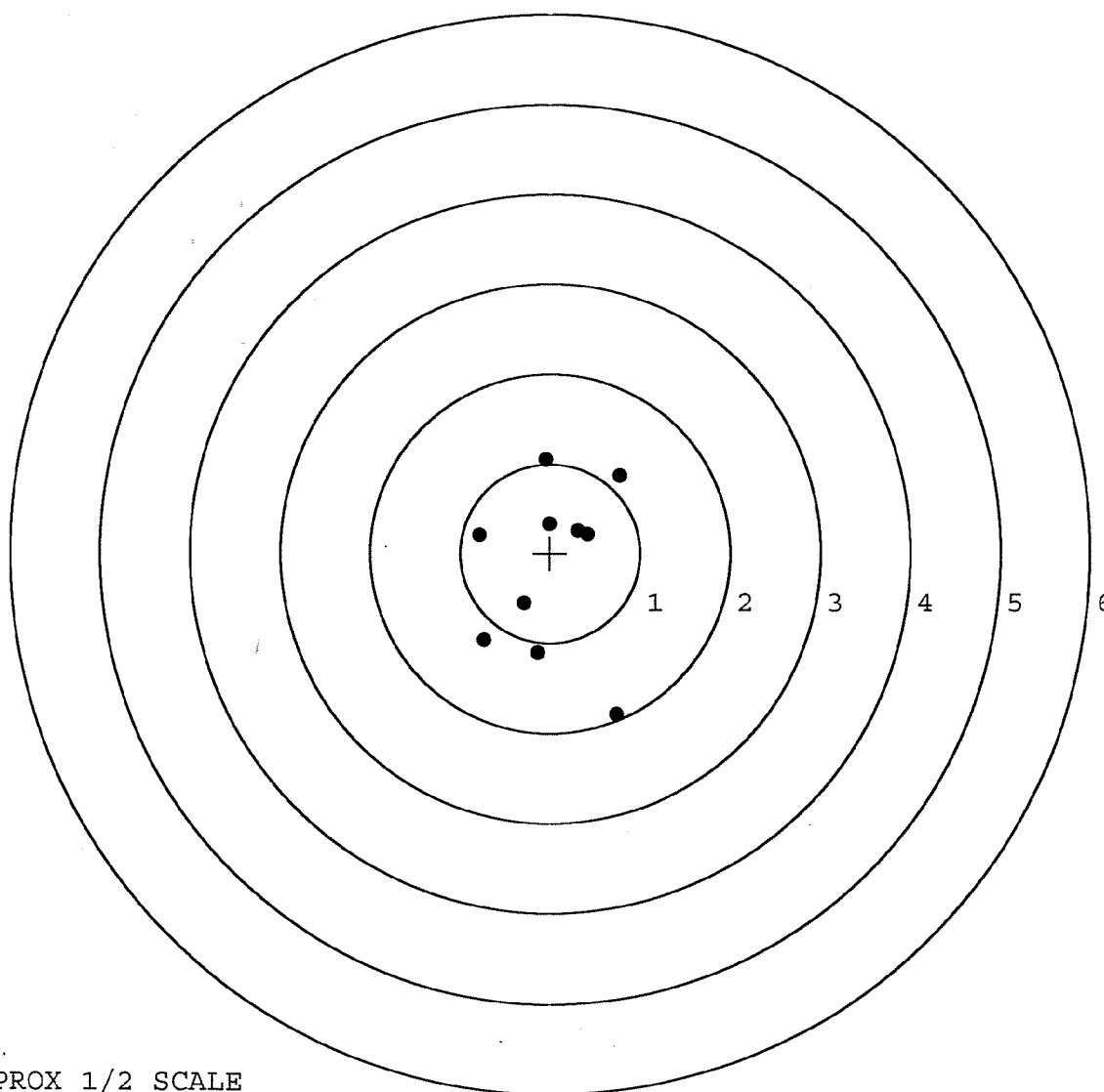
MAX RADIUS: 1.793

MEAN RADIUS: 0.930

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE