

G-646 1669

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



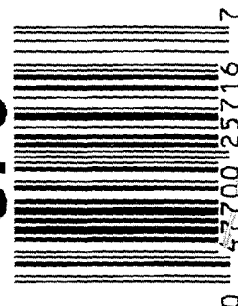
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461669

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

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SERIAL NO.



66461669

8/11/2005 9:22:37 AM

Original
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25716

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



.MA25716

Shop Order: SW5716 - SEP



.ABSW5716 - SEP

Start Date: 5/27/2005

Finish Date: 9/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004110512

0540

01PC001

Flat Black Powder Coat, Barrel and



0004110502

0560

89SWS1

Reassemble Action.



0004110503

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461669

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-9-05	RTZ
440	PROOF		9-12-05	RTZ
460	CHECK HEADSPACE		9-13-05	RTZ
470	DIS-ASSEMBLE ACTION		9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 MAGNAFLUX BOLT	9-14-05	und
500	ROLLMARK CALIBER		9-14-05	CW
510	DRILL AND TAP SIGHT HOLES		9-13-05	TRW
520	GOFF BLAST BBL / REC		9-19-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-28-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-28-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-28-05	DA
	D) OIL FIRING PIN ASSEMBLY		10-3-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

REV-8405

OP #	OPERATION NAME	BARBER M24 0154542	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>3 lbs</u>	<u>3 lbs</u>	<u>3 lbs</u>	10-11-05	Ac		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	10-11-05	Ac		
	J) ASSEMBLE STOCK					10-3-05	RTZ		
	K) ASSEMBLE SWIVEL STUDS					10-11-05	Ac		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					10-3-05	RTZ		
	M) IRON SIGHT ALIGNMENT					10-3-05	RTZ		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					10-3-05	RTZ		
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL					
			PASS	FAIL		10-5-05	TRW		
	MALFUNCTION		CORRECTION NA						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					10-5-05	R.P.		
670	FINAL INSPECTION A) HEADSPACE					10-11-05	Ac		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u>	<u>2.67</u>	<u>2.53</u>	<u>2.41</u>	<u>2.47</u>	10-7-05	BC
	C) FUNCTION					10-11-05	Ac		
690	PACK					10-12-05	DA		

BARBER - M24 0154543AVERAGE 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 _____

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.50		2.31	
PULL #2	2.60	2.42		2.67	
PULL #3	2.46	2.50		2.74	
PULL #4	2.66	2.60		2.63	
PULL #5	2.56	2.64		2.09	
TOTAL	12.90	12.66		12.46	
AVERAGE	2.58	2.53		2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.20		
PULL #2	3.27	3.25		
PULL #3	3.37	3.13		
PULL #4	3.35	3.14		
PULL #5	3.08	3.11		
TOTAL	16.46	15.83		
AVERAGE	3.29	3.16		

	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	4.65	4.13		4.58
PULL #2	4.20	4.11		4.62
PULL #3	4.19	4.14		4.68
PULL #4	4.22	4.08		4.57
PULL #5	4.13	4.12		4.38
TOTAL	21.39	20.58		22.83
AVERAGE	4.27	4.11		4.57

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461669.___0
FILE DATE AND TIME: 10/05/2005 11:21

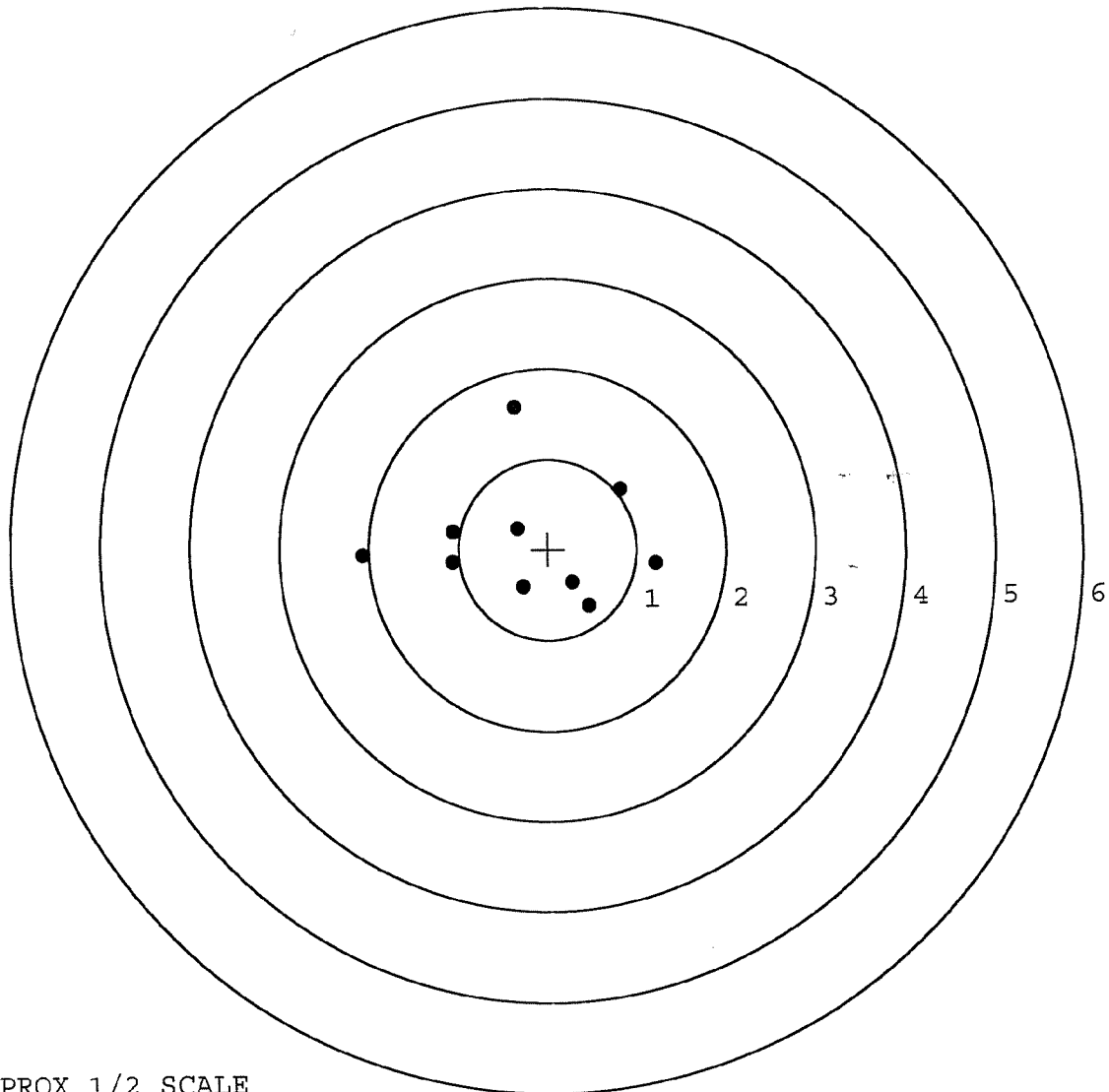
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.007
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.007
The Average Mean Radius of the Five Target Set:	0.829
The Distance from POA to Centroid Target #1:	0.258
The Distance from Centroid Target #2 to Centroid Target #1:	0.305
The Distance from Centroid Target #3 to Centroid Target #1:	0.511
The Distance from Centroid Target #4 to Centroid Target #1:	0.227
The Distance from Centroid Target #5 to Centroid Target #1:	0.312

SERIAL NUMBER: G6461669. __ 0
 TARGET NUMBER: 1
 FILE DATE: 10/05/2005
 FILE TIME: 11:21

POINT#	X	Y
1:	1.210	-0.168
2:	0.456	-0.630
3:	0.273	-0.370
4:	0.823	0.662
5:	-0.340	0.231
6:	-0.284	-0.415
7:	-1.068	-0.141
8:	-1.060	0.205
9:	-2.068	-0.057
10:	-0.362	1.578

X CENTROID: -0.242
 Y CENTROID: 0.090
 POA TO CENTROID: 0.258
 HORZ SPREAD: 3.278
 VERT SPREAD: 2.208
 GROUP SPREAD: 3.280
 MIN RADIUS: 0.172
 MAX RADIUS: 1.832
 MEAN RADIUS: 1.006
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461669. 0

TARGET NUMBER: 2

FILE DATE: 10/05/2005

FILE TIME: 11:21

X CENTROID: 0.063

Y CENTROID: 0.087

POA TO CENTROID: 0.108

HORZ SPREAD: 2.693

VERT SPREAD: 3.277

GROUP SPREAD: 3.785

MIN RADIUS: 0.419

MAX RADIUS: 1.970

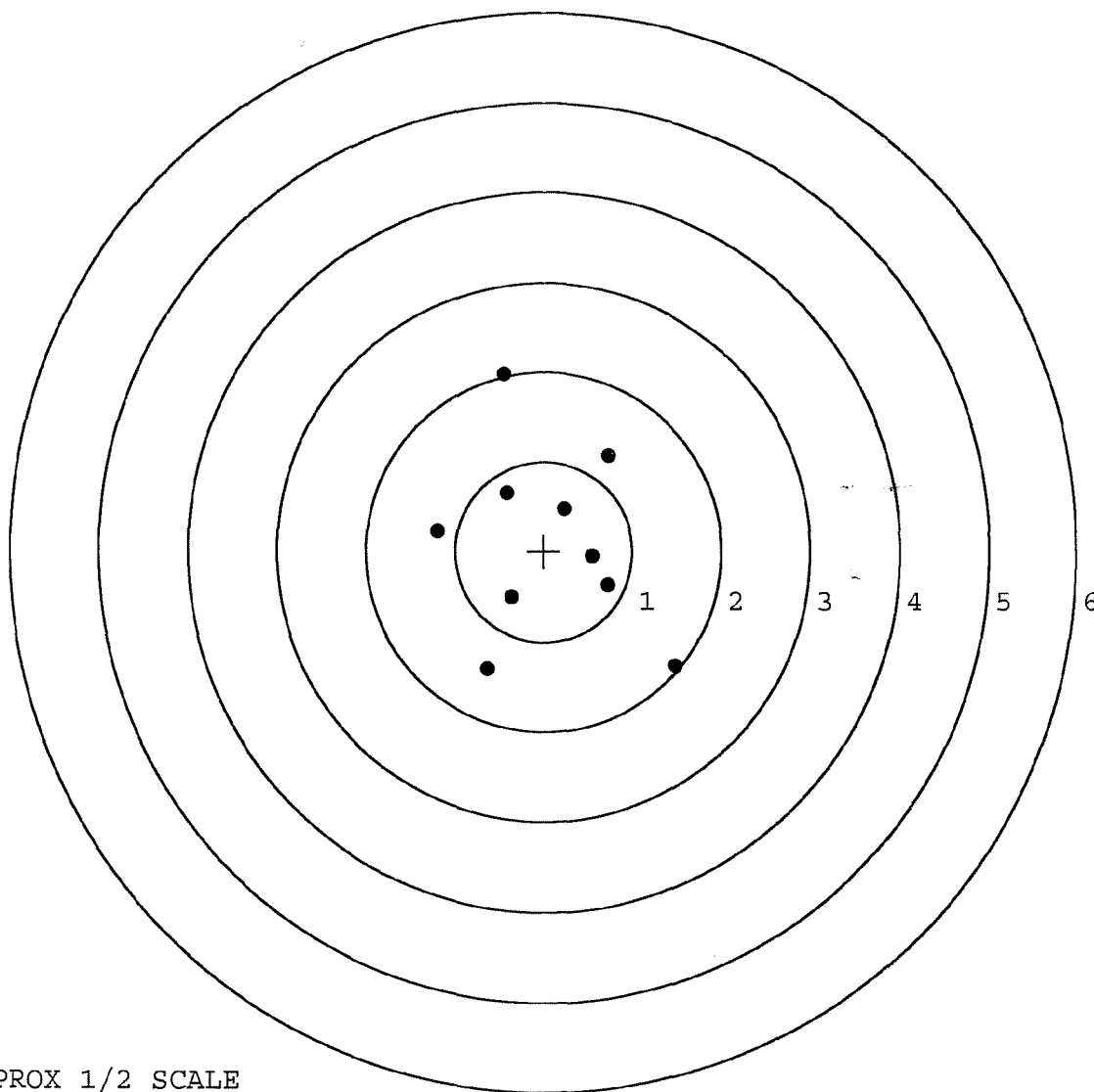
MEAN RADIUS: 1.116

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.493	-1.268
2:	0.722	-0.378
3:	0.549	-0.056
4:	0.232	0.470
5:	0.728	1.072
6:	-0.458	1.976
7:	-0.425	0.651
8:	-0.370	-0.511
9:	-0.637	-1.301
10:	-1.200	0.214



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461669. 0

TARGET NUMBER: 3

FILE DATE: 10/05/2005

FILE TIME: 11:21

X CENTROID: 0.236

Y CENTROID: -0.090

POA TO CENTROID: 0.253

HORZ SPREAD: 1.581

VERT SPREAD: 2.023

GROUP SPREAD: 2.189

MIN RADIUS: 0.259

MAX RADIUS: 1.340

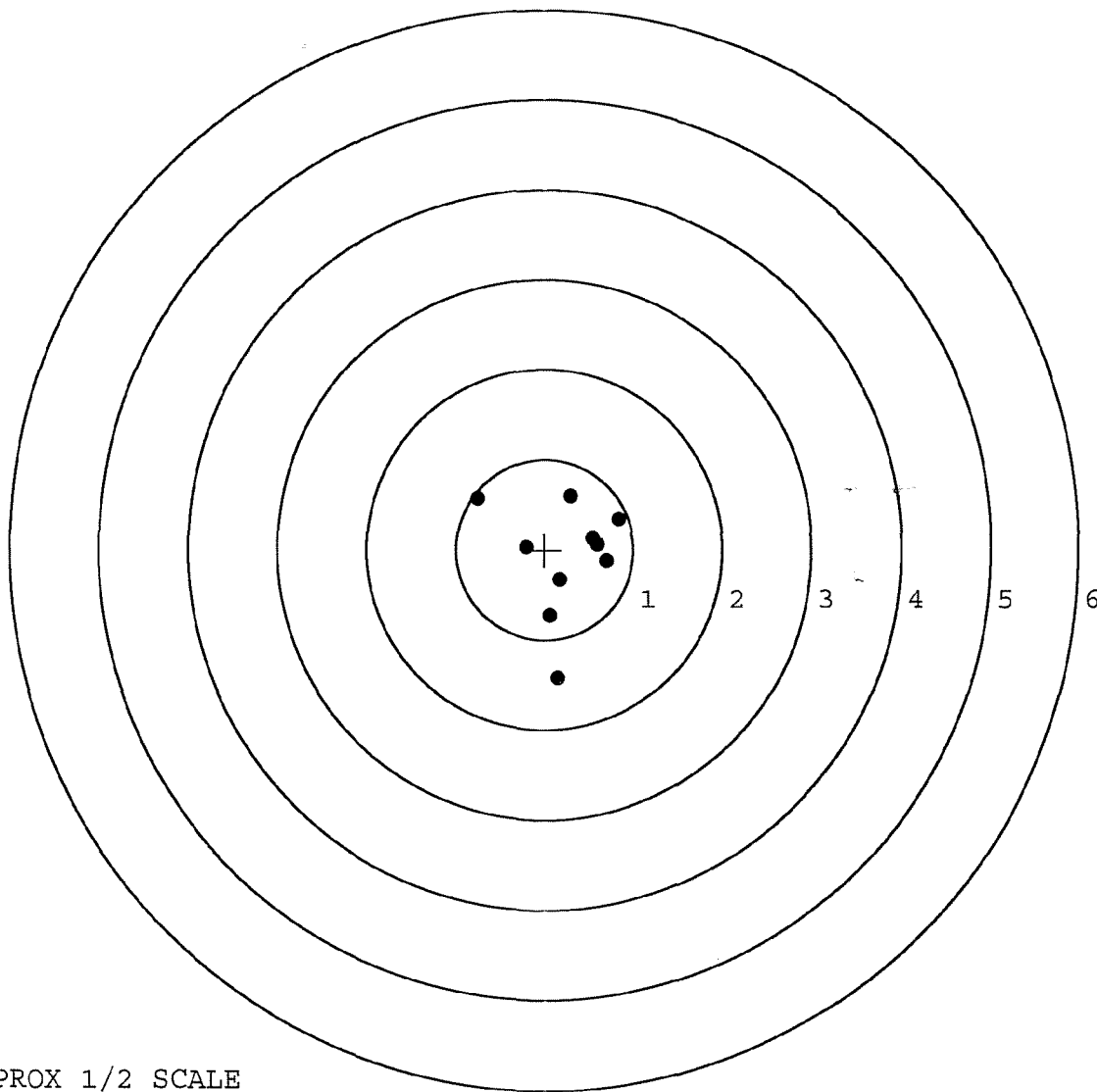
MEAN RADIUS: 0.657

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.146	-1.427
2:	0.056	-0.736
3:	0.169	-0.340
4:	0.694	-0.127
5:	0.541	0.133
6:	0.827	0.339
7:	0.291	0.596
8:	-0.209	0.030
9:	-0.754	0.568
10:	0.600	0.066



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461669. 0

TARGET NUMBER: 4

FILE DATE: 10/05/2005

FILE TIME: 11:21

X CENTROID: -0.025

Y CENTROID: 0.024

POA TO CENTROID: 0.035

HORZ SPREAD: 1.667

VERT SPREAD: 1.655

GROUP SPREAD: 2.038

MIN RADIUS: 0.164

MAX RADIUS: 1.125

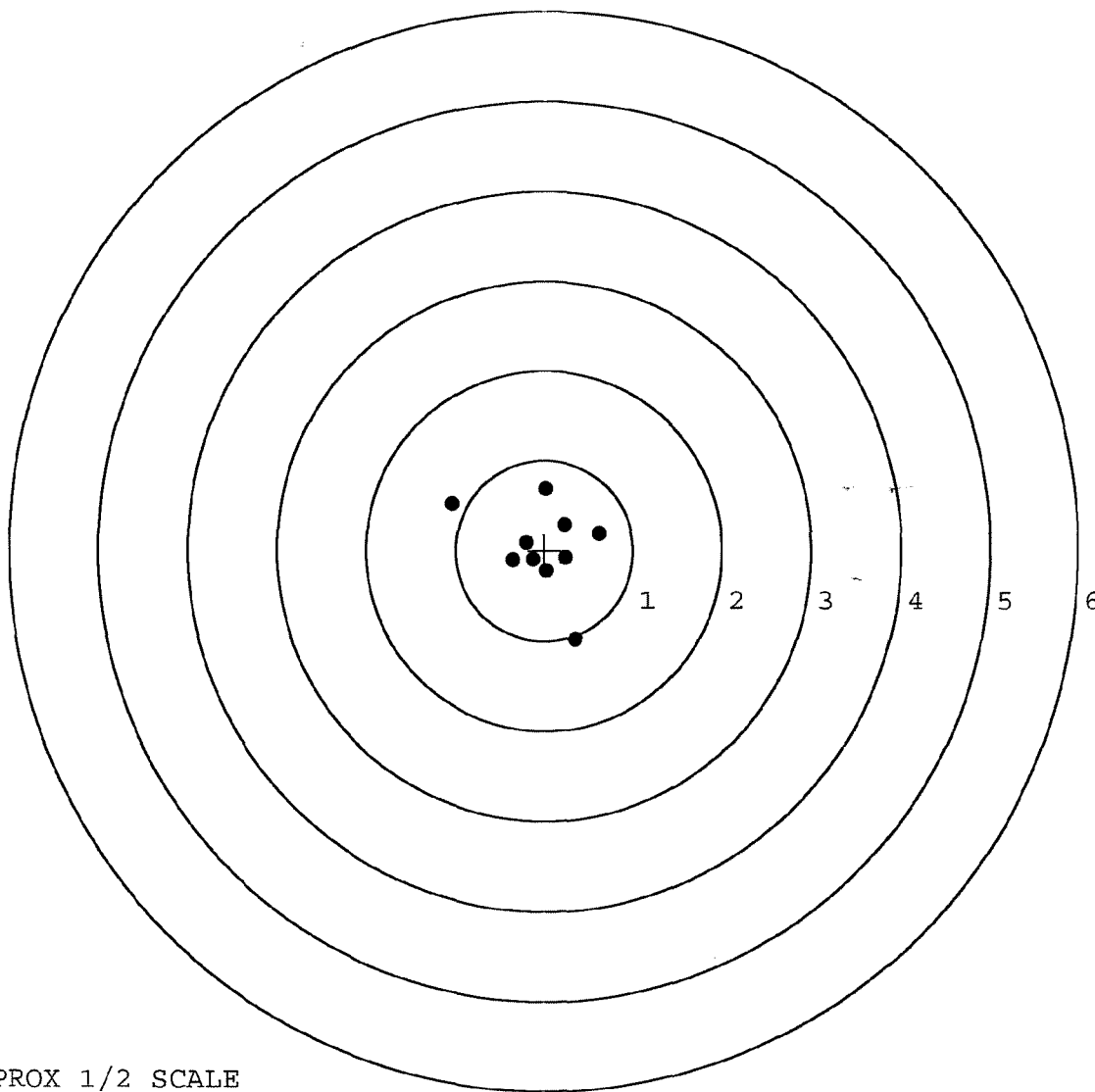
MEAN RADIUS: 0.513

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.352	-0.981
2:	0.626	0.193
3:	0.220	0.285
4:	0.019	0.674
5:	0.234	-0.082
6:	0.024	-0.233
7:	-0.355	-0.113
8:	-0.202	0.091
9:	-0.129	-0.103
10:	-1.041	0.507

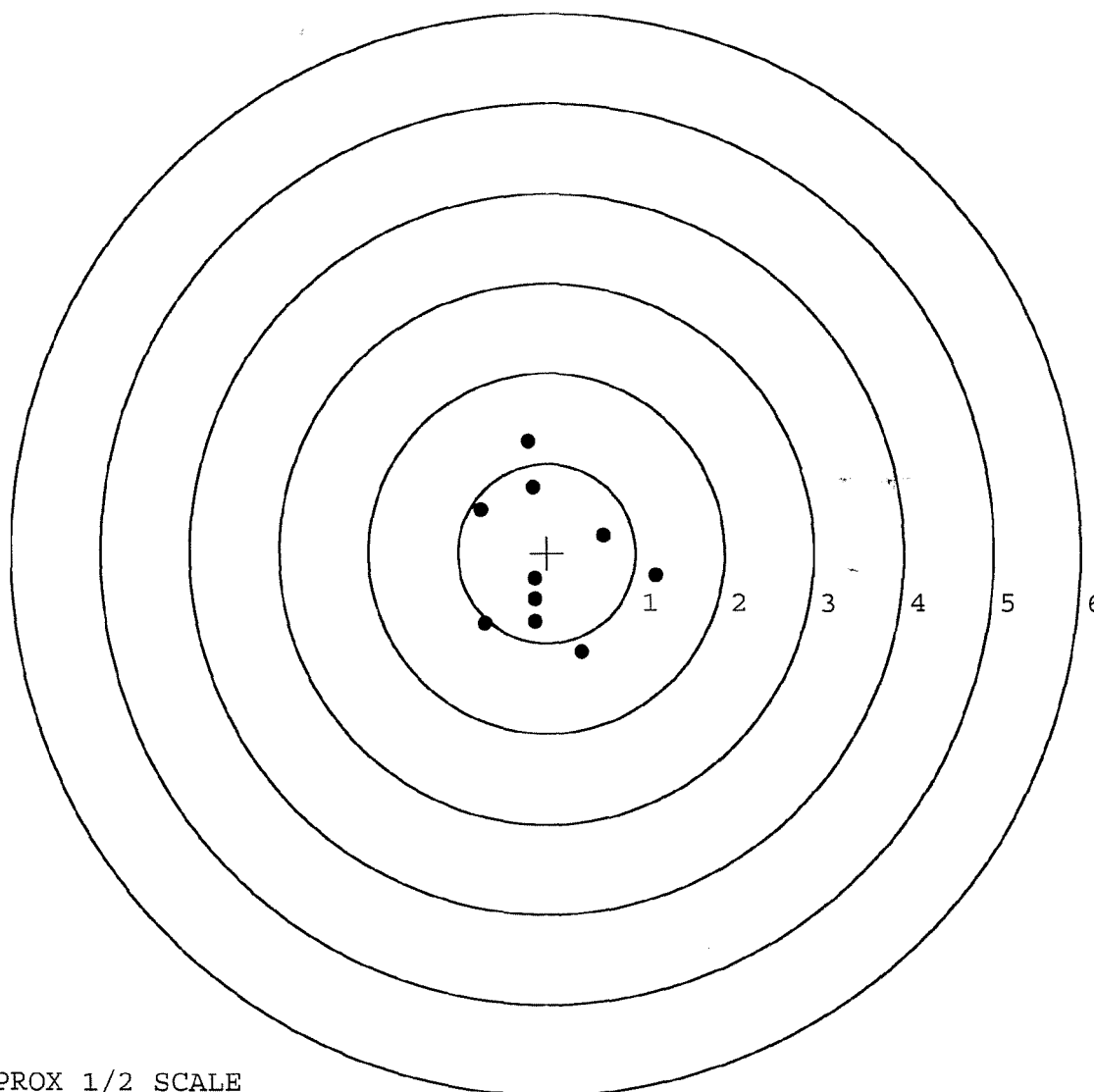


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461669. 0
 TARGET NUMBER: 5
 FILE DATE: 10/05/2005
 FILE TIME: 11:21

POINT#	X	Y
1:	1.221	-0.253
2:	0.638	0.195
3:	0.395	-1.103
4:	-0.696	-0.787
5:	-0.751	0.486
6:	-0.165	0.737
7:	-0.218	1.243
8:	-0.138	-0.292
9:	-0.135	-0.514
10:	-0.135	-0.768

X CENTROID: 0.002
 Y CENTROID: -0.106
 POA TO CENTROID: 0.106
 HORZ SPREAD: 1.972
 VERT SPREAD: 2.346
 GROUP SPREAD: 2.425
 MIN RADIUS: 0.233
 MAX RADIUS: 1.366
 MEAN RADIUS: 0.850
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE