

G 646 1670

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

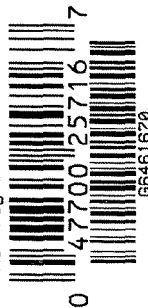
- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



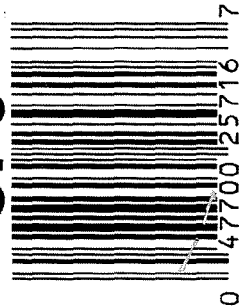
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461670

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC



SERIAL NO.



8/11/2005 9:22:37 AM

Original

31

Original

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

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461670

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	MAGNA-FLUX	9-13-05	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 PERATOR arms	9/14/05	arms
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		9-30-05	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>5 lbs</u> <u>5 lbs</u> <u>5 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>.024</u> <u>.022</u> <u>.022</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		9-30-05	RT
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-3-05	RT
	M) IRON SIGHT ALIGNMENT		10-3-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-3-05	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10-11-05	RT
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-11-05	ST
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.59</u> <u>2.59</u> <u>2.79</u> <u>2.79</u>	10-11-05	TRW
	C) FUNCTION		10-11-05	Ac
690	PACK			

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 9/29/05

TESTER RC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.53	2.50		2.13	
PULL #2	2.45	2.34		2.66	
PULL #3	2.70	2.42		2.69	
PULL #4	2.98	2.53		2.59	
PULL #5	2.82	2.50		2.47	
TOTAL	13.48	12.29		12.54	
AVERAGE	2.70	2.46		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.10		
PULL #2	2.87	2.76		
PULL #3	3.26	2.89		
PULL #4	3.28	3.01		
PULL #5	3.62	3.16		
TOTAL	16.39	14.92		
AVERAGE	3.28	2.98		

	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	4.35	4.24		4.42
PULL #2	4.34	4.21		4.08
PULL #3	3.67	4.41		4.43
PULL #4	4.43	4.38		4.62
PULL #5	4.20	4.19		4.30
TOTAL	20.99	21.43		21.85
AVERAGE	4.20	4.29		4.37

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461670.__0

FILE DATE AND TIME: 10/11/2005 10:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.036
The Average Y Centroid of the Five Target Set:	-0.108
The Average Point of Impact of the Five Target Set:	0.114
The Average Mean Radius of the Five Target Set:	0.898
The Distance from POA to Centroid Target #1:	0.376
The Distance from Centroid Target #2 to Centroid Target #1:	0.323
The Distance from Centroid Target #3 to Centroid Target #1:	0.242
The Distance from Centroid Target #4 to Centroid Target #1:	0.451
The Distance from Centroid Target #5 to Centroid Target #1:	0.320

SERIAL NUMBER: G6461670. 0

TARGET NUMBER: 1

FILE DATE: 10/11/2005

FILE TIME: 10:03

X CENTROID: 0.120

Y CENTROID: -0.356

POA TO CENTROID: 0.376

HORZ SPREAD: 2.146

VERT SPREAD: 2.801

GROUP SPREAD: 3.161

MIN RADIUS: 0.592

MAX RADIUS: 1.754

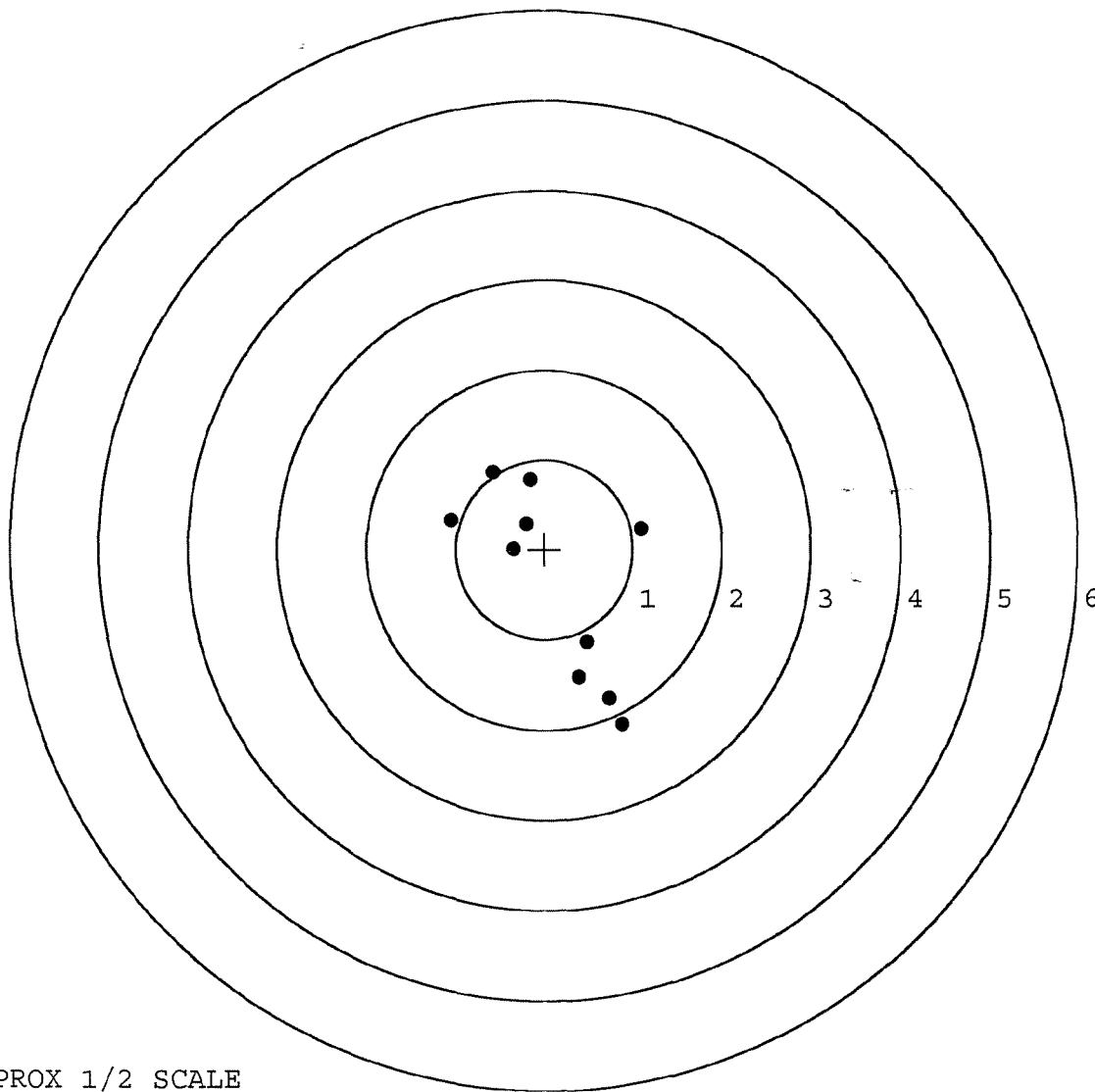
MEAN RADIUS: 1.143

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.879	-1.938
2:	0.732	-1.652
3:	0.392	-1.417
4:	0.481	-1.032
5:	1.087	0.228
6:	-0.352	0.001
7:	-0.208	0.286
8:	-0.164	0.774
9:	-0.586	0.863
10:	-1.059	0.324



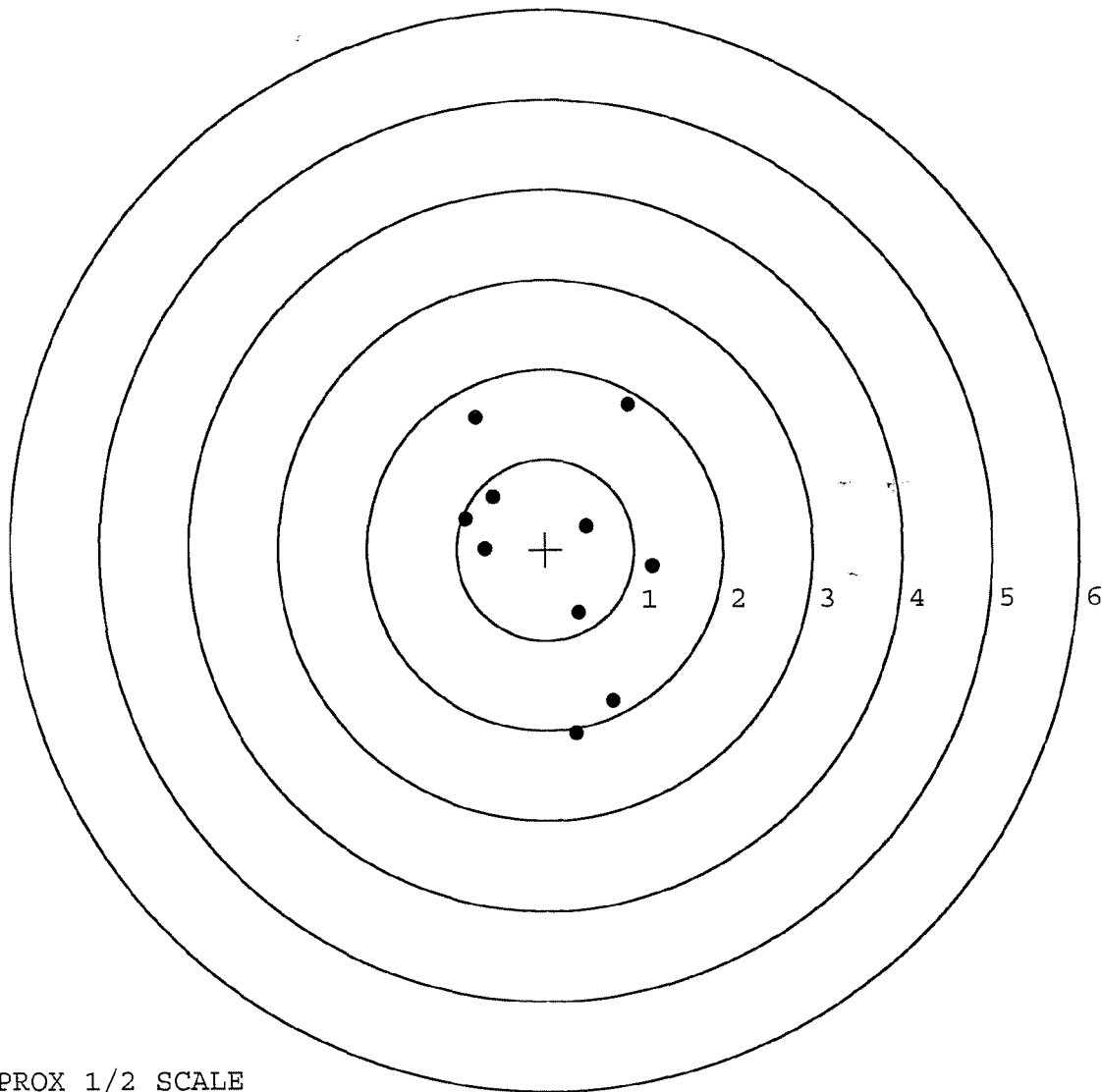
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461670. __0
TARGET NUMBER: 2
FILE DATE: 10/11/2005
FILE TIME: 10:03

X CENTROID: 0.110
Y CENTROID: -0.033
POA TO CENTROID: 0.114
HORZ SPREAD: 2.109
VERT SPREAD: 3.641
GROUP SPREAD: 3.690
MIN RADIUS: 0.449
MAX RADIUS: 2.018
MEAN RADIUS: 1.244

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.748	-1.679
2:	0.338	-2.038
3:	1.206	-0.191
4:	0.372	-0.695
5:	0.454	0.254
6:	-0.683	0.014
7:	-0.903	0.345
8:	-0.594	0.584
9:	-0.783	1.469
10:	0.940	1.603

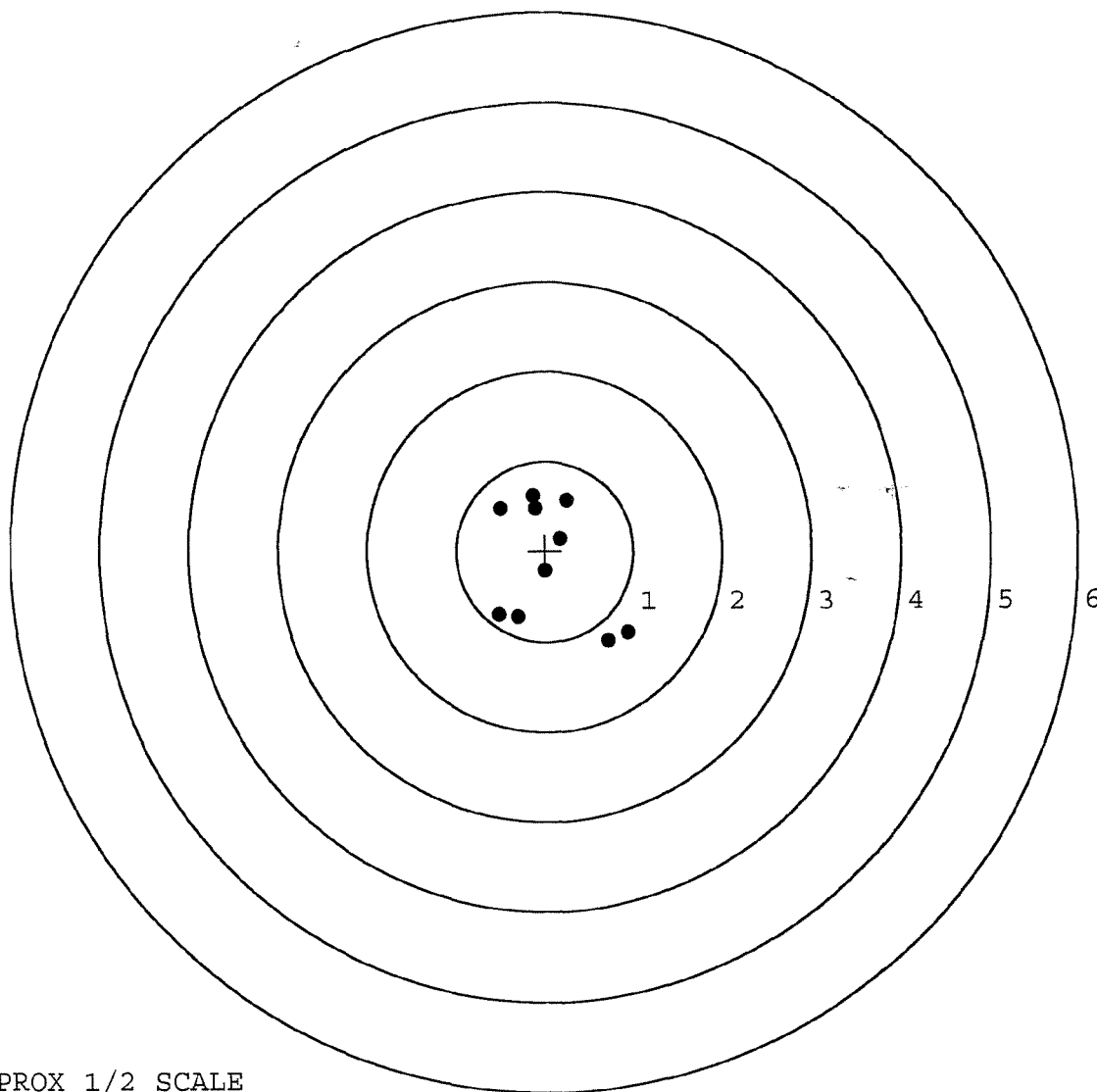


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461670. 0
TARGET NUMBER: 3
FILE DATE: 10/11/2005
FILE TIME: 10:03

X CENTROID: 0.044
Y CENTROID: -0.127
POA TO CENTROID: 0.134
HORZ SPREAD: 1.459
VERT SPREAD: 1.608
GROUP SPREAD: 1.994
MIN RADIUS: 0.111
MAX RADIUS: 1.177
MEAN RADIUS: 0.713
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.928	-0.904
2:	0.709	-0.988
3:	-0.315	-0.730
4:	-0.531	-0.703
5:	-0.007	-0.226
6:	0.173	0.135
7:	0.246	0.573
8:	-0.141	0.620
9:	-0.114	0.476
10:	-0.509	0.479



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461670. 0

TARGET NUMBER: 4

FILE DATE: 10/11/2005

FILE TIME: 10:03

X CENTROID: -0.028

Y CENTROID: 0.070

POA TO CENTROID: 0.075

HORZ SPREAD: 1.764

VERT SPREAD: 1.588

GROUP SPREAD: 1.916

MIN RADIUS: 0.075

MAX RADIUS: 1.098

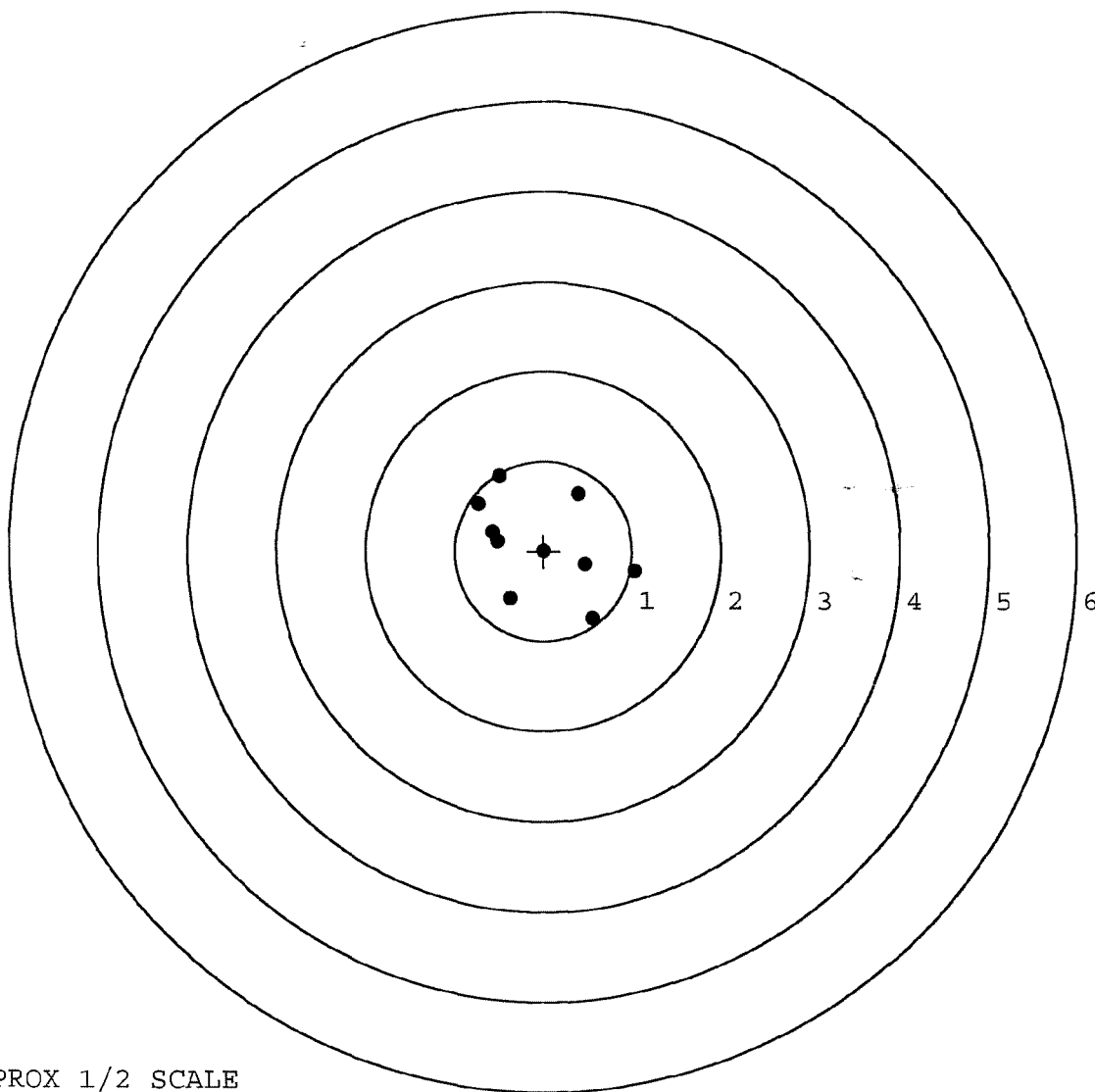
MEAN RADIUS: 0.693

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.551	-0.751
2:	1.030	-0.222
3:	0.468	-0.146
4:	0.387	0.642
5:	-0.001	0.000
6:	-0.384	-0.527
7:	-0.524	0.118
8:	-0.575	0.220
9:	-0.734	0.527
10:	-0.500	0.837



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461670. 0

TARGET NUMBER: 5

FILE DATE: 10/11/2005

FILE TIME: 10:03

X CENTROID: -0.065

Y CENTROID: -0.095

POA TO CENTROID: 0.115

HORZ SPREAD: 1.443

VERT SPREAD: 1.873

GROUP SPREAD: 2.335

MIN RADIUS: 0.210

MAX RADIUS: 1.267

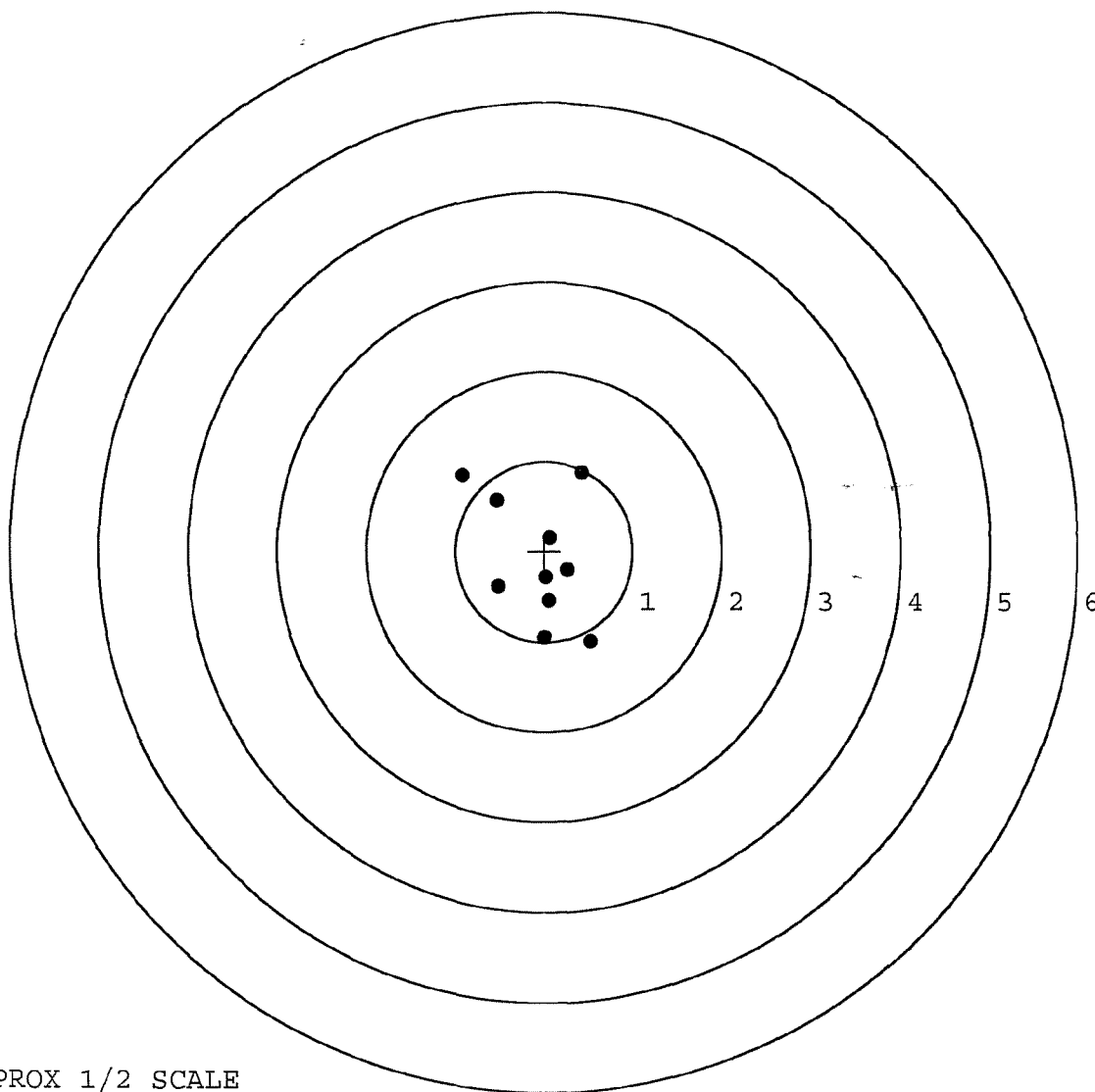
MEAN RADIUS: 0.696

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.522	-0.996
2:	-0.004	-0.955
3:	0.048	-0.548
4:	-0.526	-0.392
5:	0.266	-0.203
6:	0.020	-0.287
7:	0.062	0.151
8:	-0.546	0.562
9:	-0.921	0.840
10:	0.424	0.877



TARGET APPROX 1/2 SCALE