

G-646 1581

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



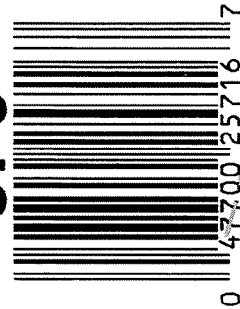
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461581

UPC



ORDER 25716

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

UPC



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ORDER 25716

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

UPC



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SERIAL NO.



66461581

6/17/2005 2:12:04 PM

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Original

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 60461581

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTL
440	PROOF		8-12-05	Ac
460	CHECK HEADSPACE		8-12-05	Ac
470	DIS-ASSEMBLE ACTION		8-15-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		8-15-05	RTL
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	al
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	mtm
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	mtm
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	mtm
	D) OIL FIRING PIN ASSEMBLY		10-10-05	RTL
	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	<u>816</u>	<u>816</u>	<u>816</u>	10-19-05	BC
CONT.						
	G) SAFETY OFF FORCE 2 LBS MIN	<u>316</u>	<u>316</u>	<u>316</u>	10-19-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT .020 MIN	<u>.023</u>	<u>.024</u>	<u>.023</u>	10-19-05	BC
	J) ASSEMBLE STOCK				10-16-05	RTZ
	K) ASSEMBLE SWIVEL STUDS				10-19-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				10-13-05	AC
	M) IRON SIGHT ALIGNMENT				10-13-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				10-13-05	AC
640 & 650	FUNCTION TEST AND TARGET	PASS	FAIL		10-18-05	TRC
		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	<u>2.76</u>	<u>2.76</u>	<u>2.57</u> <u>2.38</u> <u>2.63</u>	10-19-05	TRC
	C) FUNCTION				10-19-05	BC
690	PACK				10/25/05	RA

AVERAGE BARBER - M24 0153294
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	2.15	2.50		2.57	
PULL #2	2.27	2.30		2.58	
PULL #3	2.46	2.72		2.48	
PULL #4	2.55	2.65		2.21	
PULL #5	2.58	2.72		2.61	
TOTAL	12.01	12.89		12.45	
AVERAGE	2.40	2.58		2.49	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.02		
PULL #2	3.27	3.17		
PULL #3	3.23	3.10		
PULL #4	3.25	3.08		
PULL #5	3.30	2.55		
TOTAL	16.24	14.92		
AVERAGE	3.25	2.98		

	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	4.30	4.33		4.34
PULL #2	4.19	4.26		4.56
PULL #3	4.43	3.72		4.03
PULL #4	3.50	4.25		4.60
PULL #5	3.93	4.32		4.56
TOTAL	20.35	20.88		22.09
AVERAGE	4.07	4.18		4.42

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461581.__1
FILE DATE AND TIME: 10/18/2005 09:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.043
The Average Y Centroid of the Five Target Set:	-0.099
The Average Point of Impact of the Five Target Set:	0.108
The Average Mean Radius of the Five Target Set:	0.914
The Distance from POA to Centroid Target #1:	0.082
The Distance from Centroid Target #2 to Centroid Target #1:	0.243
The Distance from Centroid Target #3 to Centroid Target #1:	0.212
The Distance from Centroid Target #4 to Centroid Target #1:	0.177
The Distance from Centroid Target #5 to Centroid Target #1:	0.012

SERIAL NUMBER: G6461581. __1

TARGET NUMBER: 1

FILE DATE: 10/18/2005

FILE TIME: 09:25

X CENTROID: -0.020

Y CENTROID: -0.079

POA TO CENTROID: 0.082

HORZ SPREAD: 2.649

VERT SPREAD: 1.538

GROUP SPREAD: 2.865

MIN RADIUS: 0.420

MAX RADIUS: 1.588

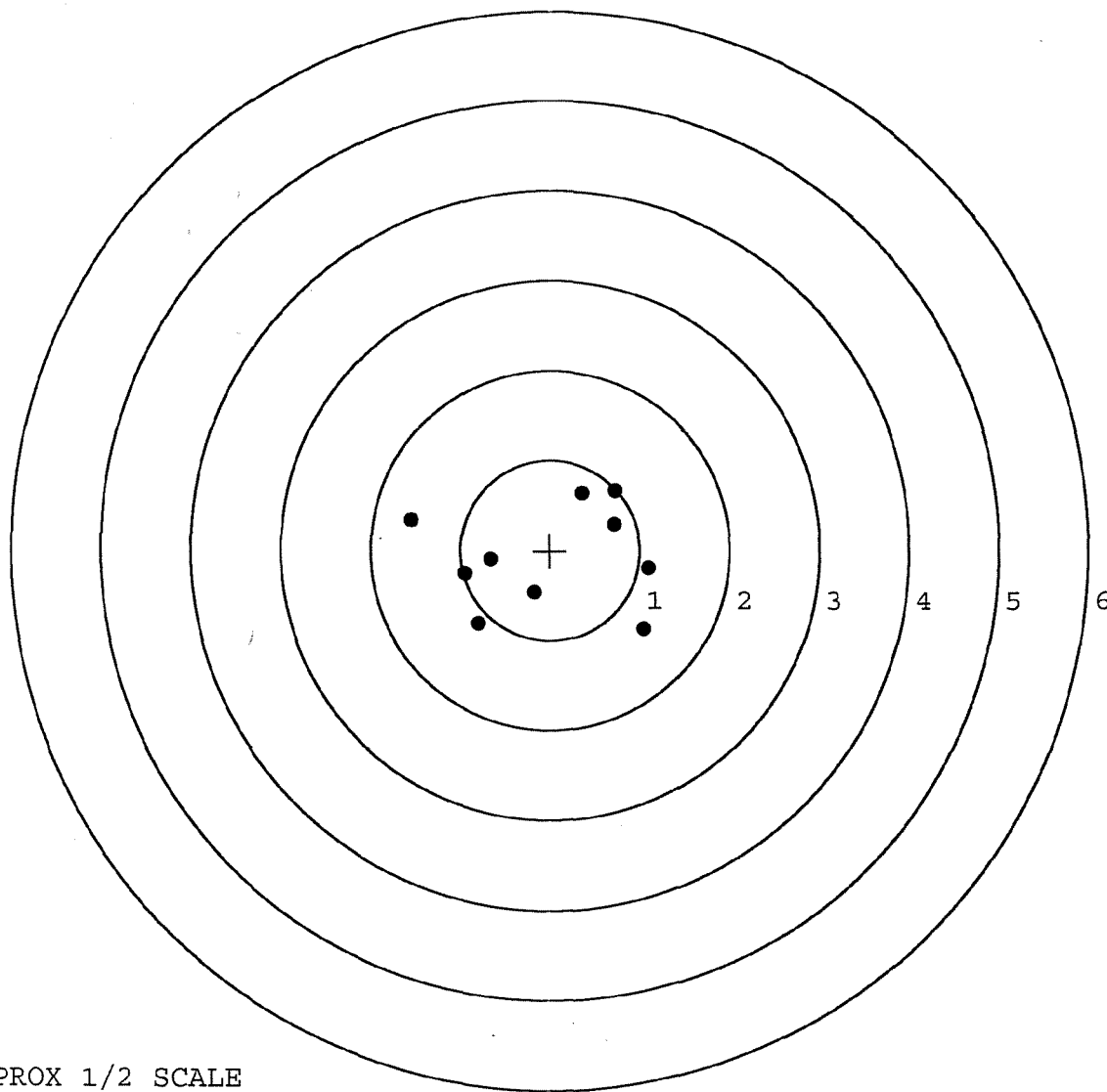
MEAN RADIUS: 0.981

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.043	-0.876
2:	1.097	-0.199
3:	0.714	0.287
4:	0.732	0.662
5:	0.359	0.640
6:	-0.177	-0.469
7:	-0.663	-0.099
8:	-0.801	-0.815
9:	-0.951	-0.260
10:	-1.552	0.337



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461581. __1

TARGET NUMBER: 2

FILE DATE: 10/18/2005

FILE TIME: 09:25

X CENTROID: 0.177

Y CENTROID: -0.223

POA TO CENTROID: 0.284

HORZ SPREAD: 1.669

VERT SPREAD: 3.024

GROUP SPREAD: 3.046

MIN RADIUS: 0.089

MAX RADIUS: 1.655

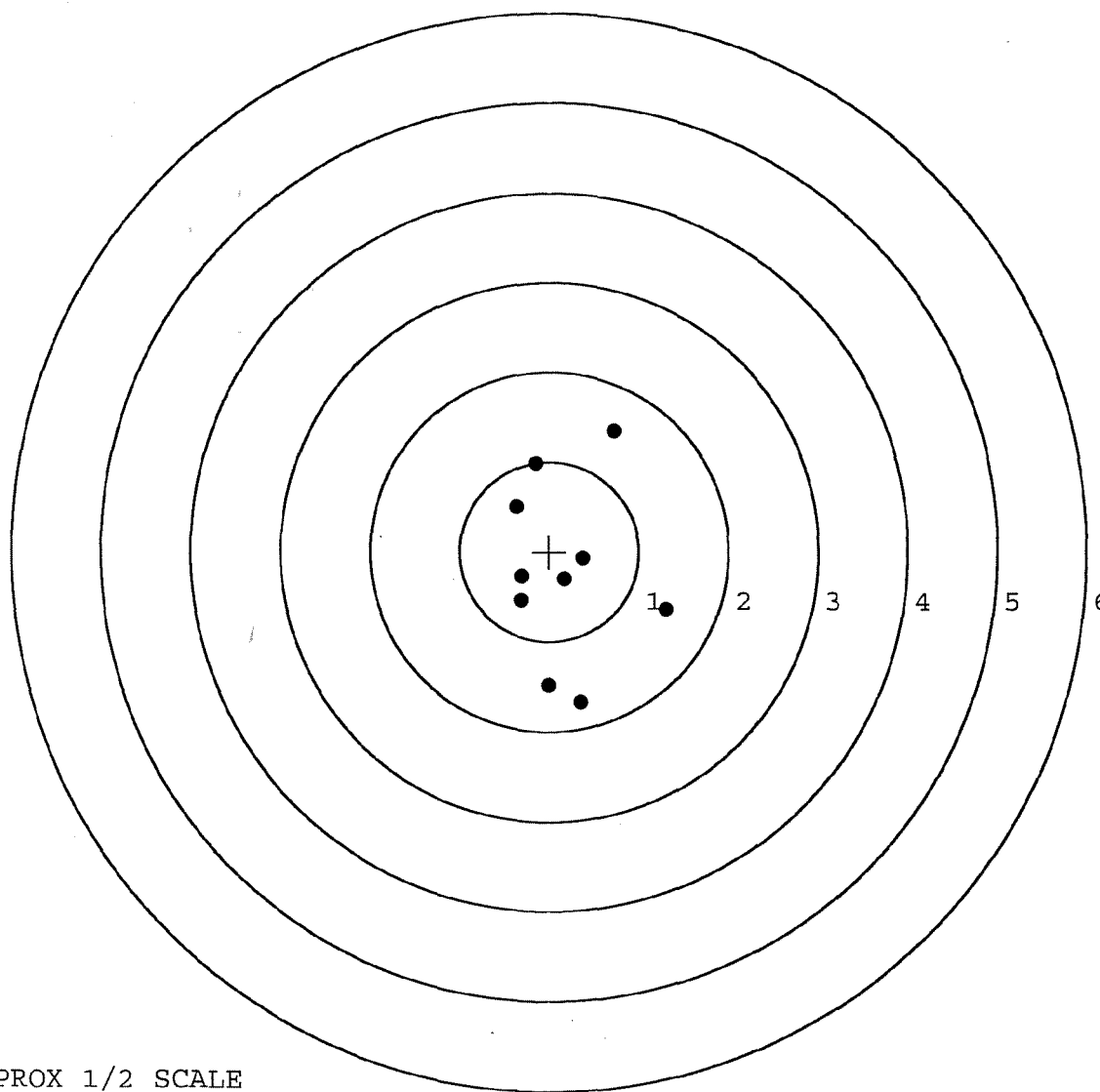
MEAN RADIUS: 0.919

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.300	-0.647
2:	0.355	-1.684
3:	-0.013	-1.499
4:	0.380	-0.080
5:	0.168	-0.311
6:	-0.312	-0.280
7:	-0.319	-0.546
8:	-0.369	0.498
9:	-0.147	0.983
10:	0.723	1.340



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461581. __1

TARGET NUMBER: 3

FILE DATE: 10/18/2005

FILE TIME: 09:25

X CENTROID: 0.161

Y CENTROID: -0.189

POA TO CENTROID: 0.248

HORZ SPREAD: 2.931

VERT SPREAD: 1.812

GROUP SPREAD: 2.955

MIN RADIUS: 0.413

MAX RADIUS: 1.490

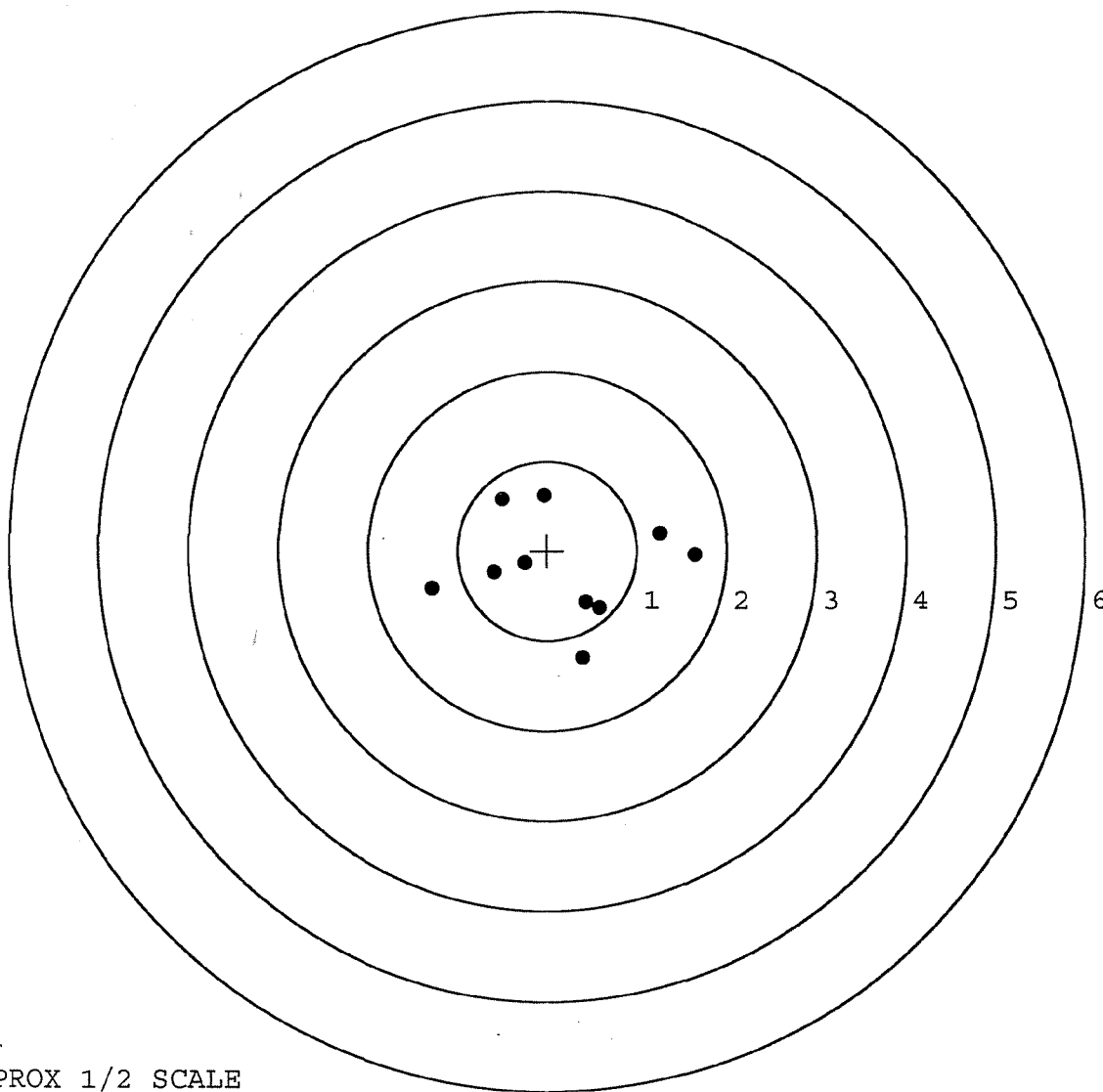
MEAN RADIUS: 0.926

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.398	-1.194
2:	0.583	-0.646
3:	0.429	-0.574
4:	1.645	-0.049
5:	1.247	0.193
6:	-0.046	0.618
7:	-0.510	0.580
8:	-0.249	-0.144
9:	-0.600	-0.246
10:	-1.286	-0.425



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461581. __ 1

TARGET NUMBER: 4

FILE DATE: 10/18/2005

FILE TIME: 09:25

POINT#	X	Y
1:	1.100	-0.699
2:	1.340	0.926
3:	-0.003	-1.136
4:	-0.220	-1.039
5:	-0.137	-0.405
6:	-0.534	-0.181
7:	-0.664	0.099
8:	-0.890	0.427
9:	0.005	0.427
10:	-0.783	2.454

X CENTROID: -0.079

Y CENTROID: 0.087

POA TO CENTROID: 0.117

HORZ SPREAD: 2.230

VERT SPREAD: 3.590

GROUP SPREAD: 3.674

MIN RADIUS: 0.350

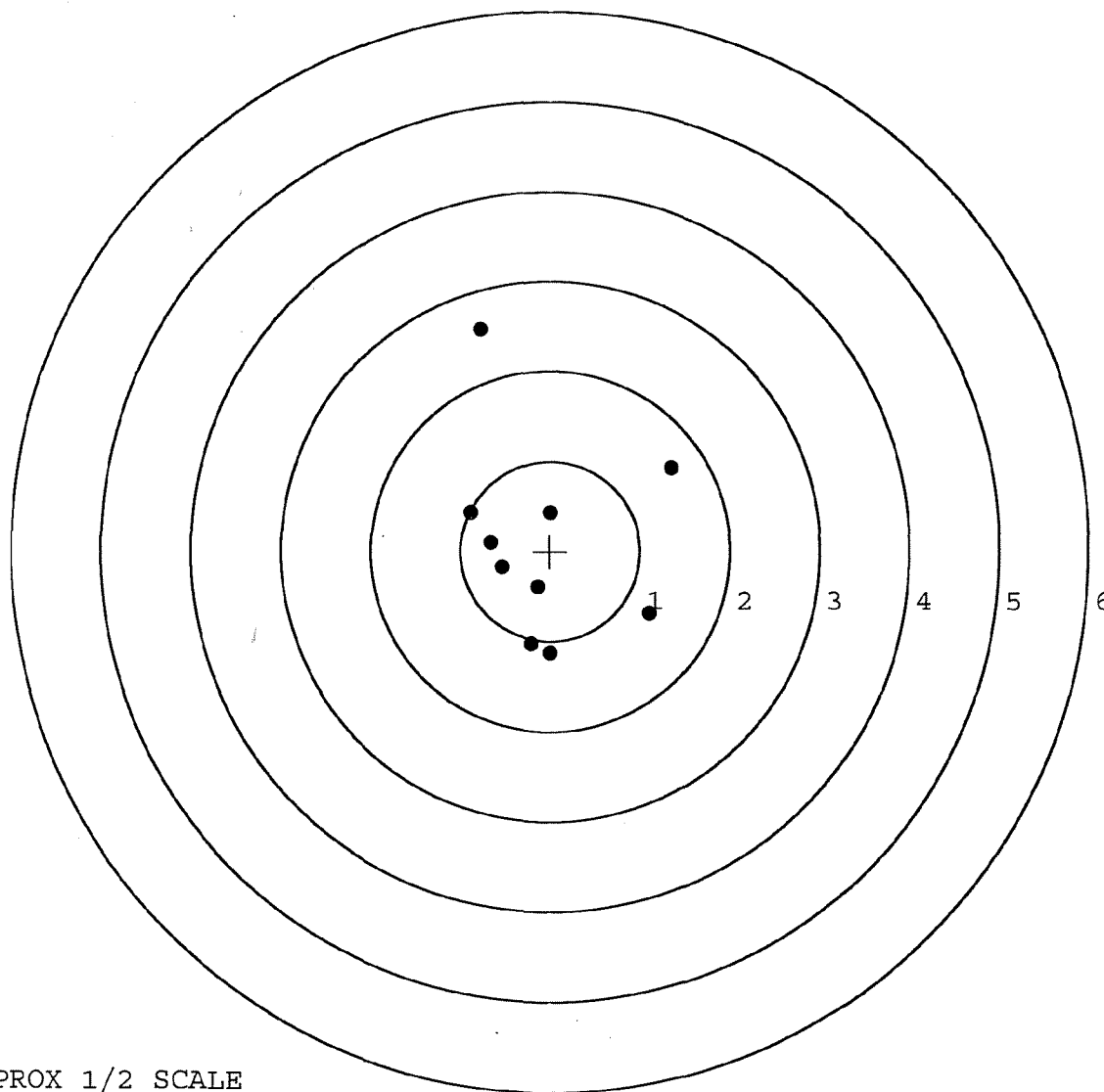
MAX RADIUS: 2.469

MEAN RADIUS: 1.073

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461581. __1

TARGET NUMBER: 5

FILE DATE: 10/18/2005

FILE TIME: 09:25

X CENTROID: -0.023

Y CENTROID: -0.091

POA TO CENTROID: 0.094

HORZ SPREAD: 2.187

VERT SPREAD: 1.518

GROUP SPREAD: 2.353

MIN RADIUS: 0.095

MAX RADIUS: 1.384

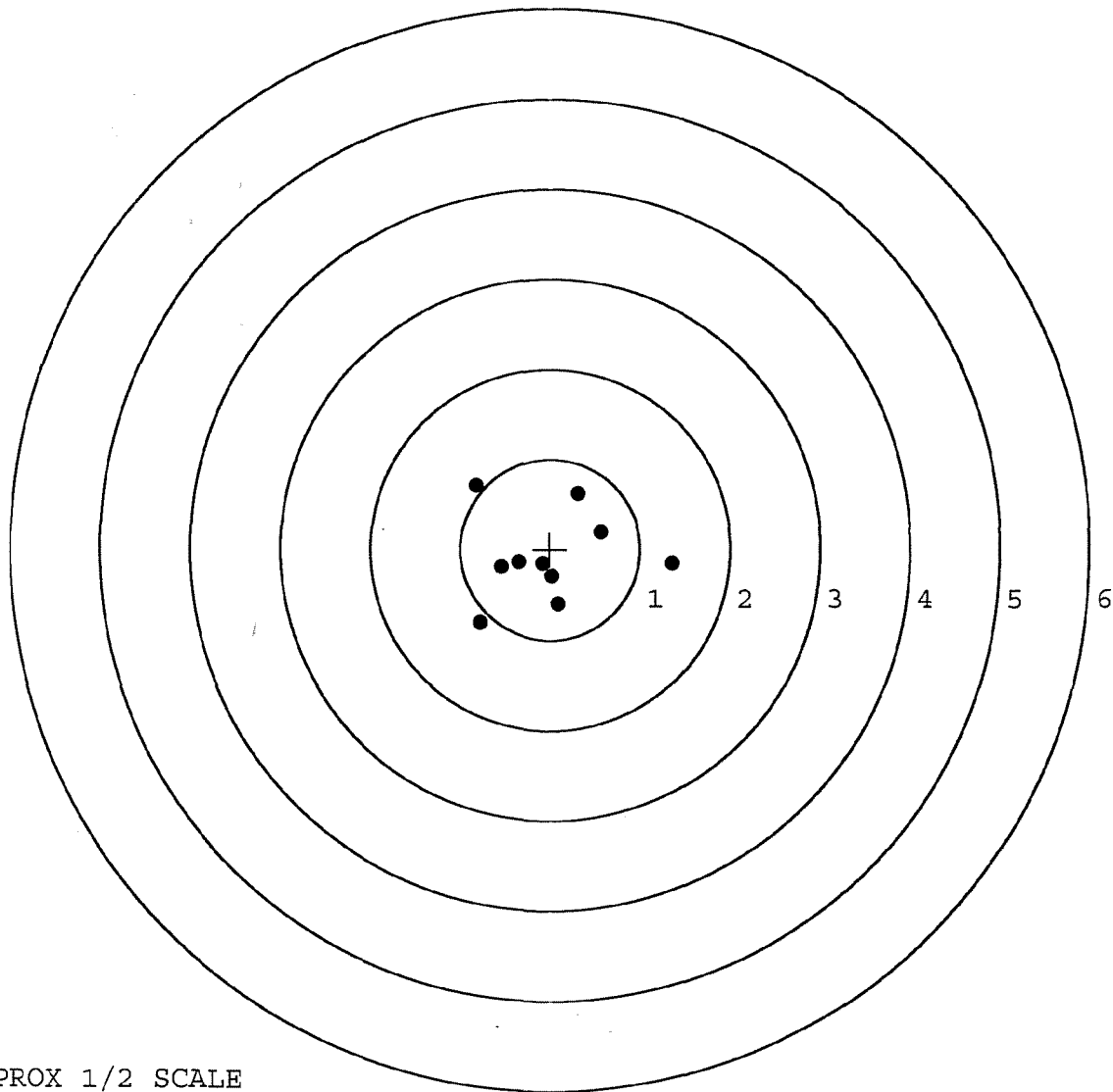
MEAN RADIUS: 0.672

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.359	-0.165
2:	0.573	0.188
3:	0.313	0.619
4:	-0.828	0.702
5:	0.091	-0.613
6:	-0.782	-0.816
7:	0.020	-0.301
8:	-0.083	-0.165
9:	-0.542	-0.203
10:	-0.353	-0.153



TARGET APPROX 1/2 SCALE