

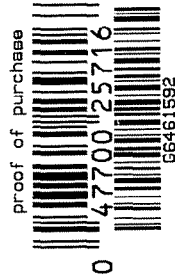
G-646 1592

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



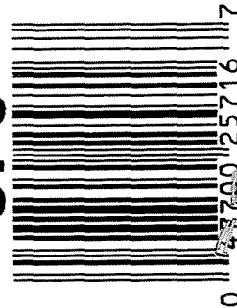
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461592

UPC



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



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



SERIAL NO.



6/17/2005 2:12:04 PM

Crib

92

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 # G60461592

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	MAGNA-FLUX INSPECTED	9-6-05	RTZ
470	DIS-ASSEMBLE ACTION	SEP 24 2005	9-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>umg</u>	9/8/05	umg
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	SW
530 & 540	APPLY COATINGS (BARREL ACTION)		9/15	RP 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

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>5.0</u> <u>4.5</u> <u>4.5</u>	10/18/05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	10/18/05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.024</u>	10/18/05	DA
	J) ASSEMBLE STOCK		9-19-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-19-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-12-05	AC
	M) IRON SIGHT ALIGNMENT		10-12-05	AC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-12-05	AC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/14/05	mgj
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-14-05	wom
670	FINAL INSPECTION A) HEADSPACE		10-19-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.74</u> <u>2.75</u> <u>2.86</u> <u>2.83</u>	10-19-05	DA
	C) FUNCTION		10-19-05	BC
690	PACK		10/25/05	DA

BARBER - M24 0153440AVERAGE 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

9/13/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.33		2.36	
PULL #2	2.63	2.34		2.39	
PULL #3	2.54	2.28		2.36	
PULL #4	2.51	2.49		2.29	
PULL #5	2.51	2.41		2.31	
TOTAL	12.81	11.85		11.71	
AVERAGE	2.56	2.37		2.34	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.02		
PULL #2	3.11	2.87		
PULL #3	2.86	2.72		
PULL #4	3.09	2.76		
PULL #5	3.07	2.90		
TOTAL	15.23	14.27		
AVERAGE	3.05	2.85		

	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	4.22	4.22		4.35
PULL #2	4.31	4.12		4.37
PULL #3	4.33	4.23		4.40
PULL #4	4.41	4.26		4.41
PULL #5	4.41	4.30		4.35
TOTAL	21.68	21.13		21.88
AVERAGE	4.34	4.23		4.38

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461592.___0

FILE DATE AND TIME: 10/14/2005 18:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.103
The Average Y Centroid of the Five Target Set:	-0.055
The Average Point of Impact of the Five Target Set:	0.117
The Average Mean Radius of the Five Target Set:	0.735
The Distance from POA to Centroid Target #1:	0.061
The Distance from Centroid Target #2 to Centroid Target #1:	0.214
The Distance from Centroid Target #3 to Centroid Target #1:	0.202
The Distance from Centroid Target #4 to Centroid Target #1:	0.287
The Distance from Centroid Target #5 to Centroid Target #1:	0.129

SERIAL NUMBER: G6461592. __0

TARGET NUMBER: 1

FILE DATE: 10/14/2005

FILE TIME: 18:13

POINT#	X	Y
1:	-0.194	0.202
2:	-0.444	-0.023
3:	-0.206	0.836
4:	-0.795	0.996
5:	0.213	-0.067
6:	0.690	-0.111
7:	0.772	0.329
8:	0.029	-1.360
9:	-0.794	-1.162
10:	0.130	0.473

X CENTROID: -0.060

Y CENTROID: 0.011

POA TO CENTROID: 0.061

HORZ SPREAD: 1.567

VERT SPREAD: 2.356

GROUP SPREAD: 2.162

MIN RADIUS: 0.233

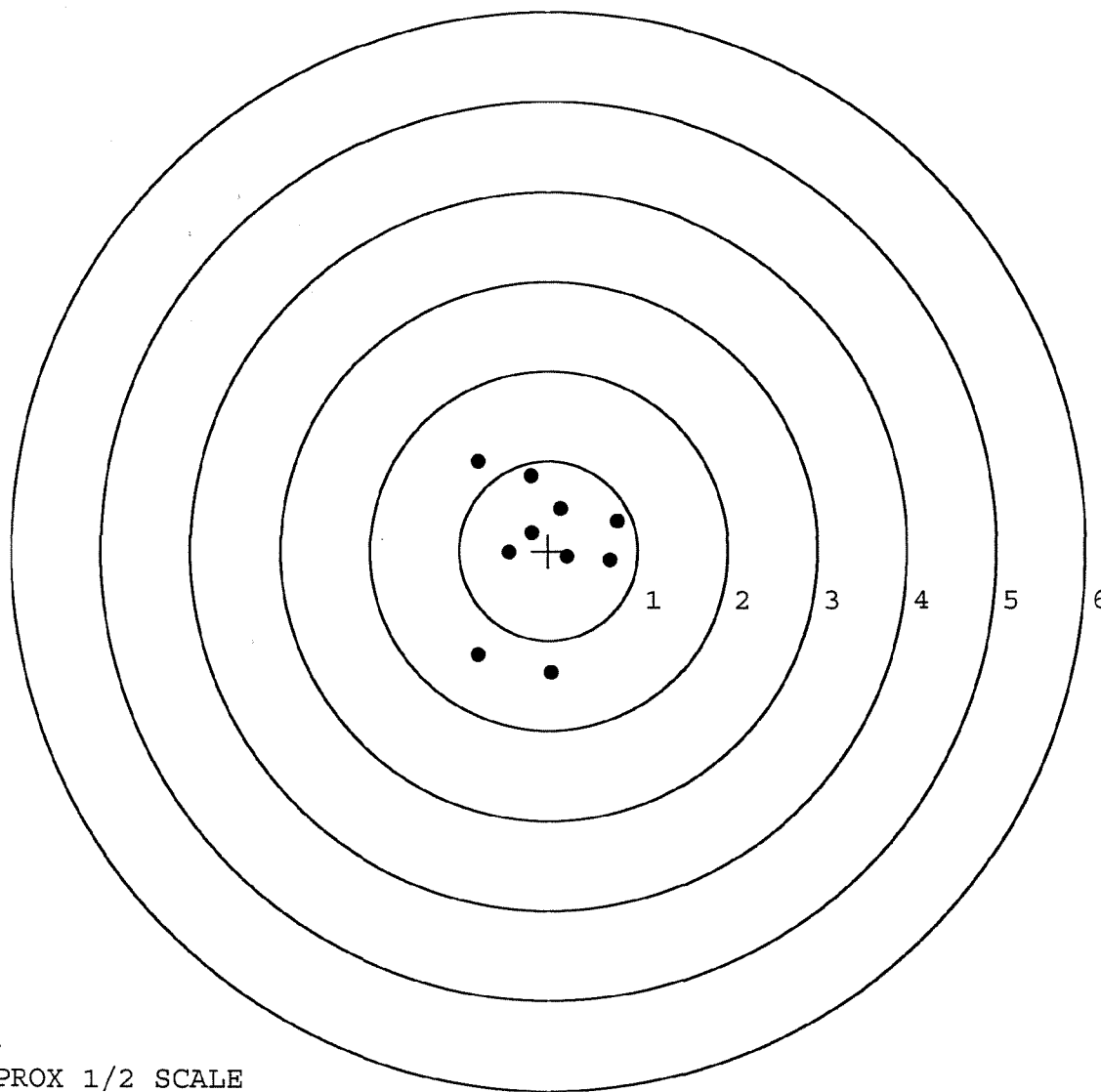
MAX RADIUS: 1.384

MEAN RADIUS: 0.788

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. __0

TARGET NUMBER: 2

FILE DATE: 10/14/2005

FILE TIME: 18:13

POINT#	X	Y
1:	-0.005	0.000
2:	0.195	-0.031
3:	0.468	0.189
4:	0.778	-0.281
5:	0.594	-0.417
6:	1.332	0.412
7:	-0.120	0.415
8:	-0.054	0.532
9:	-0.655	0.310
10:	-1.109	-0.327

X CENTROID: 0.142

Y CENTROID: 0.080

POA TO CENTROID: 0.163

HORZ SPREAD: 2.441

VERT SPREAD: 0.949

GROUP SPREAD: 2.550

MIN RADIUS: 0.123

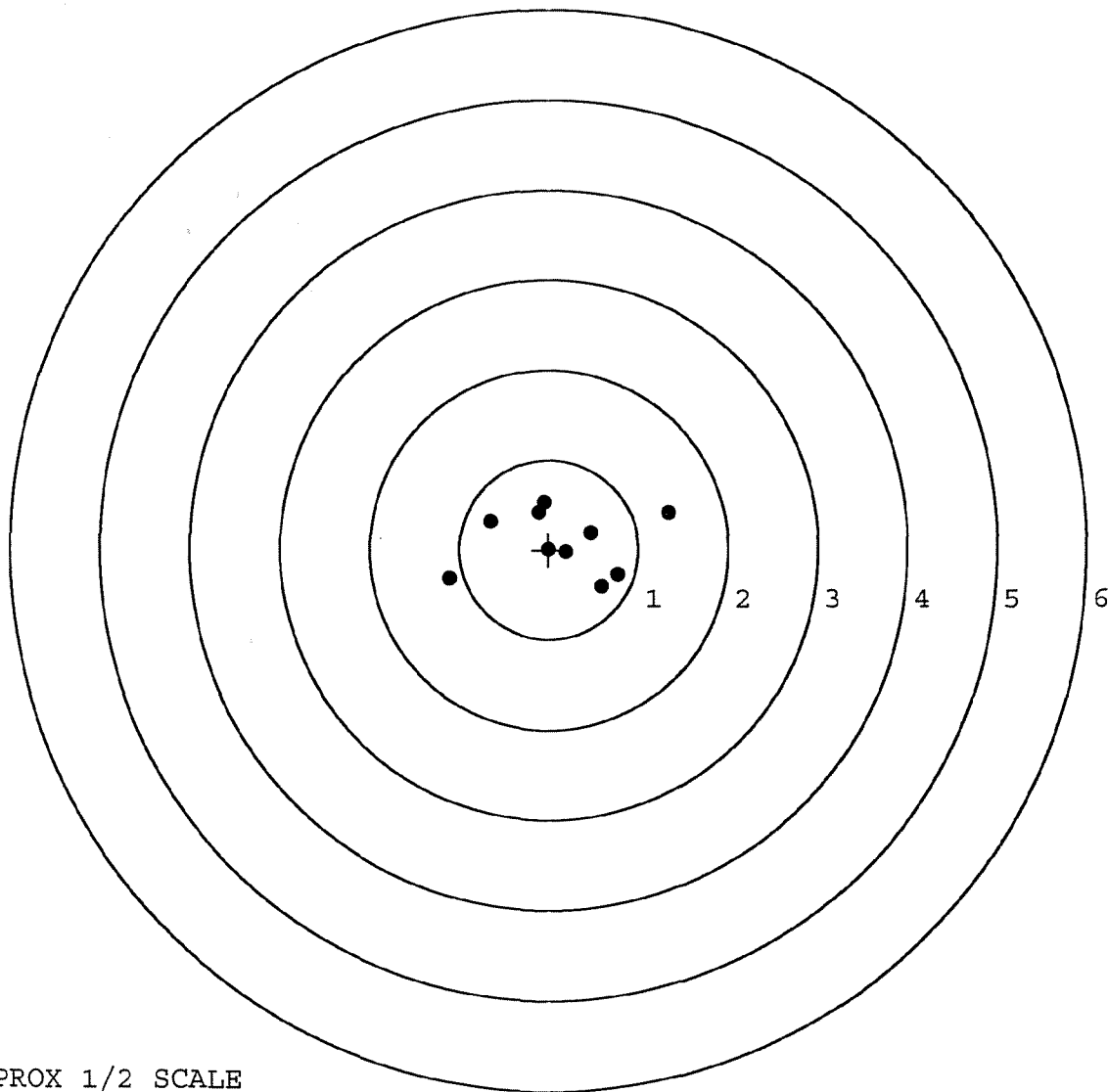
MAX RADIUS: 1.316

MEAN RADIUS: 0.634

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. __0

TARGET NUMBER: 3

FILE DATE: 10/14/2005

FILE TIME: 18:13

POINT#	X	Y
1:	0.000	0.000
2:	-0.201	-0.140
3:	-0.320	-0.050
4:	-0.974	0.434
5:	-0.074	0.571
6:	0.614	0.207
7:	0.731	-0.516
8:	0.363	-0.934
9:	-0.500	-0.691
10:	-0.922	-0.670

X CENTROID: -0.128

Y CENTROID: -0.179

POA TO CENTROID: 0.220

HORZ SPREAD: 1.705

VERT SPREAD: 1.505

GROUP SPREAD: 1.952

MIN RADIUS: 0.082

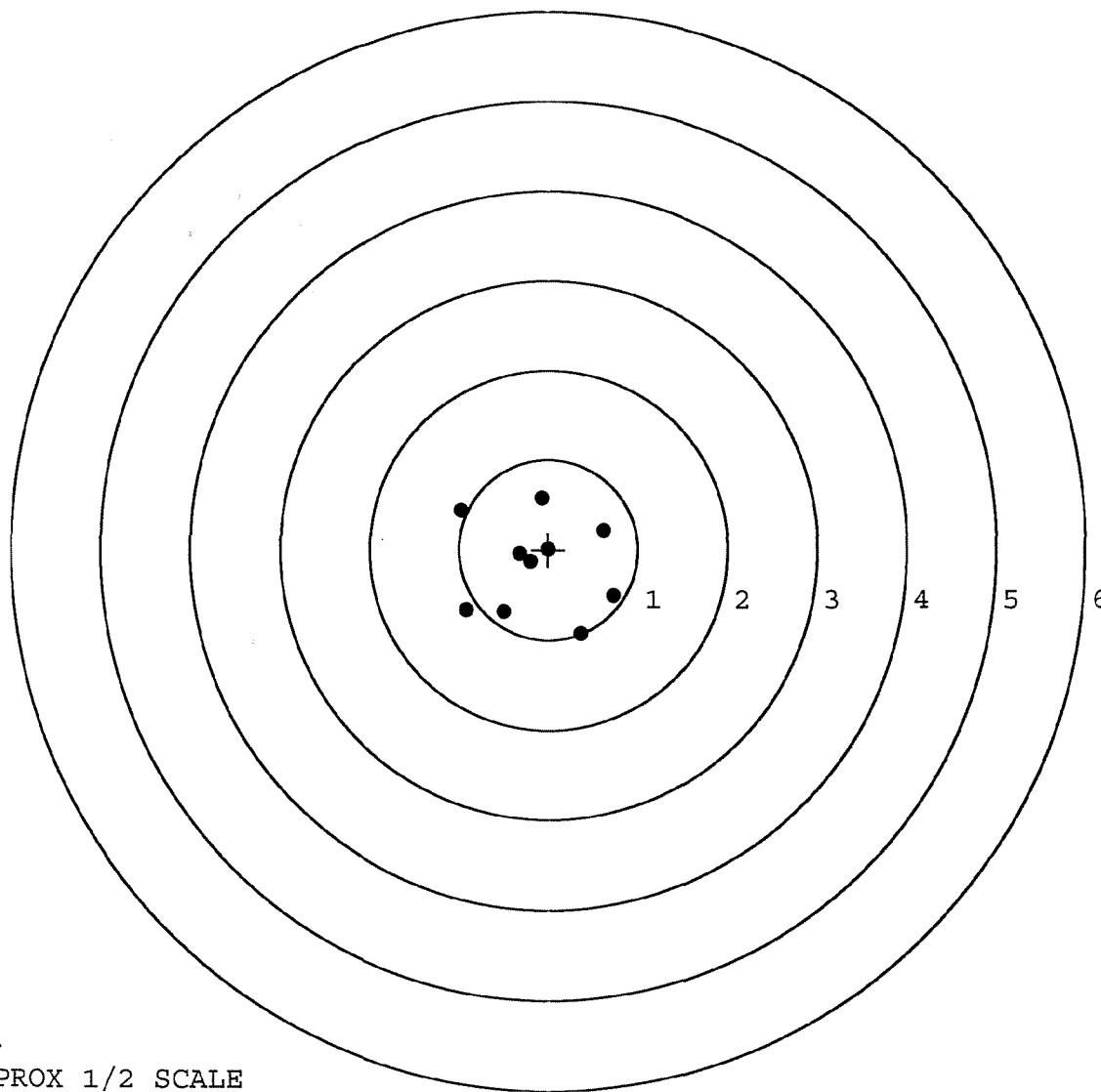
MAX RADIUS: 1.044

MEAN RADIUS: 0.656

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. 0

TARGET NUMBER: 4

FILE DATE: 10/14/2005

FILE TIME: 18:13

POINT#	X	Y
1:	0.008	-0.078
2:	-0.014	0.168
3:	-0.288	0.070
4:	-0.871	-0.788
5:	-0.974	-0.531
6:	-1.228	-0.675
7:	-0.213	-1.177
8:	1.197	-0.006
9:	-0.076	0.722
10:	-0.771	1.260

X CENTROID: -0.323

Y CENTROID: -0.103

POA TO CENTROID: 0.339

HORZ SPREAD: 2.425

VERT SPREAD: 2.437

GROUP SPREAD: 2.516

MIN RADIUS: 0.177

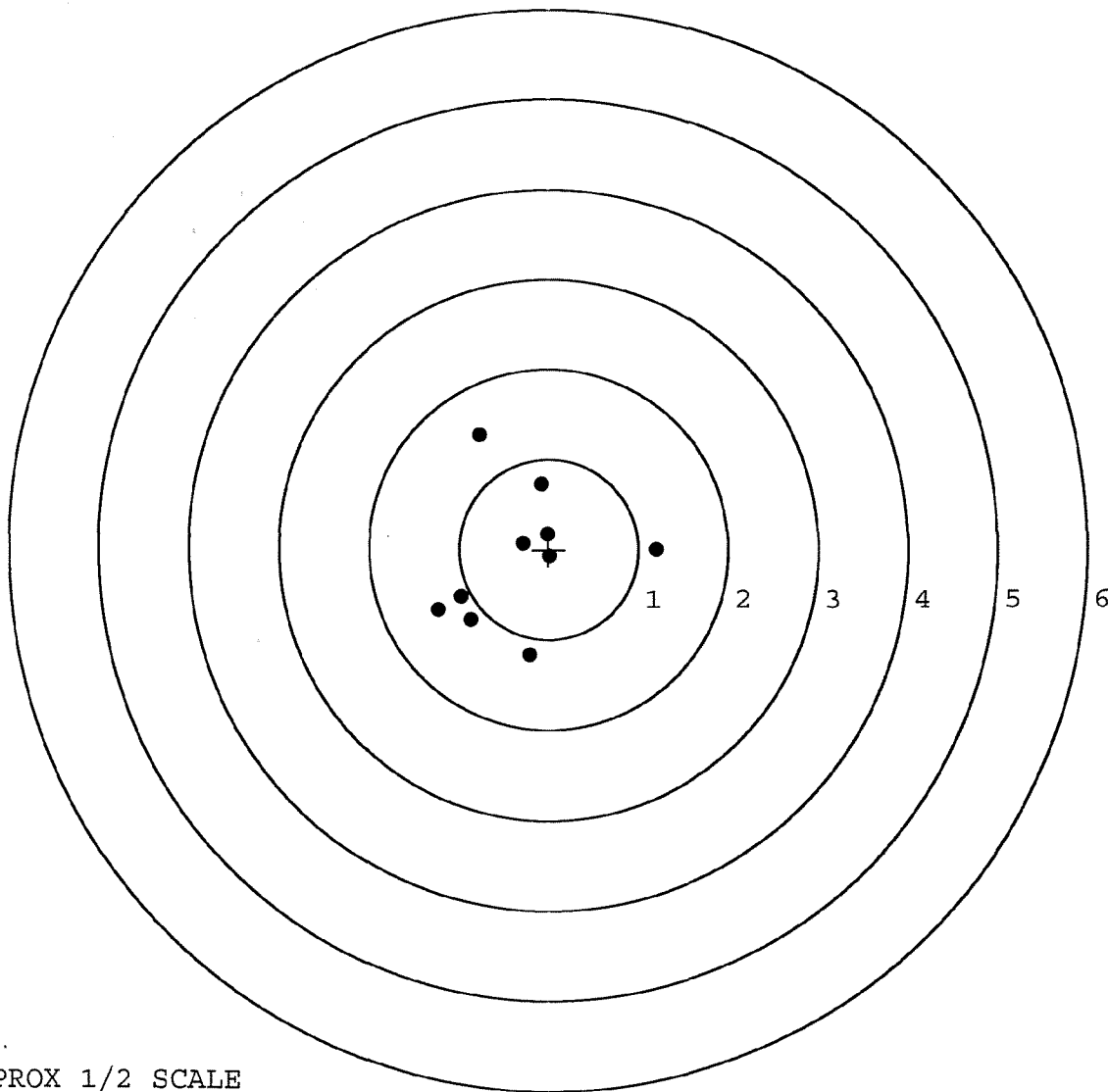
MAX RADIUS: 1.523

MEAN RADIUS: 0.855

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. __ 0

TARGET NUMBER: 5

FILE DATE: 10/14/2005

FILE TIME: 18:13

POINT#	X	Y
1:	0.334	0.111
2:	0.432	-0.058
3:	0.693	0.029
4:	0.021	0.535
5:	-0.064	0.394
6:	-0.869	-0.437
7:	-0.973	-0.492
8:	-1.405	-0.153
9:	0.080	-0.910
10:	0.309	0.124

X CENTROID: -0.144

Y CENTROID: -0.086

POA TO CENTROID: 0.168

HORZ SPREAD: 2.098

VERT SPREAD: 1.445

GROUP SPREAD: 2.106

MIN RADIUS: 0.486

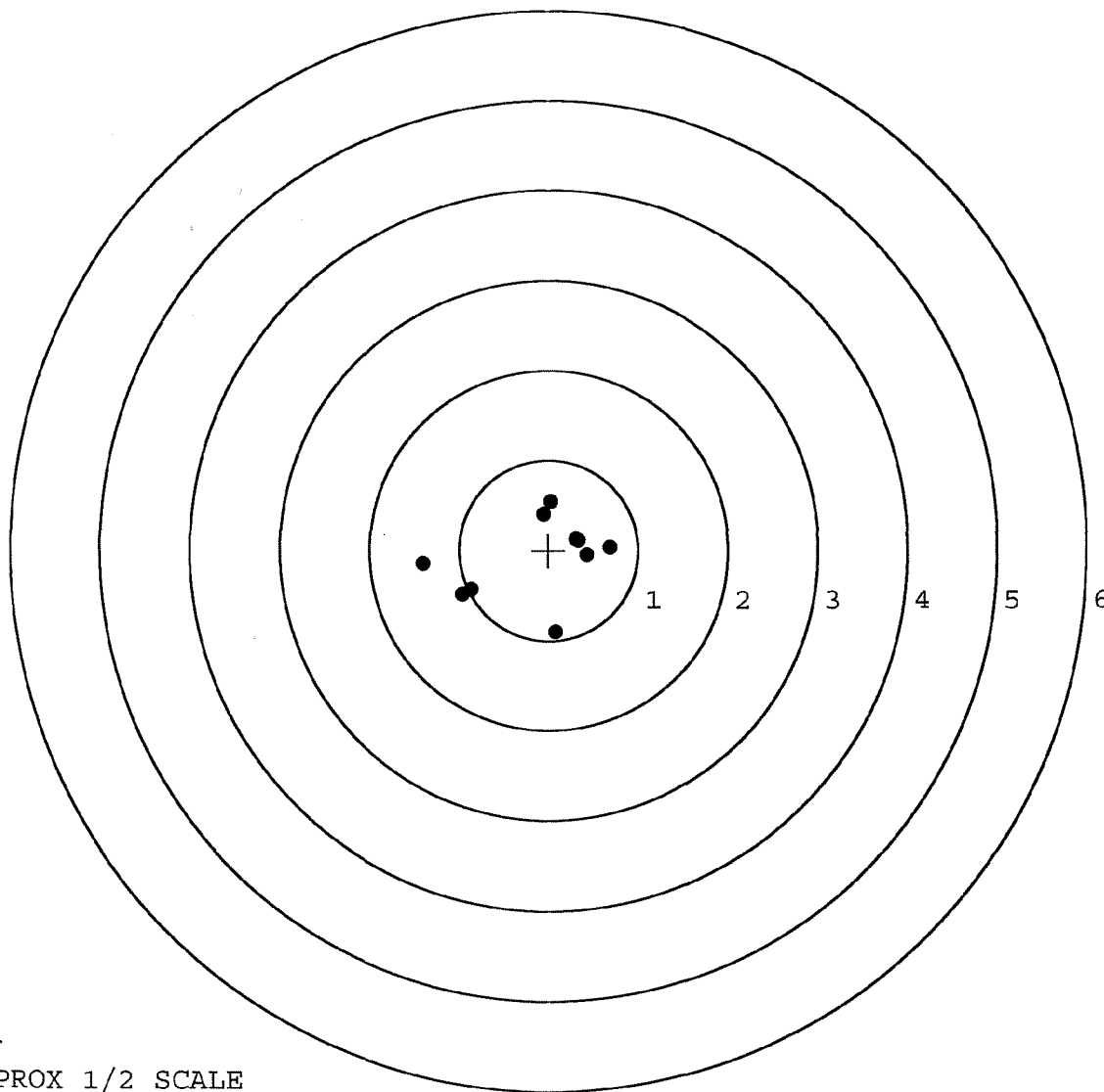
MAX RADIUS: 1.263

MEAN RADIUS: 0.741

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE