

G6461774

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.



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



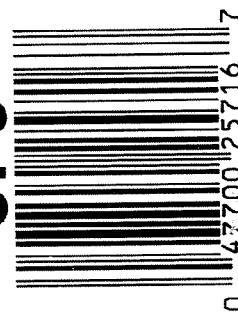
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461774

UPC



6/17/2005 2:12:04 PM

Crnb

13

Original

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0004012773

0540

Flat Black Powder Coat, Barrel and

01PC001



0004012763

0560

Reassemble Action.

89SWS1



0004012764

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461774

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	WD
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9/30	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	MTM
	D) OIL FIRING PIN ASSEMBLY		10-12-05	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>7 1/6</u> <u>7 1/6</u> <u>7 1/6</u>	10/25/05	BG
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 1/6</u> <u>4 1/6</u> <u>4 1/6</u>	10/25/05	BG
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10/25/05	BG
	J) ASSEMBLE STOCK		10-22-05	RJR
	K) ASSEMBLE SWIVEL STUDS		10/25/05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-17-05	BG
	M) IRON SIGHT ALIGNMENT		10-17-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-17-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/13/05	MJP
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/18/05	S.F.
670	FINAL INSPECTION A) HEADSPACE		10/25/05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.89</u> <u>2.07</u> <u>2.28</u> <u>2.17</u>	10-25-05	TRW
	C) FUNCTION		10/25/05	BG
690	PACK		10/26/05	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 10-3-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.45	2.43		2.63	
PULL #2	2.77	2.53		2.62	
PULL #3	2.71	2.53		2.64	
PULL #4	2.47	2.51		2.63	
PULL #5	2.28	2.54		2.49	
TOTAL	12.68	12.54		13.01	
AVERAGE	2.53	2.50		2.60	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.99	3.02		
PULL #2	3.22	3.05		
PULL #3	3.18	2.99		
PULL #4	3.08	3.17		
PULL #5	3.08	3.20		
TOTAL	15.55	15.43		
AVERAGE	3.11	3.08		

	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	4.17	4.13		4.40
PULL #2	4.34	3.94		4.35
PULL #3	4.08	4.16		4.40
PULL #4	4.32	4.22		4.40
PULL #5	4.27	4.20		4.34
TOTAL	21.18	20.65		21.89
AVERAGE	4.23	4.13		4.37

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461774.___0
FILE DATE AND TIME: 10/18/2005 18:35

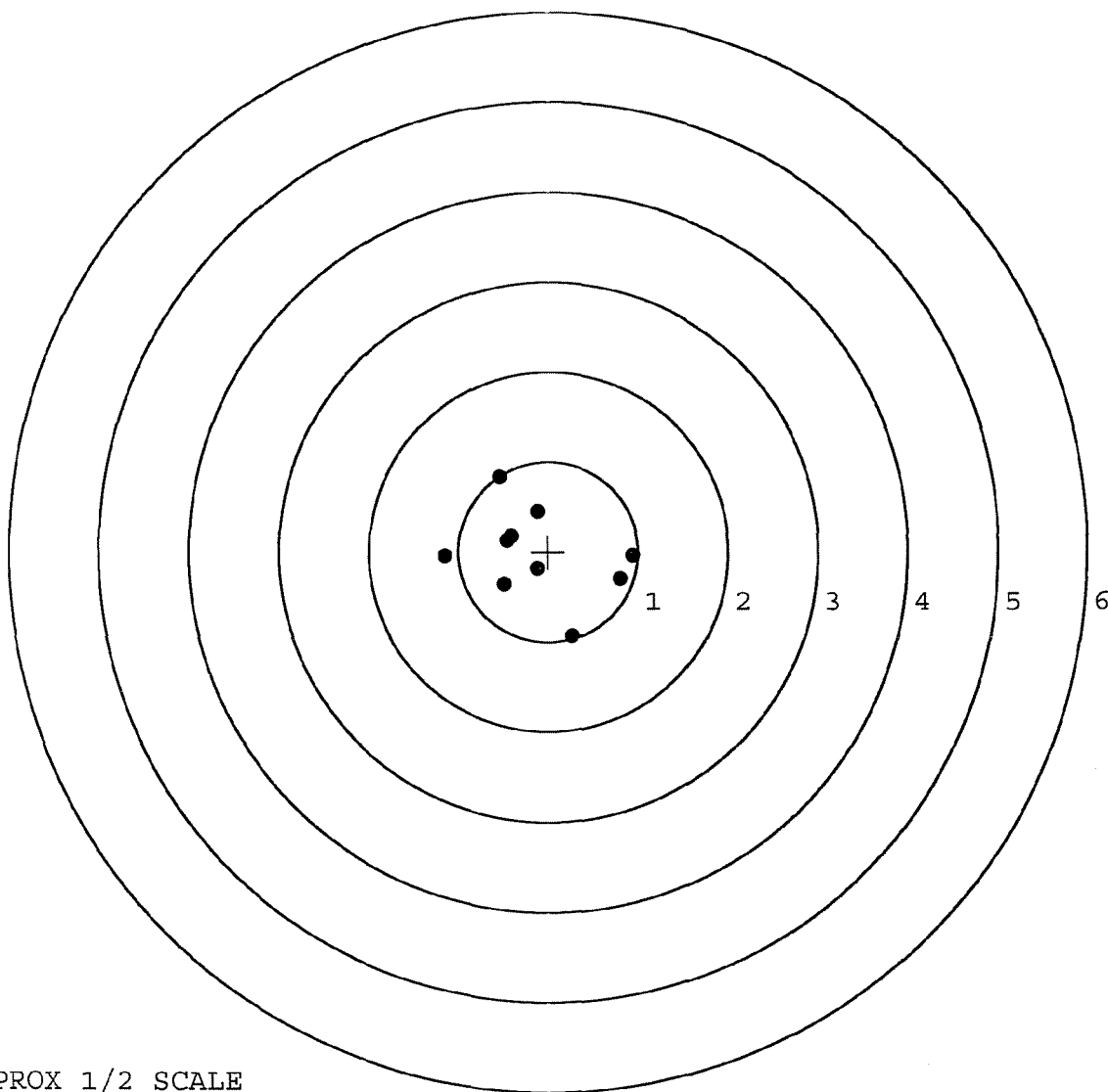
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.113
The Average Y Centroid of the Five Target Set:	0.016
The Average Point of Impact of the Five Target Set:	0.114
The Average Mean Radius of the Five Target Set:	0.789
The Distance from POA to Centroid Target #1:	0.132
The Distance from Centroid Target #2 to Centroid Target #1:	0.384
The Distance from Centroid Target #3 to Centroid Target #1:	0.092
The Distance from Centroid Target #4 to Centroid Target #1:	0.190
The Distance from Centroid Target #5 to Centroid Target #1:	0.188

SERIAL NUMBER: G6461774. __0
TARGET NUMBER: 1
FILE DATE: 10/18/2005
FILE TIME: 18:35

X CENTROID: -0.128
Y CENTROID: -0.031
POA TO CENTROID: 0.132
HORZ SPREAD: 2.094
VERT SPREAD: 1.770
GROUP SPREAD: 2.094
MIN RADIUS: 0.162
MAX RADIUS: 1.072
MEAN RADIUS: 0.687
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.126	-0.193
2:	-0.456	0.129
3:	-0.125	0.453
4:	-0.540	0.827
5:	-0.413	0.174
6:	-1.150	-0.051
7:	-0.492	-0.361
8:	0.272	-0.943
9:	0.804	-0.301
10:	0.944	-0.042

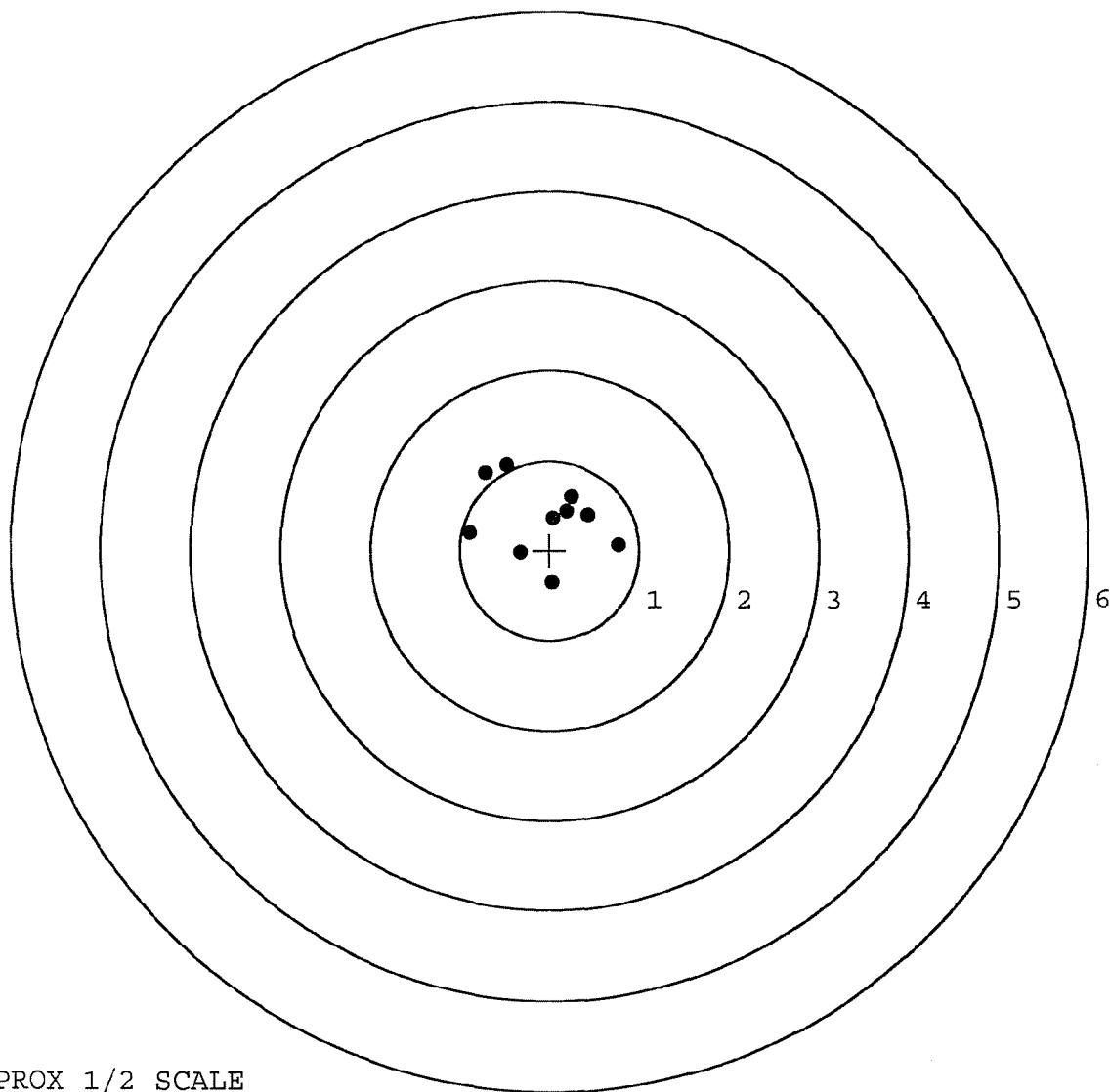


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461774. __0
TARGET NUMBER: 2
FILE DATE: 10/18/2005
FILE TIME: 18:35

X CENTROID: -0.070
Y CENTROID: 0.349
POA TO CENTROID: 0.356
HORZ SPREAD: 1.661
VERT SPREAD: 1.317
GROUP SPREAD: 1.691
MIN RADIUS: 0.104
MAX RADIUS: 0.887
MEAN RADIUS: 0.573
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.034	0.354
2:	0.430	0.400
3:	0.250	0.599
4:	0.190	0.435
5:	-0.320	-0.021
6:	-0.892	0.198
7:	-0.717	0.869
8:	-0.475	0.954
9:	0.769	0.062
10:	0.031	-0.363



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461774. 0

TARGET NUMBER: 3

FILE DATE: 10/18/2005

FILE TIME: 18:35

X CENTROID: -0.140

Y CENTROID: -0.122

POA TO CENTROID: 0.186

HORZ SPREAD: 2.596

VERT SPREAD: 2.576

GROUP SPREAD: 2.849

MIN RADIUS: 0.082

MAX RADIUS: 1.557

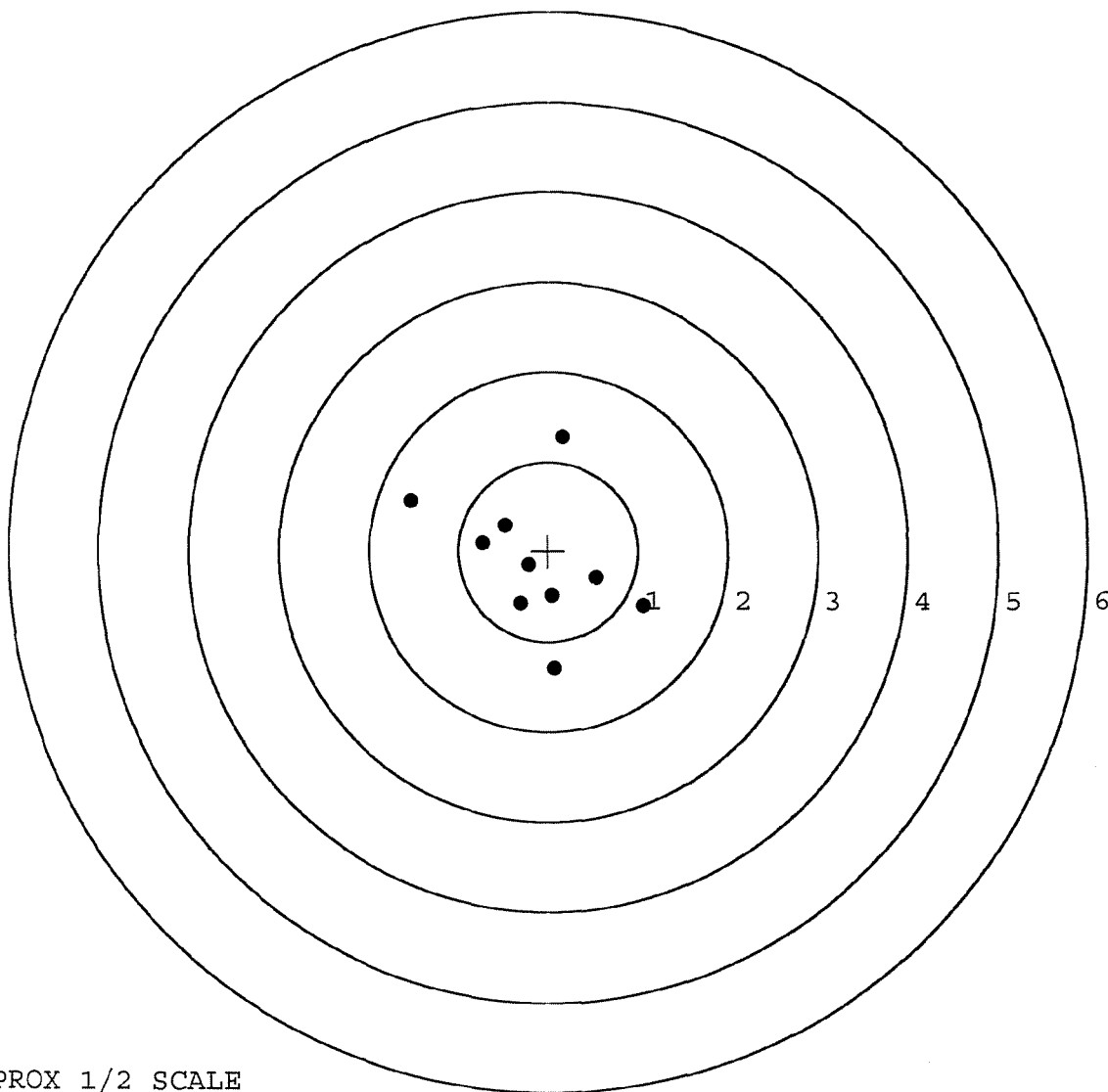
MEAN RADIUS: 0.834

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.215	-0.154
2:	0.043	-0.499
3:	-0.313	-0.580
4:	0.538	-0.296
5:	-0.486	0.291
6:	-0.729	0.093
7:	-1.538	0.562
8:	0.165	1.275
9:	0.079	-1.301
10:	1.058	-0.612



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461774. __0

TARGET NUMBER: 4

FILE DATE: 10/18/2005

FILE TIME: 18:35

POINT#	X	Y
1:	0.627	0.110
2:	0.901	0.086
3:	-0.732	0.200
4:	-0.914	0.763
5:	0.733	0.995
6:	-0.348	1.613
7:	-0.360	-0.353
8:	-0.292	-1.203
9:	0.203	-1.158
10:	0.715	-0.798

X CENTROID: 0.053

Y CENTROID: 0.025

POA TO CENTROID: 0.059

HORZ SPREAD: 1.815

VERT SPREAD: 2.816

GROUP SPREAD: 2.825

MIN RADIUS: 0.560

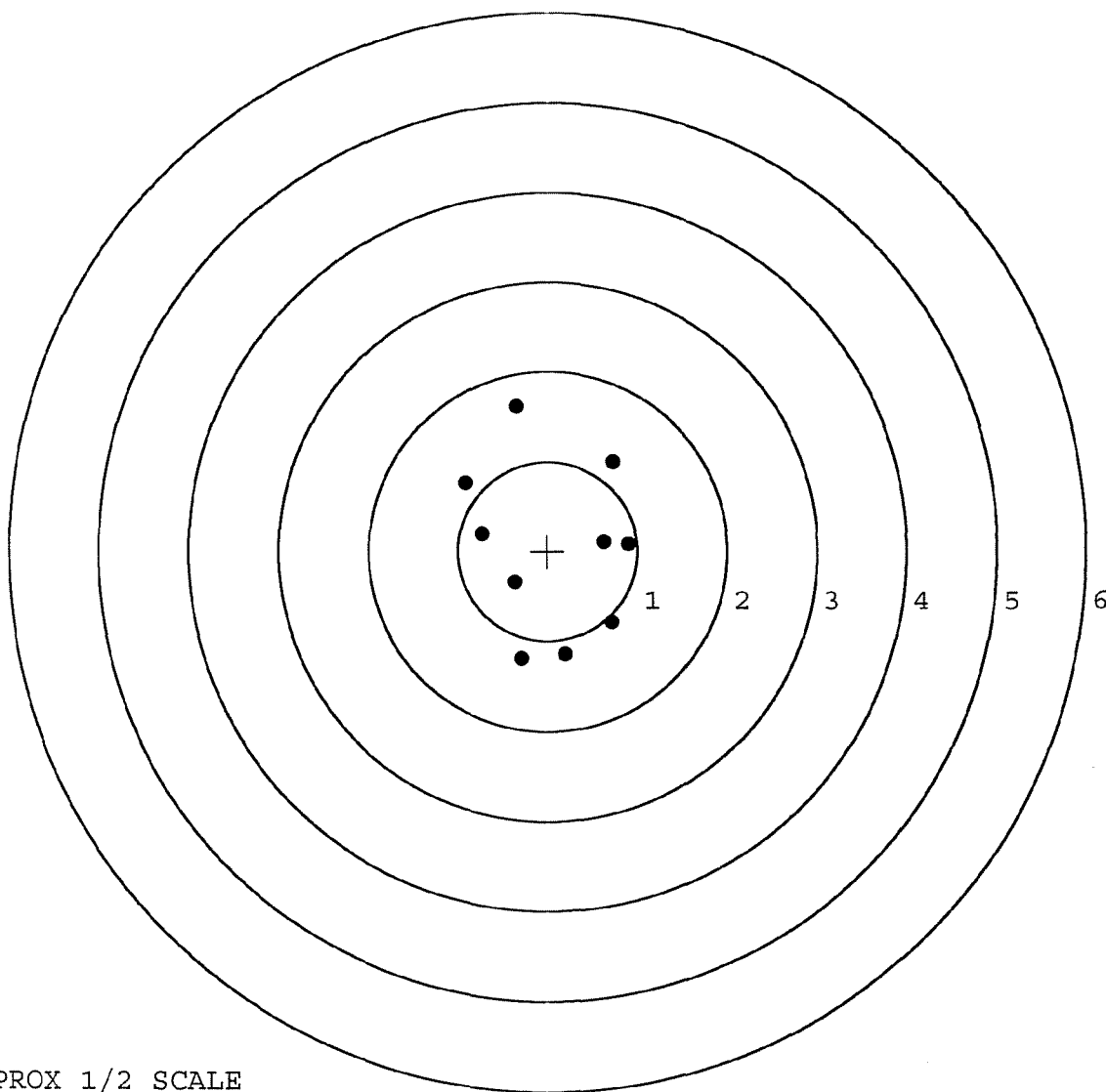
MAX RADIUS: 1.637

MEAN RADIUS: 1.036

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461774. 0

TARGET NUMBER: 5

FILE DATE: 10/18/2005

FILE TIME: 18:35

X CENTROID: -0.282

Y CENTROID: -0.140

POA TO CENTROID: 0.315

HORZ SPREAD: 1.914

VERT SPREAD: 1.761

GROUP SPREAD: 2.162

MIN RADIUS: 0.305

MAX RADIUS: 1.493

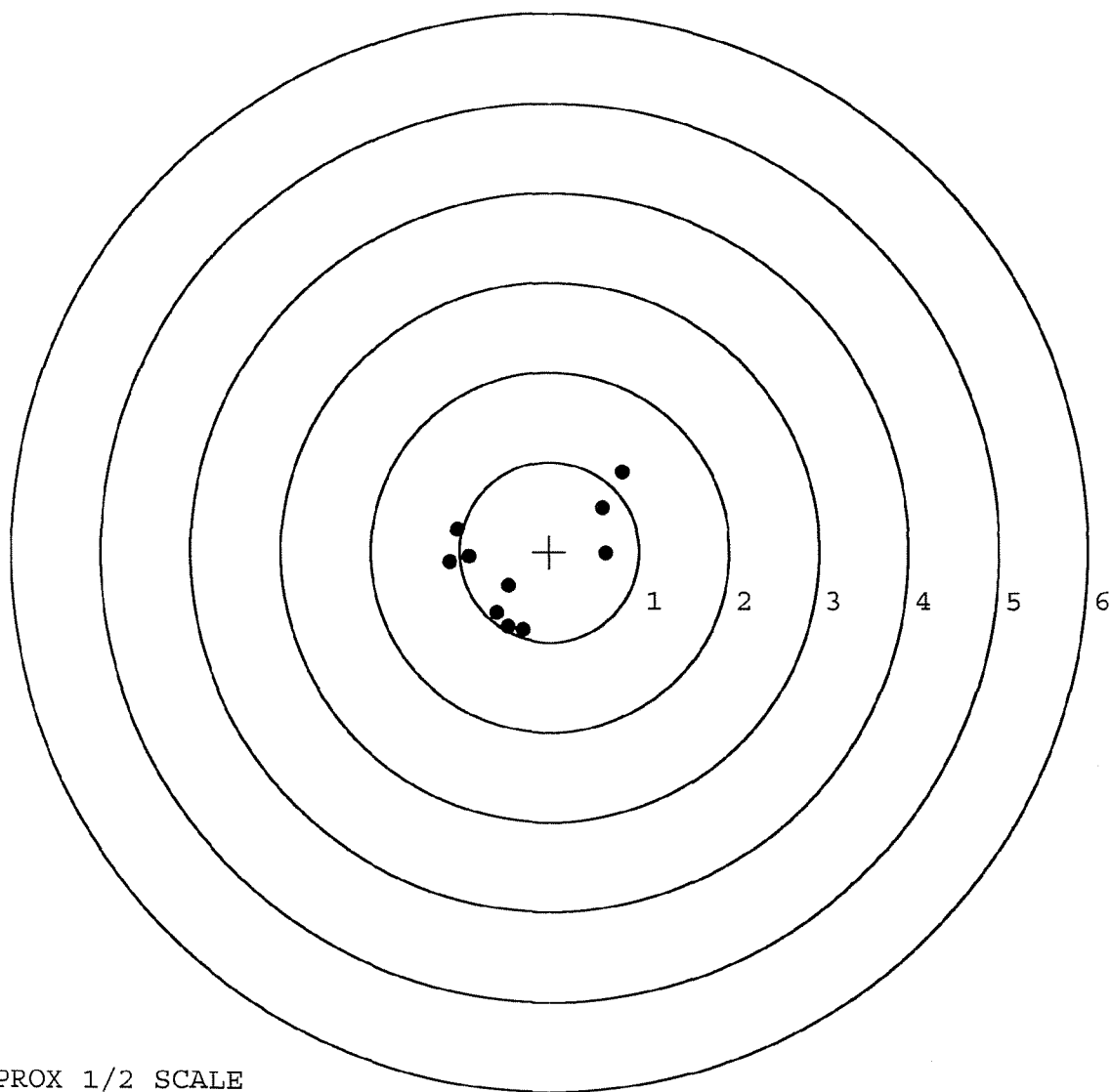
MEAN RADIUS: 0.817

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.458	-0.389
2:	-0.587	-0.687
3:	-0.464	-0.846
4:	-0.298	-0.879
5:	-0.899	-0.064
6:	-1.107	-0.123
7:	-1.027	0.243
8:	0.627	-0.023
9:	0.590	0.485
10:	0.807	0.882



TARGET APPROX 1/2 SCALE