

G6410249

ORDER 25716

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

UPC



ORDER 25716

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

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



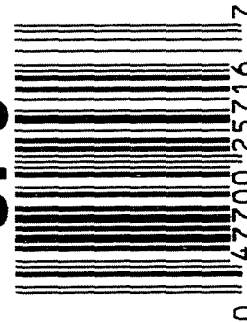
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6410249

UPC



10/27/2004 11:09:26 AM

Crib

8

Original

25716

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



.MA25716

Shop Order: SWS10-15-1



.ABSWS10-15-1

Start Date: 10/22/2004

Finish Date: 12/27/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003517903

0560

Reassemble Action.

89SWS1



0003517904

0690

Pack Rifle

89SWS1



0003517897

0700

Stencil SWS Container

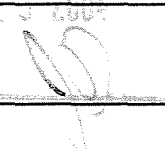
89SWS1



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G641 0249

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTL
600	PROOF		8-24-04	RTL
607	CHECK HEADSPACE	MAGNA - FLUX	8-24-04	RTL
610	DIS-ASSEMBLE GUN	INSPECTED	8-24-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		8/25/04	JB
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRW
620	APPLY COATINGS (BARREL ACTION)		9/7	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-04	RTL
	D) OIL FIRING PIN ASSEMBLY		10-11-04	RTL
	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>6.5</u> <u>6.0</u> <u>6.5</u>	11-15-04	OA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.0</u>	11-15-04	OA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.022</u> <u>.023</u>	11-15-04	OA
	J) ASSEMBLE STOCK		10-11-04	RL
	K) ASSEMBLE SWIVEL STUDS		11-29-04	RL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-29-04	RL
	M) IRON SIGHT ALIGNMENT		11-29-04	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-29-04	RL
640	GALLERY TEST AND TARGET	(PASS) FAIL	10-27-04	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
645	INSPECT FOR LIVE AMMO		10-27-04	TRW
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.25</u> <u>2.28</u> <u>2.35</u> <u>2.22</u>	11-15-04	OA
	C) FUNCTION		11-29-04	RL
660	PACK		11/29/04	OA

INITIAL BARBER - M24 0149238
 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)

DATE 10-9-04
 TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.10		2.16	
PULL #2	2.30	2.28		2.28	
PULL #3	2.41	2.38		2.23	
PULL #4	2.58	2.51		2.29	
PULL #5	2.34	2.19		2.22	
TOTAL	11.94	11.46		11.18	
AVERAGE	2.38	2.29		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.04		
PULL #2	3.39	3.21		
PULL #3	3.17	3.17		
PULL #4	3.18	3.27		
PULL #5	3.07	3.27		
TOTAL	15.90	15.96		
AVERAGE	3.18	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	4.10	4.26		4.39
PULL #2	4.07	4.40		4.42
PULL #3	4.10	4.05		4.52
PULL #4	4.04	3.99		4.51
PULL #5	4.38	4.01		4.20
TOTAL	20.69	20.71		22.04
AVERAGE	4.13	4.14		4.40

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410249.___0
FILE DATE AND TIME: 10/27/2004 08:31

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.084
The Average Y Centroid of the Five Target Set:	-0.133
The Average Point of Impact of the Five Target Set:	0.158
The Average Mean Radius of the Five Target Set:	0.832
The Distance from POA to Centroid Target #1:	0.215
The Distance from Centroid Target #2 to Centroid Target #1:	0.377
The Distance from Centroid Target #3 to Centroid Target #1:	0.146
The Distance from Centroid Target #4 to Centroid Target #1:	0.167
The Distance from Centroid Target #5 to Centroid Target #1:	0.119

SERIAL NUMBER: G6410249. __0

TARGET NUMBER: 1

FILE DATE: 10/27/2004

FILE TIME: 08:31

X CENTROID: -0.145

Y CENTROID: -0.159

POA TO CENTROID: 0.215

HORZ SPREAD: 2.476

VERT SPREAD: 1.991

GROUP SPREAD: 3.177

MIN RADIUS: 0.117

MAX RADIUS: 1.875

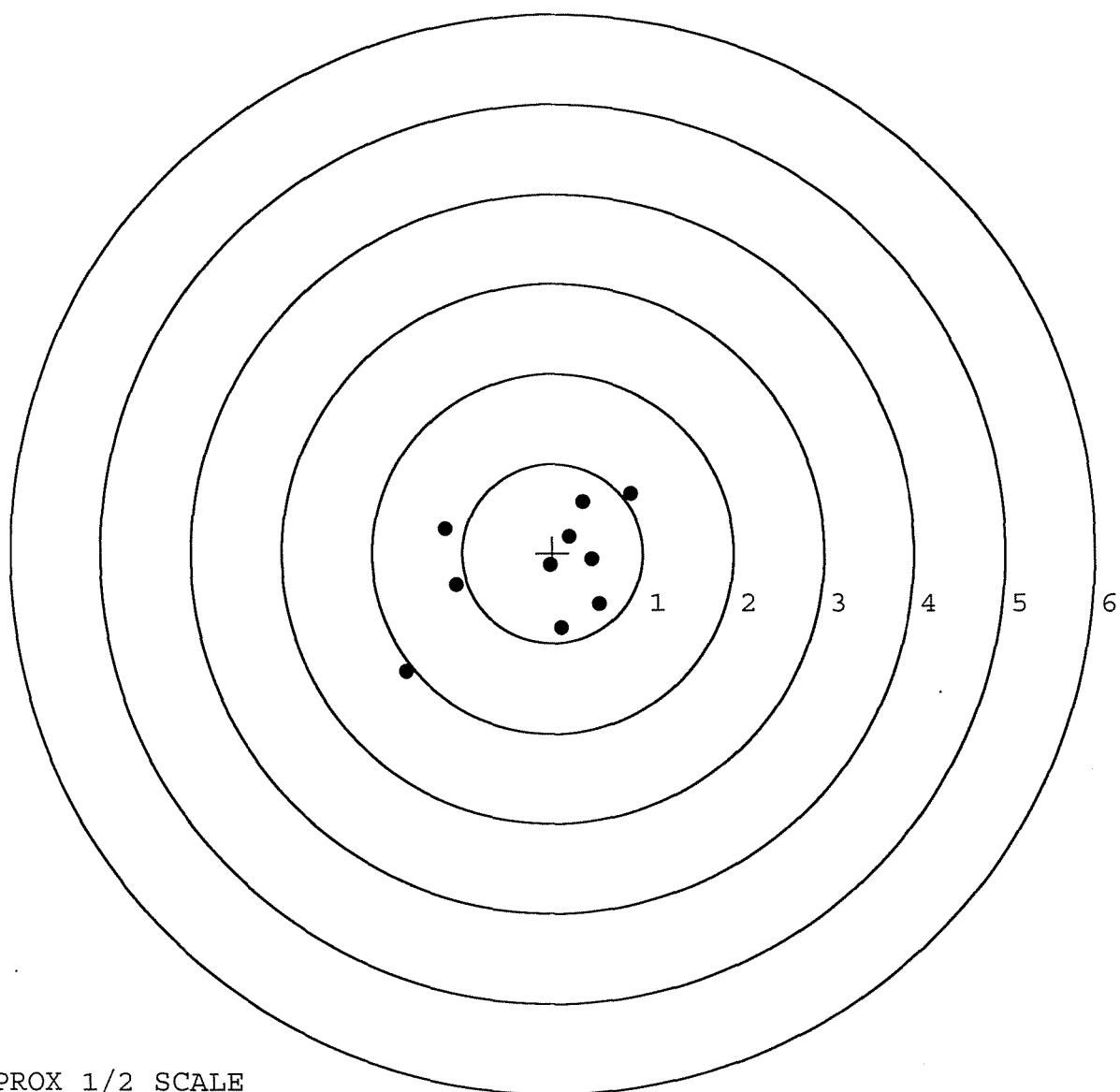
MEAN RADIUS: 0.882

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.521	-0.573
2:	0.100	-0.835
3:	-1.615	-1.324
4:	-1.065	-0.360
5:	-1.188	0.277
6:	0.861	0.667
7:	0.435	-0.068
8:	0.192	0.187
9:	-0.030	-0.139
10:	0.334	0.579

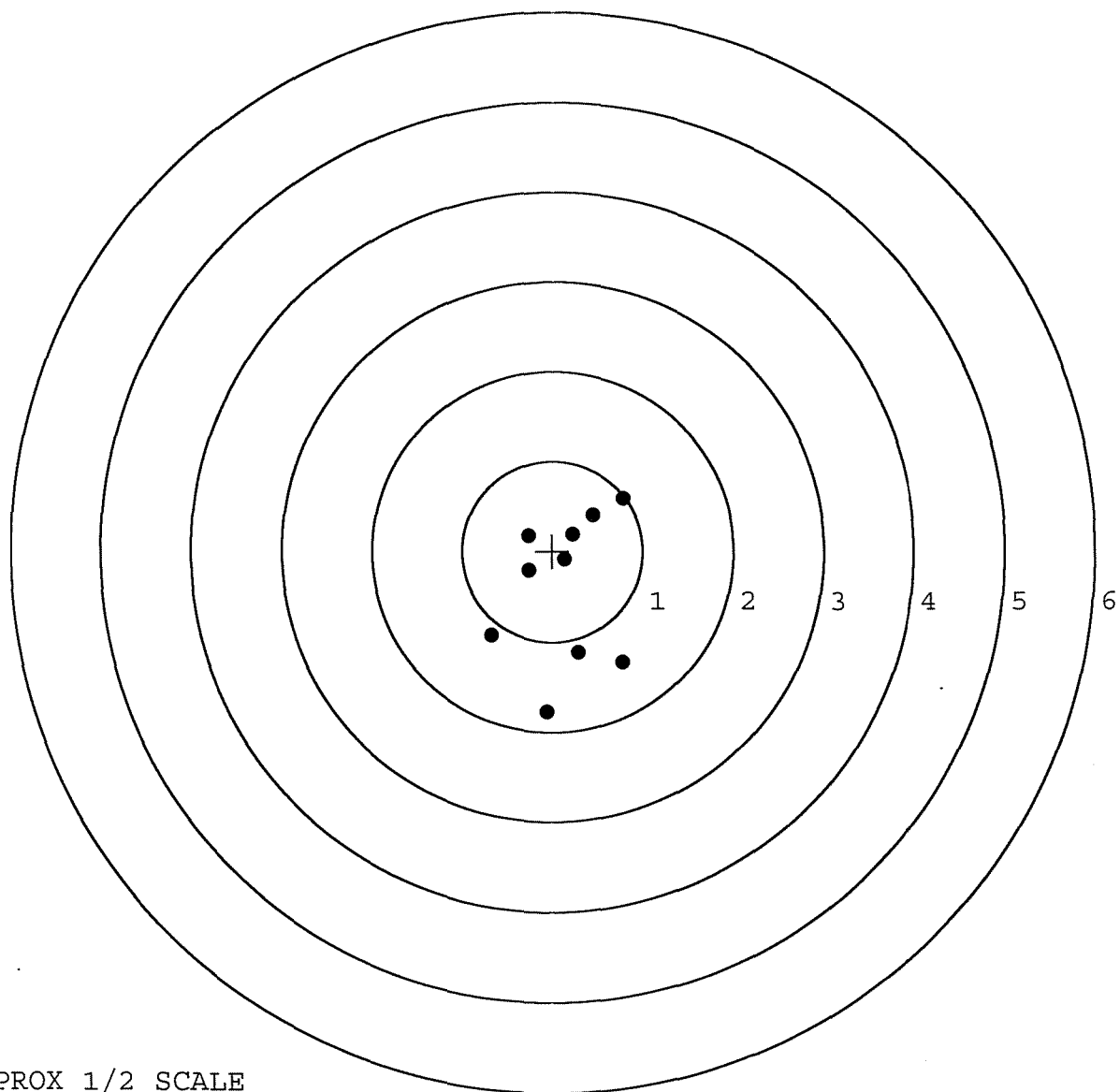


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410249. __0
 TARGET NUMBER: 2
 FILE DATE: 10/27/2004
 FILE TIME: 08:31

POINT#	X	Y
1:	0.782	0.583
2:	0.449	0.397
3:	0.233	0.185
4:	0.134	-0.098
5:	0.292	-1.123
6:	0.776	-1.229
7:	-0.061	-1.782
8:	-0.676	-0.931
9:	-0.262	-0.216
10:	-0.265	0.171

X CENTROID: 0.140
 Y CENTROID: -0.404
 POA TO CENTROID: 0.428
 HORZ SPREAD: 1.458
 VERT SPREAD: 2.365
 GROUP SPREAD: 2.511
 MIN RADIUS: 0.306
 MAX RADIUS: 1.392
 MEAN RADIUS: 0.823
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

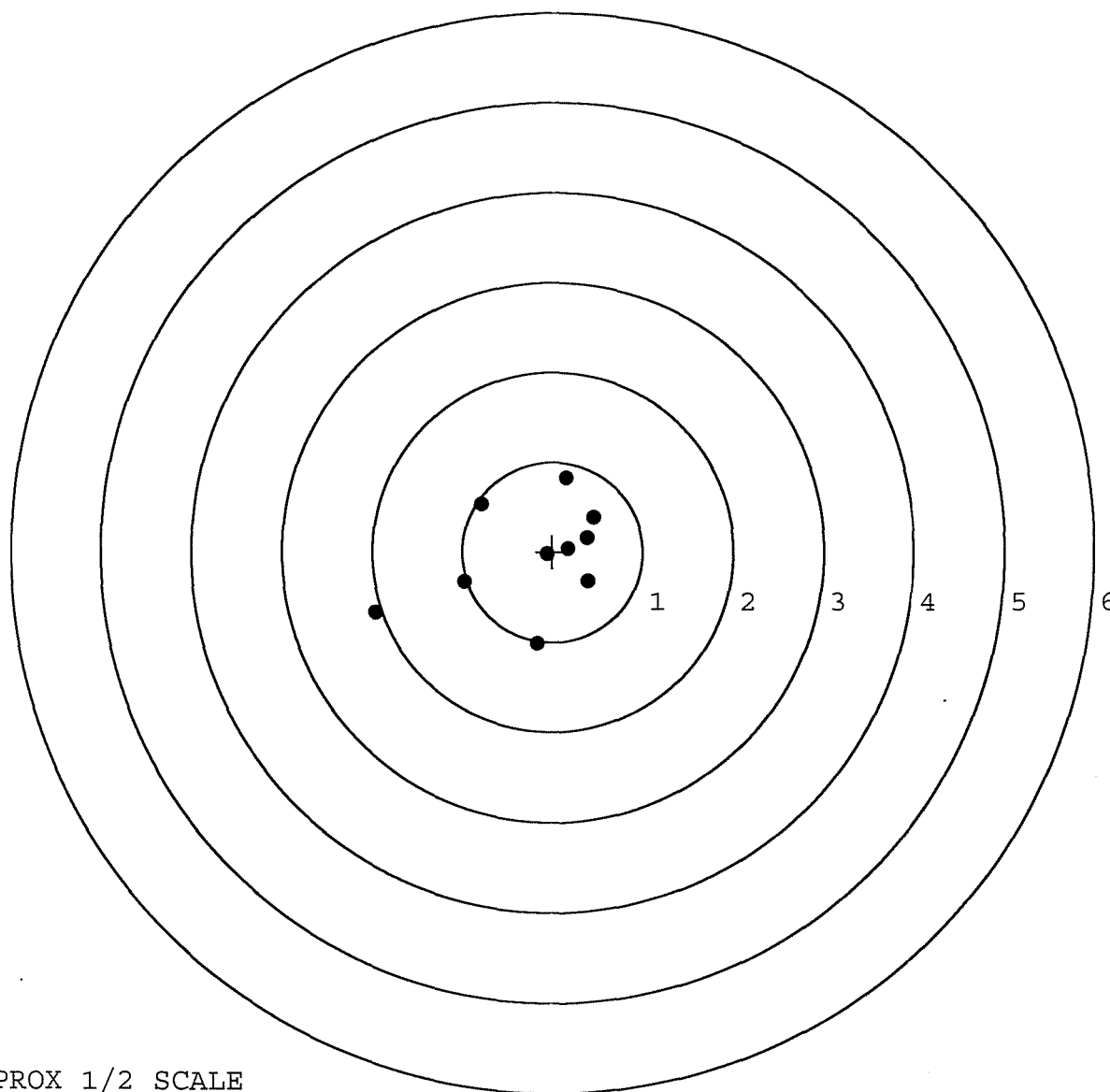


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410249. __ 0
 TARGET NUMBER: 3
 FILE DATE: 10/27/2004
 FILE TIME: 08:31

X CENTROID: -0.239
 Y CENTROID: -0.047
 POA TO CENTROID: 0.244
 HORZ SPREAD: 2.425
 VERT SPREAD: 1.843
 GROUP SPREAD: 2.649
 MIN RADIUS: 0.175
 MAX RADIUS: 1.839
 MEAN RADIUS: 0.814
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.171	-1.021
2:	-0.977	-0.335
3:	-0.065	-0.030
4:	0.154	0.822
5:	-0.790	0.528
6:	-1.966	-0.680
7:	0.459	0.386
8:	0.391	0.159
9:	0.174	0.033
10:	0.399	-0.333

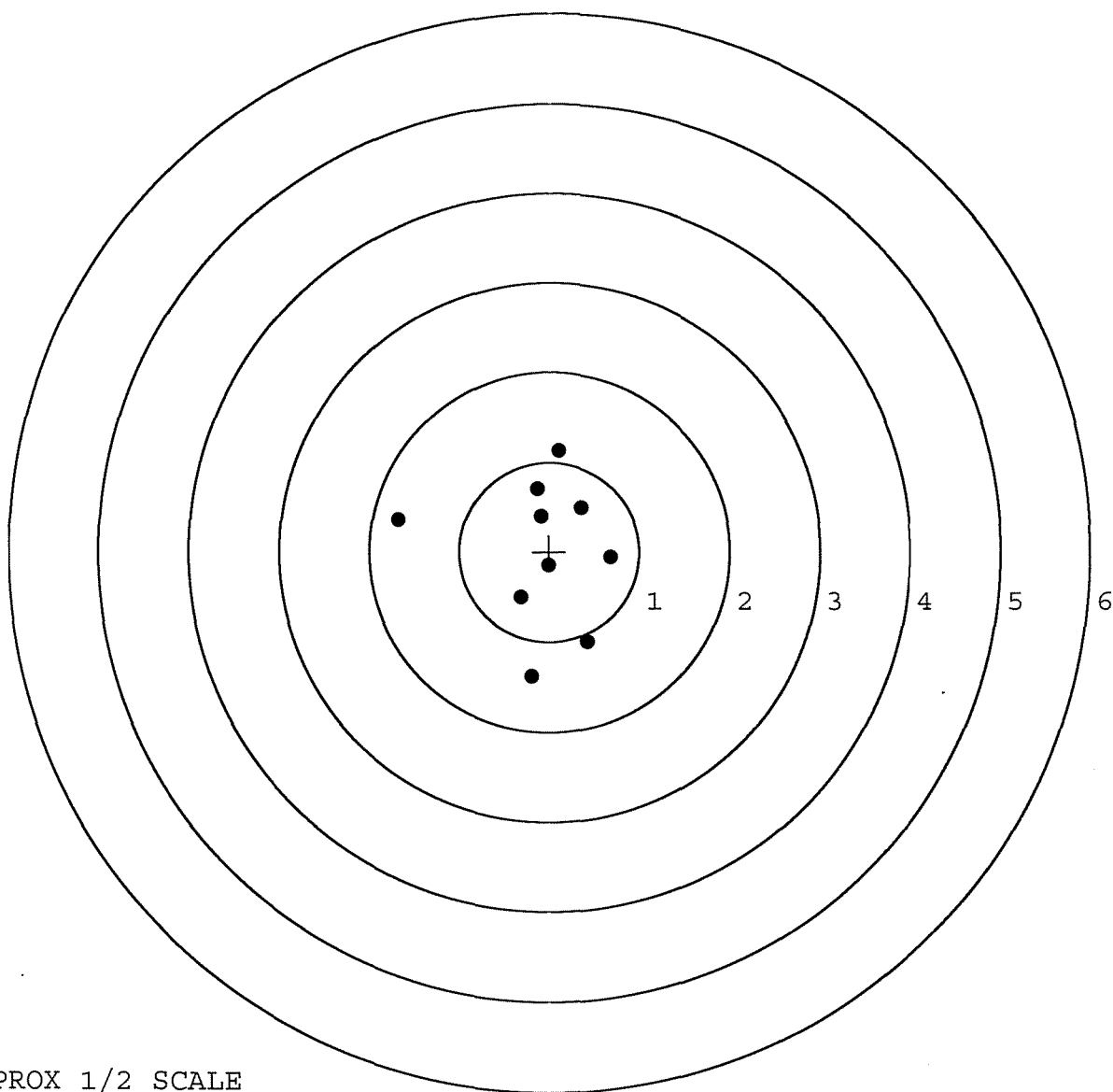


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410249. __0
 TARGET NUMBER: 4
 FILE DATE: 10/27/2004
 FILE TIME: 08:31

X CENTROID: -0.085
 Y CENTROID: -0.004
 POA TO CENTROID: 0.085
 HORZ SPREAD: 2.368
 VERT SPREAD: 2.519
 GROUP SPREAD: 2.517
 MIN RADIUS: 0.170
 MAX RADIUS: 1.641
 MEAN RADIUS: 0.858
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.428	-1.005
2:	-0.195	-1.390
3:	0.684	-0.065
4:	-0.008	-0.155
5:	-0.317	-0.509
6:	0.357	0.496
7:	-0.094	0.395
8:	-0.136	0.702
9:	0.113	1.129
10:	-1.684	0.365

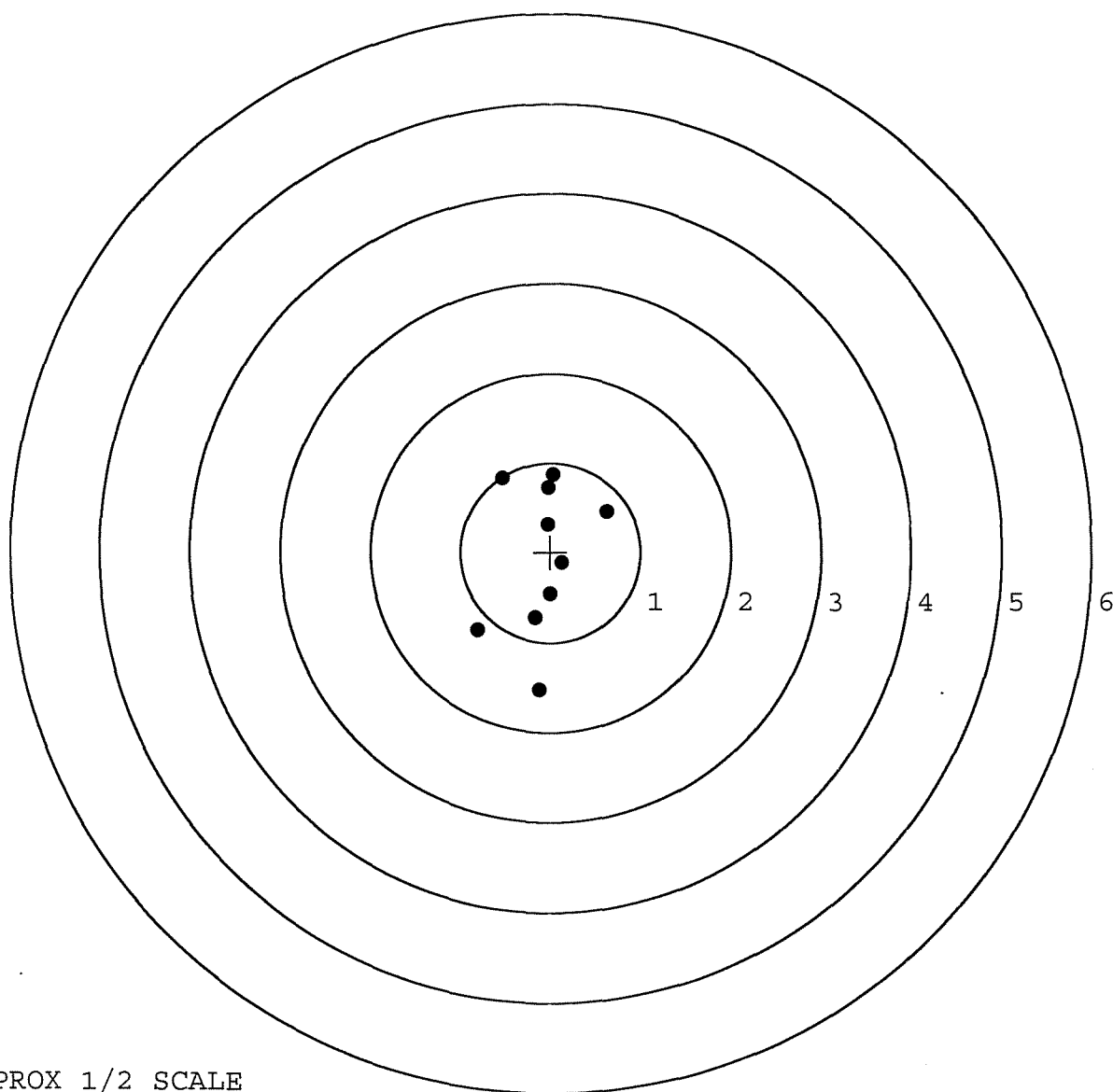


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410249. __0
 TARGET NUMBER: 5
 FILE DATE: 10/27/2004
 FILE TIME: 08:31

POINT#	X	Y
1:	-0.124	-1.532
2:	-0.809	-0.863
3:	0.625	0.456
4:	0.028	0.867
5:	-0.028	0.725
6:	-0.031	0.312
7:	-0.539	0.831
8:	0.131	-0.123
9:	-0.007	-0.467
10:	-0.167	-0.731

X CENTROID: -0.092
 Y CENTROID: -0.053
 POA TO CENTROID: 0.106
 HORZ SPREAD: 1.434
 VERT SPREAD: 2.399
 GROUP SPREAD: 2.404
 MIN RADIUS: 0.234
 MAX RADIUS: 1.480
 MEAN RADIUS: 0.785
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE