

G 659 0059

ORDER 25716

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

UPC



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SERIAL NO.



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



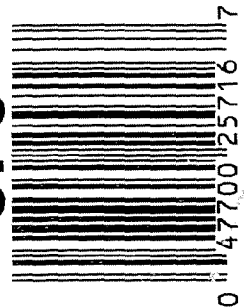
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6590059

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590059

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		8-1-06	BLG
420	ASSEMBLE ACTION		8-2-06	BLG
430	ASSEMBLE TO STOCK		8-2-06	BLG
440	PROOF		8-2-06	BLG
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-2-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 09 2006	8-2-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>QPD</u>	8-9-06	QPD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		8-9-06	CW
510	DRILL AND TAP SIGHT HOLES		8-8-06	TRW
520	GOFF BLAST BBL / REC		8-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/10/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8-11-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-11-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-11-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		8-11-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>4.0</u> <u>6.0</u>	8-21-06	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>5.2</u>	8-21-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0245</u> <u>.025</u> <u>.025</u>	8-21-06	RA
	J) ASSEMBLE STOCK		8-21-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-30-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-11-06	BLG
	M) IRON SIGHT ALIGNMENT		8-11-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-11-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-14-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-14-06	BD
670	FINAL INSPECTION A) HEADSPACE		8-30-06	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.79</u> <u>2.86</u> <u>2.78</u> <u>2.82</u> <u>2.71</u>	8/22/06	RP
	C) FUNCTION		8-30-06	RTZ
690	PACK		11/15/06	RA

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

8-10-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	243	246		242	
PULL #2	252	239		253	
PULL #3	247	239		249	
PULL #4	255	242		260	
PULL #5	240	244		259	
TOTAL	1237	1210		1263	
AVERAGE	247	242		252	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	324	309		
PULL #2	324	314		
PULL #3	307	324		
PULL #4	315	313		
PULL #5	320	312		
TOTAL	1590	1572		
AVERAGE	318	314		

	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	407		417
PULL #2	401	399		399
PULL #3	413	388		415
PULL #4	414	387		393
PULL #5	418	399		425
TOTAL	2058	1980		2049
AVERAGE	411	396		409

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590059.___0
FILE DATE AND TIME: 08/14/2006 15:05

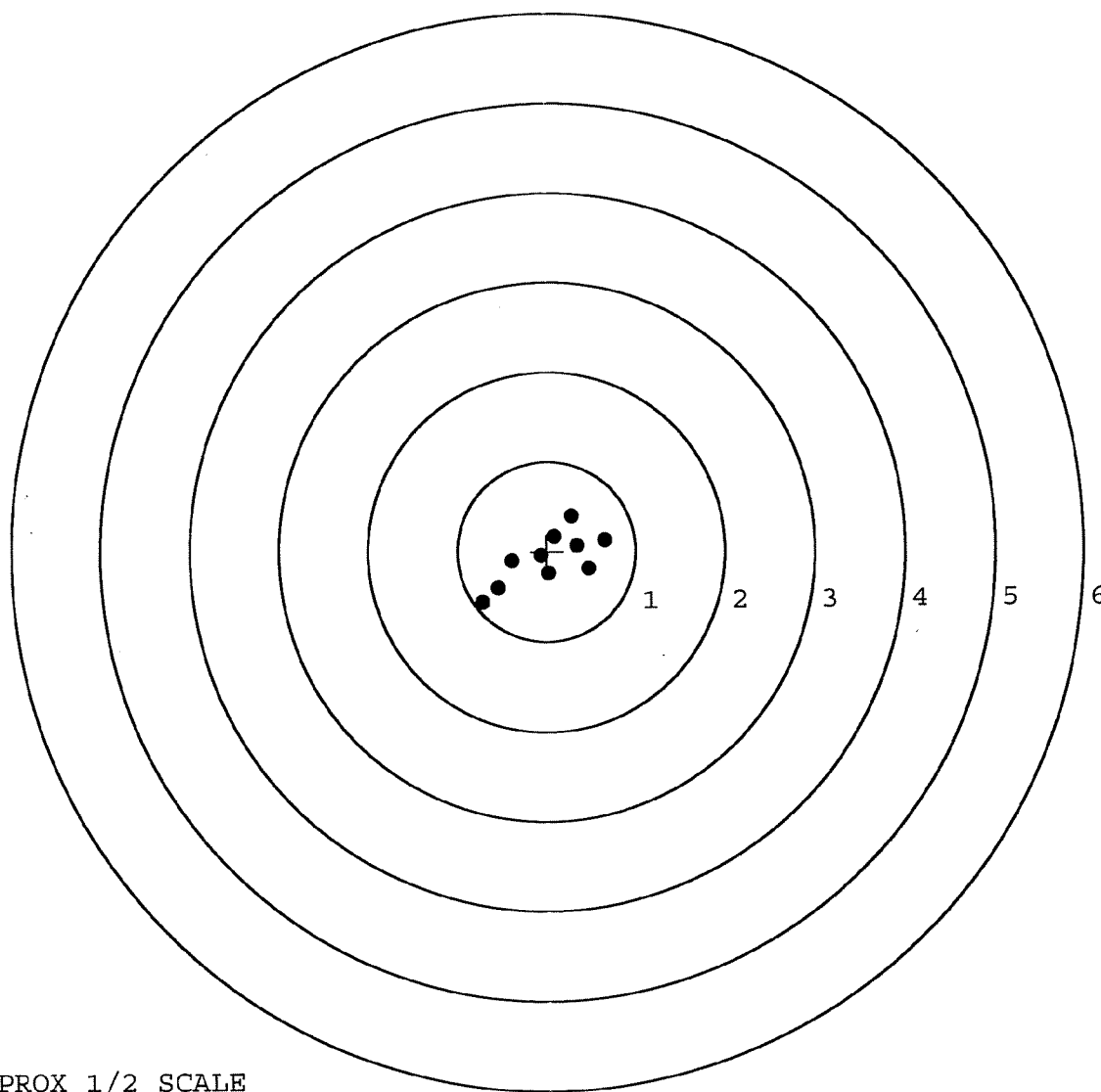
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.060
The Average Y Centroid of the Five Target Set:	-0.074
The Average Point of Impact of the Five Target Set:	0.095
The Average Mean Radius of the Five Target Set:	0.558
The Distance from POA to Centroid Target #1:	0.086
The Distance from Centroid Target #2 to Centroid Target #1:	0.105
The Distance from Centroid Target #3 to Centroid Target #1:	0.210
The Distance from Centroid Target #4 to Centroid Target #1:	0.114
The Distance from Centroid Target #5 to Centroid Target #1:	0.254

SERIAL NUMBER: G6590059. __0
TARGET NUMBER: 1
FILE DATE: 08/14/2006
FILE TIME: 15:05

X CENTROID: 0.010
Y CENTROID: -0.085
POA TO CENTROID: 0.086
HORZ SPREAD: 1.373
VERT SPREAD: 0.959
GROUP SPREAD: 1.539
MIN RADIUS: 0.086
MAX RADIUS: 0.877
MEAN RADIUS: 0.449
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.720	-0.571
2:	-0.548	-0.413
3:	-0.395	-0.107
4:	-0.067	-0.048
5:	0.015	-0.253
6:	0.083	0.165
7:	0.277	0.388
8:	0.336	0.062
9:	0.653	0.125
10:	0.470	-0.197

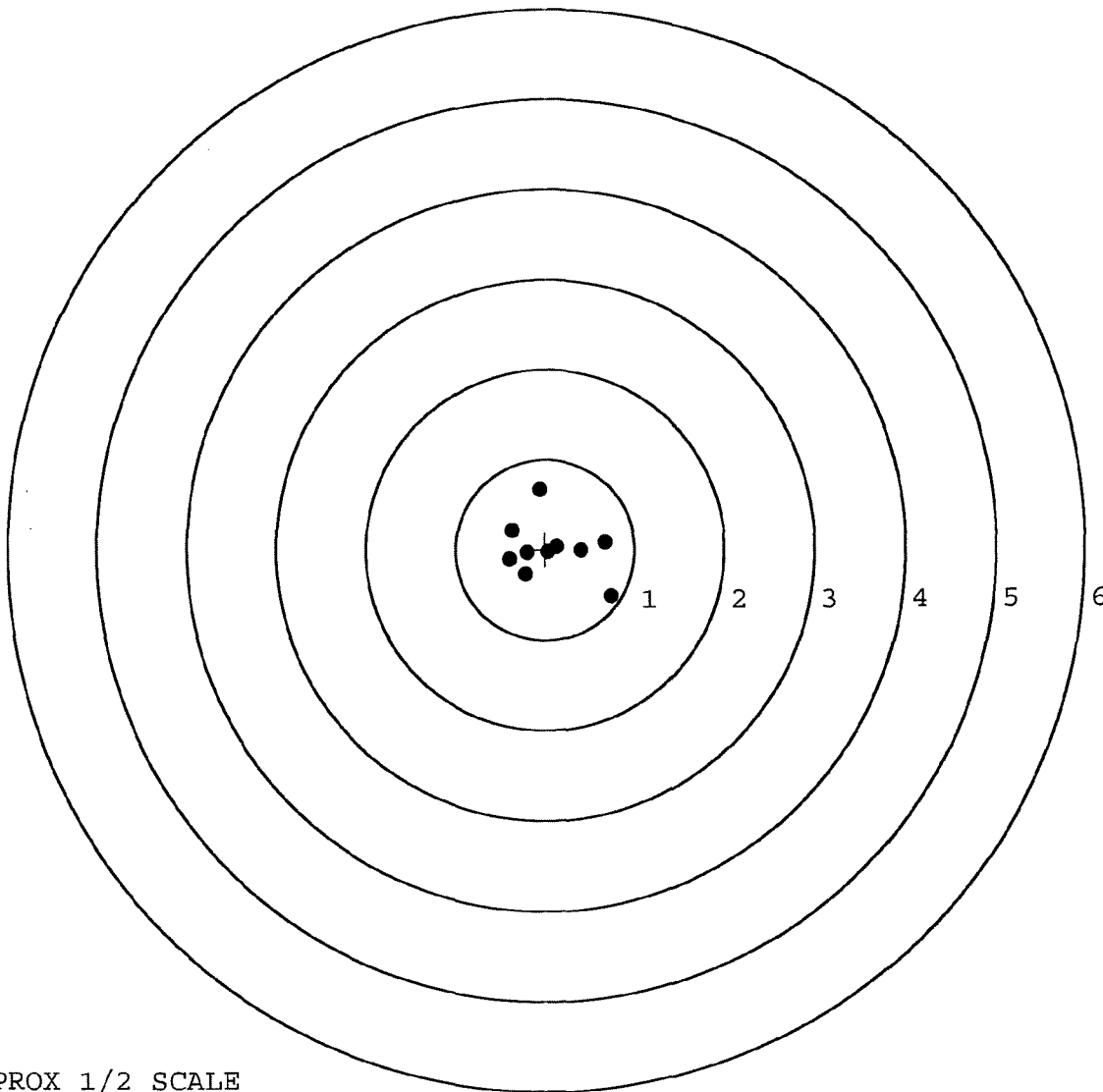


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590059. 0
TARGET NUMBER: 2
FILE DATE: 08/14/2006
FILE TIME: 15:05

X CENTROID: 0.070
Y CENTROID: 0.001
POA TO CENTROID: 0.070
HORZ SPREAD: 1.139
VERT SPREAD: 1.182
GROUP SPREAD: 1.427
MIN RADIUS: 0.052
MAX RADIUS: 0.845
MEAN RADIUS: 0.424
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.064	0.663
2:	-0.376	0.210
3:	0.130	0.033
4:	-0.224	-0.278
5:	-0.403	-0.108
6:	0.028	-0.029
7:	0.405	-0.011
8:	0.672	0.086
9:	0.736	-0.519
10:	-0.203	-0.038

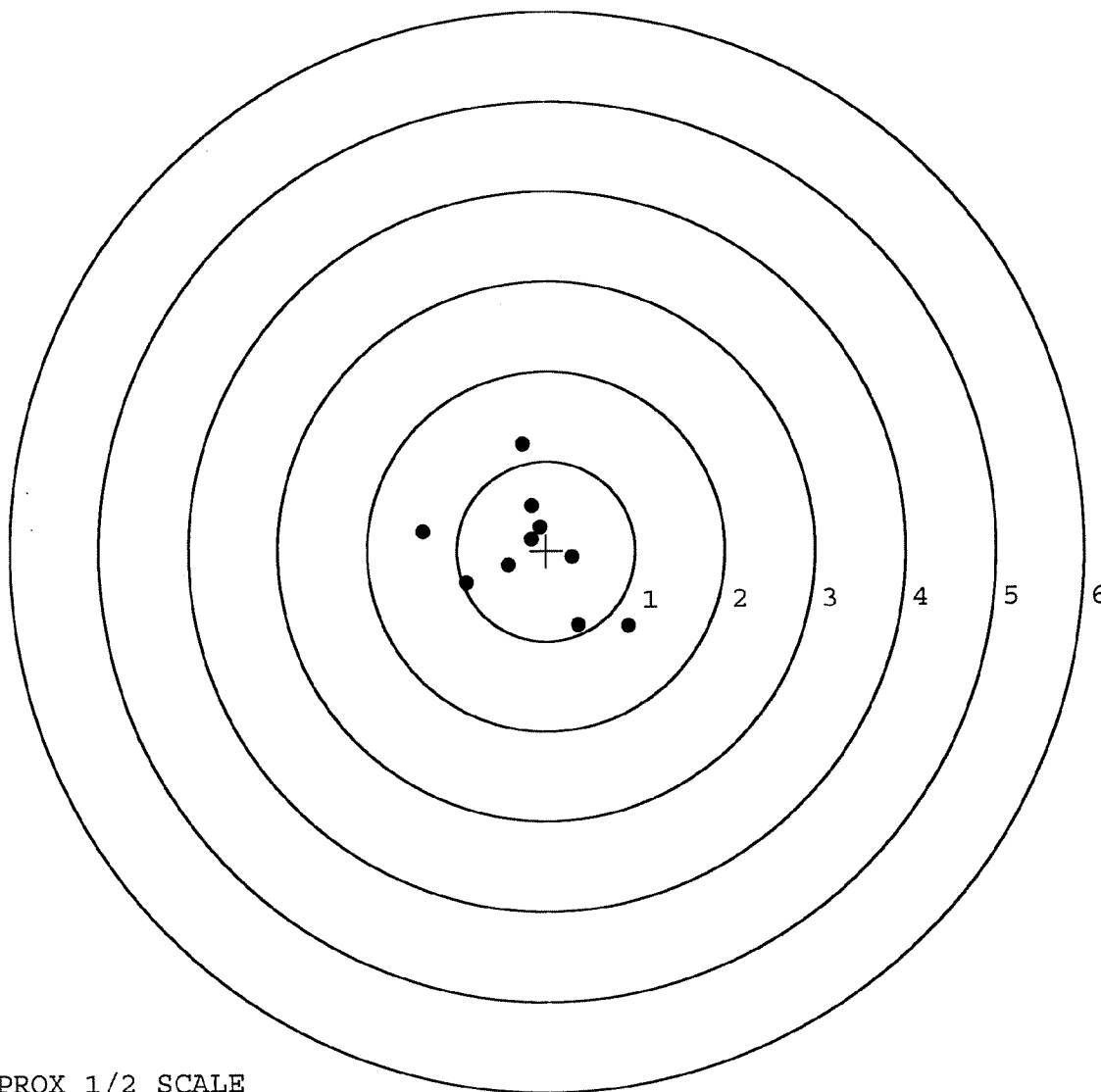


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590059. __0
TARGET NUMBER: 3
FILE DATE: 08/14/2006
FILE TIME: 15:05

X CENTROID: -0.180
Y CENTROID: 0.003
POA TO CENTROID: 0.180
HORZ SPREAD: 2.295
VERT SPREAD: 2.032
GROUP SPREAD: 2.528
MIN RADIUS: 0.130
MAX RADIUS: 1.386
MEAN RADIUS: 0.727
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.265	1.189
2:	-1.378	0.218
3:	-0.894	-0.356
4:	-0.428	-0.164
5:	-0.171	0.133
6:	-0.160	0.501
7:	-0.072	0.261
8:	0.292	-0.079
9:	0.355	-0.830
10:	0.917	-0.843



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590059. __0

TARGET NUMBER: 4

FILE DATE: 08/14/2006

FILE TIME: 15:05

POINT#	X	Y
1:	-0.075	-0.308
2:	0.255	-0.335
3:	0.311	-0.460
4:	0.105	-0.508
5:	-0.059	-0.713
6:	-0.211	-0.602
7:	-0.349	-0.004
8:	-0.188	0.522
9:	0.284	0.713
10:	0.376	-0.243

X CENTROID: 0.045

Y CENTROID: -0.194

POA TO CENTROID: 0.199

HORZ SPREAD: 0.725

VERT SPREAD: 1.426

GROUP SPREAD: 1.467

MIN RADIUS: 0.166

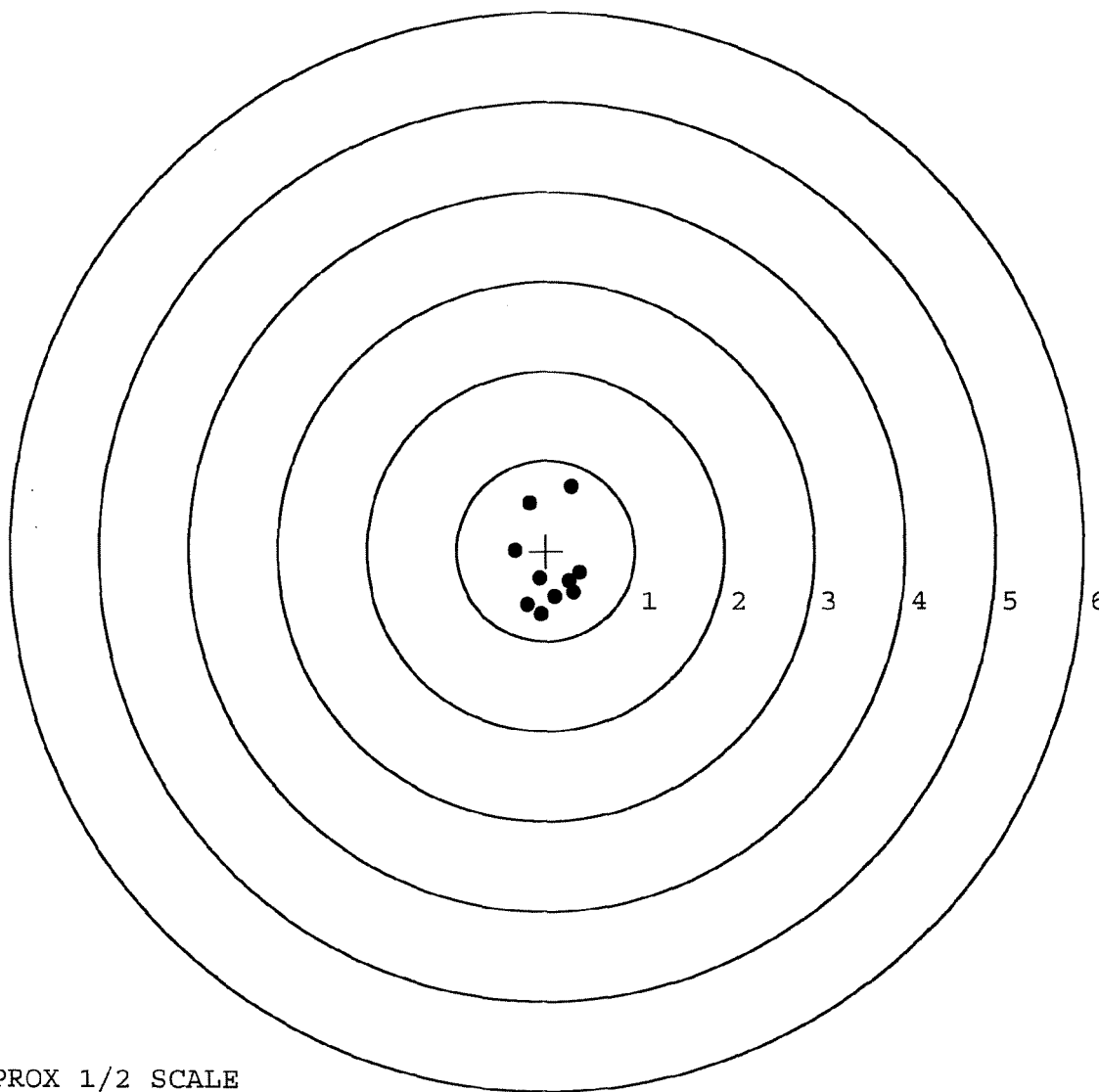
MAX RADIUS: 0.938

MEAN RADIUS: 0.459

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590059. 0

TARGET NUMBER: 5

FILE DATE: 08/14/2006

FILE TIME: 15:05

X CENTROID: -0.244

Y CENTROID: -0.093

POA TO CENTROID: 0.261

HORZ SPREAD: 1.986

VERT SPREAD: 1.885

GROUP SPREAD: 2.709

MIN RADIUS: 0.160

MAX RADIUS: 1.476

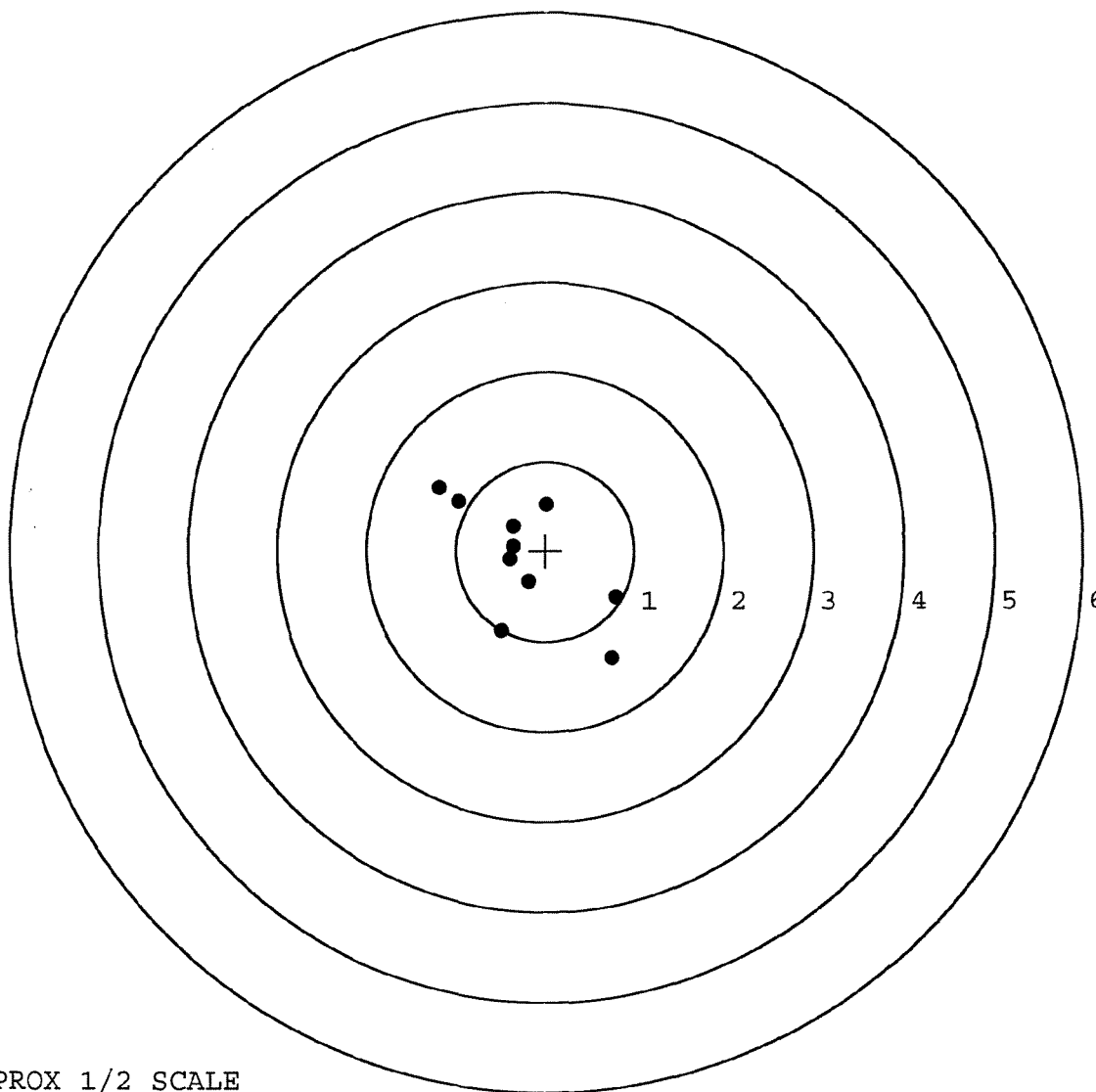
MEAN RADIUS: 0.729

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.193	0.704
2:	-0.979	0.550
3:	-0.368	0.276
4:	-0.404	-0.100
5:	-0.192	-0.345
6:	0.010	0.514
7:	-0.494	-0.884
8:	0.793	-0.511
9:	0.753	-1.181
10:	-0.364	0.050



TARGET APPROX 1/2 SCALE