

G6360899

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

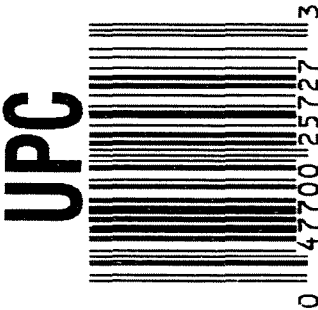
- INSTUCTION BOOK 3518

DD FORM 1651



ORDER NO.	25727
BARREL LENGTH	24"
CAPACITY	5

G6360899



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.



12/10/2004 1:21:34 PM

Original

5

Crib

25727

M/24 7.62 NATO (RIFLE W/SCOPE&SIGHTS)



.MA25727

Shop Order: SWS667663A



.ABSWS667663A

Start Date: 12/17/2004

Finish Date: 1/12/2005

0540

01PC001

Flat Black Powder Coat. Barrel and



0003592015

0560

89SWS1

Reassemble Action.



0003592016

0690

89SWS1

Pack Rifle



0003592027

0700

89SWS1

Stencil SWS Container



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 636 0899

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-1-04	RJL
600	PROOF		4-1-04	RJL
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	4-1-04	RJL
610	DIS-ASSEMBLE GUN		4-1-04	RJL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 07 2004 INSPECTOR RJL		
615	ROLLMARK CALIBER		4/5/04	LB
617	DRILL AND TAP SIGHT HOLES		4-2-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		4-7	TA
	(BOLT)		4-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-28-04	RJL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-28-04	RJL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-28-04	RJL
	D) OIL FIRING PIN ASSEMBLY		4-28-04	RJL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP # OPERATION NAME			READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	5.5	5.5	5.5	6/1/04	DA
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	2.0	2.0	2.0	4/1/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	1.023	1.022	1.022	4/1/04	DA
	J) ASSEMBLE STOCK					4-28-04	RTL
	K) ASSEMBLE SWIVEL STUDS					6-9-04	Rev
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					4-28-04	RTL
	M) IRON SIGHT ALIGNMENT					4-28-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					4-28-04	RTL
640	GALLERY TEST AND TARGET		PASS FAIL			5-25-04	TRW
	MALFUNCTION		CORRECTION			5-25-04	TRW
	MALFUNCTION		CORRECTION			5-25-04	TRW
	MALFUNCTION		CORRECTION			5-25-04	TRW
	MALFUNCTION		CORRECTION			5-25-04	TRW
645	INSPECT FOR LIVE AMMO					5-25-04	TRW
655	FINAL INSPECTION A) HEADSPACE					6-9-04	Rev
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.85	2.82	2.81 2.88 2.84	6/1/04	DA
	C) FUNCTION					6-9-04	Rev
660	PACK					12/17/04	DA

BARBER - M24 0083382
 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)

SERIAL NO. _____

DATE 4-20-04

TESTER Rev

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.39	2.43		2.45	
PULL #2	2.23	2.39		2.44	
PULL #3	2.19	2.41		2.43	
PULL #4	2.22	2.37		2.47	
PULL #5	2.23	2.40		2.40	
TOTAL	11.26	12.00		12.19	
AVERAGE	2.25	2.40		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.00		
PULL #2	3.00	3.02		
PULL #3	3.02	3.03		
PULL #4	3.02	3.06		
PULL #5	3.04	3.04		
TOTAL	15.13	15.15		
AVERAGE	3.03	3.03		

	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	4.29	4.13		4.27
PULL #2	4.31	4.19		4.32
PULL #3	4.31	4.20		4.17
PULL #4	4.36	4.15		4.30
PULL #5	4.26	4.10		4.16
TOTAL	21.53	20.77		21.22
AVERAGE	4.31	4.15		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360899. __0

FILE DATE AND TIME: 05/25/2004 07:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.012
The Average Y Centroid of the Five Target Set:	-0.063
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.663
The Distance from POA to Centroid Target #1:	0.028
The Distance from Centroid Target #2 to Centroid Target #1:	0.208
The Distance from Centroid Target #3 to Centroid Target #1:	0.235
The Distance from Centroid Target #4 to Centroid Target #1:	0.058
The Distance from Centroid Target #5 to Centroid Target #1:	0.054

BARBER - M24 0083384

SERIAL NUMBER: G6360899. __0

TARGET NUMBER: 1

FILE DATE: 05/25/2004

FILE TIME: 07:01

POINT#	X	Y
1:	0.851	-0.311
2:	0.628	-0.267
3:	-0.127	-0.651
4:	-0.652	-0.214
5:	0.116	0.806
6:	-0.623	0.759
7:	0.025	0.190
8:	-0.167	0.125
9:	0.041	-0.162
10:	-0.131	-0.002

X CENTROID: -0.004

Y CENTROID: 0.027

POA TO CENTROID: 0.028

HORZ SPREAD: 1.503

VERT SPREAD: 1.457

GROUP SPREAD: 1.821

MIN RADIUS: 0.130

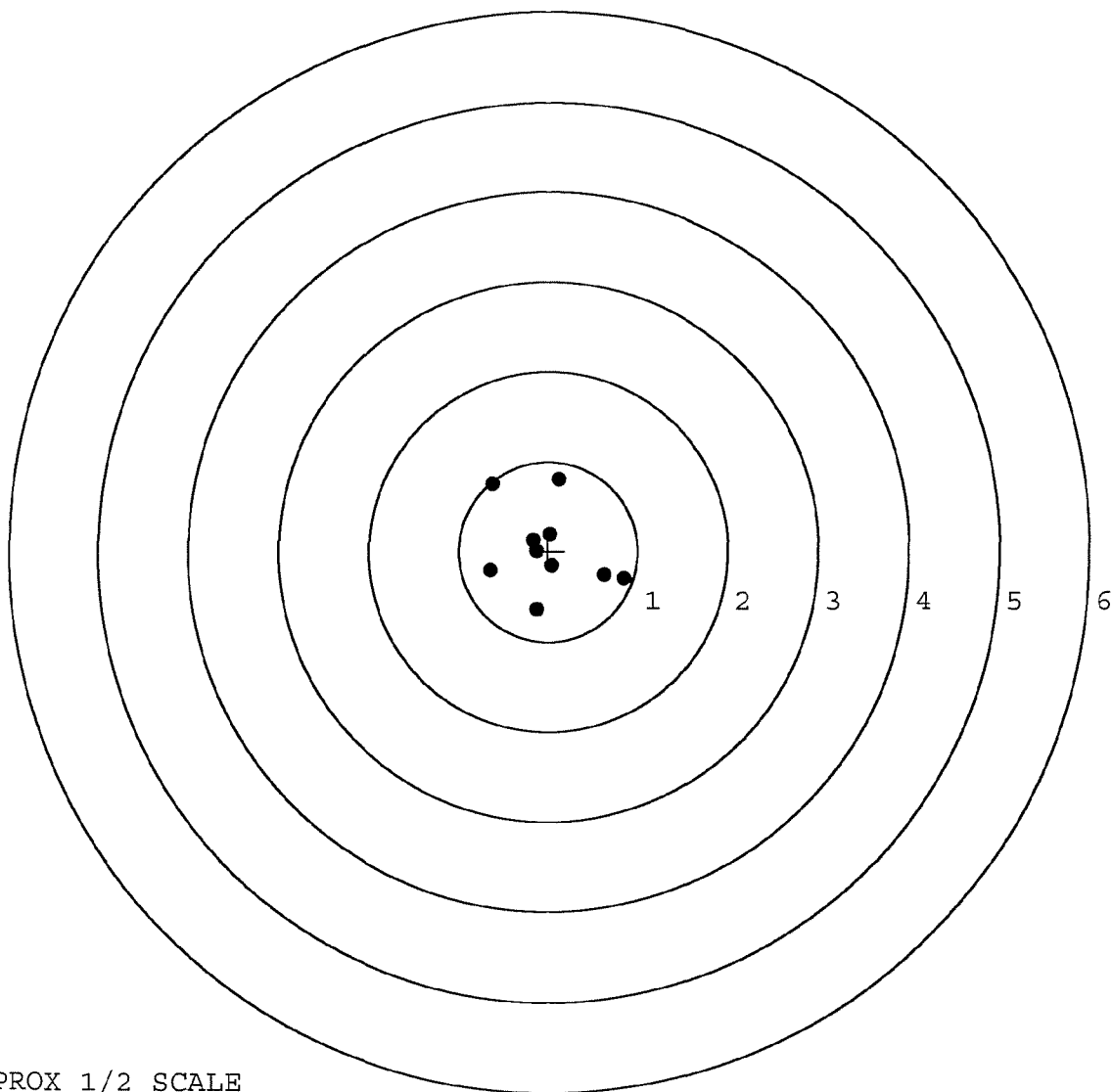
MAX RADIUS: 0.958

MEAN RADIUS: 0.542

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



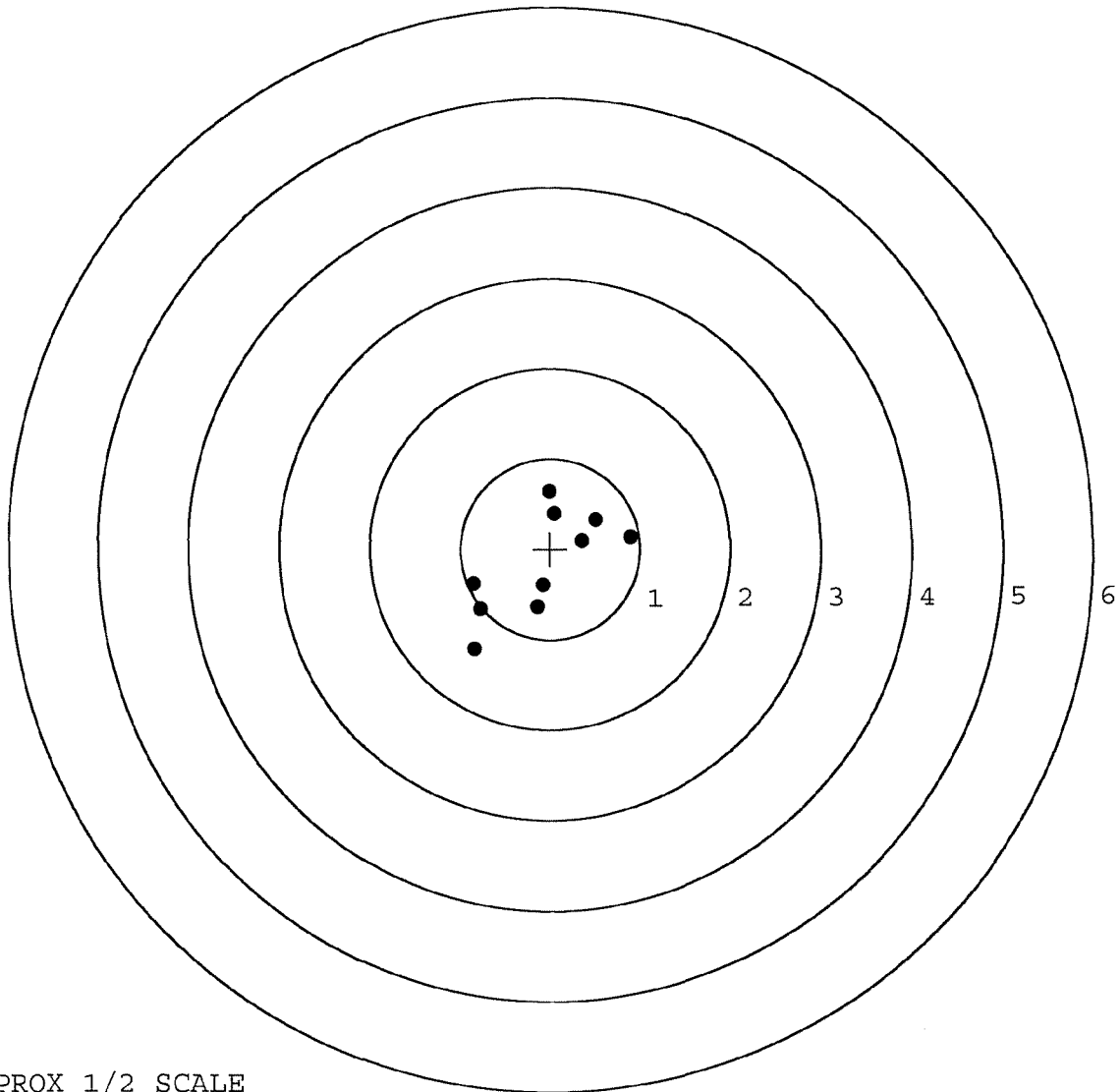
TARGET APPROX 1/2 SCALE

BARBER - M24 0083385

SERIAL NUMBER: G6360899. __0
 TARGET NUMBER: 2
 FILE DATE: 05/25/2004
 FILE TIME: 07:01

POINT#	X	Y
1:	0.899	0.133
2:	0.517	0.326
3:	0.359	0.091
4:	0.054	0.388
5:	0.002	0.636
6:	-0.085	-0.402
7:	-0.145	-0.646
8:	-0.855	-0.385
9:	-0.786	-0.664
10:	-0.851	-1.104

X CENTROID: -0.089
 Y CENTROID: -0.163
 POA TO CENTROID: 0.185
 HORZ SPREAD: 1.754
 VERT SPREAD: 1.740
 GROUP SPREAD: 2.143
 MIN RADIUS: 0.239
 MAX RADIUS: 1.211
 MEAN RADIUS: 0.729
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360899. __0

TARGET NUMBER: 3

FILE DATE: 05/25/2004

FILE TIME: 07:01

POINT#	X	Y
1:	1.019	-1.158
2:	0.773	-1.180
3:	-1.063	-0.030
4:	-0.528	-0.345
5:	-0.266	-0.693
6:	0.107	-0.383
7:	-0.046	-0.101
8:	0.246	0.474
9:	0.328	0.805
10:	0.041	0.630

X CENTROID: 0.061

Y CENTROID: -0.198

POA TO CENTROID: 0.207

HORZ SPREAD: 2.082

VERT SPREAD: 1.985

GROUP SPREAD: 2.368

MIN RADIUS: 0.145

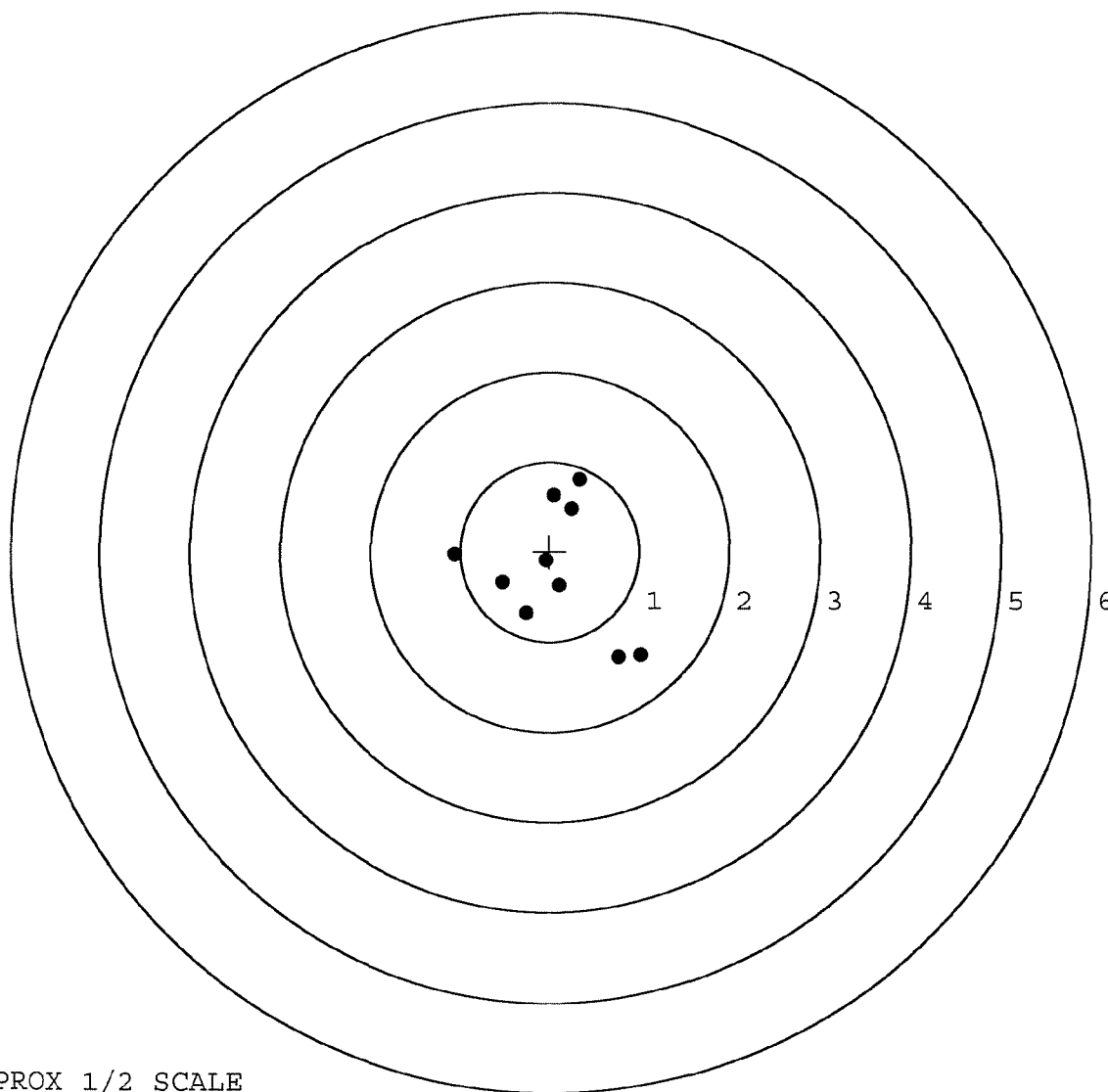
MAX RADIUS: 1.356

MEAN RADIUS: 0.780

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



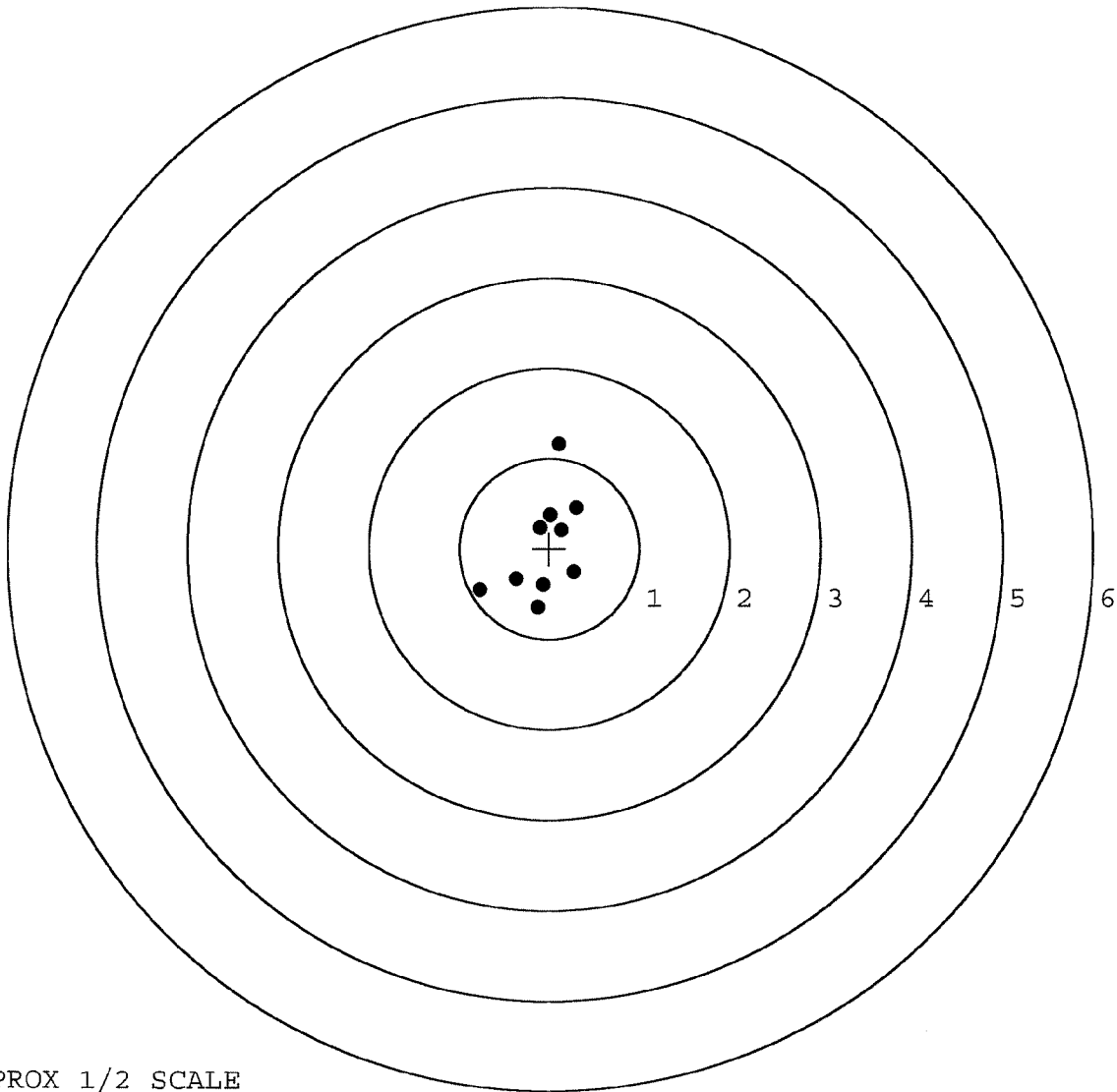
TARGET APPROX 1/2 SCALE

BARBER - M24 0083387

SERIAL NUMBER: G6360899. __0
 TARGET NUMBER: 4
 FILE DATE: 05/25/2004
 FILE TIME: 07:01

POINT#	X	Y
1:	0.110	1.158
2:	0.304	0.448
3:	0.134	0.202
4:	0.007	0.368
5:	-0.104	0.228
6:	-0.778	-0.455
7:	0.274	-0.266
8:	-0.368	-0.339
9:	-0.067	-0.404
10:	-0.127	-0.650

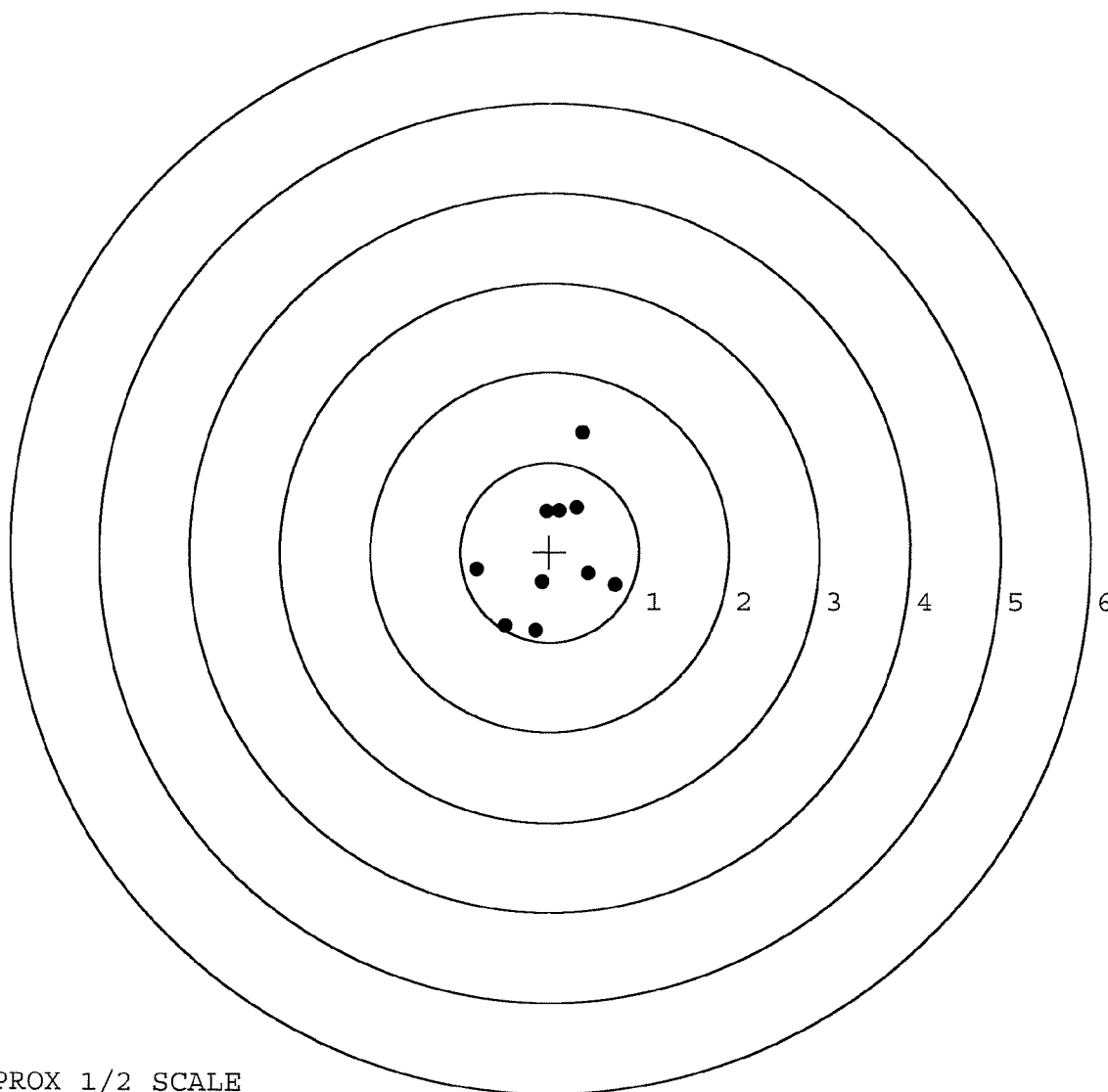
X CENTROID: -0.061
 Y CENTROID: 0.029
 POA TO CENTROID: 0.068
 HORZ SPREAD: 1.082
 VERT SPREAD: 1.808
 GROUP SPREAD: 1.841
 MIN RADIUS: 0.203
 MAX RADIUS: 1.142
 MEAN RADIUS: 0.541
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0083388

SERIAL NUMBER: G6360899. __0	POINT#	X	Y
TARGET NUMBER: 5	1:	0.734	-0.370
FILE DATE: 05/25/2004	2:	0.438	-0.242
FILE TIME: 07:01	3:	-0.083	-0.337
	4:	-0.155	-0.879
X CENTROID: 0.036	5:	-0.500	-0.823
Y CENTROID: -0.010	6:	-0.816	-0.196
POA TO CENTROID: 0.037	7:	-0.037	0.455
HORZ SPREAD: 1.550	8:	0.110	0.465
VERT SPREAD: 2.210	9:	0.300	0.498
GROUP SPREAD: 2.322	10:	0.368	1.331
MIN RADIUS: 0.348			
MAX RADIUS: 1.381			
MEAN RADIUS: 0.724			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE