

G6410500

ORDER 25716

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

UPC



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UPC



SERIAL NO.



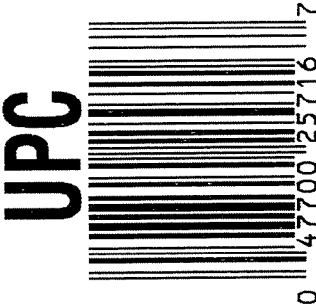
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6410500



DD FORM

Original
14
4/7/2005 2:48:09 PM
Crib

25716

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



.MA25716

Shop Order: SW5716 - APR



.ABSW5716 - APR

Start Date: 3/11/2005

Finish Date: 4/14/2005

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0003858612

0540

Flat Black Powder Coat, Barrel and

01PC001



0003858602

0560

Reassemble Action.

89SWS1



0003858603

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL6410500

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTZ
600	PROOF		1-25-05	A
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	1-25-05	A
610	DIS-ASSEMBLE GUN		1-26-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 26 2005 OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRC
620	APPLY COATINGS (BARREL ACTION)		1/31/05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		2-1-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-1-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-1-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		4-22-05	RTZ
	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	<u>5 lbs</u> <u>5 lbs</u> <u>5 lbs</u>	5-23-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		5-20-05	AC
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	5-23-05	AC
	J) ASSEMBLE STOCK		4-22-05	RTL
	K) ASSEMBLE SWIVEL STUDS		5-23-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-22-05	RTL
	M) IRON SIGHT ALIGNMENT		4-22-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-22-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	4-27-05	AC
	MALFUNCTION <i>BAC</i>	CORRECTION 5-2-05 OK	4-27-05	AC
	MALFUNCTION <i>CH</i>	CORRECTION 5-2-05 OK	4-27-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		4-27-05	TRLW
655	FINAL INSPECTION A) HEADSPACE		5-23-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.98</u> <u>2.79</u> <u>2.78</u> <u>2.86</u> <u>2.88</u>	5-9-05	TRLW
	C) FUNCTION		5-23-05	AC
660	PACK		5-25-05	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

SERIAL NO. _____

2.50 LBS (plus or minus 0.50 LBS)

DATE 4-14-05

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRLW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.22	2.56		2.33	
PULL #2	2.45	2.38		2.29	
PULL #3	2.17	2.13		2.28	
PULL #4	2.46	2.33		2.18	
PULL #5	2.57	2.35		2.28	
TOTAL				11.36	
AVERAGE				2.27	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.04		
PULL #2	3.08	3.21		
PULL #3	3.13	3.22		
PULL #4	3.11	3.13		
PULL #5	3.07	3.13		
TOTAL	15.47	15.73		
AVERAGE	3.09	3.14		

	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	4.04		4.19
PULL #2	4.01	4.02		4.20
PULL #3	4.17	3.98		4.21
PULL #4	4.01	4.01		4.15
PULL #5	4.03	3.93		4.09
TOTAL	20.24	19.98		20.84
AVERAGE	4.04	3.99		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410500.__2

FILE DATE AND TIME: 04/28/2005 11:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

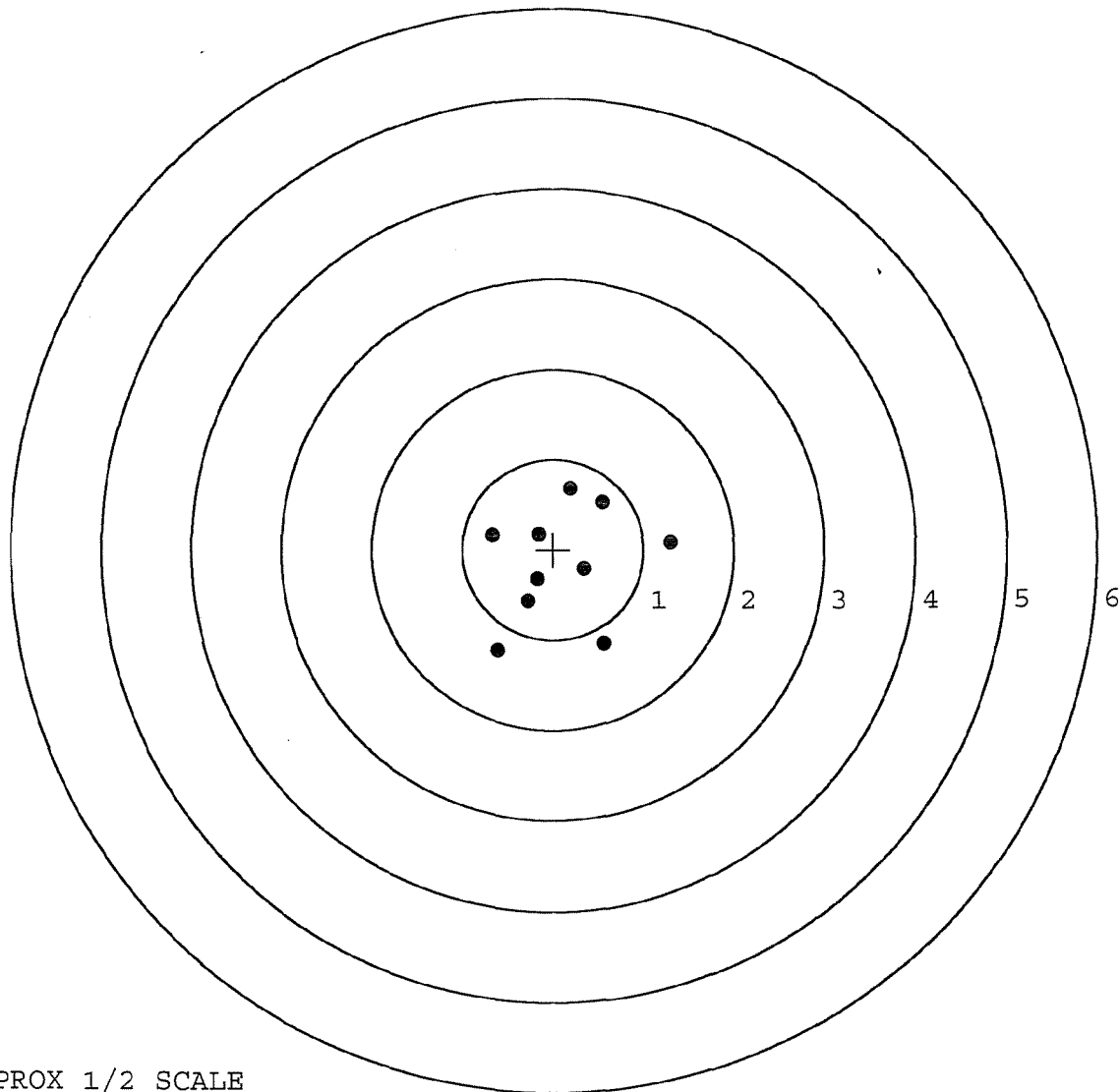
The Average X Centroid of the Five Target Set:	0.060
The Average Y Centroid of the Five Target Set:	-0.044
The Average Point of Impact of the Five Target Set:	0.075
The Average Mean Radius of the Five Target Set:	0.838
The Distance from POA to Centroid Target #1:	0.196
The Distance from Centroid Target #2 to Centroid Target #1:	0.396
The Distance from Centroid Target #3 to Centroid Target #1:	0.249
The Distance from Centroid Target #4 to Centroid Target #1:	0.172
The Distance from Centroid Target #5 to Centroid Target #1:	0.105

BARBER - M24 0150255

SERIAL NUMBER: G6410500. __2
 TARGET NUMBER: 1
 FILE DATE: 04/28/2005
 FILE TIME: 11:33

X CENTROID: 0.103
 Y CENTROID: -0.167
 POA TO CENTROID: 0.196
 HORZ SPREAD: 1.979
 VERT SPREAD: 1.791
 GROUP SPREAD: 2.258
 MIN RADIUS: 0.248
 MAX RADIUS: 1.226
 MEAN RADIUS: 0.747
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.163	0.167
2:	0.345	-0.219
3:	-0.177	-0.329
4:	-0.286	-0.572
5:	-0.613	-1.114
6:	0.555	-1.042
7:	1.303	0.080
8:	-0.676	0.154
9:	0.191	0.677
10:	0.546	0.523



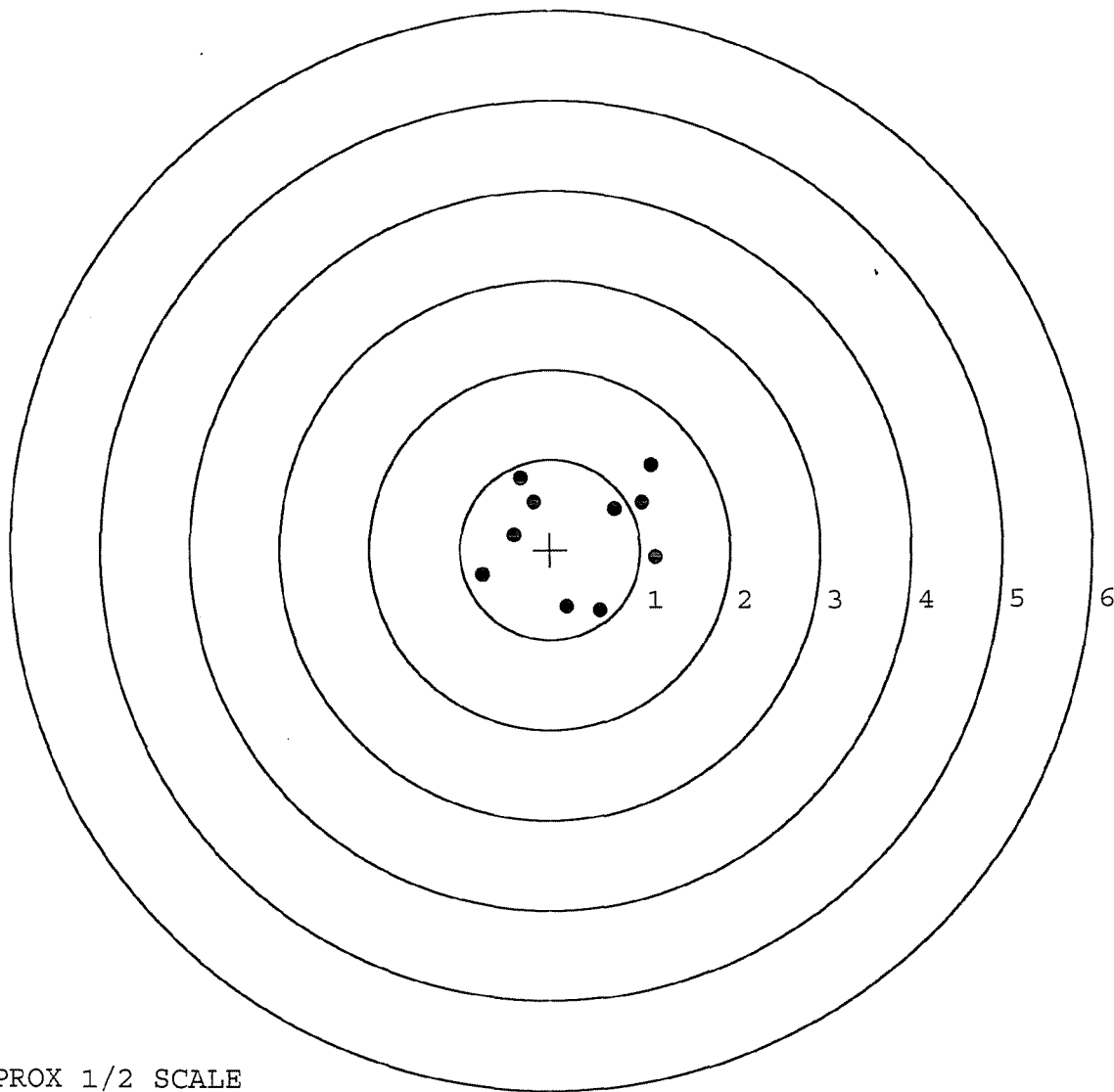
TARGET APPROX 1/2 SCALE

BARBER - M24 0150256

SERIAL NUMBER: G6410500. __ 2
 TARGET NUMBER: 2
 FILE DATE: 04/28/2005
 FILE TIME: 11:33

X CENTROID: 0.306
 Y CENTROID: 0.172
 POA TO CENTROID: 0.351
 HORZ SPREAD: 1.917
 VERT SPREAD: 1.617
 GROUP SPREAD: 2.238
 MIN RADIUS: 0.493
 MAX RADIUS: 1.151
 MEAN RADIUS: 0.839
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.182	-0.640
2:	0.547	-0.675
3:	1.167	-0.086
4:	0.711	0.454
5:	1.018	0.527
6:	1.122	0.942
7:	-0.188	0.531
8:	-0.338	0.795
9:	-0.750	-0.285
10:	-0.412	0.160



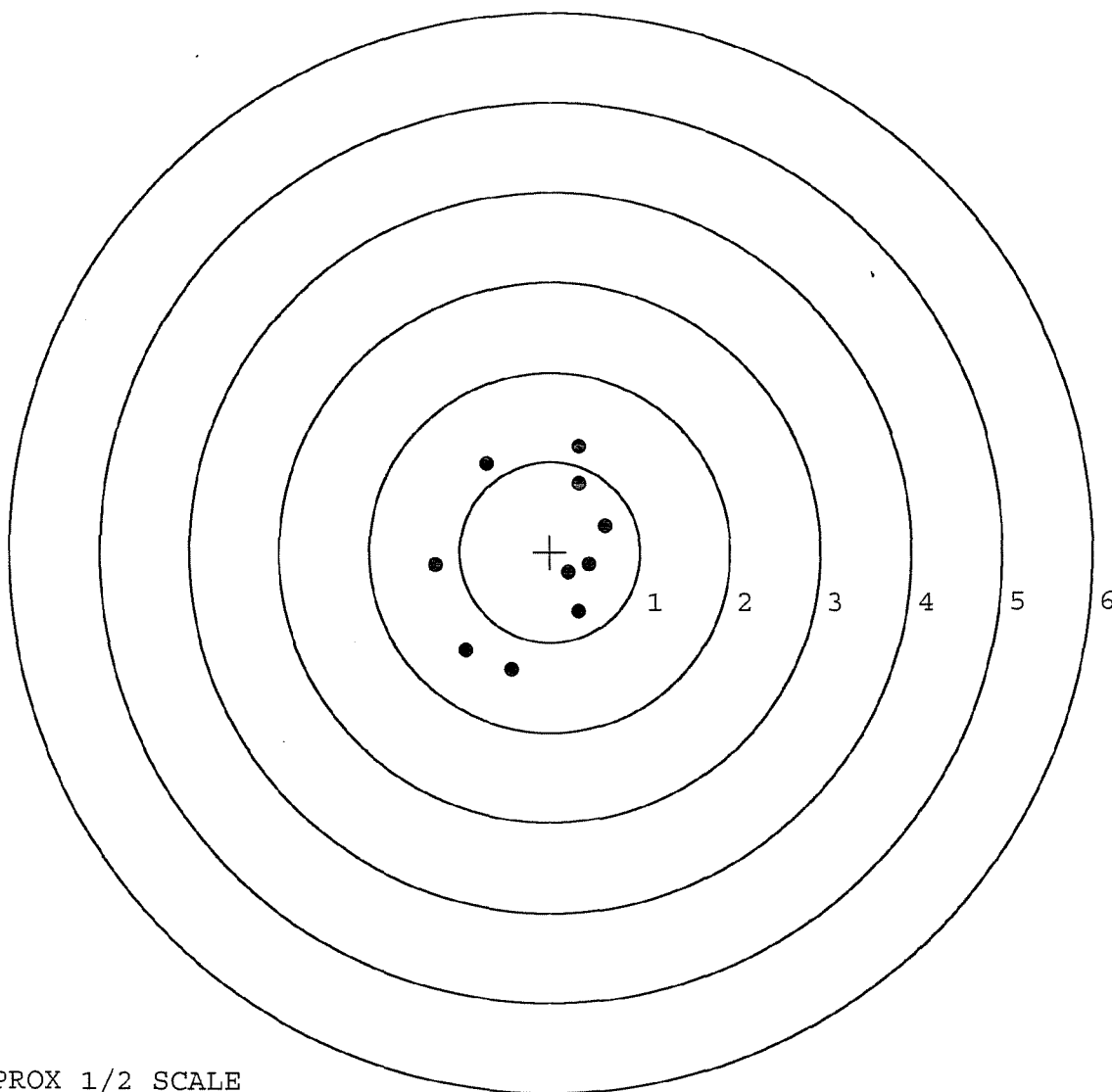
TARGET APPROX 1/2 SCALE

BARBER - M24 0150257

SERIAL NUMBER: G6410500. __2
 TARGET NUMBER: 3
 FILE DATE: 04/28/2005
 FILE TIME: 11:33

POINT#	X	Y
1:	0.437	-0.146
2:	0.206	-0.233
3:	0.319	-0.663
4:	0.607	0.288
5:	0.323	0.754
6:	0.325	1.170
7:	-0.704	0.975
8:	-1.271	-0.153
9:	-0.928	-1.097
10:	-0.427	-1.301

X CENTROID: -0.111
 Y CENTROID: -0.041
 POA TO CENTROID: 0.118
 HORZ SPREAD: 1.878
 VERT SPREAD: 2.471
 GROUP SPREAD: 2.590
 MIN RADIUS: 0.371
 MAX RADIUS: 1.335
 MEAN RADIUS: 0.964
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 10



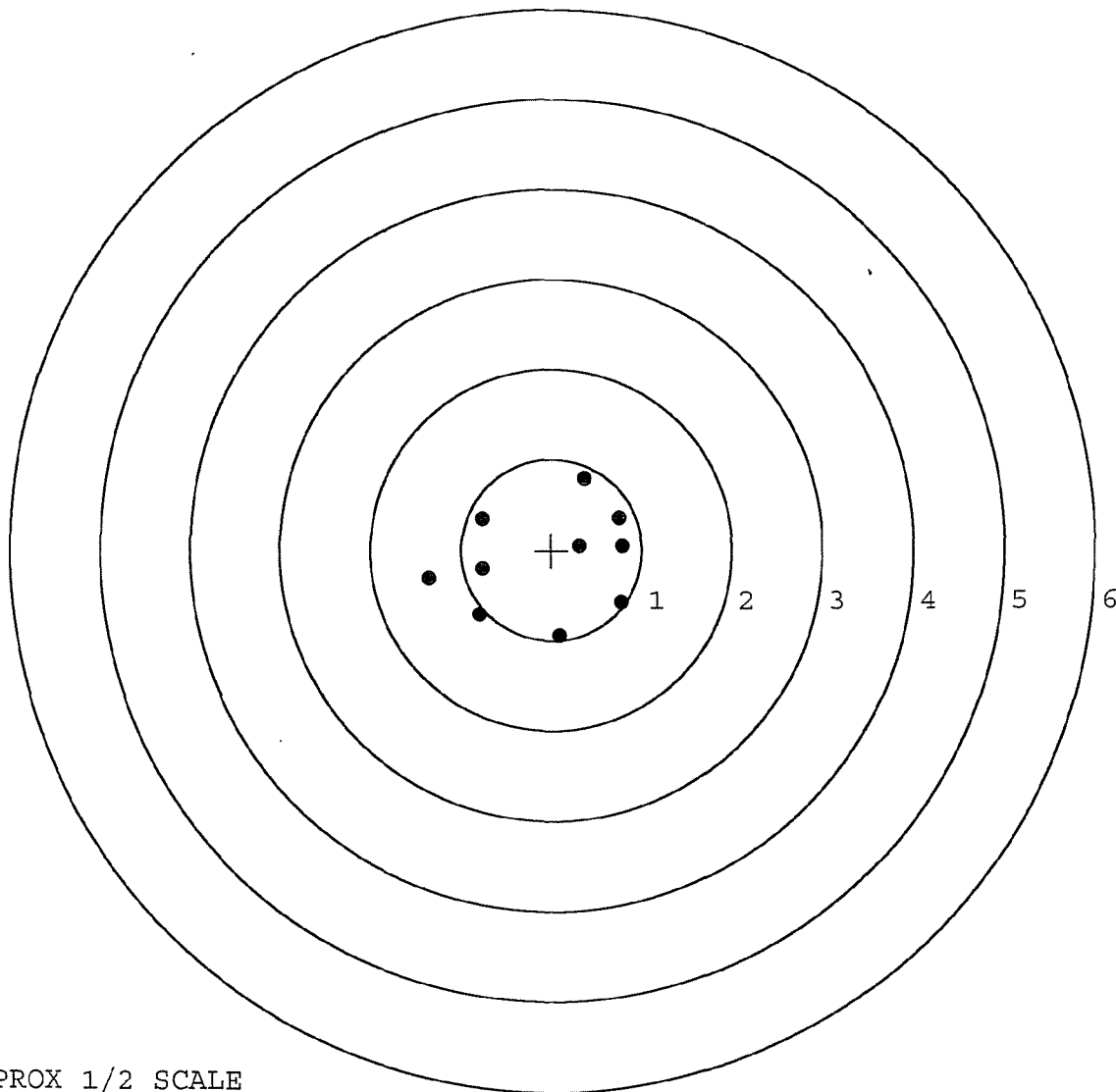
TARGET APPROX 1/2 SCALE

BARBER - M24 0150258

SERIAL NUMBER: G6410500. __2
 TARGET NUMBER: 4
 FILE DATE: 04/28/2005
 FILE TIME: 11:33

POINT#	X	Y
1:	0.308	0.051
2:	0.783	0.049
3:	0.745	0.357
4:	0.365	0.790
5:	-0.770	0.346
6:	-0.763	-0.209
7:	-1.358	-0.317
8:	-0.794	-0.715
9:	0.090	-0.949
10:	0.773	-0.574

X CENTROID: -0.062
 Y CENTROID: -0.117
 POA TO CENTROID: 0.133
 HORZ SPREAD: 2.141
 VERT SPREAD: 1.739
 GROUP SPREAD: 2.208
 MIN RADIUS: 0.406
 MAX RADIUS: 1.311
 MEAN RADIUS: 0.881
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



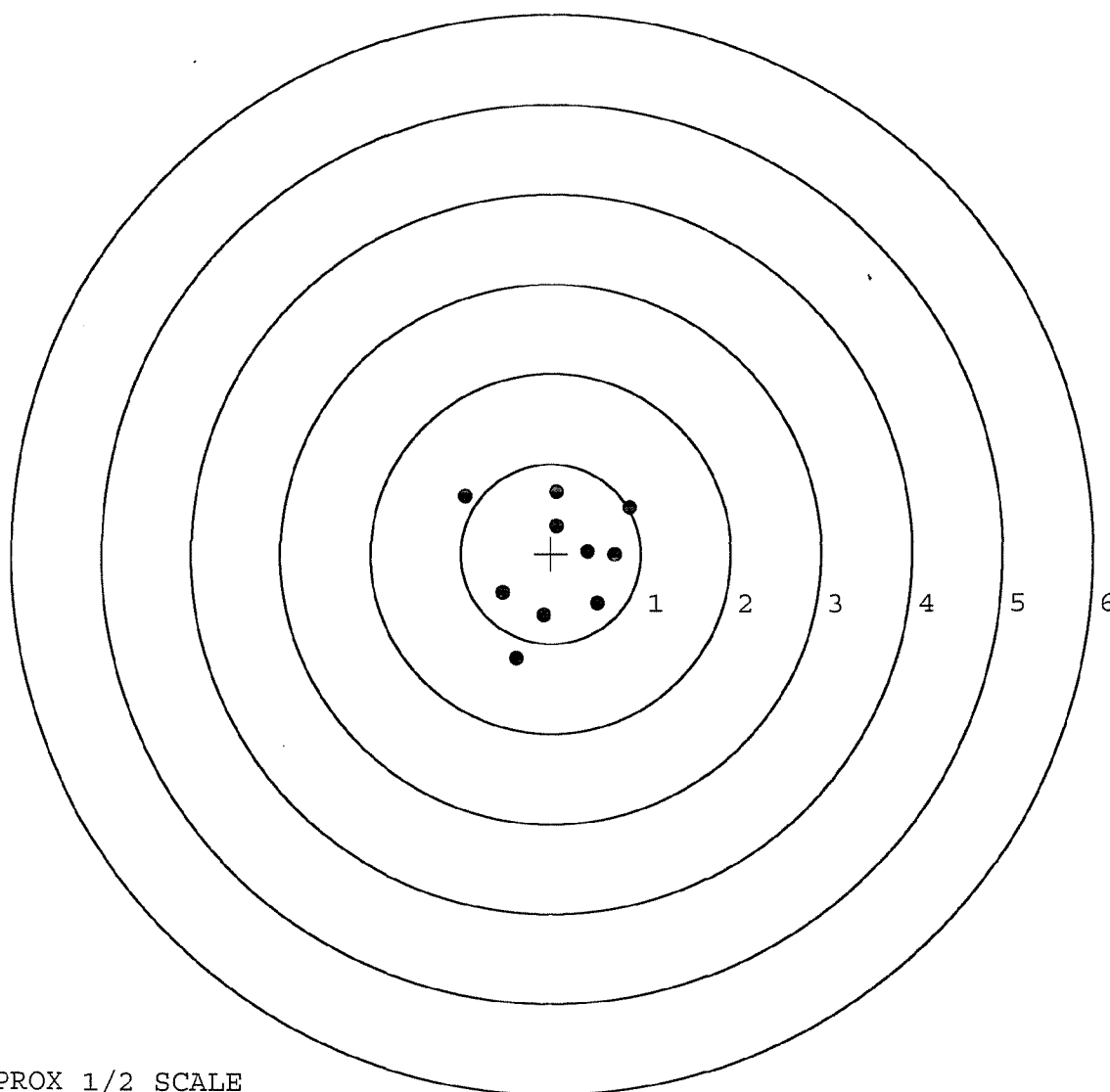
TARGET APPROX 1/2 SCALE

BARBER - M24 0150259

SERIAL NUMBER: G6410500. __2
 TARGET NUMBER: 5
 FILE DATE: 04/28/2005
 FILE TIME: 11:33

POINT#	X	Y
1:	0.409	0.023
2:	0.054	0.308
3:	0.056	0.692
4:	0.877	0.519
5:	-0.959	0.643
6:	-0.539	-0.440
7:	-0.085	-0.689
8:	-0.393	-1.173
9:	0.514	-0.558
10:	0.712	-0.020

X CENTROID: 0.065
 Y CENTROID: -0.069
 POA TO CENTROID: 0.095
 HORZ SPREAD: 1.836
 VERT SPREAD: 1.865
 GROUP SPREAD: 1.902
 MIN RADIUS: 0.357
 MAX RADIUS: 1.247
 MEAN RADIUS: 0.760
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE