

G-6410510

ORDER 25716

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

UPC



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UPC



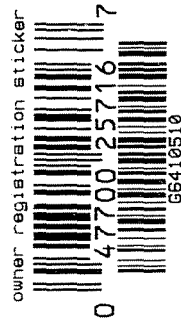
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

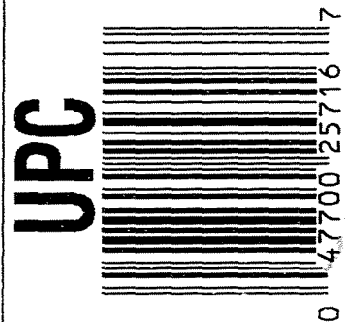


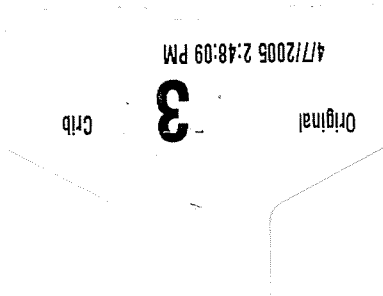
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410510





25716

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



.MA25716

Shop Order: SW5716 - APR



.ABSW5716 - APR

Start Date: 3/11/2005

Finish Date: 4/14/2005

0520 78ROT01
Goff Blast Barrel & Rec Assembly,



0003858612

0540 01PC001
Flat Black Powder Coat, Barrel and



0003858602

0560 89SWS1
Reassemble Action.



0003858603

0690 89SWS1
Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410510

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTL
600	PROOF		1-25-05	✓
607	CHECK HEADSPACE	MAGNA-FLUX	1-25-05	✓
610	DIS-ASSEMBLE GUN	INSPECTED	1-26-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 26 2005 OPERATOR <u> </u>		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRU
620	APPLY COATINGS (BARREL ACTION)		1/31/05	HP
	(BOLT)			
625	FINAL ASSEMBLY		2-1-05	RTL
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-1-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-1-05	RTL
	D) OIL FIRING PIN ASSEMBLY		4-22-05	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 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	5-19-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	5-19-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	5-19-05	AC
	J) ASSEMBLE STOCK		4-22-05	RR
	K) ASSEMBLE SWIVEL STUDS		5-19-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-22-05	RR
	M) IRON SIGHT ALIGNMENT		4-22-05	RR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-22-05	RR
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	4-27-05	TRW
	MALFUNCTION <u>OH</u>	CORRECTION <u>OK</u>	5-2-05	TRW
	MALFUNCTION <u>BAC</u>	CORRECTION <u>OK</u>	5-2-05	TRW
	MALFUNCTION	CORRECTION <u>NA</u>		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		4-27-05	AC
655	FINAL INSPECTION A) HEADSPACE		5-19-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.69</u> <u>2.83</u> <u>2.74</u> <u>2.51</u> <u>2.78</u>	5-9-05	TRW
	C) FUNCTION		5-19-05	AC
660	PACK		5-23-05	RA

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

4-14-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.38	2.70		2.24	
PULL #2	2.02	2.30		2.25	
PULL #3	2.15	2.92		2.49	
PULL #4	2.22	2.57		2.45	
PULL #5	2.15	2.63		2.42	
TOTAL	10.92	13.12		11.85	
AVERAGE	2.18	2.62		2.37	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.02		
PULL #2	3.29	3.27		
PULL #3	3.42	3.01		
PULL #4	3.30	3.03		
PULL #5	2.99	2.93		
TOTAL	16.28	15.26		
AVERAGE	3.25	3.05		

	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	4.41	3.95		4.63
PULL #2	4.64	4.43		4.51
PULL #3	4.28	4.16		4.40
PULL #4	4.24	4.23		4.26
PULL #5	4.21	4.23		4.31
TOTAL	21.78	21.00		22.11
AVERAGE	4.35	4.20		4.42

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410510.___0
FILE DATE AND TIME: 04/27/2005 08:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.038
The Average Y Centroid of the Five Target Set:	-0.185
The Average Point of Impact of the Five Target Set:	0.189
The Average Mean Radius of the Five Target Set:	1.004
The Distance from POA to Centroid Target #1:	0.603
The Distance from Centroid Target #2 to Centroid Target #1:	0.636
The Distance from Centroid Target #3 to Centroid Target #1:	0.565
The Distance from Centroid Target #4 to Centroid Target #1:	0.422
The Distance from Centroid Target #5 to Centroid Target #1:	0.617

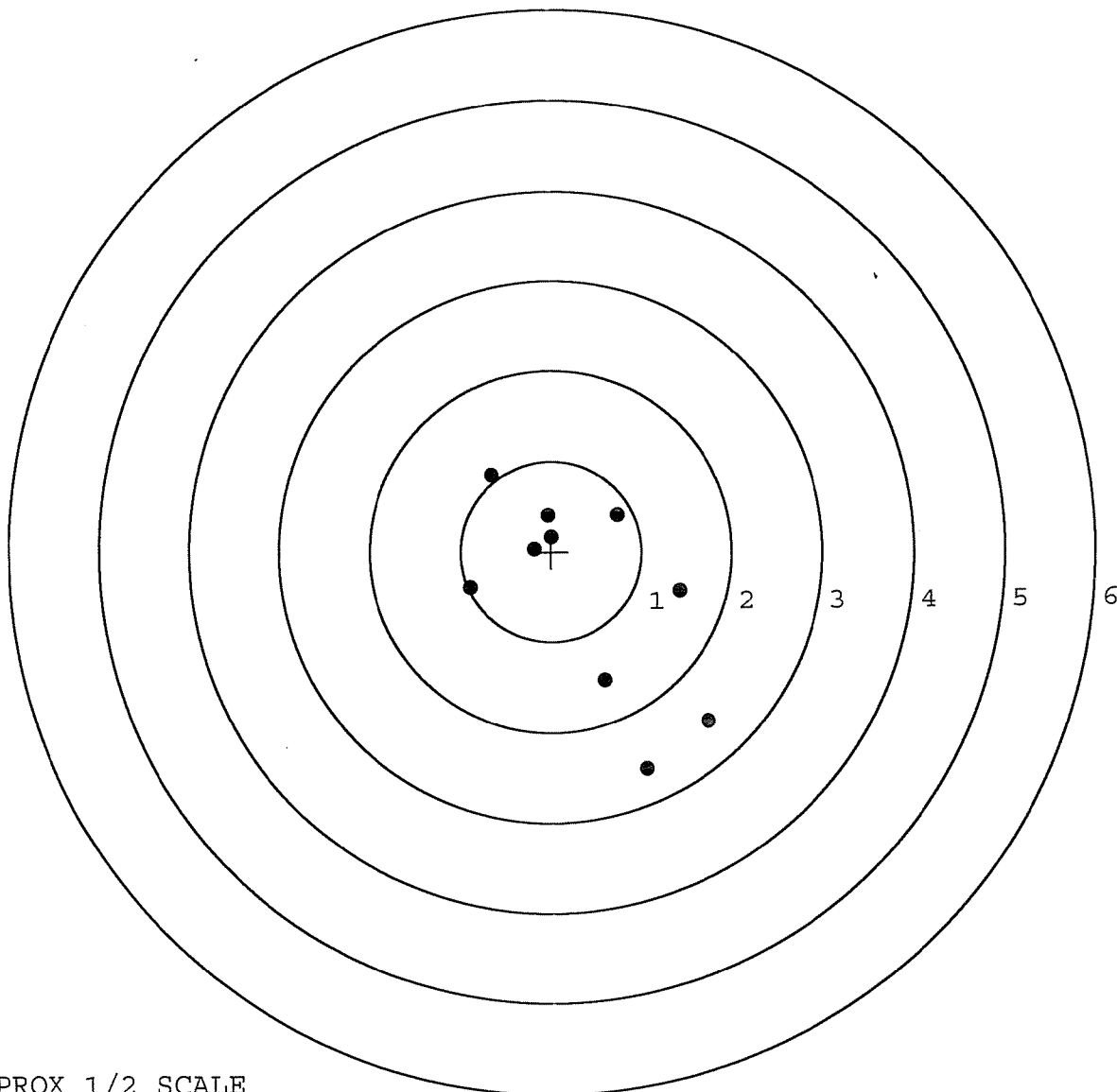
BARBER - M24 0150381

SERIAL NUMBER: G6410510. __0
TARGET NUMBER: 1
FILE DATE: 04/27/2005
FILE TIME: 08:47

X CENTROID: 0.375
Y CENTROID: -0.472
POA TO CENTROID: 0.603
HORZ SPREAD: 2.630
VERT SPREAD: 3.255
GROUP SPREAD: 3.675
MIN RADIUS: 0.739
MAX RADIUS: 2.050
MEAN RADIUS: 1.240

IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.050	-2.408
2:	1.731	-1.884
3:	0.593	-1.432
4:	1.426	-0.443
5:	0.739	0.401
6:	-0.655	0.847
7:	-0.899	-0.396
8:	-0.190	0.027
9:	-0.003	0.163
10:	-0.040	0.404



TARGET APPROX 1/2 SCALE

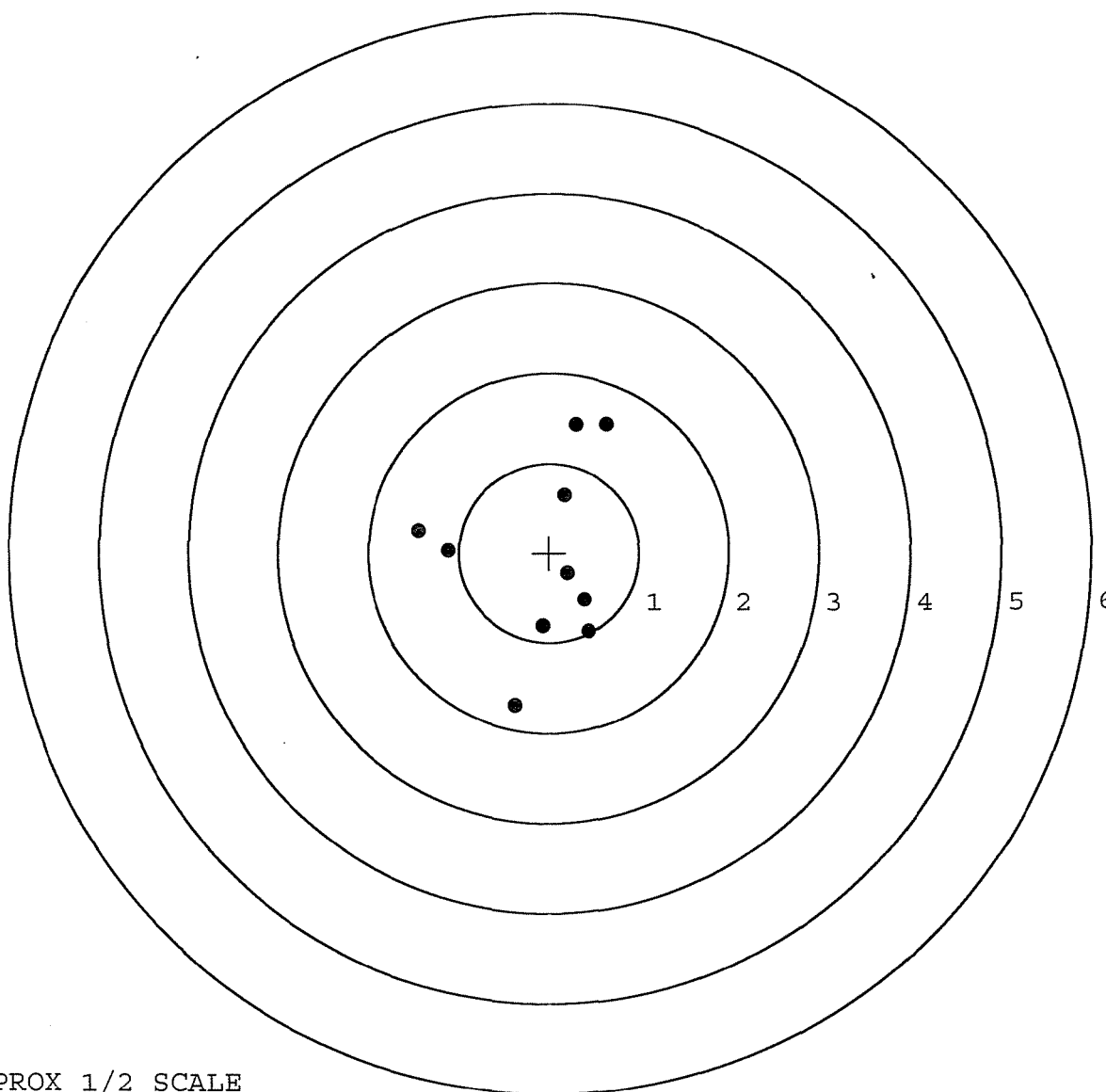
BARBER - M24 0150382

SERIAL NUMBER: G6410510. __0
TARGET NUMBER: 2
FILE DATE: 04/27/2005
FILE TIME: 08:47

X CENTROID: -0.089
Y CENTROID: -0.037
POA TO CENTROID: 0.097
HORZ SPREAD: 2.088
VERT SPREAD: 3.133
GROUP SPREAD: 3.294
MIN RADIUS: 0.350
MAX RADIUS: 1.686
MEAN RADIUS: 1.082

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.381	-1.698
2:	0.435	-0.885
3:	-0.078	-0.821
4:	0.393	-0.530
5:	0.203	-0.229
6:	0.173	0.640
7:	-1.117	0.033
8:	-1.453	0.251
9:	0.296	1.432
10:	0.635	1.435



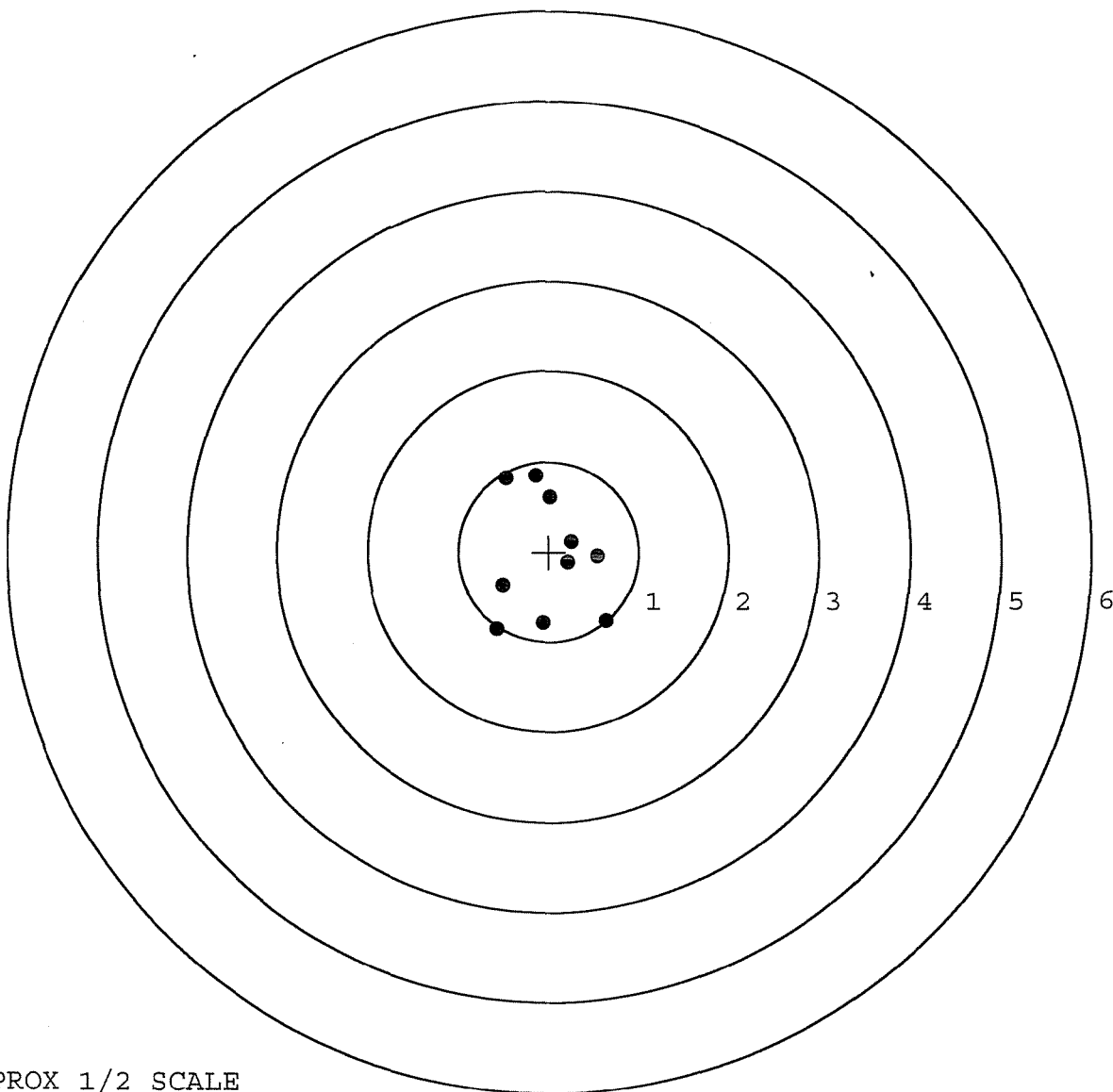
TARGET APPROX 1/2 SCALE

BARBER - M24 0150383

SERIAL NUMBER: G6410510. __0
TARGET NUMBER: 3
FILE DATE: 04/27/2005
FILE TIME: 08:47

X CENTROID: -0.009
Y CENTROID: -0.059
POA TO CENTROID: 0.059
HORZ SPREAD: 1.215
VERT SPREAD: 1.705
GROUP SPREAD: 1.942
MIN RADIUS: 0.224
MAX RADIUS: 0.990
MEAN RADIUS: 0.695
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.645	-0.772
2:	-0.062	-0.798
3:	-0.570	-0.863
4:	-0.508	-0.376
5:	0.207	-0.117
6:	0.544	-0.048
7:	0.252	0.117
8:	0.017	0.612
9:	-0.145	0.842
10:	-0.472	0.817



TARGET APPROX 1/2 SCALE

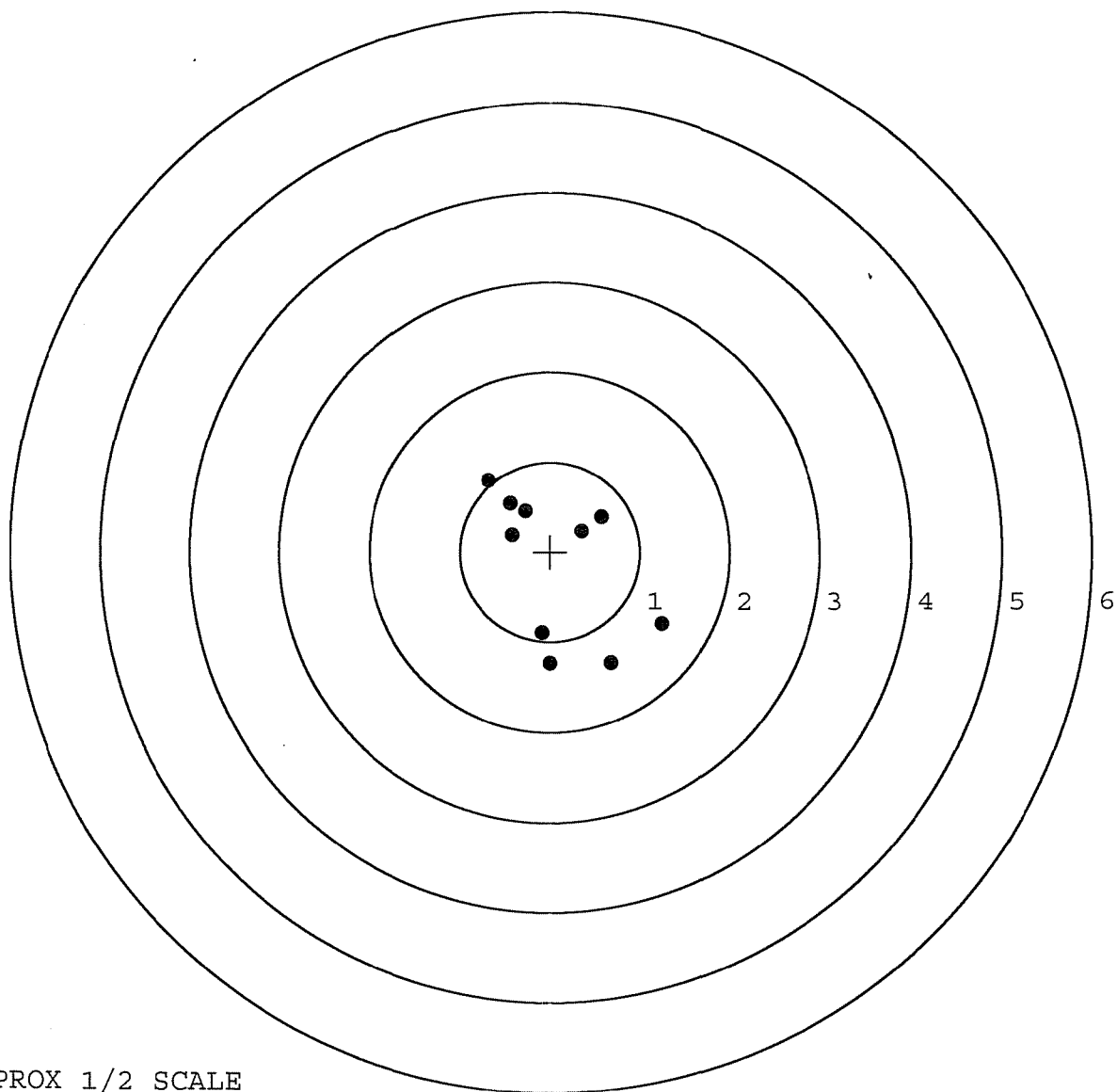
BARBER - M24 0150384

SERIAL NUMBER: G6410510. __0
TARGET NUMBER: 4
FILE DATE: 04/27/2005
FILE TIME: 08:47

X CENTROID: 0.091
Y CENTROID: -0.159
POA TO CENTROID: 0.184
HORZ SPREAD: 1.929
VERT SPREAD: 2.039
GROUP SPREAD: 2.508
MIN RADIUS: 0.464
MAX RADIUS: 1.324
MEAN RADIUS: 0.907

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.010	-1.243
2:	-0.094	-0.909
3:	0.679	-1.239
4:	1.246	-0.807
5:	0.579	0.393
6:	0.347	0.228
7:	-0.425	0.190
8:	-0.280	0.454
9:	-0.446	0.545
10:	-0.683	0.796



TARGET APPROX 1/2 SCALE

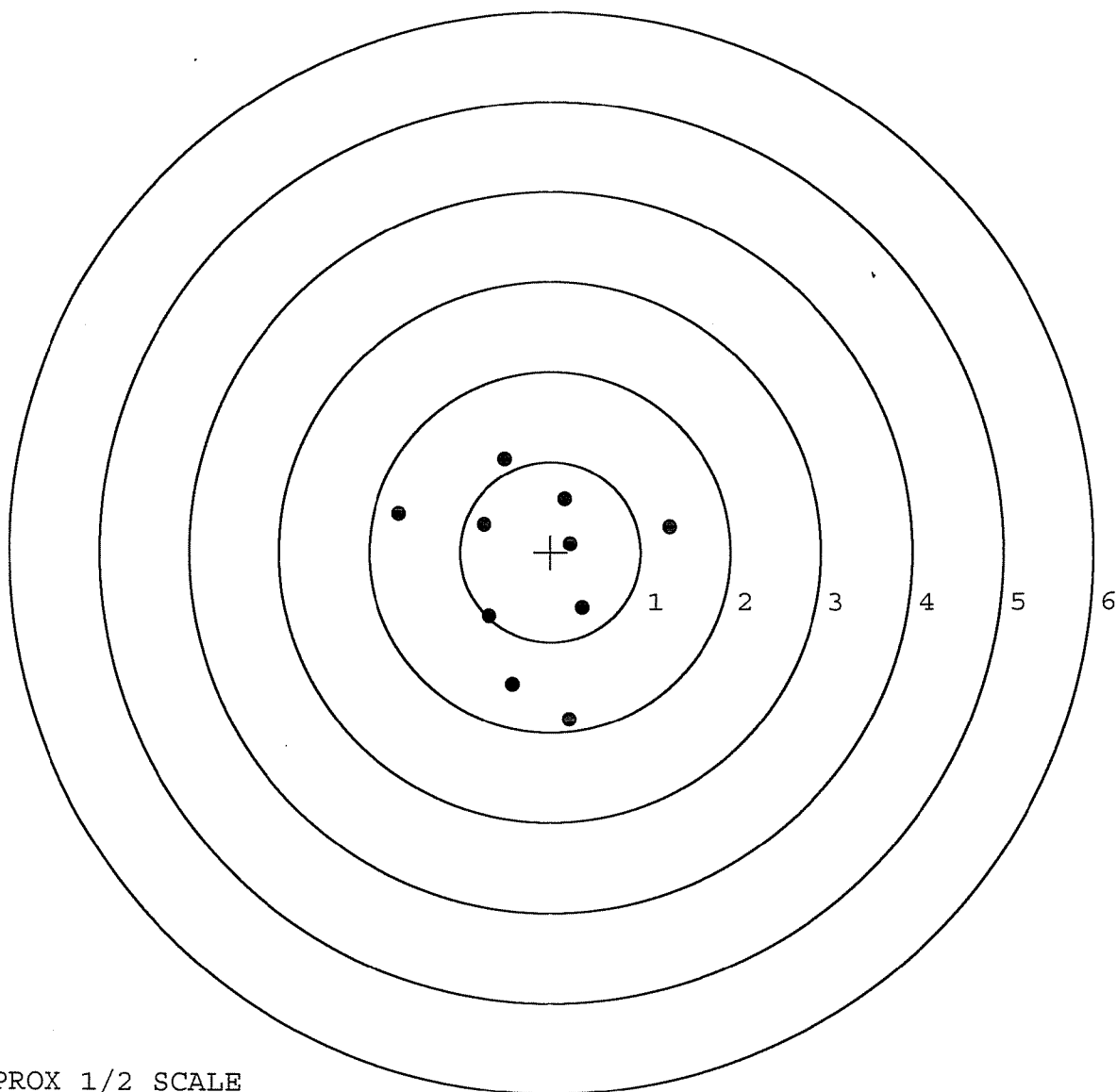
BARBER - M24 0150385

SERIAL NUMBER: G6410510. __0
TARGET NUMBER: 5
FILE DATE: 04/27/2005
FILE TIME: 08:47

X CENTROID: -0.178
Y CENTROID: -0.198
POA TO CENTROID: 0.266
HORZ SPREAD: 3.004
VERT SPREAD: 2.895
GROUP SPREAD: 2.982
MIN RADIUS: 0.487
MAX RADIUS: 1.711
MEAN RADIUS: 1.097

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.347	-0.623
2:	1.326	0.274
3:	0.216	0.088
4:	-0.682	-0.718
5:	-0.426	-1.478
6:	0.208	-1.865
7:	0.156	0.584
8:	-0.507	1.030
9:	-1.678	0.421
10:	-0.738	0.304



TARGET APPROX 1/2 SCALE