

G6414358

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



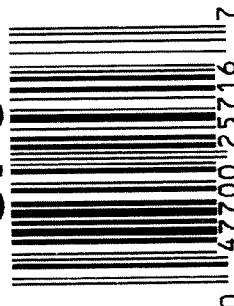
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6414358

UPC



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.



10/27/2004 11:09:26 AM

Chib

9

Original

25716

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



.MA25716

Shop Order: SWS10-15-1



.ABSWS10-15-1

Start Date: 10/22/2004

Finish Date: 12/27/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003517903

0560

Reassemble Action.

89SWS1



0003517904

0690

Pack Rifle

89SWS1



0003517897

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414358

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTL
600	PROOF			
607	CHECK HEADSPACE		MAGNA-FLUX INSPECTED	
610	DIS-ASSEMBLE GUN		001 21 2004	
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		OPERATOR	
615	ROLLMARK CALIBER		10/27/04	AB
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRL
620	APPLY COATINGS (BARREL ACTION)		10/30	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-9-04	WA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-04	BA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-04	DA
	D) OIL FIRING PIN ASSEMBLY		11-9-04	RT
	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>7.5</u> <u>7.5</u> <u>7.0</u>	11/16/04	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.0</u>	11/16/04	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.0245</u>	11/16/04	RA
	J) ASSEMBLE STOCK		11-9-04	RTZ
	K) ASSEMBLE SWIVEL STUDS		11-29-04	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-29-04	RTZ
	M) IRON SIGHT ALIGNMENT		11-29-04	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-29-04	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	11-10-04	AC
	MALFUNCTION <i>Ct Hover live</i>	<i>Correction Passed</i>	11-11-04	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		11-10-04	AC
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<i>RA</i> <u>2.55</u> <u>2.44</u> <u>2.43</u> <u>2.43</u> <u>2.46</u>	11/16/04	RA
	C) FUNCTION		11-29-04	RTZ
660	PACK		11/29/04	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 6-22-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.30		2.34	
PULL #2	2.45	2.37		2.34	
PULL #3	2.48	2.38		2.31	
PULL #4	2.43	2.34		2.35	
PULL #5	2.47	2.28		2.31	
TOTAL	12.33	11.67		11.65	
AVERAGE	2.46	2.33		2.33	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.19		
PULL #2	3.30	3.23		
PULL #3	3.31	2.95		
PULL #4	3.23	3.24		
PULL #5	2.90	3.26		
TOTAL	15.98	15.87		
AVERAGE	3.19	3.17		

	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	4.42	4.18		4.30
PULL #2	4.29	4.15		4.28
PULL #3	4.29	4.24		4.26
PULL #4	4.19	4.23		3.96
PULL #5	4.27	4.21		4.41
TOTAL	21.46	21.01		21.21
AVERAGE	4.29	4.20		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414358.___0
FILE DATE AND TIME: 11/10/2004 09:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.043
The Average Y Centroid of the Five Target Set:	0.039
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.863
The Distance from POA to Centroid Target #1:	0.233
The Distance from Centroid Target #2 to Centroid Target #1:	0.223
The Distance from Centroid Target #3 to Centroid Target #1:	0.165
The Distance from Centroid Target #4 to Centroid Target #1:	0.260
The Distance from Centroid Target #5 to Centroid Target #1:	0.819

SERIAL NUMBER: G6414358. __0

TARGET NUMBER: 1

FILE DATE: 11/10/2004

FILE TIME: 09:03

X CENTROID: -0.165

Y CENTROID: 0.165

POA TO CENTROID: 0.233

HORZ SPREAD: 1.867

VERT SPREAD: 2.110

GROUP SPREAD: 2.272

MIN RADIUS: 0.157

MAX RADIUS: 1.473

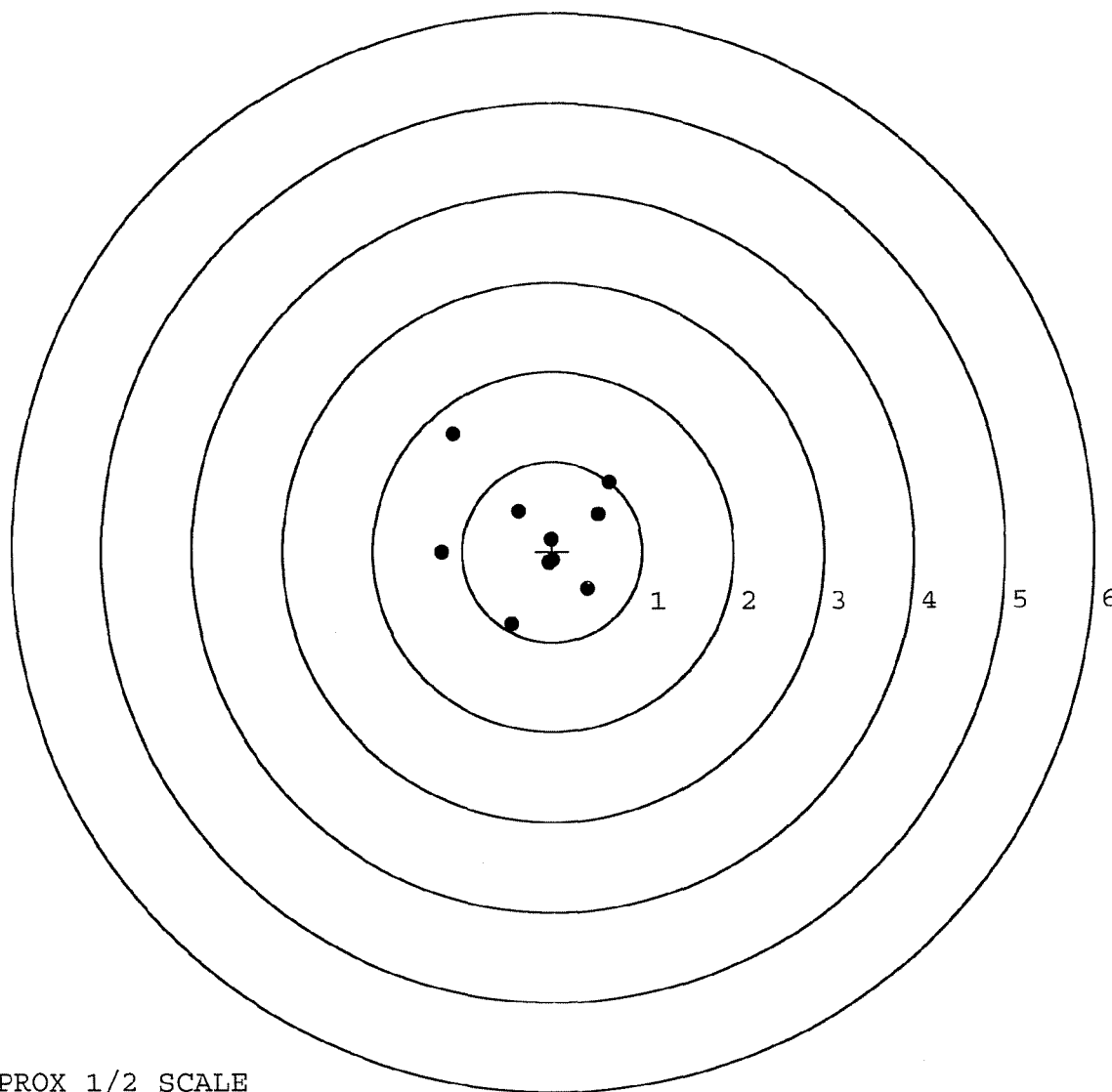
MEAN RADIUS: 0.722

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.640	0.768
2:	0.511	0.416
3:	-0.374	0.447
4:	-0.010	0.137
5:	0.011	-0.094
6:	0.392	-0.410
7:	-0.455	-0.803
8:	-1.227	0.005
9:	-1.096	1.307
10:	-0.042	-0.124



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414358. __0

TARGET NUMBER: 2

FILE DATE: 11/10/2004

FILE TIME: 09:03

POINT#	X	Y
1:	-0.015	2.058
2:	0.299	1.317
3:	0.317	0.779
4:	0.209	0.550
5:	-0.443	0.641
6:	-0.396	0.281
7:	0.516	-0.039
8:	0.361	-0.921
9:	-0.262	-0.576
10:	-0.666	-0.854

X CENTROID: -0.008

Y CENTROID: 0.324

POA TO CENTROID: 0.324

HORZ SPREAD: 1.182

VERT SPREAD: 2.979

GROUP SPREAD: 3.003

MIN RADIUS: 0.314

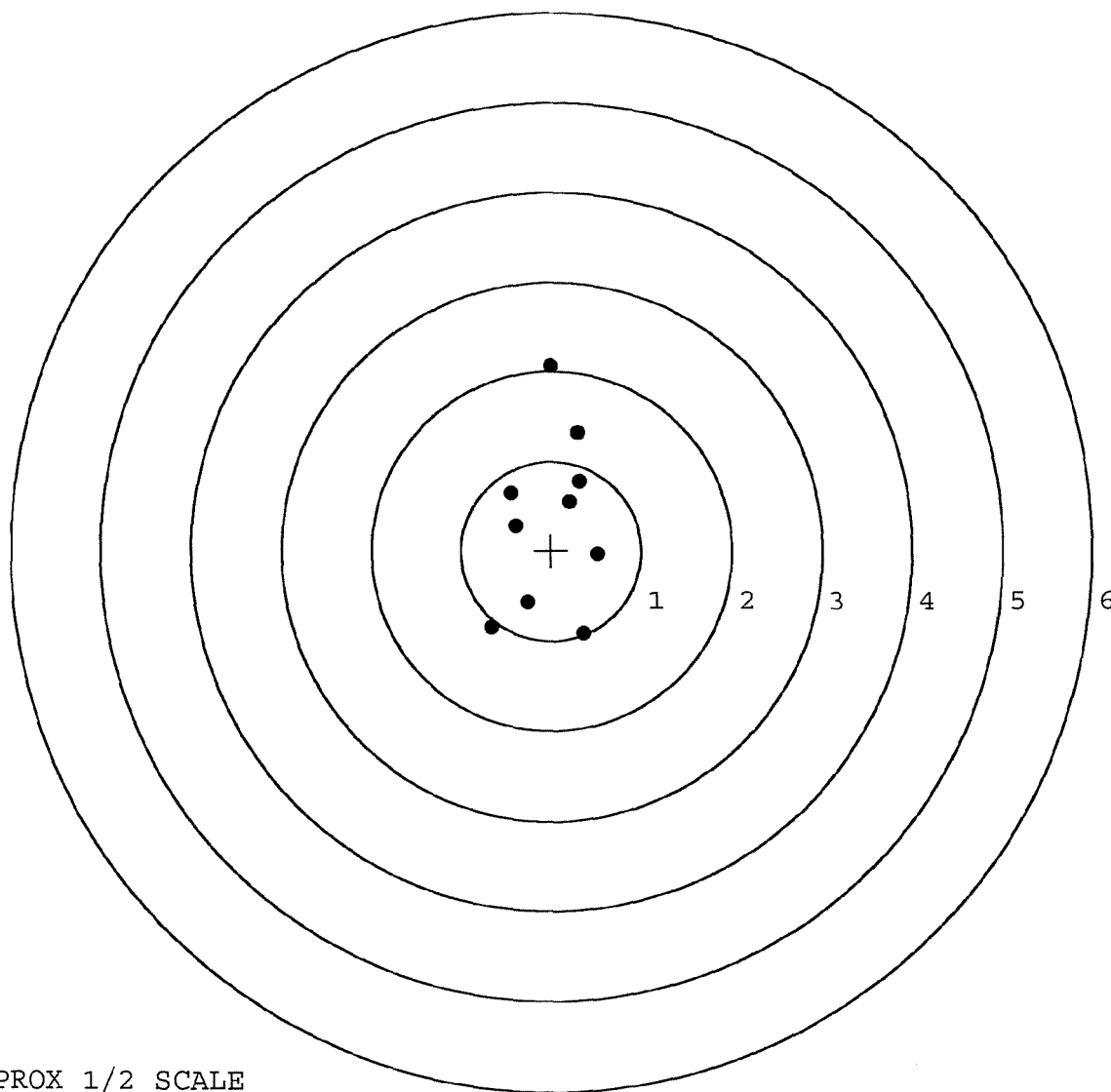
MAX RADIUS: 1.734

MEAN RADIUS: 0.880

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414358. 0

TARGET NUMBER: 3

FILE DATE: 11/10/2004

FILE TIME: 09:03

X CENTROID: -0.002

Y CENTROID: 0.138

POA TO CENTROID: 0.138

HORZ SPREAD: 2.364

VERT SPREAD: 3.802

GROUP SPREAD: 3.922

MIN RADIUS: 0.298

MAX RADIUS: 2.031

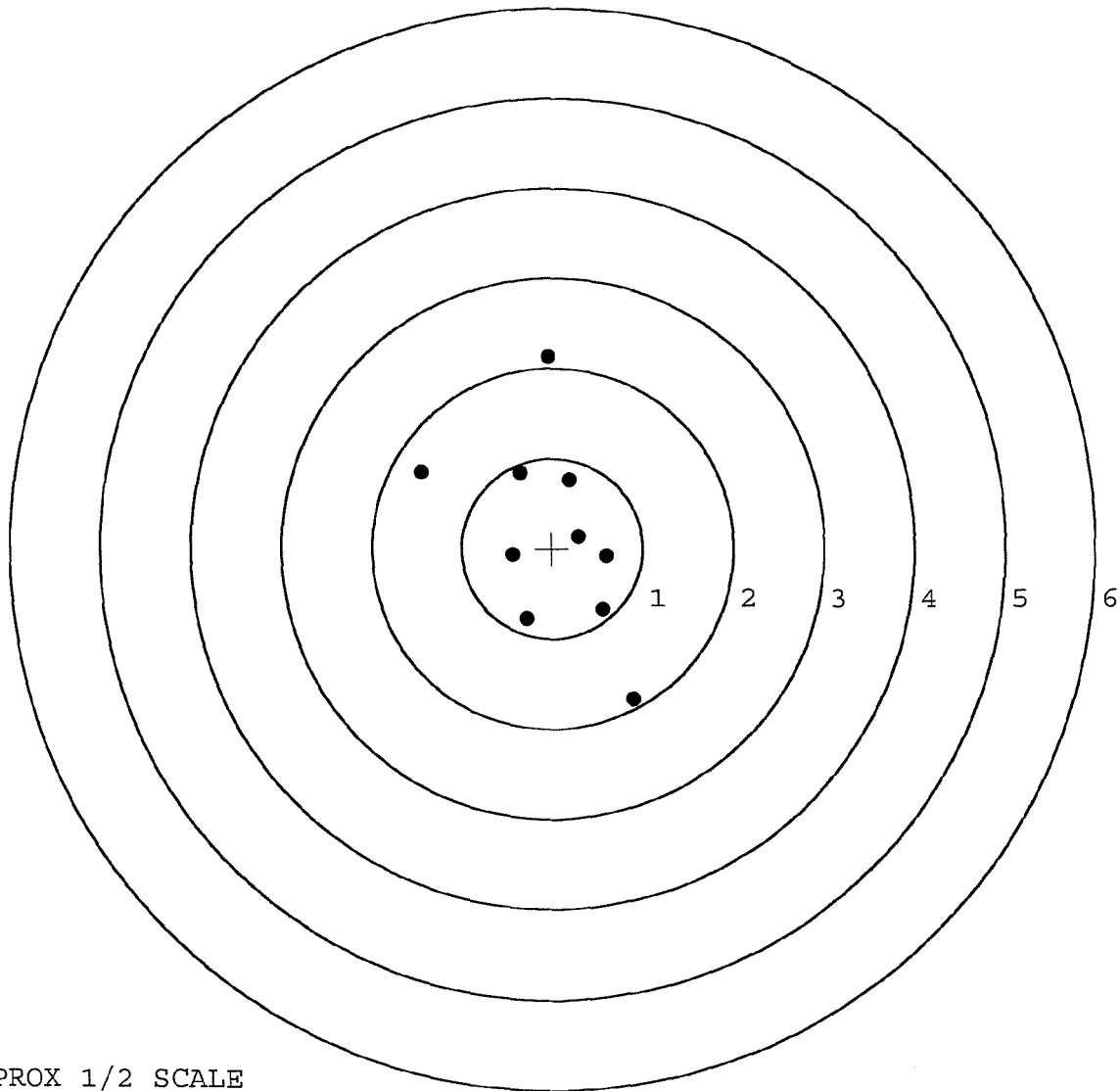
MEAN RADIUS: 1.047

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.055	2.125
2:	-1.455	0.843
3:	-0.354	0.838
4:	0.189	0.763
5:	0.295	0.130
6:	0.604	-0.092
7:	-0.439	-0.079
8:	-0.278	-0.790
9:	0.560	-0.683
10:	0.909	-1.677



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414358.___0

TARGET NUMBER: 4

FILE DATE: 11/10/2004

FILE TIME: 09:03

POINT#	X	Y
1:	-0.061	0.963
2:	0.477	0.680
3:	0.199	0.550
4:	0.586	0.537
5:	0.082	0.125
6:	-0.251	-0.254
7:	0.515	-0.311
8:	0.267	-0.977
9:	-0.392	-0.941
10:	-0.666	0.293

X CENTROID: 0.076

Y CENTROID: 0.066

POA TO CENTROID: 0.101

HORZ SPREAD: 1.252

VERT SPREAD: 1.940

GROUP SPREAD: 1.933

MIN RADIUS: 0.059

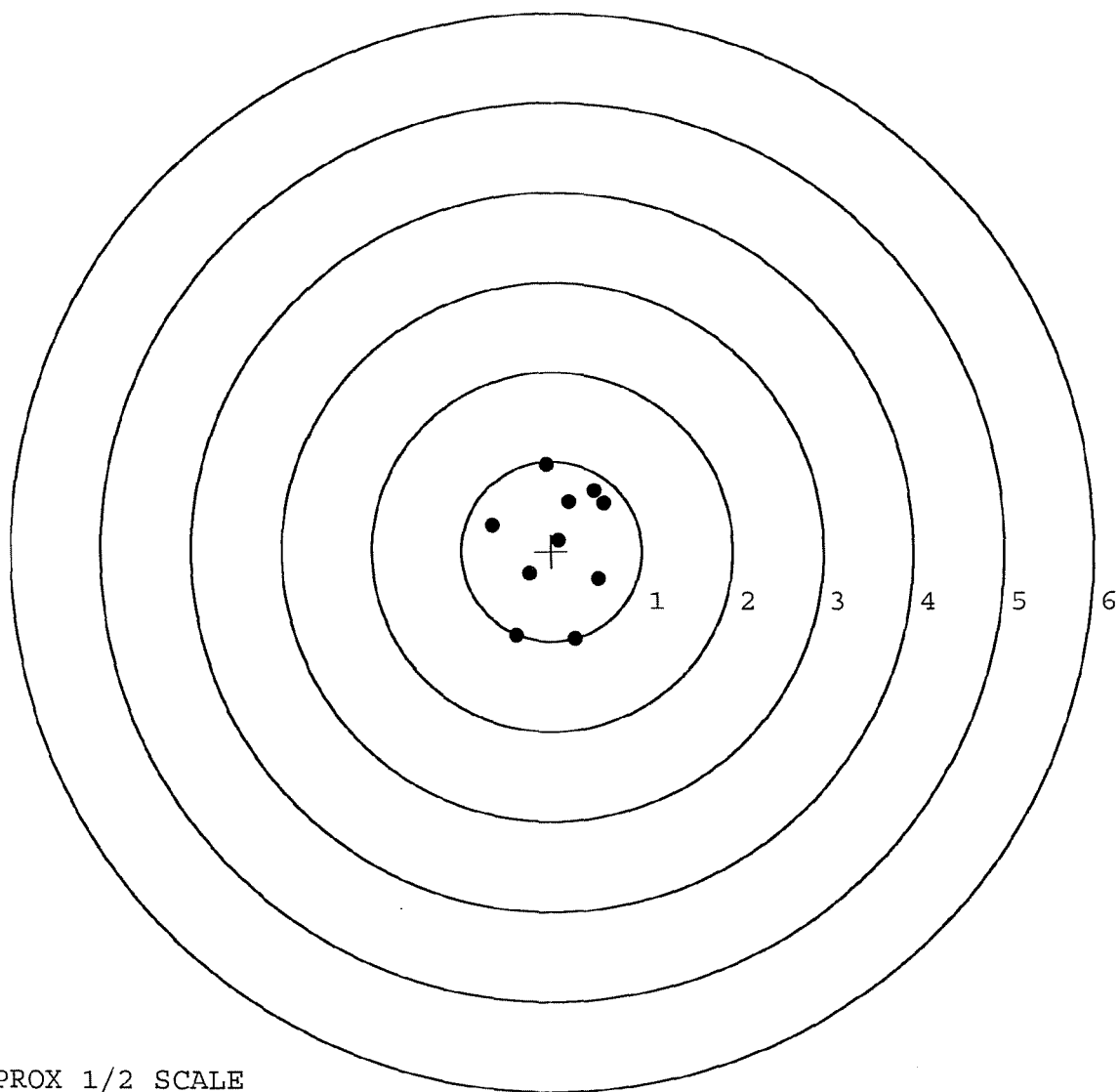
MAX RADIUS: 1.111

MEAN RADIUS: 0.688

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414358. __0

TARGET NUMBER: 5

FILE DATE: 11/10/2004

FILE TIME: 09:03

POINT#	X	Y
1:	-0.584	0.171
2:	-0.390	0.417
3:	-0.017	0.312
4:	0.278	0.245
5:	0.360	-0.084
6:	0.191	-0.356
7:	1.490	-0.601
8:	1.004	-0.911
9:	0.831	-1.851
10:	0.009	-2.314

X CENTROID: 0.317

Y CENTROID: -0.497

POA TO CENTROID: 0.590

HORZ SPREAD: 2.074

VERT SPREAD: 2.731

GROUP SPREAD: 2.760

MIN RADIUS: 0.189

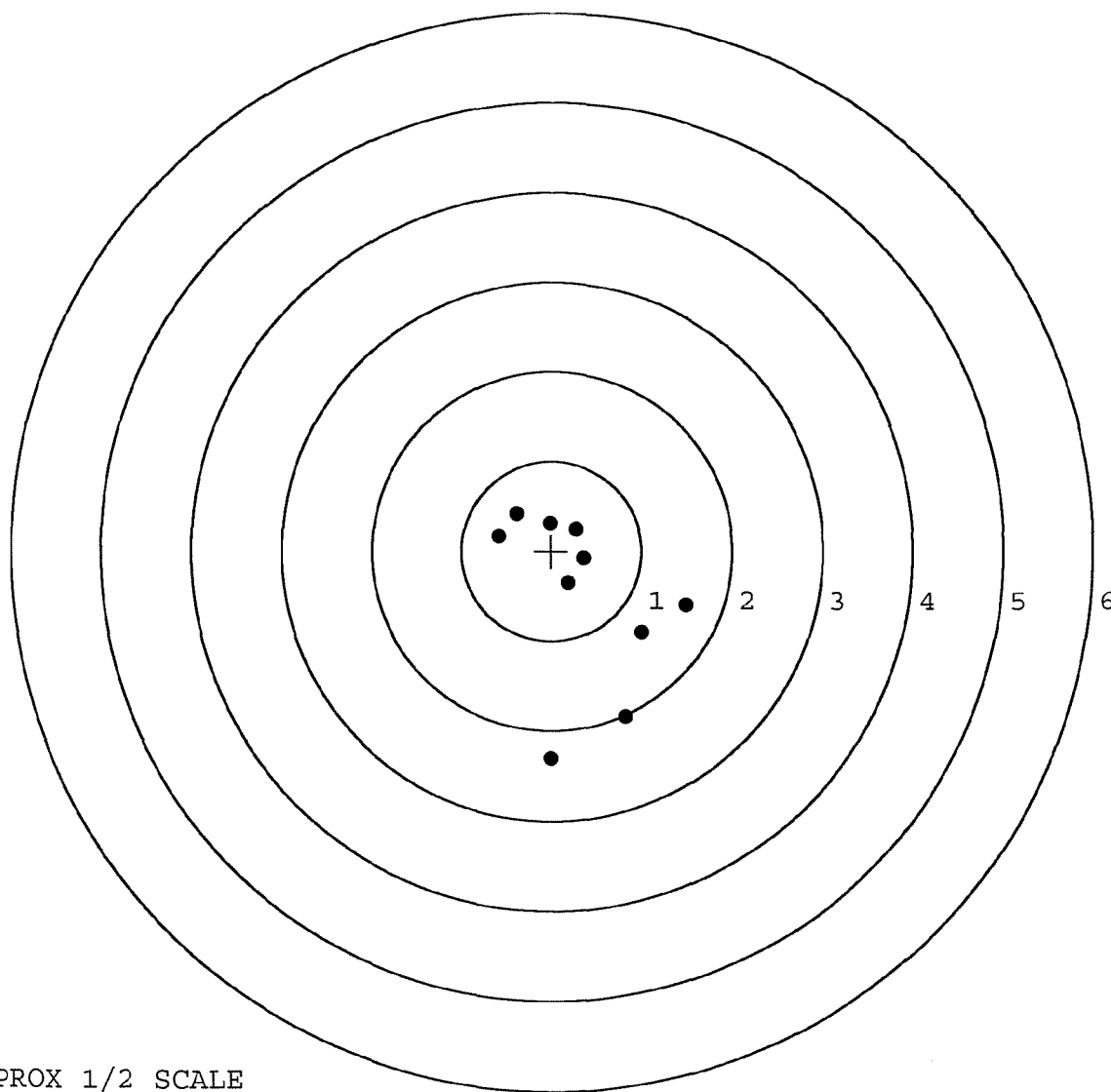
MAX RADIUS: 1.843

MEAN RADIUS: 0.977

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE