

G 641 0324

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



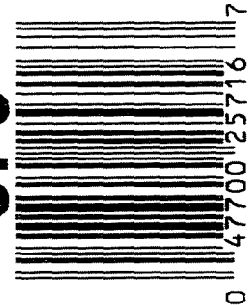
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6410326

UPC



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.



10/26/2004 7:51:17 AM

Copy

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Original

25716

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



.MA25716

Shop Order: SWS10-15-5



.ABSWS10-15-5

Start Date: 9/20/2004

Finish Date: 10/15/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003512703

0560

Reassemble Action.

89SWS1



0003512704

0690

Pack Rifle

89SWS1



0003512697

0700

Stencil SWS Container

89SWS1



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410326

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 INSPECTED	8-24-04	RTL
610	DIS-ASSEMBLE GUN	AUG 25 2004	8-24-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>[Signature]</u>		
615	ROLLMARK CALIBER		8/25/04	B
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		9/23/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/23/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/23/04	DA
	D) OIL FIRING PIN ASSEMBLY		9/23/04	DA
	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>8.2</u>	<u>8.2</u>	<u>8.2</u>	10-12-04	DA		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.2</u>	<u>2.5</u>	<u>2.2</u>	10-12-04	DA		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.022</u>	<u>.021</u>	10-12-04	DA		
	J) ASSEMBLE STOCK					9-23-04	KE		
	K) ASSEMBLE SWIVEL STUDS					10-14-04	RTZ		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					9-23-04	KE		
	M) IRON SIGHT ALIGNMENT					9-23-04	KE		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					9-23-04	KE		
640	GALLERY TEST AND TARGET		PASS	FAIL		10-4-04	TRW		
	MALFUNCTION		CORRECTION			NA	TRW		
	MALFUNCTION		CORRECTION			NA	TRW		
	MALFUNCTION		CORRECTION			NA	TRW		
	MALFUNCTION		CORRECTION			NA	TRW		
645	INSPECT FOR LIVE AMMO					10-4-04	TRW		
655	FINAL INSPECTION A) HEADSPACE					10-14-04	RTZ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.90</u>	<u>2.87</u>	<u>2.90</u>	<u>2.91</u>	<u>2.91</u>	10-12-04	DA
	C) FUNCTION					10-14-04	RTZ		
660	PACK					10/23/04	DA		

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)

DATE

TESTER

6-7-04

RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.22		2.63	
PULL #2	2.31	2.32		2.20	
PULL #3	2.34	2.29		2.69	
PULL #4	2.33	2.34		2.73	
PULL #5	2.32	2.32		2.79	
TOTAL	11.61	11.49		13.54	
AVERAGE	2.32	2.30		2.71	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.25		
PULL #2	3.17	3.32		
PULL #3	3.29	3.33		
PULL #4	3.38	3.34		
PULL #5	3.37	3.40		
TOTAL	16.34	16.64		
AVERAGE	3.27	3.33		

	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	4.06	4.07		4.38
PULL #2	4.00	4.06		4.33
PULL #3	4.18	4.05		4.33
PULL #4	4.23	4.06		4.42
PULL #5	4.38	4.09		4.39
TOTAL	20.85	20.33		21.85
AVERAGE	4.17	4.07		4.37

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410326.___0
FILE DATE AND TIME: 10/14/2004 07:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

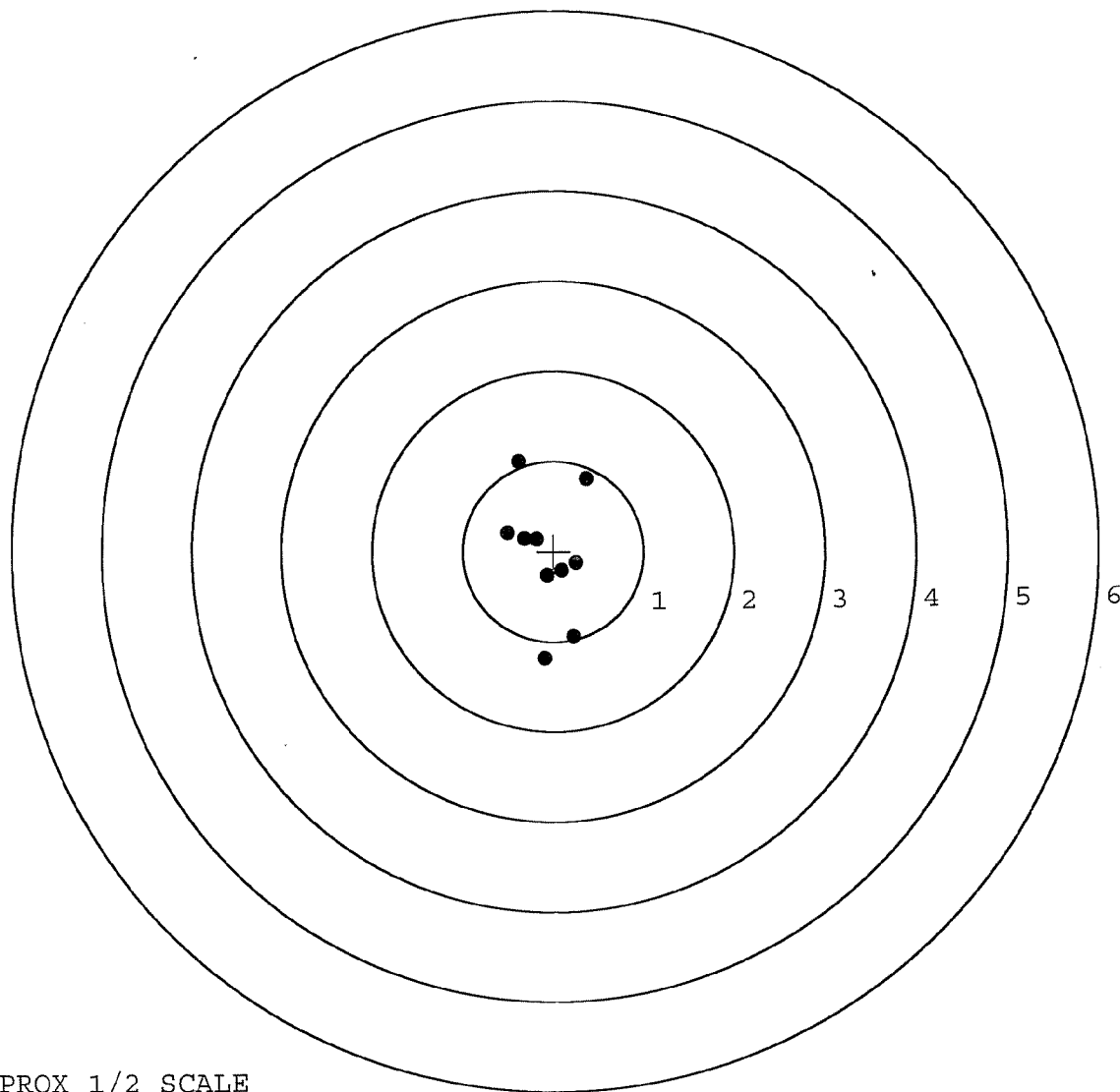
The Average X Centroid of the Five Target Set:	0.010
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.033
The Average Mean Radius of the Five Target Set:	0.828
The Distance from POA to Centroid Target #1:	0.082
The Distance from Centroid Target #2 to Centroid Target #1:	0.060
The Distance from Centroid Target #3 to Centroid Target #1:	0.111
The Distance from Centroid Target #4 to Centroid Target #1:	0.414
The Distance from Centroid Target #5 to Centroid Target #1:	0.216

BARBER - M24 0150215

SERIAL NUMBER: G6410326. __0
 TARGET NUMBER: 1
 FILE DATE: 10/14/2004
 FILE TIME: 07:11

POINT#	X	Y
1:	-0.383	0.994
2:	0.368	0.805
3:	-0.512	0.212
4:	-0.189	0.137
5:	0.249	-0.130
6:	-0.076	-0.269
7:	0.219	-0.953
8:	-0.111	-1.188
9:	0.088	-0.216
10:	-0.322	0.141

X CENTROID: -0.067
 Y CENTROID: -0.047
 POA TO CENTROID: 0.082
 HORZ SPREAD: 0.880
 VERT SPREAD: 2.182
 GROUP SPREAD: 2.199
 MIN RADIUS: 0.221
 MAX RADIUS: 1.142
 MEAN RADIUS: 0.597
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0150216

SERIAL NUMBER: G6410326. __0

TARGET NUMBER: 2

FILE DATE: 10/14/2004

FILE TIME: 07:11

X CENTROID: -0.021

Y CENTROID: -0.085

POA TO CENTROID: 0.088

HORZ SPREAD: 3.265

VERT SPREAD: 2.418

GROUP SPREAD: 3.350

MIN RADIUS: 0.364

MAX RADIUS: 1.912

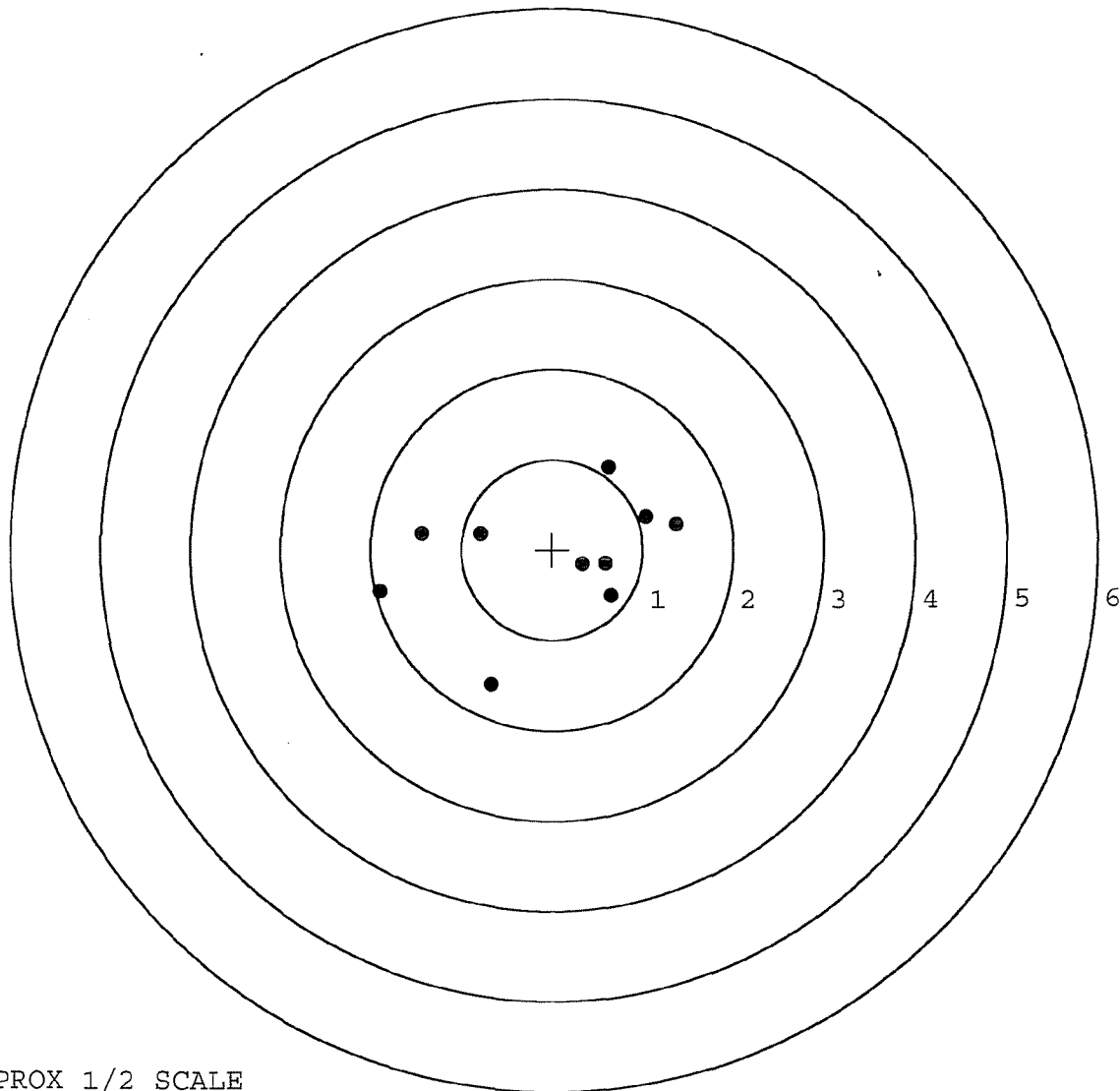
MEAN RADIUS: 1.129

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.621	0.921
2:	1.371	0.281
3:	1.029	0.371
4:	0.593	-0.151
5:	0.334	-0.163
6:	0.649	-0.507
7:	-0.674	-1.497
8:	-1.894	-0.470
9:	-1.443	0.183
10:	-0.798	0.178



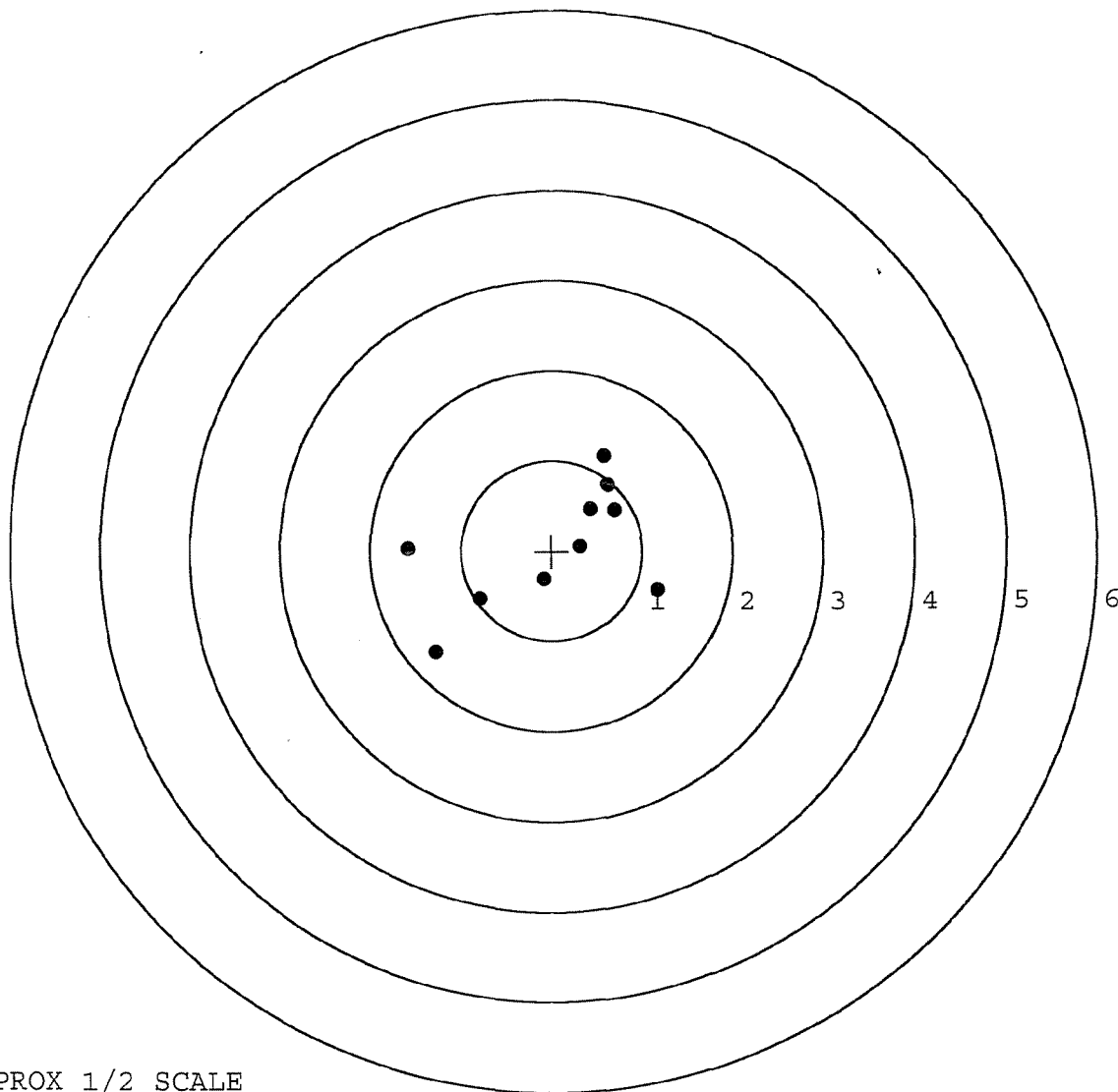
TARGET APPROX 1/2 SCALE

BARBER - M24 0150217

SERIAL NUMBER: G6410326. __ 0
 TARGET NUMBER: 3
 FILE DATE: 10/14/2004
 FILE TIME: 07:11

X CENTROID: 0.006
 Y CENTROID: 0.037
 POA TO CENTROID: 0.038
 HORZ SPREAD: 2.755
 VERT SPREAD: 2.177
 GROUP SPREAD: 2.861
 MIN RADIUS: 0.315
 MAX RADIUS: 1.735
 MEAN RADIUS: 0.974
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-1.584	0.030
2:	-1.277	-1.130
3:	-0.795	-0.537
4:	-0.089	-0.317
5:	1.171	-0.433
6:	0.320	0.059
7:	0.423	0.463
8:	0.693	0.456
9:	0.618	0.735
10:	0.580	1.047



TARGET APPROX 1/2 SCALE

BARBER - M24 0150218

SERIAL NUMBER: G6410326. __0

TARGET NUMBER: 4

FILE DATE: 10/14/2004

FILE TIME: 07:11

X CENTROID: -0.009

Y CENTROID: 0.363

POA TO CENTROID: 0.364

HORZ SPREAD: 2.106

VERT SPREAD: 2.647

GROUP SPREAD: 2.903

MIN RADIUS: 0.254

MAX RADIUS: 1.656

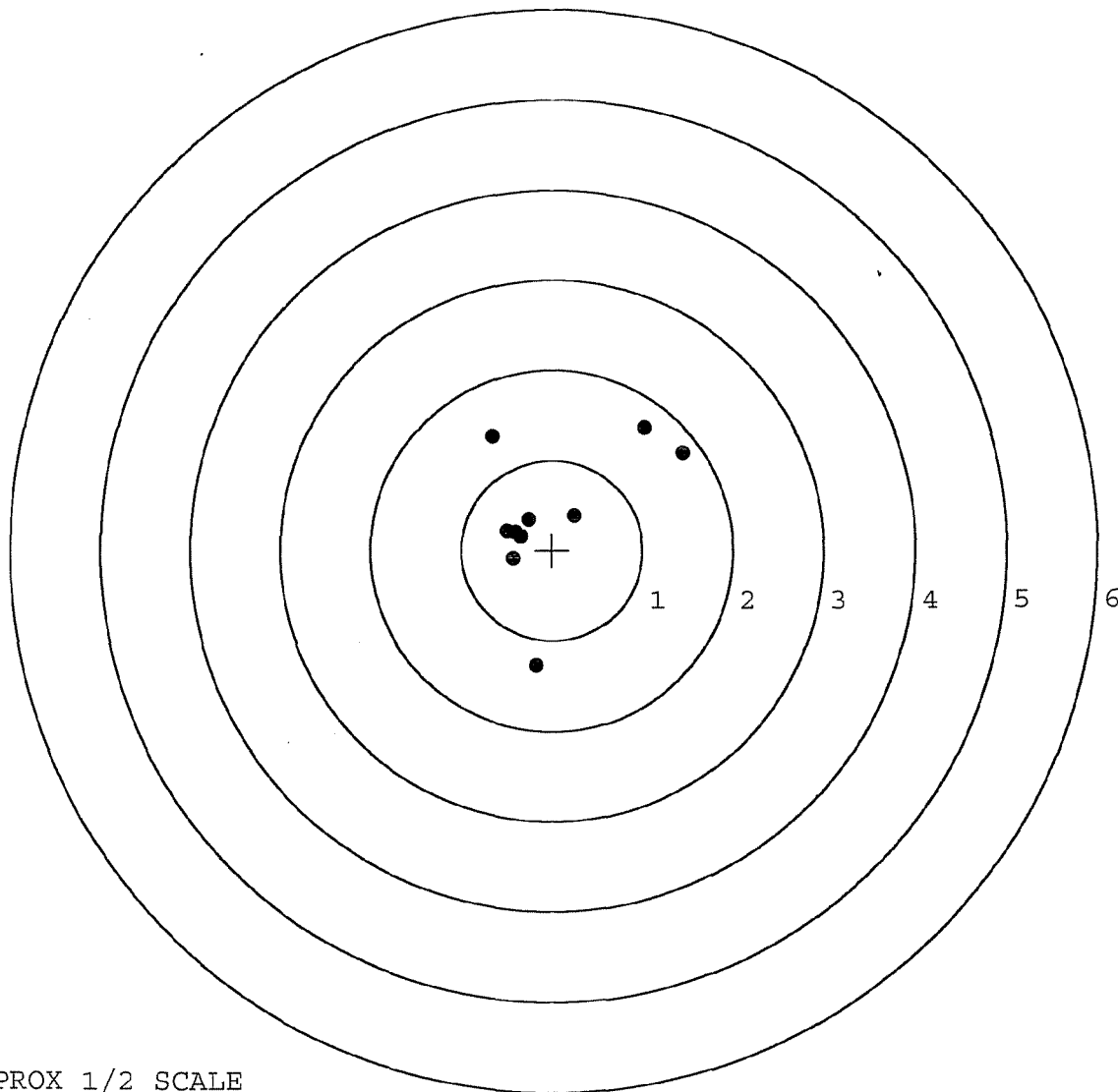
MEAN RADIUS: 0.831

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.016	1.363
2:	1.449	1.081
3:	-0.657	1.265
4:	-0.175	-1.284
5:	0.244	0.384
6:	-0.263	0.346
7:	-0.506	0.215
8:	-0.428	-0.096
9:	-0.359	0.154
10:	-0.408	0.206



TARGET APPROX 1/2 SCALE

BARBER - M24 0150219

SERIAL NUMBER: G6410326. __0

TARGET NUMBER: 5

FILE DATE: 10/14/2004

FILE TIME: 07:11

POINT#	X	Y
1:	0.416	0.698
2:	0.550	0.040
3:	0.293	0.106
4:	1.280	-0.136
5:	-0.164	0.037
6:	-0.366	0.055
7:	-0.655	-0.250
8:	0.300	-0.369
9:	-0.580	-0.931
10:	0.312	-0.378

X CENTROID: 0.139

Y CENTROID: -0.113

POA TO CENTROID: 0.179

HORZ SPREAD: 1.935

VERT SPREAD: 1.629

GROUP SPREAD: 2.023

MIN RADIUS: 0.268

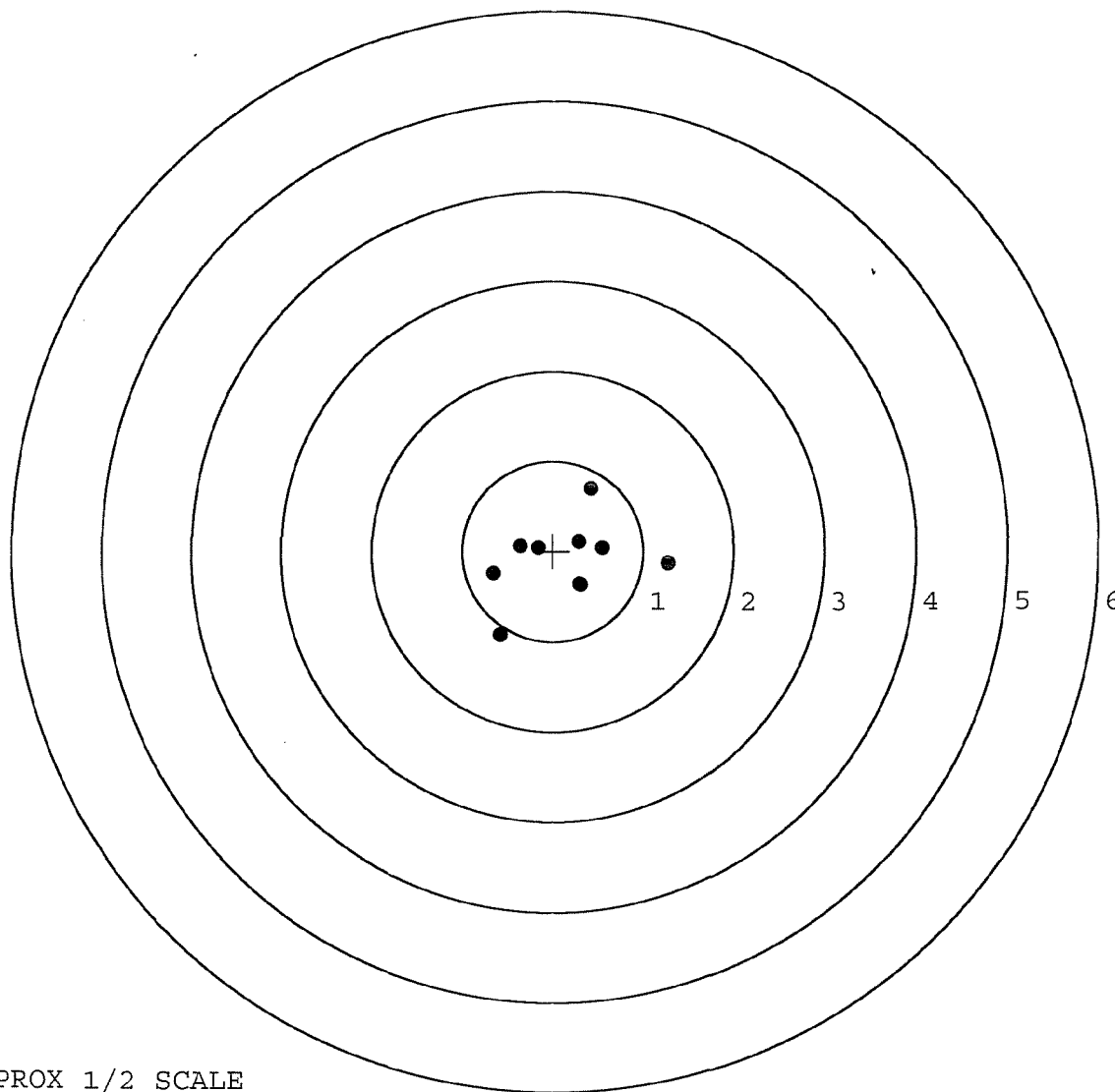
MAX RADIUS: 1.142

MEAN RADIUS: 0.609

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE