

G 646 1612

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**

G6461612



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.



6/17/2005 2:12:04 PM

Crib

27

Original

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004012773

0540

01PC001

Flat Black Powder Coat, Barrel and



0004012763

0560

89SWS1

Reassemble Action.



0004012764

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 60461612

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTZ
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTZ
470	DIS-ASSEMBLE ACTION		9-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 SENSOR null	9/8/05	unob
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	unob
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9/22/05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/22/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/22/05	DA
	D) OIL FIRING PIN ASSEMBLY		9-27-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP # OPERATION NAME		READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 lbs</u>	<u>6 lbs</u>	<u>6 lbs</u>	10-11-05	Ac		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u>	<u>2 lbs</u>	<u>2 lbs</u>	10-11-05	Ac		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT .020 MIN	<u>.025</u>	<u>.025</u>	<u>.025</u>	10-11-05	Ac		
	J) ASSEMBLE STOCK				9-27-05	RTL		
	K) ASSEMBLE SWIVEL STUDS				10-11-05	Ac		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				9-28-05	RTL		
	M) IRON SIGHT ALIGNMENT				9-28-05	RTL		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				9-28-05	RTL		
640 & 650	FUNCTION TEST AND TARGET	PASS	FAIL		10/4/05	mfg		
	<i>Feeds Hard from Mag</i> MALFUNCTION	PASS	FAIL					
	MALFUNCTION	CORRECTION	<u>OK</u>		10-6-05	TRW		
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION		<u>N/A</u>				
	MALFUNCTION	CORRECTION						
660	INSPECT FOR LIVE AMMO				10/4/05	mm		
670	FINAL INSPECTION A) HEADSPACE				10-11-05	Ac		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.92</u>	<u>2.67</u>	<u>2.89</u>	<u>2.90</u>	<u>2.87</u>	10-7-05	BG
	C) FUNCTION				10-11-05	Ac		
690	PACK				10-12-05	RA		

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

TESTER

9/21/05

RG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.20	2.20	2.58	
PULL #2	2.54	2.39	2.65	
PULL #3	2.56	2.16	2.75	
PULL #4	2.06	2.69	2.73	
PULL #5	2.60	2.33	2.76	
TOTAL	11.96	11.77	13.47	
AVERAGE	2.39	2.35	2.69	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.22	3.04	
PULL #2	3.34	3.16	
PULL #3	3.30	3.19	
PULL #4	3.47	3.25	
PULL #5	3.29	3.11	
TOTAL	16.62	15.75	
AVERAGE	3.32	3.15	

	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	4.18	4.19		4.41
PULL #2	4.21	4.40		3.95
PULL #3	4.22	4.34		4.39
PULL #4	4.42	4.46		4.33
PULL #5	4.32	4.58		4.18
TOTAL	21.35	21.97		21.26
AVERAGE	4.27	4.39		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461612.__0
FILE DATE AND TIME: 10/04/2005 18:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.116
The Average Y Centroid of the Five Target Set:	0.090
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	1.042
The Distance from POA to Centroid Target #1:	0.233
The Distance from Centroid Target #2 to Centroid Target #1:	0.996
The Distance from Centroid Target #3 to Centroid Target #1:	0.382
The Distance from Centroid Target #4 to Centroid Target #1:	0.359
The Distance from Centroid Target #5 to Centroid Target #1:	0.513

SERIAL NUMBER: G6461612. 0

TARGET NUMBER: 1

FILE DATE: 10/04/2005

FILE TIME: 18:29

X CENTROID: 0.178

Y CENTROID: -0.150

POA TO CENTROID: 0.233

HORZ SPREAD: 2.277

VERT SPREAD: 2.007

GROUP SPREAD: 2.463

MIN RADIUS: 0.198

MAX RADIUS: 1.455

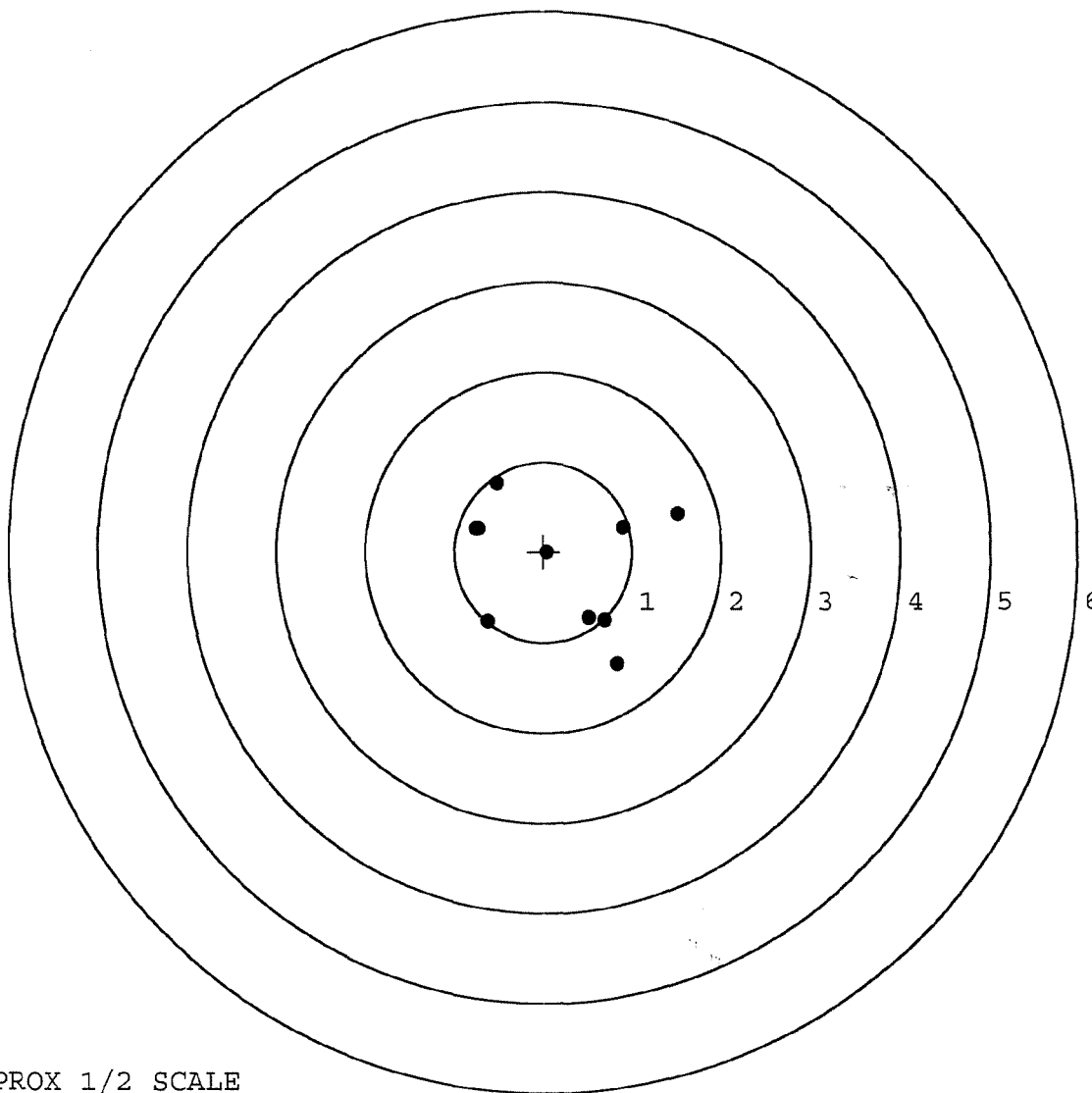
MEAN RADIUS: 0.943

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.766	0.263
2:	-0.531	0.770
3:	0.894	0.275
4:	1.511	0.432
5:	0.827	-1.237
6:	0.682	-0.760
7:	-0.637	-0.773
8:	0.037	-0.011
9:	0.505	-0.727
10:	-0.744	0.264



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. 0

TARGET NUMBER: 2

FILE DATE: 10/04/2005

FILE TIME: 18:29

POINT#	X	Y
1:	-0.818	0.932
2:	-1.318	1.602
3:	-0.534	1.579
4:	0.182	1.619
5:	0.043	1.334
6:	0.848	1.268
7:	0.470	0.899
8:	-0.146	-1.174
9:	-1.015	-0.790
10:	-1.181	-0.312

X CENTROID: -0.347

Y CENTROID: 0.696

POA TO CENTROID: 0.777

HORZ SPREAD: 2.166

VERT SPREAD: 2.793

GROUP SPREAD: 3.013

MIN RADIUS: 0.527

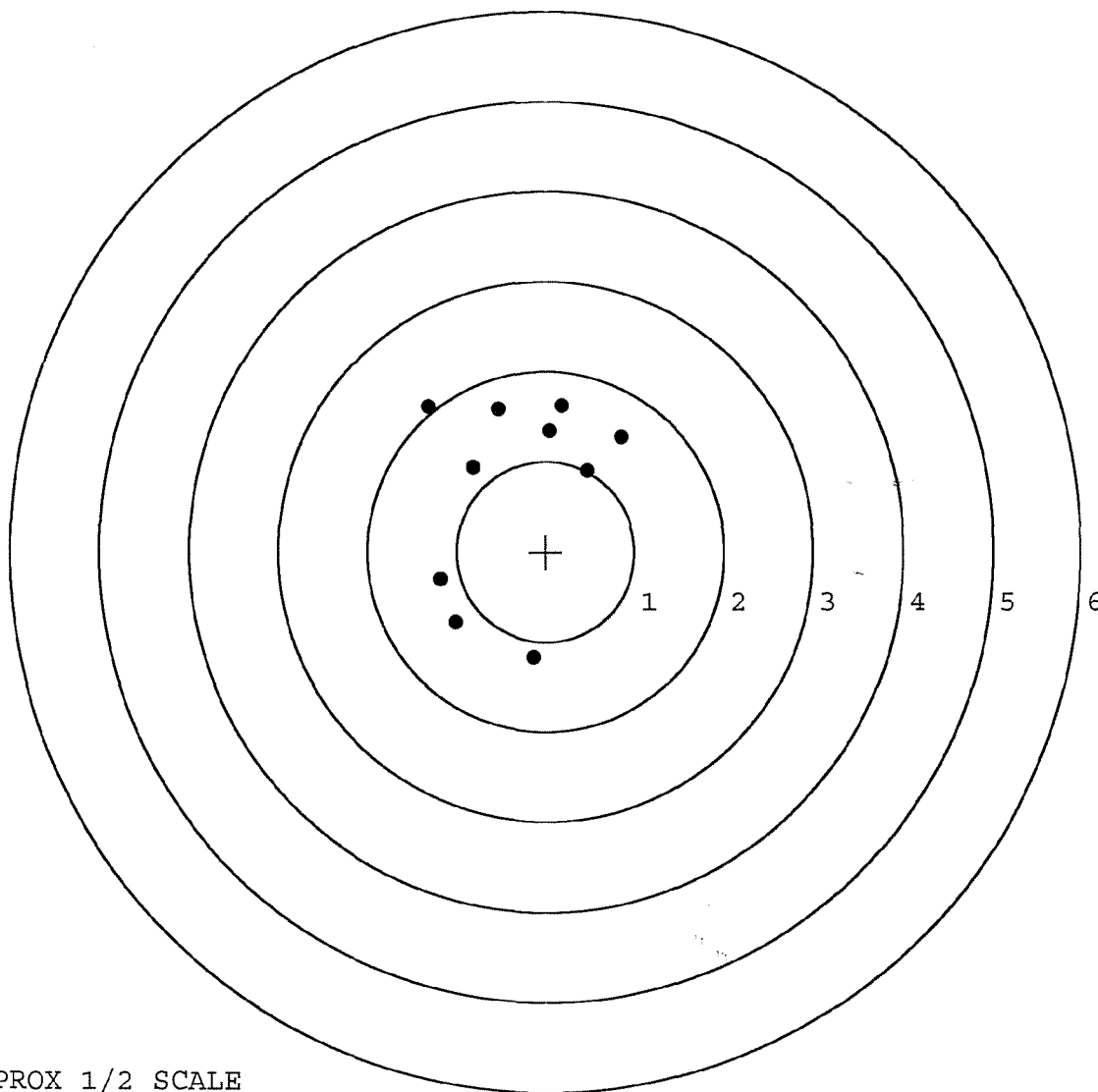
MAX RADIUS: 1.880

MEAN RADIUS: 1.155

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. __0

TARGET NUMBER: 3

FILE DATE: 10/04/2005

FILE TIME: 18:29

X CENTROID: 0.002

Y CENTROID: 0.189

POA TO CENTROID: 0.189

HORZ SPREAD: 1.664

VERT SPREAD: 2.812

GROUP SPREAD: 2.925

MIN RADIUS: 0.112

MAX RADIUS: 1.769

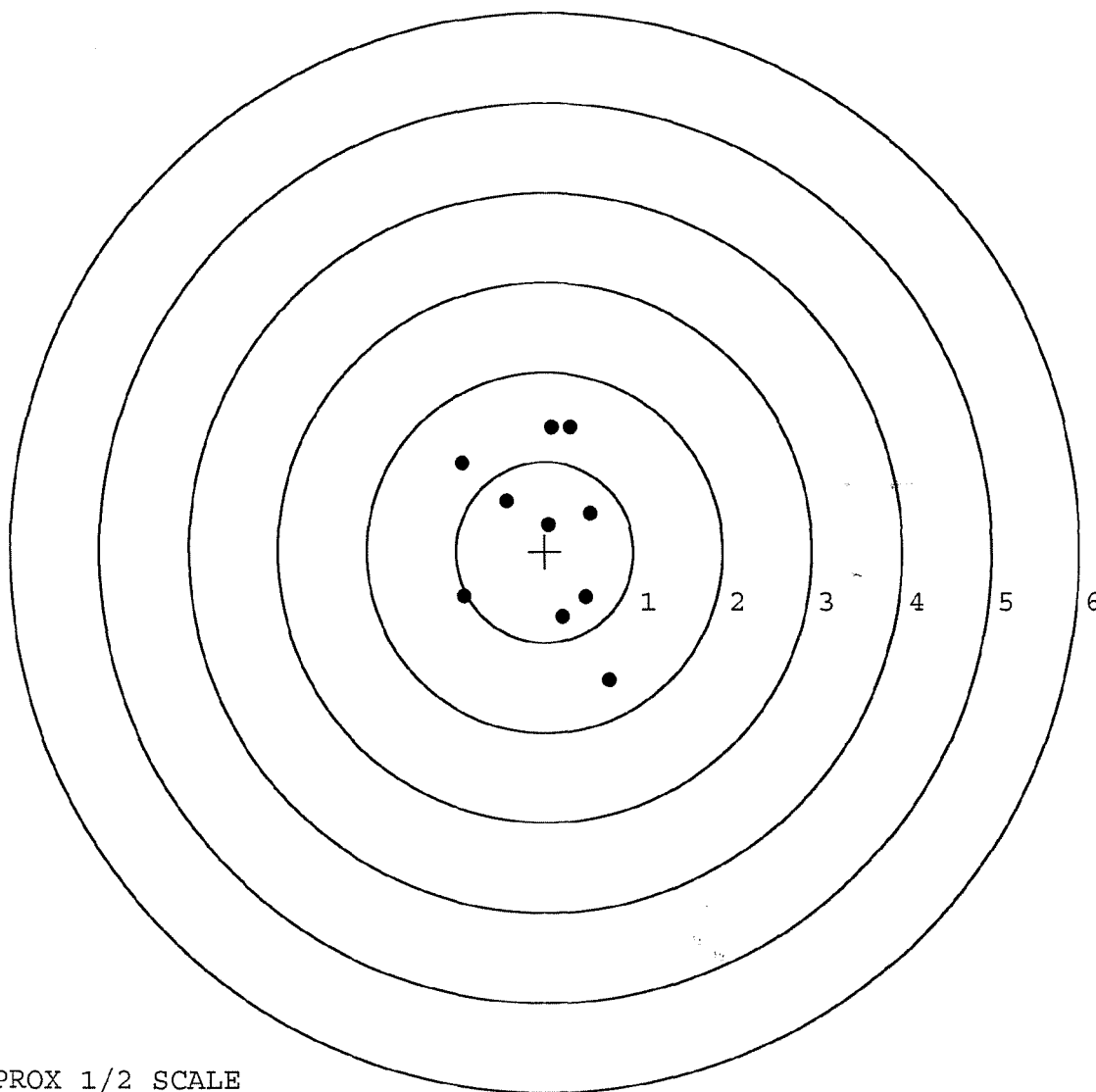
MEAN RADIUS: 0.957

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.035	0.296
2:	-0.440	0.555
3:	-0.932	0.984
4:	0.075	1.384
5:	0.291	1.390
6:	0.460	-0.502
7:	0.199	-0.722
8:	0.732	-1.422
9:	-0.909	-0.498
10:	0.507	0.423



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. 0

TARGET NUMBER: 4

FILE DATE: 10/04/2005

FILE TIME: 18:29

X CENTROID: -0.114

Y CENTROID: 0.058

POA TO CENTROID: 0.128

HORZ SPREAD: 2.388

VERT SPREAD: 2.647

GROUP SPREAD: 2.680

MIN RADIUS: 0.219

MAX RADIUS: 1.483

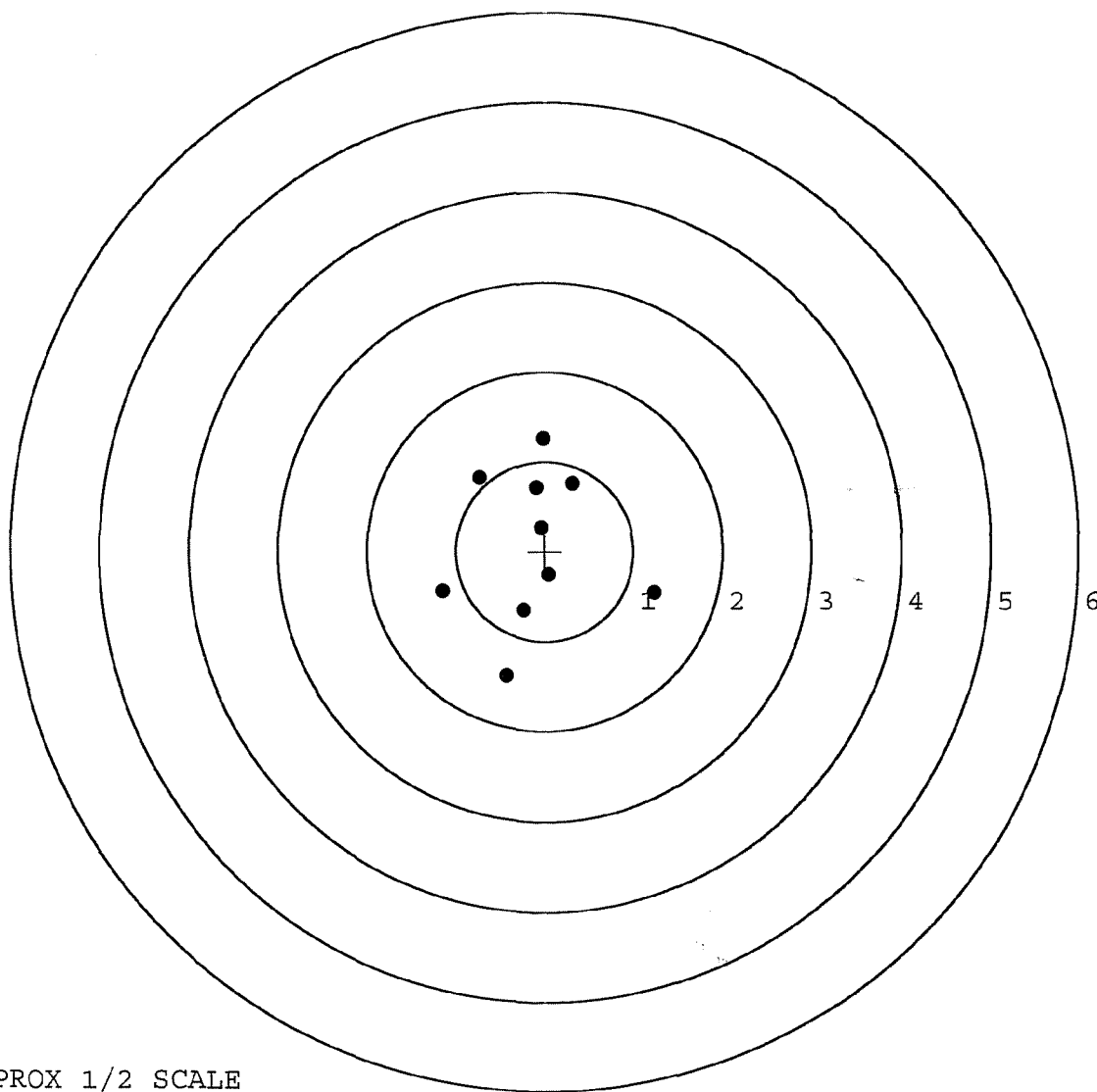
MEAN RADIUS: 0.905

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.041	-0.263
2:	-0.243	-0.660
3:	-1.152	-0.451
4:	-0.734	0.817
5:	-0.041	0.265
6:	-0.103	0.711
7:	0.312	0.757
8:	-0.022	1.258
9:	1.236	-0.463
10:	-0.439	-1.389



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. __0

TARGET NUMBER: 5

FILE DATE: 10/04/2005

FILE TIME: 18:29

POINT#	X	Y
1:	0.238	0.299
2:	-0.416	0.785
3:	-0.905	1.898
4:	-1.447	-0.421
5:	-2.214	-1.031
6:	-0.206	-1.449
7:	0.308	-0.943
8:	0.805	-1.401
9:	0.111	-0.515
10:	0.753	-0.667

X CENTROID: -0.297

Y CENTROID: -0.345

POA TO CENTROID: 0.455

HORZ SPREAD: 3.019

VERT SPREAD: 3.347

GROUP SPREAD: 3.716

MIN RADIUS: 0.442

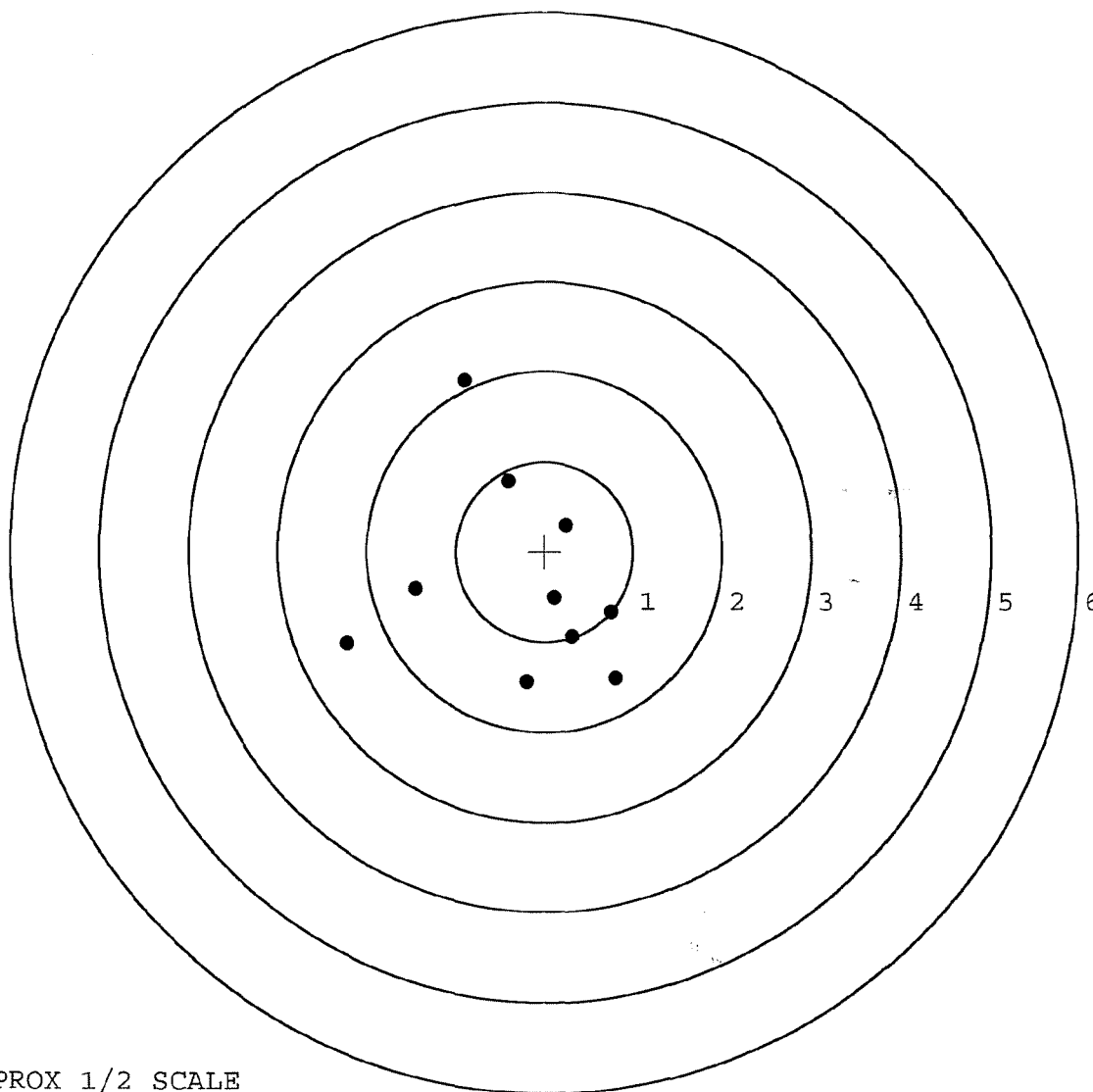
MAX RADIUS: 2.323

MEAN RADIUS: 1.251

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE