

G6590097

ORDER 25716

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

UPC



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UPC



SERIAL NO.



M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



DD FORM

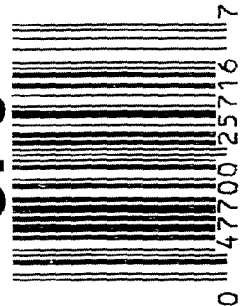
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590097

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M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590097

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		6/21/06	BLG
420	ASSEMBLE ACTION		6/22/06	BLG
430	ASSEMBLE TO STOCK		6-23-06	R.P.
440	PROOF	MAGNA-FLUX	6-23-06	TRL
460	CHECK HEADSPACE	INSPECTED	6-23-06	TRL
470	DIS-ASSEMBLE ACTION	JUN 27 2006	6-26-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	6-27-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-27-06	CDW
510	DRILL AND TAP SIGHT HOLES		6-26-06	TRL
520	GOFF BLAST BBL / REC		6-28-06	(AC)
530 & 540	APPLY COATINGS (BARREL ACTION)		7/2	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-19-06	RT
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-19-06	RT
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-19-06	RT
	D) OIL FIRING PIN ASSEMBLY		7-19-06	RT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-17-06	WSTH
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.2</u> <u>7.5</u> <u>7.2</u>	8-15-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5.5</u> <u>5.2</u> <u>5.2</u>	8-15-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-17-06	msm
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1023</u> <u>1023</u>	8-15-06	RA
	J) ASSEMBLE STOCK		7-19-06	RL
	K) ASSEMBLE SWIVEL STUDS		8-17-06	msm
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7-19-06	BLG
	M) IRON SIGHT ALIGNMENT		7-19-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7-19-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	7-24-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		7-24-06	msm
670	FINAL INSPECTION A) HEADSPACE		8-17-06	msm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.47</u> <u>2.87</u> <u>2.88</u> <u>2.75</u>	8-11-06	A
	C) FUNCTION		8-17-06	msm
690	PACK		11/14/06	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 7-19-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	250	268		241	
PULL #2	256	258		240	
PULL #3	233	260		247	
PULL #4	251	245		248	
PULL #5	238	253		249	
TOTAL	1228	1284		1225	
AVERAGE	245	256		245	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	311	314		
PULL #2	326	316		
PULL #3	310	313		
PULL #4	325	310		
PULL #5	315	313		
TOTAL	1587	1566		
AVERAGE	317	313		

	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	4.04	4.11		4.16
PULL #2	4.20	4.13		4.17
PULL #3	4.06	4.08		4.26
PULL #4	4.08	3.93		4.22
PULL #5	4.13	4.21		4.20
TOTAL	20.51	20.46		21.01
AVERAGE	4.10	4.09		4.20

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590097.__0
FILE DATE AND TIME: 07/24/2006 07:56

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.036
The Average Y Centroid of the Five Target Set:	-0.037
The Average Point of Impact of the Five Target Set:	0.051
The Average Mean Radius of the Five Target Set:	0.776
The Distance from POA to Centroid Target #1:	0.237
The Distance from Centroid Target #2 to Centroid Target #1:	0.371
The Distance from Centroid Target #3 to Centroid Target #1:	0.312
The Distance from Centroid Target #4 to Centroid Target #1:	0.429
The Distance from Centroid Target #5 to Centroid Target #1:	0.372

SERIAL NUMBER: G6590097. __0

TARGET NUMBER: 1

FILE DATE: 07/24/2006

FILE TIME: 07:56

X CENTROID: 0.229

Y CENTROID: 0.061

POA TO CENTROID: 0.237

HORZ SPREAD: 1.680

VERT SPREAD: 1.494

GROUP SPREAD: 1.924

MIN RADIUS: 0.084

MAX RADIUS: 1.223

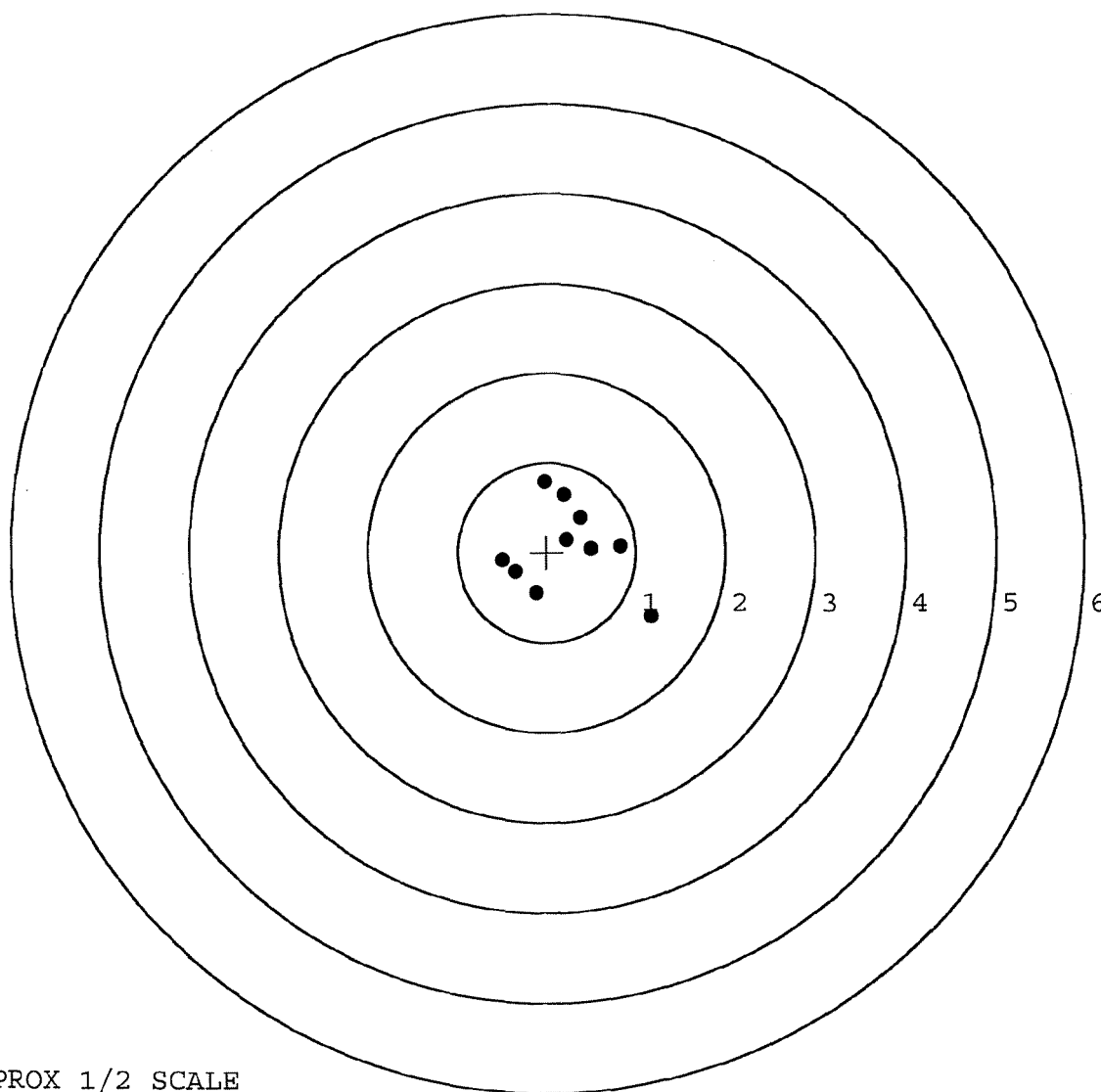
MEAN RADIUS: 0.591

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.501	-0.098
2:	-0.358	-0.217
3:	-0.118	-0.455
4:	1.179	-0.709
5:	0.830	0.074
6:	0.497	0.046
7:	0.224	0.144
8:	0.379	0.393
9:	0.191	0.642
10:	-0.033	0.785



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590097. 0

TARGET NUMBER: 2

FILE DATE: 07/24/2006

FILE TIME: 07:56

X CENTROID: -0.135

Y CENTROID: -0.008

POA TO CENTROID: 0.136

HORZ SPREAD: 1.710

VERT SPREAD: 2.136

GROUP SPREAD: 2.228

MIN RADIUS: 0.272

MAX RADIUS: 1.337

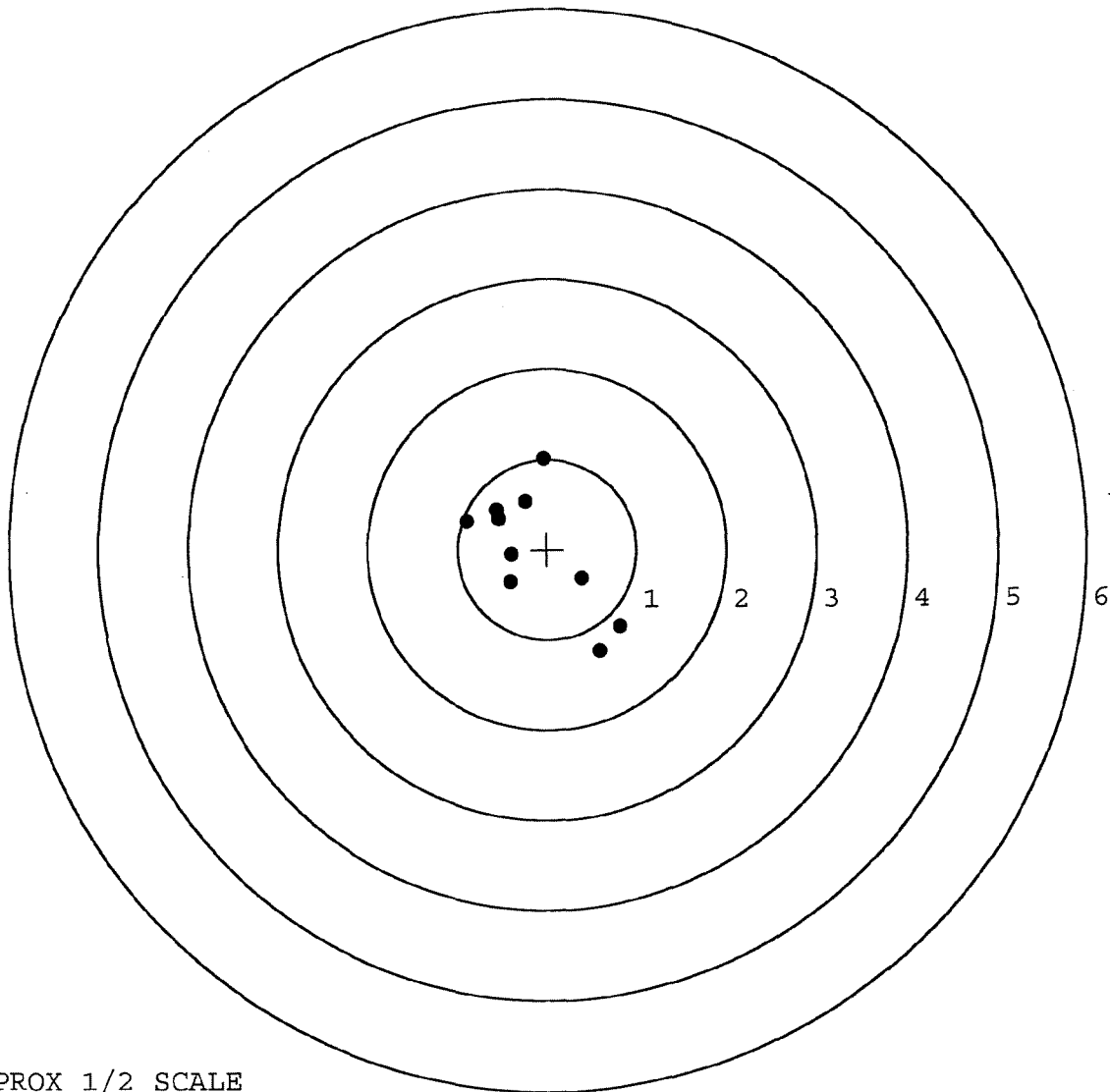
MEAN RADIUS: 0.752

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.389	-0.325
2:	0.807	-0.854
3:	0.592	-1.129
4:	-0.416	-0.361
5:	-0.403	-0.054
6:	-0.903	0.315
7:	-0.574	0.445
8:	-0.251	0.534
9:	-0.041	1.007
10:	-0.553	0.346

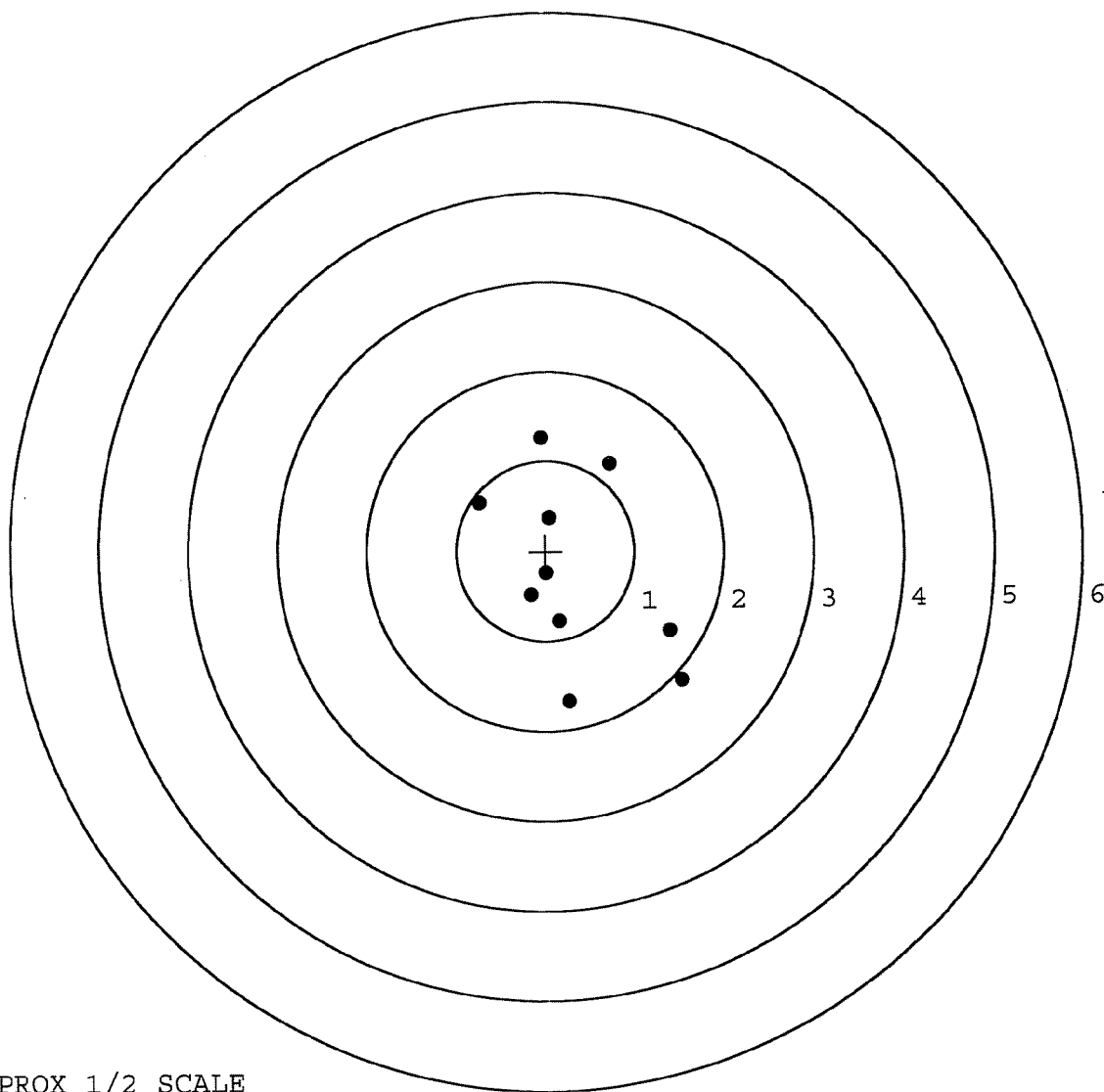


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590097.___0
TARGET NUMBER: 3
FILE DATE: 07/24/2006
FILE TIME: 07:56

X CENTROID: 0.312
Y CENTROID: -0.241
POA TO CENTROID: 0.394
HORZ SPREAD: 2.265
VERT SPREAD: 2.932
GROUP SPREAD: 3.126
MIN RADIUS: 0.313
MAX RADIUS: 1.709
MEAN RADIUS: 1.062
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.040	0.370
2:	-0.743	0.545
3:	-0.049	1.254
4:	0.724	0.964
5:	-0.001	-0.246
6:	-0.170	-0.489
7:	0.152	-0.783
8:	1.389	-0.894
9:	1.522	-1.448
10:	0.259	-1.678



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590097. __0

TARGET NUMBER: 4

FILE DATE: 07/24/2006

FILE TIME: 07:56

X CENTROID: -0.112

Y CENTROID: -0.199

POA TO CENTROID: 0.229

HORZ SPREAD: 1.550

VERT SPREAD: 2.428

GROUP SPREAD: 2.475

MIN RADIUS: 0.190

MAX RADIUS: 1.494

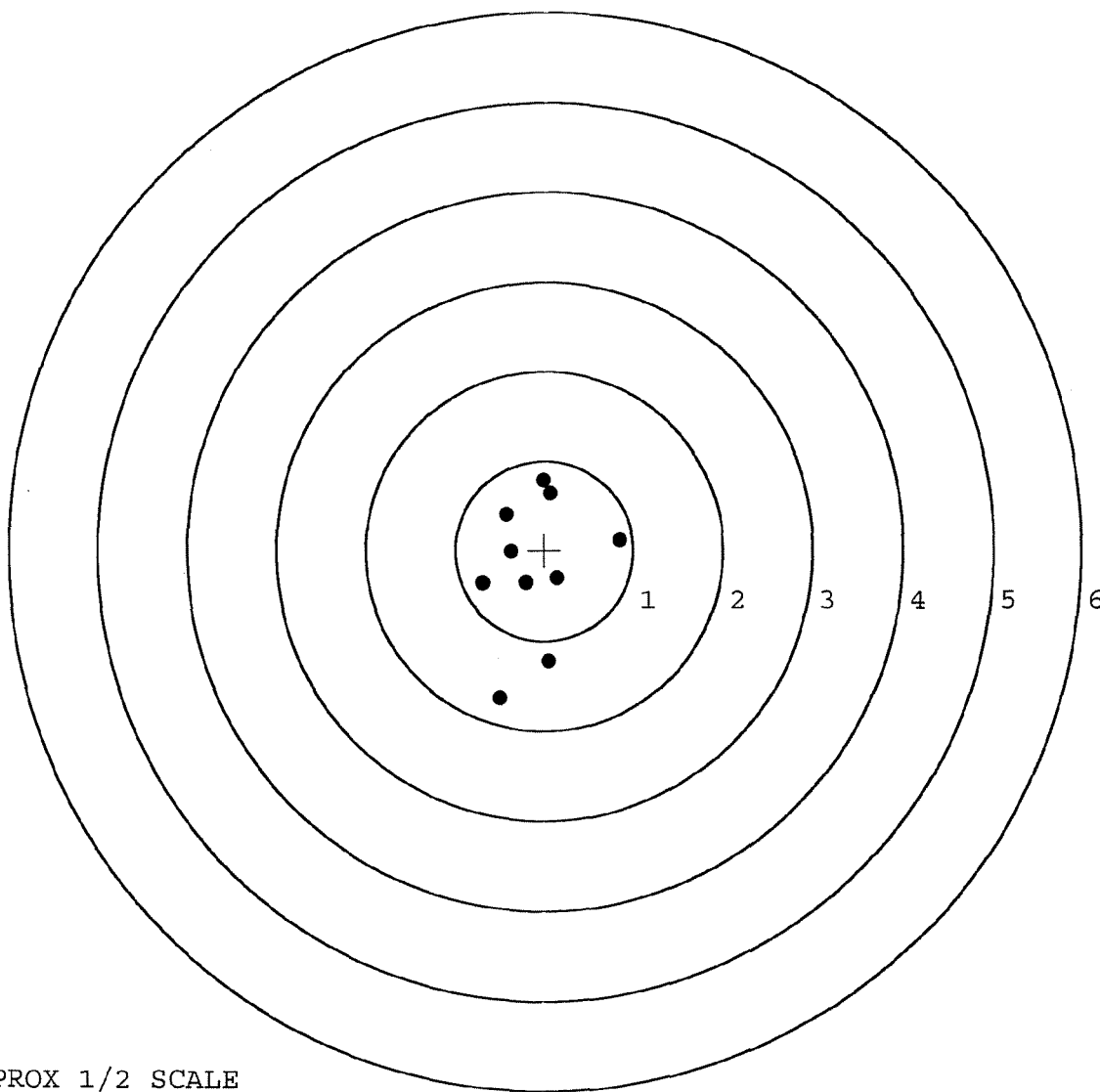
MEAN RADIUS: 0.748

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.065	0.639
2:	-0.018	0.785
3:	-0.438	0.399
4:	-0.377	-0.017
5:	-0.210	-0.362
6:	0.146	-0.315
7:	-0.697	-0.367
8:	0.853	0.119
9:	0.051	-1.231
10:	-0.498	-1.643

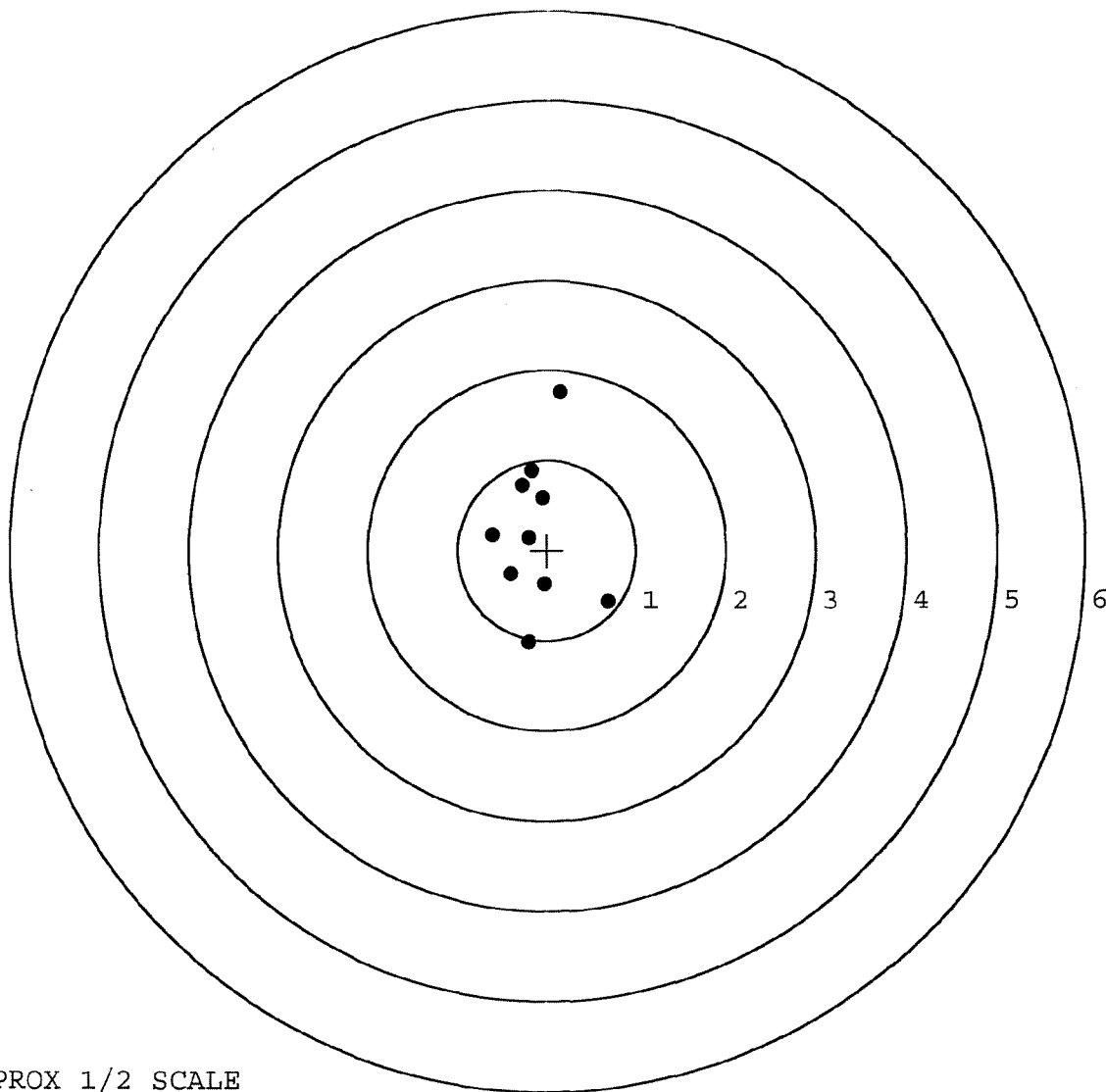


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590097. 0
TARGET NUMBER: 5
FILE DATE: 07/24/2006
FILE TIME: 07:56

X CENTROID: -0.114
Y CENTROID: 0.203
POA TO CENTROID: 0.233
HORZ SPREAD: 1.291
VERT SPREAD: 2.775
GROUP SPREAD: 2.796
MIN RADIUS: 0.109
MAX RADIUS: 1.570
MEAN RADIUS: 0.727
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.177	0.886
2:	-0.283	0.724
3:	-0.056	0.582
4:	-0.204	0.141
5:	-0.610	0.179
6:	-0.407	-0.263
7:	-0.028	-0.375
8:	0.681	-0.571
9:	-0.202	-1.023
10:	0.141	1.752



TARGET APPROX 1/2 SCALE