

G641704

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



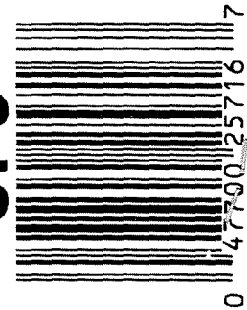
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461704

UPC



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

UPC



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

UPC



SERIAL NO.



8/11/2005 9:26:28 AM

Copy

47

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 # 66461704

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 INSPECTED	9-13-05	RTZ
470	DIS-ASSEMBLE ACTION	SET - 0.00	9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <i>unit</i>	9/14/05	<i>unit</i>
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		9-28-05	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	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		9-29-05	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>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>.022</u> <u>.022</u> <u>.022</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		9-29-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-29-05	RTL
	M) IRON SIGHT ALIGNMENT		9-29-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-29-05	RTL
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	9-29-05	TRW
	MALFUNCTION <u>BAC</u>	CORRECTION <u>OK</u>	9-29-05	TRW
	MALFUNCTION <u>OH</u>	CORRECTION <u>OK</u>	9-29-05	TRW
	MALFUNCTION <u>CH</u>	CORRECTION <u>OK</u>	9-25-05	TRW
	MALFUNCTION	CORRECTION	9-25-05	TRW
660	INSPECT FOR LIVE AMMO		9-29-05	ST
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.83</u> <u>2.85</u> <u>2.64</u> <u>2.77</u>	10-7-05	BC
	C) FUNCTION		10-11-05	Ac
690	PACK		10-12-05	DA

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

9/21/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.40		2.28	
PULL #2	2.37	2.31		2.55	
PULL #3	2.49	2.56		2.33	
PULL #4	2.61	2.37		2.28	
PULL #5	2.50	2.30		2.74	
TOTAL	12.43	11.94		12.18	
AVERAGE	2.49	2.39		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.57		
PULL #2	3.10	3.05		
PULL #3	3.20	3.14		
PULL #4	3.19	2.95		
PULL #5	3.30	3.05		
TOTAL	15.92	15.76		
AVERAGE	3.18	3.15		

	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	4.23		4.07
PULL #2	4.34	4.33		4.12
PULL #3	4.14	4.45		4.14
PULL #4	4.05	4.41		4.26
PULL #5	4.10	4.55		3.99
TOTAL	20.98	21.97		20.58
AVERAGE	4.20	4.39		4.12

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461704. __0

FILE DATE AND TIME: 09/29/2005 11:20

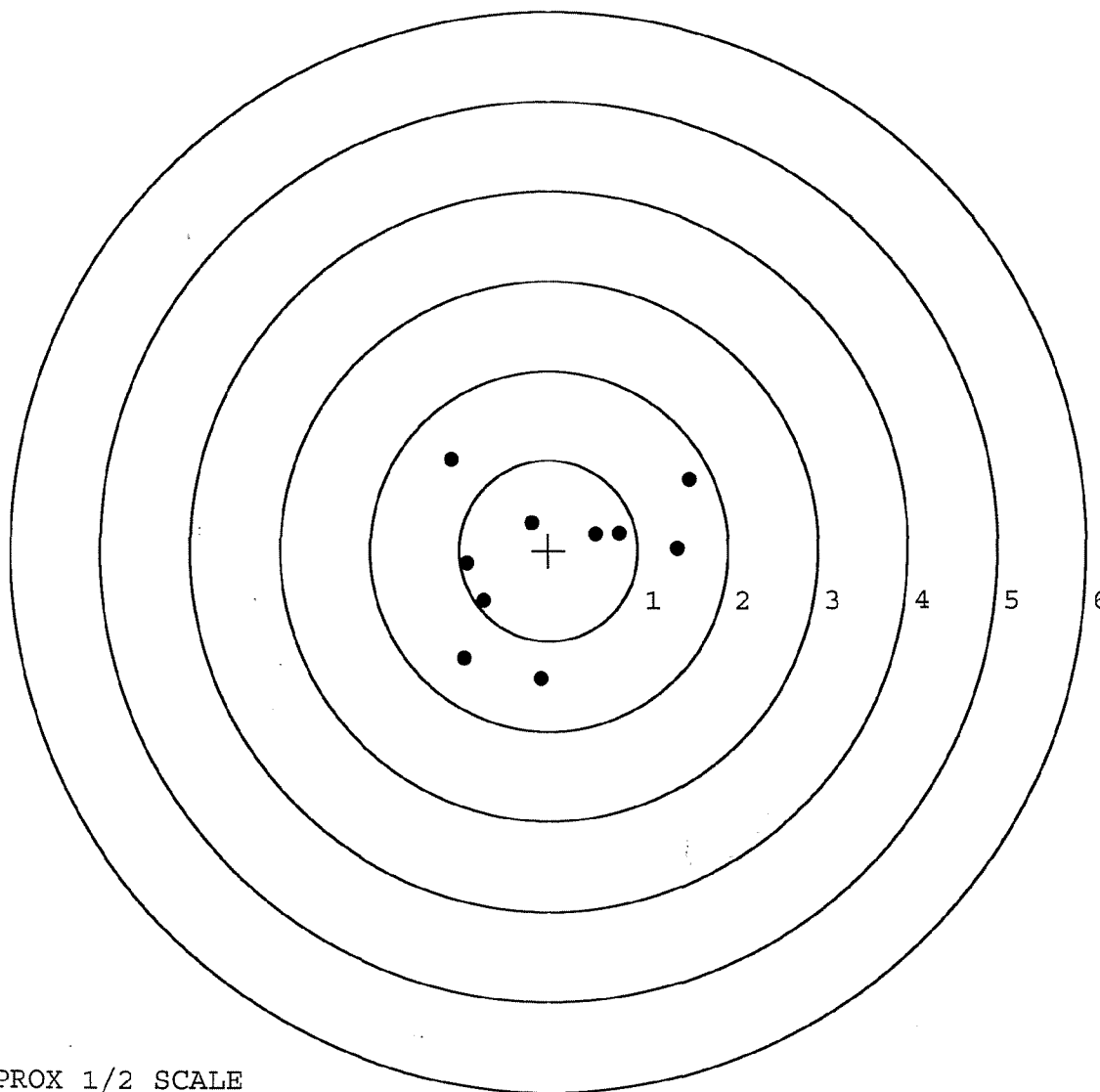
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.037
The Average Y Centroid of the Five Target Set:	-0.053
The Average Point of Impact of the Five Target Set:	0.065
The Average Mean Radius of the Five Target Set:	1.126
The Distance from POA to Centroid Target #1:	0.090
The Distance from Centroid Target #2 to Centroid Target #1:	0.794
The Distance from Centroid Target #3 to Centroid Target #1:	0.252
The Distance from Centroid Target #4 to Centroid Target #1:	0.018
The Distance from Centroid Target #5 to Centroid Target #1:	0.262

SERIAL NUMBER: G6461704. __0
TARGET NUMBER: 1
FILE DATE: 09/29/2005
FILE TIME: 11:20

X CENTROID: 0.034
Y CENTROID: -0.083
POA TO CENTROID: 0.090
HORZ SPREAD: 2.656
VERT SPREAD: 2.427
GROUP SPREAD: 3.205
MIN RADIUS: 0.449
MAX RADIUS: 1.760
MEAN RADIUS: 1.123
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.090	-1.426
2:	-0.949	-1.200
3:	-0.727	-0.554
4:	-0.914	-0.146
5:	-0.197	0.302
6:	0.522	0.186
7:	0.790	0.190
8:	1.440	0.023
9:	1.562	0.791
10:	-1.094	1.001



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461704. __0

TARGET NUMBER: 2

FILE DATE: 09/29/2005

FILE TIME: 11:20

POINT#	X	Y
1:	1.072	-0.367
2:	0.191	-0.467
3:	-0.342	0.138
4:	0.101	0.387
5:	-0.521	1.099
6:	-1.247	1.525
7:	-1.677	1.355
8:	-1.915	-0.340
9:	-2.596	-0.838
10:	-0.449	-1.496

X CENTROID: -0.738

Y CENTROID: 0.100

POA TO CENTROID: 0.745

HORZ SPREAD: 3.668

VERT SPREAD: 3.021

GROUP SPREAD: 3.698

MIN RADIUS: 0.398

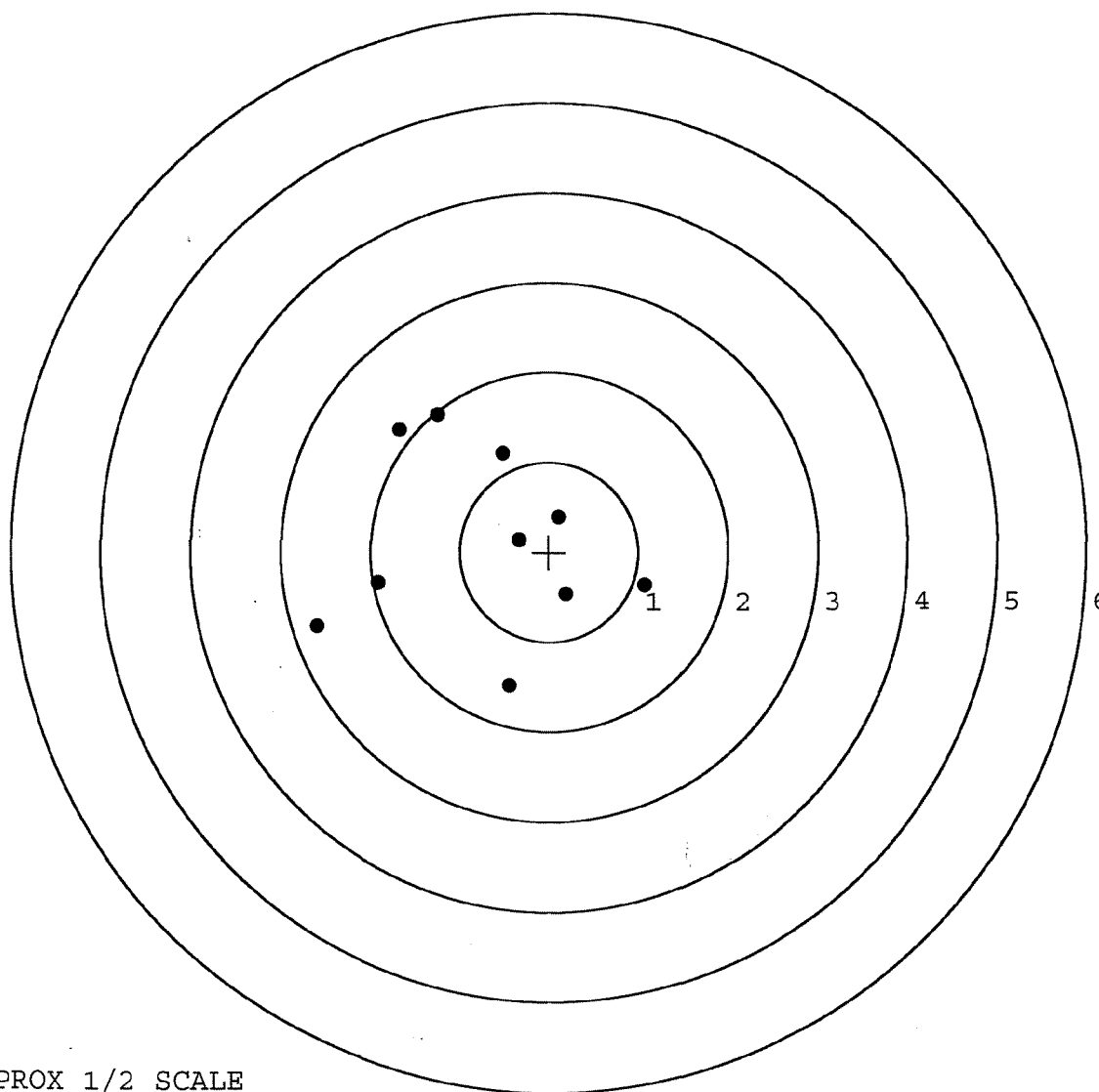
MAX RADIUS: 2.081

MEAN RADIUS: 1.331

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 5



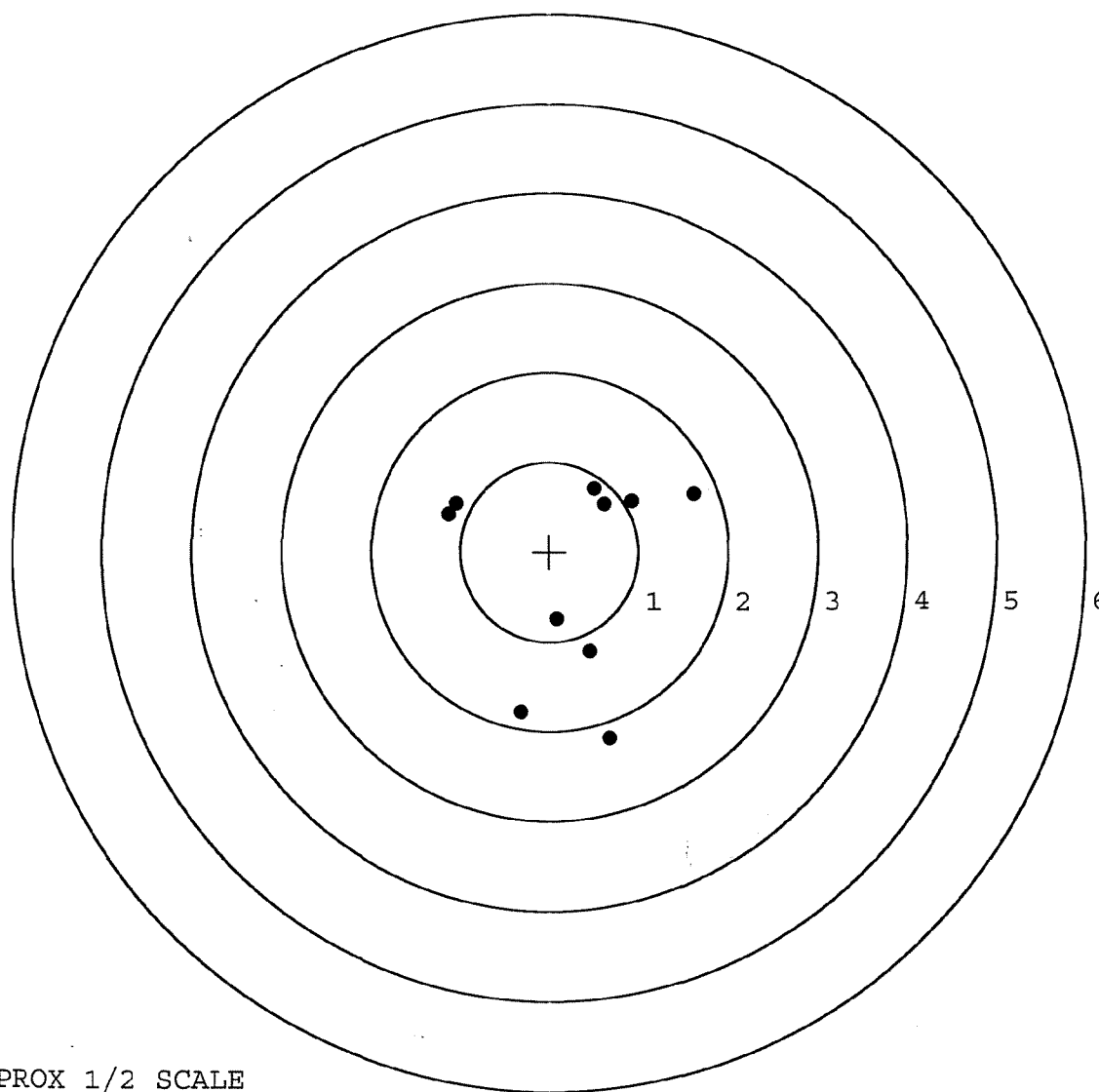
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461704. 0
TARGET NUMBER: 3
FILE DATE: 09/29/2005
FILE TIME: 11:20

POINT#	X	Y
1:	1.610	0.649
2:	0.932	0.563
3:	0.500	0.701
4:	-1.050	0.538
5:	-1.135	0.418
6:	0.084	-0.750
7:	0.455	-1.113
8:	-0.326	-1.793
9:	0.678	-2.086
10:	0.615	0.528

X CENTROID: 0.236
Y CENTROID: -0.235
POA TO CENTROID: 0.333
HORZ SPREAD: 2.745
VERT SPREAD: 2.787
GROUP SPREAD: 3.142
MIN RADIUS: 0.538
MAX RADIUS: 1.903
MEAN RADIUS: 1.254

IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461704. 0

TARGET NUMBER: 4

FILE DATE: 09/29/2005

FILE TIME: 11:20

POINT#	X	Y
1:	0.960	-1.828
2:	-0.188	-1.214
3:	0.161	-0.896
4:	0.922	-0.511
5:	-0.009	-0.032
6:	-0.462	-0.052
7:	-0.256	0.470
8:	0.298	0.621
9:	-0.867	0.876
10:	-0.359	1.629

X CENTROID: 0.020

Y CENTROID: -0.094

POA TO CENTROID: 0.096

HORZ SPREAD: 1.827

VERT SPREAD: 3.457

GROUP SPREAD: 3.700

MIN RADIUS: 0.068

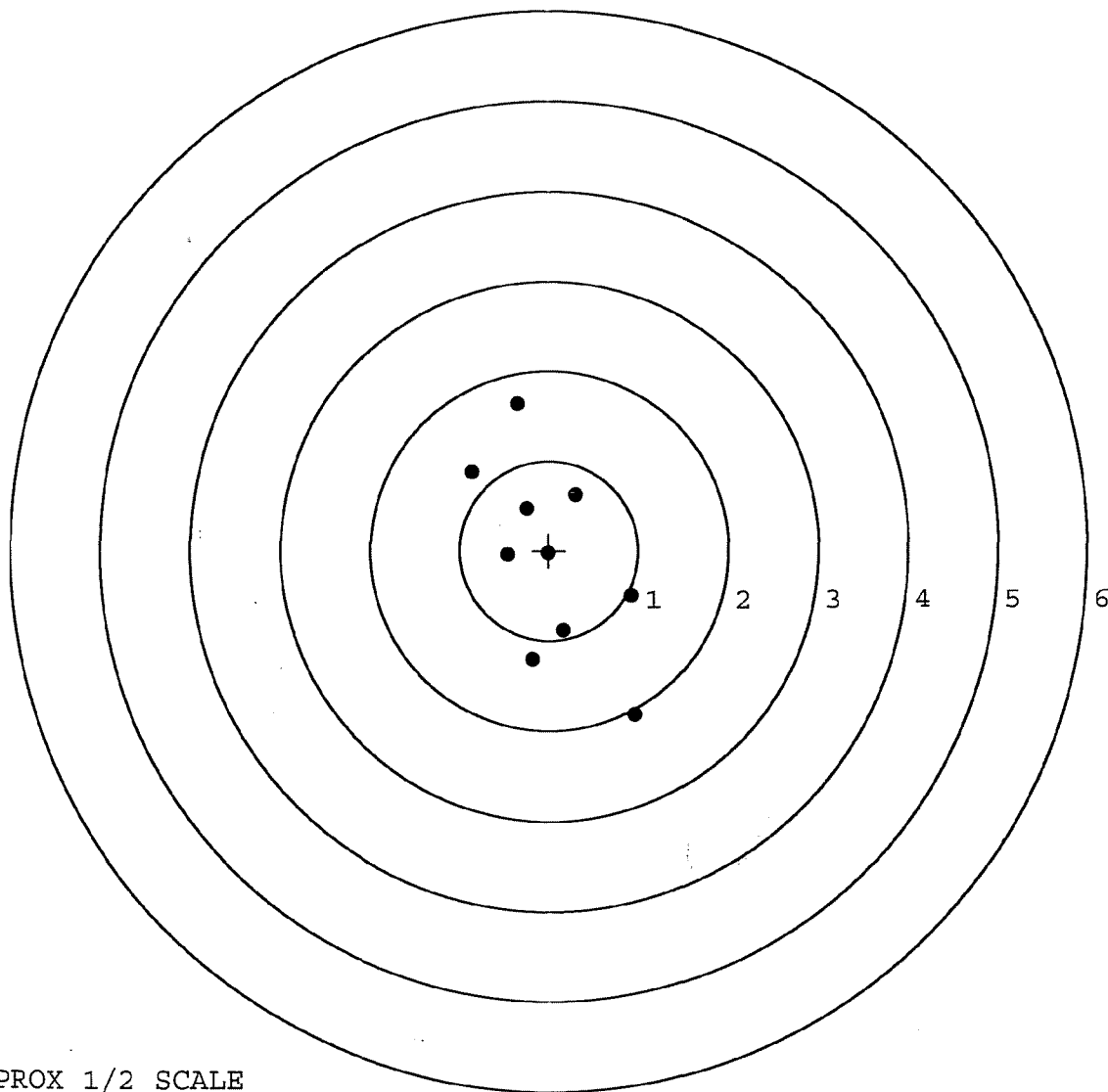
MAX RADIUS: 1.973

MEAN RADIUS: 0.995

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

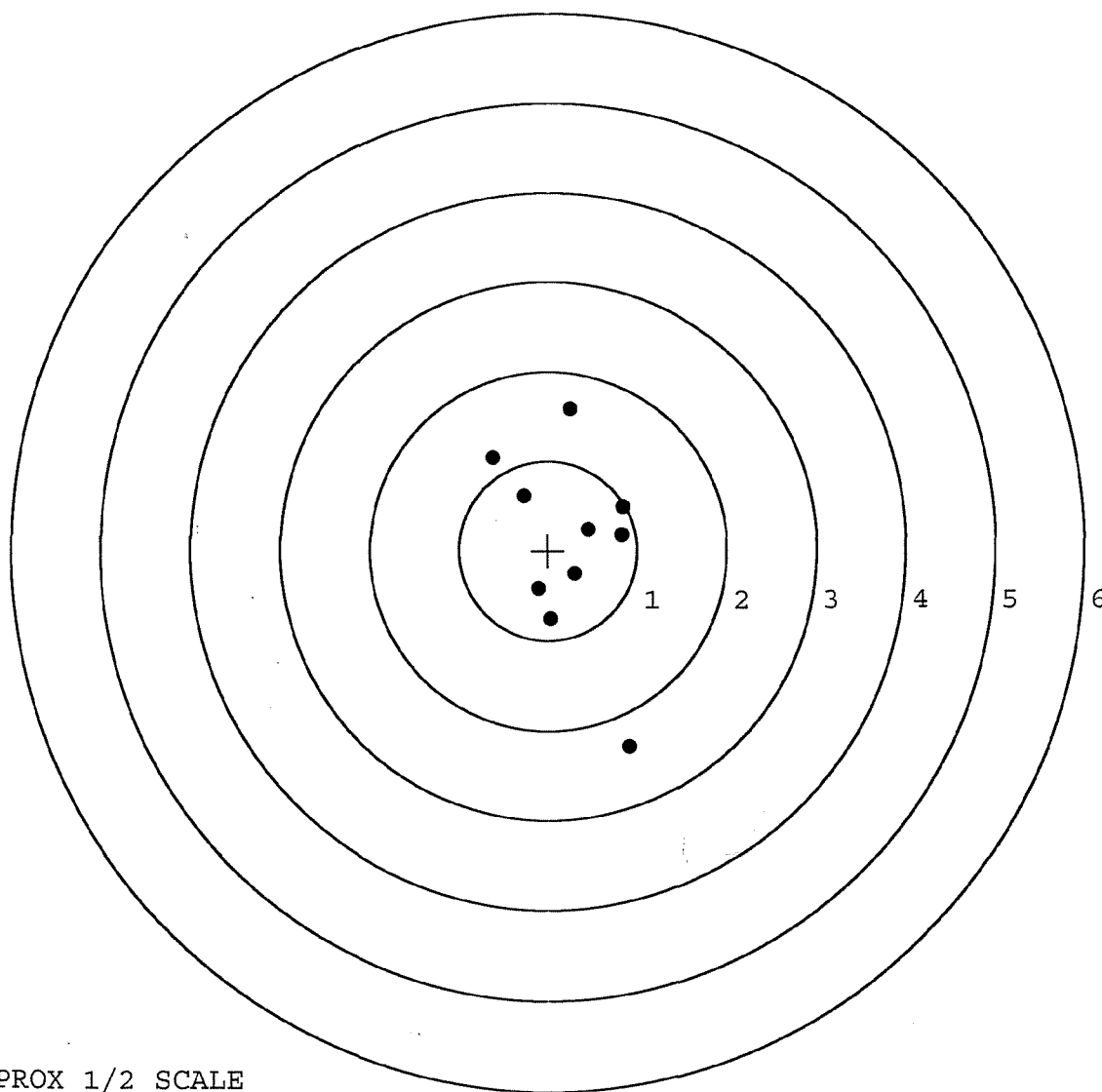


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461704. __0
TARGET NUMBER: 5
FILE DATE: 09/29/2005
FILE TIME: 11:20

X CENTROID: 0.260
Y CENTROID: 0.049
POA TO CENTROID: 0.265
HORZ SPREAD: 1.531
VERT SPREAD: 3.764
GROUP SPREAD: 3.821
MIN RADIUS: 0.268
MAX RADIUS: 2.322
MEAN RADIUS: 0.931
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.910	-2.180
2:	0.027	-0.772
3:	-0.110	-0.430
4:	0.306	-0.262
5:	0.451	0.238
6:	0.821	0.174
7:	0.844	0.492
8:	-0.277	0.609
9:	-0.621	1.038
10:	0.253	1.584



TARGET APPROX 1/2 SCALE