

G 646 1650

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



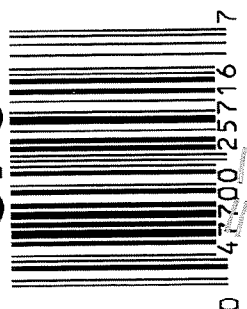
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461650

UPC



DD FORM

ORDER **25716**
M/24 7.62 NATO S.W.S. (COMPLETE SYST)

UPC



ORDER **25716**
M/24 7.62 NATO S.W.S. (COMPLETE SYST)

UPC



SERIAL NO.



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 # G64611050

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTL
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTL
470	DIS-ASSEMBLE ACTION		9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	9/8/05	umg
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/1/2	SS
530 & 540	APPLY COATINGS (BARREL ACTION)		9/1/7	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/21/05	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/21/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/21/05	DA
	D) OIL FIRING PIN ASSEMBLY		9-22-05	RTL
	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	6 lbs	6 lbs	6 lbs	10-3-05	Ac		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	3 lbs	3 lbs	3 lbs	10-3-05	Ac		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.026	.026	.026	10-3-05	Ac		
	J) ASSEMBLE STOCK					9-27-05	RTZ		
	K) ASSEMBLE SWIVEL STUDS					10-3-05	Ac		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					9-28-05	RTZ		
	M) IRON SIGHT ALIGNMENT					9-28-05	RTZ		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					9-28-05	RTZ		
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		9-29-05	TRW		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					10/29/05	SH		
670	FINAL INSPECTION A) HEADSPACE					10-3-05	Ac		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.51	2.35	2.45	2.35	2.56	10/3/05	FG
	C) FUNCTION					10-3-05	Ac		
690	PACK					10-7-05	DA		

BARBER - M24 0154307
 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

9/22/05

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.45	2.20	2.73	
PULL #2	2.56	2.65	2.69	
PULL #3	2.84	2.42	2.62	
PULL #4	2.68	2.79	2.64	
PULL #5	2.74	2.33	2.68	
TOTAL	13.27	12.19	13.36	
AVERAGE	2.65	2.44	2.67	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.28	3.39	
PULL #2	3.15	3.06	
PULL #3	3.14	3.50	
PULL #4	3.27	3.56	
PULL #5	3.08	3.35	
TOTAL	15.92	16.86	
AVERAGE	3.18	3.37	

	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	4.36	4.04		4.07
PULL #2	4.04	4.07		4.00
PULL #3	4.43	4.32		3.99
PULL #4	3.84	4.45		4.11
PULL #5	4.07	4.27		4.34
TOTAL	20.74	21.15		20.51
AVERAGE	4.15	4.23		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461650.__0
FILE DATE AND TIME: 09/29/2005 11:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.032
The Average Y Centroid of the Five Target Set:	-0.039
The Average Point of Impact of the Five Target Set:	0.051
The Average Mean Radius of the Five Target Set:	1.110
The Distance from POA to Centroid Target #1:	0.347
The Distance from Centroid Target #2 to Centroid Target #1:	1.115
The Distance from Centroid Target #3 to Centroid Target #1:	0.441
The Distance from Centroid Target #4 to Centroid Target #1:	0.280
The Distance from Centroid Target #5 to Centroid Target #1:	0.469

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 1

FILE DATE: 09/29/2005

FILE TIME: 11:25

X CENTROID: 0.055

Y CENTROID: -0.342

POA TO CENTROID: 0.347

HORZ SPREAD: 2.473

VERT SPREAD: 2.495

GROUP SPREAD: 3.166

MIN RADIUS: 0.227

MAX RADIUS: 1.803

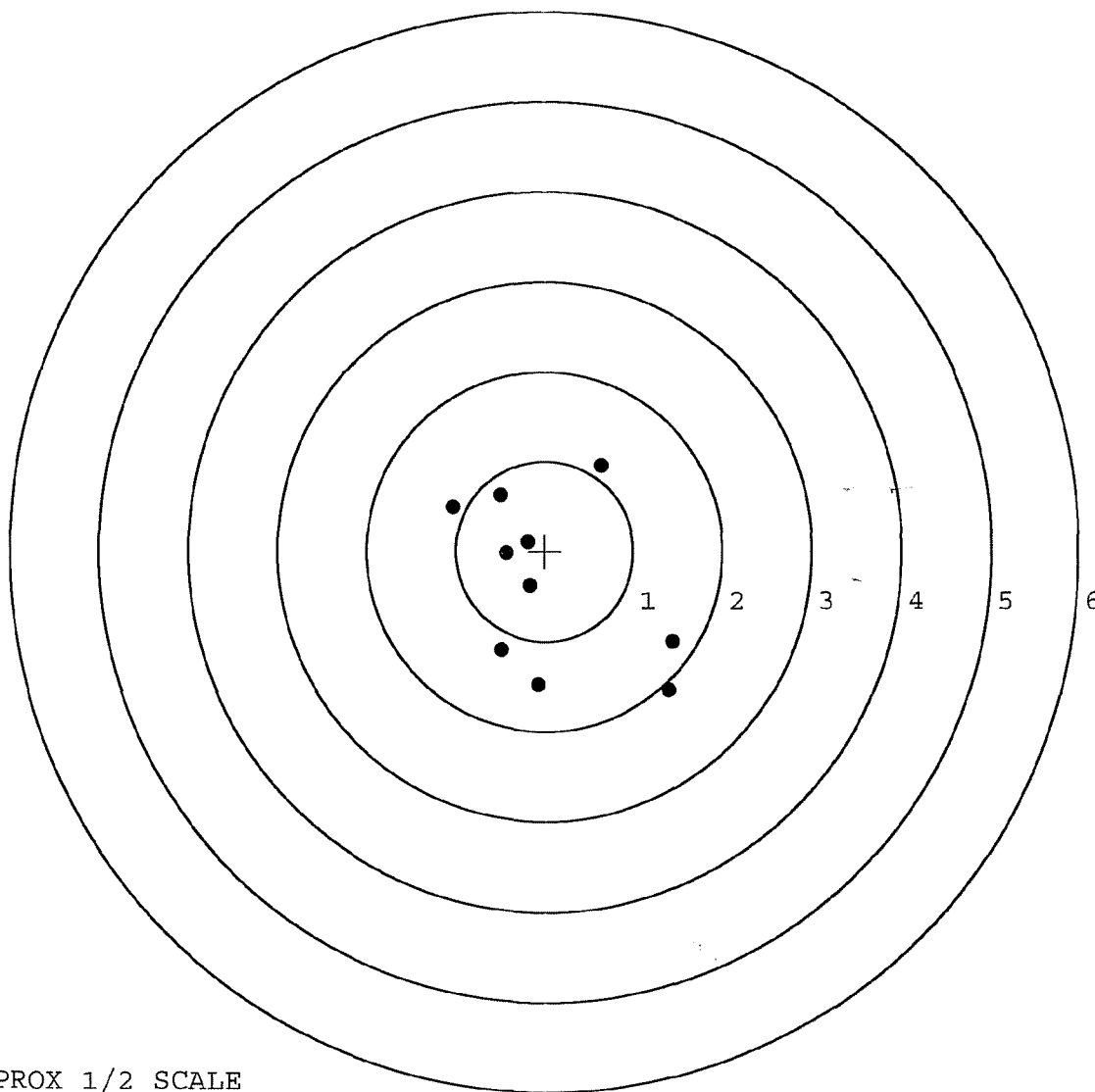
MEAN RADIUS: 1.065

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.395	-1.548
2:	1.437	-1.012
3:	-0.084	-1.491
4:	-0.497	-1.104
5:	-0.168	-0.386
6:	-0.436	-0.033
7:	-0.189	0.106
8:	-1.036	0.481
9:	-0.505	0.619
10:	0.635	0.947



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 2

FILE DATE: 09/29/2005

FILE TIME: 11:25

POINT#	X	Y
1:	2.246	0.017
2:	1.629	1.501
3:	0.500	2.363
4:	0.562	3.177
5:	0.825	-0.861
6:	0.301	0.529
7:	-0.280	0.787
8:	-0.727	0.086
9:	-0.190	-0.760
10:	-1.661	0.572

X CENTROID: 0.320

Y CENTROID: 0.741

POA TO CENTROID: 0.807

HORZ SPREAD: 3.907

VERT SPREAD: 4.038

GROUP SPREAD: 4.047

MIN RADIUS: 0.213

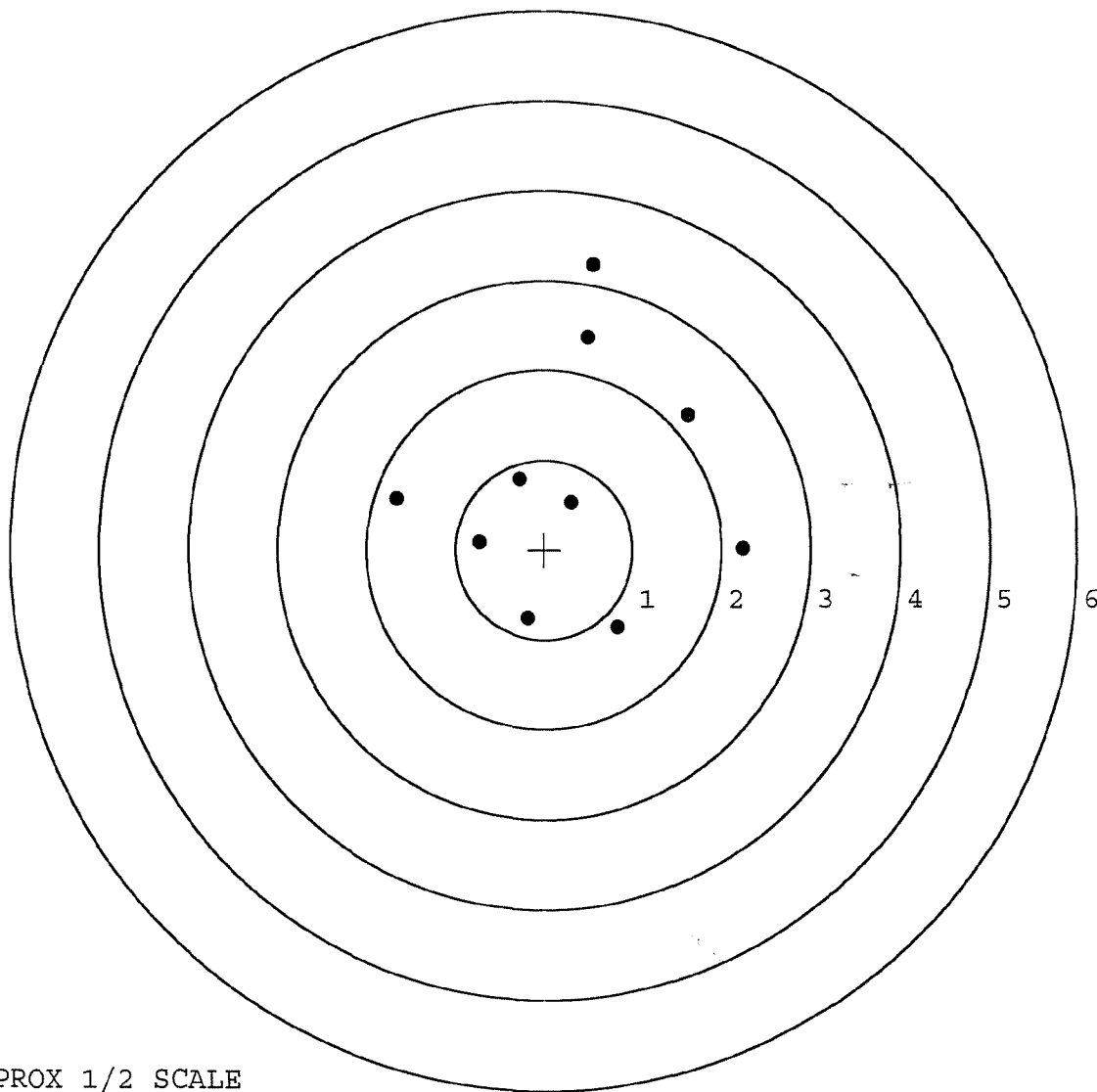
MAX RADIUS: 2.448

MEAN RADIUS: 1.495

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 3



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 3

FILE DATE: 09/29/2005

FILE TIME: 11:25

X CENTROID: -0.316

Y CENTROID: -0.581

POA TO CENTROID: 0.661

HORZ SPREAD: 2.314

VERT SPREAD: 3.406

GROUP SPREAD: 4.029

MIN RADIUS: 0.463

MAX RADIUS: 2.319

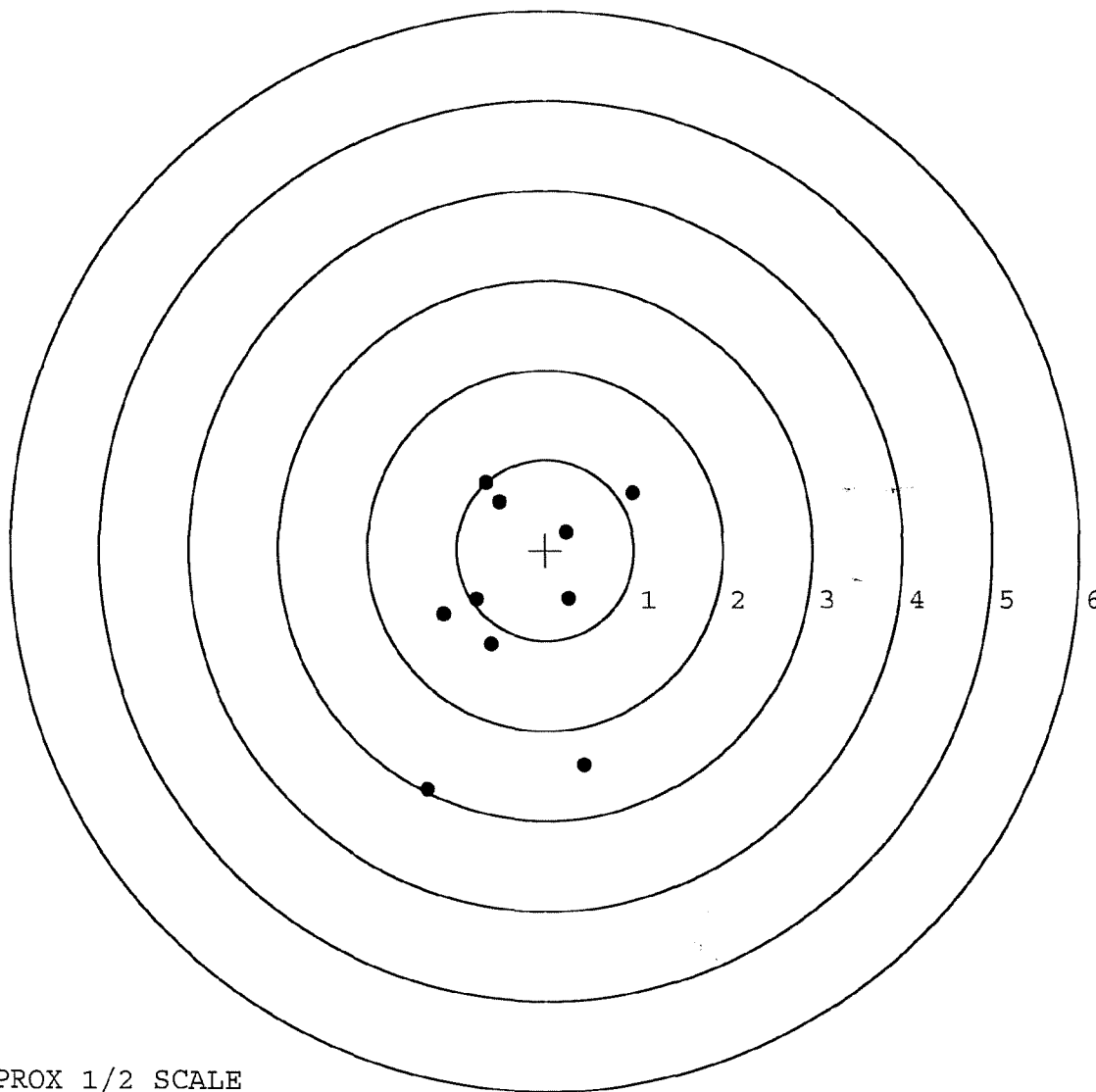
MEAN RADIUS: 1.194

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.434	-2.385
2:	-1.332	-2.665
3:	-0.620	-1.047
4:	-1.147	-0.717
5:	-0.778	-0.552
6:	0.264	-0.539
7:	0.228	0.194
8:	0.982	0.633
9:	-0.521	0.532
10:	-0.670	0.741



TARGET APPROX 1/2 SCALE

BARBER - M24 0154312

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 4

FILE DATE: 09/29/2005

FILE TIME: 11:25

X CENTROID: -0.046

Y CENTROID: -0.081

POA TO CENTROID: 0.093

HORZ SPREAD: 2.664

VERT SPREAD: 4.030

GROUP SPREAD: 4.177

MIN RADIUS: 0.438

MAX RADIUS: 2.277

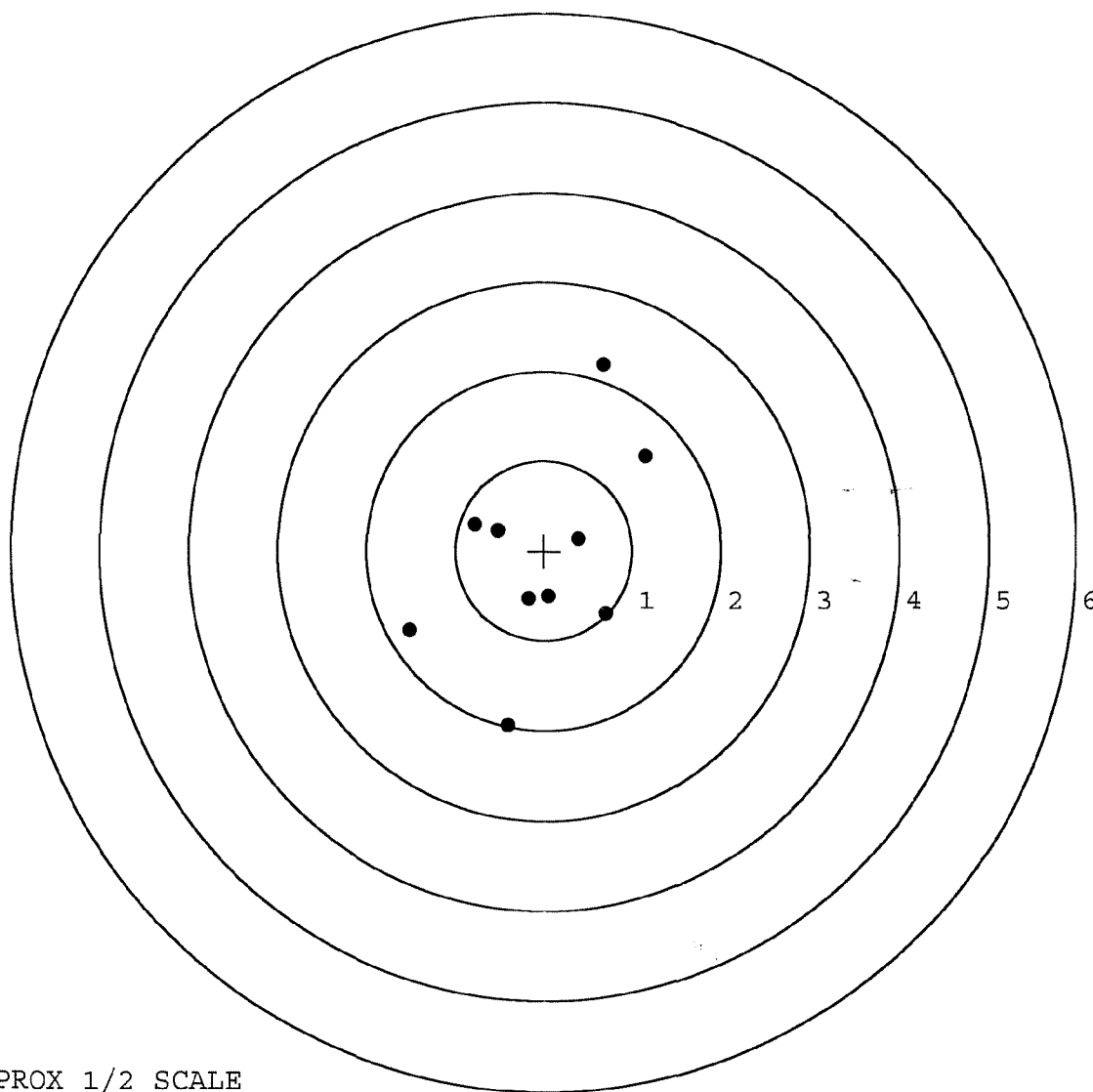
MEAN RADIUS: 1.128

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.418	-1.952
2:	-1.515	-0.891
3:	0.695	-0.706
4:	-0.178	-0.537
5:	0.048	-0.509
6:	0.390	0.135
7:	-0.530	0.229
8:	-0.781	0.297
9:	1.149	1.047
10:	0.679	2.078



TARGET APPROX 1/2 SCALE

BARBER - M24 0154313

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 5

FILE DATE: 09/29/2005

FILE TIME: 11:25

X CENTROID: -0.176

Y CENTROID: 0.066

POA TO CENTROID: 0.188

HORZ SPREAD: 1.352

VERT SPREAD: 2.551

GROUP SPREAD: 2.558

MIN RADIUS: 0.043

MAX RADIUS: 1.486

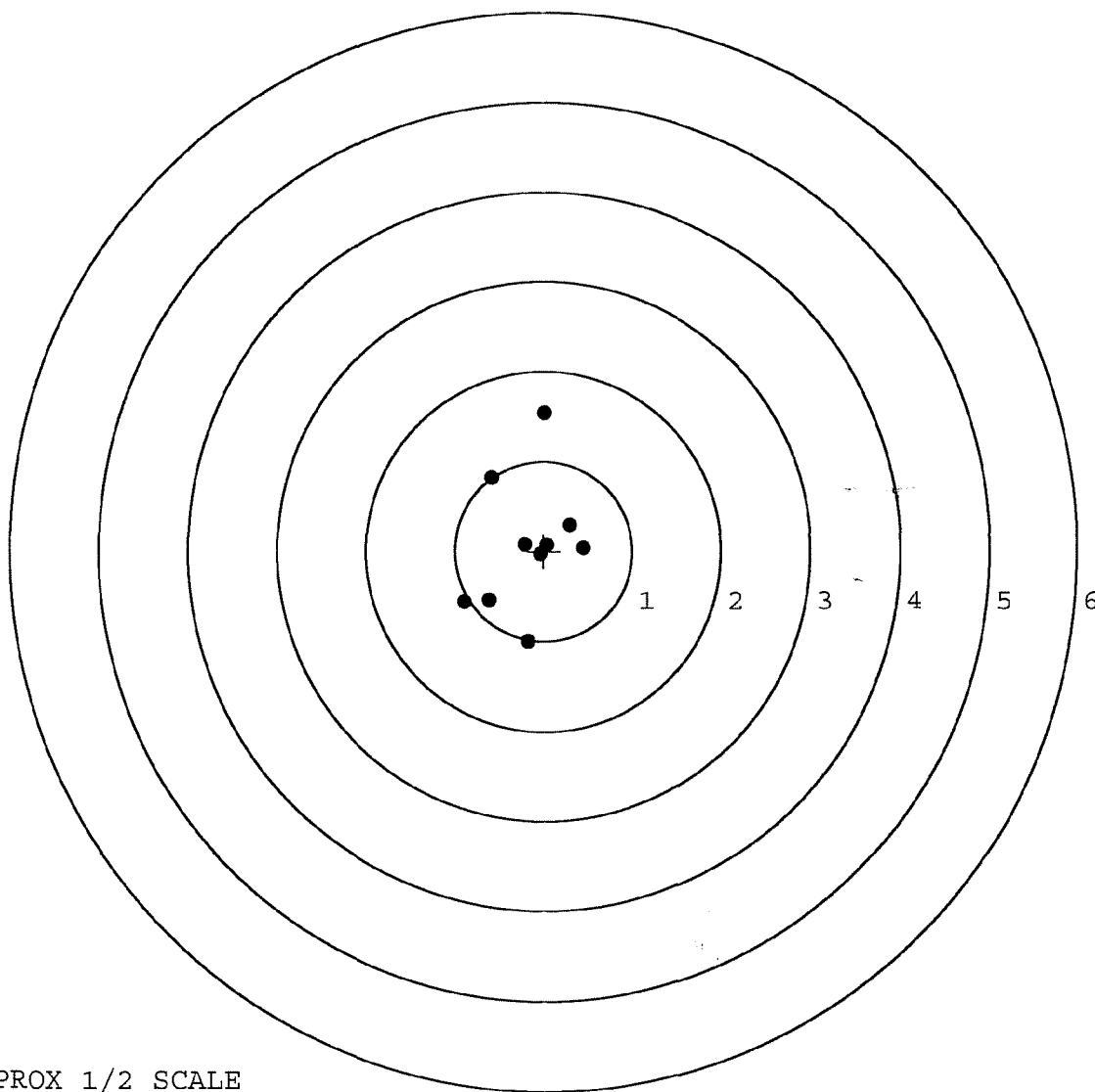
MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.183	-1.011
2:	-0.900	-0.569
3:	-0.619	-0.548
4:	0.452	0.036
5:	0.291	0.291
6:	0.036	0.067
7:	-0.218	0.076
8:	-0.046	-0.037
9:	-0.583	0.814
10:	0.010	1.540



TARGET APPROX 1/2 SCALE