

G-6590063

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

G6590063

UPC



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

UPC



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

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590063

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLC
420	ASSEMBLE ACTION		6/22/06	BLC
430	ASSEMBLE TO STOCK		6-23-06	R.P.
440	PROOF		6-23-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	6-23-06	TRW
470	DIS-ASSEMBLE ACTION	JUN 27 2006	6-26-06	BLC
480	MAGNAFLUX BBL ACTION	OPERATOR <u>C.P.D.</u>	6-27-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-28-06	CW
510	DRILL AND TAP SIGHT HOLES		6-26-06	TRW
520	GOFF BLAST BBL / REC		6-28-06	LC
530 & 540	APPLY COATINGS (BARREL ACTION)		7/12	off
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-19-06	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-19-06	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-19-06	RTZ
	D) OIL FIRING PIN ASSEMBLY		7-19-06	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>7.0</u> <u>6.5</u> <u>6.5</u>	7-20-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>45</u> <u>40</u> <u>45</u>	7-20-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1023</u> <u>1022</u>	7-20-06	DA
	J) ASSEMBLE STOCK		7-19-06	RL
	K) ASSEMBLE SWIVEL STUDS		8-9-06	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-19-06	BLC
	M) IRON SIGHT ALIGNMENT		7-19-06	BLC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-19-06	BLC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	7-19-06	MTM
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7/19/06	MTM
670	FINAL INSPECTION A) HEADSPACE		8-9-06	A
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.36</u> <u>2.20</u> <u>2.24</u> <u>2.46</u> <u>2.21</u>	7-20-06	DA
	C) FUNCTION		8-9-06	A
690	PACK		11-16-06	BLC

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

7-14-06

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.55		2.60	
PULL #2	2.42	2.55		2.59	
PULL #3	2.54	2.48		2.46	
PULL #4	2.55	2.56		2.31	
PULL #5	2.46	2.63		2.66	
TOTAL	12.51	12.77		12.62	
AVERAGE	2.50	2.55		2.52	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.18		
PULL #2	3.09	2.86		
PULL #3	3.16	3.21		
PULL #4	3.17	3.03		
PULL #5	3.20	3.12		
TOTAL	15.69	15.40		
AVERAGE	3.13	3.08		

	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	4.03	4.02		4.08
PULL #2	4.16	4.20		4.21
PULL #3	4.12	4.11		4.23
PULL #4	4.21	4.05		3.96
PULL #5	4.21	4.17		4.02
TOTAL	20.73	20.55		20.50
AVERAGE	4.14	4.11		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590063.__0
FILE DATE AND TIME: 07/19/2006 16:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.018
The Average Y Centroid of the Five Target Set:	-0.105
The Average Point of Impact of the Five Target Set:	0.106
The Average Mean Radius of the Five Target Set:	0.747
The Distance from POA to Centroid Target #1:	0.377
The Distance from Centroid Target #2 to Centroid Target #1:	0.358
The Distance from Centroid Target #3 to Centroid Target #1:	0.618
The Distance from Centroid Target #4 to Centroid Target #1:	0.243
The Distance from Centroid Target #5 to Centroid Target #1:	0.365

SERIAL NUMBER: G6590063. __0

TARGET NUMBER: 1

FILE DATE: 07/19/2006

FILE TIME: 16:59

X CENTROID: 0.172

Y CENTROID: -0.336

POA TO CENTROID: 0.377

HORZ SPREAD: 2.288

VERT SPREAD: 2.195

GROUP SPREAD: 2.648

MIN RADIUS: 0.339

MAX RADIUS: 1.384

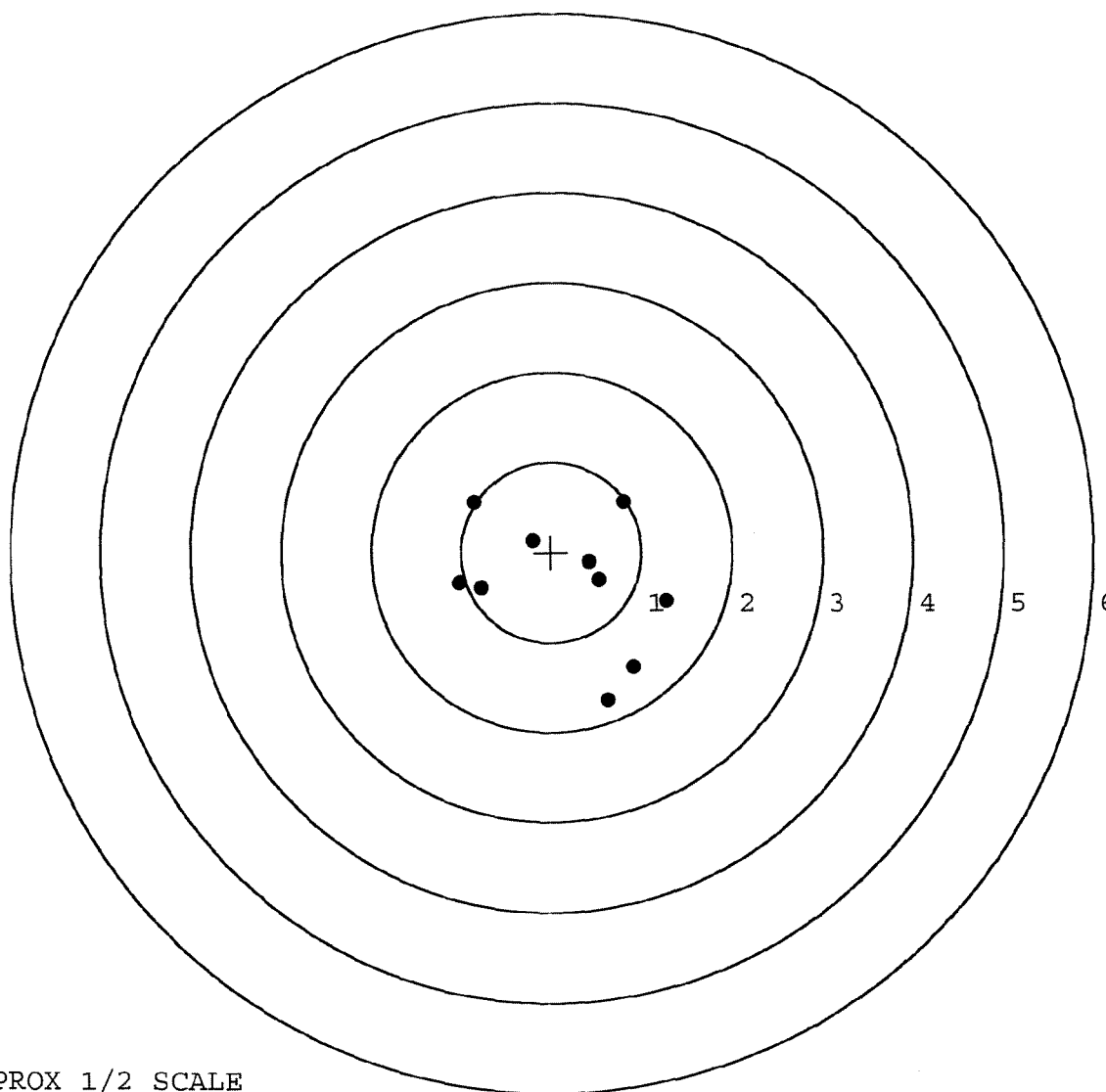
MEAN RADIUS: 0.957

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.858	0.548
2:	-1.014	-0.337
3:	-0.773	-0.394
4:	-0.205	0.123
5:	0.421	-0.105
6:	0.529	-0.302
7:	0.801	0.555
8:	1.274	-0.537
9:	0.914	-1.267
10:	0.634	-1.640



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590063. __0

TARGET NUMBER: 2

FILE DATE: 07/19/2006

FILE TIME: 16:59

POINT#	X	Y
1:	-0.213	0.706
2:	0.311	0.927
3:	0.891	0.370
4:	0.383	-0.018
5:	0.068	0.193
6:	0.478	-0.547
7:	0.122	-1.046
8:	-0.781	-0.613
9:	-0.869	-0.398
10:	-0.845	-0.095

X CENTROID: -0.046

Y CENTROID: -0.052

POA TO CENTROID: 0.069

HORZ SPREAD: 1.760

VERT SPREAD: 1.973

GROUP SPREAD: 1.982

MIN RADIUS: 0.270

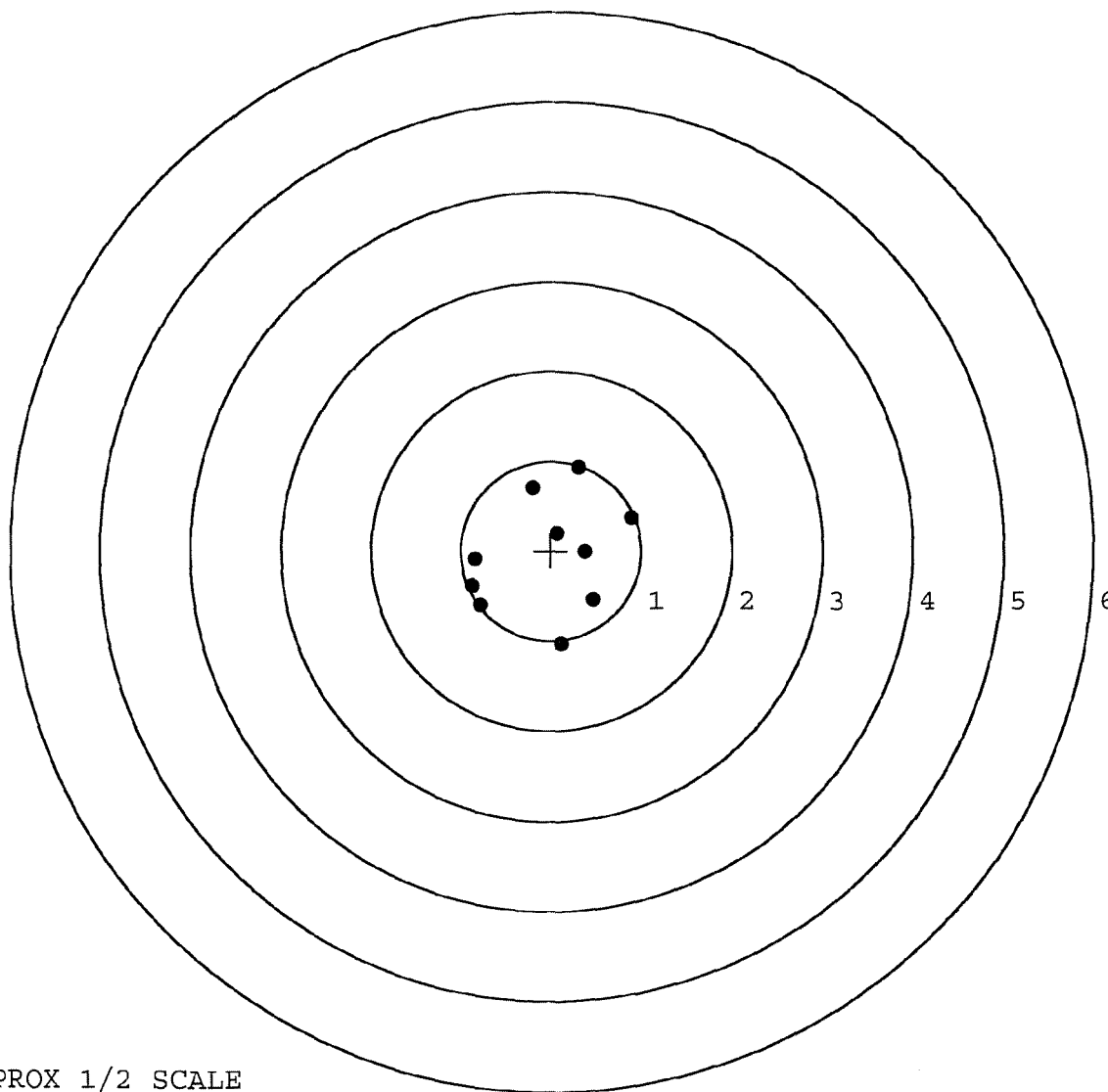
MAX RADIUS: 1.042

MEAN RADIUS: 0.789

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590063.___0

TARGET NUMBER: 3

FILE DATE: 07/19/2006

FILE TIME: 16:59

X CENTROID: -0.259

Y CENTROID: 0.108

POA TO CENTROID: 0.280

HORZ SPREAD: 2.093

VERT SPREAD: 1.431

GROUP SPREAD: 2.183

MIN RADIUS: 0.190

MAX RADIUS: 1.414

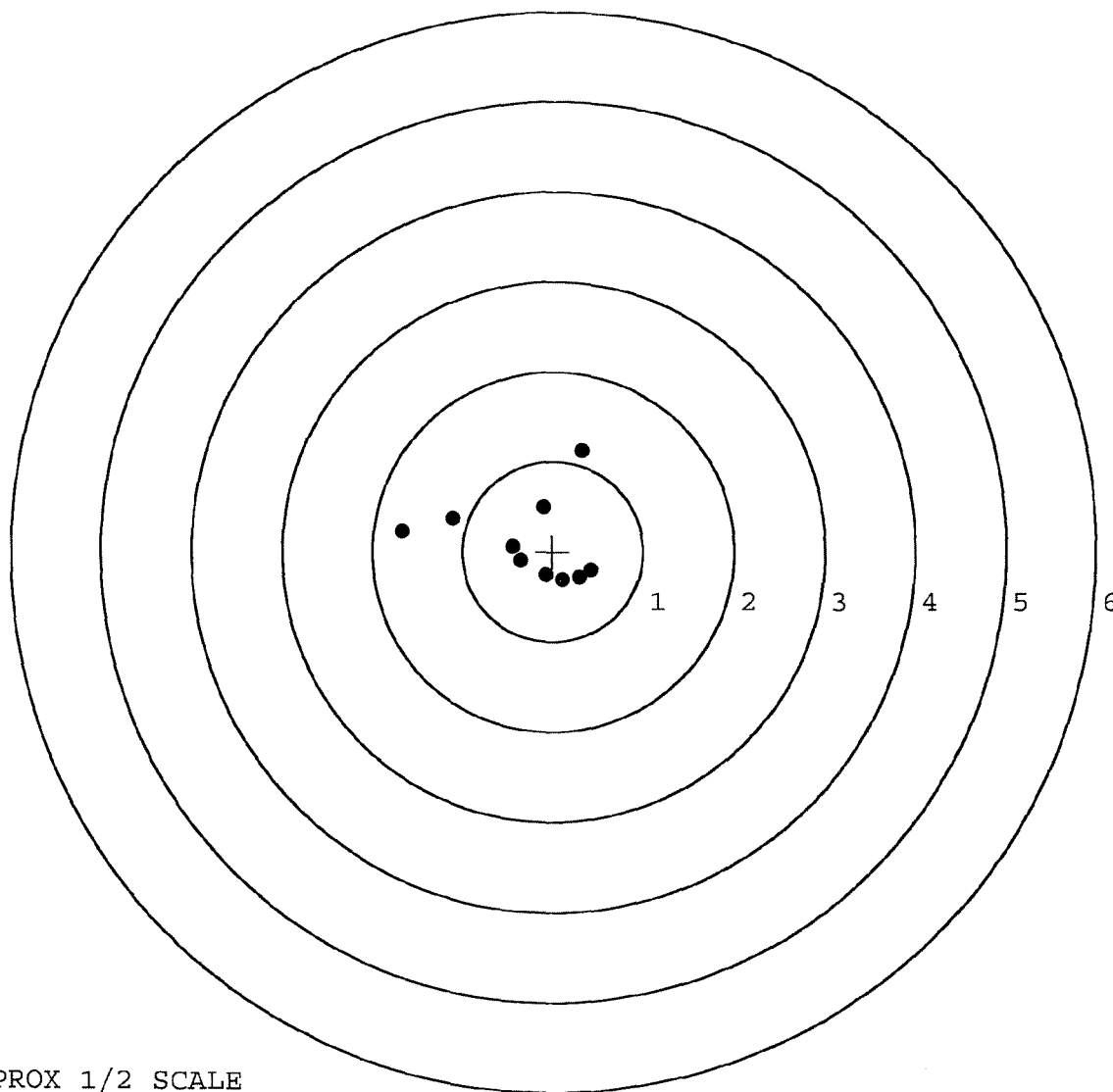
MEAN RADIUS: 0.672

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.668	0.224
2:	-1.108	0.368
3:	0.325	1.115
4:	-0.100	0.492
5:	-0.442	0.057
6:	-0.357	-0.101
7:	-0.076	-0.263
8:	0.117	-0.316
9:	0.296	-0.293
10:	0.425	-0.207

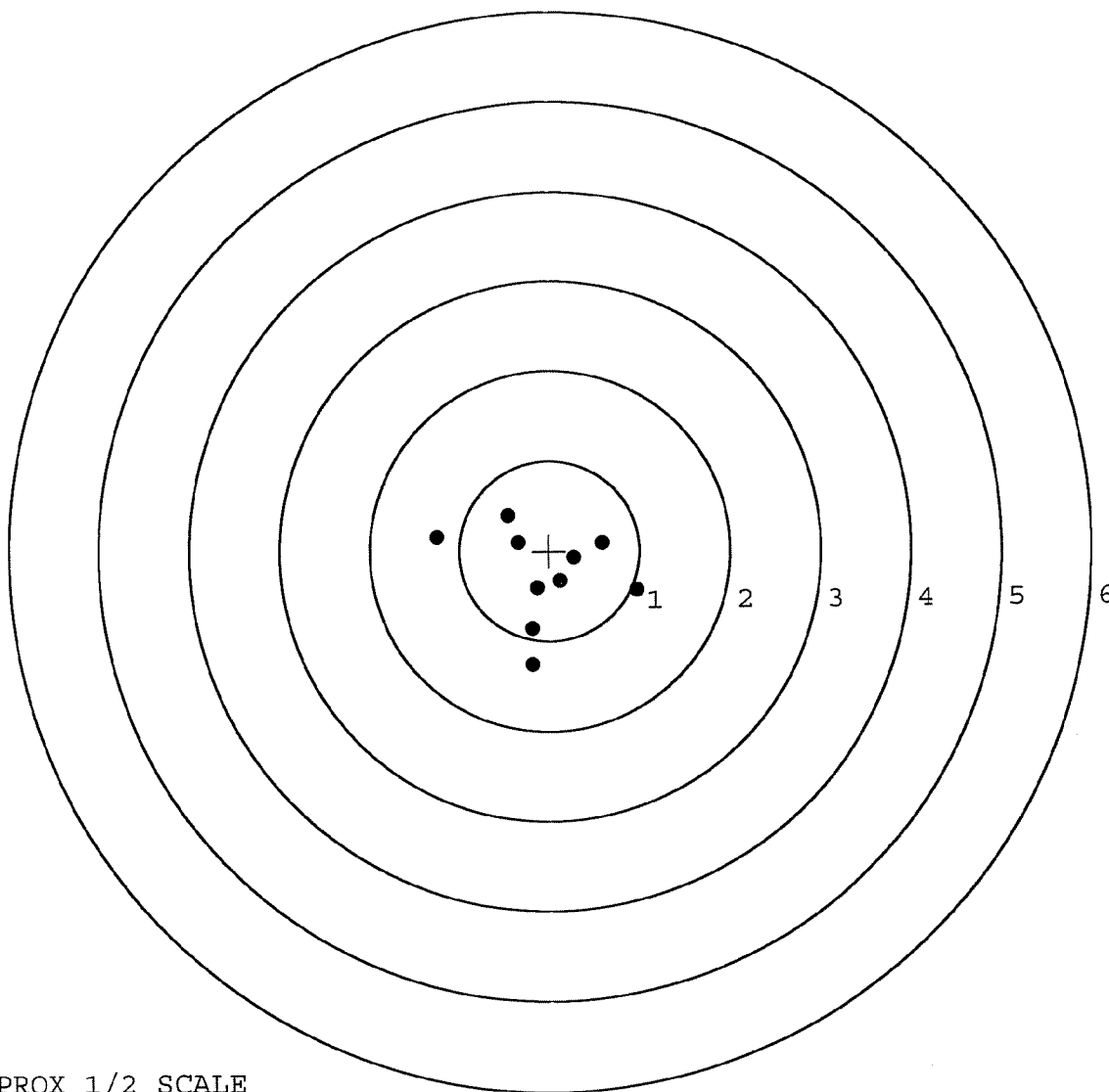


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590063.___0
TARGET NUMBER: 4
FILE DATE: 07/19/2006
FILE TIME: 16:59

X CENTROID: -0.060
Y CENTROID: -0.267
POA TO CENTROID: 0.273
HORZ SPREAD: 2.216
VERT SPREAD: 1.671
GROUP SPREAD: 2.297
MIN RADIUS: 0.166
MAX RADIUS: 1.263
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.248	0.162
2:	-0.458	0.399
3:	-0.346	0.096
4:	-0.135	-0.415
5:	0.126	-0.337
6:	0.280	-0.074
7:	0.593	0.090
8:	0.968	-0.444
9:	-0.192	-0.870
10:	-0.192	-1.272

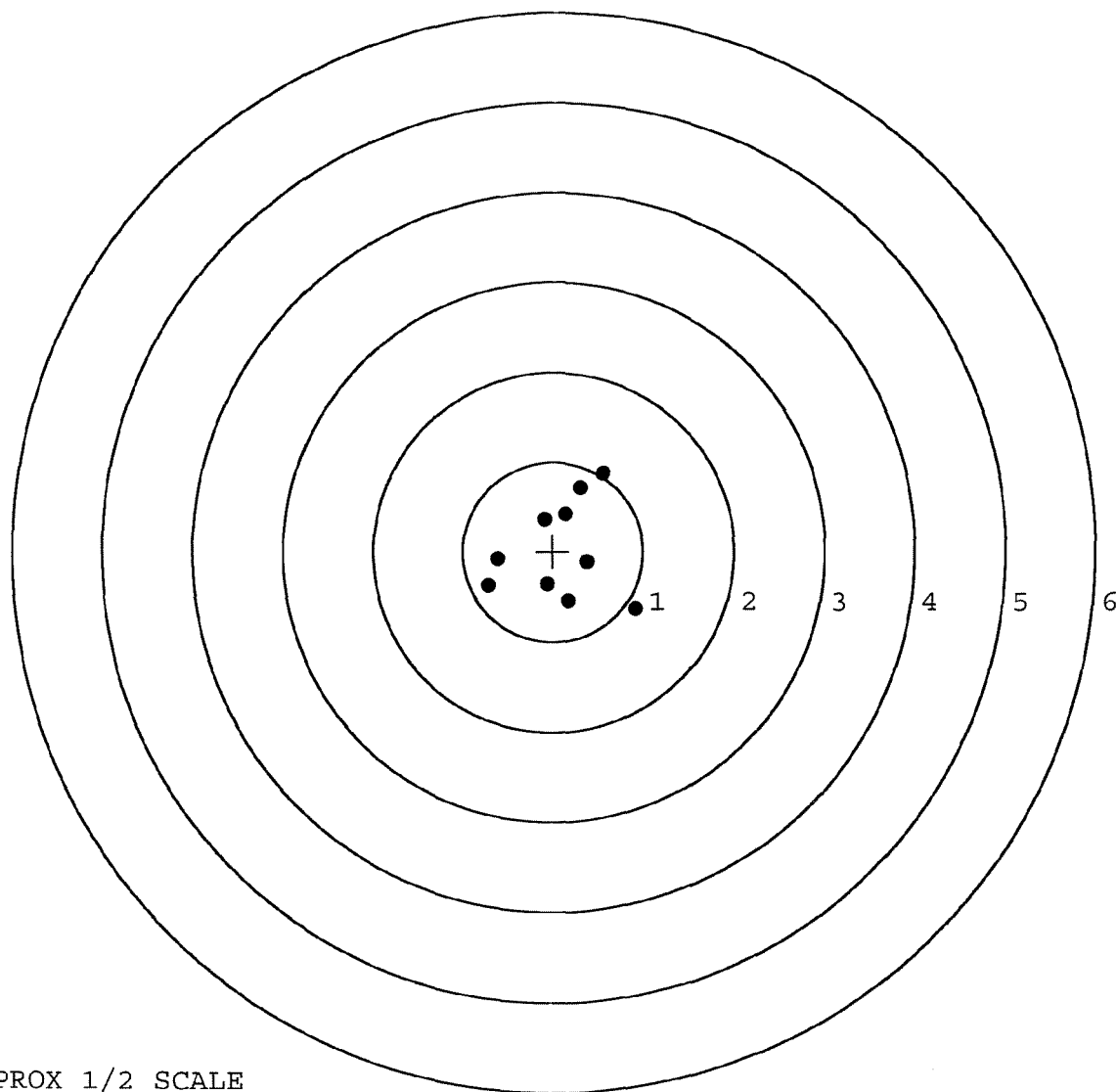


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590063. __0
TARGET NUMBER: 5
FILE DATE: 07/19/2006
FILE TIME: 16:59

POINT#	X	Y
1:	-0.715	-0.386
2:	-0.613	-0.093
3:	-0.064	-0.368
4:	0.184	-0.548
5:	0.386	-0.114
6:	0.922	-0.635
7:	-0.100	0.355
8:	0.146	0.426
9:	0.311	0.715
10:	0.556	0.877

X CENTROID: 0.101
Y CENTROID: 0.023
POA TO CENTROID: 0.104
HORZ SPREAD: 1.637
VERT SPREAD: 1.512
GROUP SPREAD: 1.656
MIN RADIUS: 0.316
MAX RADIUS: 1.052
MEAN RADIUS: 0.649
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE