

G646 1590

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



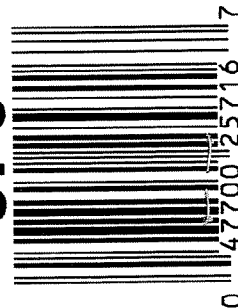
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461590

UPC



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

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UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461590

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-3-05	RTZ
440	PROOF		10-3-05	RTZ
460	CHECK HEADSPACE		10-3-05	RTZ
470	DIS-ASSEMBLE ACTION		10-4-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/80 OFFENSE	10/7/05	unint
500	ROLLMARK CALIBER		10-7-05	CW
510	DRILL AND TAP SIGHT HOLES		10-6-05	TRW
520	GOFF BLAST BBL / REC		10/10/05	JD
530 & 540	APPLY COATINGS (BARREL ACTION)		10/14/05	RB
	(BOLT)		10/14/05	RB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-12-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-05	DA
	D) OIL FIRING PIN ASSEMBLY		10-25-05	RTZ
	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>4 lb</u>	10-28-05	BC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lb</u> <u>2 lb</u> <u>2 lb</u>	10-28-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.025</u>	10-28-05	BC
	J) ASSEMBLE STOCK		10-25-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-28-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-28-05	BC
	M) IRON SIGHT ALIGNMENT		10-28-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-28-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/25/05	MMJ
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/25/05	MMJ
670	FINAL INSPECTION A) HEADSPACE		10-28-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u> <u>2.70</u> <u>2.84</u> <u>2.75</u> <u>2.84</u>	10-28-05	TRL
	C) FUNCTION		10-28-05	BC
690	PACK			

AVERAGE PULL FORCE AFTER 50 CYCLES

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 10-24-05

TESTER S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.64		2.36	
PULL #2	2.65	2.63		2.43	
PULL #3	2.44	2.36		2.51	
PULL #4	2.46	2.59		2.46	
PULL #5	2.47	2.35		2.43	
TOTAL	12.64	12.57		12.19	
AVERAGE	2.53	2.51		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	2.97		
PULL #2	3.18	2.96		
PULL #3	3.17	2.94		
PULL #4	3.18	3.19		
PULL #5	3.07	2.91		
TOTAL	15.79	14.97		
AVERAGE	3.16	2.99		

	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	3.97	3.91		4.13
PULL #2	3.94	4.02		4.21
PULL #3	4.20	4.01		4.05
PULL #4	4.04	4.06		3.99
PULL #5	4.15	4.11		4.05
TOTAL	20.30	20.11		20.43
AVERAGE	4.06	4.02		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461590.___0
FILE DATE AND TIME: 10/25/2005 17:15

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:	0.077
The Average Point of Impact of the Five Target Set:	0.078
The Average Mean Radius of the Five Target Set:	0.724
The Distance from POA to Centroid Target #1:	0.204
The Distance from Centroid Target #2 to Centroid Target #1:	0.443
The Distance from Centroid Target #3 to Centroid Target #1:	0.137
The Distance from Centroid Target #4 to Centroid Target #1:	0.222
The Distance from Centroid Target #5 to Centroid Target #1:	0.330

SERIAL NUMBER: G6461590. __0

TARGET NUMBER: 1

FILE DATE: 10/25/2005

FILE TIME: 17:15

POINT#	X	Y
1:	-0.186	1.331
2:	0.012	1.057
3:	0.179	0.546
4:	1.141	0.303
5:	0.130	-0.495
6:	-0.131	-0.967
7:	-0.402	-0.884
8:	-0.563	-0.320
9:	-1.614	-0.616
10:	-0.601	0.135

X CENTROID: -0.203

Y CENTROID: 0.009

POA TO CENTROID: 0.204

HORZ SPREAD: 2.755

VERT SPREAD: 2.298

GROUP SPREAD: 2.904

MIN RADIUS: 0.417

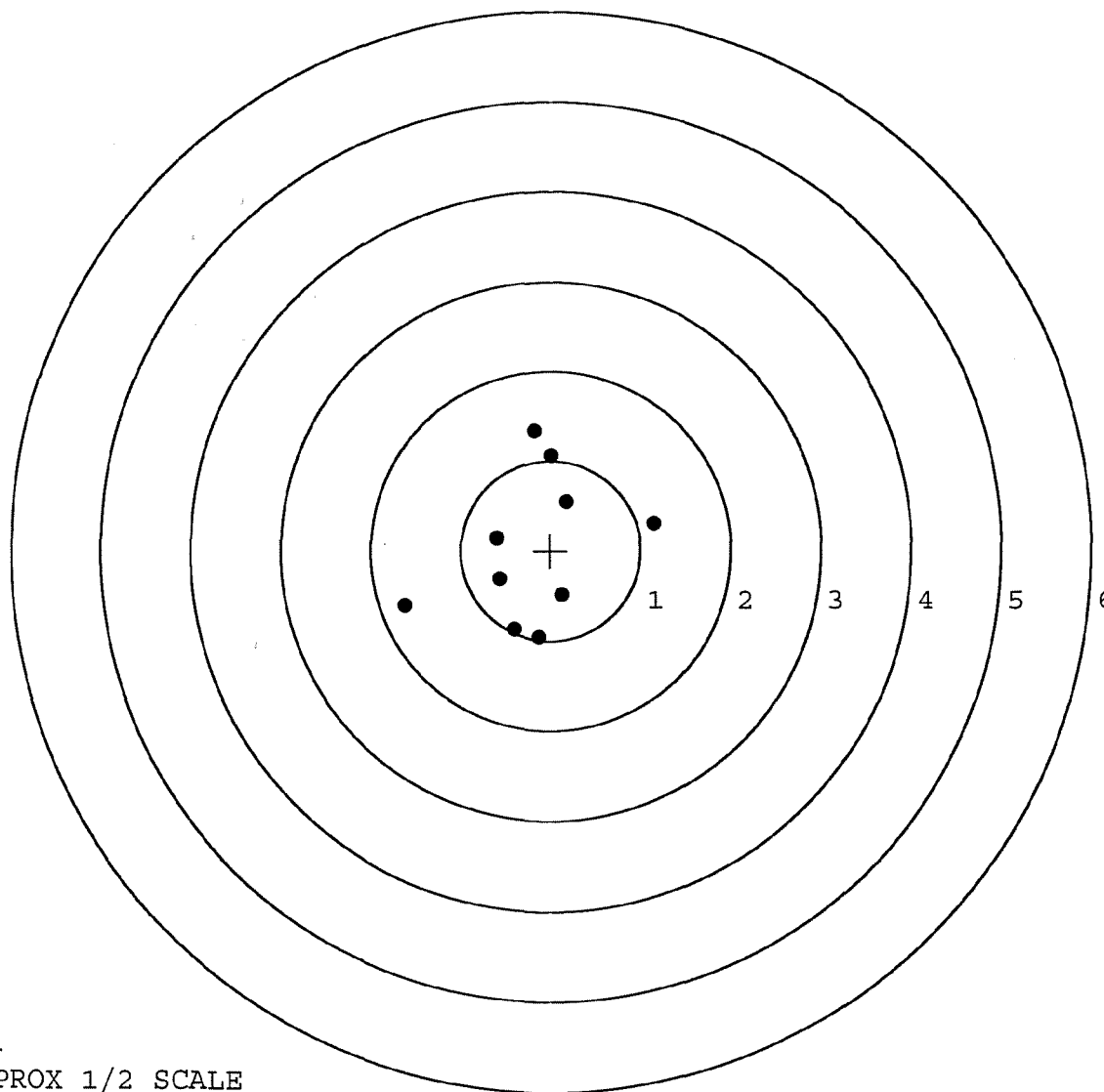
MAX RADIUS: 1.543

MEAN RADIUS: 0.937

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

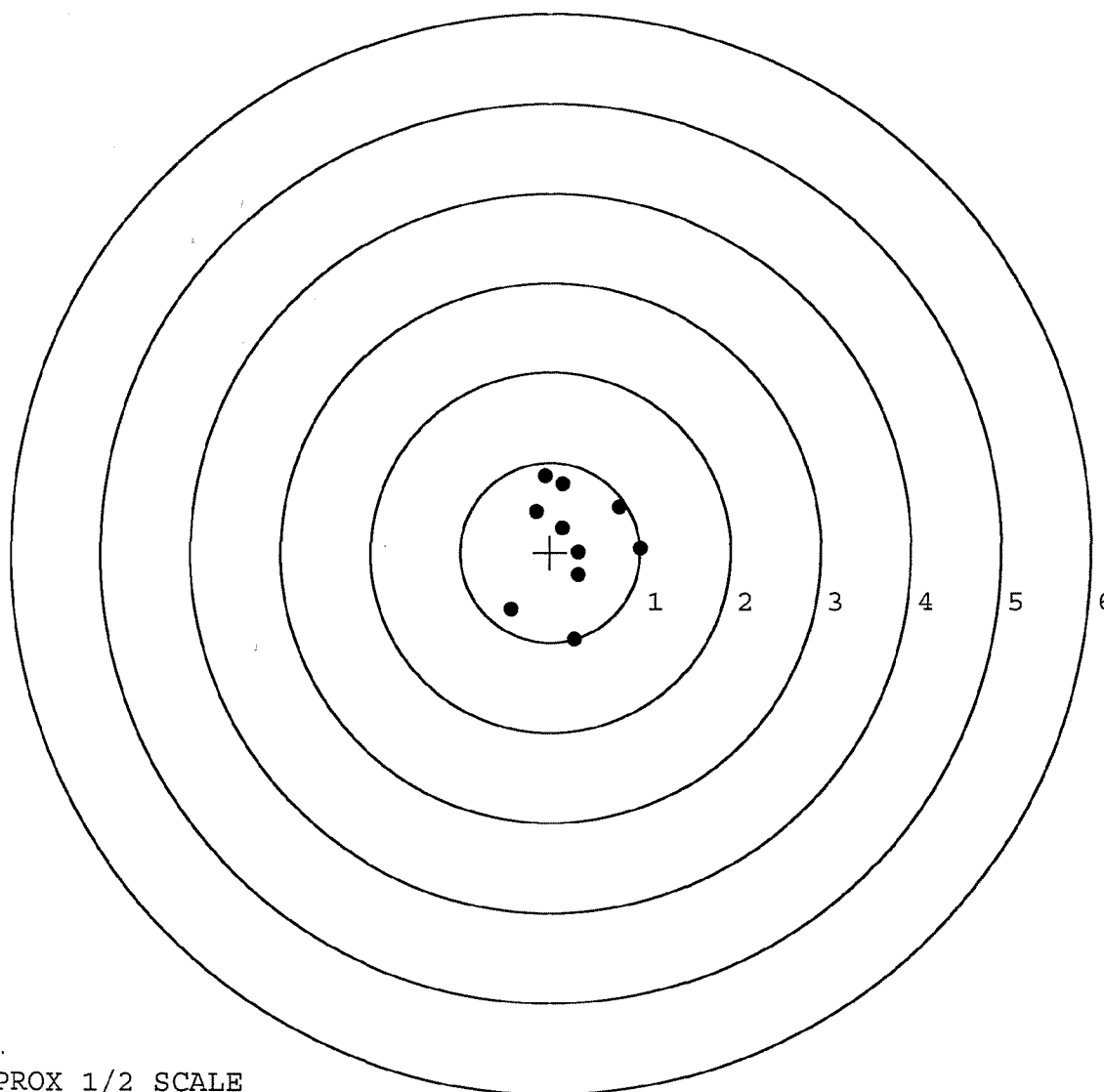


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461590. __0
TARGET NUMBER: 2
FILE DATE: 10/25/2005
FILE TIME: 17:15

X CENTROID: 0.229
Y CENTROID: 0.102
POA TO CENTROID: 0.251
HORZ SPREAD: 1.442
VERT SPREAD: 1.832
GROUP SPREAD: 1.862
MIN RADIUS: 0.131
MAX RADIUS: 1.082
MEAN RADIUS: 0.623
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.140	0.766
2:	-0.065	0.853
3:	-0.160	0.455
4:	-0.437	-0.637
5:	0.267	-0.979
6:	1.005	0.041
7:	0.776	0.503
8:	0.130	0.271
9:	0.319	0.006
10:	0.317	-0.259



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461590. 0

TARGET NUMBER: 3

FILE DATE: 10/25/2005

FILE TIME: 17:15

POINT#	X	Y
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1:	-0.430	0.431
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2:	-0.282	0.524
----	--------	-------

3:	0.075	0.407
----	-------	-------

4:	-0.442	-0.166
----	--------	--------

5:	-0.761	-0.063
----	--------	--------

6:	0.306	-0.873
----	-------	--------

7:	0.404	-0.046
----	-------	--------

8:	0.738	-0.191
----	-------	--------

9:	-0.367	0.993
----	--------	-------

10:	-0.234	-0.039
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X CENTROID: -0.099

Y CENTROID: 0.098

POA TO CENTROID: 0.139

HORZ SPREAD: 1.499

VERT SPREAD: 1.866

GROUP SPREAD: 1.984

MIN RADIUS: 0.192

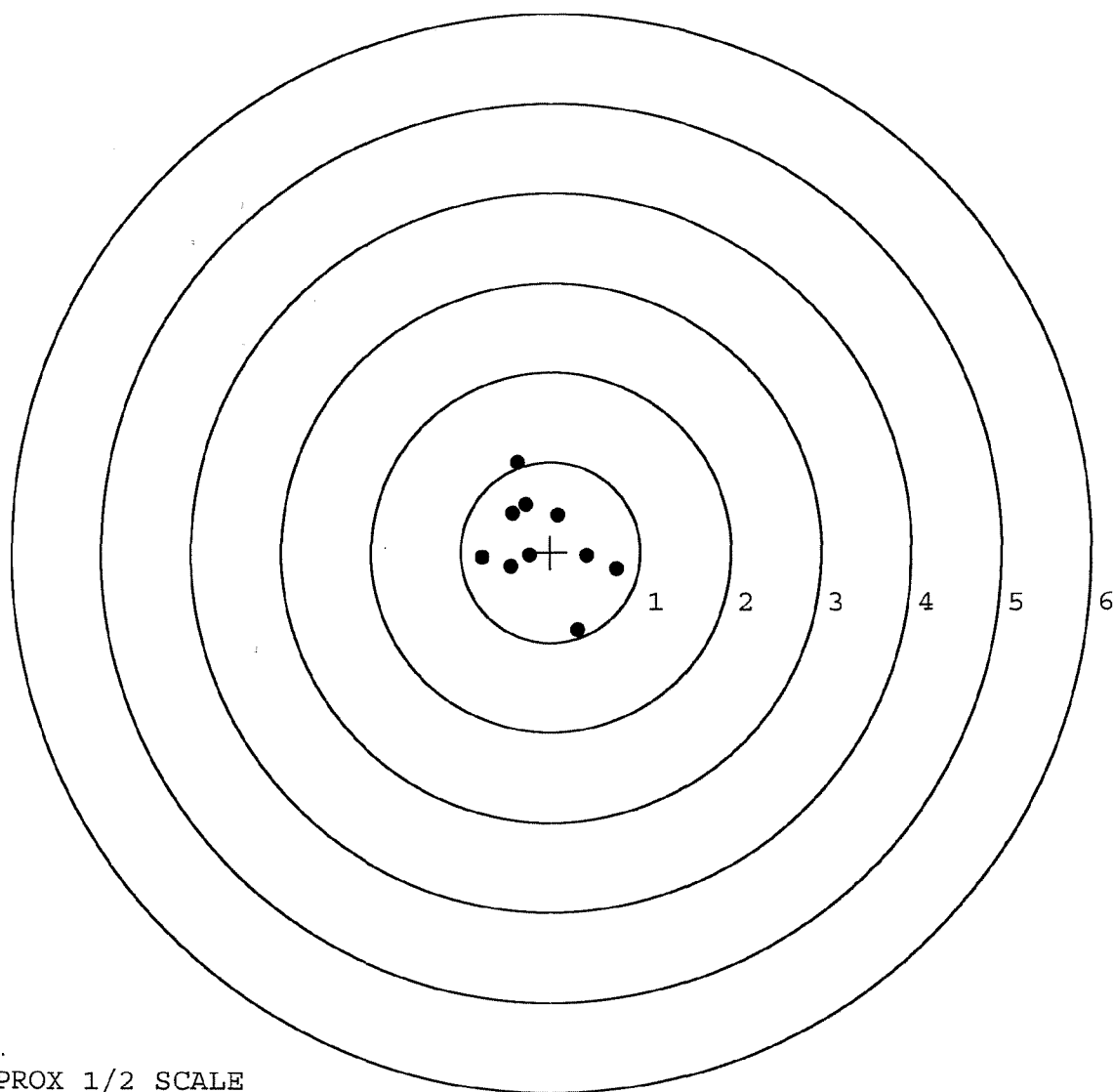
MAX RADIUS: 1.052

MEAN RADIUS: 0.599

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461590. __0

TARGET NUMBER: 4

FILE DATE: 10/25/2005

FILE TIME: 17:15

POINT#	X	Y
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1:	0.380	0.551
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2:	0.273	0.458
----	-------	-------

3:	-0.152	0.476
----	--------	-------

4:	-0.759	0.459
----	--------	-------

5:	-0.819	0.780
----	--------	-------

6:	-0.463	-0.340
----	--------	--------

7:	0.100	-0.299
----	-------	--------

8:	0.324	-0.227
----	-------	--------

9:	0.736	-0.316
----	-------	--------

10:	0.439	-0.722
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X CENTROID: 0.006

Y CENTROID: 0.082

POA TO CENTROID: 0.082

HORZ SPREAD: 1.555

VERT SPREAD: 1.502

GROUP SPREAD: 1.959

MIN RADIUS: 0.392

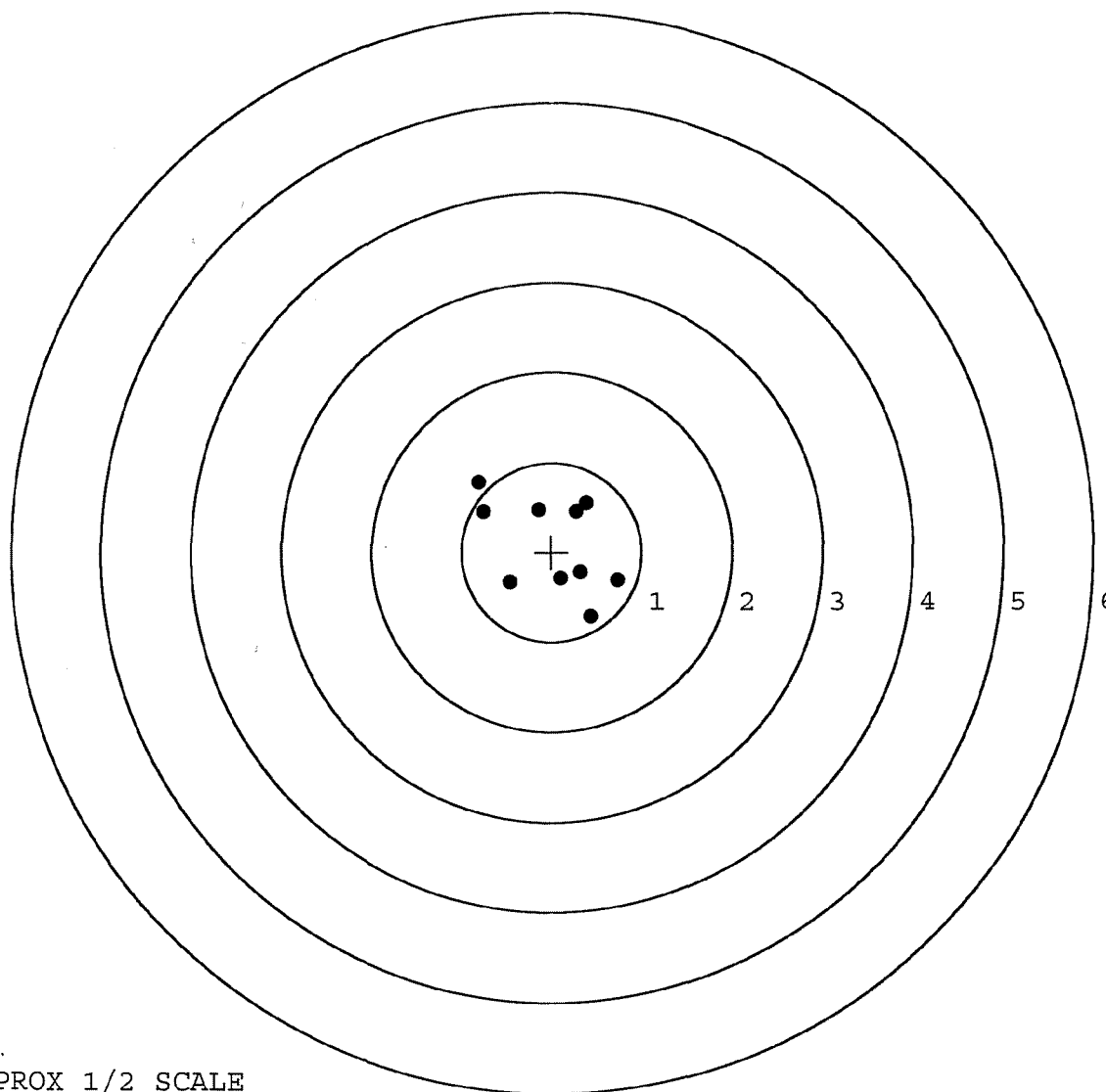
MAX RADIUS: 1.081

MEAN RADIUS: 0.663

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

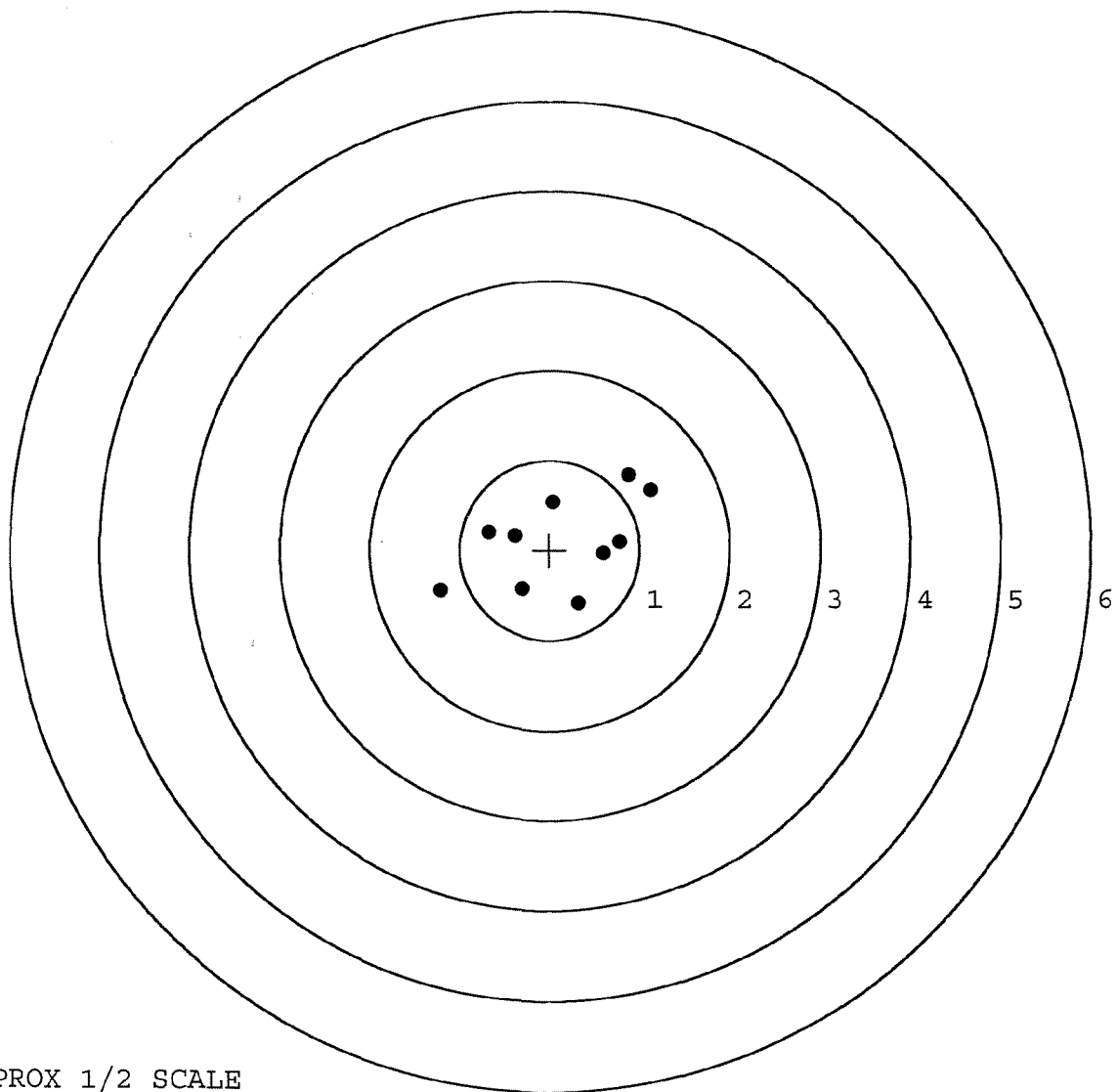


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461590. __0
TARGET NUMBER: 5
FILE DATE: 10/25/2005
FILE TIME: 17:15

X CENTROID: 0.115
Y CENTROID: 0.095
POA TO CENTROID: 0.150
HORZ SPREAD: 2.325
VERT SPREAD: 1.432
GROUP SPREAD: 2.583
MIN RADIUS: 0.446
MAX RADIUS: 1.437
MEAN RADIUS: 0.798
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.037	0.535
2:	-0.388	0.156
3:	-0.683	0.200
4:	-1.211	-0.458
5:	-0.303	-0.437
6:	0.323	-0.594
7:	0.606	-0.042
8:	0.784	0.090
9:	1.114	0.667
10:	0.875	0.838



TARGET APPROX 1/2 SCALE