

G 6360956

9/27/2004 10:33:18 AM

Crit

43

Original

25716

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



.MA25716

Shop Order: SWS631059



.ABSWS631059

Start Date: 8/9/2004

Finish Date: 10/26/2004

0540

01PC001

Flat Black Powder Coat, Barrel and



0003451403

0560

89SWS1

Reassemble Action.



0003451404

0690

89SWS1

Pack Rifle



0003451397

0700

89SWS1

Stencil SWS Container



.OP0700

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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



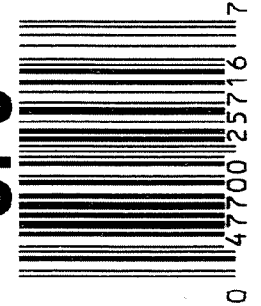
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

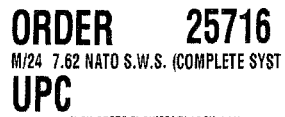
G6360956

UPC



DD FORM

UPC



7/22/2004 3:21:04 PM

Original

19

Original

25716

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



.MA25716

Shop Order: SWS631055



.ABSWS631055

Start Date: 7/23/2004

Finish Date: 9/23/2004

0630

Flat Black Powder Coat, Barrel and

01PC001



0003338116

0640

Reassemble Action.

89SWS1



0003338117

0685

Attach Front and Rear Sight Assemblies

89SWS1



0003338122

0710

Pack Rifle & Stencil SWS Container

89SWS1



.OP0710

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6360956

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		6-15-04	RTL
600	PROOF		6-15-04	RTL
607	CHECK HEADSPACE	MAGNA - FLUX	6-15-04	RTL
610	DIS-ASSEMBLE GUN	INSPECTED	6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JUN 15 2004 OPERATOR BS		
615	ROLLMARK CALIBER		6-16-04	SB
617	DRILL AND TAP SIGHT HOLES		6-15-04	RTL
620	APPLY COATINGS (BARREL ACTION)		6/08	HP
	(BOLT)		6/08	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		8/12/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8/12/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8/12/04	DA
	D) OIL FIRING PIN ASSEMBLY		8/12/04	DA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>5.5</u> <u>5.5</u>	9/13/04	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	9/13/04	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.024</u>	9/13/04	RA
	J) ASSEMBLE STOCK		8-24-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-17-04	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-24-04	RW
	M) IRON SIGHT ALIGNMENT		8-24-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-24-04	RW
640	GALLERY TEST AND TARGET	PASS FAIL	8-26-04	TRW
	MALFUNCTION	CORRECTION	8-26-04	TRW
	MALFUNCTION	CORRECTION	8-26-04	TRW
	MALFUNCTION	CORRECTION	8-26-04	TRW
	MALFUNCTION	CORRECTION	8-26-04	TRW
645	INSPECT FOR LIVE AMMO		8-26-04	TRW
655	FINAL INSPECTION A) HEADSPACE		9-17-04	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u> <u>2.52</u> <u>2.57</u> <u>2.71</u> <u>2.67</u>	9/13/04	RA
	C) FUNCTION		9-17-04	RTZ
660	PACK		9-20-04	AC

AVERAGE PULL FORCE BETWEEN
 INITIAL 2.50 LBS TESTS
BARBER - M24 0083038
 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

8-24-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.25	2.27		2.59	
PULL #2	2.22	2.32		2.45	
PULL #3	2.23	2.46		2.64	
PULL #4	2.26	2.41		2.70	
PULL #5	2.23	2.41		2.64	
TOTAL	11.19	11.87		13.02	
AVERAGE	2.23	2.37		2.60	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.19		
PULL #2	3.27	3.22		
PULL #3	3.34	3.17		
PULL #4	3.09	3.21		
PULL #5	3.36	3.19		
TOTAL	16.38	15.98		
AVERAGE	3.27	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	4.39	4.33		4.57
PULL #2	4.33	4.31		4.34
PULL #3	4.35	4.30		4.40
PULL #4	4.29	4.45		4.43
PULL #5	4.41	4.43		4.47
TOTAL	21.77	21.82		22.21
AVERAGE	4.35	4.36		4.44

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360956.__0

FILE DATE AND TIME: 08/26/2004 05:40

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	-0.078
The Average Point of Impact of the Five Target Set:	0.078
The Average Mean Radius of the Five Target Set:	0.978
The Distance from POA to Centroid Target #1:	0.065
The Distance from Centroid Target #2 to Centroid Target #1:	0.109
The Distance from Centroid Target #3 to Centroid Target #1:	0.240
The Distance from Centroid Target #4 to Centroid Target #1:	0.229
The Distance from Centroid Target #5 to Centroid Target #1:	0.241

SERIAL NUMBER: G6360956. __0

TARGET NUMBER: 1

FILE DATE: 08/26/2004

FILE TIME: 05:40

POINT#	X	Y
1:	0.597	0.107
2:	0.226	0.488
3:	0.069	0.254
4:	0.038	0.017
5:	-0.742	0.842
6:	0.146	-0.356
7:	0.258	-0.572
8:	-0.147	-0.424
9:	-0.390	-0.354
10:	-0.657	-0.260

X CENTROID: -0.060

Y CENTROID: -0.026

POA TO CENTROID: 0.065

HORZ SPREAD: 1.339

VERT SPREAD: 1.414

GROUP SPREAD: 1.732

MIN RADIUS: 0.107

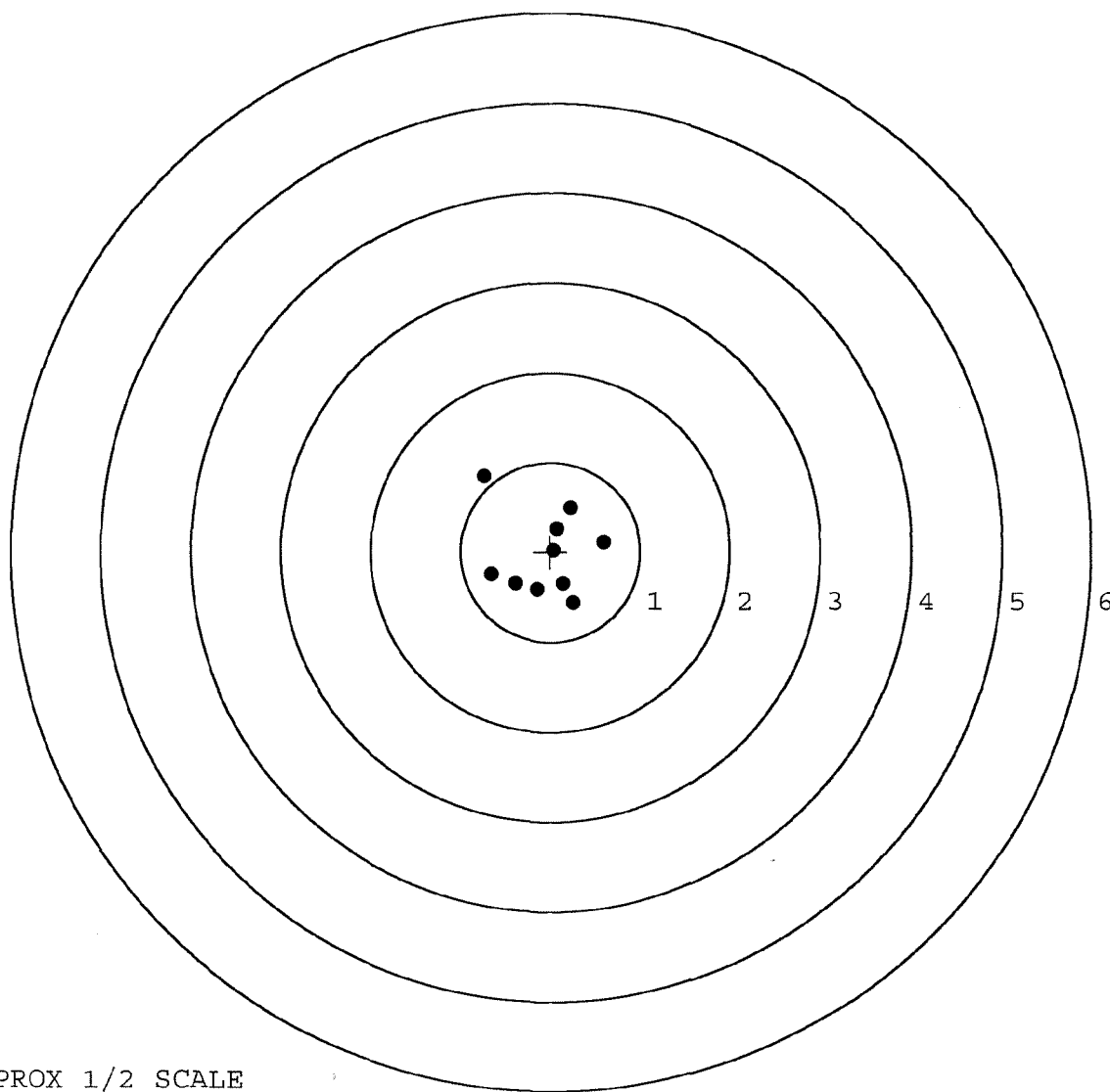
MAX RADIUS: 1.104

MEAN RADIUS: 0.531

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360956. 0

TARGET NUMBER: 2

FILE DATE: 08/26/2004

FILE TIME: 05:40

X CENTROID: -0.066

Y CENTROID: -0.135

POA TO CENTROID: 0.150

HORZ SPREAD: 1.235

VERT SPREAD: 2.958

GROUP SPREAD: 2.960

MIN RADIUS: 0.111

MAX RADIUS: 1.595

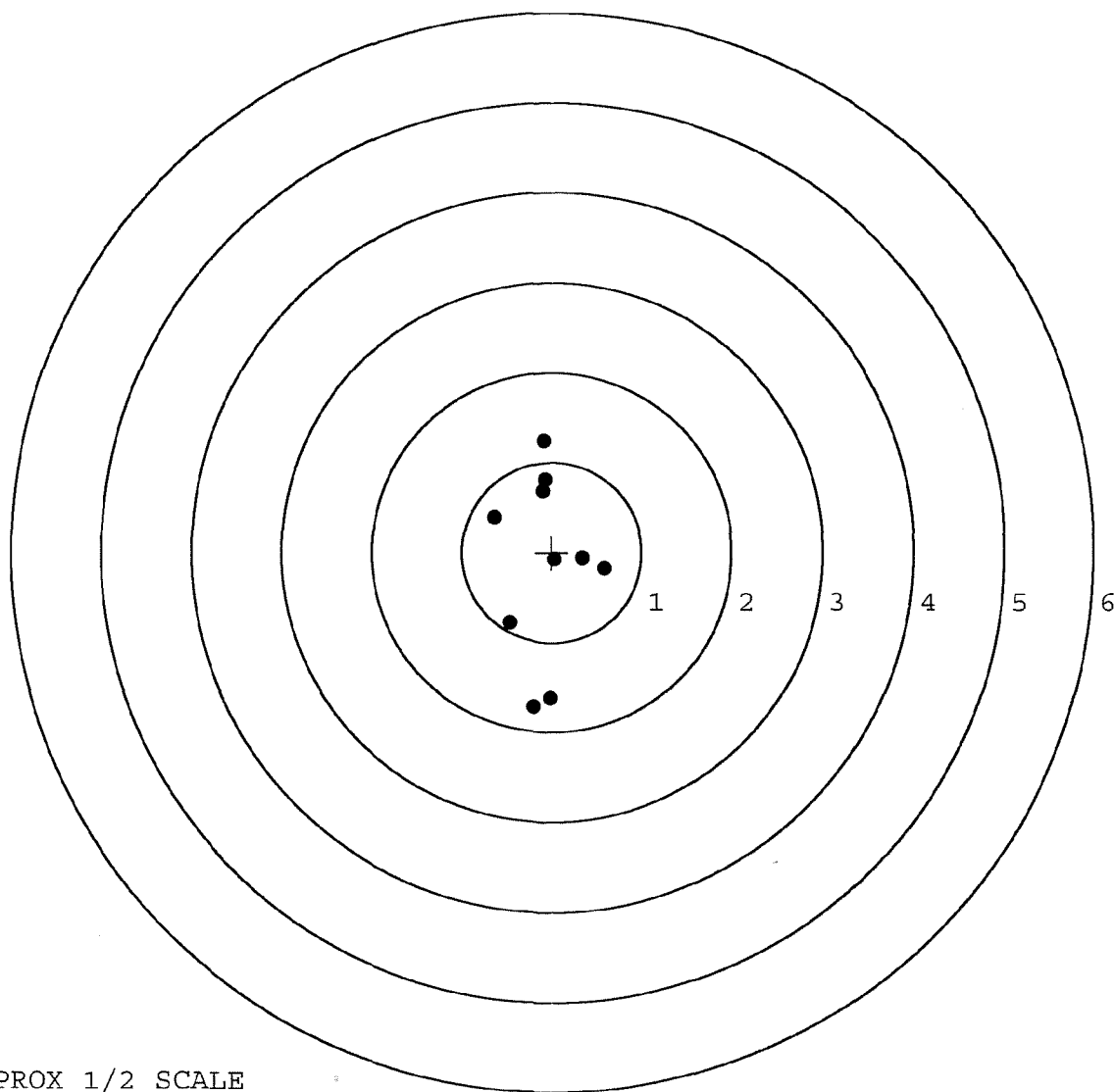
MEAN RADIUS: 0.893

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.018	-1.628
2:	-0.203	-1.724
3:	-0.471	-0.781
4:	-0.643	0.382
5:	-0.108	0.679
6:	-0.086	0.801
7:	-0.094	1.234
8:	0.028	-0.075
9:	0.342	-0.060
10:	0.592	-0.175



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360956. 0

TARGET NUMBER: 3

FILE DATE: 08/26/2004

FILE TIME: 05:40

POINT#	X	Y
1:	0.772	-0.890
2:	0.207	-0.835
3:	-0.193	-0.713
4:	0.751	-0.103
5:	0.095	0.506
6:	-0.119	0.458
7:	-0.648	-0.320
8:	-0.948	0.658
9:	-0.486	1.506
10:	0.364	1.838

X CENTROID: -0.020

Y CENTROID: 0.211

POA TO CENTROID: 0.211

HORZ SPREAD: 1.720

VERT SPREAD: 2.728

GROUP SPREAD: 2.758

MIN RADIUS: 0.266

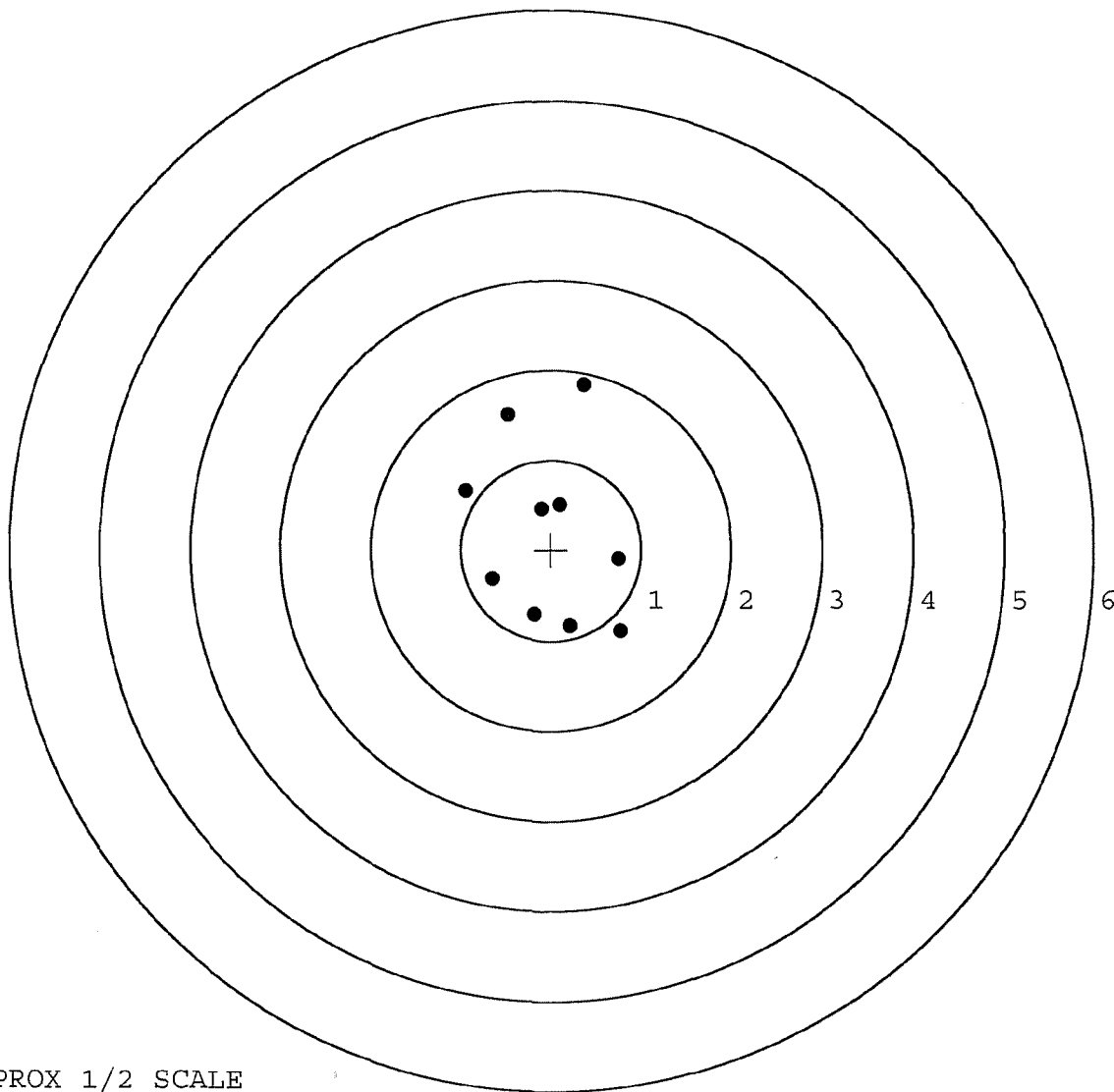
MAX RADIUS: 1.672

MEAN RADIUS: 0.968

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360956. 0

TARGET NUMBER: 4

FILE DATE: 08/26/2004

FILE TIME: 05:40

POINT#	X	Y
1:	0.289	-1.692
2:	1.352	-2.946
3:	1.972	-0.147
4:	0.070	-0.194
5:	-0.013	-0.678
6:	-0.312	-0.521
7:	-0.975	0.427
8:	-0.117	1.001
9:	-0.758	1.024
10:	-1.057	1.435

X CENTROID: 0.045

Y CENTROID: -0.229

POA TO CENTROID: 0.233

HORZ SPREAD: 3.029

VERT SPREAD: 4.381

GROUP SPREAD: 5.000

MIN RADIUS: 0.043

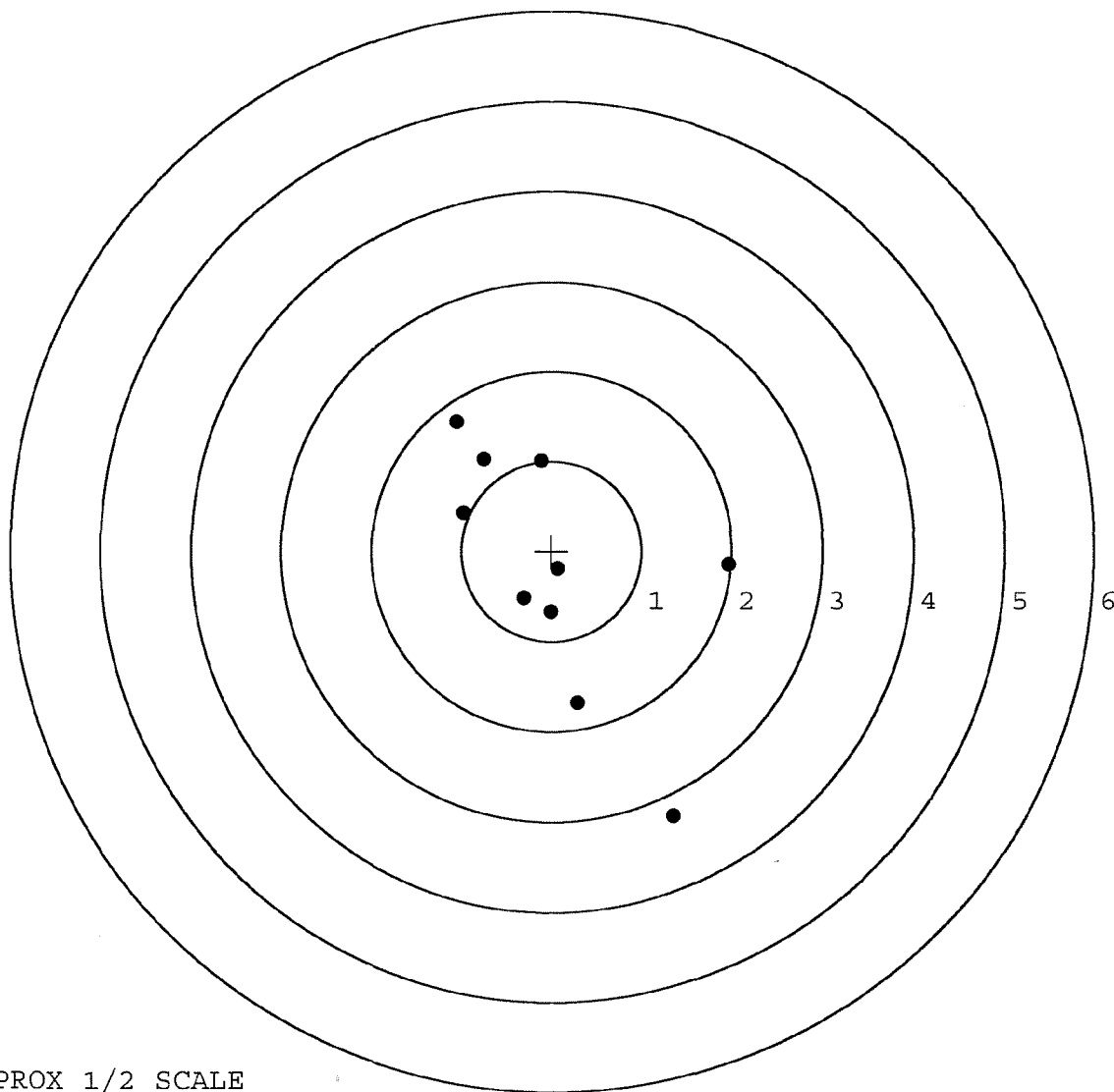
MAX RADIUS: 3.015

MEAN RADIUS: 1.332

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360956. __0

TARGET NUMBER: 5

FILE DATE: 08/26/2004

FILE TIME: 05:40

X CENTROID: 0.093

Y CENTROID: -0.211

POA TO CENTROID: 0.231

HORZ SPREAD: 1.852

VERT SPREAD: 5.141

GROUP SPREAD: 5.210

MIN RADIUS: 0.422

MAX RADIUS: 3.362

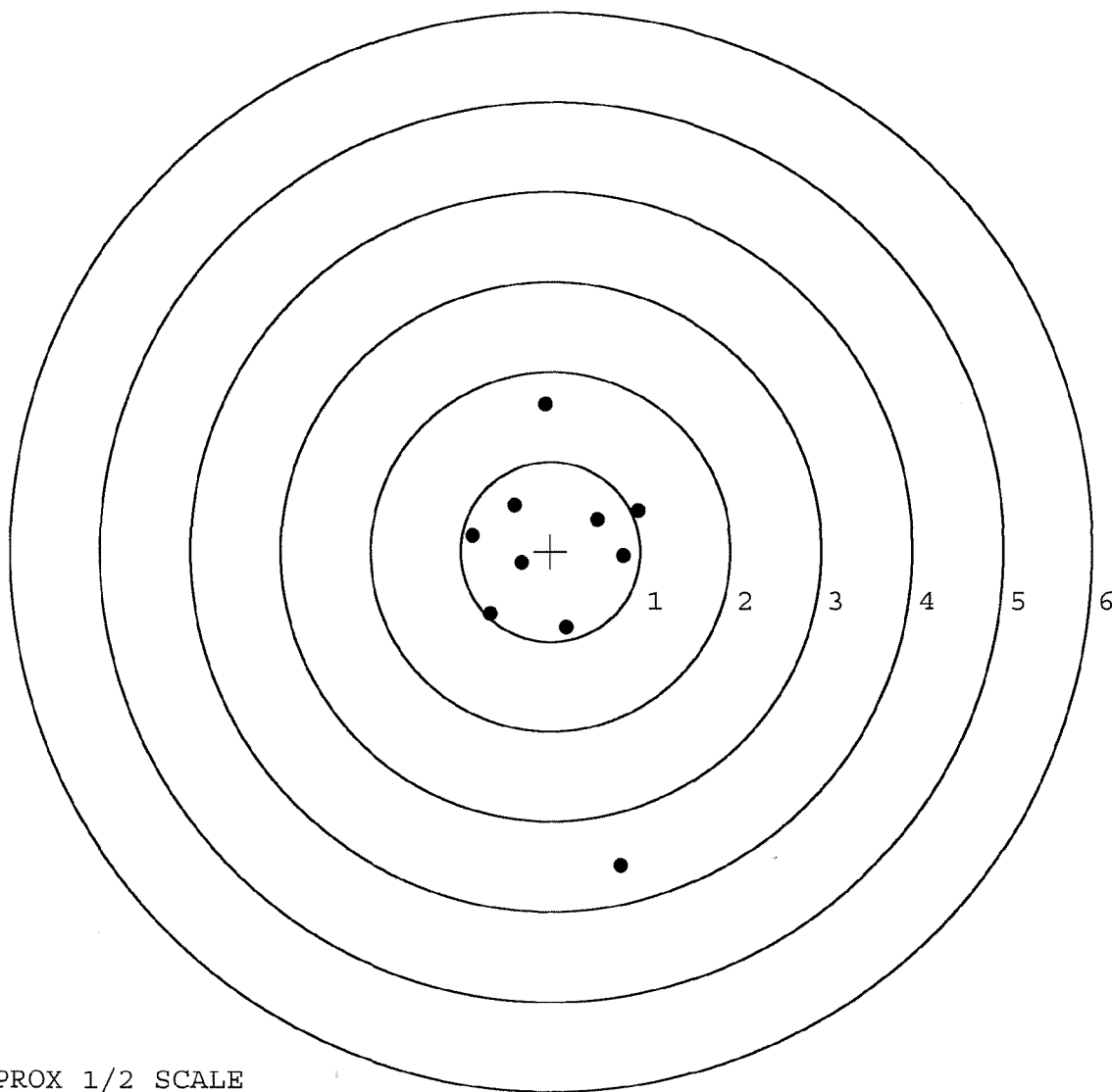
MEAN RADIUS: 1.165

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.784	-3.501
2:	0.812	-0.058
3:	0.517	0.349
4:	0.979	0.453
5:	-0.063	1.640
6:	0.175	-0.852
7:	-0.321	-0.130
8:	-0.411	0.507
9:	-0.873	0.176
10:	-0.669	-0.696



TARGET APPROX 1/2 SCALE