

G 646 1656

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

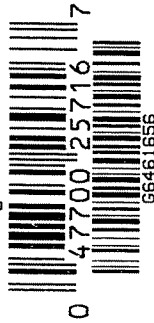
- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



ORDER NO.

25716

BARREL LENGTH

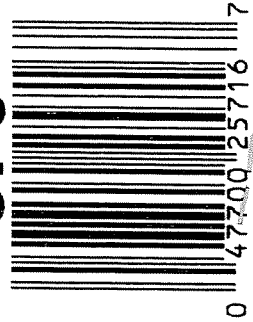
24"

CAPACITY

6

G6461656

UPC



ORDER 25716

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

UPC

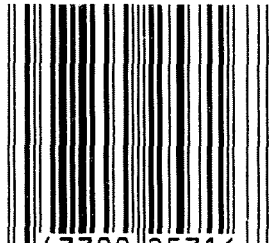


0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



66461656

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

78RQT01

Goff Blast Barrel & Rec Assembly,



0003858612

0540

01PC001

Flat Black Powder Coat, Barrel and



0003858602

0560

89SWS1

Reassemble Action.



0003858603

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461656

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	K
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-18-05	K
610	DIS-ASSEMBLE GUN	APR 20 2005	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRW
620	APPLY COATINGS (BARREL ACTION)		5-6-05	WJ
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-17-05	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>7 lbs</u> <u>7 lbs</u> <u>7 lbs</u>	5-31-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-31-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		5-27-05	Ac
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-31-05	Ac
	J) ASSEMBLE STOCK		5-17-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-31-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-17-05	RTZ
	M) IRON SIGHT ALIGNMENT		5-17-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-17-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-17-05	RTZ TRW
	MALFUNCTION	CORRECTION	5-20-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-20-05	Ac
655	FINAL INSPECTION A) HEADSPACE		5-31-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.11</u> <u>2.37</u> <u>2.23</u> <u>2.10</u> <u>2.08</u>	5-27-05	Ac
	C) FUNCTION		5-31-05	Ac
660	PACK		6-1-05	DP

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 5-16-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.57		2.29	
PULL #2	2.51	2.73		2.31	
PULL #3	2.32	2.48		2.44	
PULL #4	2.41	2.46		2.41	
PULL #5	2.41	2.65		2.46	
TOTAL	12.16	12.89		11.91	
AVERAGE	2.43	2.57		2.38	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.13		
PULL #2	3.15	3.26		
PULL #3	3.13	3.10		
PULL #4	3.20	3.30		
PULL #5	2.98	3.17		
TOTAL	15.51	15.96		
AVERAGE	3.10	3.19		

	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	4.47	4.32		4.14
PULL #2	4.48	4.21		4.10
PULL #3	4.20	4.13		4.22
PULL #4	4.44	4.15		4.24
PULL #5	4.39	4.17		4.18
TOTAL	21.98	20.98		20.88
AVERAGE	4.39	4.19		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461656.___0

FILE DATE AND TIME: 05/20/2005 06:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.026
The Average Y Centroid of the Five Target Set:	-0.074
The Average Point of Impact of the Five Target Set:	0.079
The Average Mean Radius of the Five Target Set:	0.704
The Distance from POA to Centroid Target #1:	0.208
The Distance from Centroid Target #2 to Centroid Target #1:	0.157
The Distance from Centroid Target #3 to Centroid Target #1:	0.139
The Distance from Centroid Target #4 to Centroid Target #1:	0.389
The Distance from Centroid Target #5 to Centroid Target #1:	0.288

SERIAL NUMBER: G6461656. __0

TARGET NUMBER: 1

FILE DATE: 05/20/2005

FILE TIME: 06:48

POINT#	X	Y
1:	0.397	-0.928
2:	-1.343	-1.082
3:	-1.131	-0.571
4:	-0.392	0.103
5:	-0.246	-0.323
6:	0.548	0.322
7:	0.738	0.609
8:	0.234	-0.205
9:	0.051	0.027
10:	0.249	0.165

X CENTROID: -0.089

Y CENTROID: -0.188

POA TO CENTROID: 0.208

HORZ SPREAD: 2.081

VERT SPREAD: 1.691

GROUP SPREAD: 2.681

MIN RADIUS: 0.206

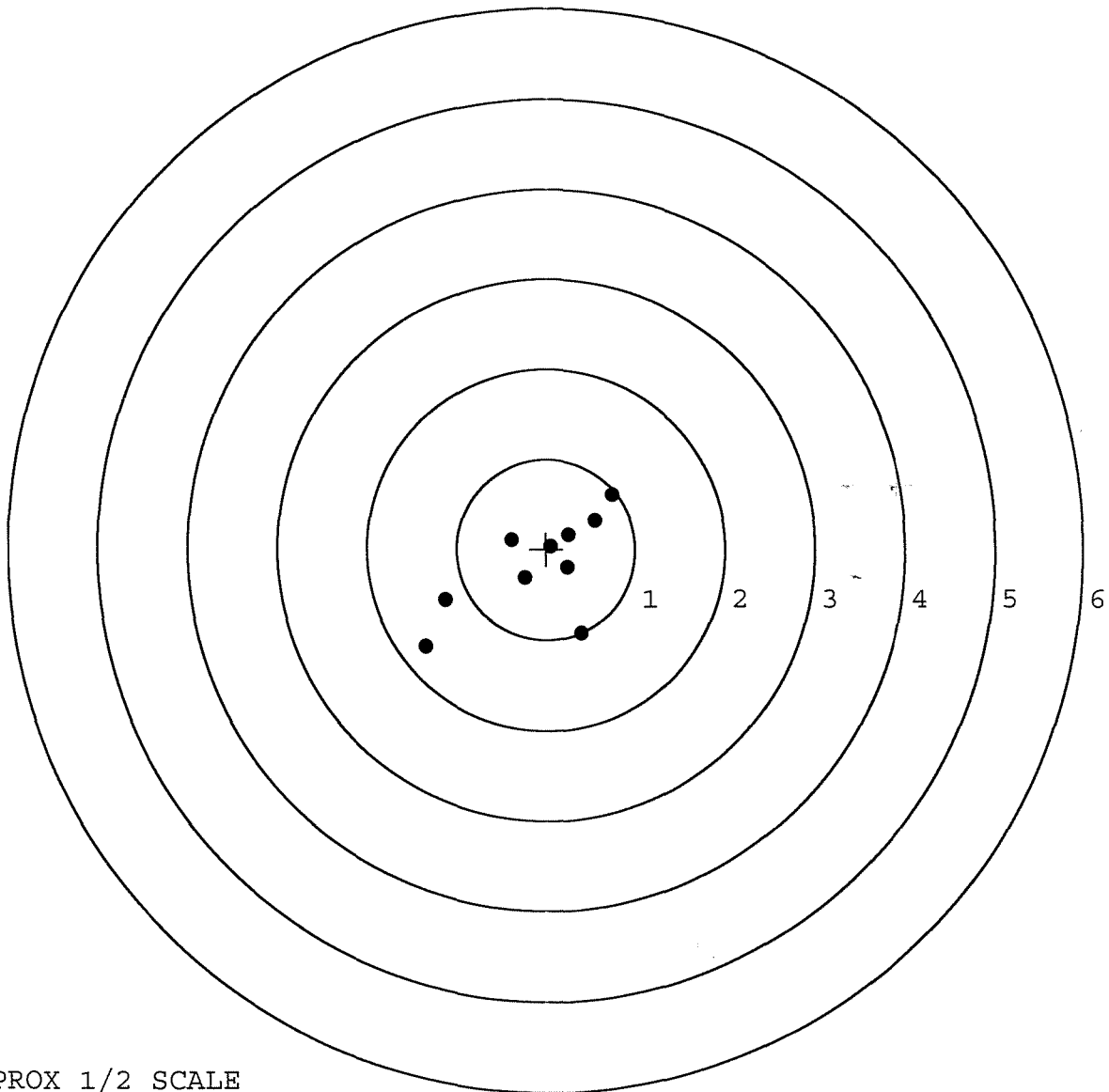
MAX RADIUS: 1.539

MEAN RADIUS: 0.720

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461656. __0

TARGET NUMBER: 2

FILE DATE: 05/20/2005

FILE TIME: 06:48

POINT#	X	Y
1:	-0.694	-0.753
2:	-0.632	0.199
3:	-0.844	0.836
4:	-0.165	0.469
5:	0.110	0.616
6:	0.302	-0.013
7:	0.336	-0.159
8:	0.101	-0.317
9:	0.038	-0.585
10:	-0.117	-0.757

X CENTROID: -0.157

Y CENTROID: -0.046

POA TO CENTROID: 0.163

HORZ SPREAD: 1.180

VERT SPREAD: 1.593

GROUP SPREAD: 1.751

MIN RADIUS: 0.374

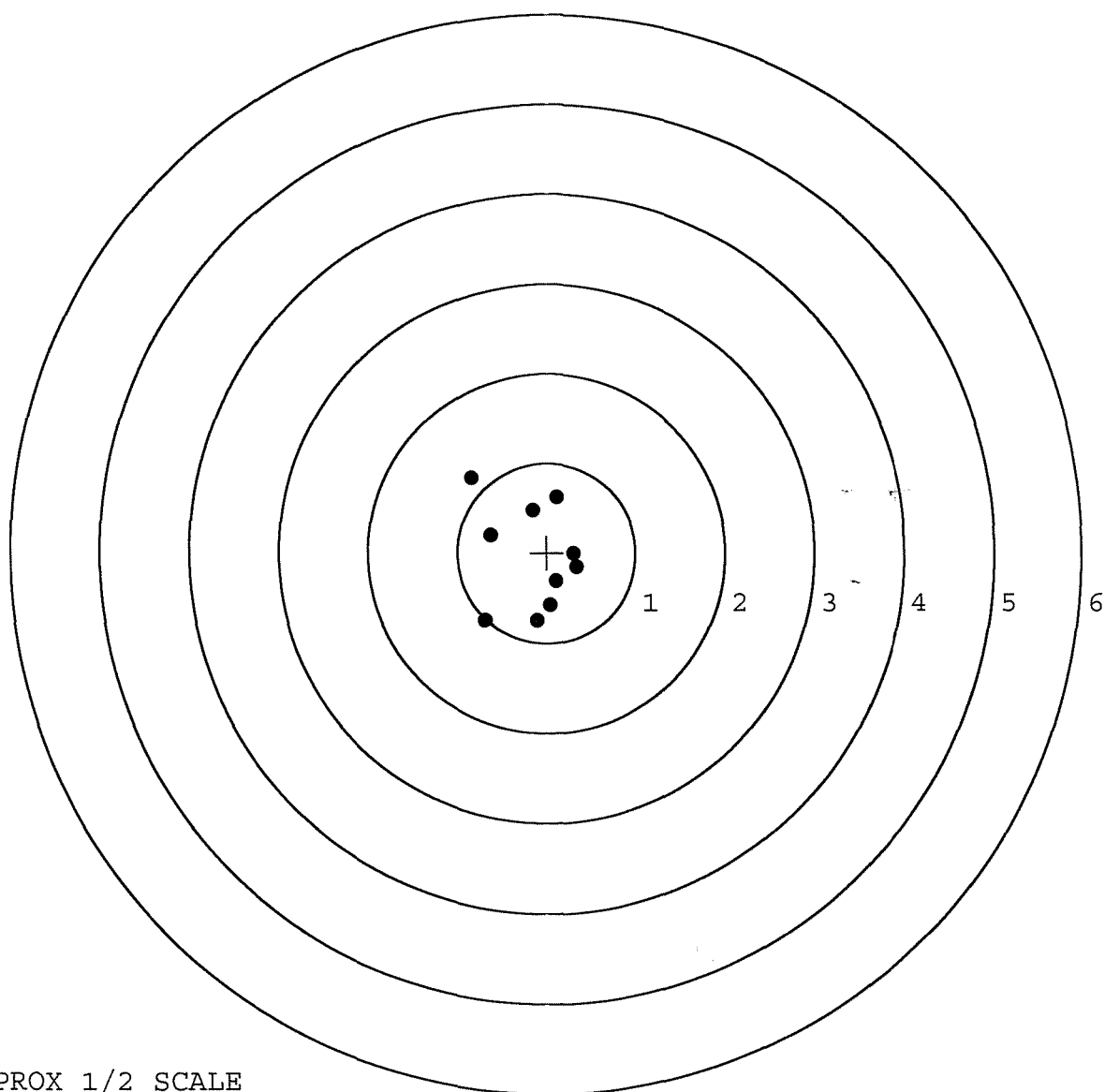
MAX RADIUS: 1.119

MEAN RADIUS: 0.639

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

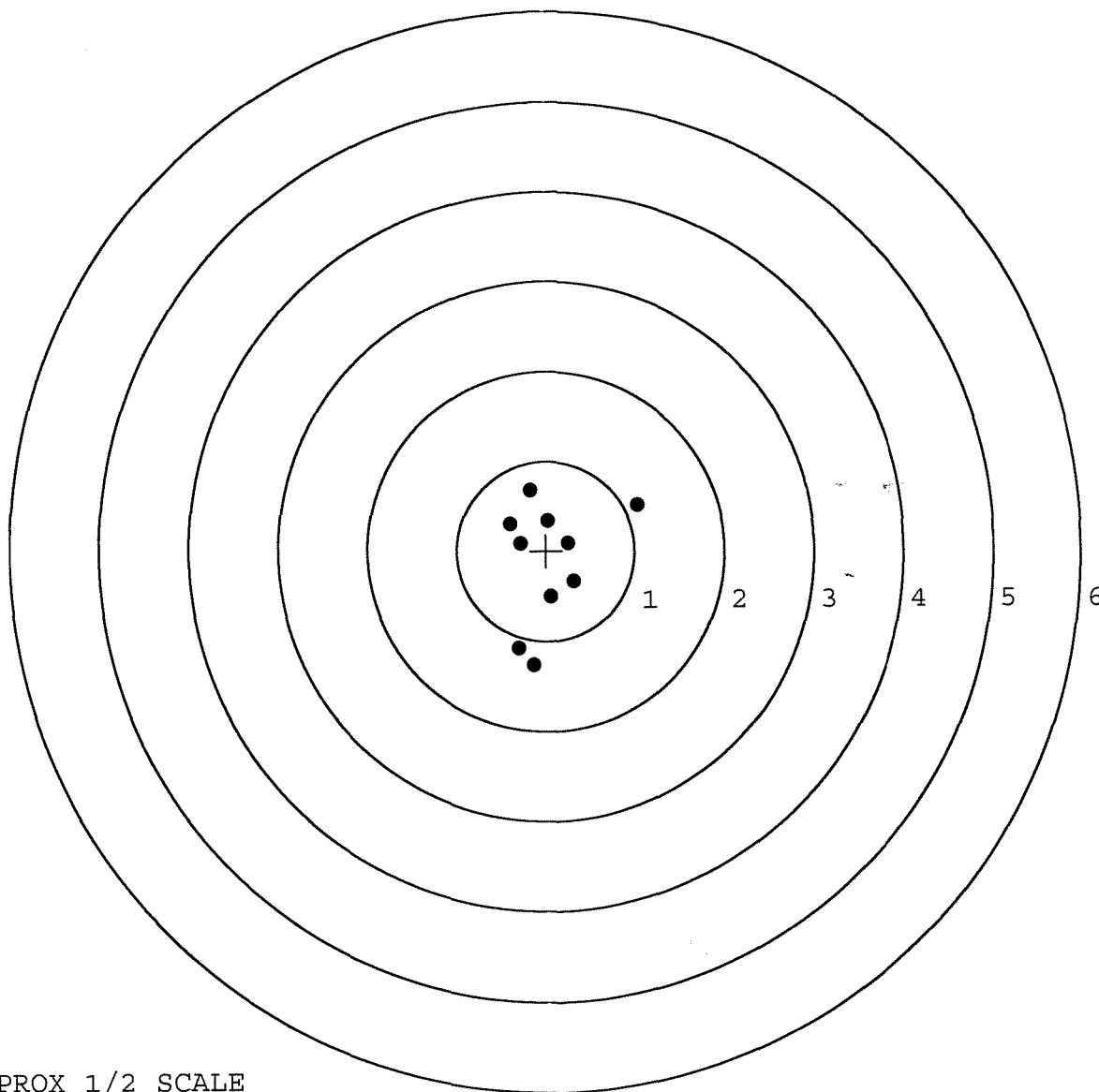


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461656. __0
TARGET NUMBER: 3
FILE DATE: 05/20/2005
FILE TIME: 06:48

POINT#	X	Y
1:	1.032	0.509
2:	0.253	0.093
3:	0.309	-0.343
4:	0.049	-0.519
5:	-0.147	-1.267
6:	-0.319	-1.083
7:	-0.183	0.674
8:	0.026	0.339
9:	-0.292	0.082
10:	-0.405	0.303

X CENTROID: 0.032
Y CENTROID: -0.121
POA TO CENTROID: 0.125
HORZ SPREAD: 1.437
VERT SPREAD: 1.941
GROUP SPREAD: 2.132
MIN RADIUS: 0.308
MAX RADIUS: 1.182
MEAN RADIUS: 0.670
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461656. __0

TARGET NUMBER: 4

FILE DATE: 05/20/2005

FILE TIME: 06:48

POINT#	X	Y
1:	1.689	0.879
2:	0.640	0.030
3:	-0.311	0.503
4:	-0.630	0.145
5:	-0.826	0.638
6:	0.672	-0.015
7:	0.163	-0.509
8:	-0.126	-0.235
9:	0.048	0.090
10:	0.186	-0.351

X CENTROID: 0.150

Y CENTROID: 0.117

POA TO CENTROID: 0.191

HORZ SPREAD: 2.515

VERT SPREAD: 1.388

GROUP SPREAD: 2.527

MIN RADIUS: 0.106

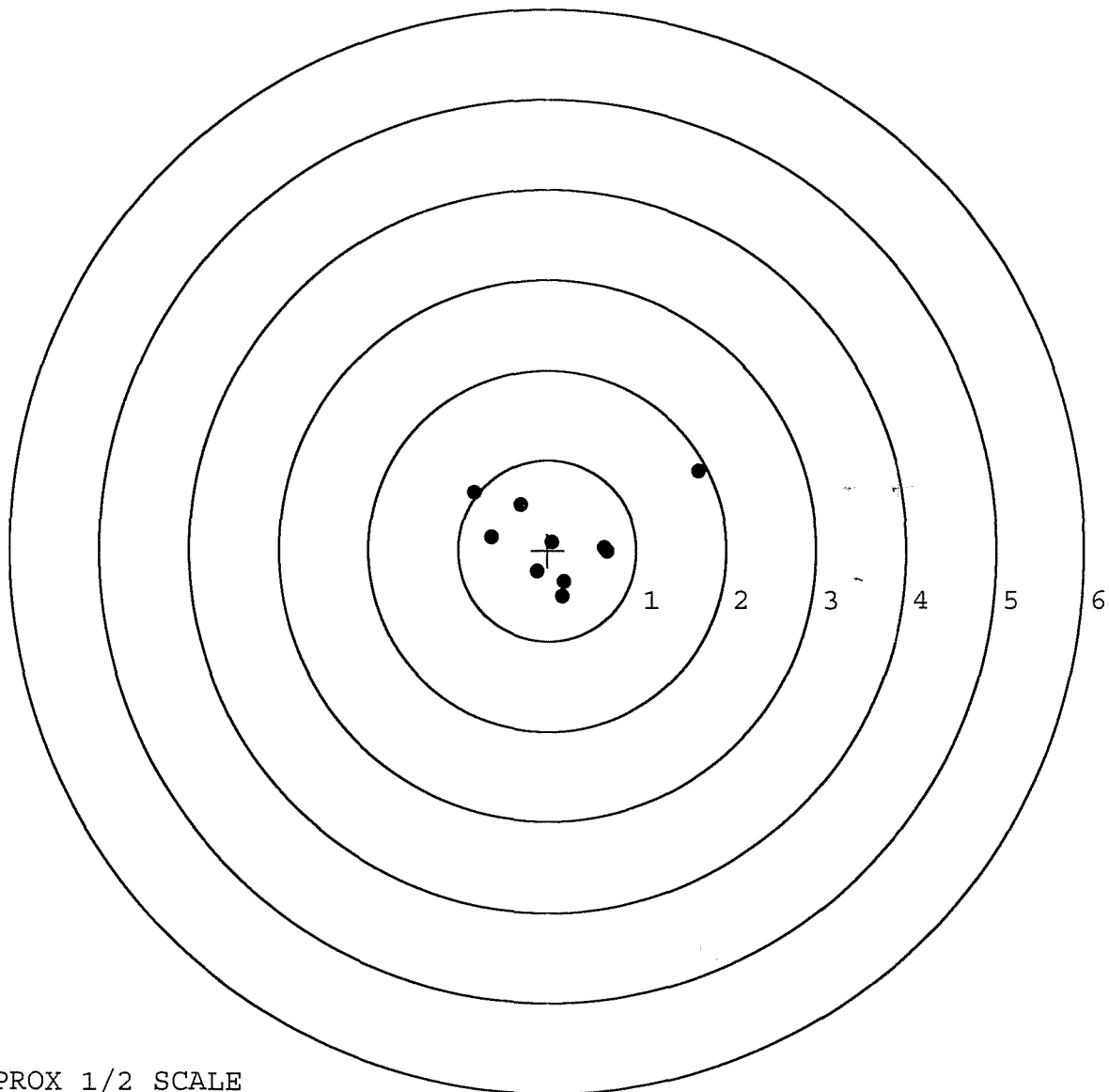
MAX RADIUS: 1.717

MEAN RADIUS: 0.689

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461656. __0

TARGET NUMBER: 5

FILE DATE: 05/20/2005

FILE TIME: 06:48

POINT#	X	Y
1:	1.591	0.092
2:	0.884	-0.392
3:	0.277	-1.152
4:	-1.169	-0.708
5:	-0.492	-0.197
6:	-0.682	0.778
7:	0.441	-0.234
8:	0.451	-0.033
9:	0.440	0.191
10:	0.192	0.323

X CENTROID: 0.193

Y CENTROID: -0.133

POA TO CENTROID: 0.235

HORZ SPREAD: 2.760

VERT SPREAD: 1.930

GROUP SPREAD: 2.874

MIN RADIUS: 0.267

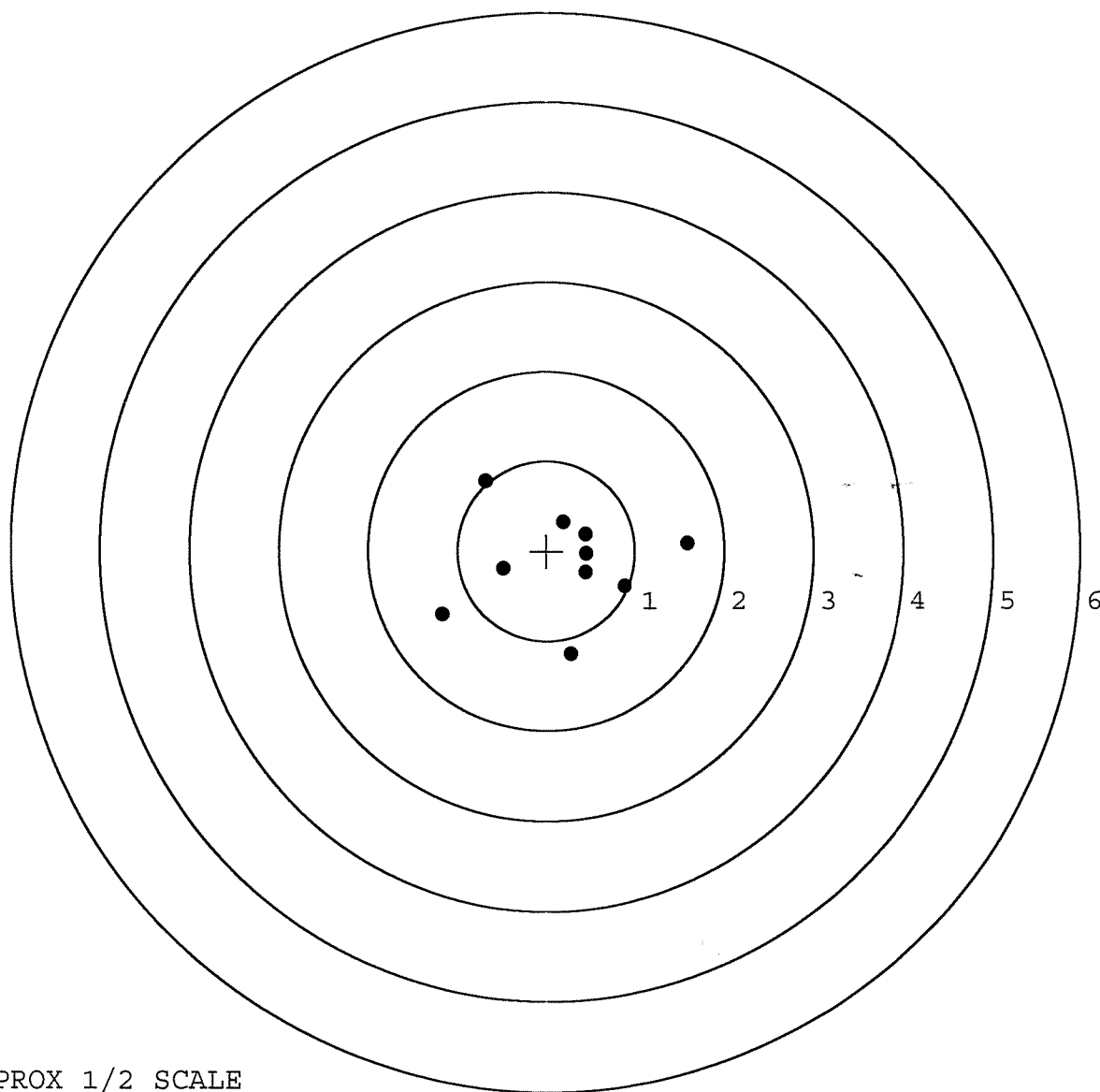
MAX RADIUS: 1.479

MEAN RADIUS: 0.801

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE