

G 646 15-5-8

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



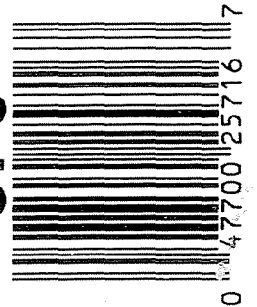
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461558

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



SERIAL NO.



Original
6/17/2005 2:12:04 PM
28
Crib

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004012773

0540

01PC001

Flat Black Powder Coat, Barrel and



0004012763

0560

89SWS1

Reassemble Action.



0004012764

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 60461558

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTZ
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTZ
470	DIS-ASSEMBLE ACTION		9-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	9/8/05	mm8
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	mm
530 & 540	APPLY COATINGS (BARREL ACTION)		9/15	RB HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-19-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-19-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-19-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		9-19-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

REV-8405

BARBER - M24 0152005			READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>416</u>	<u>416</u>	<u>416</u>	10/24/05	BC		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>216</u>	<u>216</u>	<u>216</u>	10/24/05	BC		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u>	<u>.025</u>	<u>.025</u>	10/24/05	BC		
	J) ASSEMBLE STOCK					9-19-05	RTL		
	K) ASSEMBLE SWIVEL STUDS					10/24/05	BC		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					10-12-05	A		
	M) IRON SIGHT ALIGNMENT					10-12-05	A		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					10-12-05	A		
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		10-13-05	TRW		
			PASS	FAIL					
	MALFUNCTION		N/A						
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION								
660	INSPECT FOR LIVE AMMO					10-13-05	A		
670	FINAL INSPECTION A) HEADSPACE					10/24/05	BC		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.61</u>	<u>2.52</u>	<u>2.70</u>	<u>2.49</u>	<u>2.58</u>	10-24-05	TRW
	C) FUNCTION					10/24/05	BC		
690	PACK					10/24/05	OA		

BARBER - M24 0152986

 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

TESTER

9/15/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.23	2.20	2.38	
PULL #2	2.26	2.44	2.60	
PULL #3	2.55	2.32	2.87	
PULL #4	2.45	2.26	2.76	
PULL #5	2.72	2.41	2.37	
TOTAL	12.21	11.63	12.98	
AVERAGE	2.44	2.33	2.60	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.62	2.82	
PULL #2	3.36	2.83	
PULL #3	3.35	2.93	
PULL #4	3.17	2.95	
PULL #5	3.18	3.13	
TOTAL	16.68	14.66	
AVERAGE	3.34	2.93	

	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	3.98	3.48		4.09
PULL #2	4.04	3.60		3.86
PULL #3	4.06	3.73		4.12
PULL #4	3.66	3.96		4.16
PULL #5	4.03	3.64		4.12
TOTAL	19.77	18.41		20.35
AVERAGE	3.95	3.68		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461558.___0

FILE DATE AND TIME: 10/13/2005 09:49

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.117
The Average Y Centroid of the Five Target Set:	-0.016
The Average Point of Impact of the Five Target Set:	0.118
The Average Mean Radius of the Five Target Set:	0.684
The Distance from POA to Centroid Target #1:	0.059
The Distance from Centroid Target #2 to Centroid Target #1:	0.102
The Distance from Centroid Target #3 to Centroid Target #1:	0.128
The Distance from Centroid Target #4 to Centroid Target #1:	0.378
The Distance from Centroid Target #5 to Centroid Target #1:	0.066

BARBER - M24 0152988

SERIAL NUMBER: G6461558. __0

TARGET NUMBER: 1

FILE DATE: 10/13/2005

FILE TIME: 09:49

POINT#	X	Y
1:	0.280	-0.934
2:	-0.775	-0.524
3:	0.025	-0.474
4:	0.255	-0.388
5:	0.150	-0.179
6:	0.216	-0.027
7:	-0.377	0.044
8:	-0.120	0.248
9:	-0.735	0.874
10:	0.534	1.150

X CENTROID: -0.055

Y CENTROID: -0.021

POA TO CENTROID: 0.059

HORZ SPREAD: 1.309

VERT SPREAD: 2.084

GROUP SPREAD: 2.125

MIN RADIUS: 0.259

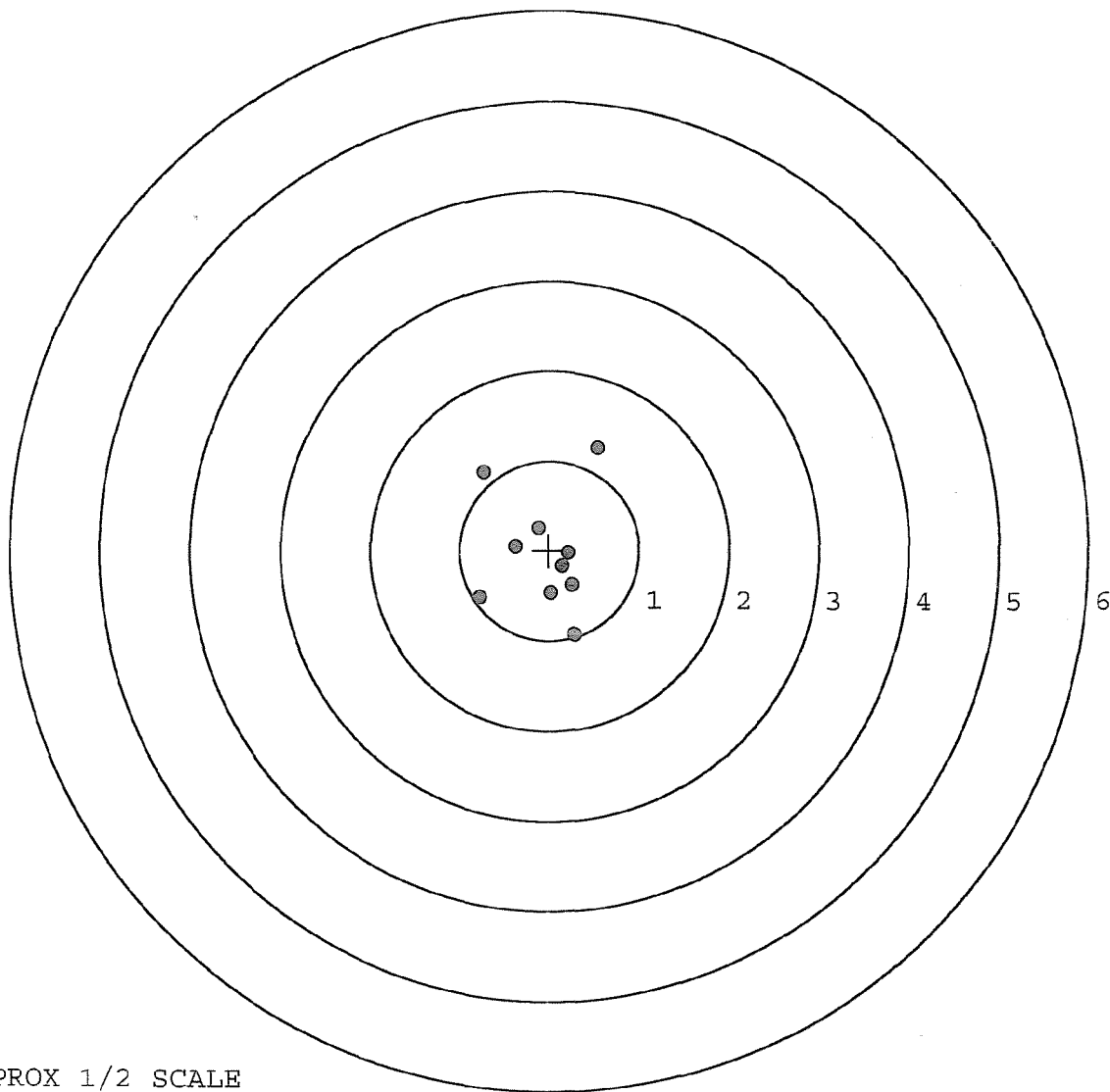
MAX RADIUS: 1.311

MEAN RADIUS: 0.636

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



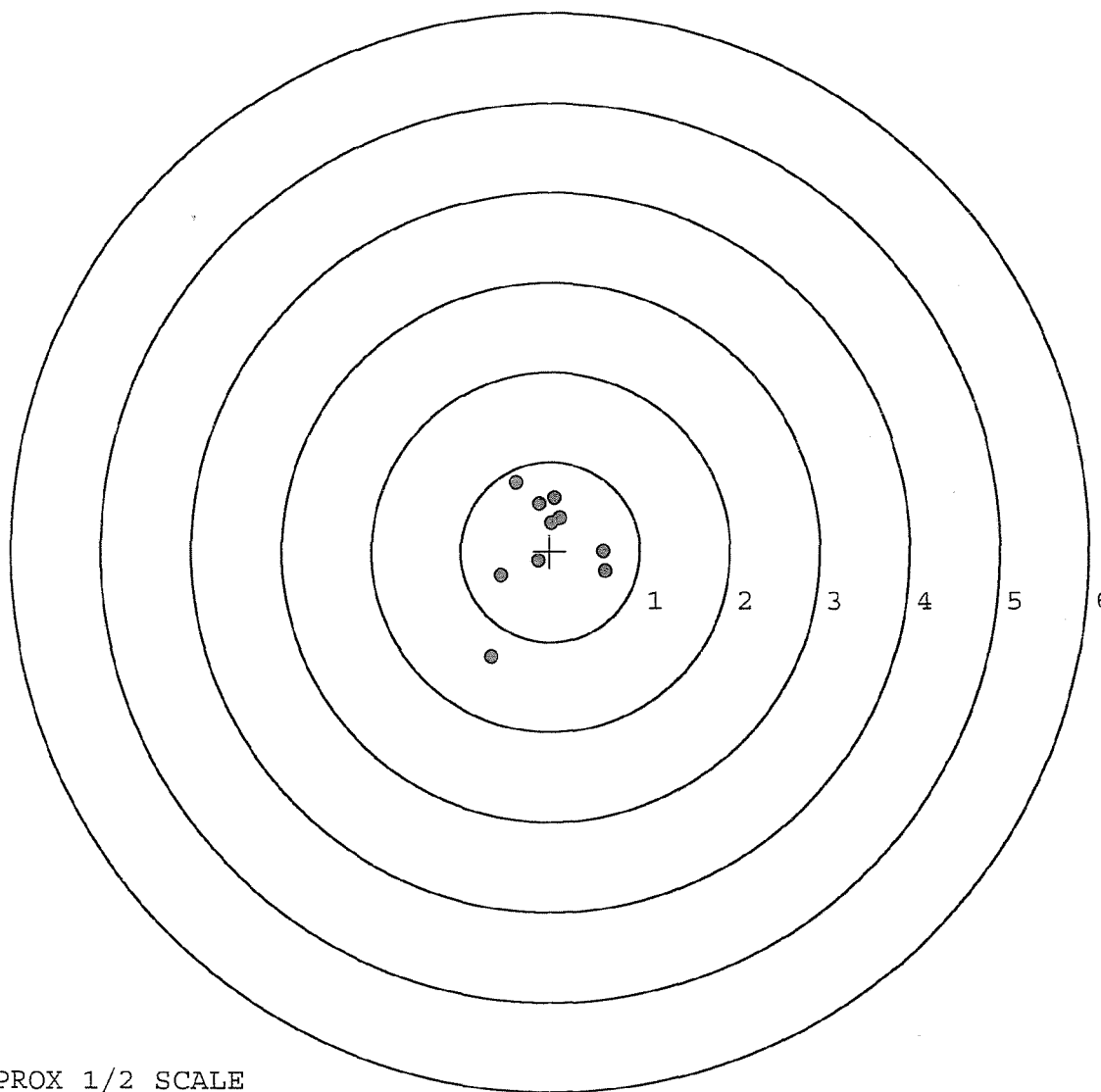
TARGET APPROX 1/2 SCALE

BARBER - M24 0152989

SERIAL NUMBER: G6461558. __0
 TARGET NUMBER: 2
 FILE DATE: 10/13/2005
 FILE TIME: 09:49

POINT#	X	Y
1:	0.614	-0.221
2:	0.595	-0.001
3:	-0.655	-1.171
4:	-0.553	-0.273
5:	-0.132	-0.111
6:	0.016	0.314
7:	0.111	0.373
8:	0.049	0.598
9:	-0.121	0.530
10:	-0.386	0.773

X CENTROID: -0.046
 Y CENTROID: 0.081
 POA TO CENTROID: 0.093
 HORZ SPREAD: 1.269
 VERT SPREAD: 1.944
 GROUP SPREAD: 1.963
 MIN RADIUS: 0.210
 MAX RADIUS: 1.392
 MEAN RADIUS: 0.592
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



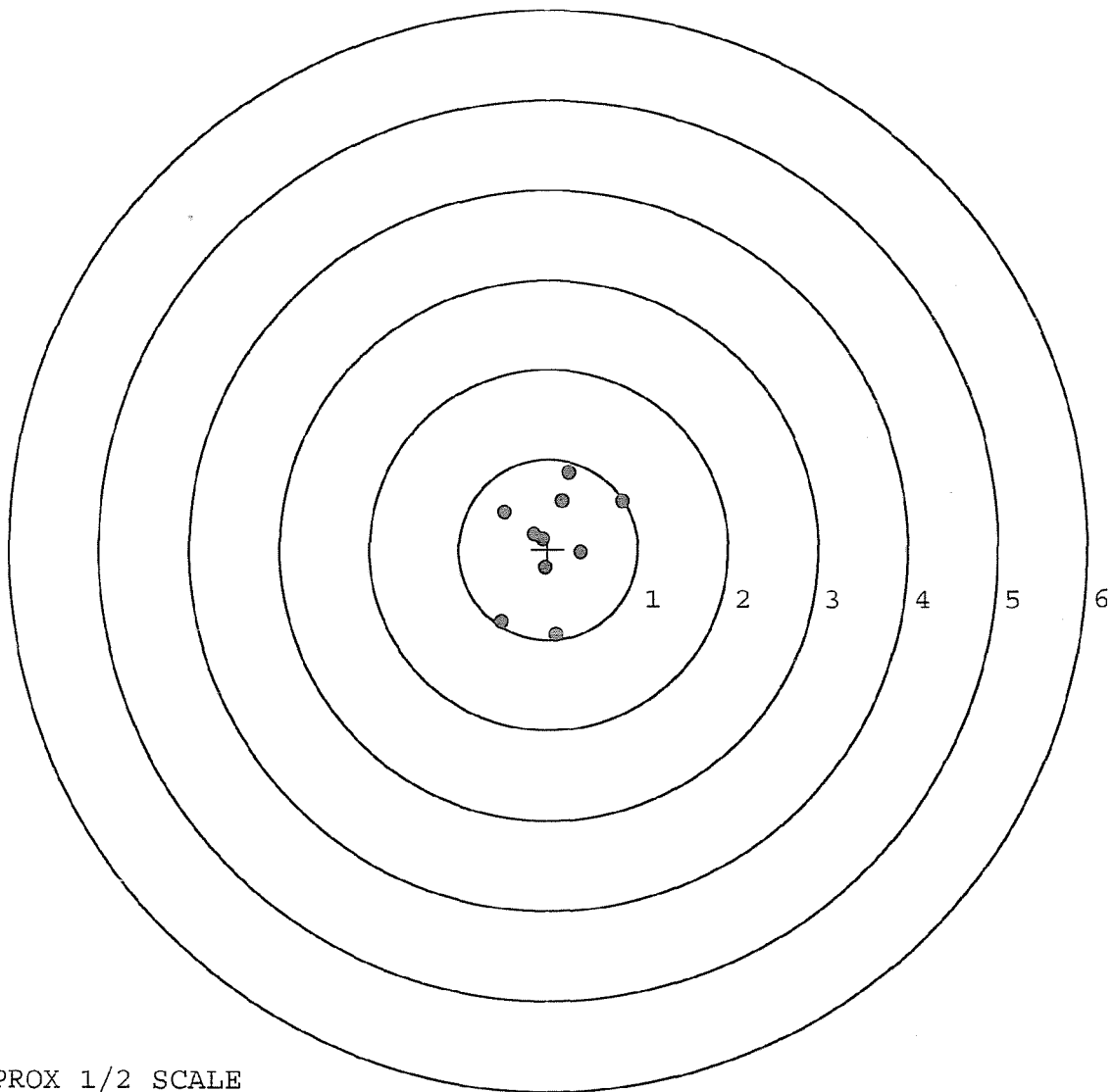
TARGET APPROX 1/2 SCALE

BARBER - M24 0152990

SERIAL NUMBER: G6461558. __0
 TARGET NUMBER: 3
 FILE DATE: 10/13/2005
 FILE TIME: 09:49

POINT#	X	Y
1:	0.089	-0.948
2:	-0.522	-0.802
3:	0.821	0.534
4:	0.232	0.854
5:	0.158	0.538
6:	-0.487	0.415
7:	-0.159	0.168
8:	-0.059	0.116
9:	-0.030	-0.201
10:	0.366	-0.029

X CENTROID: 0.041
 Y CENTROID: 0.065
 POA TO CENTROID: 0.076
 HORZ SPREAD: 1.343
 VERT SPREAD: 1.802
 GROUP SPREAD: 1.894
 MIN RADIUS: 0.112
 MAX RADIUS: 1.033
 MEAN RADIUS: 0.584
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



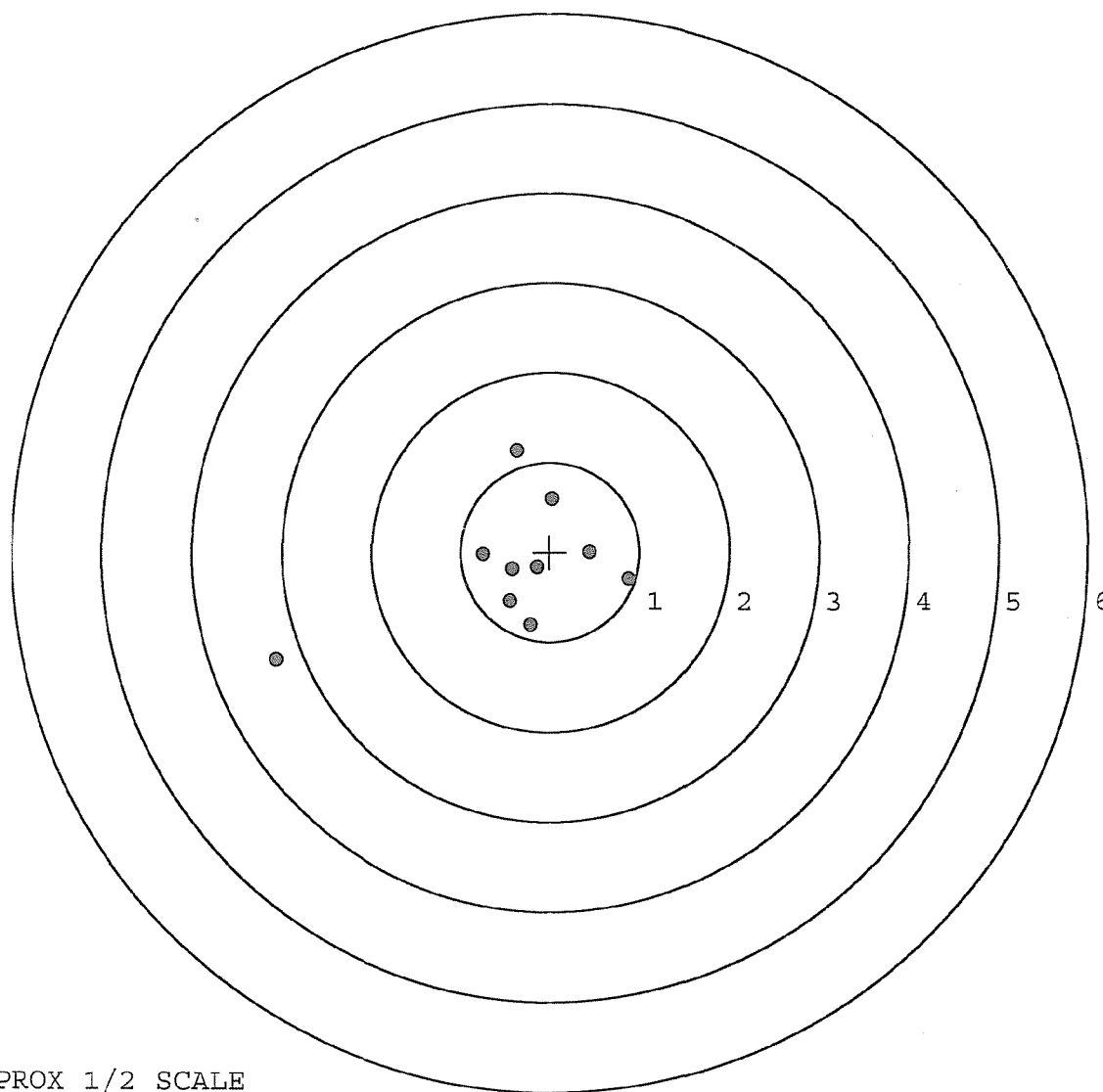
TARGET APPROX 1/2 SCALE

BARBER - M24 0152991

SERIAL NUMBER: G6461558. __0
 TARGET NUMBER: 4
 FILE DATE: 10/13/2005
 FILE TIME: 09:49

POINT#	X	Y
1:	0.880	-0.303
2:	0.444	0.004
3:	0.020	0.599
4:	-0.376	1.131
5:	-0.146	-0.171
6:	-0.422	-0.187
7:	-0.749	-0.021
8:	-0.224	-0.814
9:	-0.447	-0.549
10:	-3.073	-1.203

X CENTROID: -0.409
 Y CENTROID: -0.151
 POA TO CENTROID: 0.436
 HORZ SPREAD: 3.953
 VERT SPREAD: 2.334
 GROUP SPREAD: 4.054
 MIN RADIUS: 0.038
 MAX RADIUS: 2.864
 MEAN RADIUS: 0.893
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 9



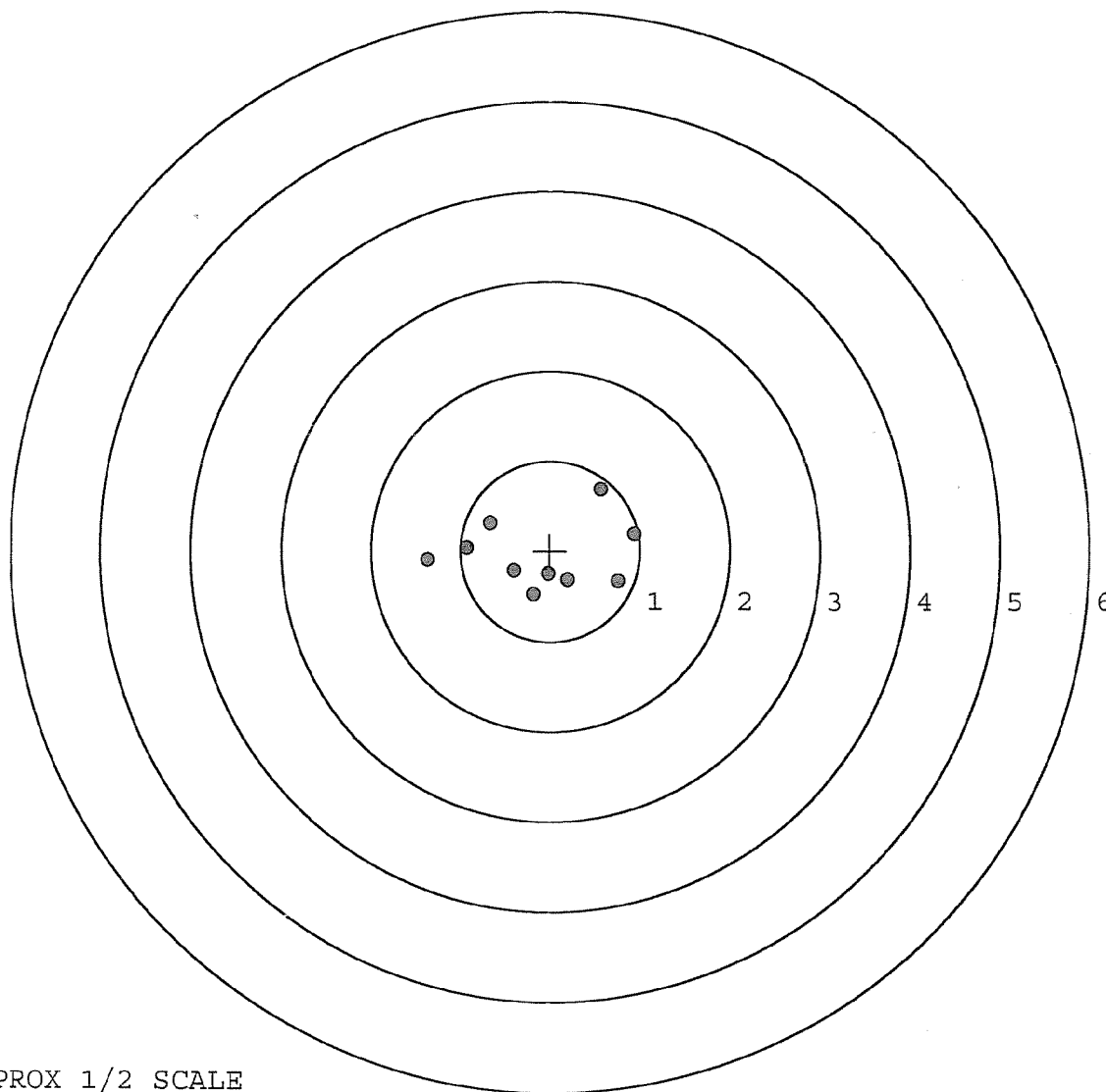
TARGET APPROX 1/2 SCALE

BARBER - M24 0152992

SERIAL NUMBER: G6461558. __0
 TARGET NUMBER: 5
 FILE DATE: 10/13/2005
 FILE TIME: 09:49

POINT#	X	Y
1:	0.756	-0.336
2:	0.936	0.187
3:	0.566	0.680
4:	0.200	-0.325
5:	-0.020	-0.260
6:	-0.193	-0.484
7:	-0.402	-0.222
8:	-0.673	0.307
9:	-0.933	0.036
10:	-1.370	-0.106

X CENTROID: -0.113
 Y CENTROID: -0.052
 POA TO CENTROID: 0.125
 HORZ SPREAD: 2.306
 VERT SPREAD: 1.164
 GROUP SPREAD: 2.325
 MIN RADIUS: 0.228
 MAX RADIUS: 1.258
 MEAN RADIUS: 0.715
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE