

G6591578

ORDER 25716

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

UPC



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SERIAL NO.



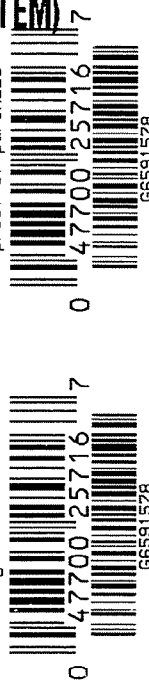
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase

owner registration sticker



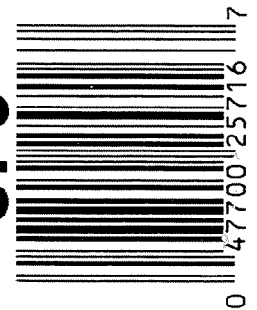
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6591578

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M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6591578

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		10-6-06	RTZ
420	ASSEMBLE ACTION		10-6-06	BLG
430	ASSEMBLE TO STOCK		10-7-06	W/R
440	PROOF		10-7-06	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-7-06	TRW
470	DIS-ASSEMBLE ACTION	OCT 10 2006	10-9-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>CPD</u>	10-10-06	APD
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		12-10-06	W
510	DRILL AND TAP SIGHT HOLES		10-9-06	TRW
520	GOFF BLAST BBL / REC		10-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		10/18/06	TS
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-25-06	SD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-25-06	SD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-25-06	SD
	D) OIL FIRING PIN ASSEMBLY		11-2-06	BLG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>50</u> <u>45</u> <u>50</u>	11-14-06	SD
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>70</u> <u>75</u> <u>70</u>	11-14-06	SD
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	11-14-06	SD
	J) ASSEMBLE STOCK		11-2-06	BLG
	K) ASSEMBLE SWIVEL STUDS		11-16-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-16-06	RT
	M) IRON SIGHT ALIGNMENT		11-16-06	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-16-06	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	11-2-06	L.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		11/2/06	mm
670	FINAL INSPECTION A) HEADSPACE		11-16-06	L.P.D.
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.49</u> <u>2.41</u> <u>2.41</u> <u>2.62</u>	11/11/06	mm
	C) FUNCTION		11-16-06	L.P.D.
690	PACK		12-5-06	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 9-14-06
TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.35	2.60		2.42	
PULL #2	2.42	2.37		2.43	
PULL #3	2.53	2.54		2.49	
PULL #4	2.54	2.64		2.52	
PULL #5	2.60	2.62		2.54	
TOTAL	12.44	12.77		12.40	
AVERAGE	2.48	2.55		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	299	305		
PULL #2	309	305		
PULL #3	314	311		
PULL #4	307	310		
PULL #5	319	307		
TOTAL	15.48	15.38		
AVERAGE	309	307		

	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	4.02	4.16		4.14
PULL #2	4.07	4.28		4.08
PULL #3	4.02	4.17		4.17
PULL #4	3.98	4.24		4.19
PULL #5	4.09	4.17		4.12
TOTAL	20.18	21.02		20.70
AVERAGE	4.03	4.20		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591578.___0
FILE DATE AND TIME: 11/03/2006 06:33

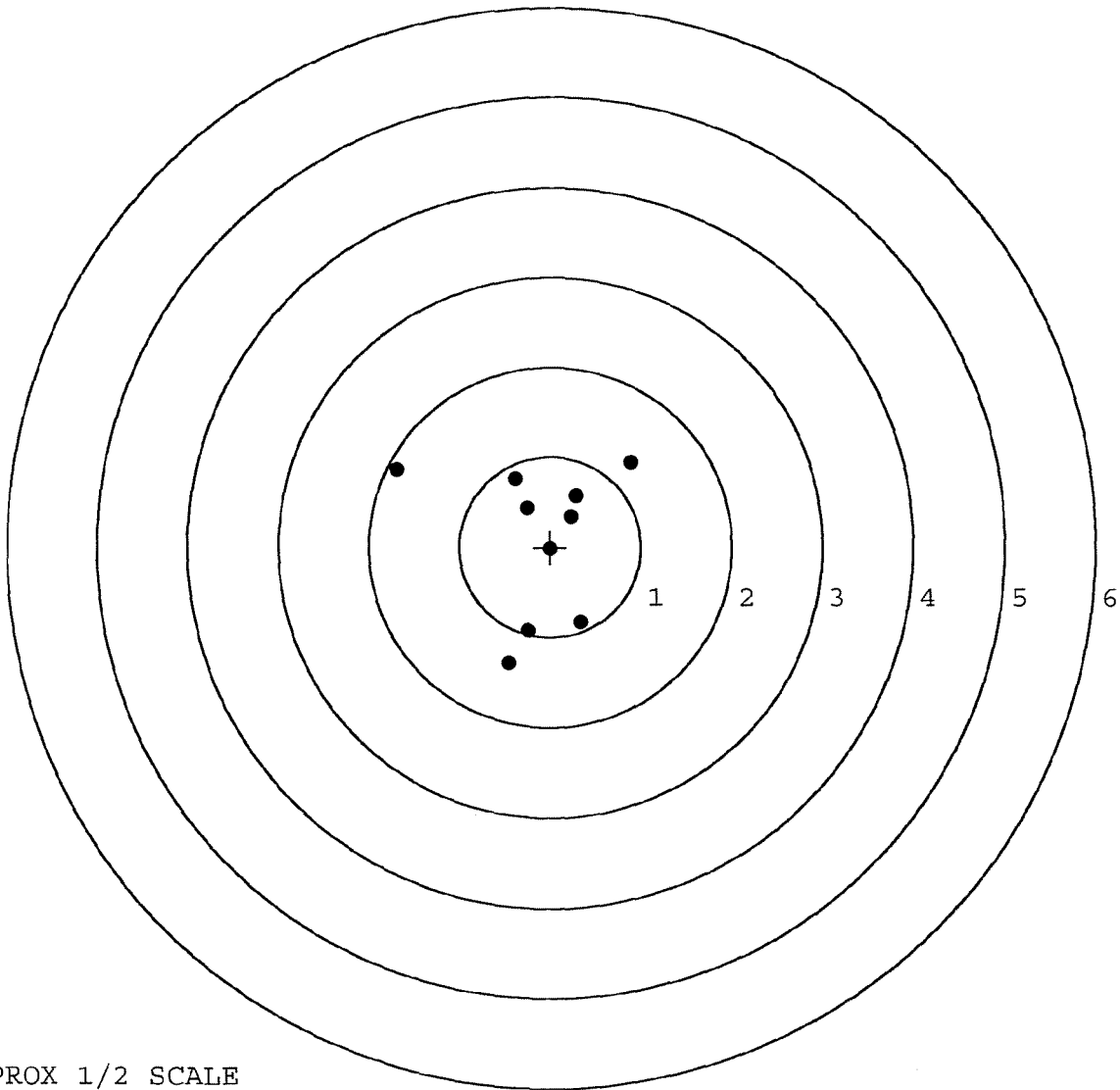
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.034
The Average Y Centroid of the Five Target Set:	0.099
The Average Point of Impact of the Five Target Set:	0.105
The Average Mean Radius of the Five Target Set:	0.849
The Distance from POA to Centroid Target #1:	0.149
The Distance from Centroid Target #2 to Centroid Target #1:	0.320
The Distance from Centroid Target #3 to Centroid Target #1:	0.094
The Distance from Centroid Target #4 to Centroid Target #1:	0.100
The Distance from Centroid Target #5 to Centroid Target #1:	0.067

SERIAL NUMBER: G6591578.___0
TARGET NUMBER: 1
FILE DATE: 11/03/2006
FILE TIME: 06:33

X CENTROID: -0.127
Y CENTROID: 0.078
POA TO CENTROID: 0.149
HORZ SPREAD: 2.582
VERT SPREAD: 2.234
GROUP SPREAD: 2.643
MIN RADIUS: 0.168
MAX RADIUS: 1.745
MEAN RADIUS: 0.889
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.448	-1.300
2:	-0.243	-0.939
3:	0.345	-0.834
4:	0.888	0.934
5:	-0.387	0.749
6:	-0.257	0.432
7:	0.285	0.569
8:	0.233	0.345
9:	0.006	-0.024
10:	-1.694	0.847



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591578. __0

TARGET NUMBER: 2

FILE DATE: 11/03/2006

FILE TIME: 06:33

POINT#	X	Y
1:	0.939	-0.711
2:	1.541	-0.587
3:	1.135	-0.178
4:	0.434	0.180
5:	0.216	0.199
6:	0.008	0.149
7:	-0.290	-0.329
8:	-0.462	0.138
9:	-0.738	0.345
10:	-0.984	0.677

X CENTROID: 0.180

Y CENTROID: -0.012

POA TO CENTROID: 0.180

HORZ SPREAD: 2.525

VERT SPREAD: 1.388

GROUP SPREAD: 2.824

MIN RADIUS: 0.214

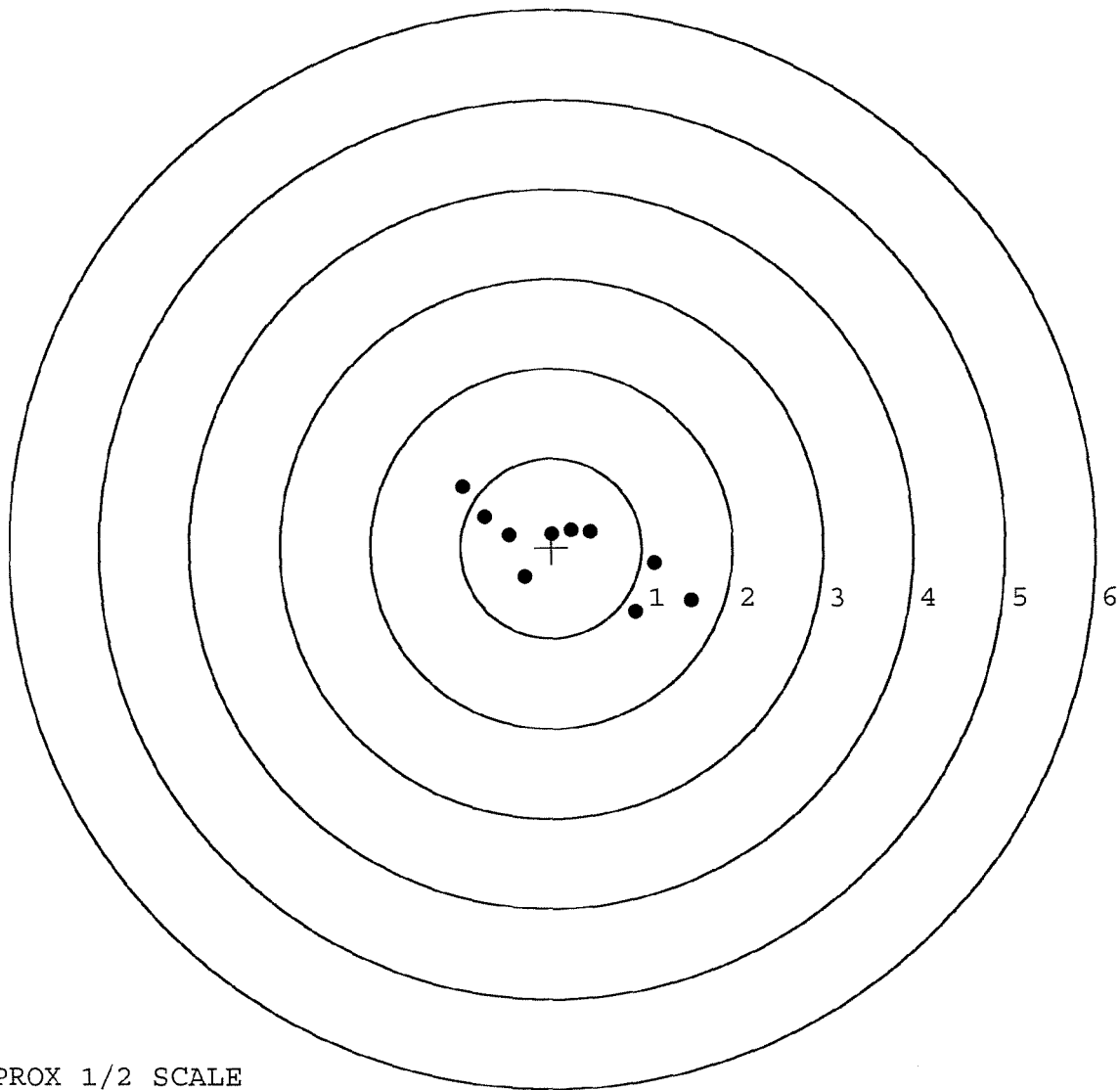
MAX RADIUS: 1.478

MEAN RADIUS: 0.781

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591578. 0

TARGET NUMBER: 3

FILE DATE: 11/03/2006

FILE TIME: 06:33

POINT#	X	Y
1:	0.480	-1.229
2:	0.069	-0.858
3:	0.368	-0.545
4:	0.800	0.100
5:	0.307	0.398
6:	0.876	1.055
7:	-0.267	0.545
8:	-0.766	0.529
9:	-0.701	0.984
10:	-1.760	0.454

X CENTROID: -0.059

Y CENTROID: 0.143

POA TO CENTROID: 0.155

HORZ SPREAD: 2.636

VERT SPREAD: 2.284

GROUP SPREAD: 2.802

MIN RADIUS: 0.446

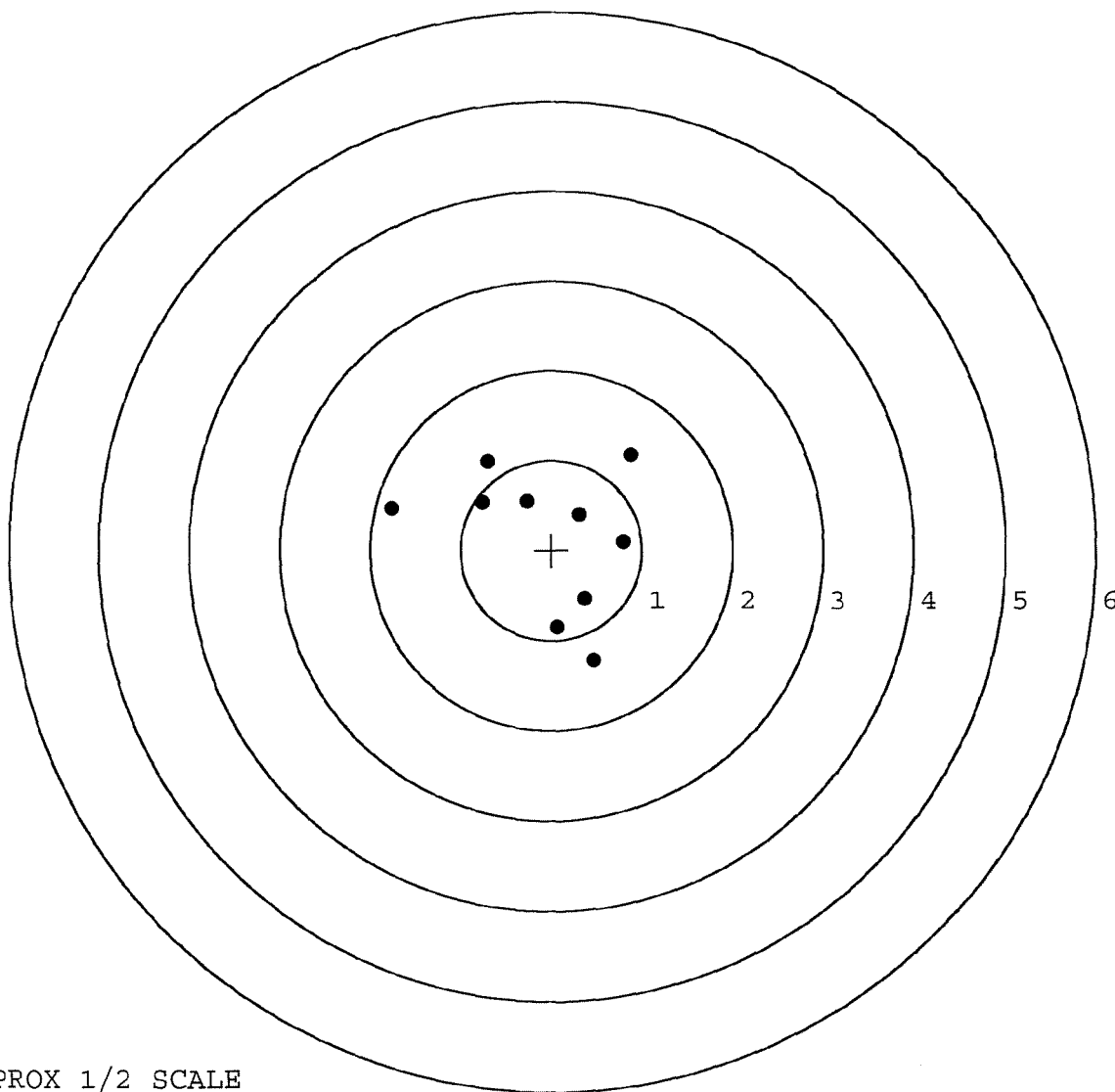
MAX RADIUS: 1.729

MEAN RADIUS: 0.995

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

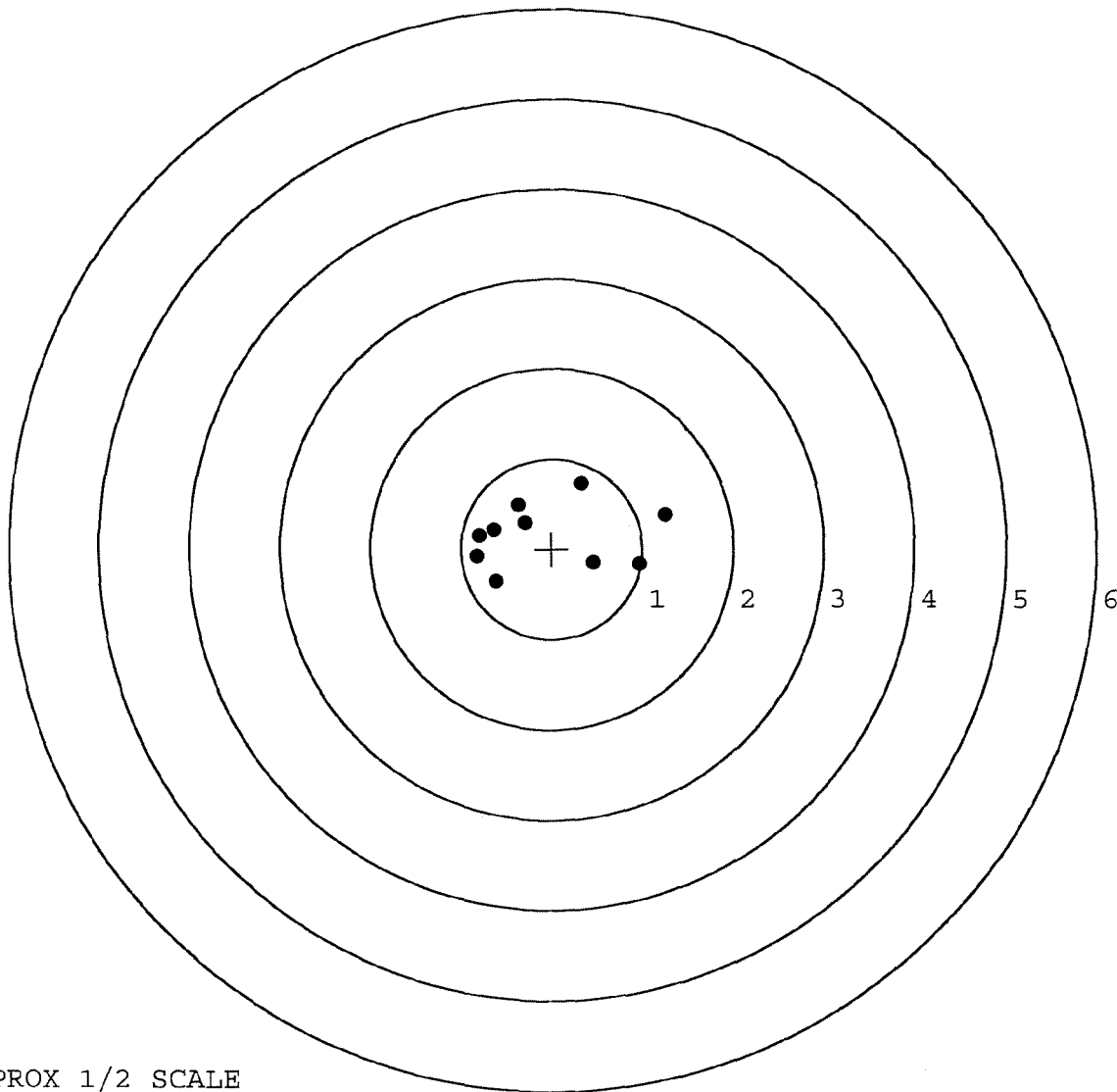


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591578. __0
TARGET NUMBER: 4
FILE DATE: 11/03/2006
FILE TIME: 06:33

X CENTROID: -0.053
Y CENTROID: 0.145
POA TO CENTROID: 0.154
HORZ SPREAD: 2.077
VERT SPREAD: 1.101
GROUP SPREAD: 2.131
MIN RADIUS: 0.282
MAX RADIUS: 1.328
MEAN RADIUS: 0.736
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.253	0.384
2:	0.973	-0.173
3:	0.463	-0.154
4:	0.332	0.731
5:	-0.297	0.287
6:	-0.370	0.485
7:	-0.643	0.207
8:	-0.800	0.146
9:	-0.824	-0.092
10:	-0.616	-0.370



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591578. 0

TARGET NUMBER: 5

FILE DATE: 11/03/2006

FILE TIME: 06:33

X CENTROID: -0.108

Y CENTROID: 0.142

POA TO CENTROID: 0.178

HORZ SPREAD: 1.888

VERT SPREAD: 2.167

GROUP SPREAD: 2.570

MIN RADIUS: 0.424

MAX RADIUS: 1.624

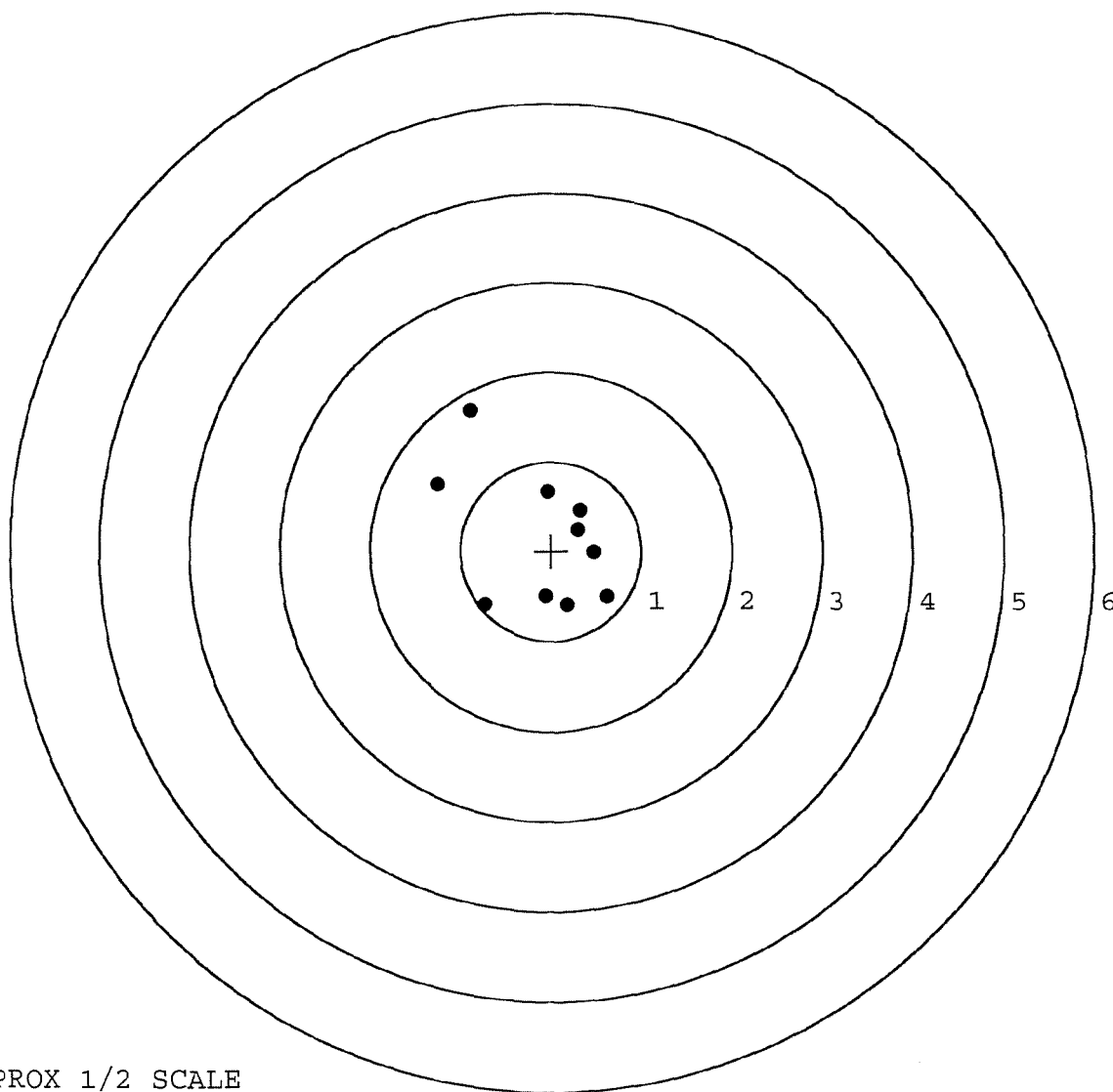
MEAN RADIUS: 0.842

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.897	1.561
2:	-1.262	0.746
3:	-0.728	-0.601
4:	-0.045	0.662
5:	0.323	0.460
6:	0.305	0.236
7:	0.478	-0.018
8:	0.626	-0.509
9:	0.184	-0.606
10:	-0.064	-0.512



TARGET APPROX 1/2 SCALE