

G 6590098

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



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SERIAL NO.



M24 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

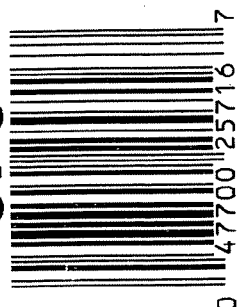
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590098

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G-6590098

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>APD</u>	6-27-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		6-27-06	CW
510	DRILL AND TAP SIGHT HOLES		6-26-06	TRW
520	GOFF BLAST BBL / REC		6-26-06	LC
530 & 540	APPLY COATINGS (BARREL ACTION)		7/12	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		7-21-06	BLC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-21-06	BLC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-21-06	BLC
	D) OIL FIRING PIN ASSEMBLY		7-31-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		8-22-06	MTJ
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.5</u> <u>6.5</u> <u>6.5</u>	8-22-06	RA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.0</u>	8-22-06	RA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-22-06	WJH
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	8-22-06	RA
	J) ASSEMBLE STOCK		7-31-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-22-06	WJH
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-1-06	RTZ
	M) IRON SIGHT ALIGNMENT		8-1-06	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-1-06	RTZ
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	8-2-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/2/06	MJD
670	FINAL INSPECTION A) HEADSPACE		8-22-06	WJH
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>250</u> <u>2.84</u> <u>2.81</u> <u>2.54</u> <u>2.79</u>	8/22/06	RP.
	C) FUNCTION		8-22-06	WJH
690	PACK		11/13/06	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 7-25-06

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.63	2.64		2.48	
PULL #2	2.58	2.63		2.60	
PULL #3	2.45	2.50		2.58	
PULL #4	2.64	2.51		2.43	
PULL #5	2.45	2.43		2.60	
TOTAL	12.75	12.71		12.69	
AVERAGE	2.55	2.54		2.53	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.00		
PULL #2	3.11	3.02		
PULL #3	2.99	3.00		
PULL #4	3.01	3.03		
PULL #5	2.89	2.90		
TOTAL	15.12	14.95		
AVERAGE	3.02	2.99		

	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	4.01	4.04		4.07
PULL #2	4.10	4.06		4.02
PULL #3	4.06	4.05		4.04
PULL #4	4.11	4.00		4.01
PULL #5	3.98	4.16		4.09
TOTAL	20.26	20.31		20.23
AVERAGE	4.05	4.06		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590098.___0
FILE DATE AND TIME: 08/02/2006 08:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	0.046
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.662
The Distance from POA to Centroid Target #1:	0.094
The Distance from Centroid Target #2 to Centroid Target #1:	0.231
The Distance from Centroid Target #3 to Centroid Target #1:	0.180
The Distance from Centroid Target #4 to Centroid Target #1:	0.109
The Distance from Centroid Target #5 to Centroid Target #1:	0.215

SERIAL NUMBER: G6590098. __0

TARGET NUMBER: 1

FILE DATE: 08/02/2006

FILE TIME: 08:04

X CENTROID: -0.047

Y CENTROID: -0.082

POA TO CENTROID: 0.094

HORZ SPREAD: 2.784

VERT SPREAD: 2.274

GROUP SPREAD: 3.261

MIN RADIUS: 0.087

MAX RADIUS: 2.463

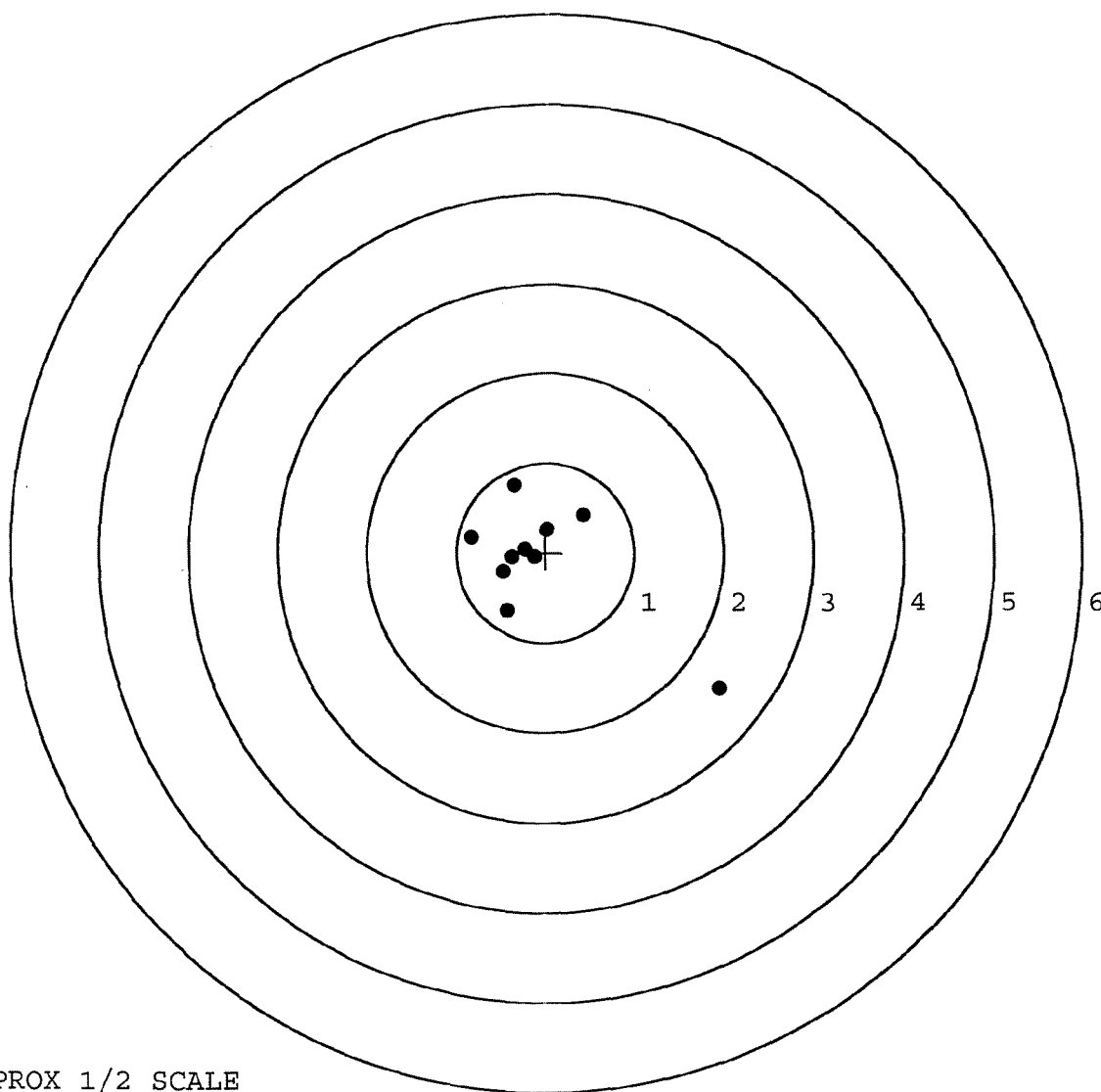
MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.423	0.424
2:	-0.357	0.755
3:	-0.831	0.180
4:	0.010	0.256
5:	-0.128	-0.051
6:	-0.382	-0.047
7:	-0.482	-0.215
8:	-0.439	-0.644
9:	1.953	-1.519
10:	-0.235	0.046



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590098. __0

TARGET NUMBER: 2

FILE DATE: 08/02/2006

FILE TIME: 08:04

X CENTROID: 0.109

Y CENTROID: 0.090

POA TO CENTROID: 0.141

HORZ SPREAD: 2.054

VERT SPREAD: 1.954

GROUP SPREAD: 2.414

MIN RADIUS: 0.148

MAX RADIUS: 1.421

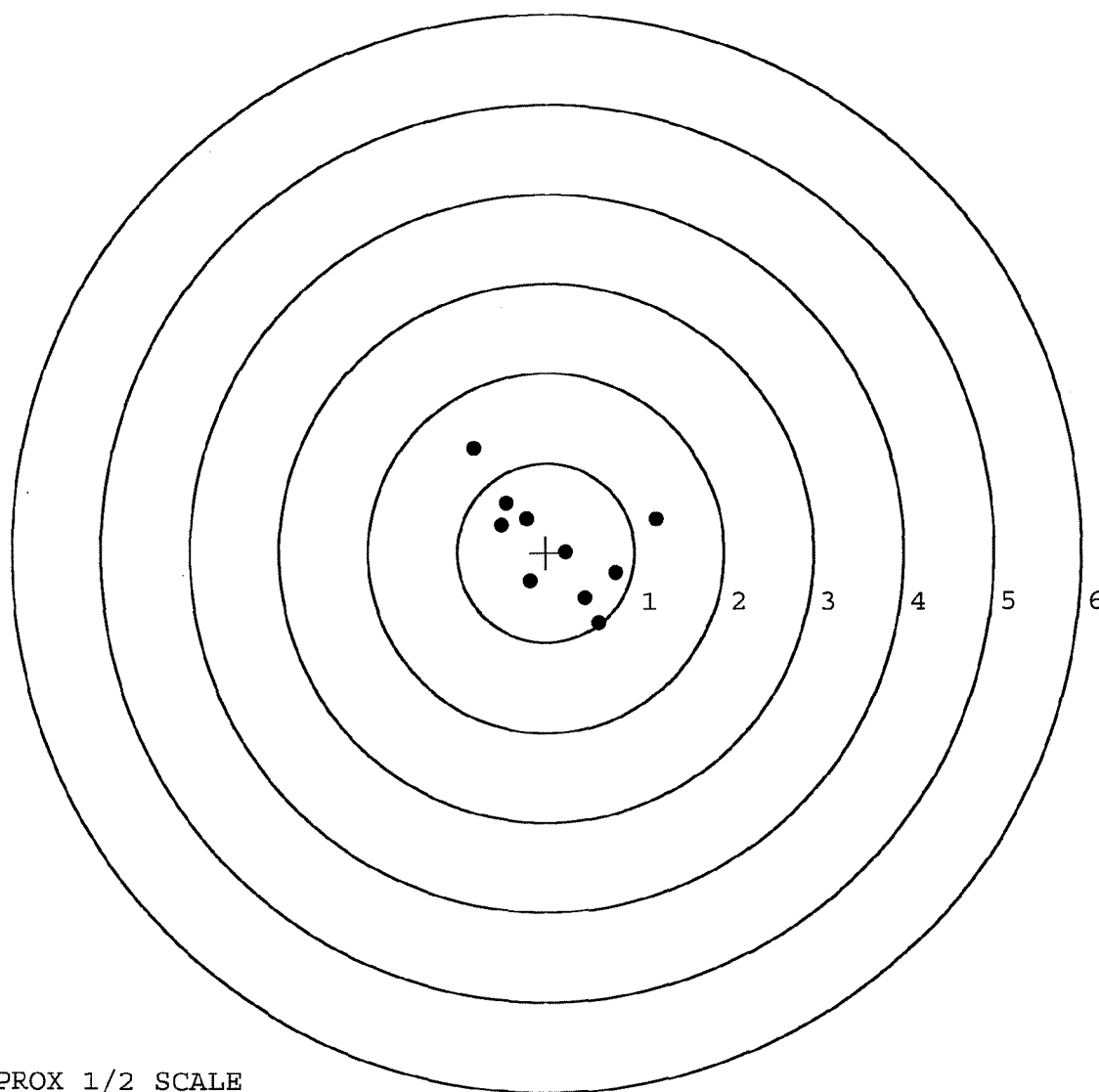
MEAN RADIUS: 0.750

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.599	-0.788
2:	0.434	-0.519
3:	0.786	-0.228
4:	1.235	0.367
5:	0.226	0.000
6:	-0.184	-0.325
7:	-0.460	0.547
8:	-0.507	0.302
9:	-0.223	0.377
10:	-0.819	1.166

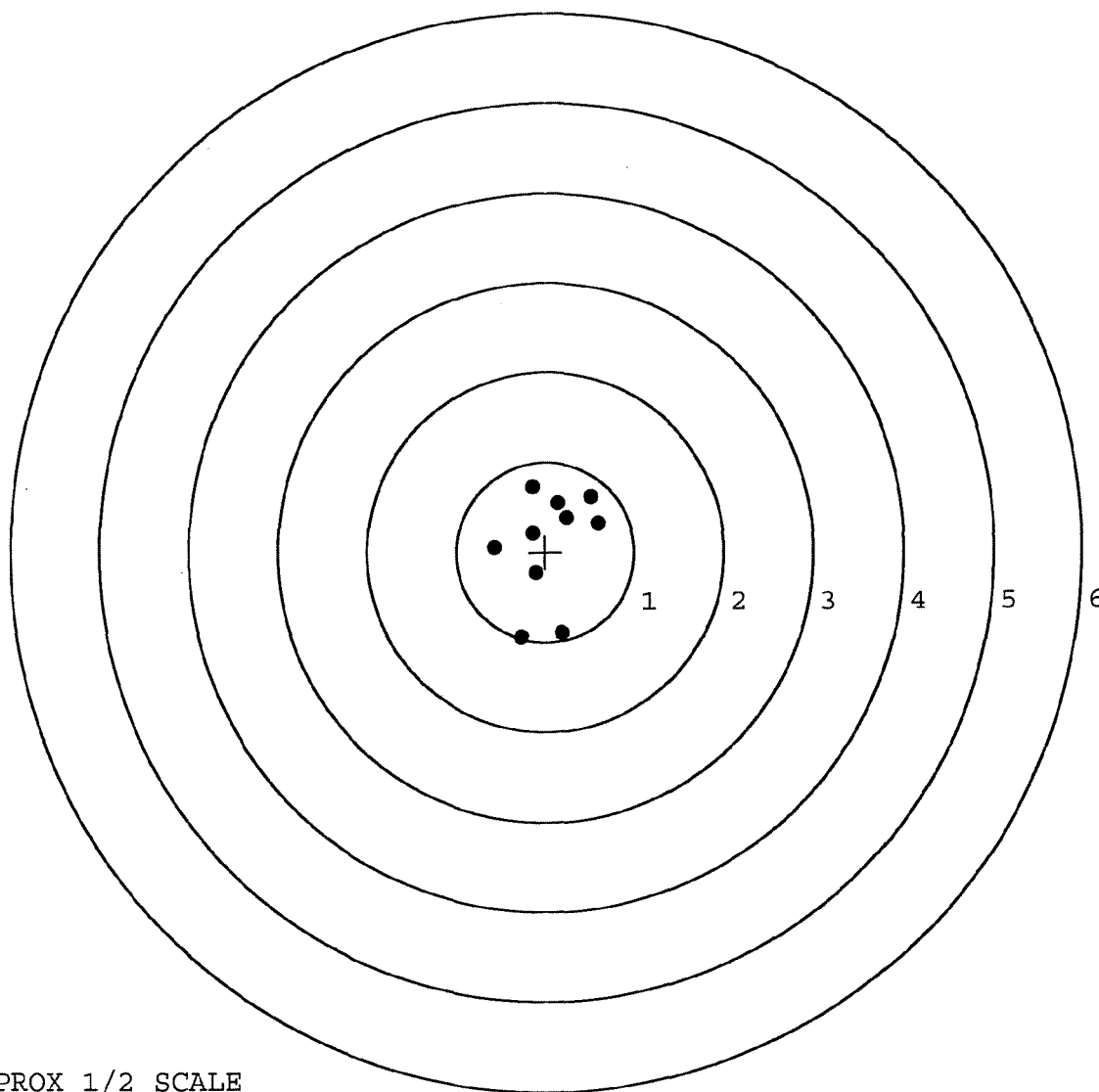


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590098. __0
TARGET NUMBER: 3
FILE DATE: 08/02/2006
FILE TIME: 08:04

X CENTROID: 0.039
Y CENTROID: 0.077
POA TO CENTROID: 0.086
HORZ SPREAD: 1.165
VERT SPREAD: 1.670
GROUP SPREAD: 1.751
MIN RADIUS: 0.225
MAX RADIUS: 1.071
MEAN RADIUS: 0.607
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.277	-0.947
2:	0.186	-0.900
3:	-0.112	-0.234
4:	-0.577	0.054
5:	-0.143	0.208
6:	-0.149	0.723
7:	0.134	0.541
8:	0.508	0.618
9:	0.588	0.321
10:	0.234	0.382



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590098. __0

TARGET NUMBER: 4

FILE DATE: 08/02/2006

FILE TIME: 08:04

X CENTROID: -0.102

Y CENTROID: 0.012

POA TO CENTROID: 0.103

HORZ SPREAD: 1.685

VERT SPREAD: 1.904

GROUP SPREAD: 1.706

MIN RADIUS: 0.241

MAX RADIUS: 1.098

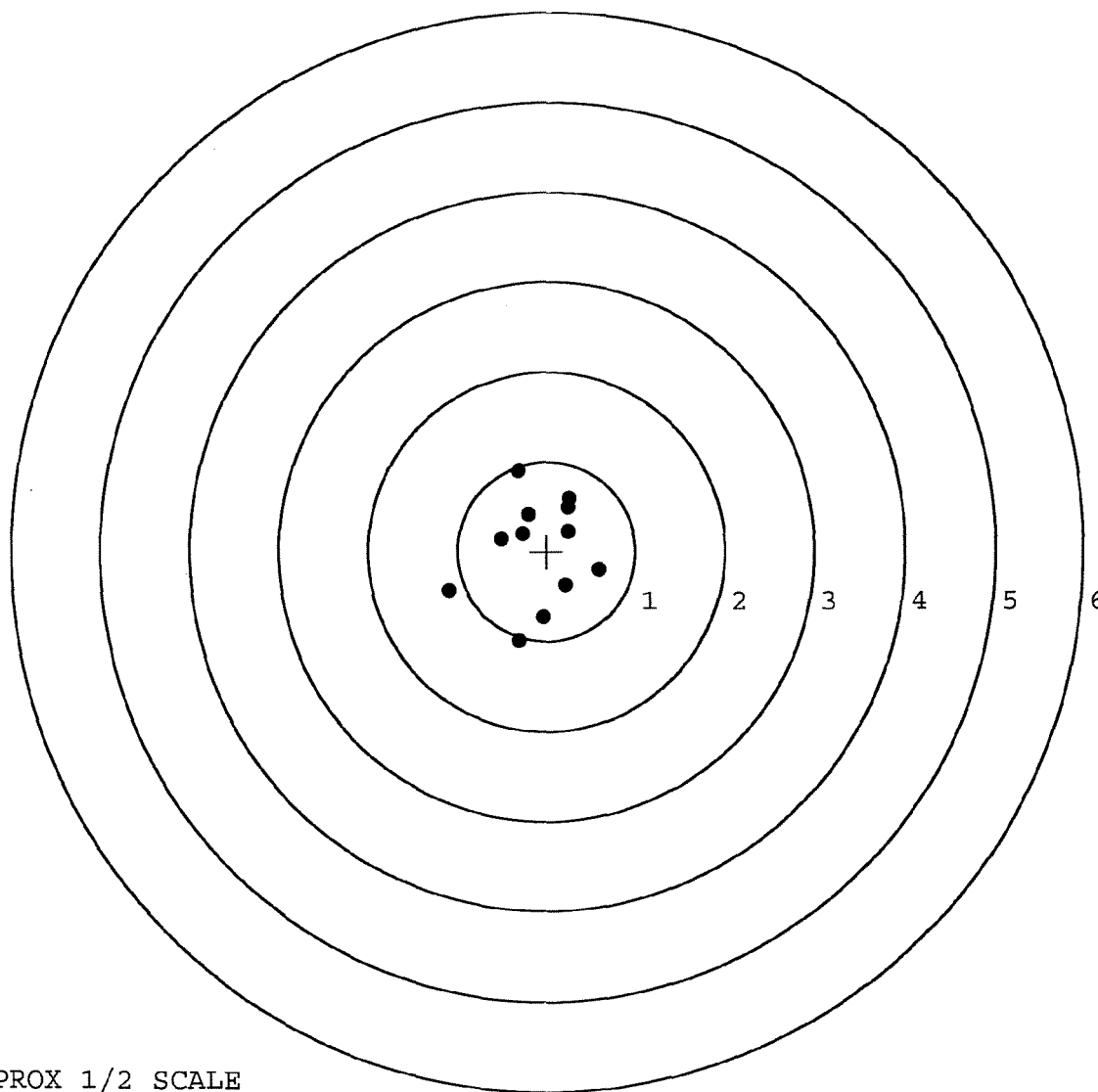
MEAN RADIUS: 0.648

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 12

POINT#	X	Y
1:	-0.309	-1.005
2:	-0.035	-0.743
3:	0.208	-0.384
4:	0.587	-0.208
5:	-1.098	-0.452
6:	-0.513	0.139
7:	-0.267	0.188
8:	0.239	0.216
9:	0.239	0.491
10:	-0.321	0.899
11:	0.250	0.593
12:	-0.208	0.409



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590098. 0

TARGET NUMBER: 5

FILE DATE: 08/02/2006

FILE TIME: 08:04

POINT#	X	Y
1:	-0.219	-0.629
2:	-0.532	-0.515
3:	0.719	-0.164
4:	0.005	-0.117
5:	0.442	0.040
6:	0.510	0.393
7:	-0.381	0.830
8:	-0.172	0.684
9:	-0.190	0.392
10:	-0.600	0.421

X CENTROID: -0.042

Y CENTROID: 0.133

POA TO CENTROID: 0.140

HORZ SPREAD: 1.319

VERT SPREAD: 1.459

GROUP SPREAD: 1.483

MIN RADIUS: 0.255

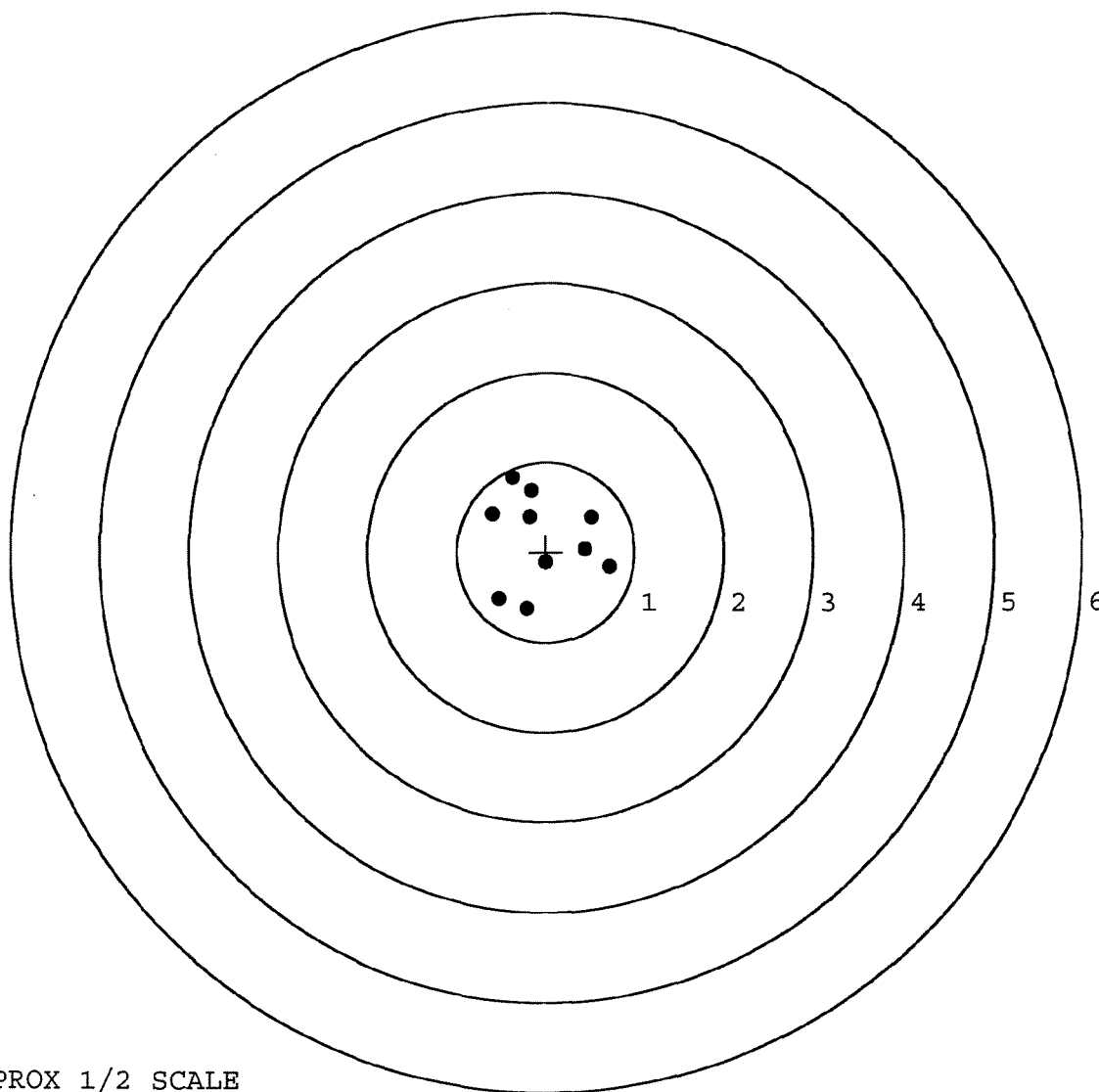
MAX RADIUS: 0.817

MEAN RADIUS: 0.604

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE