

G 659 1669

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 1651

proof of purchase



owner registration sticker



ORDER NO.

25727

BARREL LENGTH

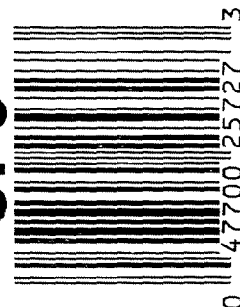
24"

CAPACITY

5

G6591669

UPC



ORDER 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)

UPC



ORDER 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66591669

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		9-6-06	RTZ
420	ASSEMBLE ACTION		9-7-06	RTZ
430	ASSEMBLE TO STOCK		9-7-06	BD
440	PROOF		9-7-06	TRW
460	CHECK HEADSPACE	INSPECTED	9-7-06	TRW
470	DIS-ASSEMBLE ACTION	SEP 11 2006	9-7-06	RTZ
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	9/11/06	<u>mm</u>
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-11-06	CW
510	DRILL AND TAP SIGHT HOLES		9-11-06	TRW
520	GOFF BLAST BBL / REC		9-11-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		9/14/06	PB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-19-06	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-19-06	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-19-06	DA
	D) OIL FIRING PIN ASSEMBLY		9-21-06	BLC
	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>6.2</u> <u>6.2</u> <u>6.2</u>	9/27/06	BA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.2</u> <u>3.2</u> <u>3.5</u>	9/27/06	BA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.0245</u> <u>.024</u>	9/27/06	BA
	J) ASSEMBLE STOCK		9-21-06	BLG
	K) ASSEMBLE SWIVEL STUDS		9-27-06	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-21-06	BLG
	M) IRON SIGHT ALIGNMENT		9-21-06	BLG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-21-06	BLG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	9-22-06	TKW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-22-06	AD
670	FINAL INSPECTION A) HEADSPACE		9-27-06	RR
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.60</u> <u>2.63</u> <u>2.58</u> <u>2.53</u>	9/27/06	BA
	C) FUNCTION		9/27-06	RTZ
690	PACK			

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 9-19-06
TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	246	254		231	
PULL #2	234	247		229	
PULL #3	235	248		230	
PULL #4	231	248		233	
PULL #5	246	244		234	
TOTAL	1192	1241		1157	
AVERAGE	238	248		231	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	315	325		
PULL #2	290	304		
PULL #3	299	289		
PULL #4	298	280		
PULL #5	297	284		
TOTAL	1499	1482		
AVERAGE	299	296		

	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	408	418		405
PULL #2	399	408		402
PULL #3	414	406		401
PULL #4	407	401		403
PULL #5	409	401		401
TOTAL	2037	2034		2012
AVERAGE	407	406		402

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591669.__0

FILE DATE AND TIME: 09/25/2006 06:12

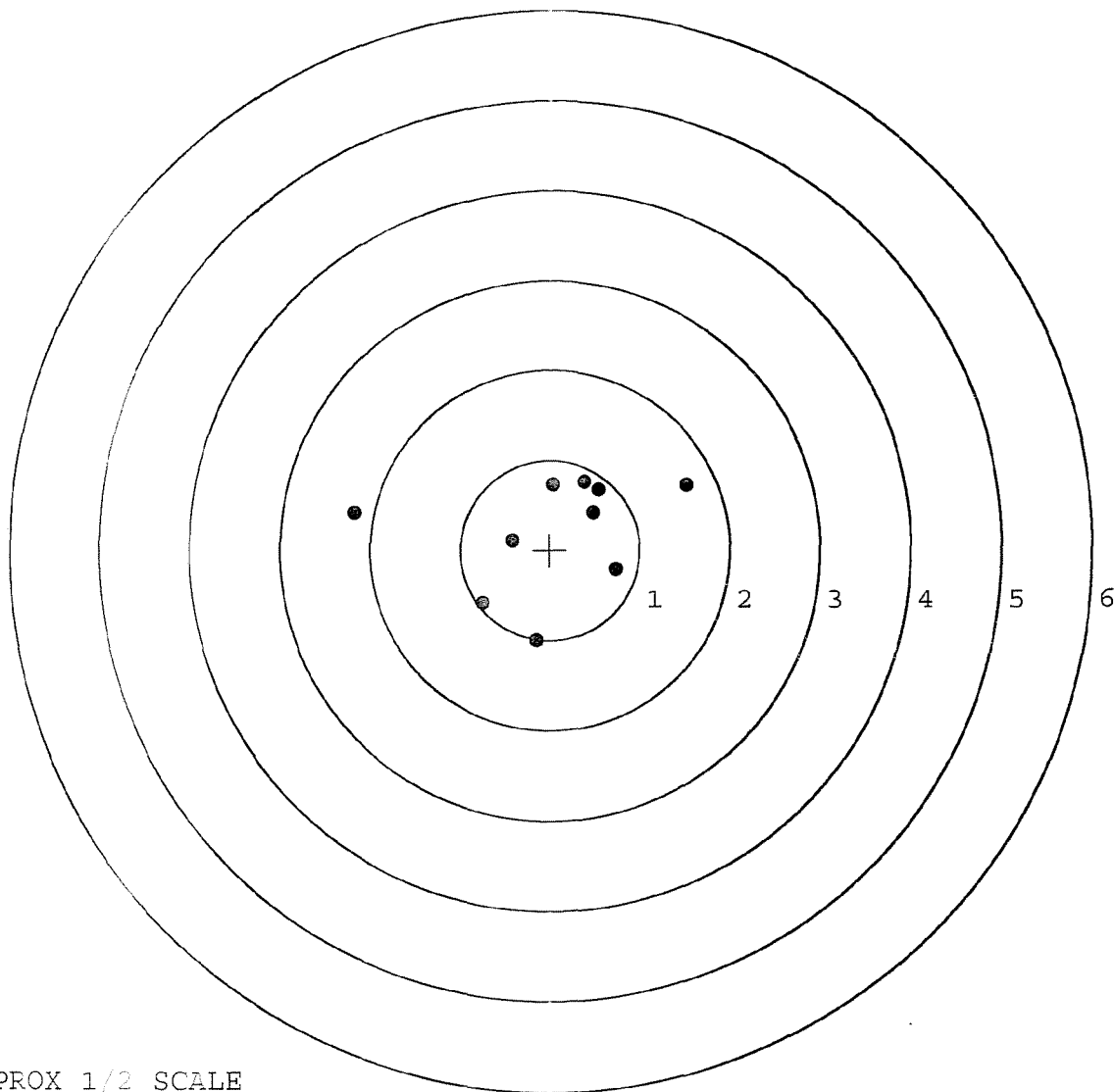
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.038
The Average Y Centroid of the Five Target Set:	0.060
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.707
The Distance from POA to Centroid Target #1:	0.205
The Distance from Centroid Target #2 to Centroid Target #1:	0.246
The Distance from Centroid Target #3 to Centroid Target #1:	0.123
The Distance from Centroid Target #4 to Centroid Target #1:	0.164
The Distance from Centroid Target #5 to Centroid Target #1:	0.204

SERIAL NUMBER: G6591669. __0
TARGET NUMBER: 1
FILE DATE: 09/25/2006
FILE TIME: 06:12

POINT#	X	Y
1:	-2.174	0.415
2:	-0.753	-0.592
3:	-0.158	-1.008
4:	0.738	-0.214
5:	1.516	0.732
6:	0.484	0.424
7:	0.545	0.677
8:	0.382	0.761
9:	0.034	0.730
10:	-0.424	0.113

X CENTROID: 0.019
Y CENTROID: 0.204
POA TO CENTROID: 0.205
HORZ SPREAD: 3.690
VERT SPREAD: 1.769
GROUP SPREAD: 3.704
MIN RADIUS: 0.452
MAX RADIUS: 2.203
MEAN RADIUS: 0.982
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __0

TARGET NUMBER: 2

FILE DATE: 09/25/2006

FILE TIME: 06:12

POINT#	X	Y
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1:	0.309	0.916
----	-------	-------

2:	0.719	0.431
----	-------	-------

3:	-0.250	0.276
----	--------	-------

4:	-0.765	-0.148
----	--------	--------

5:	-0.259	-0.158
----	--------	--------

6:	-0.031	-0.134
----	--------	--------

7:	0.335	-0.531
----	-------	--------

8:	0.053	-0.788
----	-------	--------

9:	-0.044	-0.528
----	--------	--------

10:	-0.180	0.260
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X CENTROID: -0.011

Y CENTROID: -0.040

POA TO CENTROID: 0.042

HORZ SPREAD: 1.484

VERT SPREAD: 1.704

GROUP SPREAD: 1.723

MIN RADIUS: 0.096

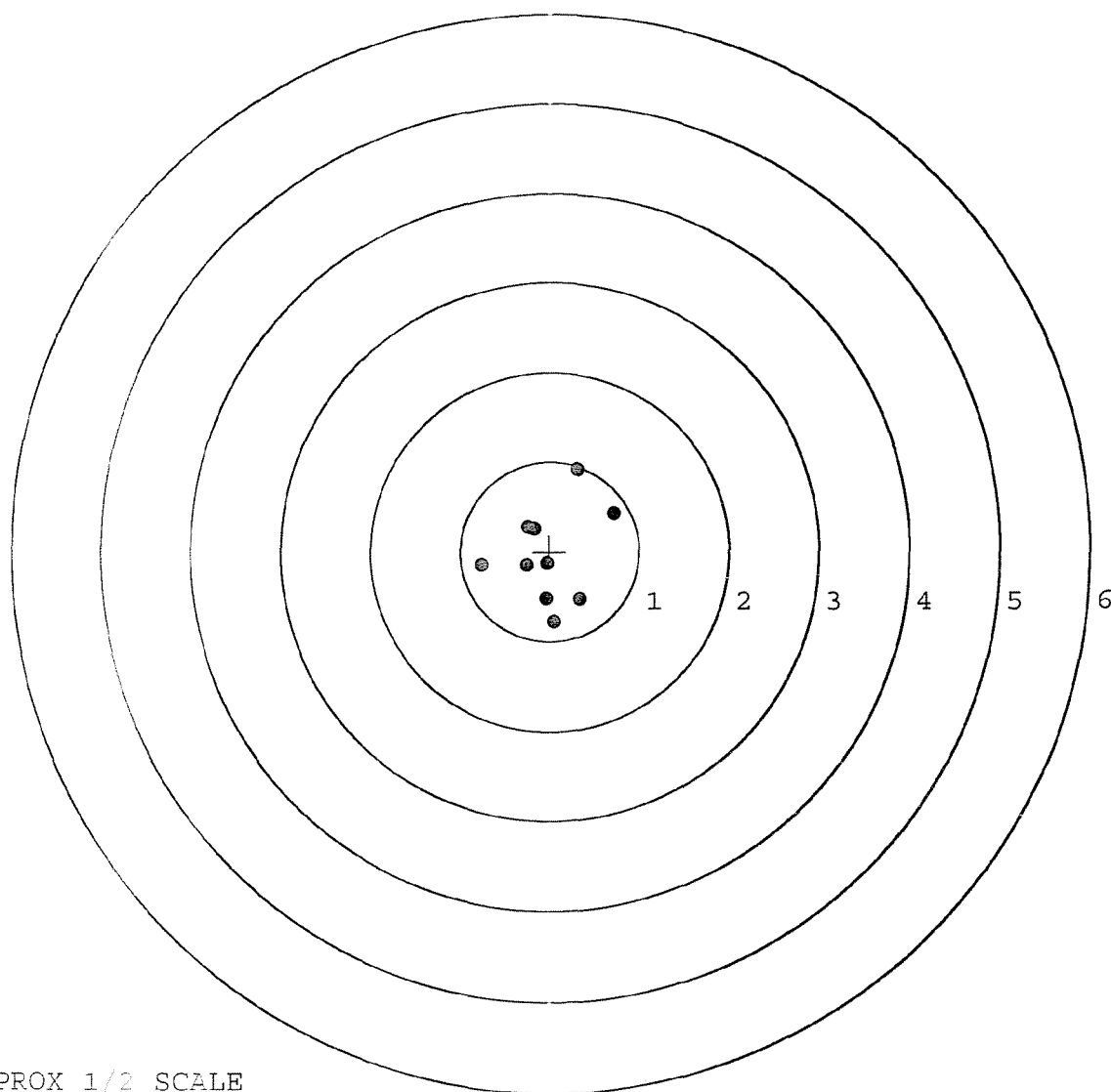
MAX RADIUS: 1.009

MEAN RADIUS: 0.559

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

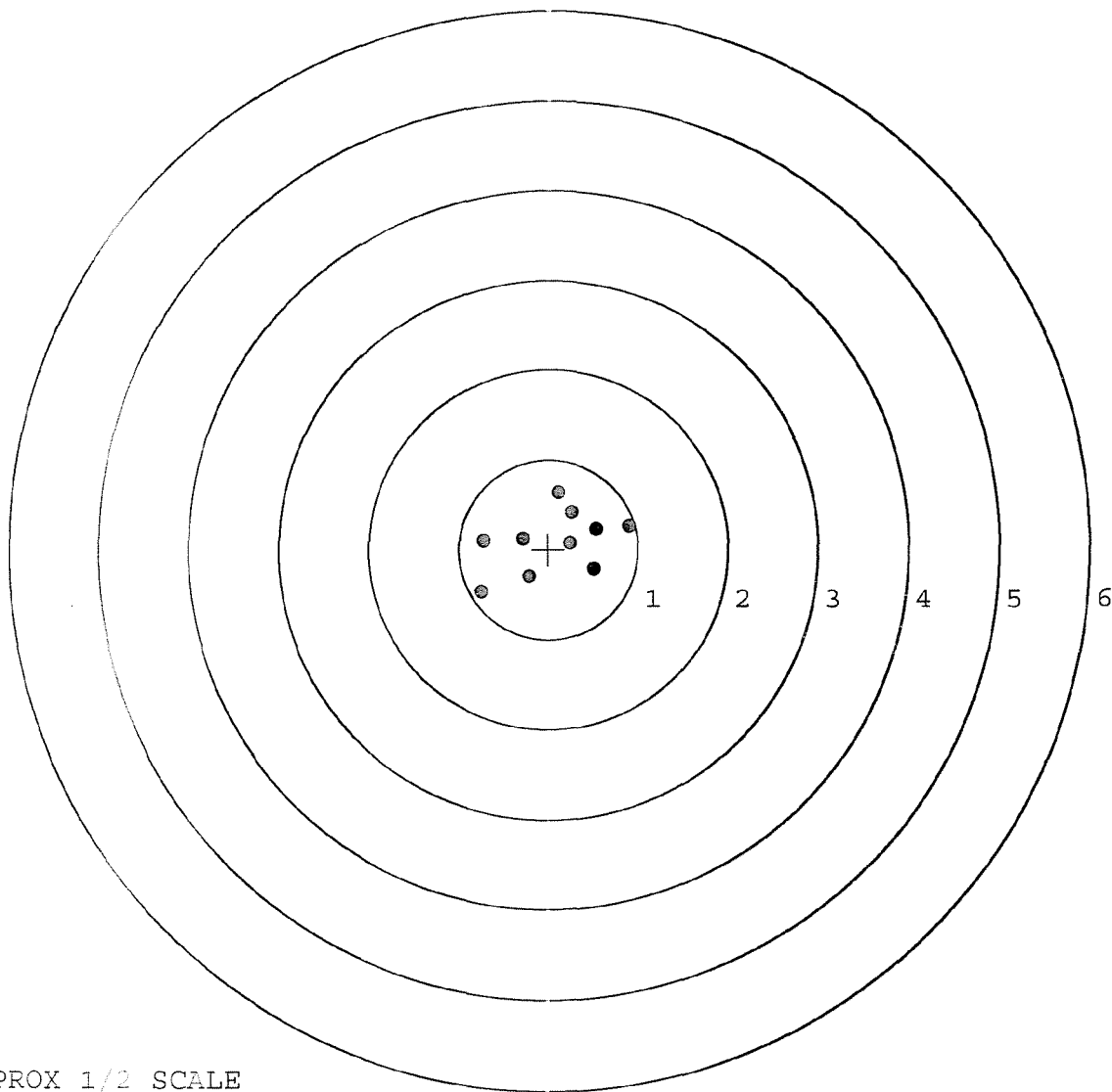


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __0
TARGET NUMBER: 3
FILE DATE: 09/25/2006
FILE TIME: 06:12

POINT#	X	Y
1:	-0.752	-0.469
2:	-0.732	0.103
3:	-0.220	-0.302
4:	-0.291	0.123
5:	0.511	-0.219
6:	0.898	0.264
7:	0.246	0.072
8:	0.530	0.230
9:	0.258	0.420
10:	0.112	0.639

X CENTROID: 0.056
Y CENTROID: 0.086
POA TO CENTROID: 0.103
HORZ SPREAD: 1.650
VERT SPREAD: 1.108
GROUP SPREAD: 1.805
MIN RADIUS: 0.191
MAX RADIUS: 0.980
MEAN RADIUS: 0.563
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

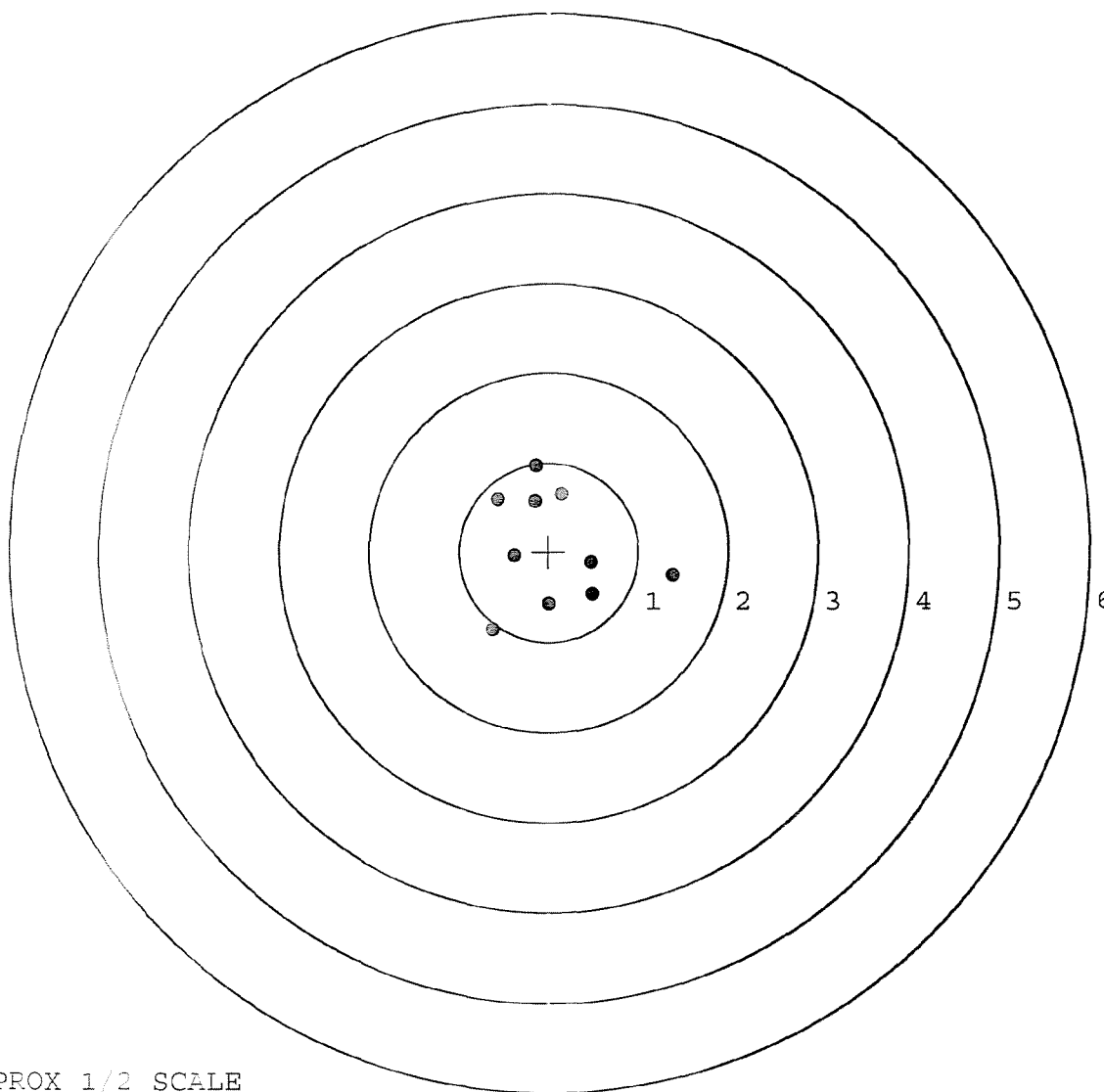


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __0
TARGET NUMBER: 4
FILE DATE: 09/25/2006
FILE TIME: 06:12

X CENTROID: 0.060
Y CENTROID: 0.045
POA TO CENTROID: 0.075
HORZ SPREAD: 2.013
VERT SPREAD: 1.830
GROUP SPREAD: 2.134
MIN RADIUS: 0.447
MAX RADIUS: 1.359
MEAN RADIUS: 0.766
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.631	-0.860
2:	-0.006	-0.580
3:	0.490	-0.472
4:	1.382	-0.268
5:	0.477	-0.116
6:	-0.386	-0.041
7:	0.140	0.649
8:	-0.157	0.569
9:	-0.568	0.600
10:	-0.145	0.970

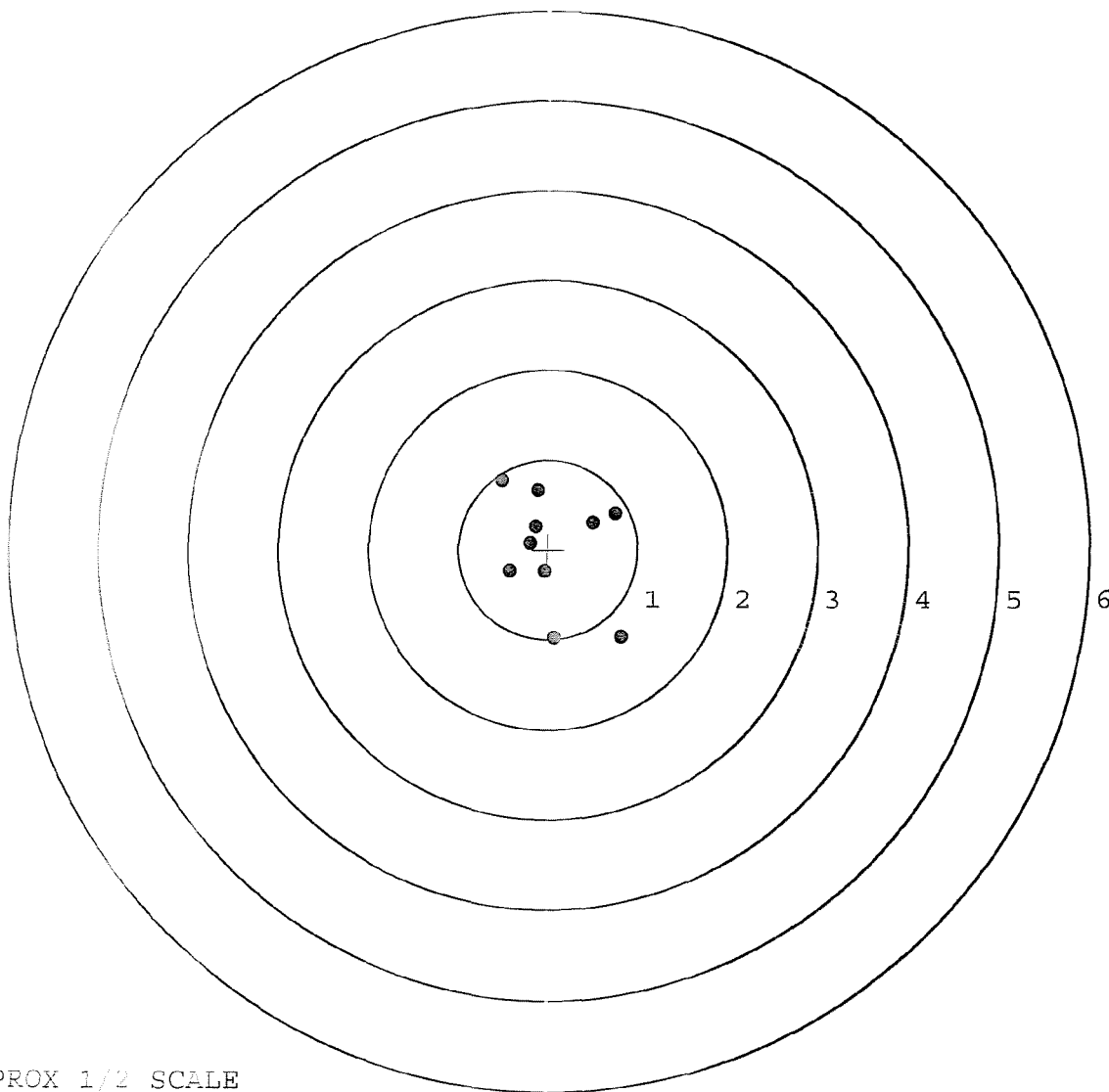


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. 0
TARGET NUMBER: 5
FILE DATE: 09/25/2006
FILE TIME: 06:12

POINT#	X	Y
1:	0.817	-0.979
2:	0.067	-0.992
3:	0.749	0.407
4:	0.499	0.311
5:	-0.432	-0.234
6:	-0.039	-0.241
7:	-0.518	0.780
8:	-0.118	0.662
9:	-0.143	0.263
10:	-0.204	0.078

X CENTROID: 0.068
Y CENTROID: 0.005
POA TO CENTROID: 0.068
HORZ SPREAD: 1.335
VERT SPREAD: 1.772
GROUP SPREAD: 2.208
MIN RADIUS: 0.269
MAX RADIUS: 1.237
MEAN RADIUS: 0.664
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6591669. __1
FILE DATE AND TIME: 10/14/2006 09:25

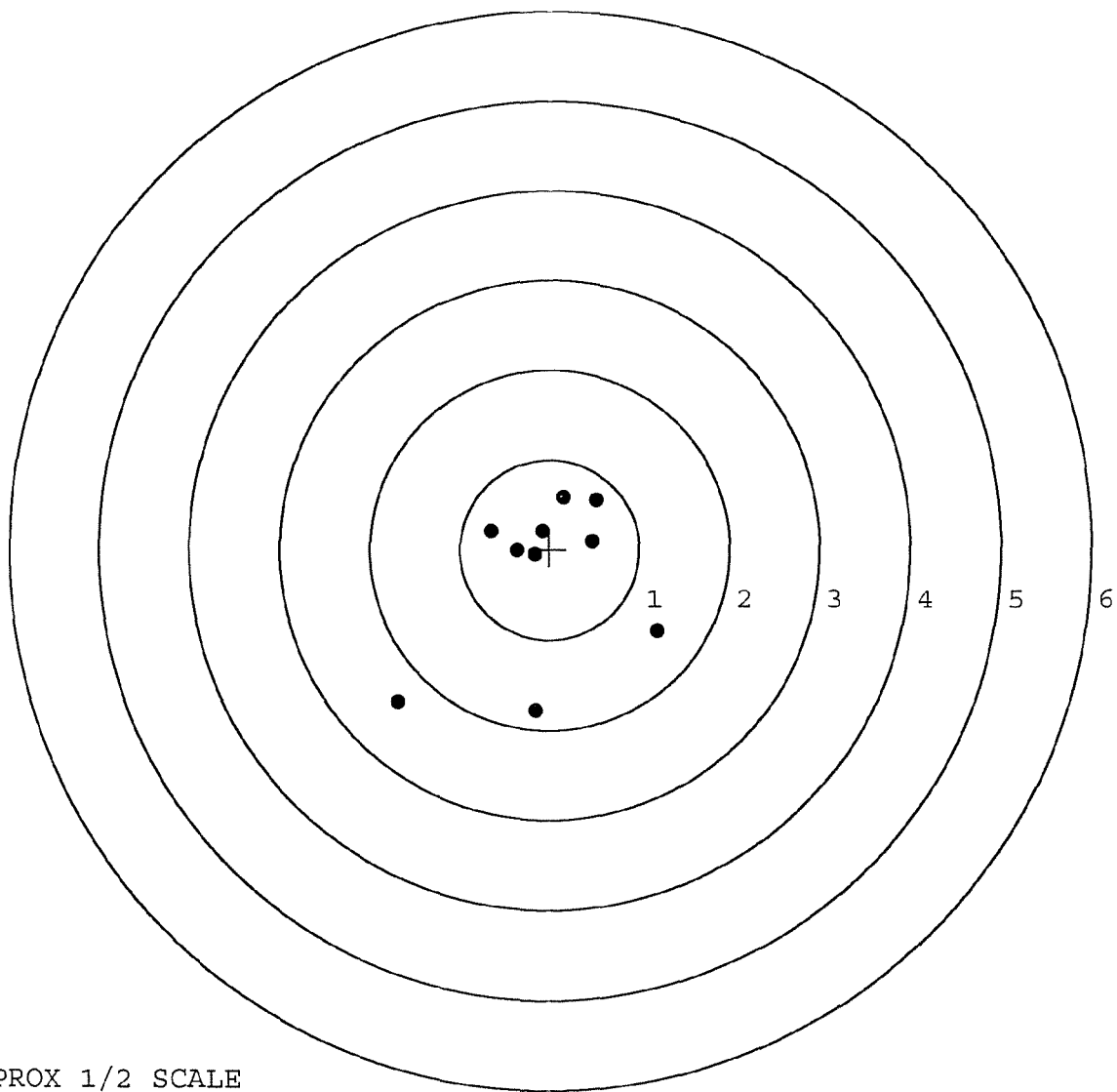
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.018
The Average Y Centroid of the Five Target Set:	-0.021
The Average Point of Impact of the Five Target Set:	0.028
The Average Mean Radius of the Five Target Set:	0.856
The Distance from POA to Centroid Target #1:	0.292
The Distance from Centroid Target #2 to Centroid Target #1:	0.405
The Distance from Centroid Target #3 to Centroid Target #1:	0.375
The Distance from Centroid Target #4 to Centroid Target #1:	0.170
The Distance from Centroid Target #5 to Centroid Target #1:	0.430

SERIAL NUMBER: G6591669. __1
TARGET NUMBER: 1
FILE DATE: 10/14/2006
FILE TIME: 09:25

POINT#	X	Y
1:	0.475	0.091
2:	0.525	0.553
3:	0.154	0.582
4:	-0.074	0.202
5:	-0.163	-0.056
6:	-0.361	-0.015
7:	-0.659	0.202
8:	1.206	-0.908
9:	-0.148	-1.790
10:	-1.684	-1.692

X CENTROID: -0.073
Y CENTROID: -0.283
POA TO CENTROID: 0.292
HORZ SPREAD: 2.890
VERT SPREAD: 2.372
GROUP SPREAD: 3.150
MIN RADIUS: 0.244
MAX RADIUS: 2.140
MEAN RADIUS: 0.954
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

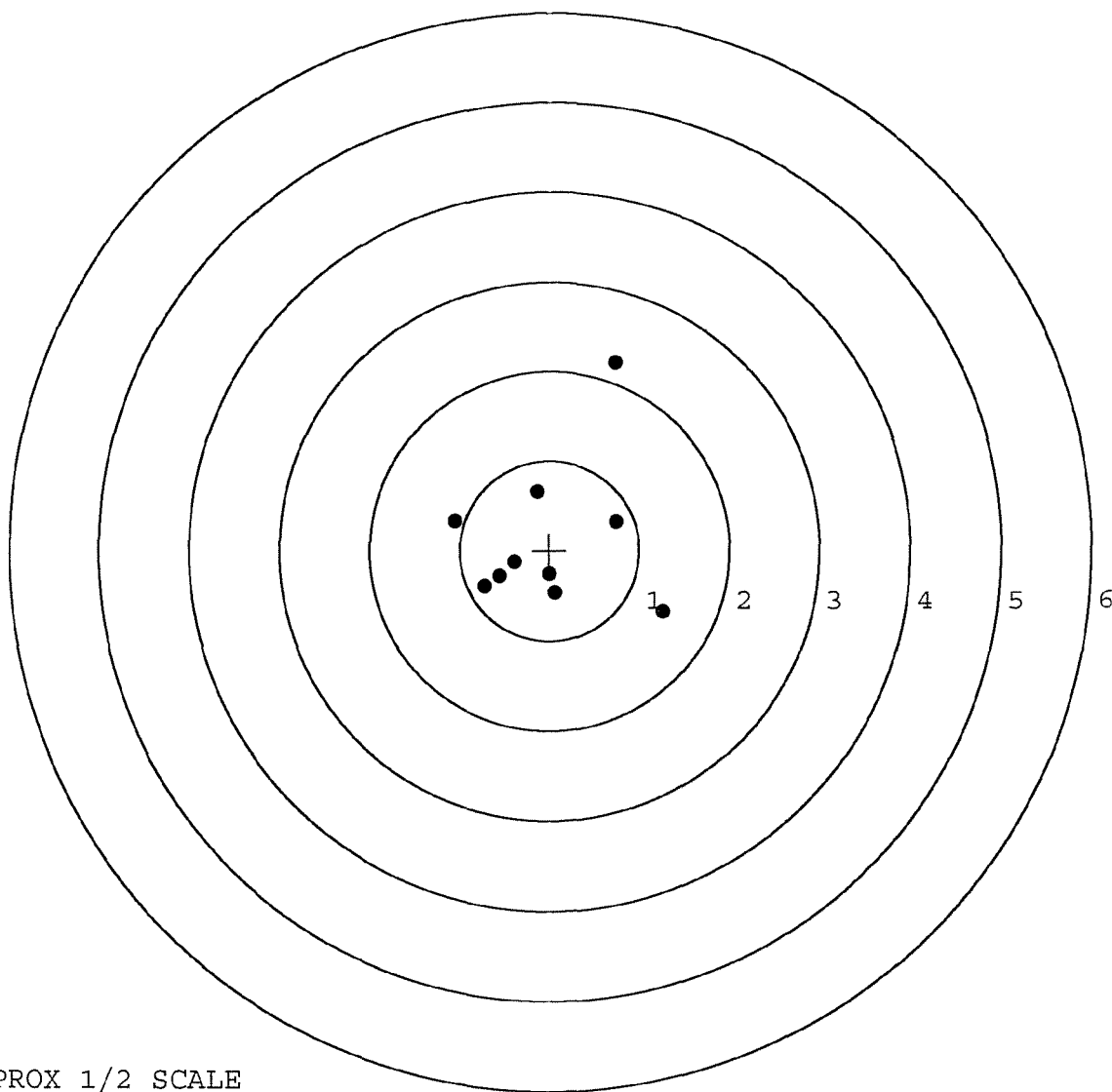


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __1
TARGET NUMBER: 2
FILE DATE: 10/14/2006
FILE TIME: 09:25

POINT#	X	Y
1:	1.263	-0.686
2:	0.745	0.317
3:	-0.136	0.653
4:	-1.059	0.320
5:	0.736	2.095
6:	0.066	-0.468
7:	0.006	-0.264
8:	-0.388	-0.127
9:	-0.558	-0.284
10:	-0.722	-0.399

X CENTROID: -0.005
Y CENTROID: 0.116
POA TO CENTROID: 0.116
HORZ SPREAD: 2.322
VERT SPREAD: 2.781
GROUP SPREAD: 2.889
MIN RADIUS: 0.380
MAX RADIUS: 2.113
MEAN RADIUS: 0.900
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

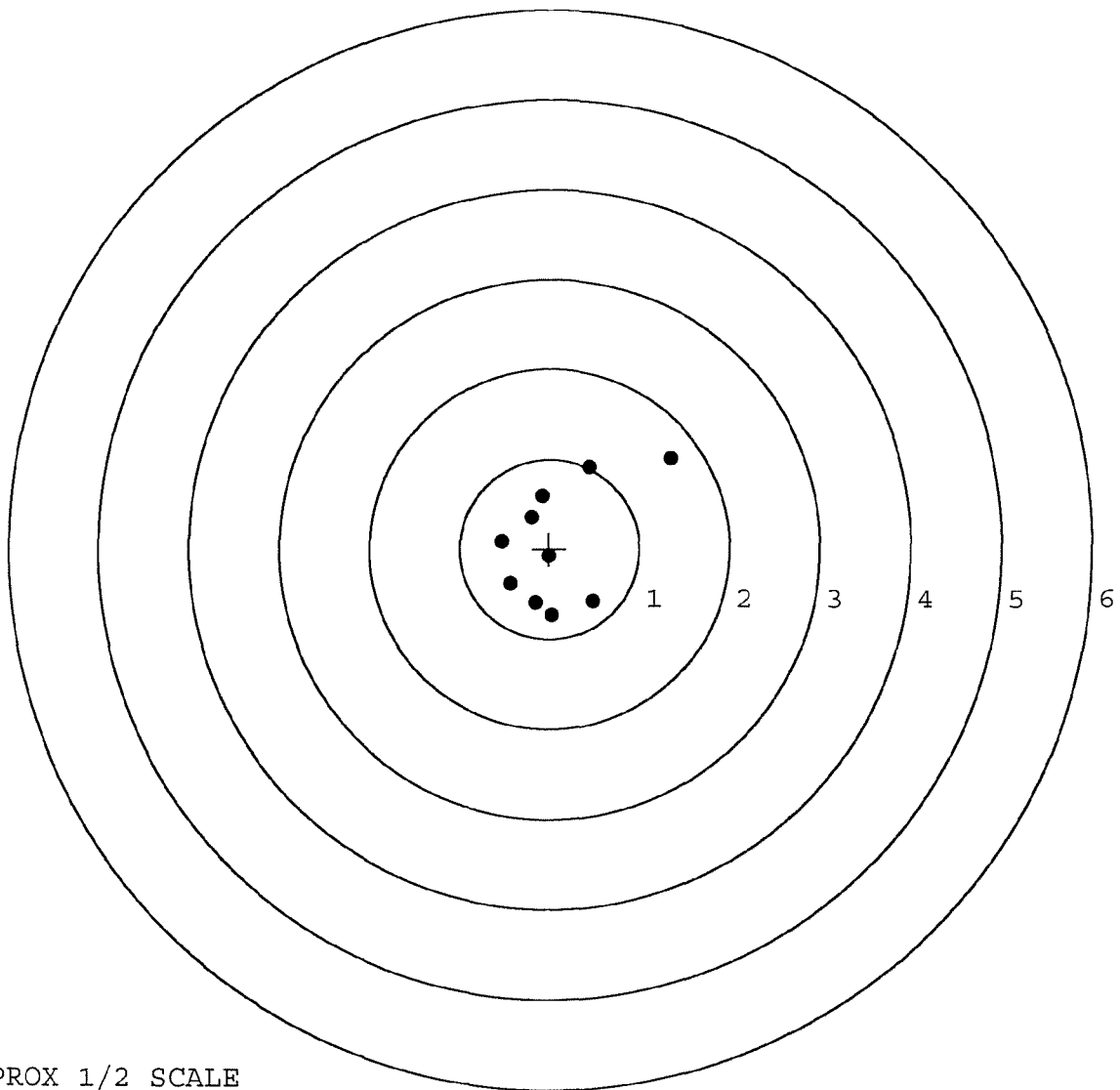


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __1
TARGET NUMBER: 3
FILE DATE: 10/14/2006
FILE TIME: 09:25

POINT#	X	Y
1:	1.343	1.011
2:	0.444	0.915
3:	0.491	-0.585
4:	0.030	-0.746
5:	-0.155	-0.601
6:	-0.011	-0.082
7:	-0.434	-0.391
8:	-0.528	0.086
9:	-0.206	0.349
10:	-0.081	0.590

X CENTROID: 0.089
Y CENTROID: 0.055
POA TO CENTROID: 0.105
HORZ SPREAD: 1.871
VERT SPREAD: 1.757
GROUP SPREAD: 2.263
MIN RADIUS: 0.169
MAX RADIUS: 1.577
MEAN RADIUS: 0.722
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __1

TARGET NUMBER: 4

FILE DATE: 10/14/2006

FILE TIME: 09:25

POINT#	X	Y
1:	0.088	-1.432
2:	0.595	-0.734
3:	0.689	-0.585
4:	0.603	-0.285
5:	-0.344	-0.130
6:	-0.668	-0.035
7:	-0.386	0.290
8:	-0.563	0.483
9:	-0.962	1.029
10:	-0.412	0.146

X CENTROID: -0.136

Y CENTROID: -0.125

POA TO CENTROID: 0.185

HORZ SPREAD: 1.651

VERT SPREAD: 2.461

GROUP SPREAD: 2.676

MIN RADIUS: 0.208

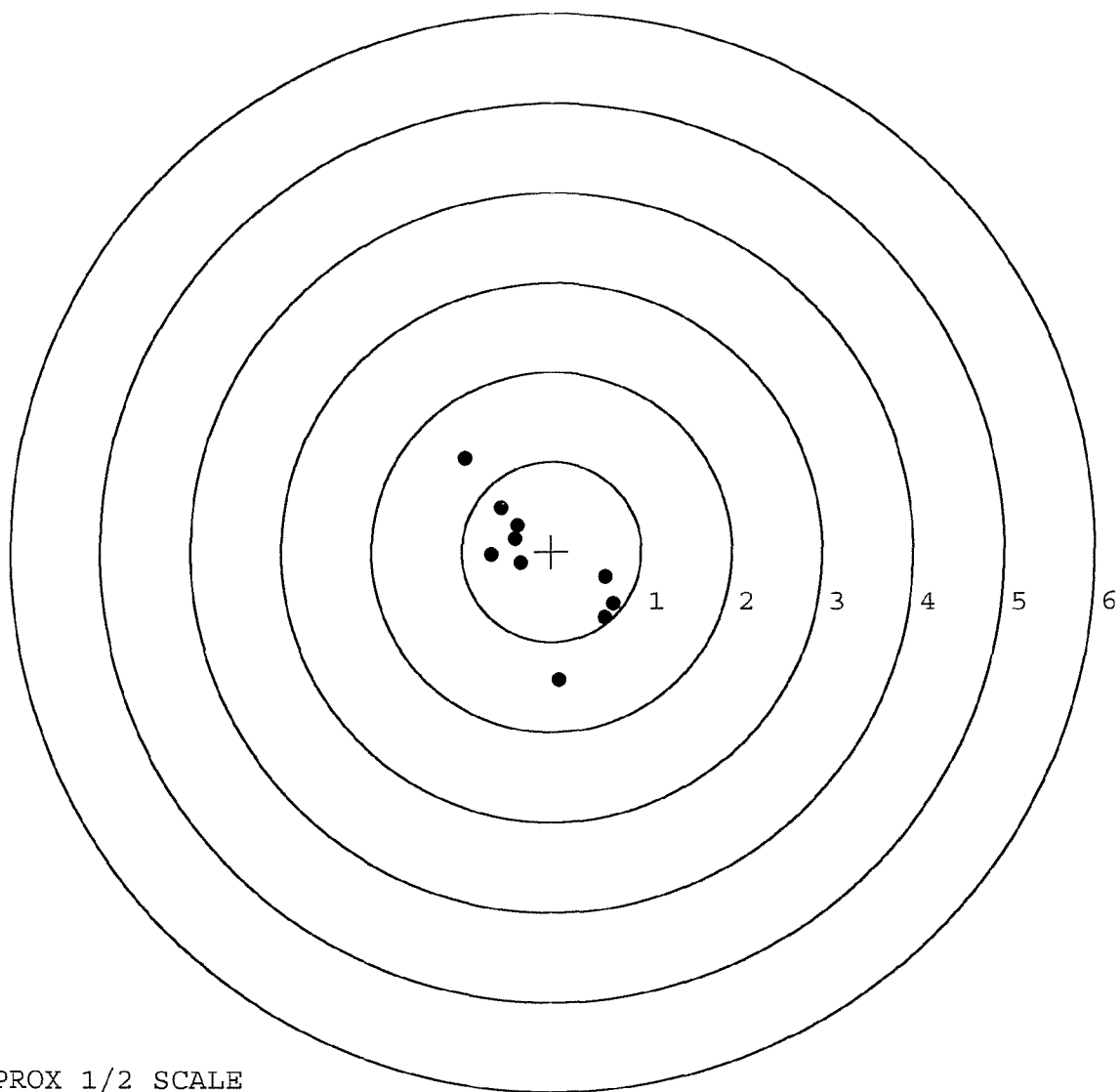
MAX RADIUS: 1.419

MEAN RADIUS: 0.776

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

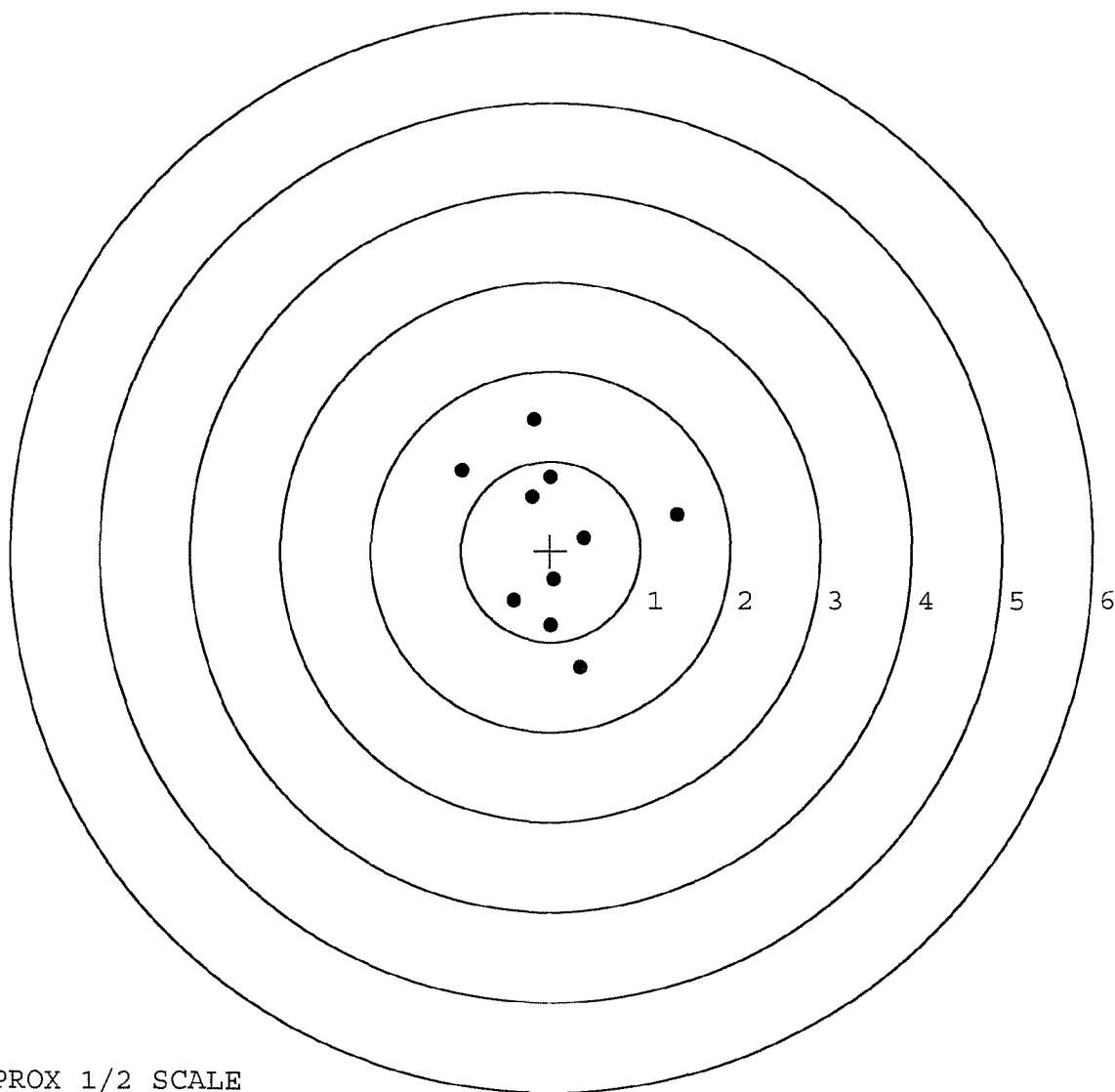


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6591669. __1
TARGET NUMBER: 5
FILE DATE: 10/14/2006
FILE TIME: 09:25

POINT#	X	Y
1:	1.401	0.399
2:	0.331	-1.290
3:	0.000	-0.822
4:	-0.407	-0.560
5:	0.034	-0.317
6:	0.370	0.140
7:	-0.213	0.605
8:	-0.007	0.824
9:	-0.190	1.461
10:	-0.989	0.894

X CENTROID: 0.033
Y CENTROID: 0.133
POA TO CENTROID: 0.137
HORZ SPREAD: 2.390
VERT SPREAD: 2.751
GROUP SPREAD: 2.800
MIN RADIUS: 0.337
MAX RADIUS: 1.454
MEAN RADIUS: 0.926
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE