

G6590183

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



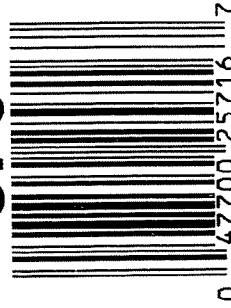
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6590183

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 # G6590183

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		8-2-06	BLG
460	CHECK HEADSPACE	MAGNA-FLUX 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	TRL
520	GOFF BLAST BBL / REC		8-9-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		8/10/06	BB
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		8-17-06	mm

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.0</u> <u>5.5</u> <u>6.0</u>	8-15-06	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.5</u> <u>2.5</u>	8-15-06	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		8-17-06	nm
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	8-15-06	DA
	J) ASSEMBLE STOCK		8-11-06	RL
	K) ASSEMBLE SWIVEL STUDS		8-17-06	nm
	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	8-14-06	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		8-14-06	R.P.
670	FINAL INSPECTION A) HEADSPACE		8-17-06	nm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.79</u> <u>2.81</u> <u>2.85</u> <u>2.88</u>	8-15-06	DA
	C) FUNCTION		8-17-06	nm
690	PACK		11/14/06	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 8-9-06

TESTER mjm

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.63	2.34	2.34	
PULL #2	2.24	2.63	2.54	
PULL #3	2.77	2.53	2.55	
PULL #4	2.71	2.48	2.56	
PULL #5	2.44	2.76	2.57	
TOTAL	12.82	12.74	12.55	
AVERAGE	2.56	2.54	2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.21	2.81	
PULL #2	2.94	3.36	
PULL #3	3.30	3.39	
PULL #4	3.31	2.88	
PULL #5	2.94	2.95	
TOTAL	15.70	15.33	
AVERAGE	3.14	3.07	

	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	3.89	4.00		4.15
PULL #2	4.05	4.27		3.85
PULL #3	4.17	4.37		4.08
PULL #4	4.13	4.27		4.10
PULL #5	3.90	4.15		3.78
TOTAL	20.14	21.05		19.95
AVERAGE	4.02	4.21		3.99

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6590183.__0
FILE DATE AND TIME: 08/14/2006 08:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.038
The Average Y Centroid of the Five Target Set:	-0.012
The Average Point of Impact of the Five Target Set:	0.040
The Average Mean Radius of the Five Target Set:	0.655
The Distance from POA to Centroid Target #1:	0.070
The Distance from Centroid Target #2 to Centroid Target #1:	0.178
The Distance from Centroid Target #3 to Centroid Target #1:	0.052
The Distance from Centroid Target #4 to Centroid Target #1:	0.202
The Distance from Centroid Target #5 to Centroid Target #1:	0.192

SERIAL NUMBER: G6590183. __0

TARGET NUMBER: 1

FILE DATE: 08/14/2006

FILE TIME: 08:38

X CENTROID: 0.029

Y CENTROID: 0.063

POA TO CENTROID: 0.070

HORZ SPREAD: 1.866

VERT SPREAD: 1.401

GROUP SPREAD: 2.207

MIN RADIUS: 0.091

MAX RADIUS: 1.354

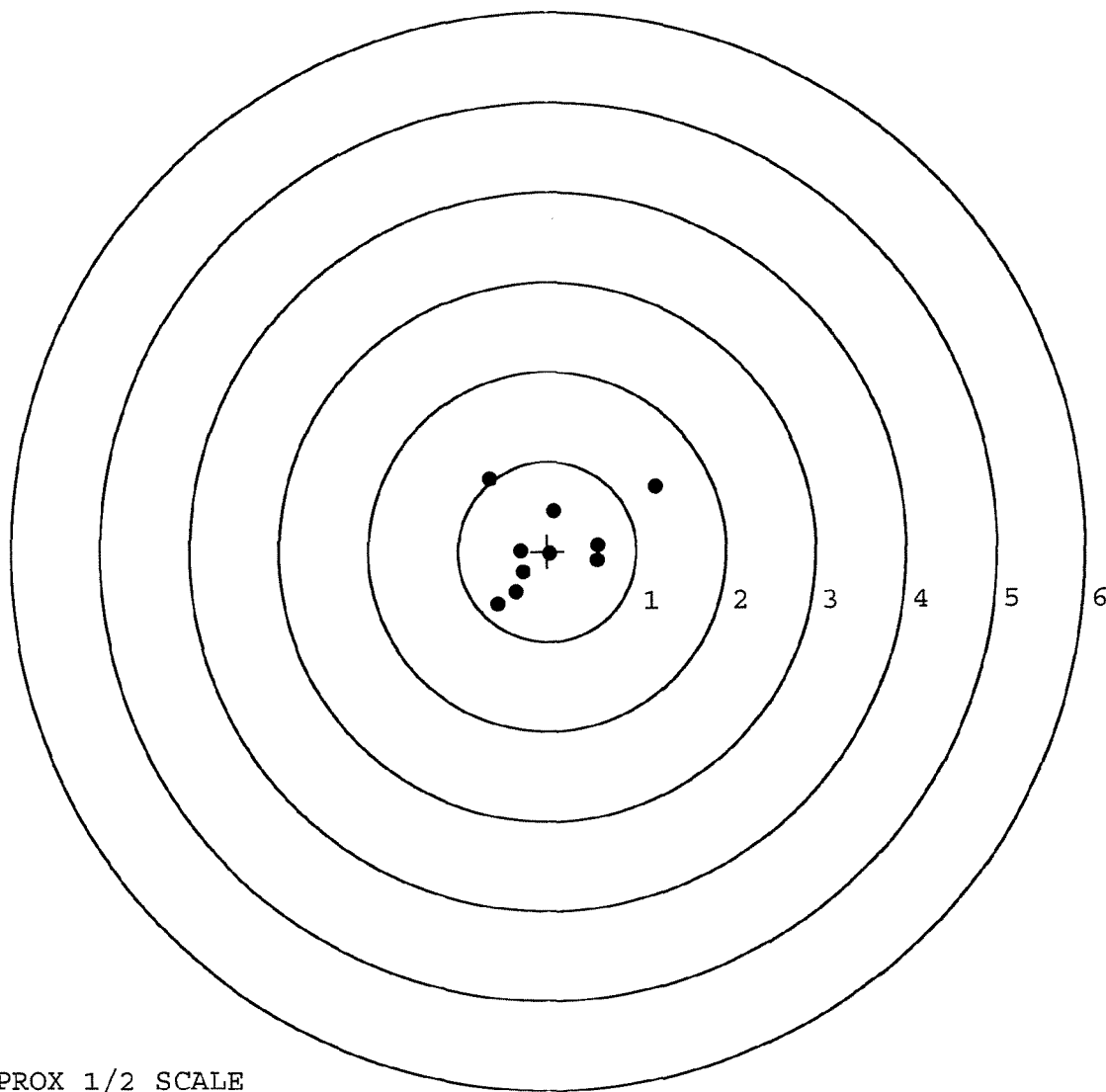
MEAN RADIUS: 0.624

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.215	0.716
2:	-0.651	0.811
3:	-0.564	-0.590
4:	-0.302	0.001
5:	0.071	0.447
6:	0.567	0.071
7:	0.563	-0.101
8:	-0.357	-0.457
9:	-0.280	-0.236
10:	0.030	-0.028

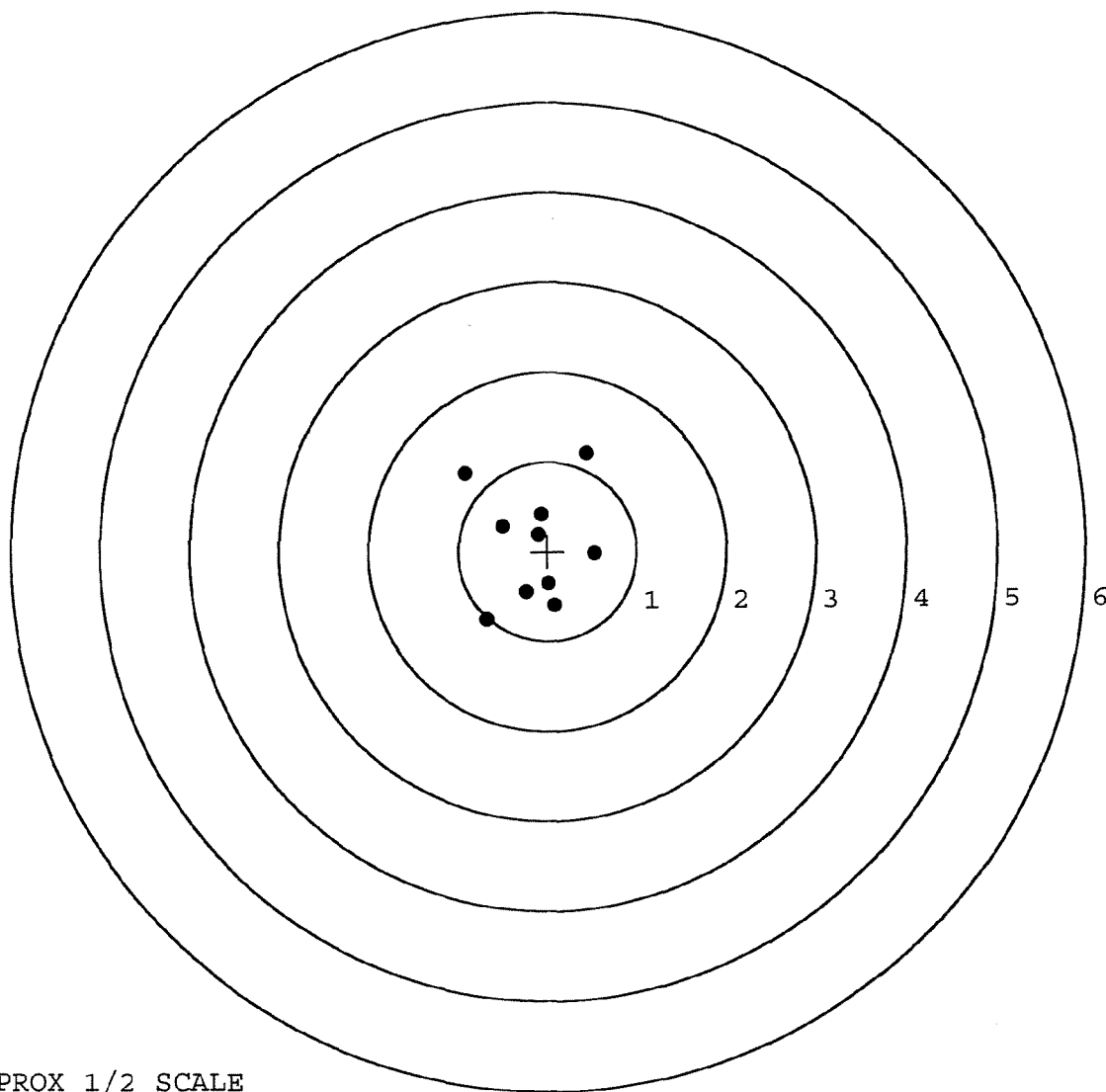


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590183. __0
TARGET NUMBER: 2
FILE DATE: 08/14/2006
FILE TIME: 08:38

X CENTROID: -0.149
Y CENTROID: 0.064
POA TO CENTROID: 0.162
HORZ SPREAD: 1.456
VERT SPREAD: 1.863
GROUP SPREAD: 2.180
MIN RADIUS: 0.135
MAX RADIUS: 1.190
MEAN RADIUS: 0.661
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.443	1.097
2:	-0.923	0.877
3:	0.533	-0.021
4:	-0.246	-0.457
5:	-0.690	-0.766
6:	-0.513	0.280
7:	-0.076	0.417
8:	-0.106	0.192
9:	0.013	-0.363
10:	0.076	-0.612



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590183. 0

TARGET NUMBER: 3

FILE DATE: 08/14/2006

FILE TIME: 08:38

X CENTROID: -0.004

Y CENTROID: 0.023

POA TO CENTROID: 0.023

HORZ SPREAD: 2.050

VERT SPREAD: 1.068

GROUP SPREAD: 2.092

MIN RADIUS: 0.420

MAX RADIUS: 1.133

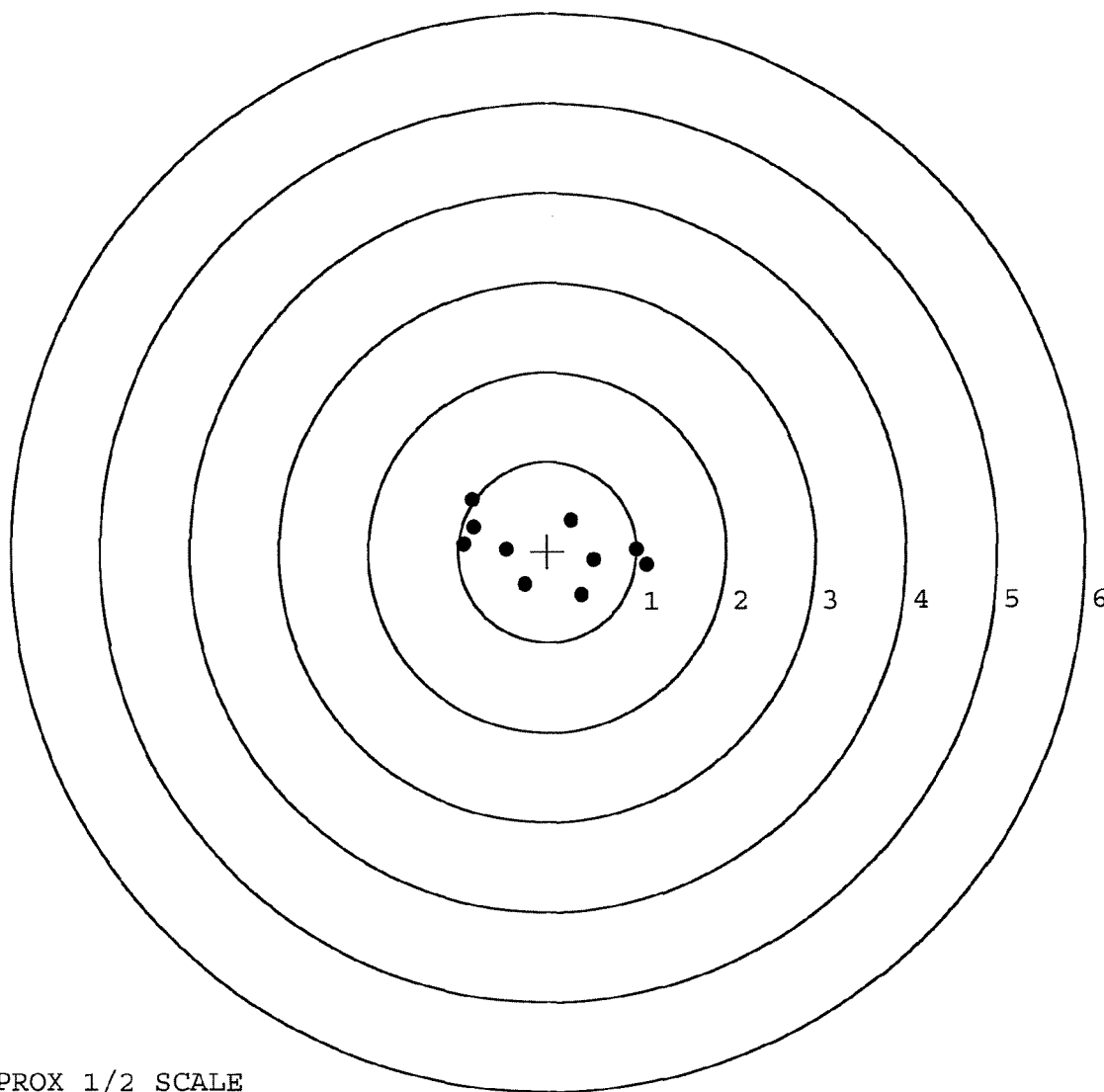
MEAN RADIUS: 0.747

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.115	-0.155
2:	1.003	0.015
3:	0.524	-0.100
4:	0.264	0.347
5:	0.386	-0.483
6:	-0.259	-0.367
7:	-0.461	0.020
8:	-0.935	0.088
9:	-0.830	0.279
10:	-0.842	0.585



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590183. 0

TARGET NUMBER: 4

FILE DATE: 08/14/2006

FILE TIME: 08:38

X CENTROID: -0.111

Y CENTROID: -0.082

POA TO CENTROID: 0.138

HORZ SPREAD: 1.774

VERT SPREAD: 2.118

GROUP SPREAD: 2.151

MIN RADIUS: 0.411

MAX RADIUS: 1.165

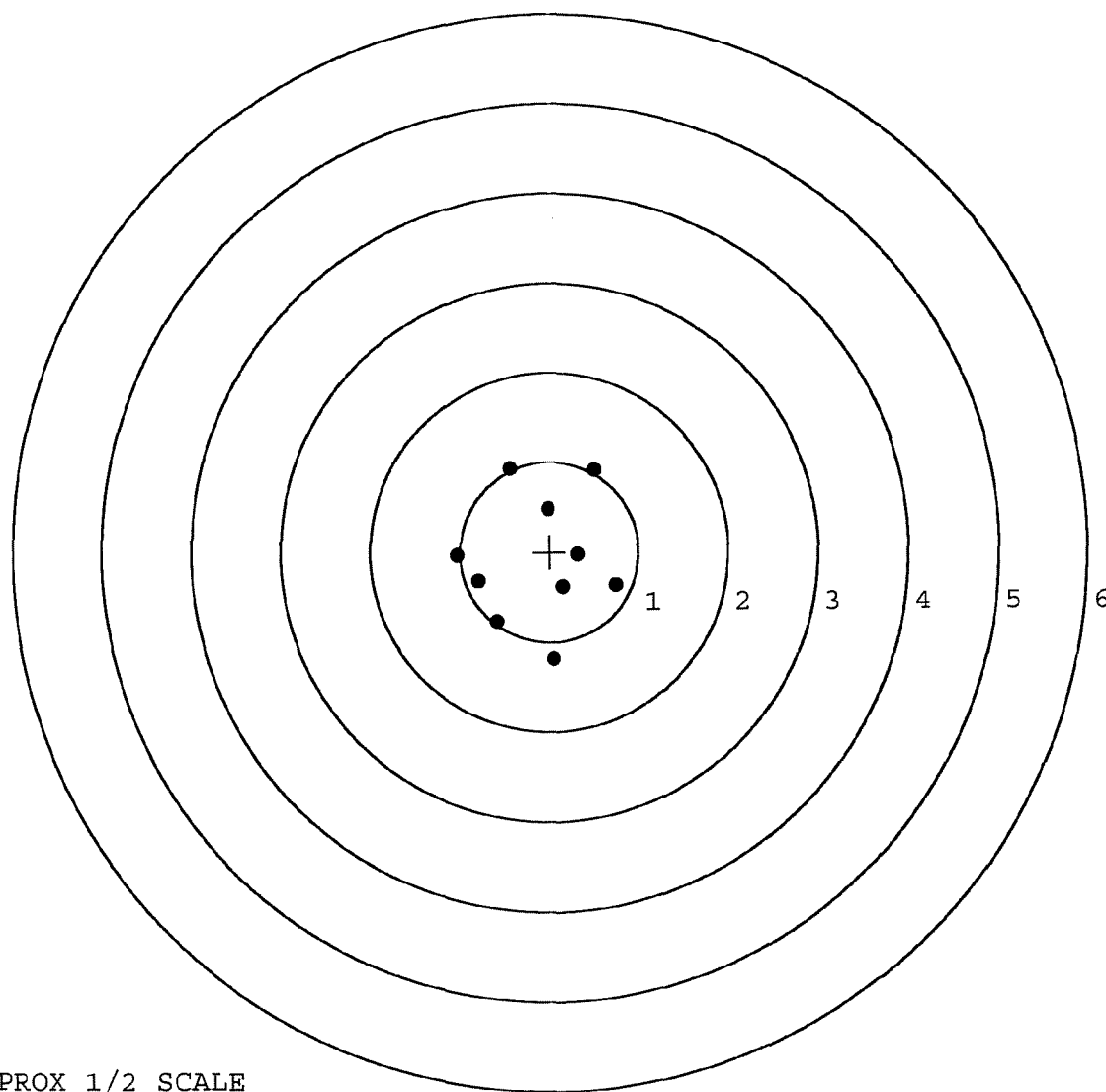
MEAN RADIUS: 0.816

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.051	-1.196
2:	-0.595	-0.777
3:	-0.798	-0.324
4:	-1.030	-0.040
5:	0.744	-0.367
6:	0.159	-0.392
7:	0.323	-0.033
8:	-0.026	0.477
9:	0.505	0.907
10:	-0.441	0.922



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6590183. 0

TARGET NUMBER: 5

FILE DATE: 08/14/2006

FILE TIME: 08:38

X CENTROID: 0.044

Y CENTROID: -0.128

POA TO CENTROID: 0.135

HORZ SPREAD: 1.390

VERT SPREAD: 0.727

GROUP SPREAD: 1.419

MIN RADIUS: 0.043

MAX RADIUS: 0.769

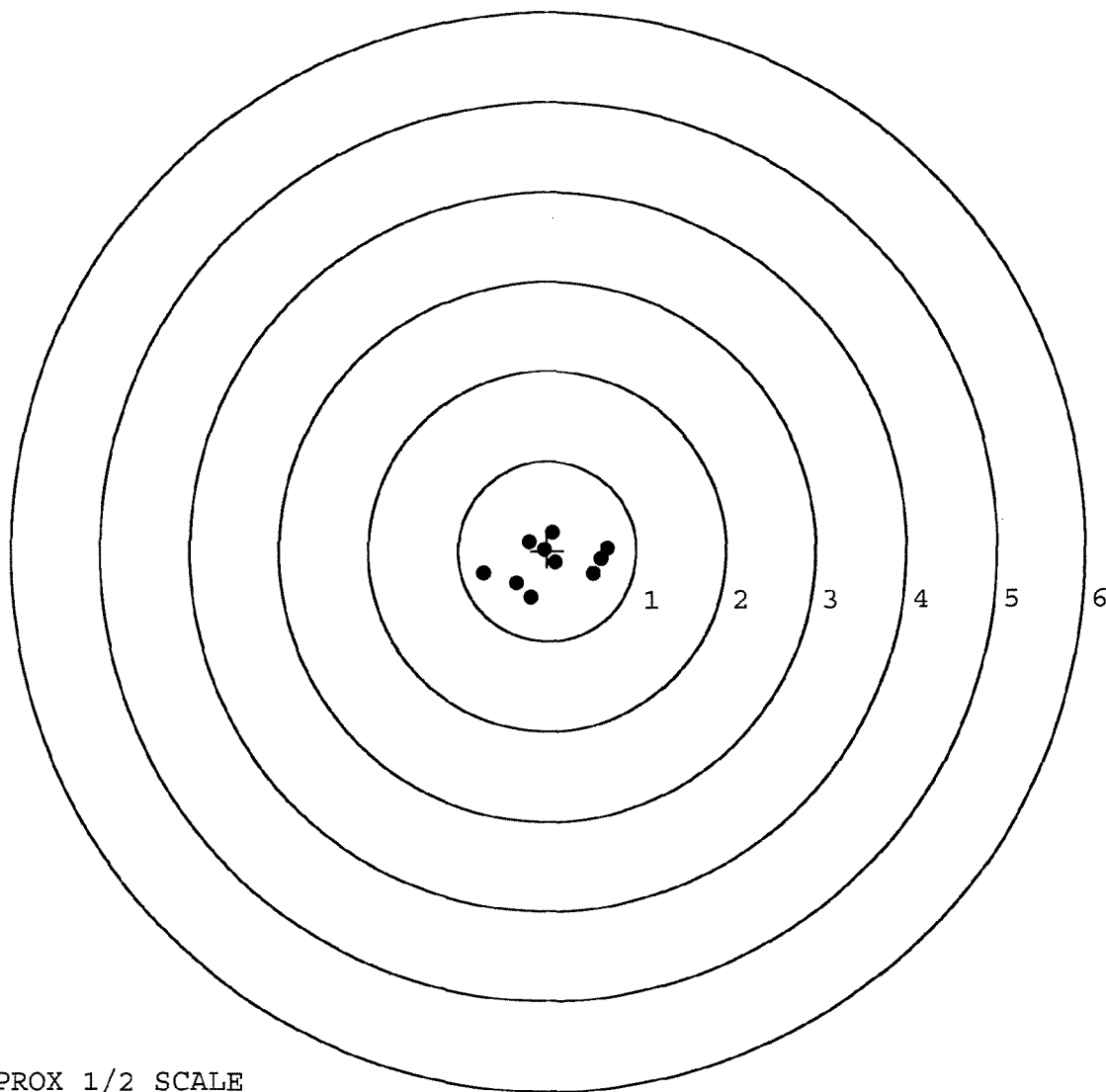
MEAN RADIUS: 0.427

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.676	0.031
2:	0.601	-0.087
3:	0.517	-0.259
4:	-0.191	-0.525
5:	-0.351	-0.362
6:	-0.714	-0.252
7:	-0.209	0.100
8:	0.087	-0.136
9:	-0.038	0.013
10:	0.066	0.202



TARGET APPROX 1/2 SCALE