

G 6590041

ORDER 25716

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

UPC



0 47700 25716 7

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SERIAL NO.



66590041

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



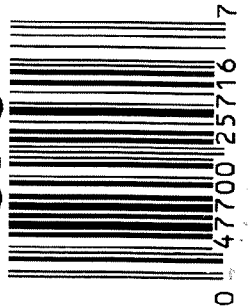
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6590041

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590041

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-6-06	RTZ
420	ASSEMBLE ACTION		9-13-06	RTZ
430	ASSEMBLE TO STOCK			
440	PROOF		9-13-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-13-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 18 2006		
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	9/18/06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-18-06	CW
510	DRILL AND TAP SIGHT HOLES		9-15-06	TRW
520	GOFF BLAST BBL / REC		9-18-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/20/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/22/06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/22/06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/22/06	DA
	D) OIL FIRING PIN ASSEMBLY		9-23-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10/11/06	MMH

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7⁹</u> <u>7⁹</u> <u>6⁹</u>	10-2-06	SD
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>6⁹</u> <u>6⁹</u> <u>6⁹</u>	10-2-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		10/11/06	WJH
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	10-2-06	SD
	J) ASSEMBLE STOCK		9-23-06	BLC
	K) ASSEMBLE SWIVEL STUDS		10/11/06	WJH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-23-06	BLC
	M) IRON SIGHT ALIGNMENT		9-23-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-23-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-23-06	L.P.H.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-23-06	WJH
670	FINAL INSPECTION A) HEADSPACE		10/11/06	WJH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.28</u> <u>2.29</u> <u>2.31</u> <u>2.35</u> <u>2.29</u>	9-25-06	DA
	C) FUNCTION		10/11/06	WJH
690	PACK		10-31-06	DA

F004 REV 5/2006

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)

DATE 9-22-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	257	257		255	
PULL #2	255	260		260	
PULL #3	261	257		265	
PULL #4	236	251		239	
PULL #5	253	247		258	
TOTAL	1262	1272		1277	
AVERAGE	252	254		255	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	310	300		
PULL #2	317	302		
PULL #3	306	302		
PULL #4	315	293		
PULL #5	311	287		
TOTAL	1559	1484		
AVERAGE	311	296		

	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	412	391		403
PULL #2	426	405		397
PULL #3	406	394		403
PULL #4	416	395		403
PULL #5	415	398		401
TOTAL	2075	1983		2007
AVERAGE	415	396		401

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590041.___0
FILE DATE AND TIME: 09/25/2006 07:32

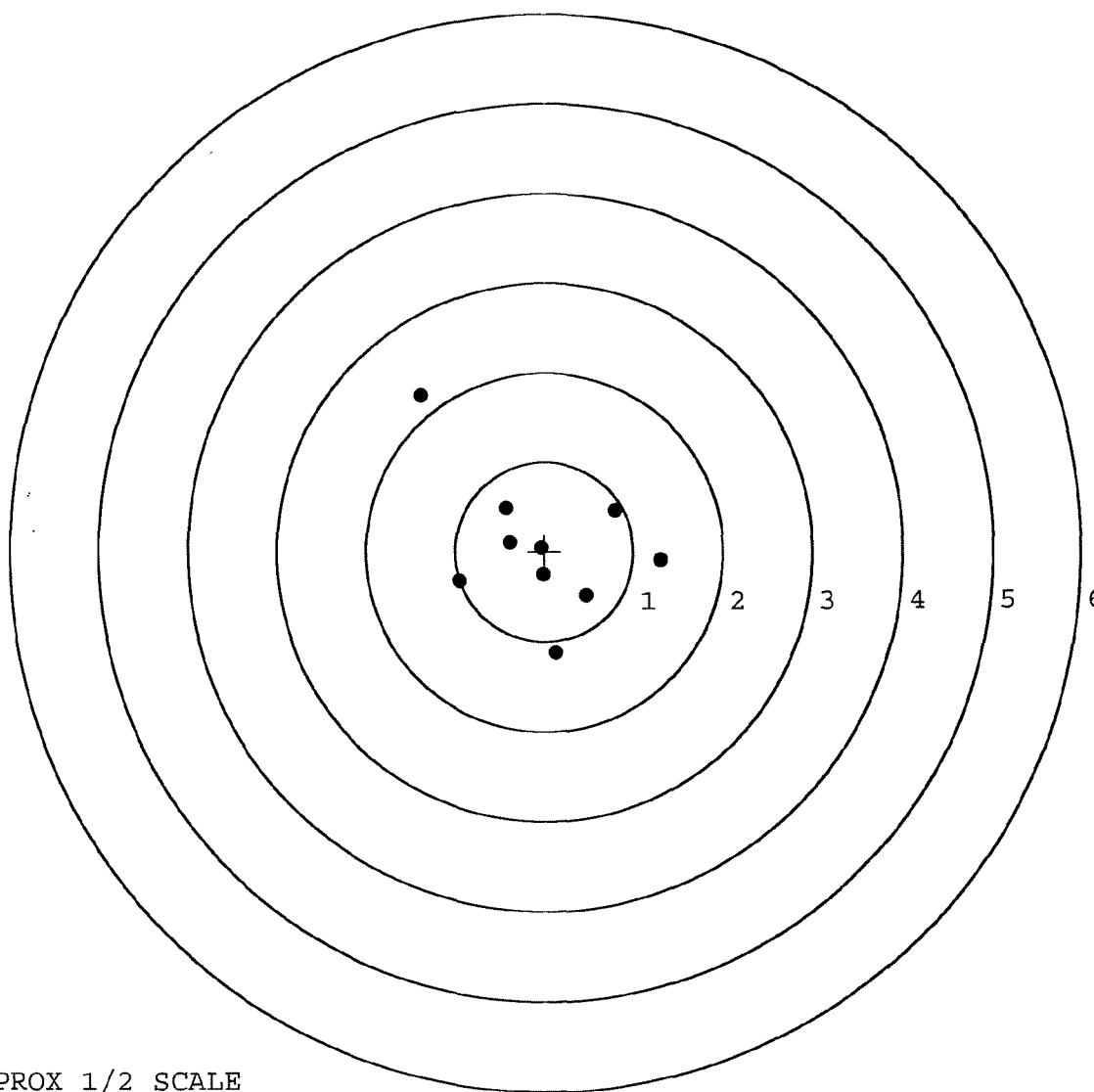
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.035
The Average Y Centroid of the Five Target Set:	0.052
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.856
The Distance from POA to Centroid Target #1:	0.072
The Distance from Centroid Target #2 to Centroid Target #1:	0.197
The Distance from Centroid Target #3 to Centroid Target #1:	0.207
The Distance from Centroid Target #4 to Centroid Target #1:	0.164
The Distance from Centroid Target #5 to Centroid Target #1:	0.203

SERIAL NUMBER: G6590041. __0
TARGET NUMBER: 1
FILE DATE: 09/25/2006
FILE TIME: 07:32

X CENTROID: -0.051
Y CENTROID: 0.051
POA TO CENTROID: 0.072
HORZ SPREAD: 2.689
VERT SPREAD: 2.875
GROUP SPREAD: 3.263
MIN RADIUS: 0.021
MAX RADIUS: 2.156
MEAN RADIUS: 0.864
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.306	-0.103
2:	0.130	-1.129
3:	-0.952	-0.331
4:	0.472	-0.487
5:	0.793	0.454
6:	-0.436	0.482
7:	-0.392	0.101
8:	-0.014	-0.260
9:	-0.038	0.035
10:	-1.383	1.746

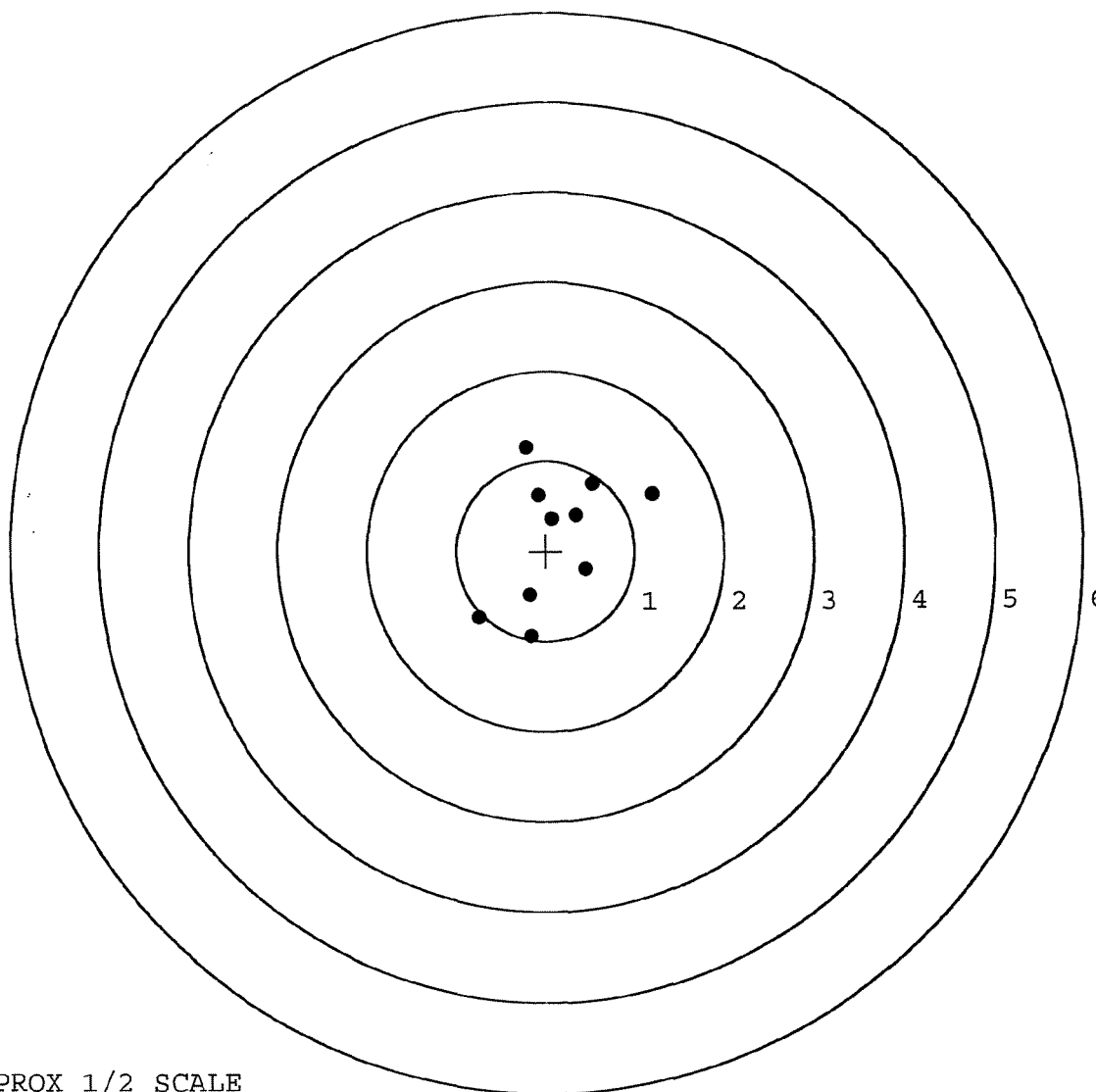


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590041. __0
TARGET NUMBER: 2
FILE DATE: 09/25/2006
FILE TIME: 07:32

X CENTROID: 0.117
Y CENTROID: 0.154
POA TO CENTROID: 0.194
HORZ SPREAD: 1.945
VERT SPREAD: 2.102
GROUP SPREAD: 2.377
MIN RADIUS: 0.210
MAX RADIUS: 1.239
MEAN RADIUS: 0.759
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.168	-0.949
2:	-0.747	-0.734
3:	-0.185	-0.489
4:	0.451	-0.199
5:	1.198	0.632
6:	0.525	0.751
7:	-0.222	1.153
8:	0.339	0.406
9:	0.065	0.358
10:	-0.090	0.616



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590041. __0

TARGET NUMBER: 3

FILE DATE: 09/25/2006

FILE TIME: 07:32

POINT#	X	Y
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1:	0.110	1.125
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2:	-0.638	1.133
----	--------	-------

3:	-0.171	0.605
----	--------	-------

4:	-0.452	0.216
----	--------	-------

5:	0.431	0.162
----	-------	-------

6:	-0.625	-0.606
----	--------	--------

7:	-0.281	-0.588
----	--------	--------

8:	0.285	-0.585
----	-------	--------

9:	1.125	-0.576
----	-------	--------

10:	1.578	-1.246
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X CENTROID: 0.136

Y CENTROID: -0.036

POA TO CENTROID: 0.141

HORZ SPREAD: 2.216

VERT SPREAD: 2.379

GROUP SPREAD: 3.251

MIN RADIUS: 0.355

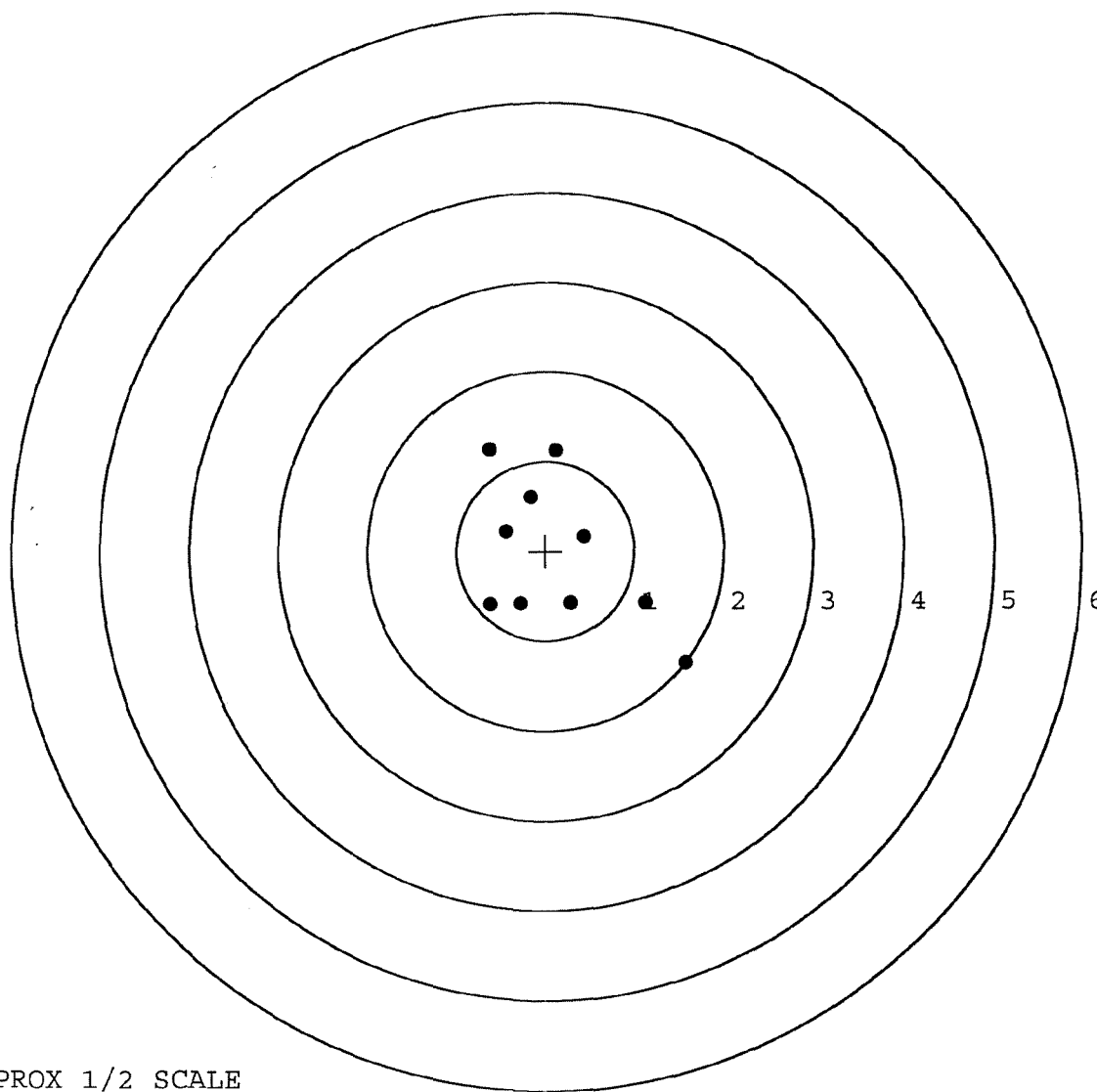
MAX RADIUS: 1.882

MEAN RADIUS: 0.949

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590041. 0

TARGET NUMBER: 4

FILE DATE: 09/25/2006

FILE TIME: 07:32

X CENTROID: -0.130

Y CENTROID: -0.093

POA TO CENTROID: 0.160

HORZ SPREAD: 2.393

VERT SPREAD: 1.642

GROUP SPREAD: 2.552

MIN RADIUS: 0.299

MAX RADIUS: 1.347

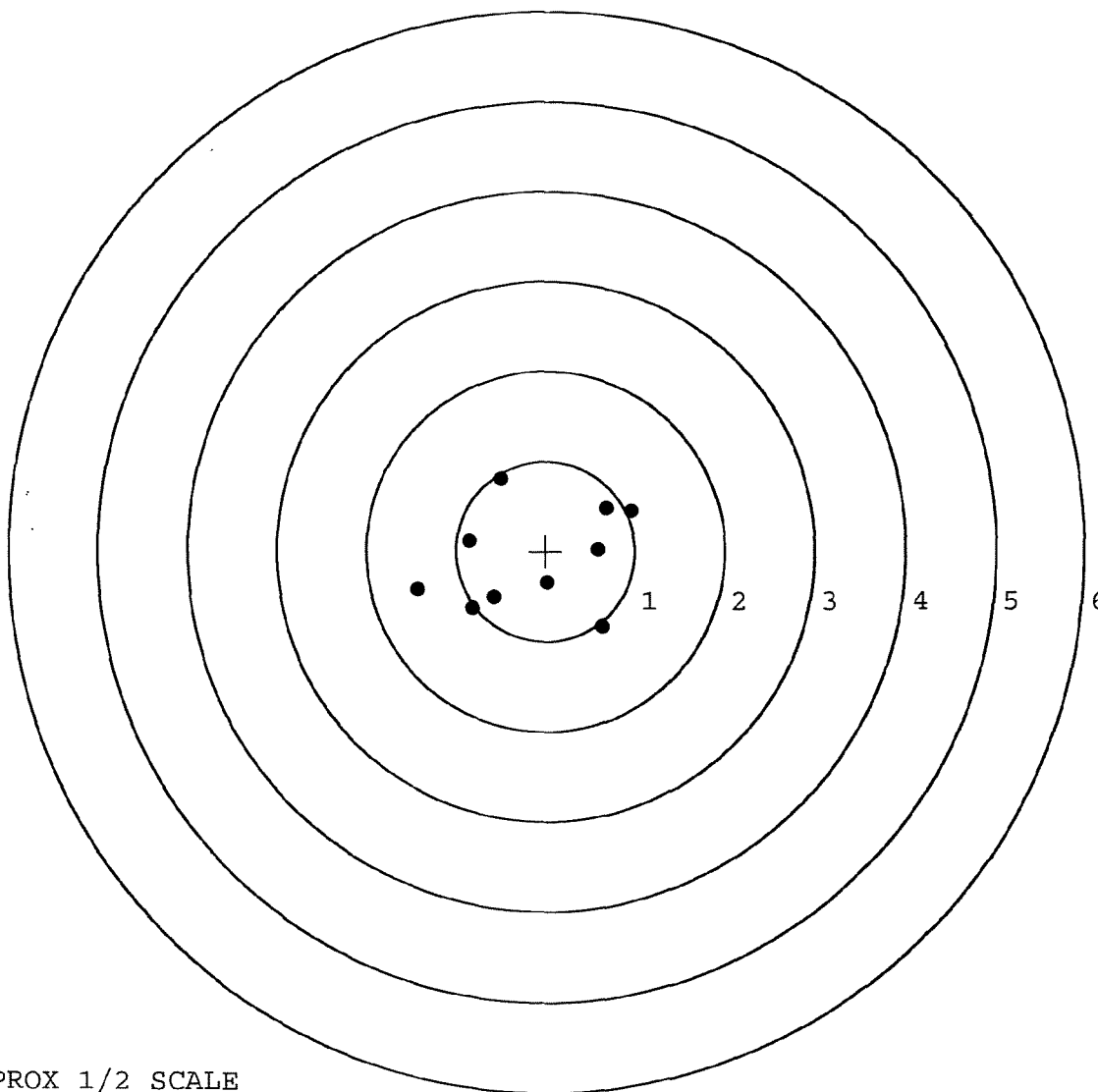
MEAN RADIUS: 0.887

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.635	-0.839
2:	0.017	-0.354
3:	0.593	0.014
4:	0.960	0.451
5:	0.677	0.480
6:	-0.505	0.803
7:	-0.849	0.107
8:	-0.585	-0.516
9:	-0.810	-0.644
10:	-1.433	-0.435

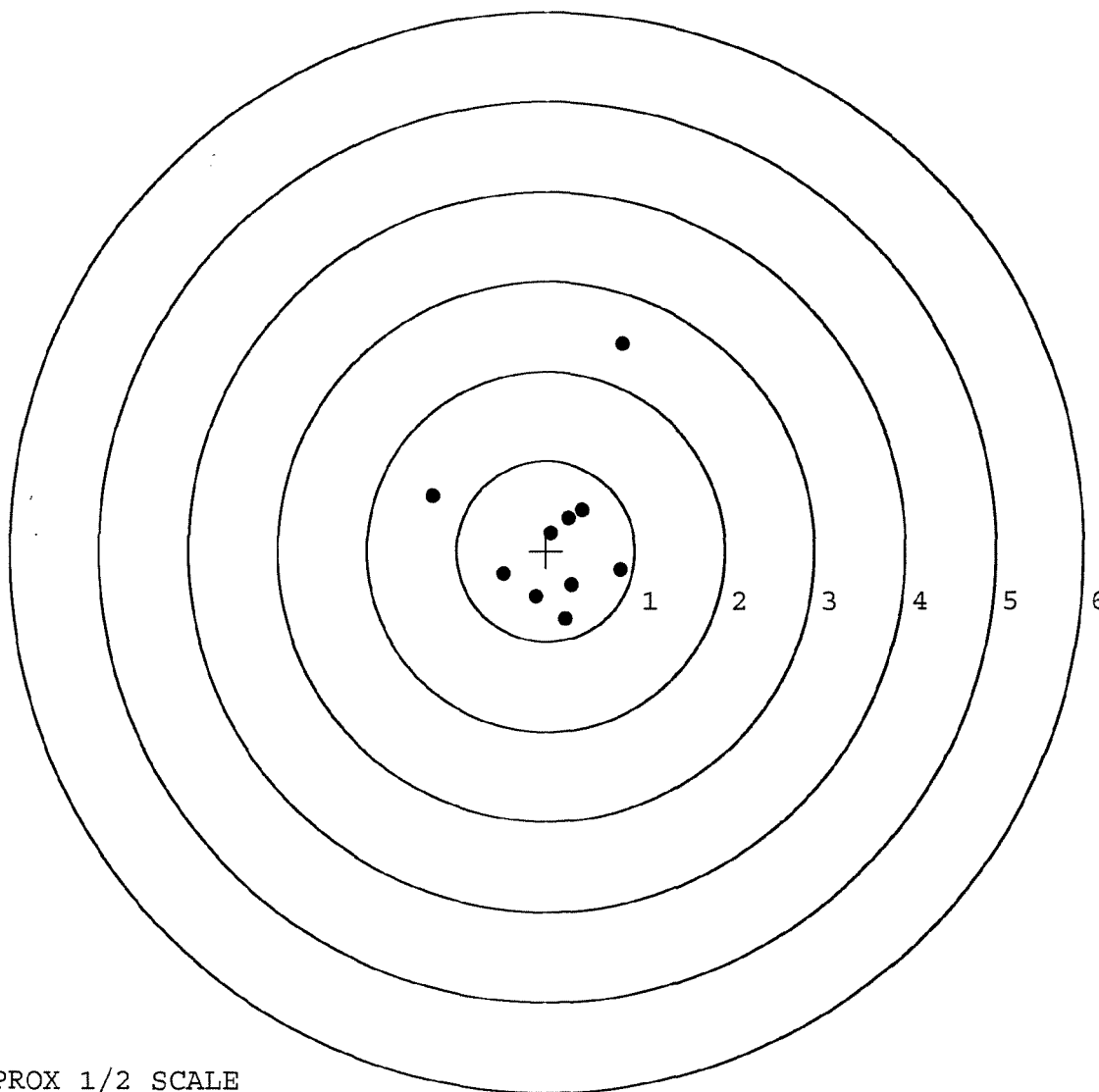


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590041. 0
TARGET NUMBER: 5
FILE DATE: 09/25/2006
FILE TIME: 07:32

X CENTROID: 0.104
Y CENTROID: 0.182
POA TO CENTROID: 0.209
HORZ SPREAD: 2.123
VERT SPREAD: 3.066
GROUP SPREAD: 3.132
MIN RADIUS: 0.052
MAX RADIUS: 2.256
MEAN RADIUS: 0.820
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.214	-0.757
2:	0.289	-0.377
3:	-0.115	-0.509
4:	-0.478	-0.258
5:	0.835	-0.210
6:	-1.267	0.605
7:	0.054	0.194
8:	0.251	0.364
9:	0.404	0.454
10:	0.856	2.309



TARGET APPROX 1/2 SCALE