

G-646 1651

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



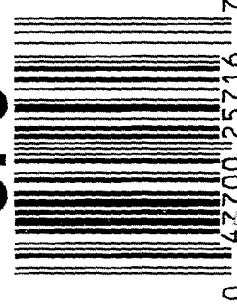
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461651

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

Original

88

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 # G64611051

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 MAGNAFLUX ACTION	9/8/05	unsub
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	unsub
530 & 540	APPLY COATINGS (BARREL ACTION)		9/15	RB 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>6.0</u>	<u>5.5</u>	<u>5.5</u>	10/13/05	DA		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u>	<u>2.5</u>	<u>2.5</u>	10/18/05	DA		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT .020 MIN	<u>1024</u>	<u>1024</u>	<u>024</u>	10/18/05	DA		
	J) ASSEMBLE STOCK				9-19-05	RTL		
	K) ASSEMBLE SWIVEL STUDS				10-19-05	RC		
	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	PASS	FAIL		10/14/05	MAJ		
		PASS	FAIL					
	MALFUNCTION	CORRECTION						
	MALFUNCTION							
	MALFUNCTION							
	MALFUNCTION							
660	INSPECT FOR LIVE AMMO				10-14-05	WOW		
670	FINAL INSPECTION A) HEADSPACE				10-19-05	BG		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.71</u>	<u>2.61</u>	<u>2.83</u>	<u>2.48</u>	<u>2.60</u>	10-19-05	DA
	C) FUNCTION				10-19-05	BG		
690	PACK				10/25/05	DA		

BARBER - M24 0154320

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

9/15/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.59	2.29		2.25	
PULL #2	2.83	2.14		2.24	
PULL #3	2.24	2.46		2.39	
PULL #4	2.82	2.09		2.15	
PULL #5	2.57	2.47		2.46	
TOTAL	13.05	11.45		11.49	
AVERAGE	2.61	2.29		2.30	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.32		
PULL #2	3.46	3.46		
PULL #3	3.62	3.49		
PULL #4	3.63	3.13		
PULL #5	3.42	3.63		
TOTAL	17.49	17.03		
AVERAGE	3.50	3.41		

	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	4.07	3.77		4.33
PULL #2	3.94	4.06		4.09
PULL #3	4.16	4.01		4.26
PULL #4	3.81	4.03		3.98
PULL #5	4.04	3.81		4.27
TOTAL	20.02	19.68		20.93
AVERAGE	4.00	3.94		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461651. __0

FILE DATE AND TIME: 10/14/2005 18:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

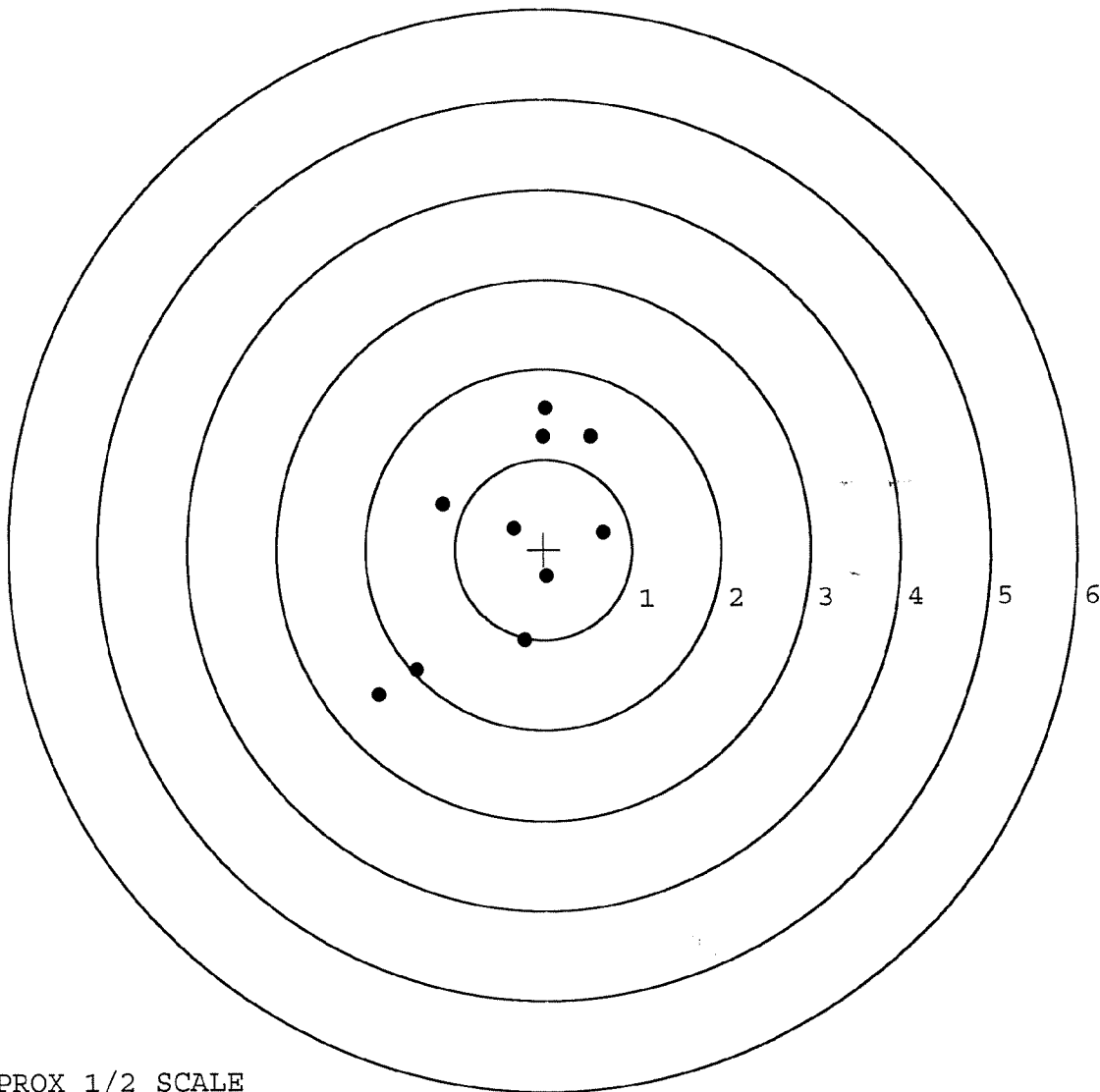
The Average X Centroid of the Five Target Set:	-0.123
The Average Y Centroid of the Five Target Set:	0.079
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	1.050
The Distance from POA to Centroid Target #1:	0.380
The Distance from Centroid Target #2 to Centroid Target #1:	0.238
The Distance from Centroid Target #3 to Centroid Target #1:	0.661
The Distance from Centroid Target #4 to Centroid Target #1:	0.135
The Distance from Centroid Target #5 to Centroid Target #1:	0.469

SERIAL NUMBER: G6461651. __0
 TARGET NUMBER: 1
 FILE DATE: 10/14/2005
 FILE TIME: 18:17

X CENTROID: -0.373
 Y CENTROID: 0.074
 POA TO CENTROID: 0.380
 HORZ SPREAD: 2.530
 VERT SPREAD: 3.173
 GROUP SPREAD: 3.733
 MIN RADIUS: 0.166
 MAX RADIUS: 2.247
 MEAN RADIUS: 1.200

POINT#	X	Y
1:	0.029	-0.298
2:	-0.338	0.236
3:	0.667	0.189
4:	-0.225	-1.010
5:	-1.437	-1.339
6:	-1.863	-1.609
7:	-1.130	0.509
8:	-0.003	1.247
9:	0.028	1.564
10:	0.540	1.248

IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 3
 # in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461651. 0

TARGET NUMBER: 2

FILE DATE: 10/14/2005

FILE TIME: 18:17

X CENTROID: -0.136

Y CENTROID: 0.097

POA TO CENTROID: 0.167

HORZ SPREAD: 1.548

VERT SPREAD: 2.560

GROUP SPREAD: 2.632

MIN RADIUS: 0.528

MAX RADIUS: 1.496

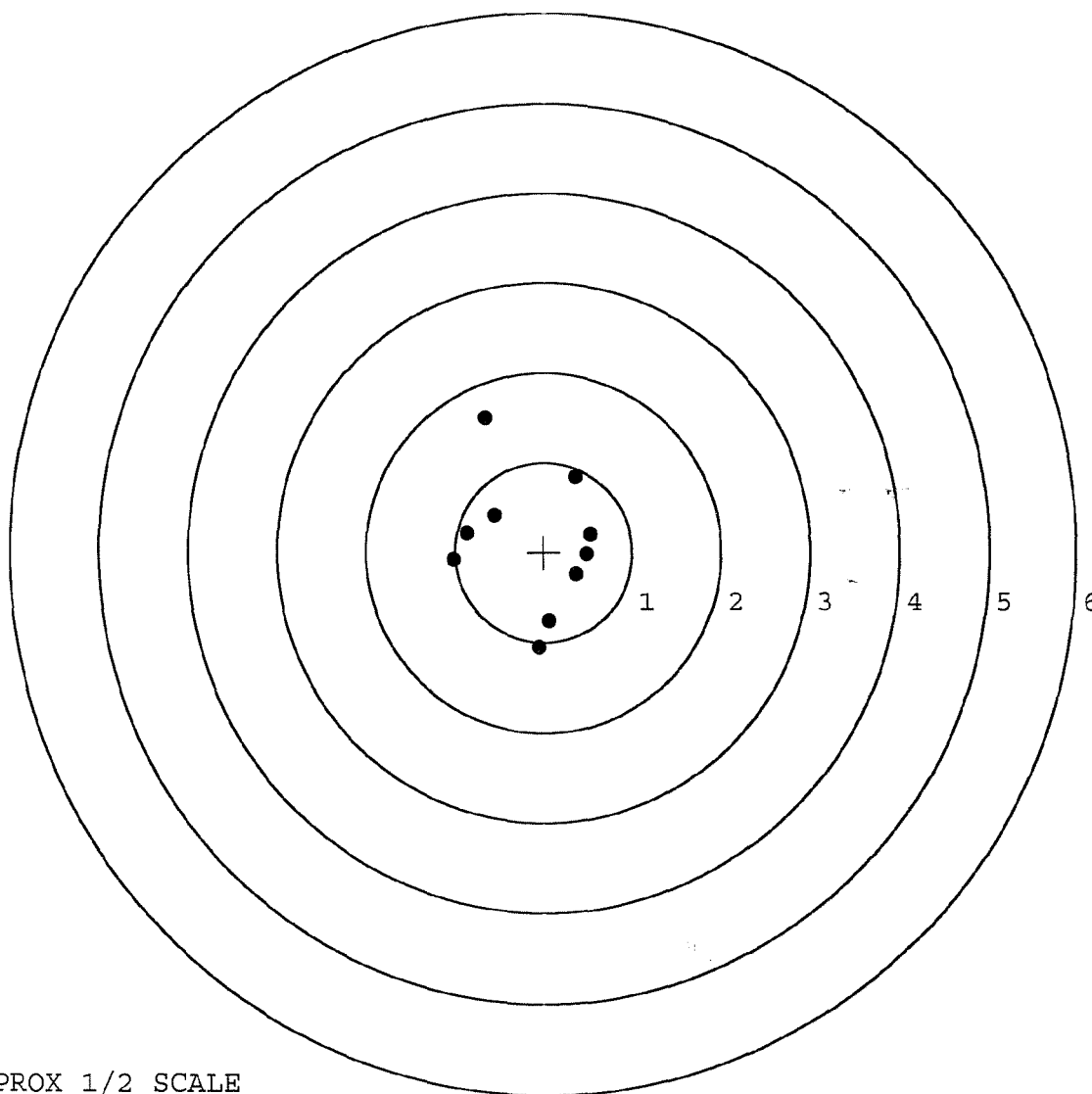
MEAN RADIUS: 0.851

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.560	0.412
2:	-0.862	0.212
3:	-1.018	-0.091
4:	-0.054	-1.064
5:	0.065	-0.767
6:	0.365	-0.251
7:	0.481	-0.021
8:	0.530	0.206
9:	0.354	0.836
10:	-0.665	1.496



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461651. 0

TARGET NUMBER: 3

FILE DATE: 10/14/2005

FILE TIME: 18:17

X CENTROID: 0.169

Y CENTROID: 0.452

POA TO CENTROID: 0.483

HORZ SPREAD: 1.729

VERT SPREAD: 2.933

GROUP SPREAD: 3.086

MIN RADIUS: 0.413

MAX RADIUS: 1.681

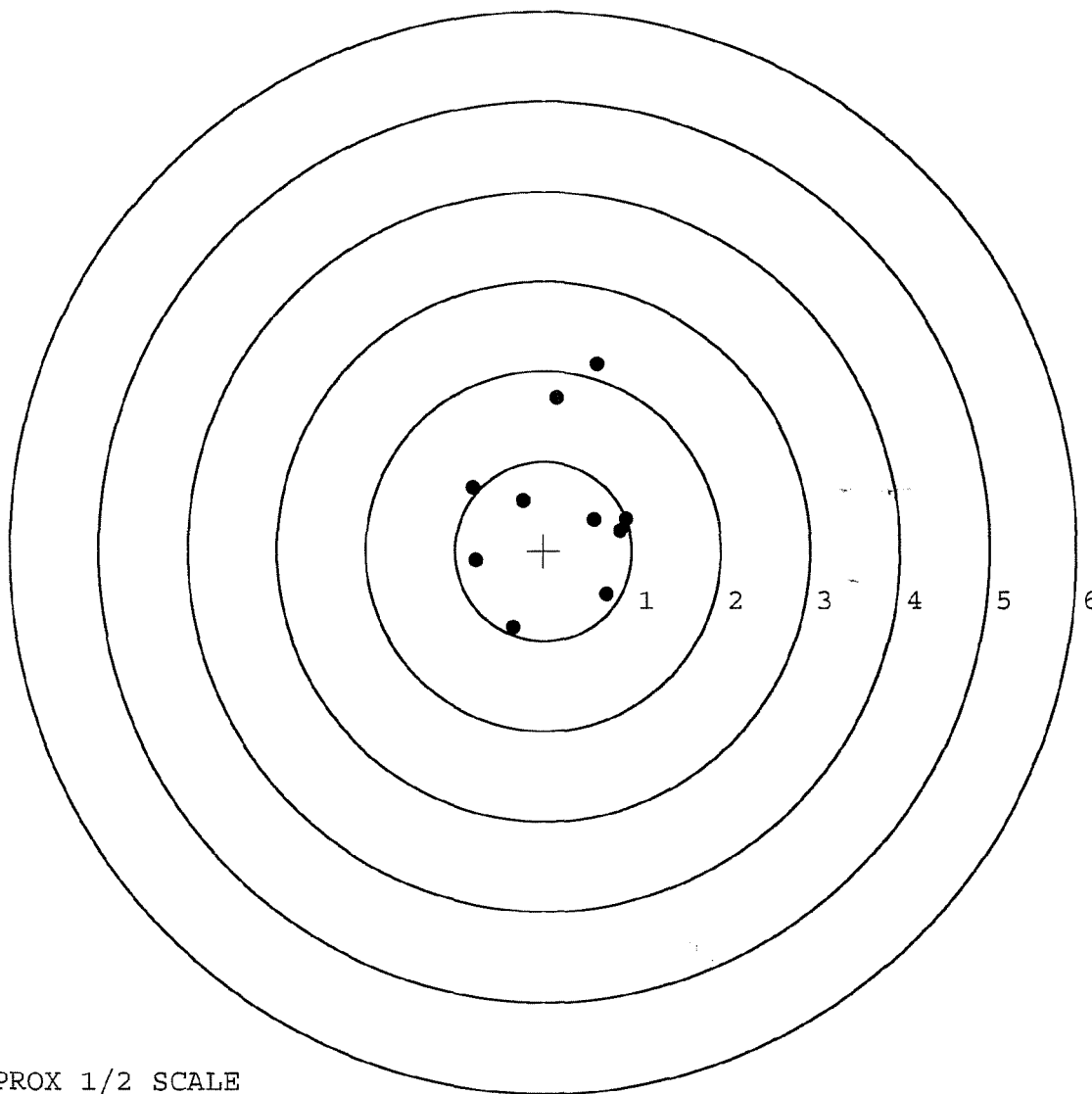
MEAN RADIUS: 0.984

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.352	-0.858
2:	-0.761	-0.109
3:	-0.240	0.562
4:	-0.798	0.708
5:	0.150	1.695
6:	0.608	2.075
7:	0.872	0.228
8:	0.931	0.358
9:	0.568	0.348
10:	0.708	-0.486



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461651. __0

TARGET NUMBER: 4

FILE DATE: 10/14/2005

FILE TIME: 18:17

X CENTROID: -0.273

Y CENTROID: -0.016

POA TO CENTROID: 0.273

HORZ SPREAD: 2.512

VERT SPREAD: 2.193

GROUP SPREAD: 3.120

MIN RADIUS: 0.120

MAX RADIUS: 1.695

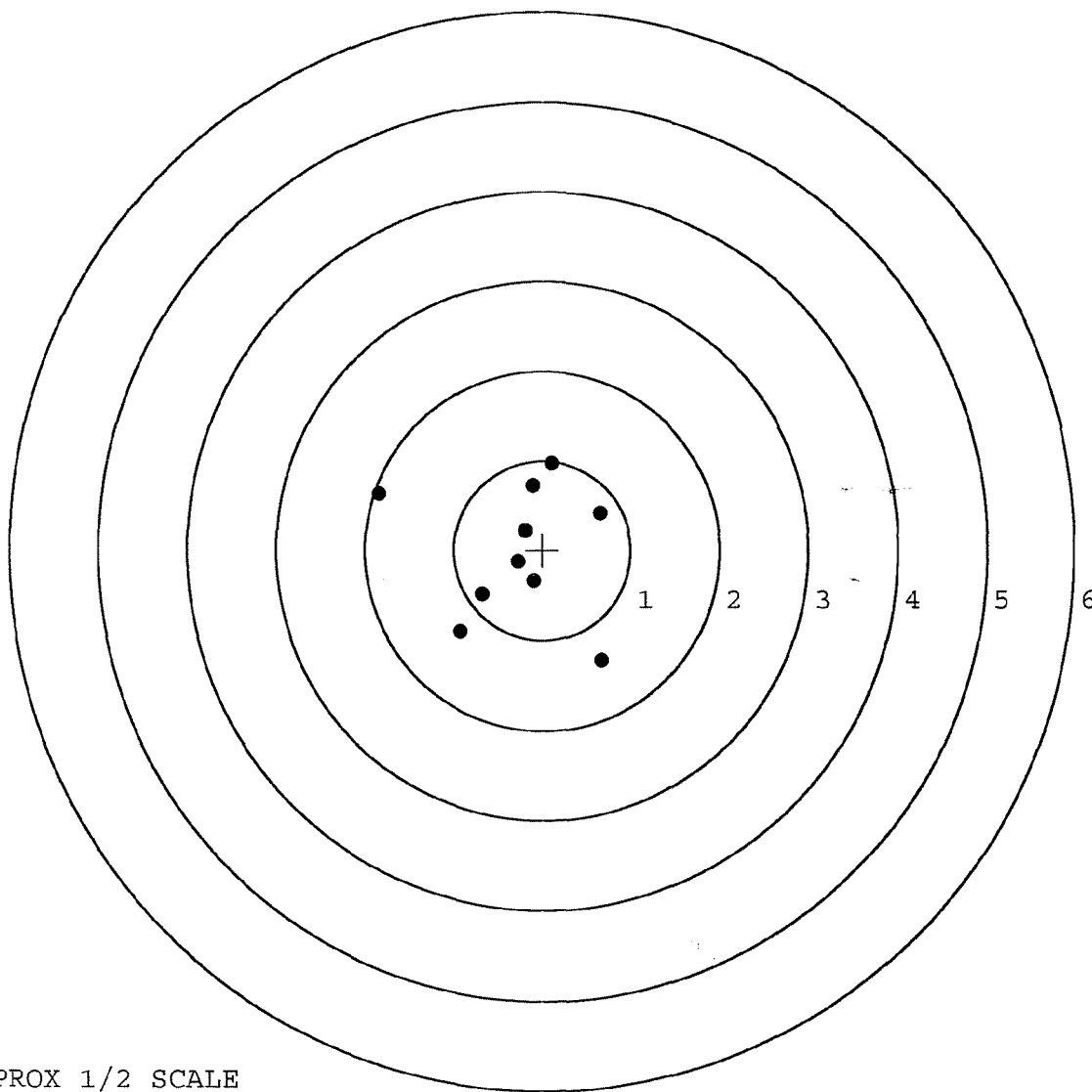
MEAN RADIUS: 0.854

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.103	0.971
2:	-0.118	0.722
3:	-0.201	0.219
4:	-1.841	0.628
5:	-0.277	-0.136
6:	-0.105	-0.352
7:	0.652	0.414
8:	0.671	-1.222
9:	-0.686	-0.496
10:	-0.928	-0.911



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461651. 0

TARGET NUMBER: 5

FILE DATE: 10/14/2005

FILE TIME: 18:17

X CENTROID: 0.000

Y CENTROID: -0.210

POA TO CENTROID: 0.210

HORZ SPREAD: 2.405

VERT SPREAD: 3.637

GROUP SPREAD: 3.804

MIN RADIUS: 0.347

MAX RADIUS: 1.974

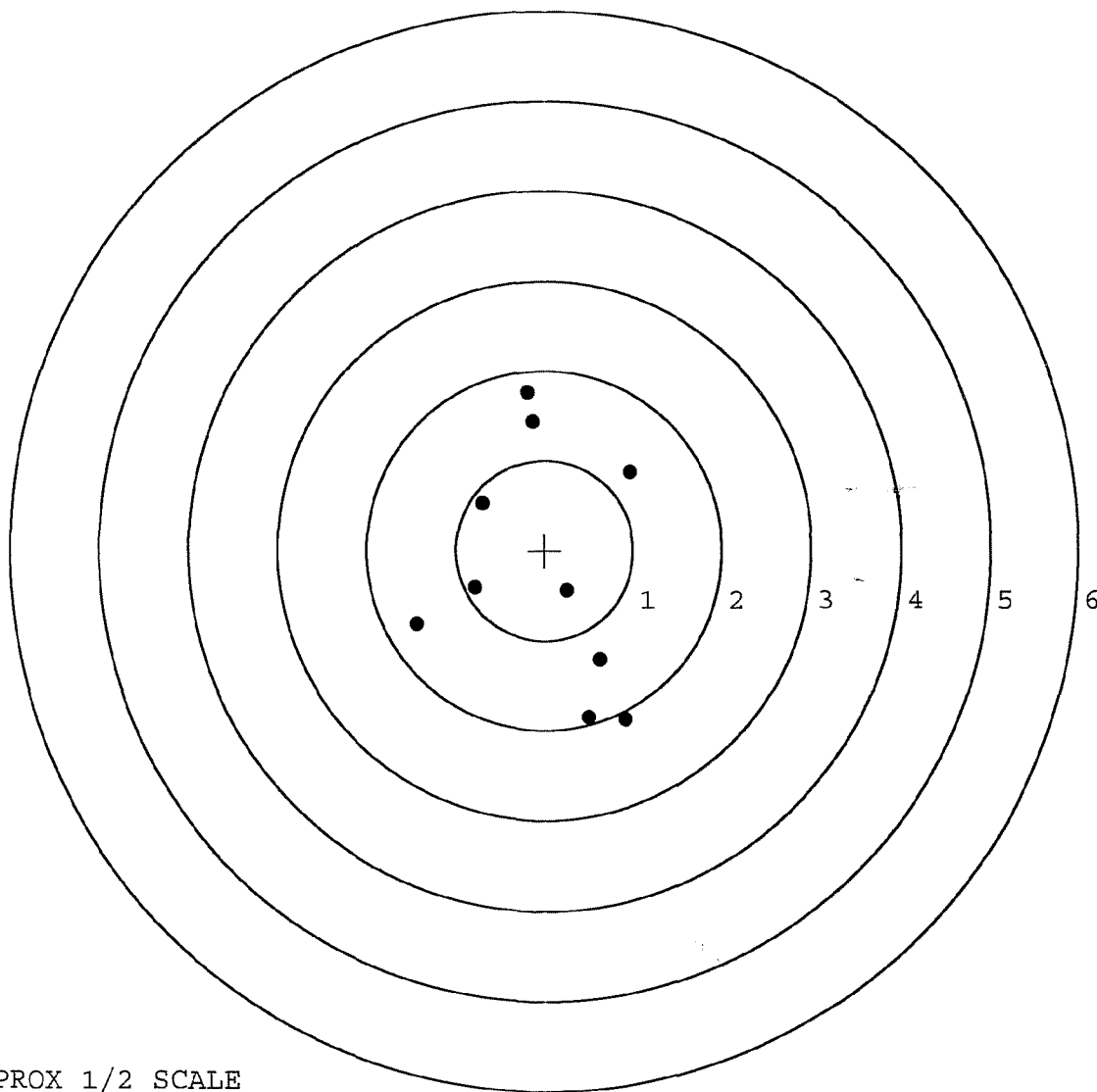
MEAN RADIUS: 1.362

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 5

POINT#	X	Y
1:	0.251	-0.450
2:	-0.780	-0.423
3:	-1.441	-0.825
4:	-0.705	0.514
5:	-0.138	1.427
6:	-0.195	1.755
7:	0.964	0.870
8:	0.624	-1.219
9:	0.920	-1.882
10:	0.504	-1.865



TARGET APPROX 1/2 SCALE