

G646 1629

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

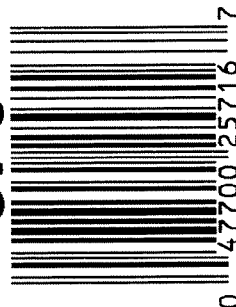
24"

CAPACITY

6

G6461629

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 6461629

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-4-05	RTL
440	PROOF		10-5-05	BG
460	CHECK HEADSPACE	MAGNA-FLUX	10-5-05	BG
470	DIS-ASSEMBLE ACTION	INSPECT OCT 10 6	10-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	440 OPERATOR <u>WMS</u>	10/10/05	WMS
500	ROLLMARK CALIBER		10-10-05	CW
510	DRILL AND TAP SIGHT HOLES		10-7-05	TRL
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		10/20/05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/20/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/20/05	DA
	D) OIL FIRING PIN ASSEMBLY		10-20-05	RTL
	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>6.2</u> <u>5.5</u> <u>5.5</u>	11-9-05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.5</u> <u>2.5</u>	11-9-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>		DA
	J) ASSEMBLE STOCK			
	K) ASSEMBLE SWIVEL STUDS		11-21-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-21-05	BG
	M) IRON SIGHT ALIGNMENT		11-21-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-21-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-27-05	TRC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-27-05	SN
670	FINAL INSPECTION A) HEADSPACE		11-21-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>262</u> <u>275</u> <u>278</u> <u>280</u> <u>281</u>	11-9-05	DA
	C) FUNCTION		11-21-05	BG
690	PACK		12/6/05	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 10-24-05

TESTER S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.60	2.47		2.56	
PULL #2	2.40	2.63		2.68	
PULL #3	2.39	2.50		2.54	
PULL #4	2.58	2.36		2.56	
PULL #5	2.41	2.68		2.44	
TOTAL	12.38	12.64		12.78	
AVERAGE	2.48	2.53		2.55	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.14		
PULL #2	3.26	3.15		
PULL #3	2.82	2.85		
PULL #4	2.96	3.07		
PULL #5	2.84	3.16		
TOTAL	14.96	15.37		
AVERAGE	2.99	3.07		

	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	3.99	4.20		4.17
PULL #2	4.19	3.78		4.14
PULL #3	3.96	3.81		3.99
PULL #4	4.14	4.07		4.26
PULL #5	4.08	4.02		4.15
TOTAL	20.36	19.88		20.71
AVERAGE	4.07	3.97		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461629.___0

FILE DATE AND TIME: 10/27/2005 05:58

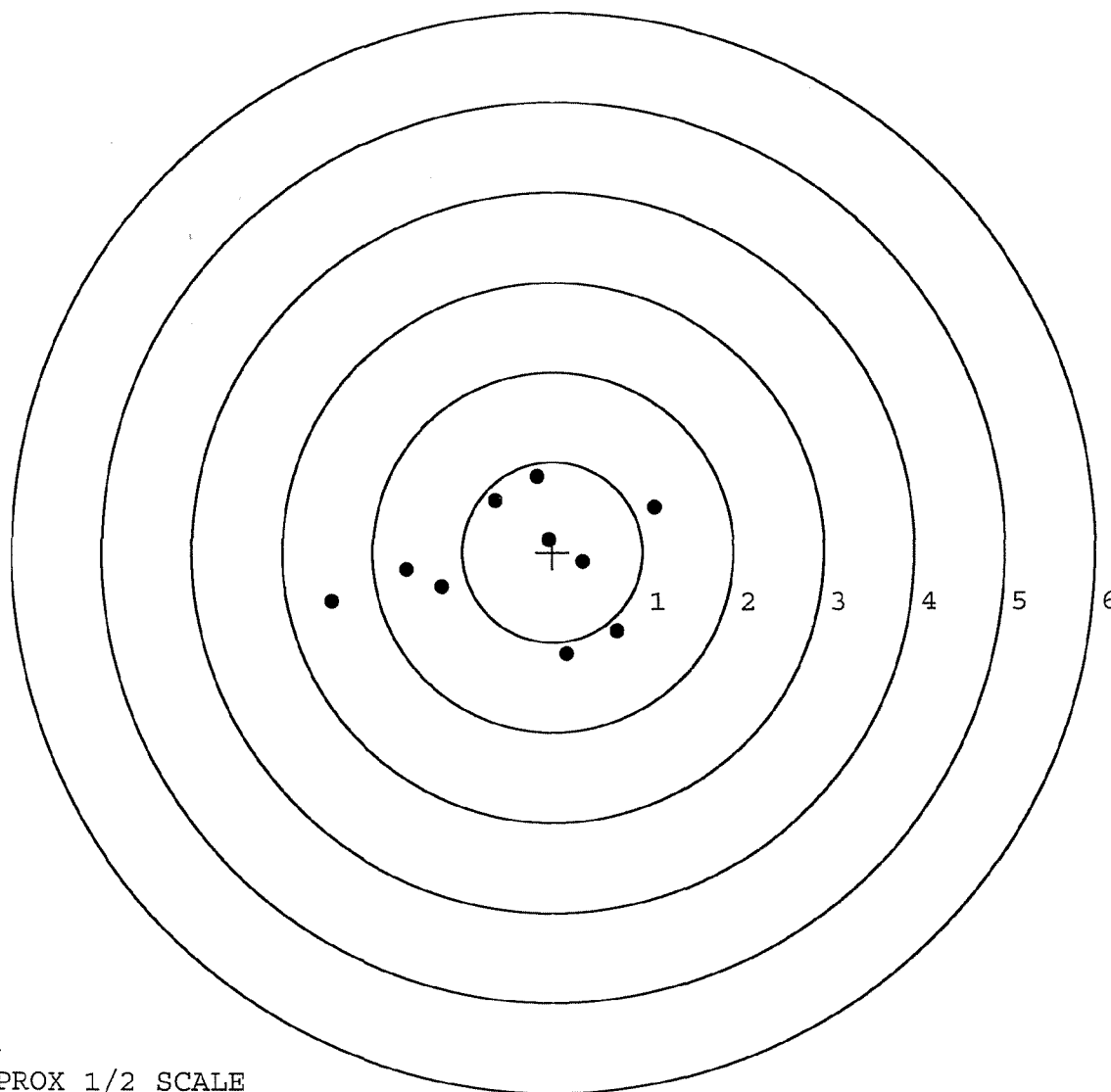
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.143
The Average Y Centroid of the Five Target Set:	-0.020
The Average Point of Impact of the Five Target Set:	0.145
The Average Mean Radius of the Five Target Set:	0.749
The Distance from POA to Centroid Target #1:	0.404
The Distance from Centroid Target #2 to Centroid Target #1:	0.380
The Distance from Centroid Target #3 to Centroid Target #1:	0.502
The Distance from Centroid Target #4 to Centroid Target #1:	0.379
The Distance from Centroid Target #5 to Centroid Target #1:	0.122

SERIAL NUMBER: G6461629. 0
TARGET NUMBER: 1
FILE DATE: 10/27/2005
FILE TIME: 05:58

X CENTROID: -0.384
Y CENTROID: -0.123
POA TO CENTROID: 0.404
HORZ SPREAD: 3.568
VERT SPREAD: 1.978
GROUP SPREAD: 3.719
MIN RADIUS: 0.430
MAX RADIUS: 2.107
MEAN RADIUS: 1.123
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.156	-1.138
2:	0.717	-0.884
3:	0.334	-0.108
4:	1.121	0.496
5:	-0.042	0.137
6:	-0.646	0.567
7:	-0.180	0.840
8:	-1.231	-0.390
9:	-1.626	-0.196
10:	-2.447	-0.554

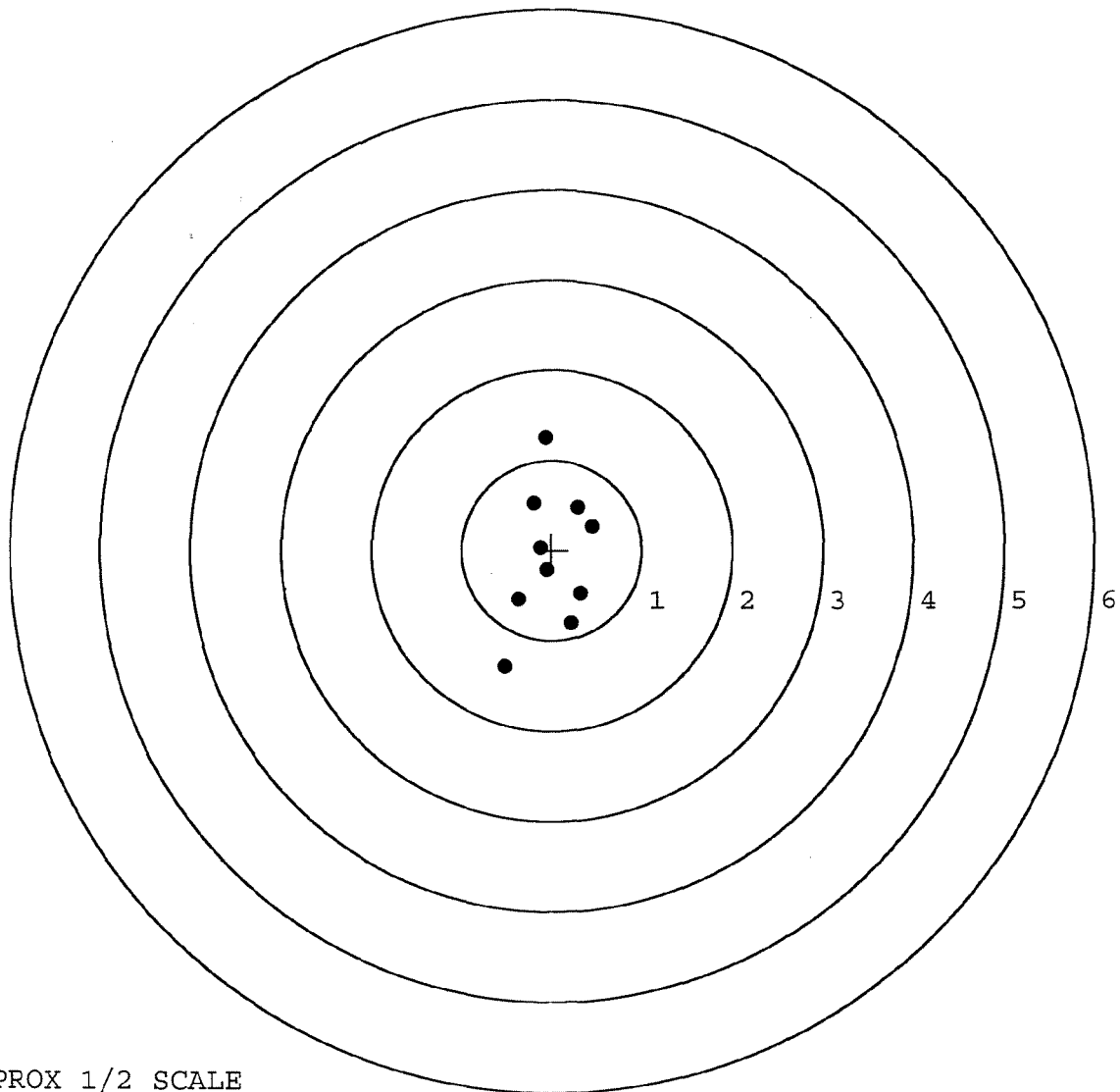


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461629. __0
TARGET NUMBER: 2
FILE DATE: 10/27/2005
FILE TIME: 05:58

POINT#	X	Y
1:	0.217	-0.819
2:	0.325	-0.478
3:	-0.369	-0.553
4:	-0.518	-1.294
5:	0.447	0.267
6:	0.290	0.482
7:	-0.202	0.525
8:	-0.071	1.247
9:	-0.126	0.029
10:	-0.058	-0.220

X CENTROID: -0.007
Y CENTROID: -0.081
POA TO CENTROID: 0.082
HORZ SPREAD: 0.965
VERT SPREAD: 2.541
GROUP SPREAD: 2.580
MIN RADIUS: 0.148
MAX RADIUS: 1.330
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



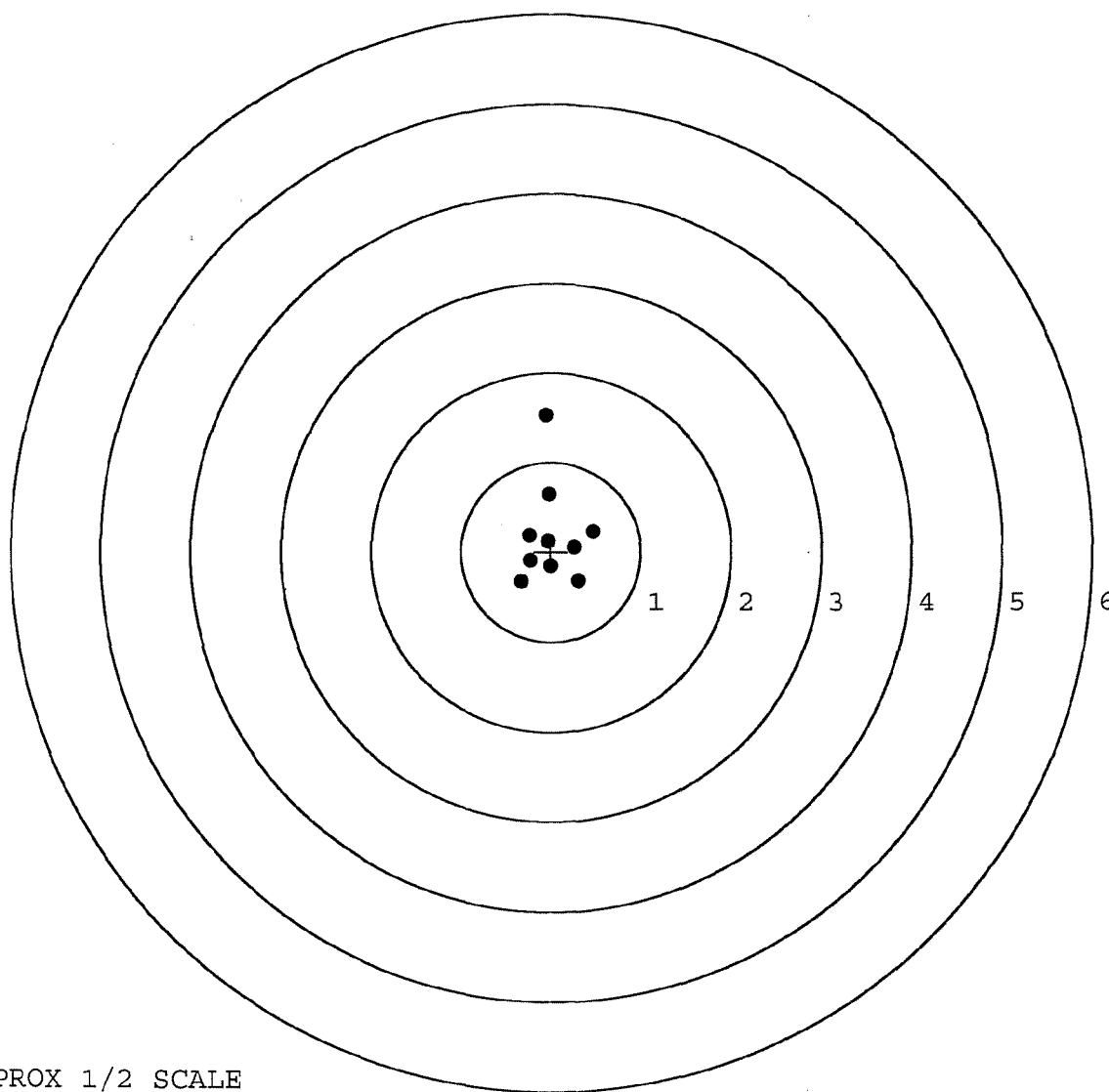
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461629. 0
TARGET NUMBER: 3
FILE DATE: 10/27/2005
FILE TIME: 05:58

X CENTROID: 0.013
Y CENTROID: 0.183
POA TO CENTROID: 0.184
HORZ SPREAD: 0.799
VERT SPREAD: 1.855
GROUP SPREAD: 1.885
MIN RADIUS: 0.078
MAX RADIUS: 1.340
MEAN RADIUS: 0.481

POINT#	X	Y
1:	-0.066	1.521
2:	-0.024	0.646
3:	0.472	0.231
4:	0.261	0.059
5:	0.311	-0.326
6:	0.006	-0.164
7:	-0.029	0.118
8:	-0.241	0.185
9:	-0.231	-0.104
10:	-0.327	-0.334

IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

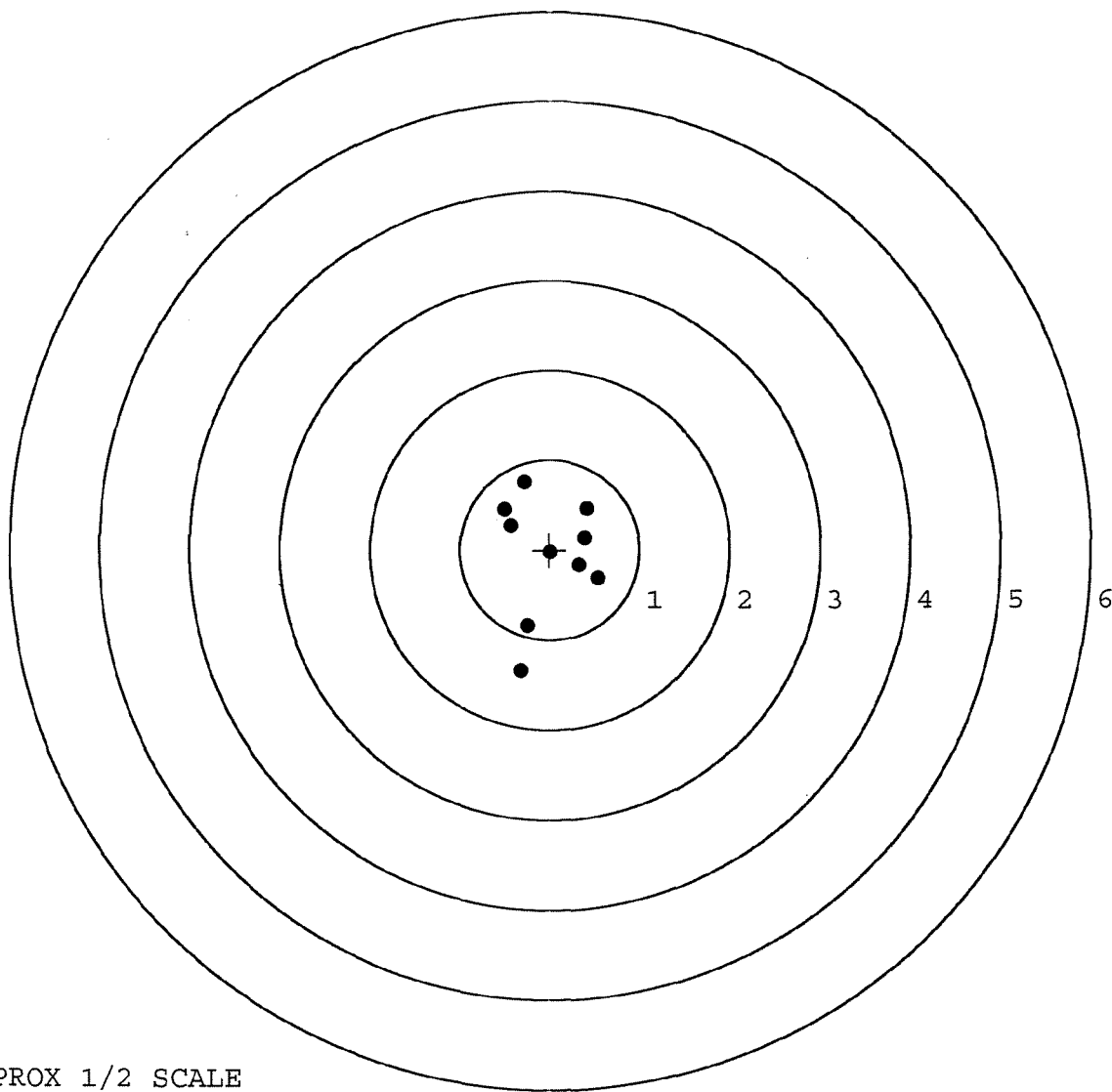


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461629. __0
TARGET NUMBER: 4
FILE DATE: 10/27/2005
FILE TIME: 05:58

X CENTROID: -0.010
Y CENTROID: -0.064
POA TO CENTROID: 0.065
HORZ SPREAD: 1.046
VERT SPREAD: 2.103
GROUP SPREAD: 2.103
MIN RADIUS: 0.038
MAX RADIUS: 1.324
MEAN RADIUS: 0.640
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.320	-1.351
2:	-0.249	-0.848
3:	-0.440	0.267
4:	-0.501	0.453
5:	-0.286	0.752
6:	0.414	0.466
7:	0.007	-0.030
8:	0.398	0.134
9:	0.545	-0.317
10:	0.330	-0.168

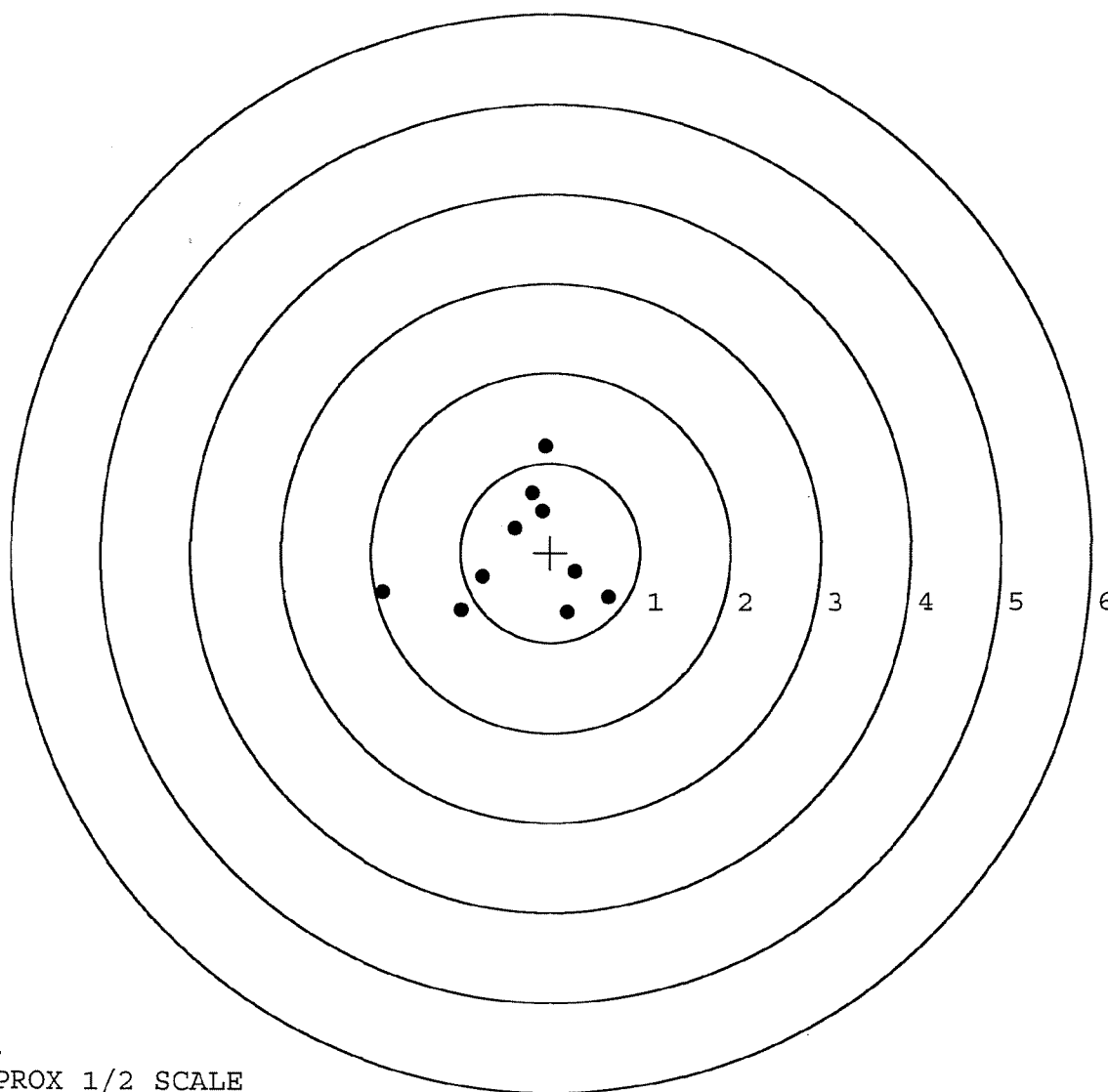


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461629. __0
TARGET NUMBER: 5
FILE DATE: 10/27/2005
FILE TIME: 05:58

POINT#	X	Y
1:	0.650	-0.506
2:	0.280	-0.214
3:	0.190	-0.668
4:	-0.759	-0.268
5:	-0.998	-0.641
6:	-1.868	-0.435
7:	-0.066	1.185
8:	-0.209	0.665
9:	-0.097	0.461
10:	-0.403	0.270

X CENTROID: -0.328
Y CENTROID: -0.015
POA TO CENTROID: 0.328
HORZ SPREAD: 2.518
VERT SPREAD: 1.853
GROUP SPREAD: 2.519
MIN RADIUS: 0.295
MAX RADIUS: 1.596
MEAN RADIUS: 0.832
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE