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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



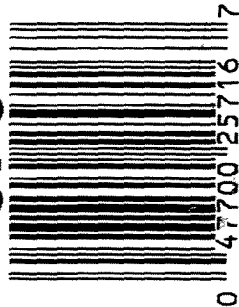
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461560

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.



6/17/2005 2:12:04 PM
Original
4
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 # G6461560

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	WJ
	(BOLT)			
560	RE-ASSEMBLE ACTION		10-6-05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-05	MTM
	D) OIL FIRING PIN ASSEMBLY		10-11-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP # OPERATION NAME			READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	516	516	516	10-19-05	BC		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	216	216	216	10-19-05	BC		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.024	10-19-05	BC		
	J) ASSEMBLE STOCK					10-11-05	RTL		
	K) ASSEMBLE SWIVEL STUDS					10-19-05	BC		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					10-17-05	BC		
	M) IRON SIGHT ALIGNMENT					10-17-05	BC		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					10-17-05	BC		
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		10-18-05	TRW		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					10-18-05	R.P		
670	FINAL INSPECTION A) HEADSPACE					10-19-05	BC		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.13	2.03	2.33	2.25	2.32	10-19-05	TRW
	C) FUNCTION					10-19-05	BC		
690	PACK					10-11-05	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)

SERIAL NO.

DATE

TESTER

10/4/05

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.81	2.89		2.14	
PULL #2	2.61	2.98		2.26	
PULL #3	2.60	2.89		2.09	
PULL #4	2.94	2.90		2.33	
PULL #5	2.77	2.77		2.42	
TOTAL	13.73	14.43		11.24	
AVERAGE	2.75	2.89		2.25	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.33		
PULL #2	3.29	3.44		
PULL #3	3.50	3.56		
PULL #4	3.53	3.59		
PULL #5	3.62	3.54		
TOTAL	17.29	17.46		
AVERAGE	3.46	3.49		

	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	4.43	4.40		4.30
PULL #2	4.10	4.22		4.29
PULL #3	4.52	4.55		4.30
PULL #4	4.31	4.46		4.54
PULL #5	4.67	4.18		4.61
TOTAL	22.03	21.81		22.04
AVERAGE	4.41	4.36		4.41

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461560.___0
FILE DATE AND TIME: 10/18/2005 09:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.095
The Average Y Centroid of the Five Target Set:	-0.152
The Average Point of Impact of the Five Target Set:	0.179
The Average Mean Radius of the Five Target Set:	0.929
The Distance from POA to Centroid Target #1:	0.403
The Distance from Centroid Target #2 to Centroid Target #1:	0.049
The Distance from Centroid Target #3 to Centroid Target #1:	0.286
The Distance from Centroid Target #4 to Centroid Target #1:	0.601
The Distance from Centroid Target #5 to Centroid Target #1:	0.321

SERIAL NUMBER: G6461560. __ 0

TARGET NUMBER: 1

FILE DATE: 10/18/2005

FILE TIME: 09:42

X CENTROID: 0.059

Y CENTROID: -0.399

POA TO CENTROID: 0.403

HORZ SPREAD: 1.825

VERT SPREAD: 3.227

GROUP SPREAD: 3.301

MIN RADIUS: 0.300

MAX RADIUS: 2.245

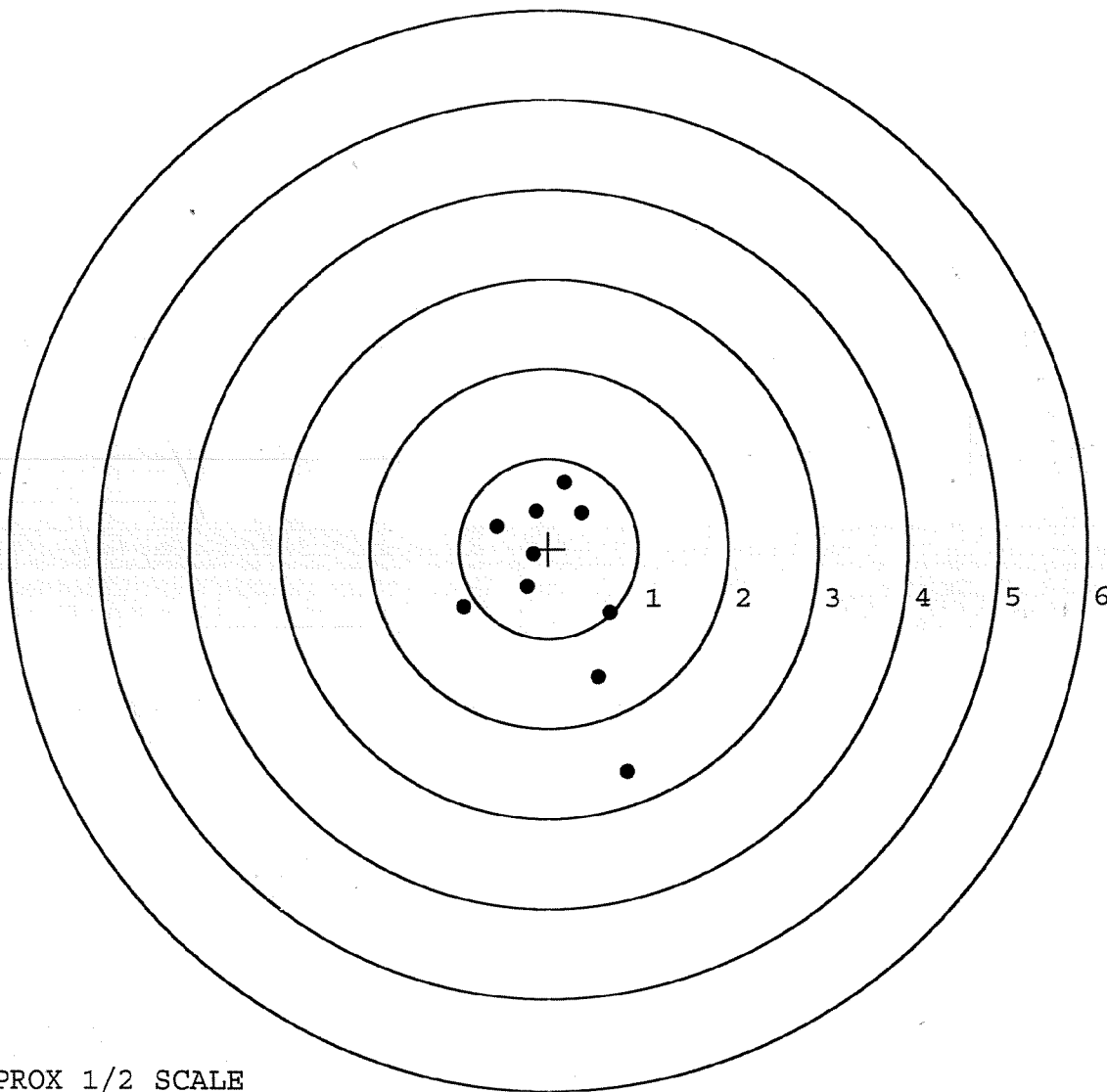
MEAN RADIUS: 0.958

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.878	-2.489
2:	0.553	-1.439
3:	0.685	-0.720
4:	-0.947	-0.652
5:	-0.240	-0.422
6:	-0.170	-0.063
7:	-0.574	0.249
8:	0.368	0.395
9:	0.181	0.738
10:	-0.139	0.416



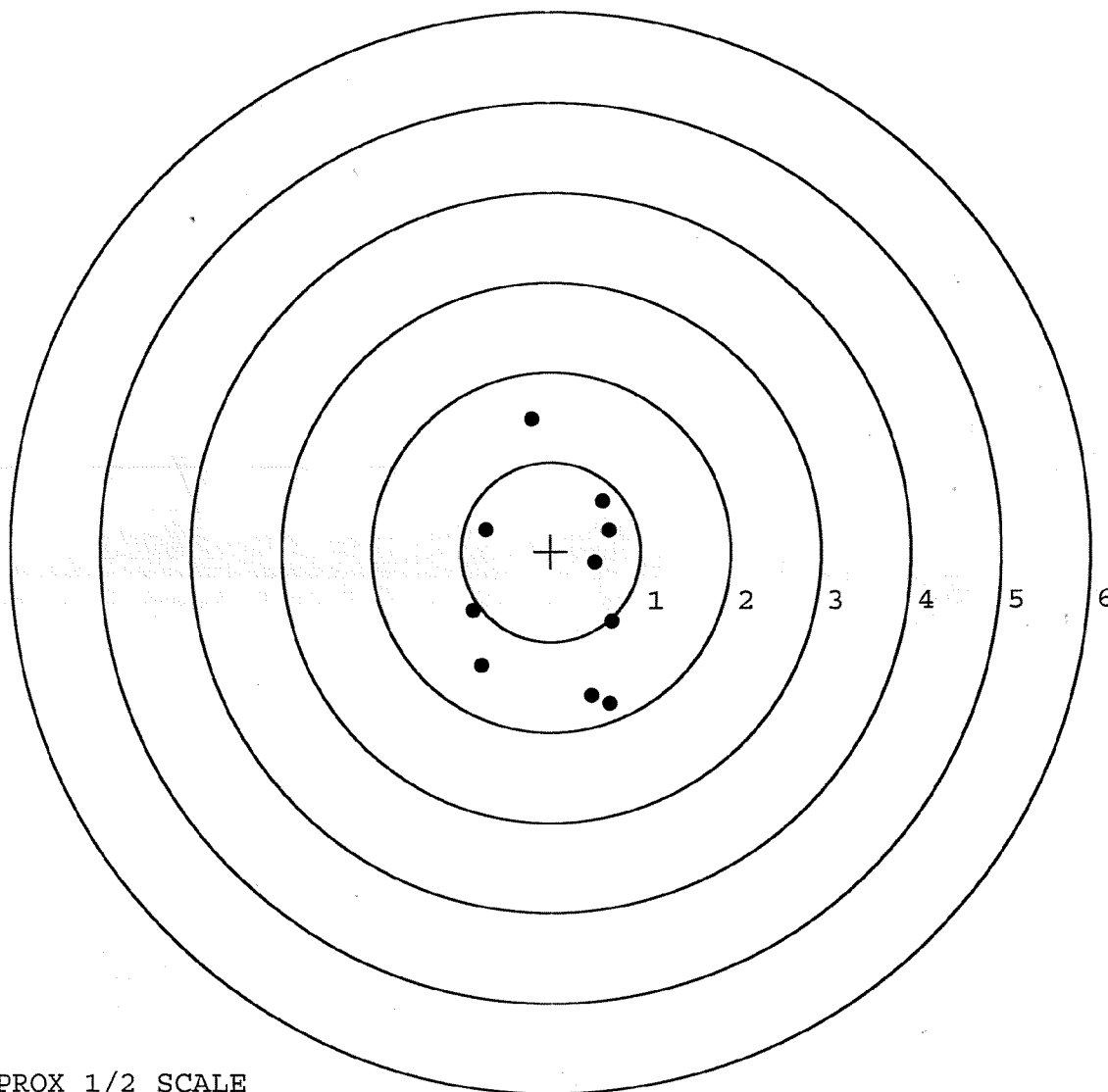
TARGET APPROX 1/2 SCALE

BARBER - M24 0153023

SERIAL NUMBER: G6461560. __0
 TARGET NUMBER: 2
 FILE DATE: 10/18/2005
 FILE TIME: 09:42

POINT#	X	Y
1:	-0.653	-1.691
2:	0.452	-1.601
3:	-0.774	-1.263
4:	-0.868	-0.654
5:	0.677	-0.784
6:	0.490	-0.133
7:	0.653	0.228
8:	0.582	0.557
9:	-0.724	0.242
10:	-0.213	1.475

X CENTROID: 0.093
 Y CENTROID: -0.362
 POA TO CENTROID: 0.374
 HORZ SPREAD: 1.545
 VERT SPREAD: 3.166
 GROUP SPREAD: 3.282
 MIN RADIUS: 0.459
 MAX RADIUS: 1.863
 MEAN RADIUS: 1.090
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 3
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461560. __0

TARGET NUMBER: 3

FILE DATE: 10/18/2005

FILE TIME: 09:42

POINT#	X	Y
1:	1.138	-0.267
2:	0.422	-0.175
3:	1.138	0.591
4:	0.315	1.071
5:	-0.165	0.762
6:	-0.861	-0.212
7:	0.020	-0.639
8:	-0.065	-0.916
9:	-0.422	-0.748
10:	-0.552	-0.616

X CENTROID: 0.097

Y CENTROID: -0.115

POA TO CENTROID: 0.150

HORZ SPREAD: 1.999

VERT SPREAD: 1.987

GROUP SPREAD: 2.154

MIN RADIUS: 0.331

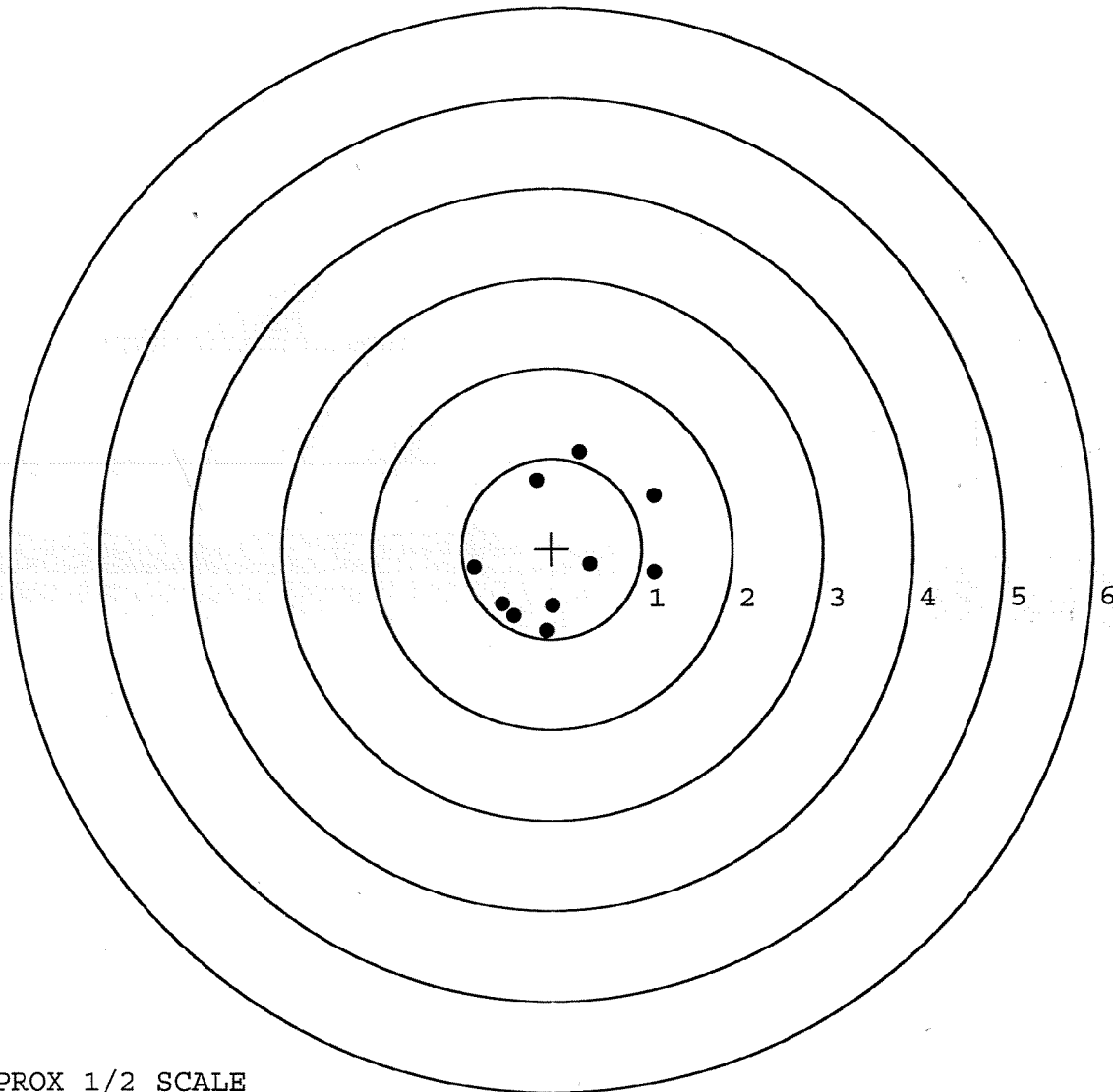
MAX RADIUS: 1.258

MEAN RADIUS: 0.871

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



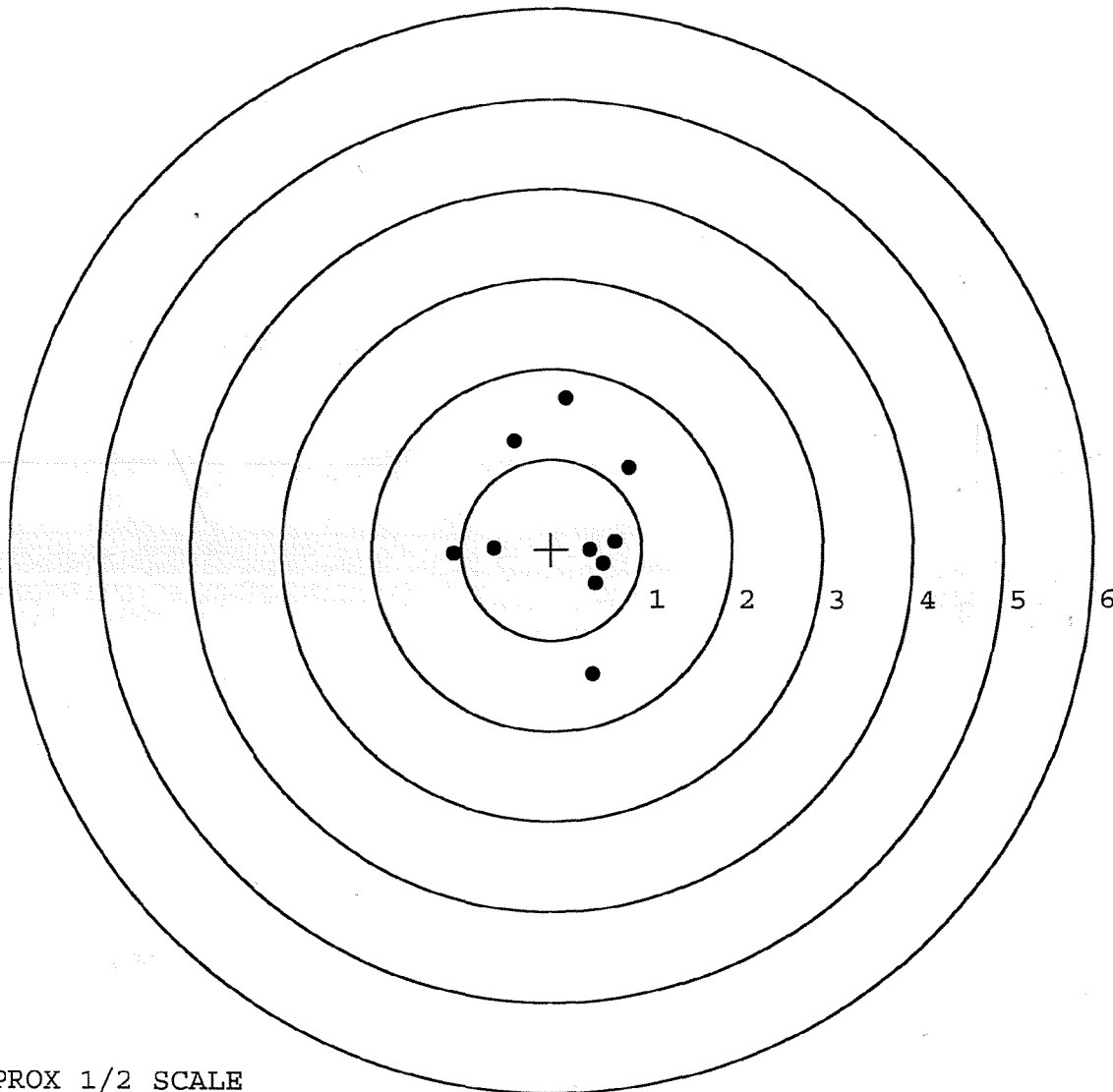
TARGET APPROX 1/2 SCALE

BARBER - M24 0153025

SERIAL NUMBER: G6461560. __0
 TARGET NUMBER: 4
 FILE DATE: 10/18/2005
 FILE TIME: 09:42

POINT#	X	Y
1:	0.465	-1.370
2:	-0.638	0.020
3:	-1.082	-0.051
4:	0.854	0.913
5:	-0.411	1.201
6:	0.164	1.678
7:	0.433	-0.002
8:	0.696	0.089
9:	0.490	-0.378
10:	0.578	-0.155

X CENTROID: 0.155
 Y CENTROID: 0.194
 POA TO CENTROID: 0.249
 HORZ SPREAD: 1.936
 VERT SPREAD: 3.048
 GROUP SPREAD: 3.063
 MIN RADIUS: 0.341
 MAX RADIUS: 1.595
 MEAN RADIUS: 0.941
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461560. __0

TARGET NUMBER: 5

FILE DATE: 10/18/2005

FILE TIME: 09:42

POINT#	X	Y
1:	1.460	-1.329
2:	-0.206	-0.977
3:	1.050	-0.206
4:	-0.150	1.015
5:	-0.007	0.523
6:	-0.648	0.439
7:	-0.748	-0.174
8:	0.143	-0.095
9:	-0.189	-0.153
10:	0.017	0.182

X CENTROID: 0.072

Y CENTROID: -0.078

POA TO CENTROID: 0.106

HORZ SPREAD: 2.208

VERT SPREAD: 2.344

GROUP SPREAD: 2.844

MIN RADIUS: 0.073

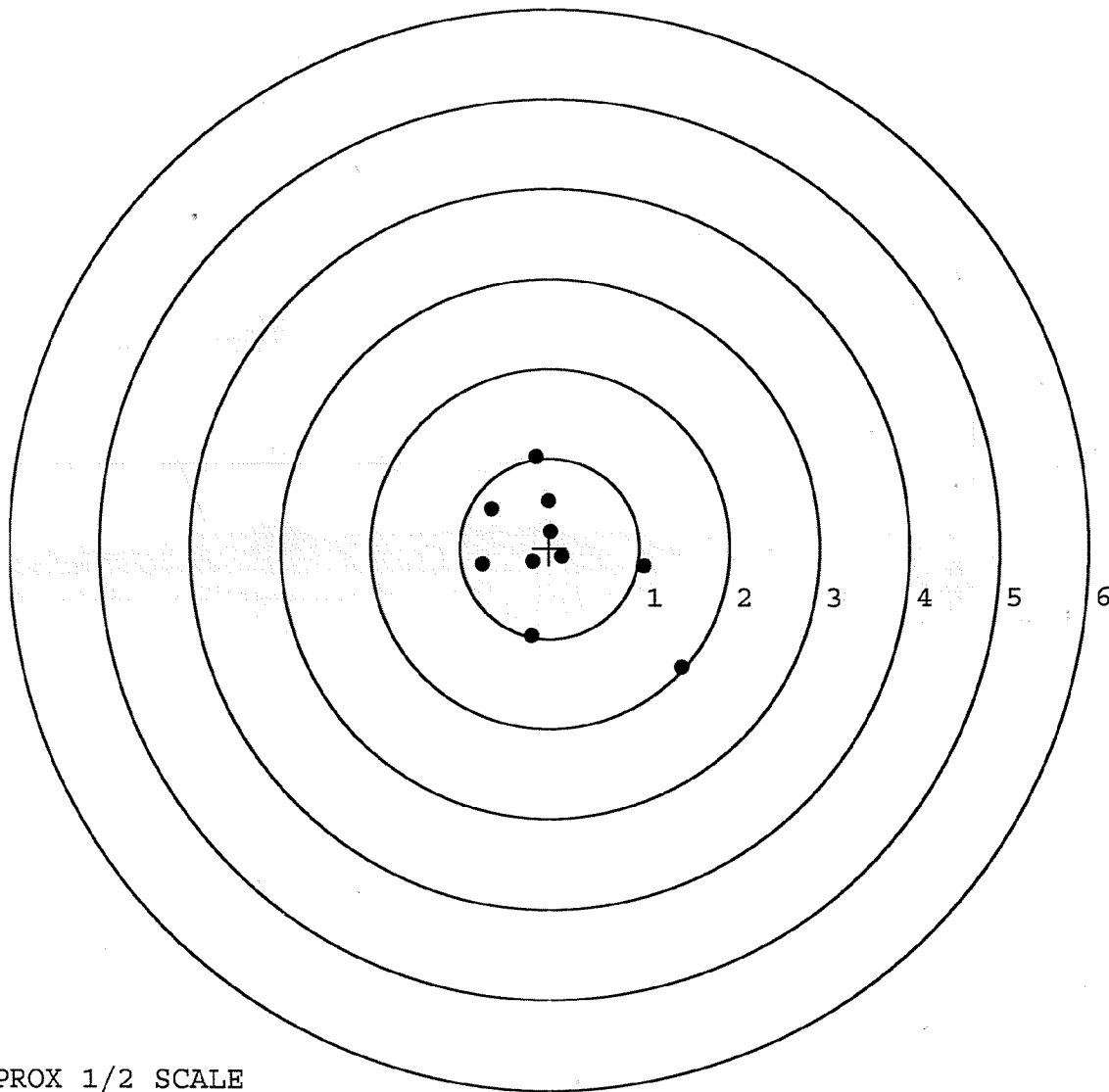
MAX RADIUS: 1.869

MEAN RADIUS: 0.784

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE