

G-6461562

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



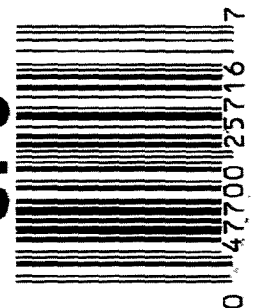
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461562

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
34
6/17/2005 2:12:04 PM

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

Goff Blast Barrel & Rec Assembly,

78ROT01



0004012773

0540

Flat Black Powder Coat, Barrel and

01PC001



0004012763

0560

Reassemble Action.

89SWS1



0004012764

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461562

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 units	9/8/05	units
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-1-2	
530 & 540	APPLY COATINGS (BARREL ACTION)		9/15	RE HP
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-05	RR
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-05	RR
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		9-22-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

REV-8405

OP #	OPERATION NAME	153044	READINGS			DATE	INITIAL	
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>616</u>	<u>616</u>	<u>616</u>	10-19-05	BG	
CONT.								
	G) SAFETY OFF FORCE	2 LBS MIN	<u>216</u>	<u>216</u>	<u>216</u>	10-19-05	BG	
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT	.020 MIN	<u>.025</u>	<u>.025</u>	<u>.024</u>	10-19-05	BG	
	J) ASSEMBLE STOCK					9-22-05	RTL	
	K) ASSEMBLE SWIVEL STUDS					10-19-05	BG	
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					10-11-05	BG	
	M) IRON SIGHT ALIGNMENT					10-11-05	BG	
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					10-11-05	BG	
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u>	FAIL		10/18/05	MfJ	
			<u>PASS</u>	FAIL				
	MALFUNCTION		N/A					
	MALFUNCTION							
	MALFUNCTION							
	MALFUNCTION							
660	INSPECT FOR LIVE AMMO					10-12-05	MSW	
670	FINAL INSPECTION A) HEADSPACE					10-19-05	BG	
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u>	<u>2.84</u>	<u>2.37</u>	<u>2.90</u>	<u>2.66</u>	TPW 10-19-05
	C) FUNCTION					10-19-05	BG	
690	PACK					10/25/05	OTA	

BARBER - M24 0153045

 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

9/14/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.42	2.35	2.36	
PULL #2	2.52	2.39	2.44	
PULL #3	2.68	2.72	2.39	
PULL #4	2.51	2.44	2.45	
PULL #5	2.67	2.24	2.35	
TOTAL	12.8	12.4	11.99	
AVERAGE	2.56	2.42	2.40	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.32	3.47	
PULL #2	3.08	3.43	
PULL #3	3.25	3.23	
PULL #4	3.28	3.00	
PULL #5	3.09	3.11	
TOTAL	16.02	16.24	
AVERAGE	3.20	3.24	

	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	4.27	4.52		4.30
PULL #2	4.27	4.17		4.40
PULL #3	4.24	4.14		4.32
PULL #4	4.22	4.12		4.37
PULL #5	4.14	3.92		4.38
TOTAL	21.14	20.87		21.77
AVERAGE	4.23	4.17		4.35

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461562.__0

FILE DATE AND TIME: 10/12/2005 17:44

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.024
The Average Y Centroid of the Five Target Set:	-0.004
The Average Point of Impact of the Five Target Set:	0.025
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.118
The Distance from Centroid Target #2 to Centroid Target #1:	0.193
The Distance from Centroid Target #3 to Centroid Target #1:	0.116
The Distance from Centroid Target #4 to Centroid Target #1:	0.126
The Distance from Centroid Target #5 to Centroid Target #1:	0.283

SERIAL NUMBER: G6461562. __0

TARGET NUMBER: 1

FILE DATE: 10/12/2005

FILE TIME: 17:44

POINT#	X	Y
1:	0.193	1.172
2:	-0.113	1.102
3:	-0.032	0.624
4:	-0.345	0.004
5:	-0.408	-0.252
6:	-0.860	-0.568
7:	-0.753	-1.241
8:	0.315	-0.230
9:	0.444	-0.389
10:	0.851	-1.169

X CENTROID: -0.071

Y CENTROID: -0.095

POA TO CENTROID: 0.118

HORZ SPREAD: 1.711

VERT SPREAD: 2.413

GROUP SPREAD: 2.467

MIN RADIUS: 0.291

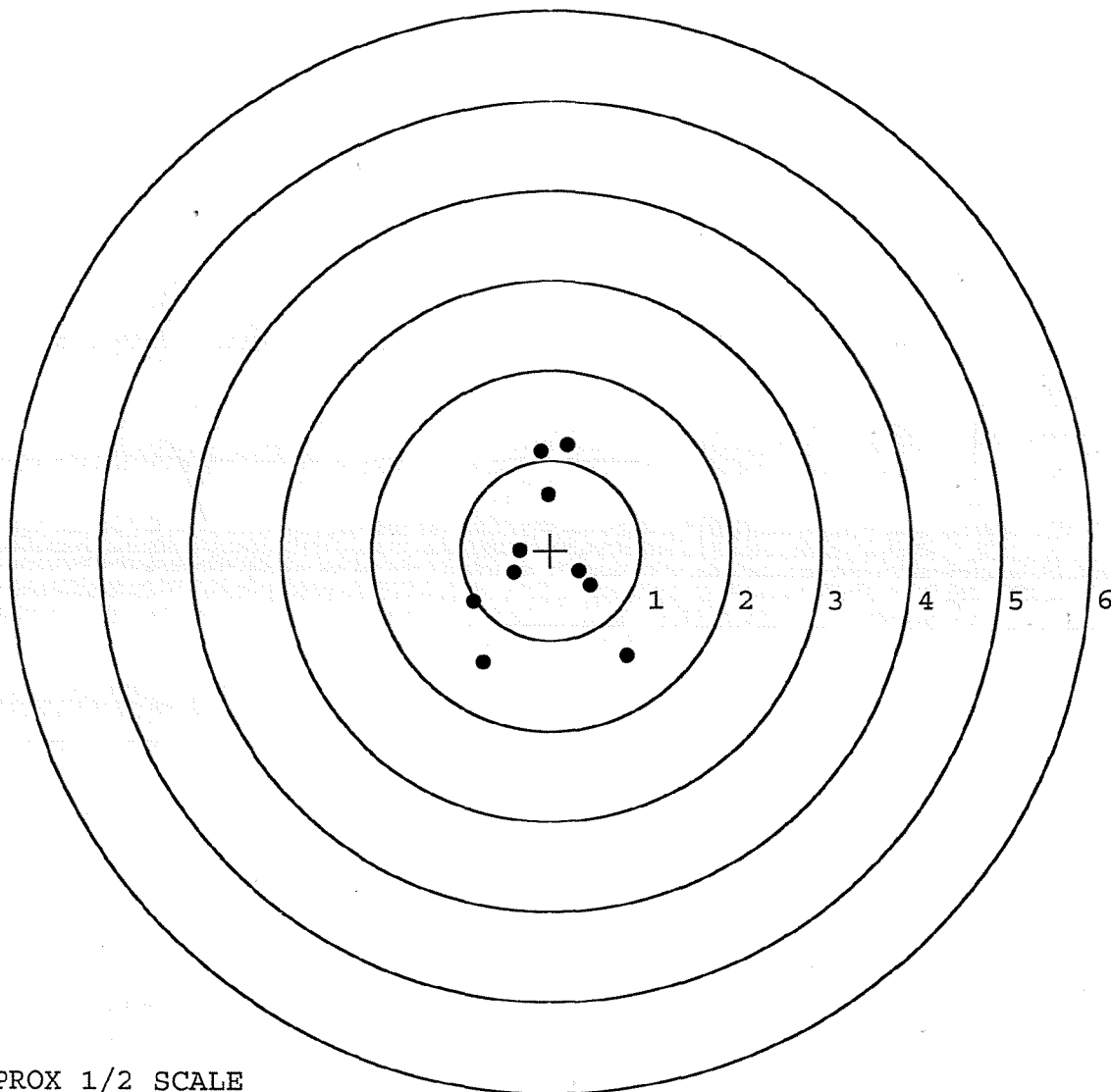
MAX RADIUS: 1.416

MEAN RADIUS: 0.855

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

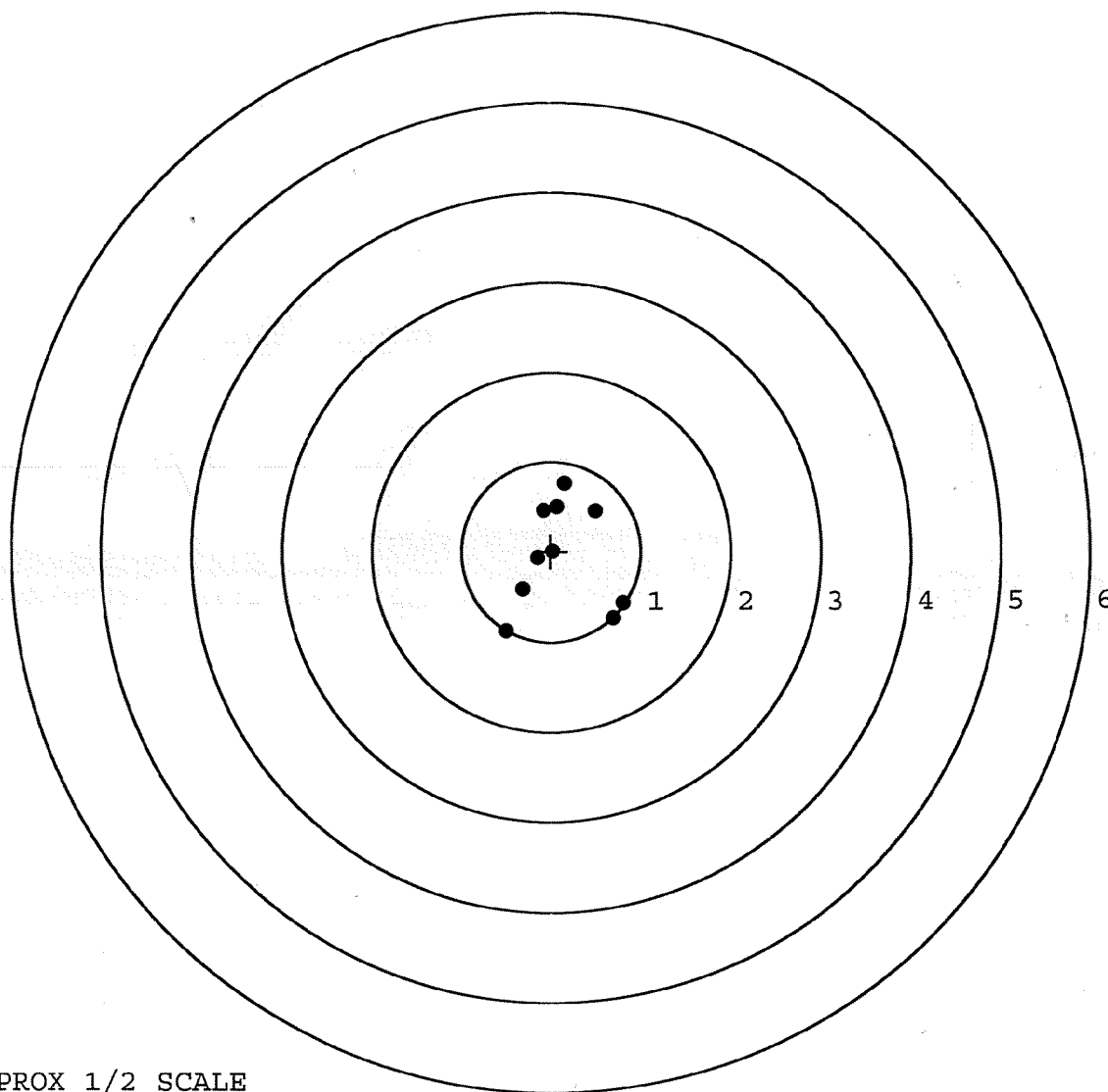


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461562. __0
 TARGET NUMBER: 2
 FILE DATE: 10/12/2005
 FILE TIME: 17:44

POINT#	X	Y
1:	-0.021	0.006
2:	-0.153	-0.074
3:	-0.318	-0.423
4:	-0.500	-0.884
5:	0.690	-0.741
6:	0.801	-0.577
7:	0.495	0.448
8:	-0.081	0.455
9:	0.068	0.496
10:	0.159	0.758

X CENTROID: 0.118
 Y CENTROID: -0.054
 POA TO CENTROID: 0.130
 HORZ SPREAD: 1.301
 VERT SPREAD: 1.642
 GROUP SPREAD: 1.769
 MIN RADIUS: 0.114
 MAX RADIUS: 1.035
 MEAN RADIUS: 0.629
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461562. __0

TARGET NUMBER: 3

FILE DATE: 10/12/2005

FILE TIME: 17:44

X CENTROID: -0.179

Y CENTROID: -0.053

POA TO CENTROID: 0.187

HORZ SPREAD: 1.816

VERT SPREAD: 1.486

GROUP SPREAD: 1.816

MIN RADIUS: 0.231

MAX RADIUS: 1.001

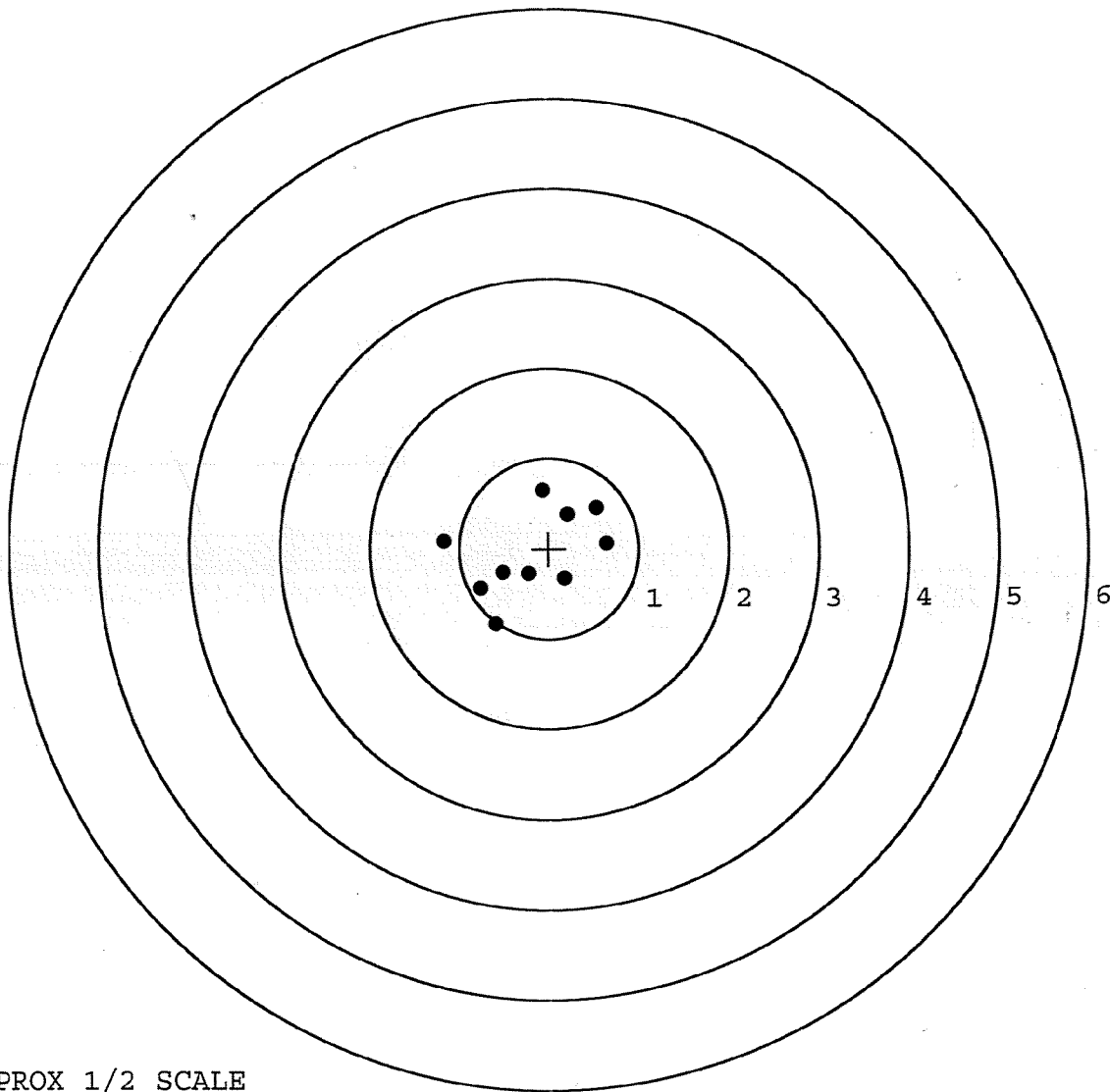
MEAN RADIUS: 0.666

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.228	-0.279
2:	0.174	-0.331
3:	0.646	0.054
4:	0.528	0.453
5:	0.209	0.375
6:	-0.070	0.646
7:	-1.170	0.088
8:	-0.763	-0.435
9:	-0.518	-0.264
10:	-0.598	-0.840



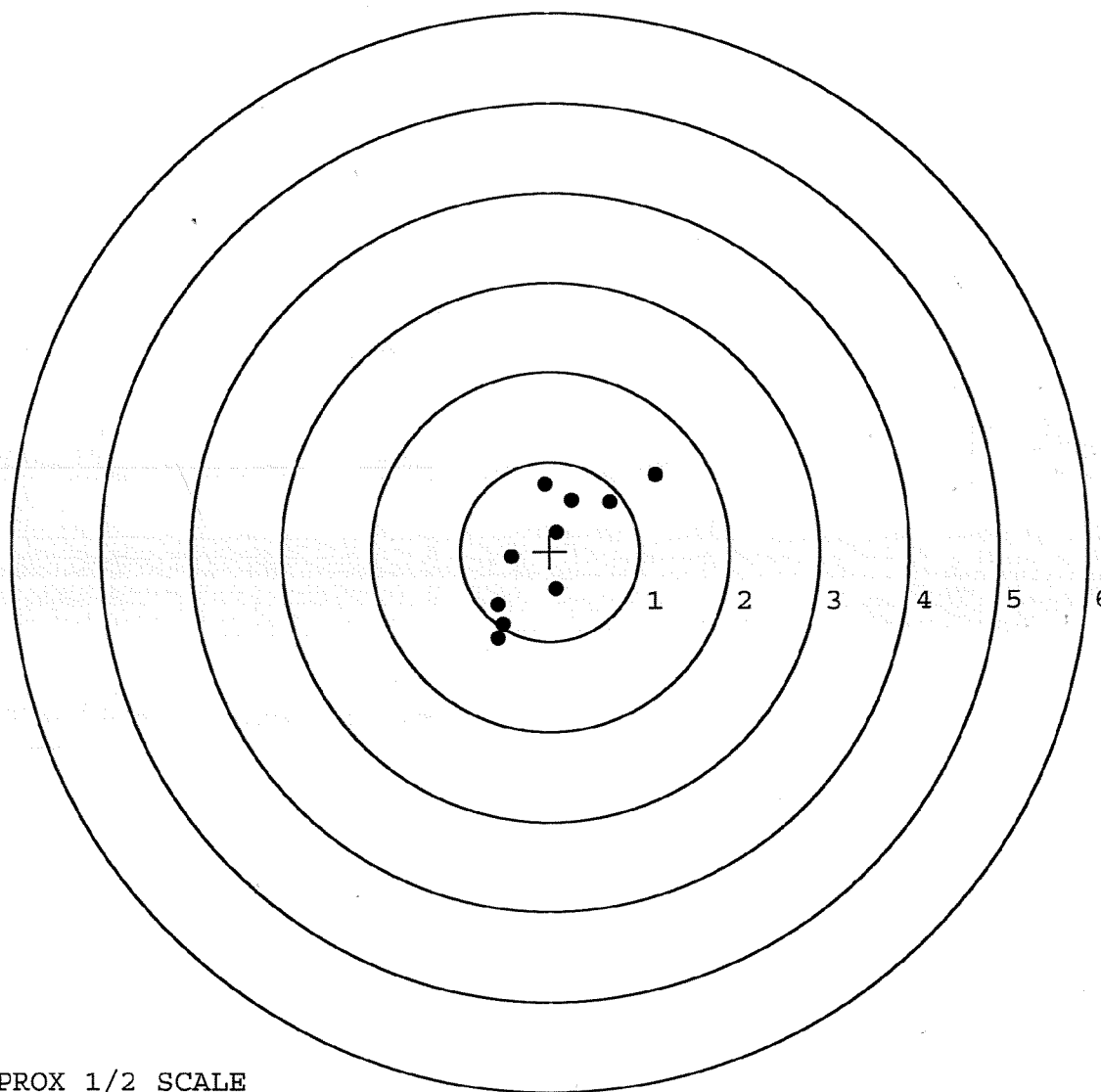
TARGET APPROX 1/2 SCALE

BARBER - M24 0153050

SERIAL NUMBER: G6461562. __0
 TARGET NUMBER: 4
 FILE DATE: 10/12/2005
 FILE TIME: 17:44

POINT#	X	Y
1:	-0.074	0.212
2:	0.246	0.572
3:	-0.058	0.748
4:	0.673	0.549
5:	1.175	0.849
6:	0.072	-0.421
7:	-0.429	-0.065
8:	-0.586	-0.596
9:	-0.586	-0.971
10:	-0.527	-0.817

X CENTROID: 0.005
 Y CENTROID: 0.006
 POA TO CENTROID: 0.008
 HORZ SPREAD: 1.761
 VERT SPREAD: 1.820
 GROUP SPREAD: 2.532
 MIN RADIUS: 0.217
 MAX RADIUS: 1.442
 MEAN RADIUS: 0.772
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461562. __0

TARGET NUMBER: 5

FILE DATE: 10/12/2005

FILE TIME: 17:44

POINT#	X	Y
1:	-0.198	0.356
2:	-0.133	0.687
3:	0.139	0.579
4:	0.054	0.336
5:	0.406	0.393
6:	0.458	0.062
7:	-0.389	-0.312
8:	-0.663	-1.033
9:	0.032	0.390
10:	0.340	0.318

X CENTROID: 0.005

Y CENTROID: 0.178

POA TO CENTROID: 0.178

HORZ SPREAD: 1.121

VERT SPREAD: 1.720

GROUP SPREAD: 1.800

MIN RADIUS: 0.166

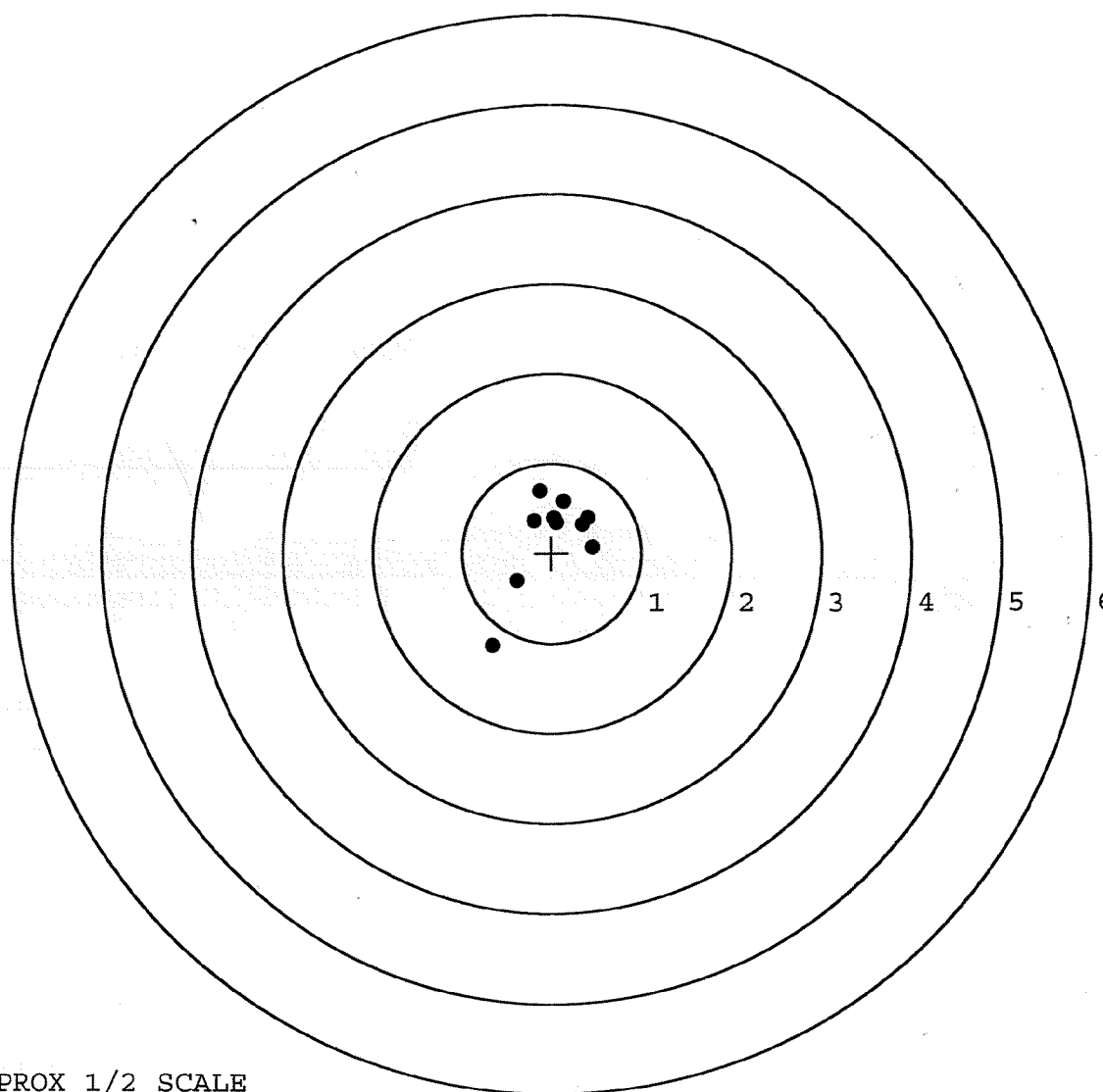
MAX RADIUS: 1.382

MEAN RADIUS: 0.490

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE