

G659 0120

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



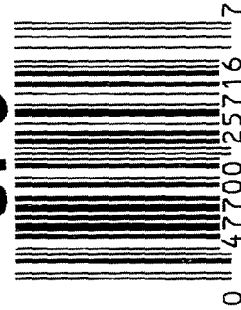
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590120

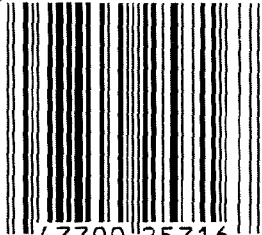
UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

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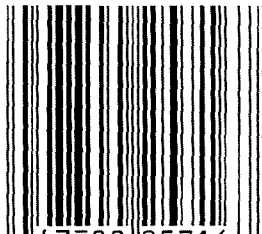


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M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

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SERIAL NO.



66590120

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6590120

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-17-06	RTZ
420	ASSEMBLE ACTION		10-17-06	RTZ
430	ASSEMBLE TO STOCK		10-17-06	R.P.D.
440	PROOF		10-17-06	R.P.D.
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-17-06	R.P.D.
470	DIS-ASSEMBLE ACTION	OCT 19 2006	10-18-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	10-19-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		10/20/06	CW
510	DRILL AND TAP SIGHT HOLES		10-18-06	TRW
520	GOFF BLAST BBL / REC		10-23-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/27/06	FB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11/17/06	mon
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/17/06	mon
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/17/06	mon
	D) OIL FIRING PIN ASSEMBLY		12-1-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12/22/06	mon
F004 REV 5/2006				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>40</u> <u>45</u> <u>45</u>	12/3/06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>60</u> <u>60</u> <u>55</u>	12/3/06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY		12/22/06	nom
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.026</u> <u>.025</u>	12/3/06	SD
	J) ASSEMBLE STOCK		12-1-06	BLG
	K) ASSEMBLE SWIVEL STUDS		12/22/06	nom
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12/22/06	nom
	M) IRON SIGHT ALIGNMENT		12/22/06	nom
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12/22/06	nom
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	12/1/06	nom
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12/1/06	MPJ
670	FINAL INSPECTION A) HEADSPACE		12/22/06	nom
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.60</u> <u>2.80</u> <u>2.57</u> <u>2.63</u> <u>2.48</u>	12-12-06	BLG
	C) FUNCTION		12/22/06	nom
690	PACK		1-25-07	RAH

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 11-13-06

TESTER SO

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.07		2.48	
PULL #2	2.61	2.20		2.54	
PULL #3	2.29	2.27		2.37	
PULL #4	2.52	2.61		2.39	
PULL #5	2.55	2.45		2.42	
TOTAL	1247	1160		1220	
AVERAGE	249	232		244	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.00		
PULL #2	3.24	2.92		
PULL #3	3.42	2.91		
PULL #4	3.34	2.97		
PULL #5	3.17	3.08		
TOTAL	1627	1488		
AVERAGE	325	297		

	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	4.24	4.45		4.25
PULL #2	4.47	4.44		4.24
PULL #3	4.28	4.43		4.15
PULL #4	4.39	4.48		4.18
PULL #5	4.47	4.20		4.18
TOTAL	2185	2200		2100
AVERAGE	437	440		420

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590120.___0
FILE DATE AND TIME: 12/02/2006 09:32

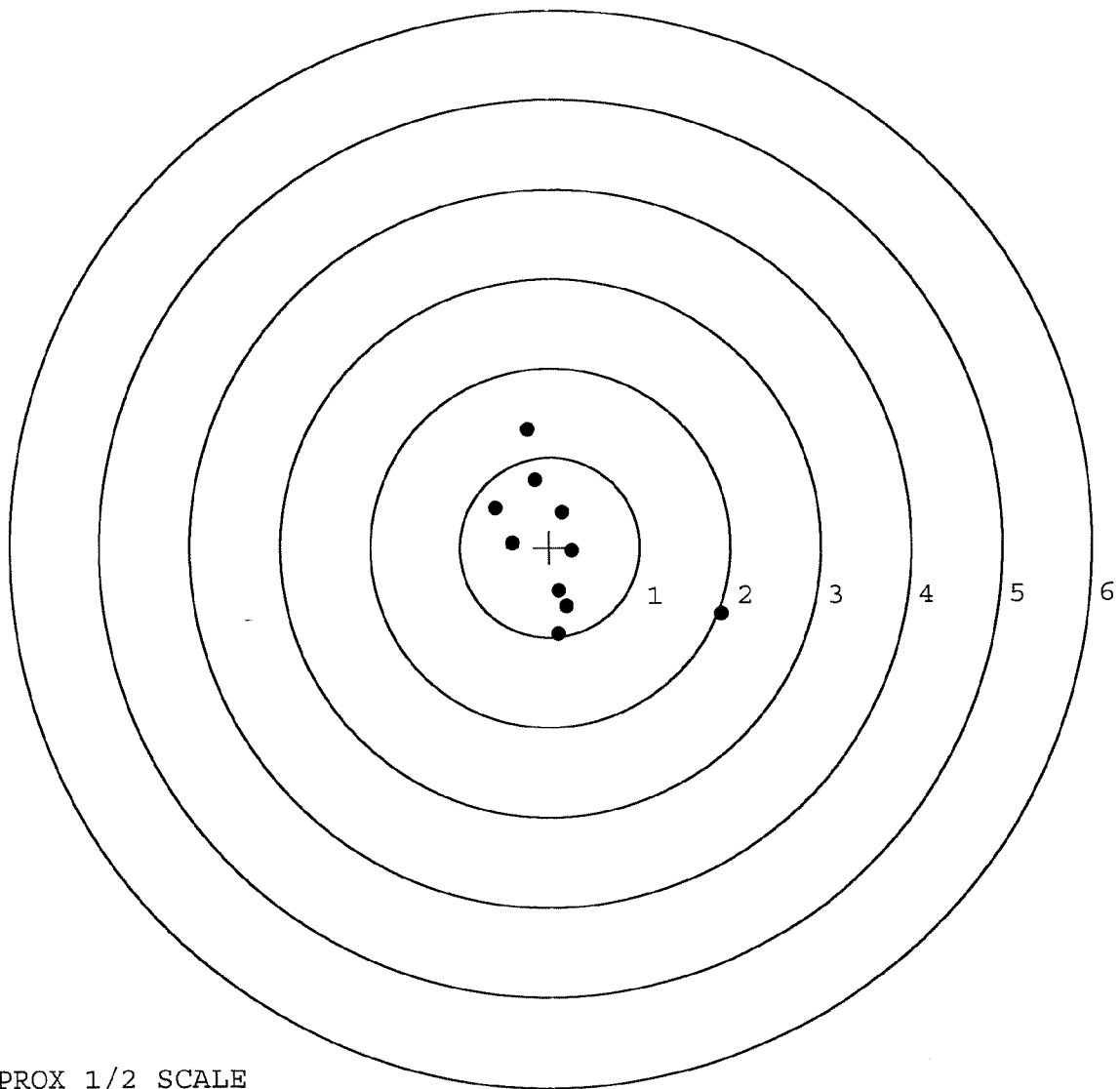
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.010
The Average Y Centroid of the Five Target Set:	-0.097
The Average Point of Impact of the Five Target Set:	0.098
The Average Mean Radius of the Five Target Set:	0.798
The Distance from POA to Centroid Target #1:	0.126
The Distance from Centroid Target #2 to Centroid Target #1:	0.393
The Distance from Centroid Target #3 to Centroid Target #1:	0.079
The Distance from Centroid Target #4 to Centroid Target #1:	0.380
The Distance from Centroid Target #5 to Centroid Target #1:	0.255

SERIAL NUMBER: G6590120.___0
TARGET NUMBER: 1
FILE DATE: 12/02/2006
FILE TIME: 09:32

X CENTROID: 0.126
Y CENTROID: 0.002
POA TO CENTROID: 0.126
HORZ SPREAD: 2.497
VERT SPREAD: 2.280
GROUP SPREAD: 2.980
MIN RADIUS: 0.133
MAX RADIUS: 1.929
MEAN RADIUS: 0.813
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.240	1.313
2:	-0.164	0.747
3:	-0.601	0.446
4:	-0.417	0.049
5:	0.141	0.391
6:	0.252	-0.041
7:	0.103	-0.488
8:	0.190	-0.660
9:	0.098	-0.967
10:	1.896	-0.765

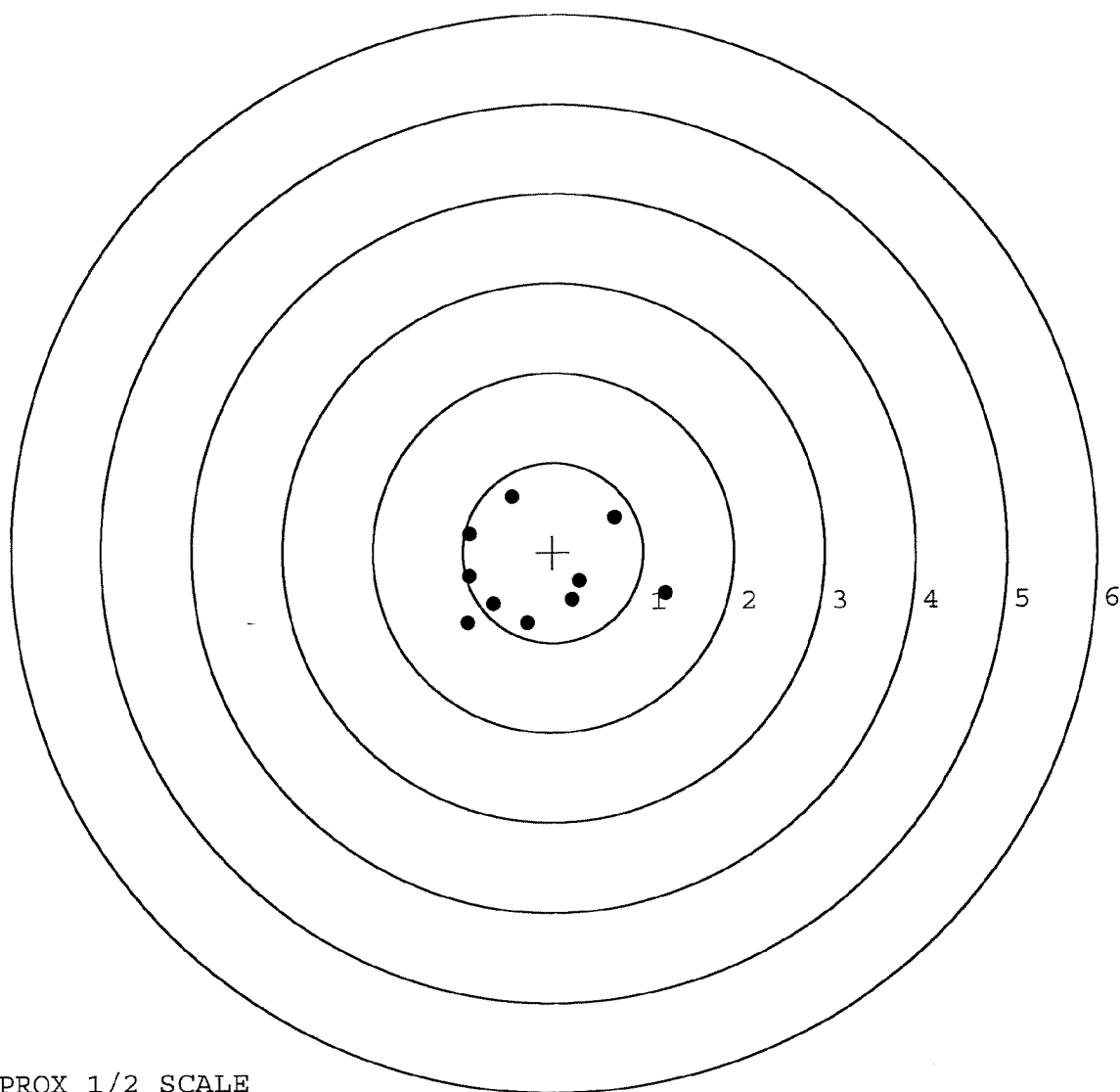


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590120. __0
TARGET NUMBER: 2
FILE DATE: 12/02/2006
FILE TIME: 09:32

POINT#	X	Y
1:	-0.451	0.624
2:	-0.926	0.213
3:	-0.928	-0.264
4:	-0.663	-0.570
5:	-0.951	-0.776
6:	-0.290	-0.783
7:	0.220	-0.527
8:	0.294	-0.321
9:	0.689	0.385
10:	1.244	-0.468

X CENTROID: -0.176
Y CENTROID: -0.249
POA TO CENTROID: 0.305
HORZ SPREAD: 2.195
VERT SPREAD: 1.407
GROUP SPREAD: 2.274
MIN RADIUS: 0.476
MAX RADIUS: 1.437
MEAN RADIUS: 0.808
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590120. __0

TARGET NUMBER: 3

FILE DATE: 12/02/2006

FILE TIME: 09:32

POINT#	X	Y
1:	-0.254	0.959
2:	-0.549	0.449
3:	-1.062	-0.022
4:	0.156	-1.181
5:	0.221	-0.010
6:	0.553	-0.001
7:	0.601	-0.378
8:	0.733	-0.211
9:	0.973	0.070
10:	0.665	0.502

X CENTROID: 0.204

Y CENTROID: 0.018

POA TO CENTROID: 0.204

HORZ SPREAD: 2.035

VERT SPREAD: 2.140

GROUP SPREAD: 2.037

MIN RADIUS: 0.033

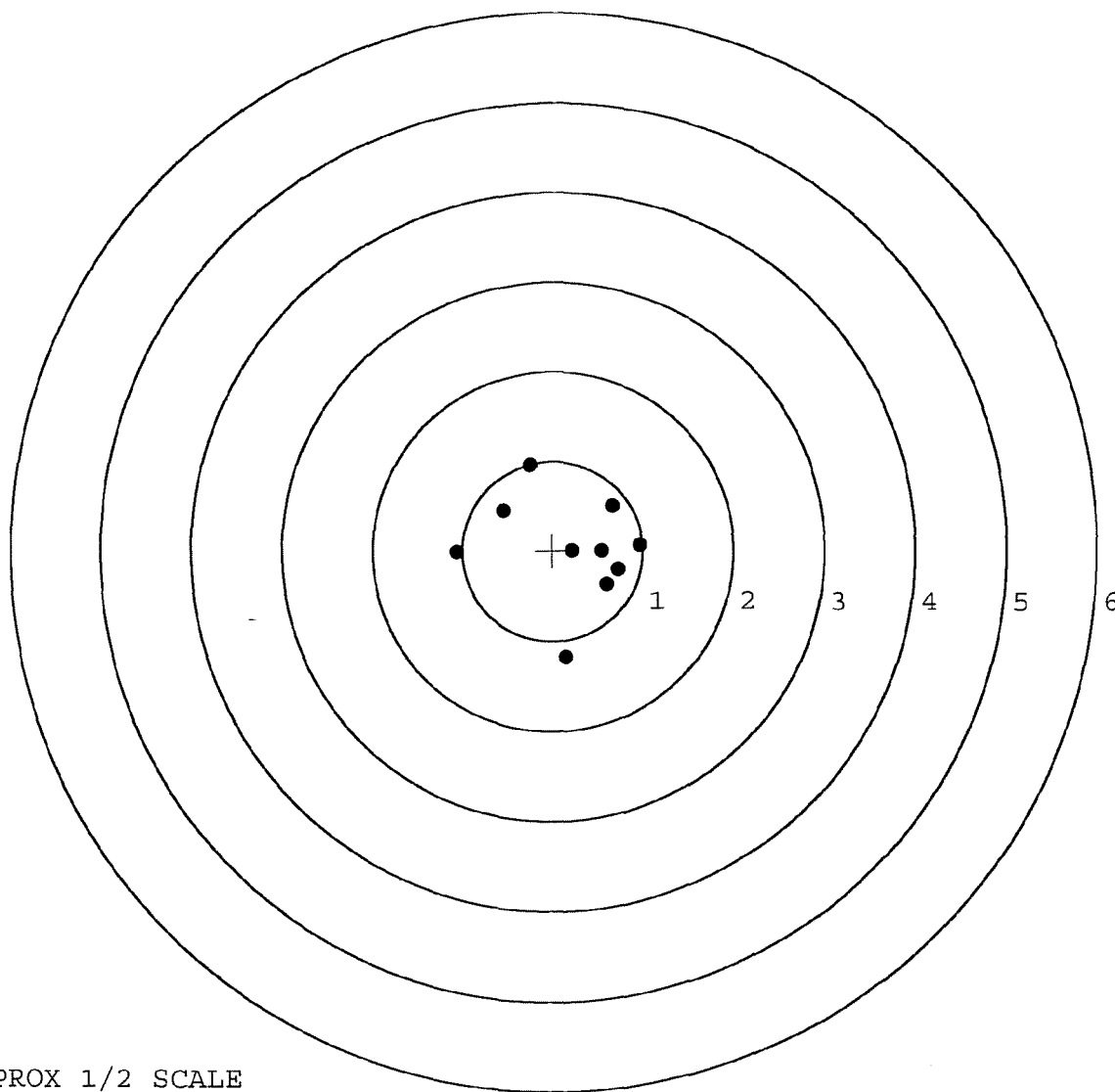
MAX RADIUS: 1.266

MEAN RADIUS: 0.734

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590120. __0

TARGET NUMBER: 4

FILE DATE: 12/02/2006

FILE TIME: 09:32

POINT#	X	Y
1:	-0.944	0.681
2:	-1.360	-0.017
3:	-0.580	0.387
4:	-0.604	-0.107
5:	-0.519	-0.447
6:	-0.396	-0.211
7:	0.249	0.347
8:	0.966	-0.174
9:	0.372	-0.904
10:	0.278	0.365

X CENTROID: -0.254

Y CENTROID: -0.008

POA TO CENTROID: 0.254

HORZ SPREAD: 2.326

VERT SPREAD: 1.585

GROUP SPREAD: 2.331

MIN RADIUS: 0.248

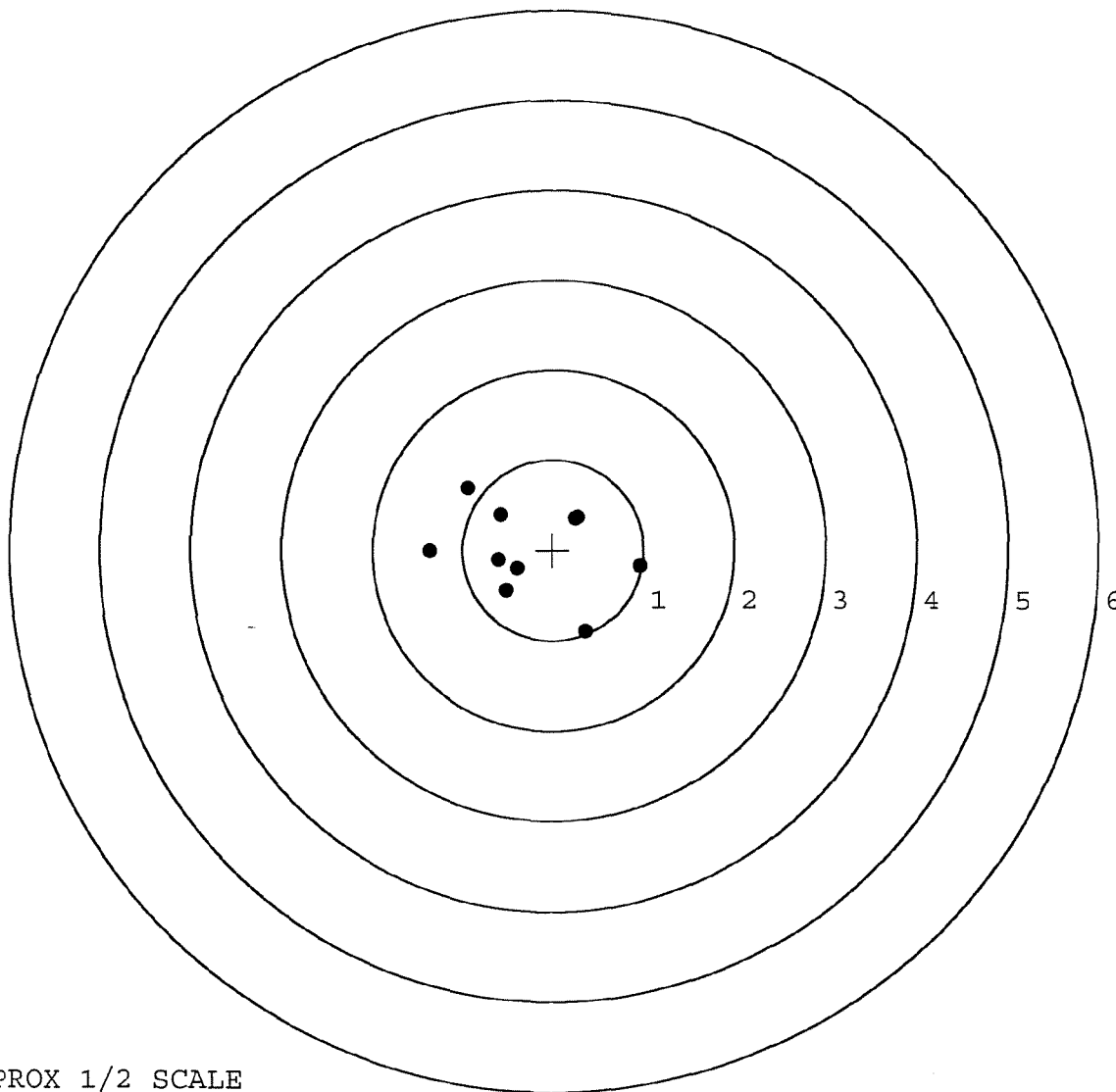
MAX RADIUS: 1.231

MEAN RADIUS: 0.731

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590120. 0

TARGET NUMBER: 5

FILE DATE: 12/02/2006

FILE TIME: 09:32

POINT#	X	Y
1:	0.205	0.941
2:	-0.349	1.059
3:	-0.698	0.487
4:	-0.292	-0.105
5:	0.360	-0.180
6:	0.791	-0.546
7:	0.269	-0.734
8:	-0.467	-0.678
9:	0.594	-1.258
10:	1.103	-1.495

X CENTROID: 0.152

Y CENTROID: -0.251

POA TO CENTROID: 0.293

HORZ SPREAD: 1.801

VERT SPREAD: 2.554

GROUP SPREAD: 2.938

MIN RADIUS: 0.220

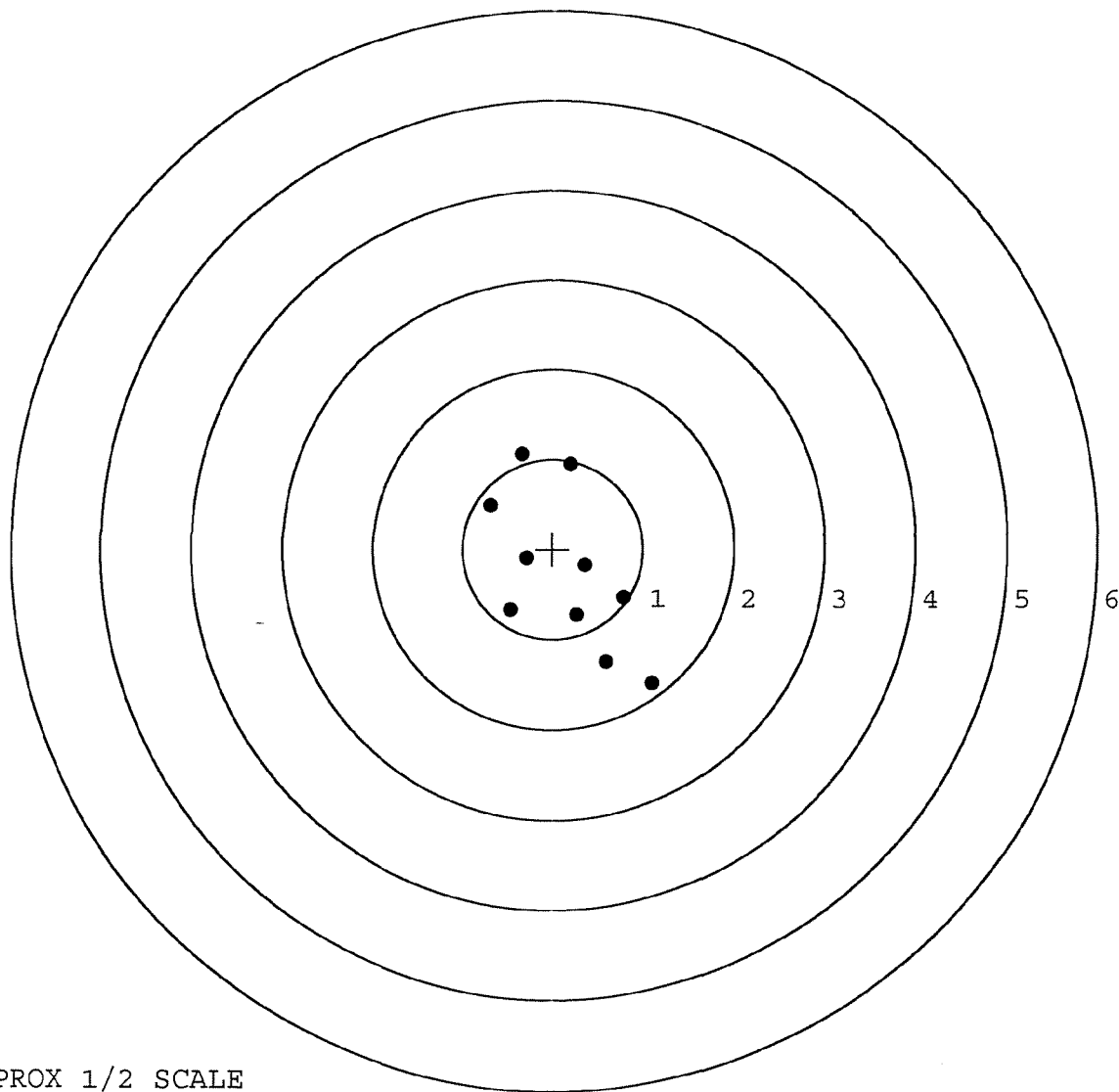
MAX RADIUS: 1.566

MEAN RADIUS: 0.903

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE