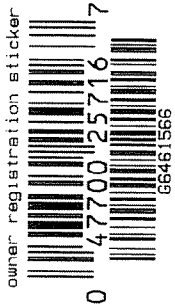
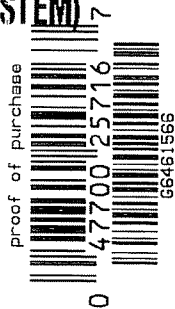


G-646 1566

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

- INSTRUCTION BOOK 3518



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6
G6461566	



DD FORM

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



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



SERIAL NO.



Original
6/17/2005 2:12:04 PM
62
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 # G6461566

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTL
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTL
470	DIS-ASSEMBLE ACTION	INSPECTED	9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 SEP 2005 MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	9/8/05	WMS
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	WMS
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9/22/05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/22/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/22/05	DA
	D) OIL FIRING PIN ASSEMBLY		9-27-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

BARBER - M24 0153112 OP # OPERATION NAME			READINGS			DATE	INITIAL
560	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6 lbs</u>	<u>6 lbs</u>	<u>6 lbs</u>	10-3-05	Ac
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2 lbs</u>	<u>2 lbs</u>	<u>2 lbs</u>	10-3-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY					X	X
	I) FIRING PIN INDENT	.020 MIN	<u>.022</u>	<u>.022</u>	<u>.022</u>	10-3-05	Ac
	J) ASSEMBLE STOCK					9-22-05	RTL
	K) ASSEMBLE SWIVEL STUDS					10-3-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					9-28-05	RTL
	M) IRON SIGHT ALIGNMENT					9-28-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					9-28-05	RTL
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		9-29-05	TRW
			PASS	FAIL			
	MALFUNCTION						
	MALFUNCTION						
	MALFUNCTION						
	MALFUNCTION						
660	INSPECT FOR LIVE AMMO					9-29-05	TRW
670	FINAL INSPECTION A) HEADSPACE					10-3-05	Ac
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u>	<u>2.67</u>	<u>2.59</u>	10-3-05	RG
	C) FUNCTION					10-3-05	Ac
690	PACK					10-7-05	DA

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE

9/22/05

3.00 LBS (plus or minus 0.75 LBS)

TESTER

BG

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.20	2.45	2.40	
PULL #2	2.51	2.80	2.71	
PULL #3	2.84	2.68	2.30	
PULL #4	2.63	2.72	2.82	
PULL #5	2.85	2.77	2.67	
TOTAL	13.03	13.42	12.90	
AVERAGE	2.61	2.68	2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.27	3.36	
PULL #2	3.14	3.64	
PULL #3	2.46	3.20	
PULL #4	3.41	3.52	
PULL #5	3.48	3.27	
TOTAL	15.76	16.99	
AVERAGE	3.15	3.40	

	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	4.32	4.08		4.04
PULL #2	4.35	4.76		4.02
PULL #3	4.32	3.85		3.99
PULL #4	4.02	4.32		3.93
PULL #5	4.24	4.74		4.12
TOTAL	21.25	21.75		20.10
AVERAGE	4.25	4.35		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461566.___0
FILE DATE AND TIME: 09/29/2005 11:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

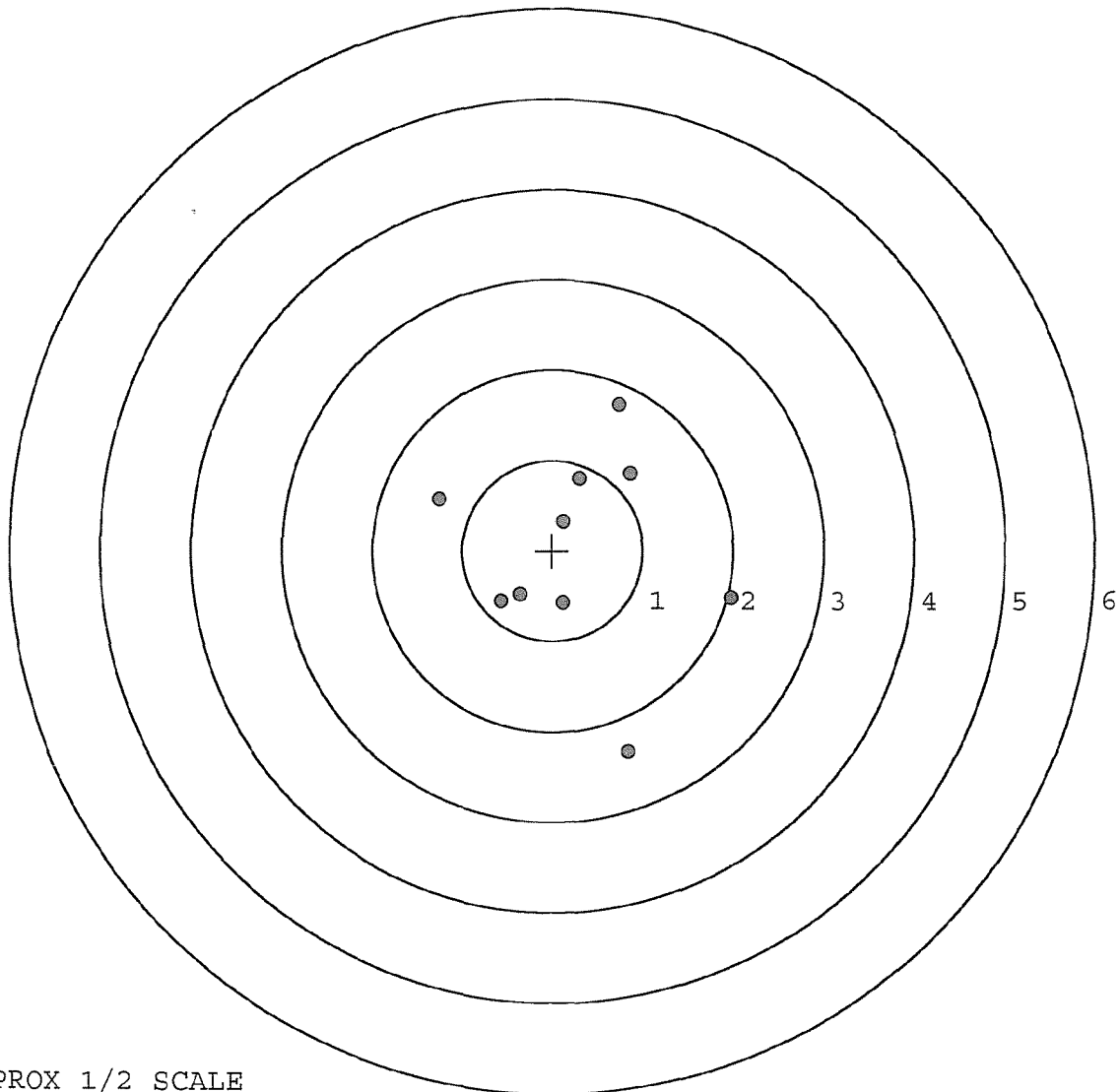
The Average X Centroid of the Five Target Set:	0.123
The Average Y Centroid of the Five Target Set:	-0.184
The Average Point of Impact of the Five Target Set:	0.221
The Average Mean Radius of the Five Target Set:	0.992
The Distance from POA to Centroid Target #1:	0.280
The Distance from Centroid Target #2 to Centroid Target #1:	0.471
The Distance from Centroid Target #3 to Centroid Target #1:	0.434
The Distance from Centroid Target #4 to Centroid Target #1:	0.349
The Distance from Centroid Target #5 to Centroid Target #1:	0.148

BARBER - M24 0153115

SERIAL NUMBER: G6461566. __0
 TARGET NUMBER: 1
 FILE DATE: 09/29/2005
 FILE TIME: 11:06

POINT#	X	Y
1:	0.843	-2.223
2:	1.978	-0.526
3:	0.864	0.857
4:	0.735	1.615
5:	0.305	0.801
6:	0.126	0.321
7:	0.124	-0.585
8:	-0.356	-0.493
9:	-0.573	-0.564
10:	-1.260	0.568

X CENTROID: 0.279
 Y CENTROID: -0.023
 POA TO CENTROID: 0.280
 HORZ SPREAD: 3.238
 VERT SPREAD: 3.838
 GROUP SPREAD: 3.840
 MIN RADIUS: 0.376
 MAX RADIUS: 2.271
 MEAN RADIUS: 1.203
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 6



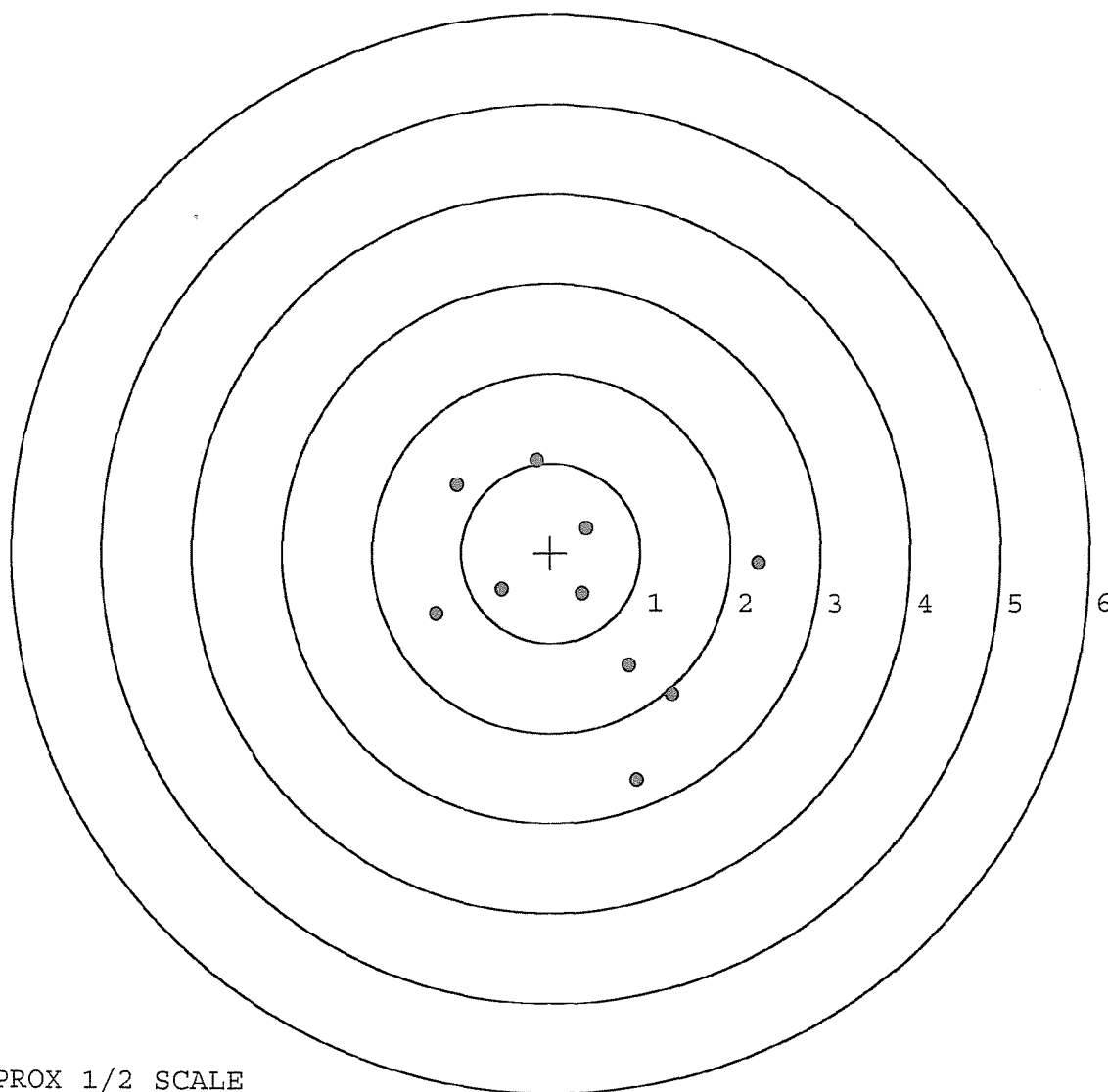
TARGET APPROX 1/2 SCALE

BARBER - M24 0153116

SERIAL NUMBER: G6461566. __0
 TARGET NUMBER: 2
 FILE DATE: 09/29/2005
 FILE TIME: 11:06

POINT#	X	Y
1:	0.961	-2.525
2:	1.350	-1.567
3:	0.878	-1.244
4:	2.308	-0.107
5:	0.353	-0.452
6:	0.388	0.275
7:	-0.547	-0.408
8:	-1.285	-0.683
9:	-1.053	0.756
10:	-0.159	1.033

X CENTROID: 0.319
 Y CENTROID: -0.492
 POA TO CENTROID: 0.587
 HORZ SPREAD: 3.593
 VERT SPREAD: 3.558
 GROUP SPREAD: 3.850
 MIN RADIUS: 0.052
 MAX RADIUS: 2.132
 MEAN RADIUS: 1.335
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 5



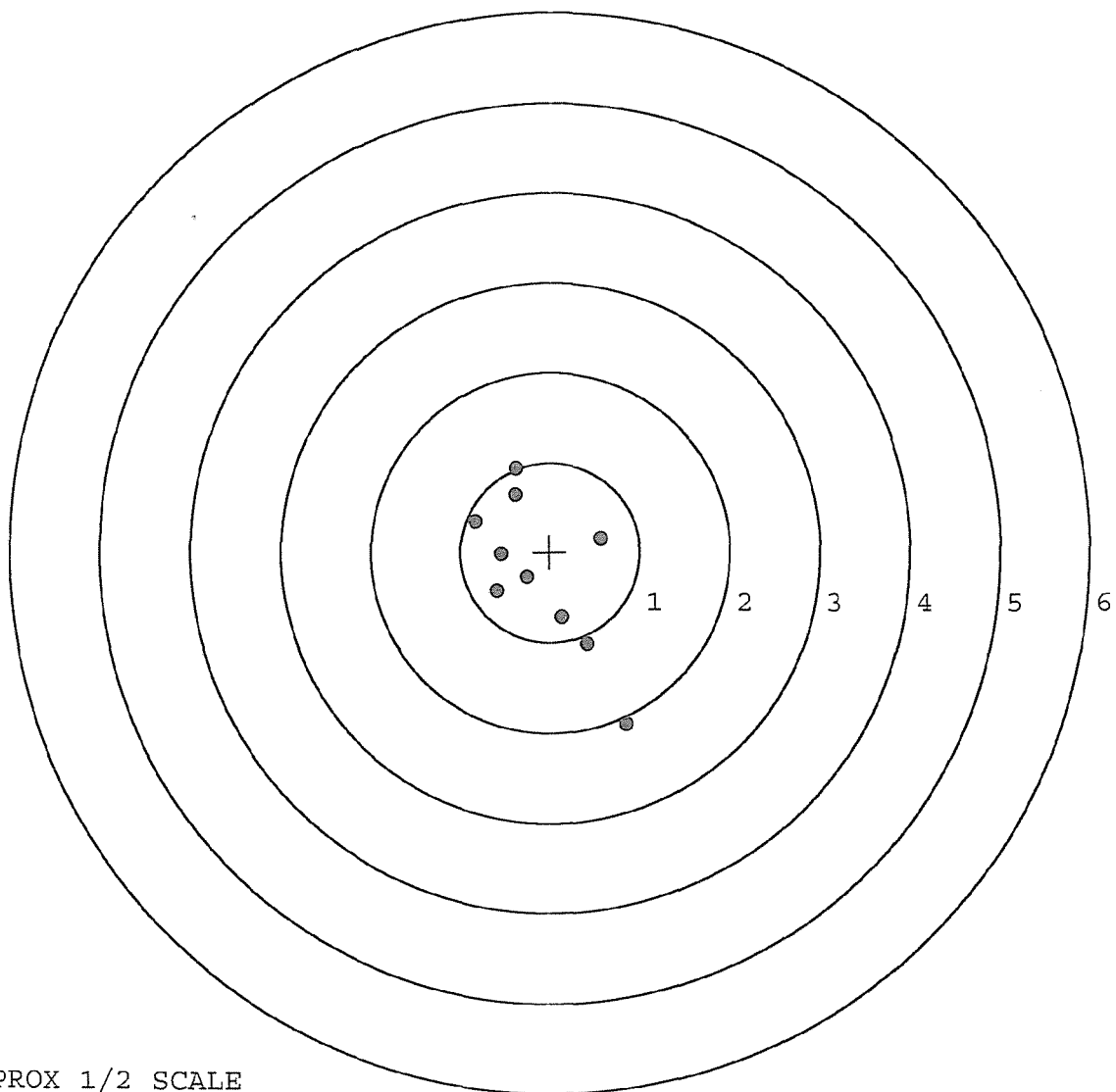
TARGET APPROX 1/2 SCALE

BARBER - M24 0153117

SERIAL NUMBER: G6461566. __0
 TARGET NUMBER: 3
 FILE DATE: 09/29/2005
 FILE TIME: 11:06

POINT#	X	Y
1:	0.858	-1.901
2:	0.418	-1.025
3:	0.137	-0.728
4:	-0.260	-0.281
5:	-0.590	-0.436
6:	-0.543	-0.020
7:	-0.838	0.342
8:	0.564	0.154
9:	-0.391	0.644
10:	-0.382	0.940

X CENTROID: -0.103
 Y CENTROID: -0.231
 POA TO CENTROID: 0.253
 HORZ SPREAD: 1.696
 VERT SPREAD: 2.841
 GROUP SPREAD: 3.100
 MIN RADIUS: 0.165
 MAX RADIUS: 1.927
 MEAN RADIUS: 0.844
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



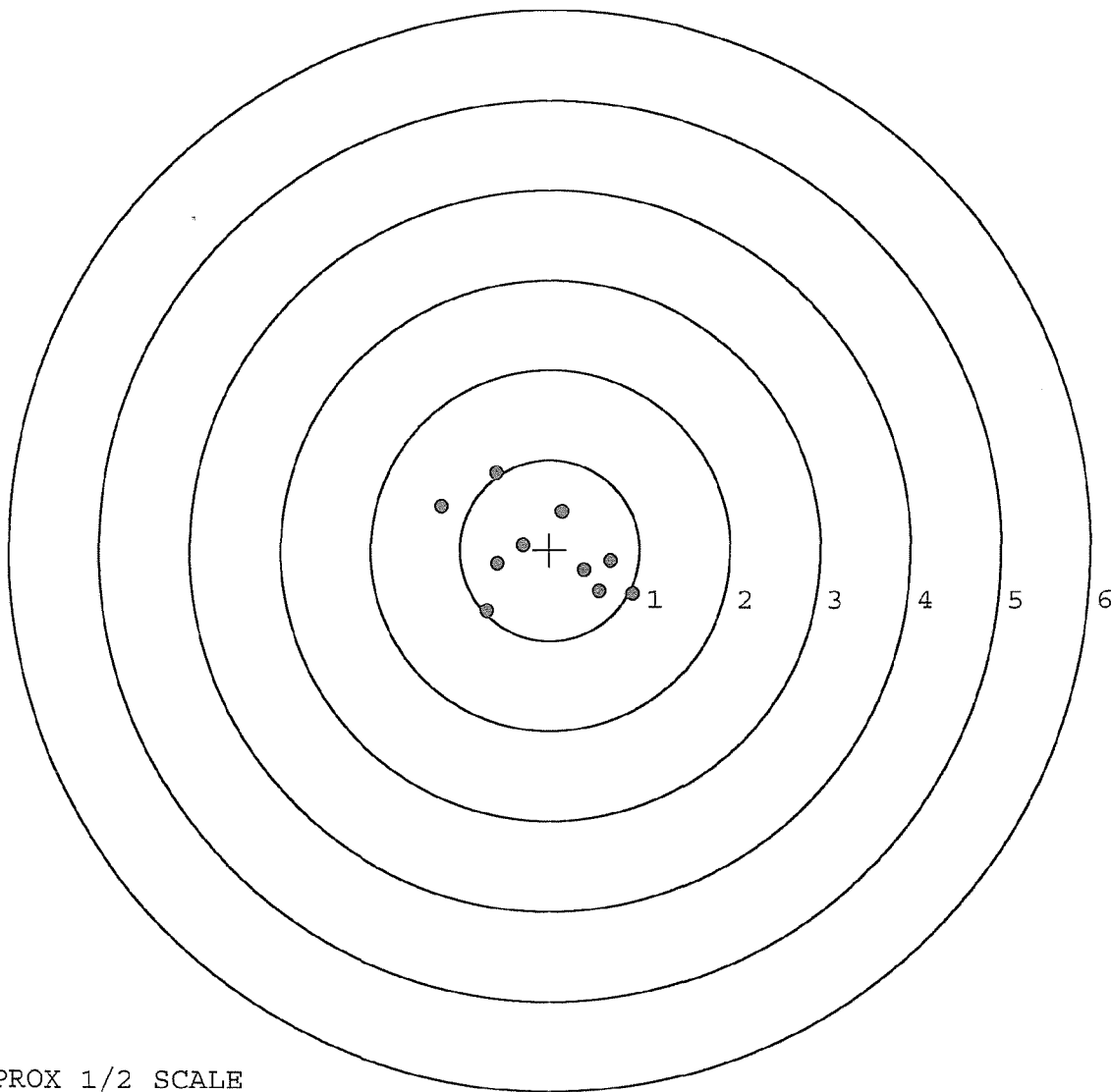
TARGET APPROX 1/2 SCALE

BARBER - M24 0153118

SERIAL NUMBER: G6461566. __0
TARGET NUMBER: 4
FILE DATE: 09/29/2005
FILE TIME: 11:06

POINT#	X	Y
1:	0.921	-0.490
2:	0.551	-0.461
3:	0.677	-0.128
4:	0.384	-0.227
5:	0.140	0.426
6:	-0.298	0.053
7:	-0.580	-0.159
8:	-0.700	-0.679
9:	-1.209	0.483
10:	-0.587	0.856

X CENTROID: -0.070
Y CENTROID: -0.033
POA TO CENTROID: 0.077
HORZ SPREAD: 2.130
VERT SPREAD: 1.535
GROUP SPREAD: 2.342
MIN RADIUS: 0.243
MAX RADIUS: 1.250
MEAN RADIUS: 0.755
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



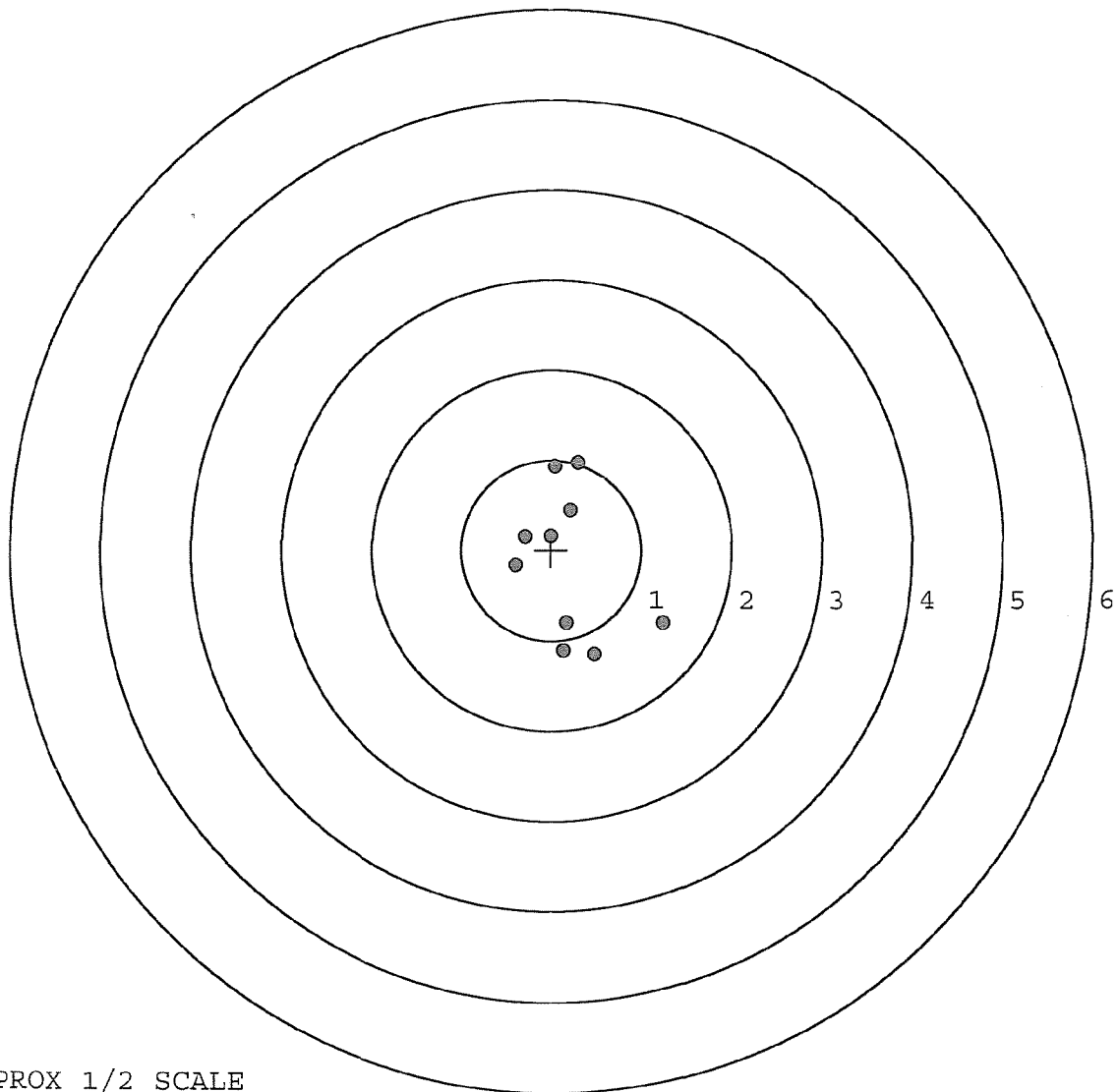
TARGET APPROX 1/2 SCALE

BARBER - M24 0153119

SERIAL NUMBER: G6461566. __0
 TARGET NUMBER: 5
 FILE DATE: 09/29/2005
 FILE TIME: 11:06

POINT#	X	Y
1:	1.240	-0.808
2:	0.477	-1.155
3:	0.135	-1.117
4:	0.167	-0.808
5:	-0.397	-0.167
6:	-0.296	0.147
7:	0.002	0.160
8:	0.211	0.444
9:	0.050	0.927
10:	0.301	0.972

X CENTROID: 0.189
 Y CENTROID: -0.141
 POA TO CENTROID: 0.236
 HORZ SPREAD: 1.637
 VERT SPREAD: 2.127
 GROUP SPREAD: 2.104
 MIN RADIUS: 0.354
 MAX RADIUS: 1.245
 MEAN RADIUS: 0.823
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE