

66590139

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



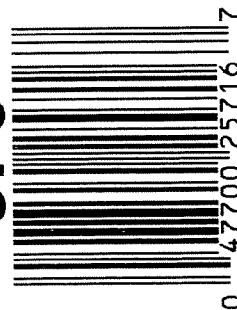
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590139

UPC



ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



G6590139

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6590139

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	MAGNA-FLUX	8-2-06	BLG
460	CHECK HEADSPACE	INSPECTED	8-2-06	BLG
470	DIS-ASSEMBLE ACTION	AUG 09 2006	8-2-06	BLG
480	MAGNAFLUX BBL ACTION	OPERATOR <u>APD</u>	8-9-06	APD
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	TRB
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	8-22-06	MTH
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>7.5</u> <u>7.5</u>	8-17-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.5</u> <u>4.5</u> <u>5.0</u>	8-17-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-22-06	MTM
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1023</u> <u>1023</u>	8-17-06	DA
	J) ASSEMBLE STOCK		8-11-06	RTZ
	K) ASSEMBLE SWIVEL STUDS		8-22-06	MTM
	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	8-11-06	R.P.D.
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8/11/06	R.P.D.
670	FINAL INSPECTION A) HEADSPACE		8-22-06	MTM
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>270</u> <u>264</u> <u>257</u> <u>252</u> <u>250</u>	8-18-06	R.P.
	C) FUNCTION		8-22-06	MTM
690	PACK		11/13/06	DA

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 mjm

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.68		2.43	
PULL #2	2.38	2.40		2.67	
PULL #3	2.47	2.42		2.57	
PULL #4	2.31	2.44		2.50	
PULL #5	2.38	2.49		2.55	
TOTAL	12.11	12.43		12.72	
AVERAGE	2.42	2.49		2.54	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.13		
PULL #2	2.94	2.93		
PULL #3	2.94	3.04		
PULL #4	2.98	3.15		
PULL #5	3.13	2.98		
TOTAL	15.06	15.23		
AVERAGE	3.01	3.05		

	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	4.11	4.13		4.15
PULL #2	4.12	4.12		4.07
PULL #3	4.02	4.15		4.21
PULL #4	4.04	4.15		4.28
PULL #5	4.13	4.25		4.38
TOTAL	20.44	20.80		21.09
AVERAGE	4.09	4.16		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590139.___0
FILE DATE AND TIME: 08/11/2006 18:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.006
The Average Y Centroid of the Five Target Set:	0.109
The Average Point of Impact of the Five Target Set:	0.109
The Average Mean Radius of the Five Target Set:	0.739
The Distance from POA to Centroid Target #1:	0.124
The Distance from Centroid Target #2 to Centroid Target #1:	0.247
The Distance from Centroid Target #3 to Centroid Target #1:	0.352
The Distance from Centroid Target #4 to Centroid Target #1:	0.352
The Distance from Centroid Target #5 to Centroid Target #1:	0.339

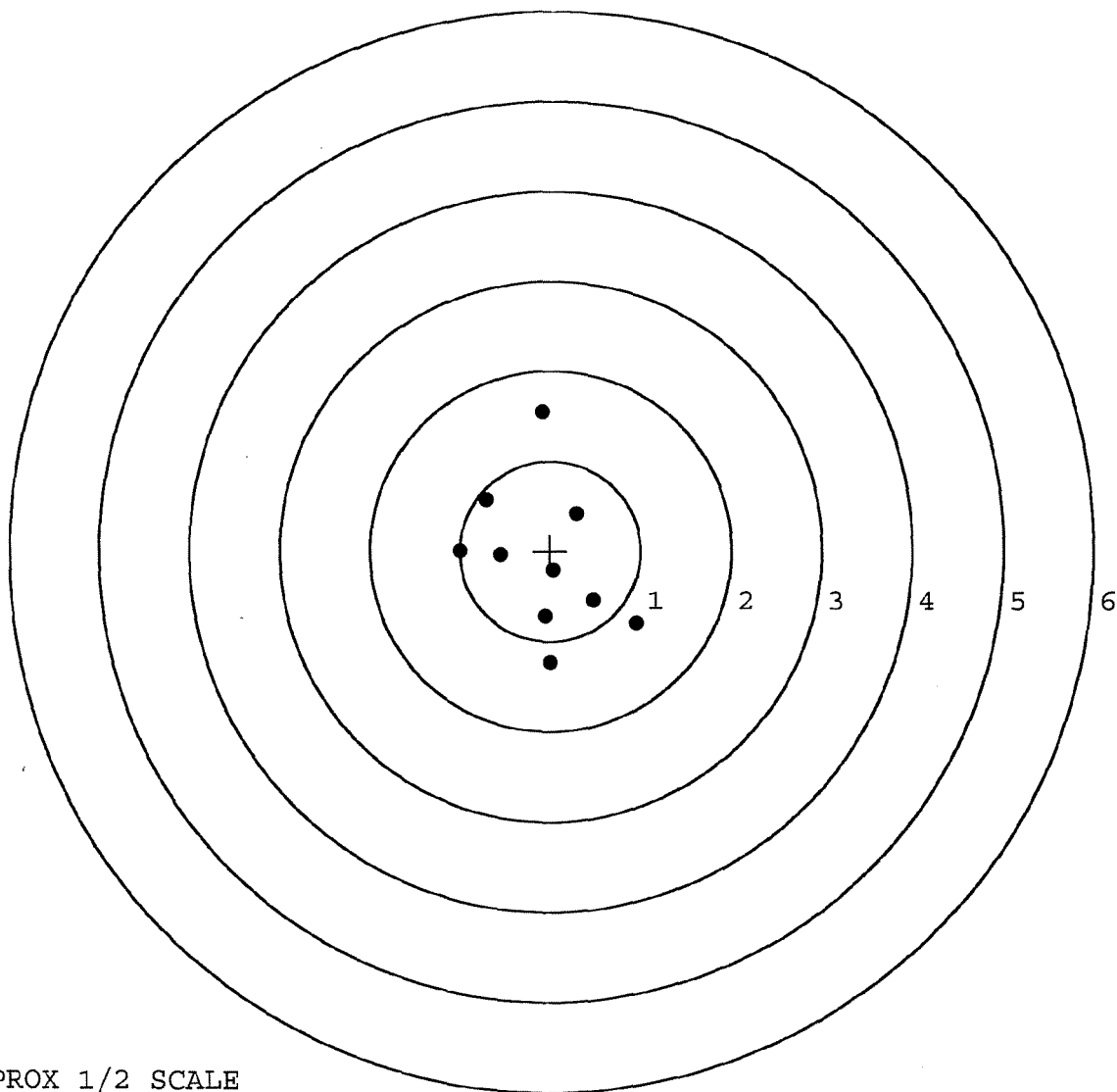
SERIAL NUMBER: G6590139. 0

TARGET NUMBER: 1

FILE DATE: 08/11/2006

FILE TIME: 18:29

	POINT#	X	Y
	1:	-0.096	1.543
	2:	0.287	0.418
	3:	-0.710	0.571
	4:	-0.999	-0.005
X CENTROID:	5:	-0.552	-0.046
Y CENTROID:	6:	0.038	-0.219
POA TO CENTROID:	7:	0.959	-0.805
HORZ SPREAD:	8:	0.485	-0.552
VERT SPREAD:	9:	-0.056	-0.732
GROUP SPREAD:	10:	0.012	-1.241
MIN RADIUS:		0.151	
MAX RADIUS:		1.650	
MEAN RADIUS:		0.851	
# IN 1 IN DIAMETER:		2	
# IN 2 IN DIAMETER:		7	
# in 3 IN DIAMETER:		9	



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590139. __0

TARGET NUMBER: 2

FILE DATE: 08/11/2006

FILE TIME: 18:29

X CENTROID: -0.164

Y CENTROID: 0.119

POA TO CENTROID: 0.202

HORZ SPREAD: 1.694

VERT SPREAD: 2.159

GROUP SPREAD: 2.174

MIN RADIUS: 0.120

MAX RADIUS: 1.144

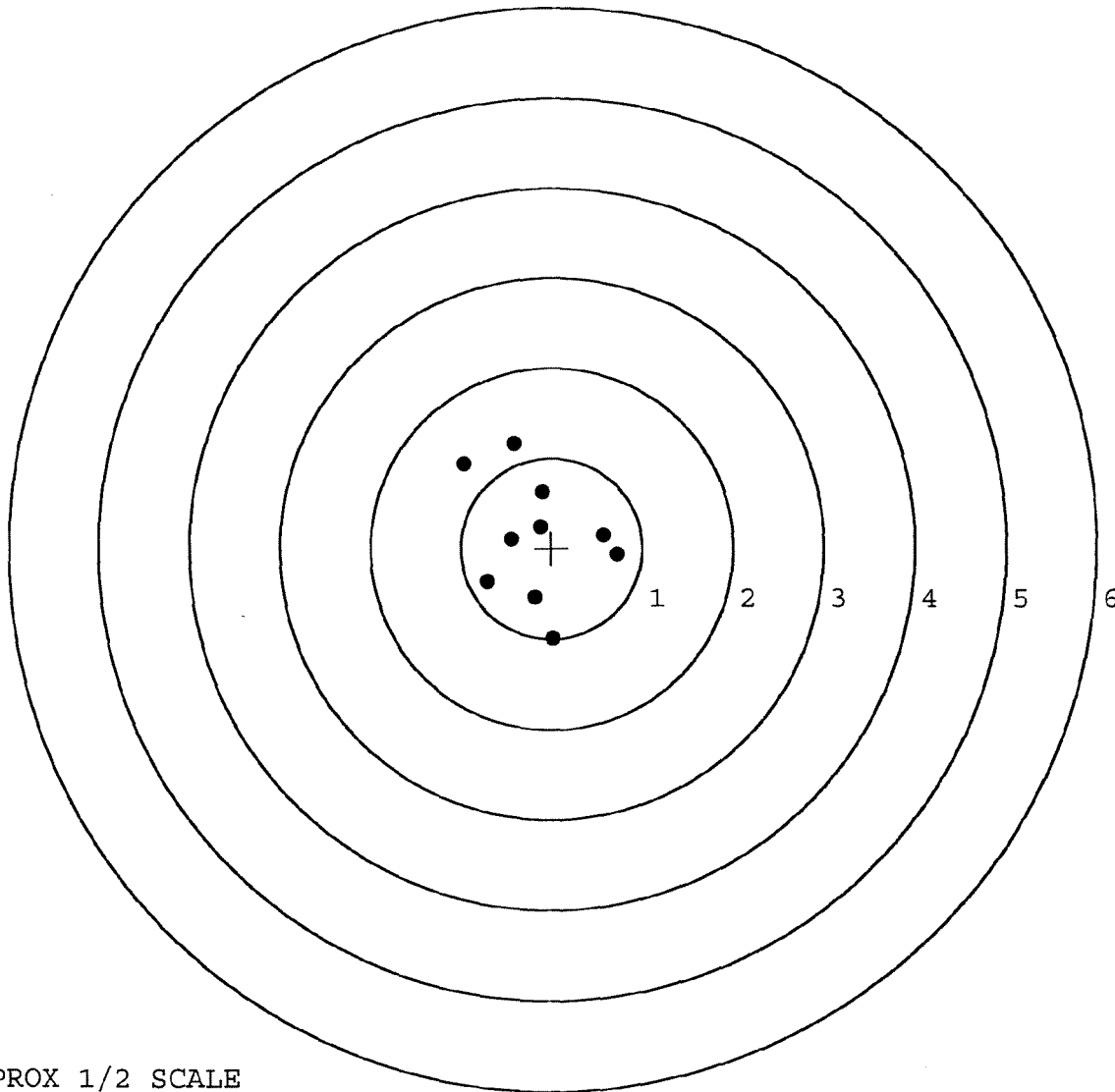
MEAN RADIUS: 0.731

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.426	1.154
2:	-0.971	0.929
3:	-0.105	0.626
4:	0.578	0.152
5:	0.723	-0.071
6:	-0.129	0.234
7:	-0.441	0.098
8:	-0.706	-0.375
9:	-0.184	-0.552
10:	0.023	-1.005

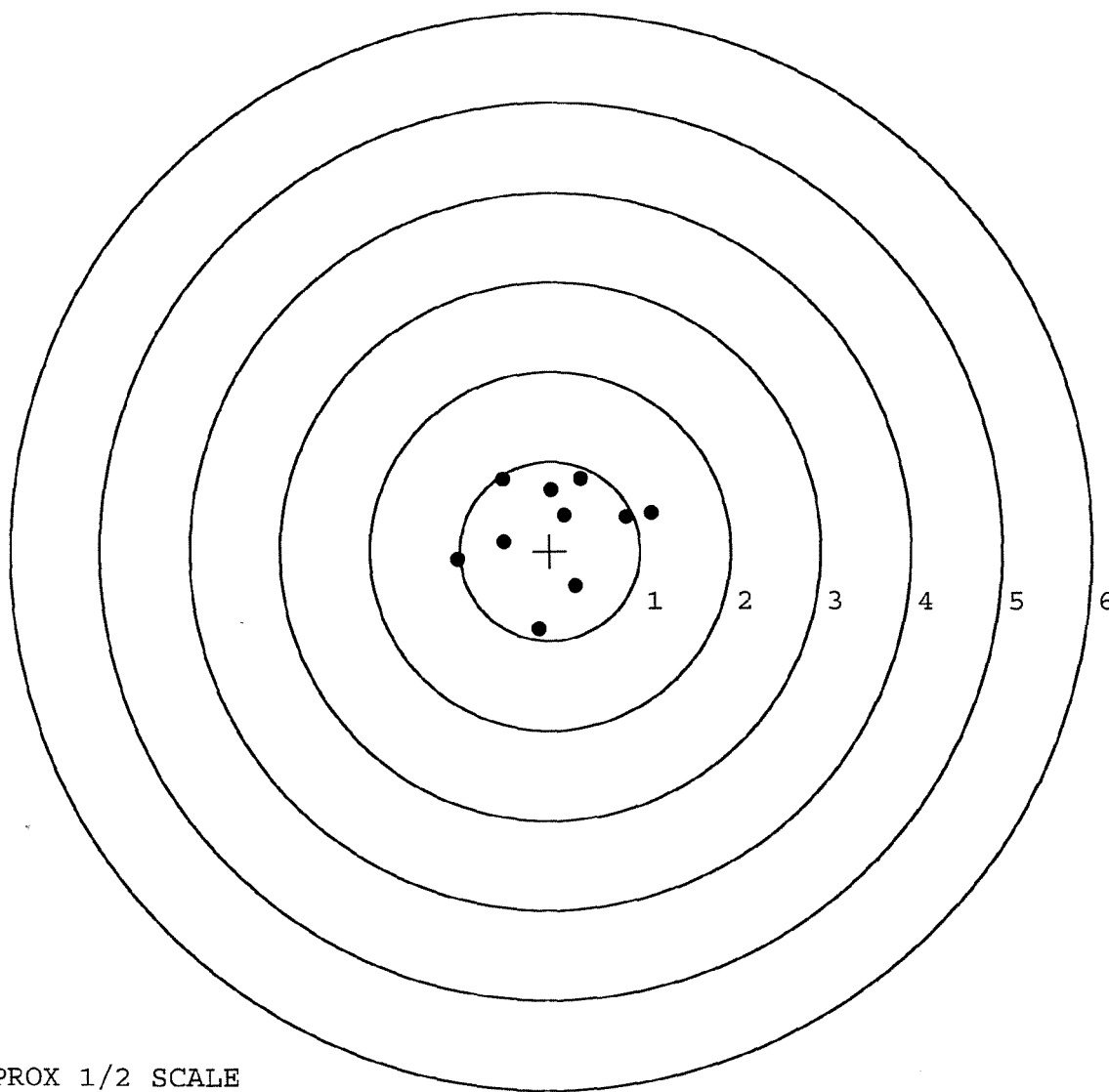


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590139. __0
TARGET NUMBER: 3
FILE DATE: 08/11/2006
FILE TIME: 18:29

POINT#	X	Y
1:	-0.116	-0.876
2:	0.292	-0.393
3:	-1.026	-0.104
4:	-0.510	0.097
5:	-0.532	0.796
6:	0.005	0.686
7:	0.339	0.812
8:	1.126	0.428
9:	0.846	0.386
10:	0.159	0.404

X CENTROID: 0.058
Y CENTROID: 0.224
POA TO CENTROID: 0.231
HORZ SPREAD: 2.152
VERT SPREAD: 1.688
GROUP SPREAD: 2.217
MIN RADIUS: 0.207
MAX RADIUS: 1.133
MEAN RADIUS: 0.753
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

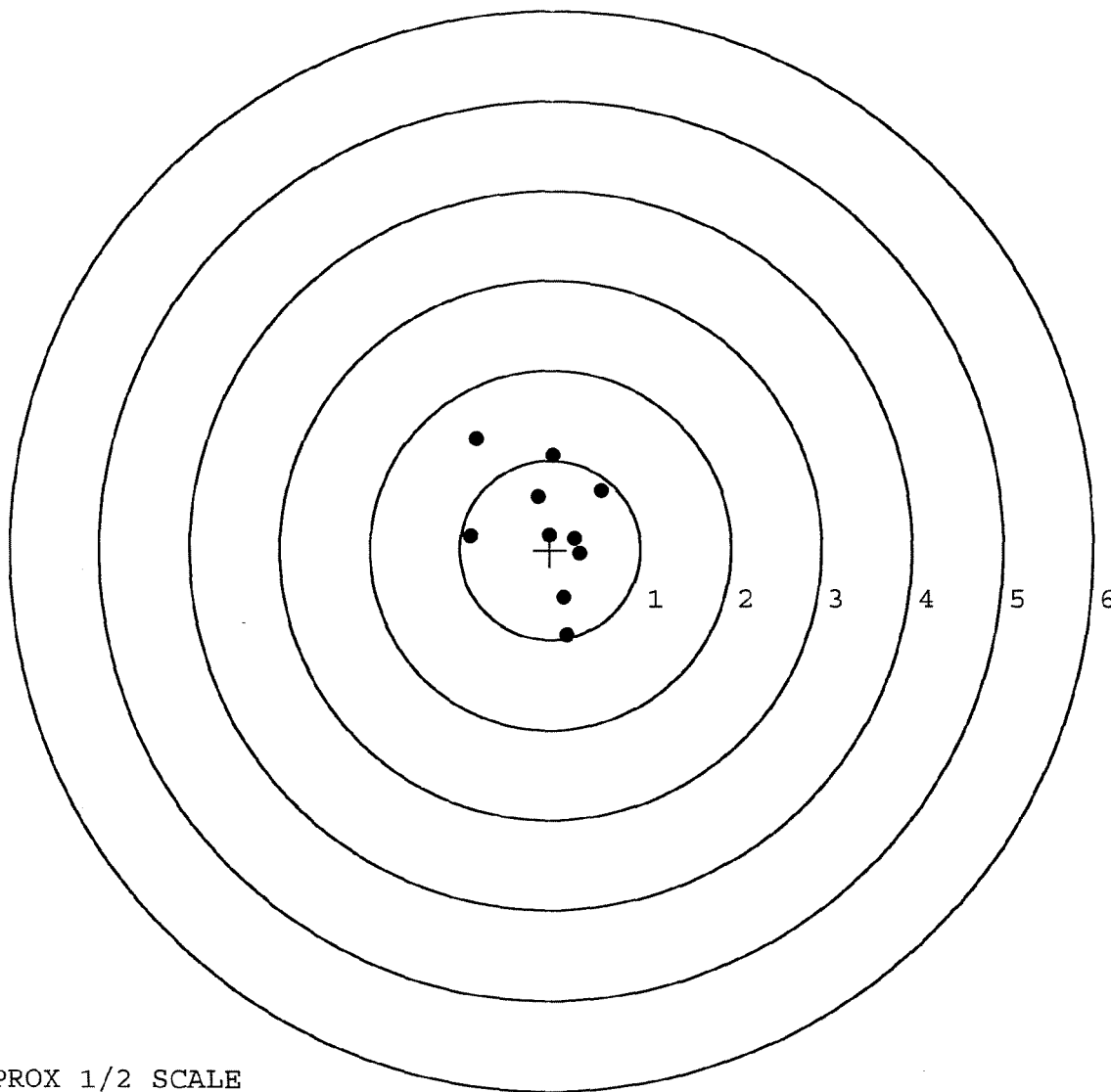


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590139. __0
TARGET NUMBER: 4
FILE DATE: 08/11/2006
FILE TIME: 18:29

X CENTROID: -0.030
Y CENTROID: 0.244
POA TO CENTROID: 0.246
HORZ SPREAD: 1.446
VERT SPREAD: 2.193
GROUP SPREAD: 2.417
MIN RADIUS: 0.084
MAX RADIUS: 1.269
MEAN RADIUS: 0.694
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.823	1.235
2:	0.030	1.056
3:	-0.138	0.593
4:	-0.884	0.151
5:	0.562	0.666
6:	0.194	-0.958
7:	0.160	-0.535
8:	0.330	-0.053
9:	0.276	0.120
10:	-0.010	0.162

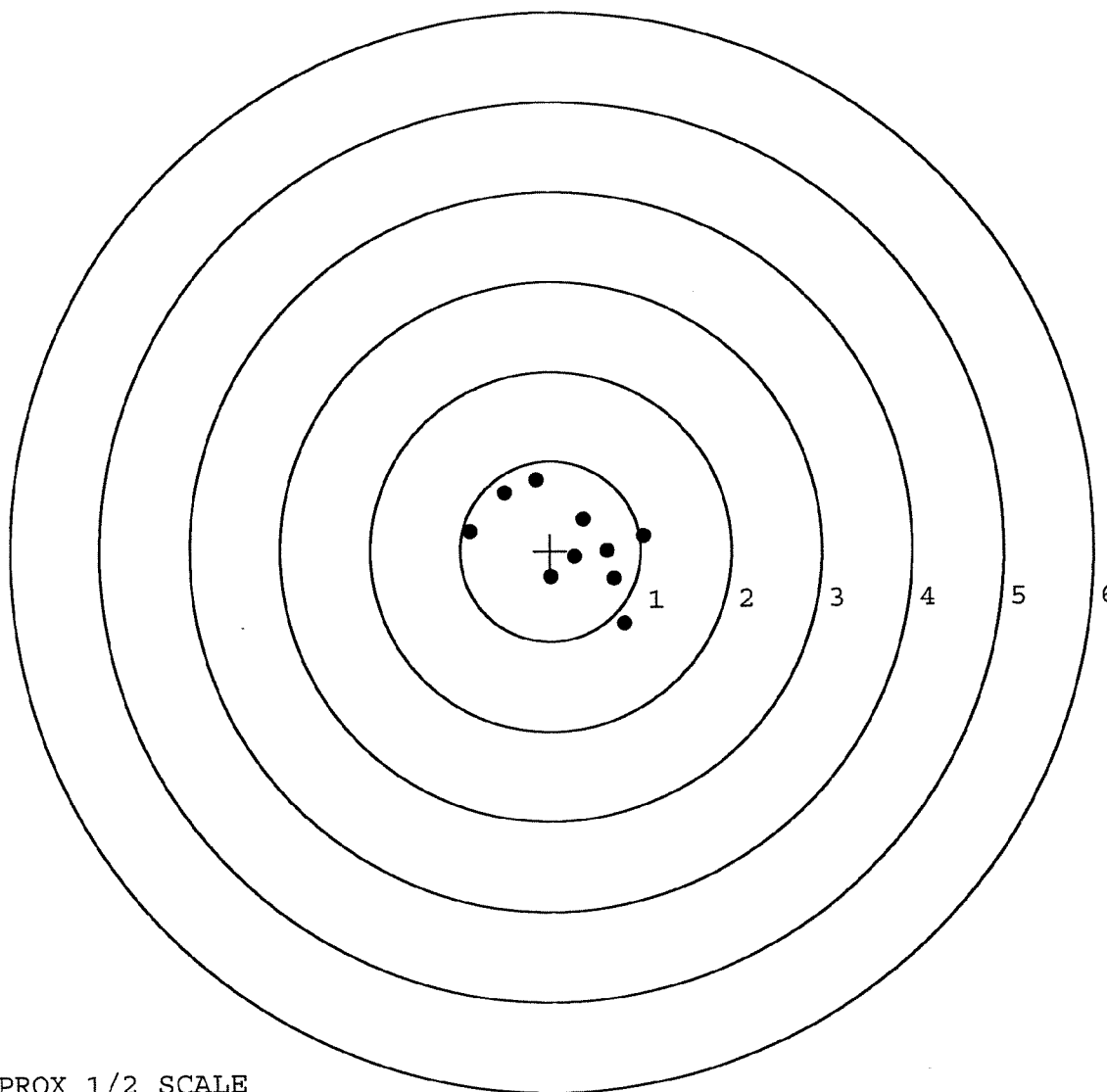


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590139. __0
TARGET NUMBER: 5
FILE DATE: 08/11/2006
FILE TIME: 18:29

X CENTROID: 0.228
Y CENTROID: 0.067
POA TO CENTROID: 0.237
HORZ SPREAD: 1.918
VERT SPREAD: 1.610
GROUP SPREAD: 1.996
MIN RADIUS: 0.142
MAX RADIUS: 1.127
MEAN RADIUS: 0.666
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.815	-0.817
2:	0.706	-0.316
3:	1.029	0.156
4:	0.373	0.353
5:	0.272	-0.068
6:	0.001	-0.293
7:	-0.889	0.222
8:	-0.501	0.648
9:	-0.158	0.793
10:	0.629	-0.010



TARGET APPROX 1/2 SCALE