

G-64/ 4395

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

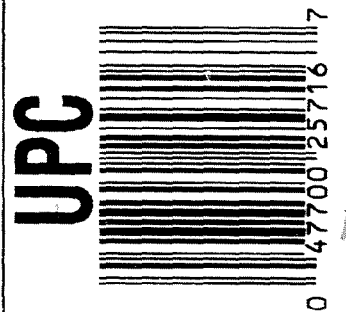
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6414395



ORDER 25716

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

UPC



0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



65414385

BARBER - M24 0151572

1/10/2005 2:46:09 PM

qmc

92

Original

25716

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



.MA25716

Shop Order: SWS10-15-6



.ABSWS10-15-6

Start Date: 1/10/2005

Finish Date: 2/15/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0003662183

0540

01PC001

Flat Black Powder Coat, Barrel and



0003662173

0560

89SWS1

Reassemble Action.



0003662174

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0151572 0151611

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL6414395

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTL
600	PROOF		12/28/04	HC
607	CHECK HEADSPACE		12/28/04	HC
610	DIS-ASSEMBLE GUN		12-28-04	RTA
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		OPERATOR	
615	ROLLMARK CALIBER		12-29-04	RS
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRL
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-7-05	RR
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-7-05	RR
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-7-05	RR
	D) OIL FIRING PIN ASSEMBLY		2-9-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-29-05	TRW

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>	3-29-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	3-29-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	3-29-05	Ac
	J) ASSEMBLE STOCK		2-9-05	RT
	K) ASSEMBLE SWIVEL STUDS		3-29-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-9-05	RT
	M) IRON SIGHT ALIGNMENT		2-9-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-9-05	RT
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	2-11-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-10-05	Ac
655	FINAL INSPECTION A) HEADSPACE		3-29-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.78</u> <u>2.73</u> <u>2.35</u> <u>2.77</u>	3-29-05	TRW
	C) FUNCTION		3-29-05	Ac
660	PACK		3/30/05	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.

G 641 4395

DATE

2-1-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.51		2.32	
PULL #2	2.46	2.36		2.35	
PULL #3	2.65	2.31		2.31	
PULL #4	2.67	2.31		2.25	
PULL #5	2.65	2.34		2.26	
TOTAL	12.80	11.83		11.49	
AVERAGE	2.56	2.36		2.29	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.29		
PULL #2	3.21	3.26		
PULL #3	3.28	3.27		
PULL #4	3.24	3.24		
PULL #5	3.32	3.26		
TOTAL	16.12	16.32		
AVERAGE	3.22	3.26		

	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	4.05		3.97
PULL #2	4.15	4.02		4.36
PULL #3	4.24	3.89		4.30
PULL #4	4.08	4.22		4.33
PULL #5	4.10	4.14		4.29
TOTAL	20.74	20.32		21.25
AVERAGE	4.14	4.06		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

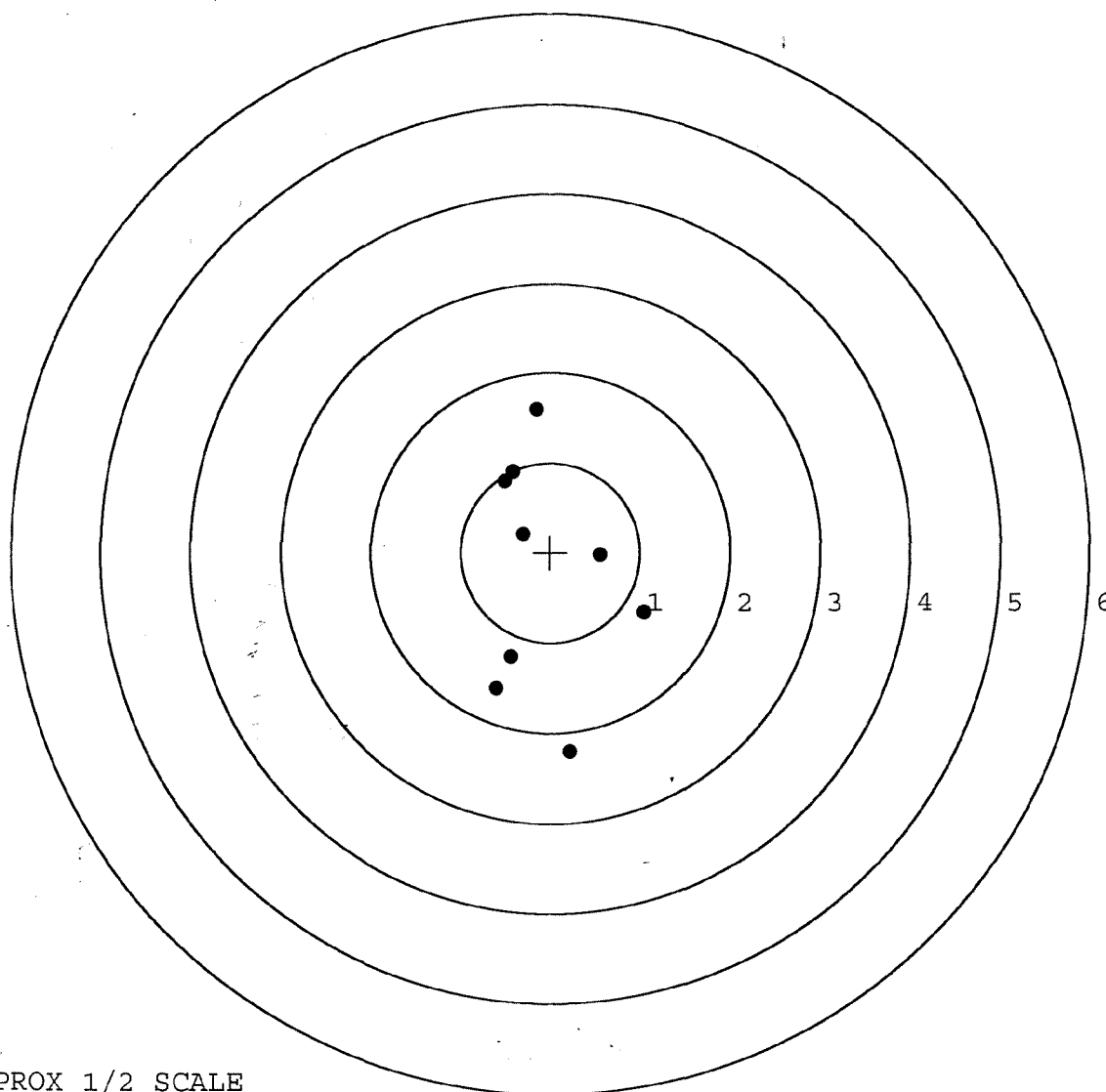
FIREARM SERIAL NUMBER / DATASET NAME: G6414395.____0
FILE DATE AND TIME: 02/11/2005 09:34

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.169
The Average Y Centroid of the Five Target Set:	-0.163
The Average Point of Impact of the Five Target Set:	0.235
The Average Mean Radius of the Five Target Set:	1.036
The Distance from POA to Centroid Target #1:	0.243
The Distance from Centroid Target #2 to Centroid Target #1:	0.250
The Distance from Centroid Target #3 to Centroid Target #1:	0.114
The Distance from Centroid Target #4 to Centroid Target #1:	0.334
The Distance from Centroid Target #5 to Centroid Target #1:	0.127

BARBER - M24 0151577

SERIAL NUMBER: G6414395: __0	POINT#	X	Y
TARGET NUMBER: 1	1:	0.215	-2.207
FILE DATE: 02/11/2005	2:	-0.611	-1.512
FILE TIME: 09:34	3:	-0.446	-1.166
	4:	1.042	-0.670
X CENTROID: -0.071	5:	0.554	-0.030
Y CENTROID: -0.232	6:	-0.312	0.203
POA TO CENTROID: 0.243	7:	-0.508	0.798
HORZ SPREAD: 1.653	8:	-0.417	0.900
VERT SPREAD: 3.799	9:	-0.158	1.592
GROUP SPREAD: 3.817			
MIN RADIUS: 0.498			
MAX RADIUS: 1.995			
MEAN RADIUS: 1.208			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 2			
# in 3 IN DIAMETER: 7			



TARGET APPROX 1/2 SCALE

BARBER - M24 0151578

SERIAL NUMBER: G6414395: 0

TARGET NUMBER: 2

FILE DATE: 02/11/2005

FILE TIME: 09:34

POINT#	X	Y
1:	0.184	-1.338
2:	-0.199	-1.177
3:	-1.196	-1.852
4:	-1.248	-2.612
5:	-0.506	-0.222
6:	0.174	0.238
7:	0.141	0.457
8:	-0.177	0.589
9:	-0.866	1.099
10:	0.744	1.386

X CENTROID: -0.295

Y CENTROID: -0.343

POA TO CENTROID: 0.452

HORZ SPREAD: 1.992

VERT SPREAD: 3.998

GROUP SPREAD: 4.467

MIN RADIUS: 0.243

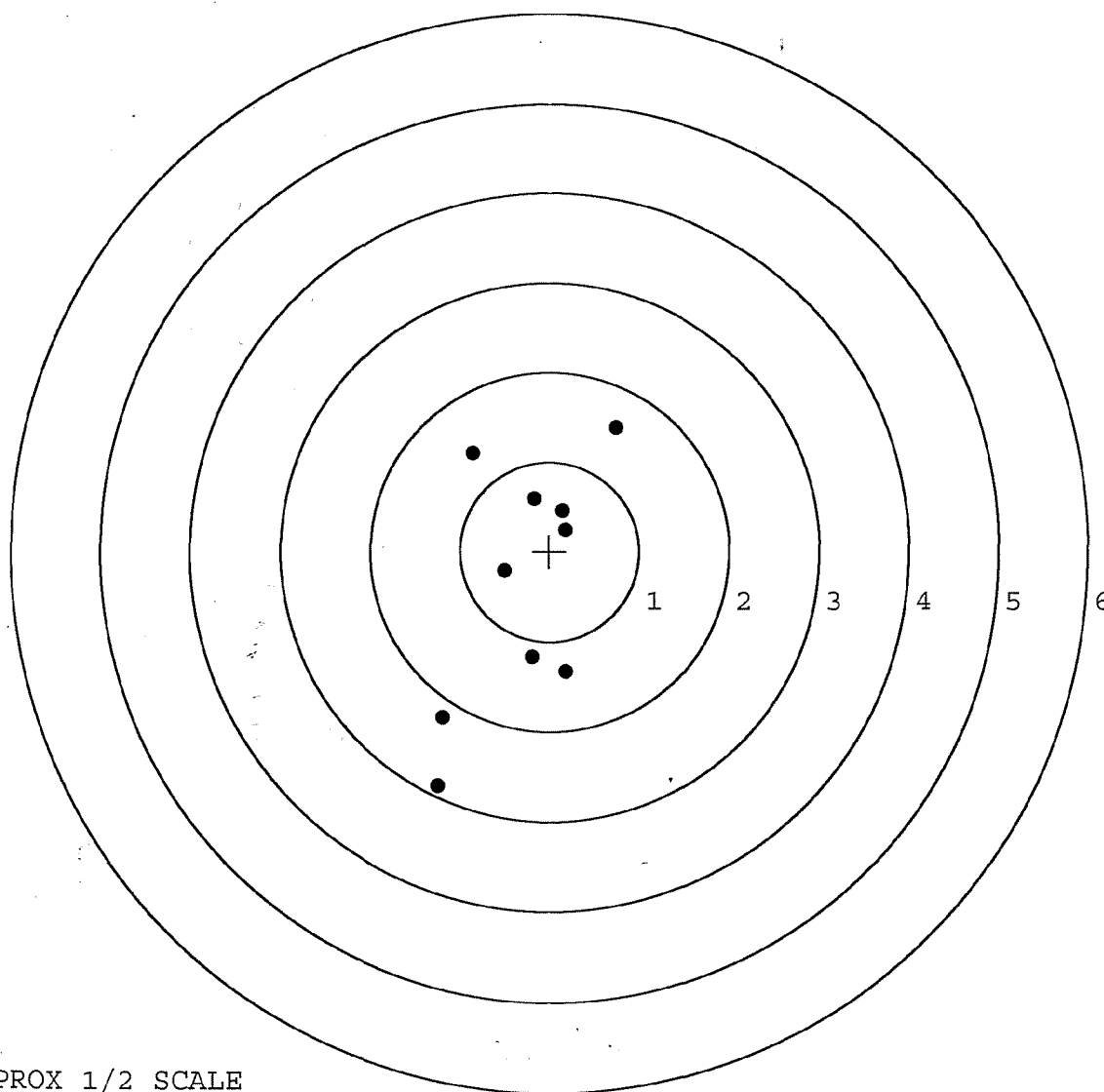
MAX RADIUS: 2.461

MEAN RADIUS: 1.257

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

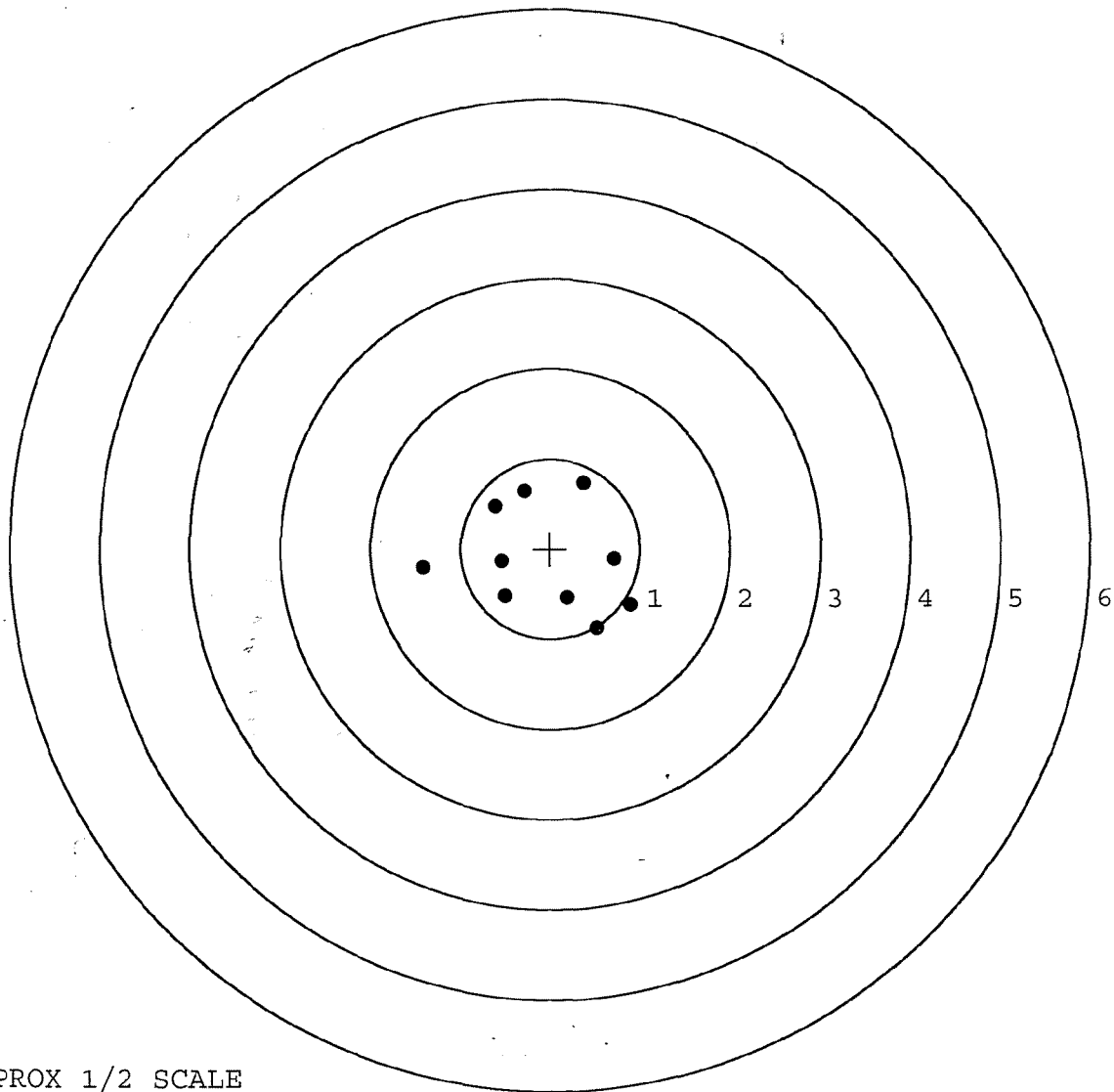
in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

BARBER - M24 0151579

SERIAL NUMBER: G6414395: 0	POINT#	X	Y
TARGET NUMBER: 3	1:	0.896	-0.624
FILE DATE: 02/11/2005	2:	0.514	-0.881
FILE TIME: 09:34	3:	0.190	-0.548
	4:	0.716	-0.111
X CENTROID: -0.068	5:	0.370	0.737
Y CENTROID: -0.118	6:	-0.289	0.646
POA TO CENTROID: 0.137	7:	-0.616	0.474
HORZ SPREAD: 2.314	8:	-0.541	-0.135
VERT SPREAD: 1.618	9:	-0.502	-0.528
GROUP SPREAD: 2.350	10:	-1.418	-0.214
MIN RADIUS: 0.473			
MAX RADIUS: 1.353			
MEAN RADIUS: 0.832			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

BARBER - M24 0151580

SERIAL NUMBER: G6414395: __0

TARGET NUMBER: 4

FILE DATE: 02/11/2005

FILE TIME: 09:34

POINT#	X	Y
1:	0.625	0.320
2:	-0.096	0.661
3:	-0.384	1.101
4:	-1.428	2.480
5:	-0.145	-0.070
6:	0.281	-0.446
7:	-0.139	-0.619
8:	-0.534	-1.003
9:	-0.496	-1.254
10:	0.131	-0.495

X CENTROID: -0.218

Y CENTROID: 0.068

POA TO CENTROID: 0.229

HORZ SPREAD: 2.053

VERT SPREAD: 3.734

GROUP SPREAD: 3.849

MIN RADIUS: 0.156

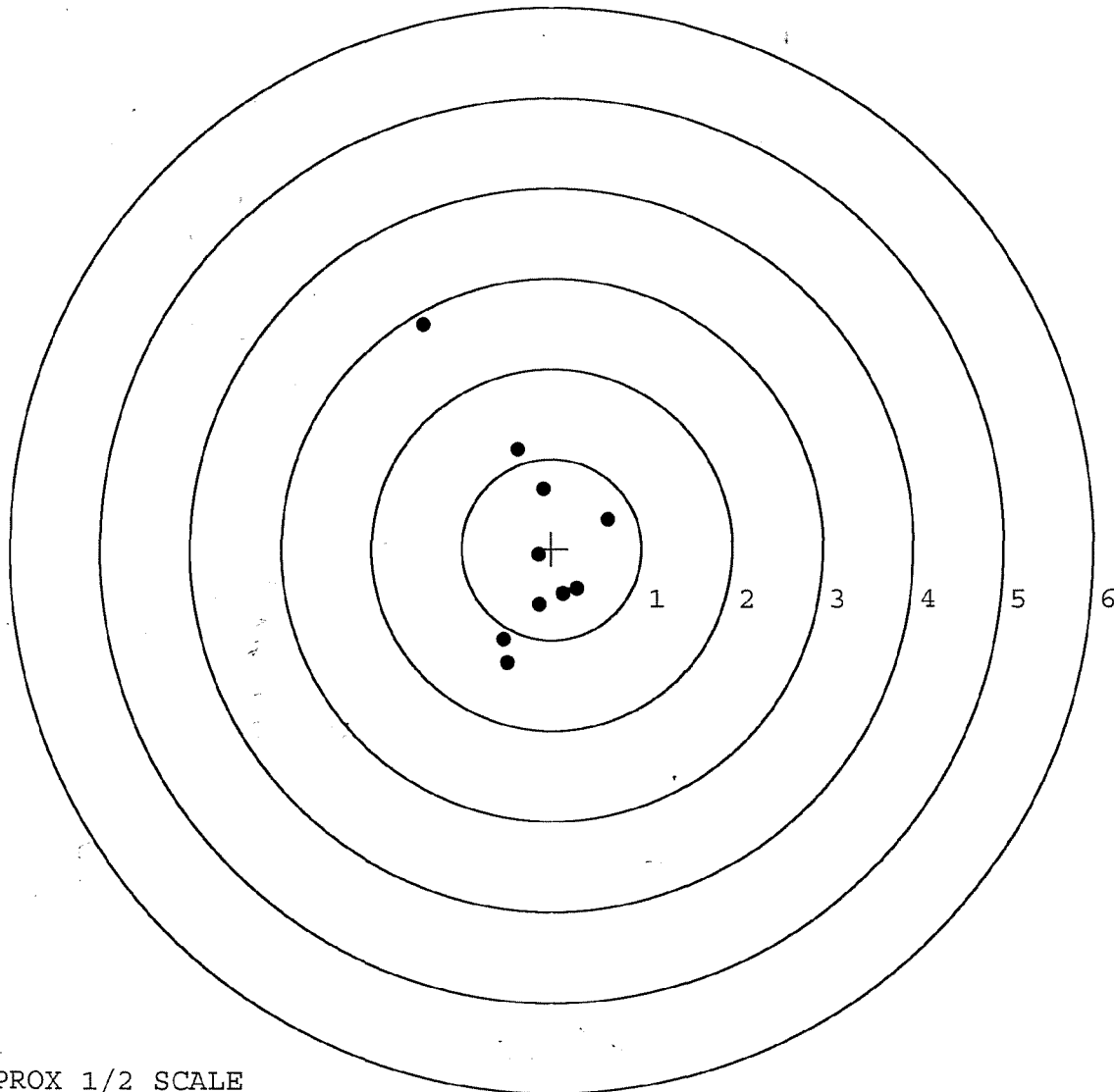
MAX RADIUS: 2.699

MEAN RADIUS: 0.992

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

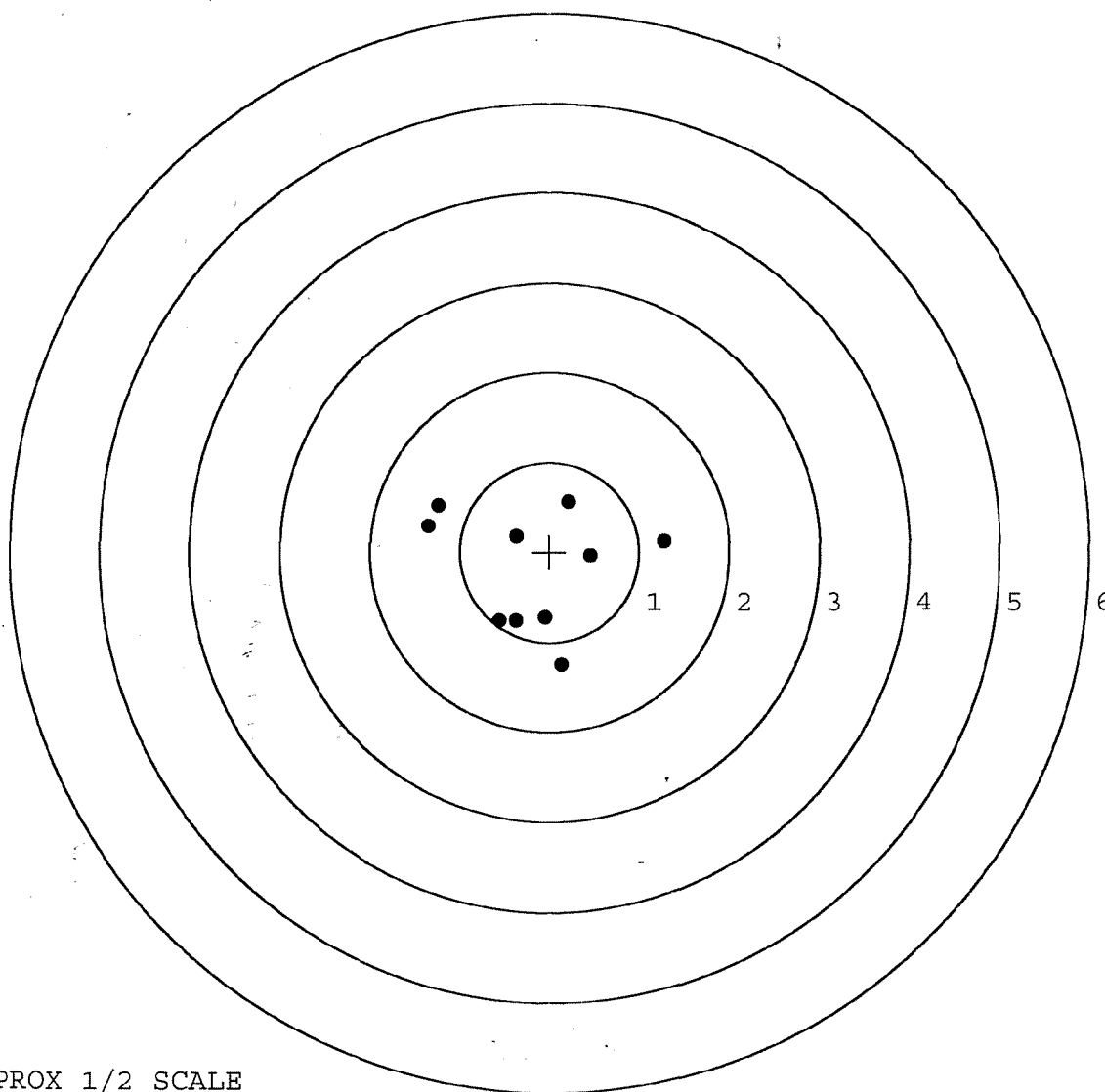
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0151581

SERIAL NUMBER: G6414395:___0	POINT#	X	Y
TARGET NUMBER: 5	1:	1.267	0.121
FILE DATE: 02/11/2005	2:	0.457	-0.044
FILE TIME: 09:34	3:	0.138	-1.256
	4:	-0.052	-0.733
X CENTROID: -0.191	5:	-0.378	-0.764
Y CENTROID: -0.190	6:	-0.566	-0.762
POA TO CENTROID: 0.269	7:	-1.243	0.517
HORZ SPREAD: 2.627	8:	0.208	0.556
VERT SPREAD: 1.812	9:	-0.378	0.178
GROUP SPREAD: 2.632	10:	-1.360	0.288
MIN RADIUS: 0.413			
MAX RADIUS: 1.490			
MEAN RADIUS: 0.891			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 6			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE