

G646 1655

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



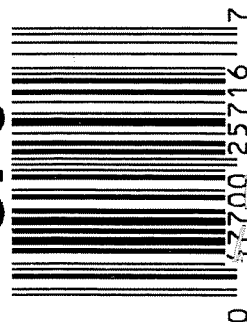
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461655

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.



Original
6/17/2005 2:12:04 PM
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 # G6461655

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	Ac
460	CHECK HEADSPACE		8-12-05	Ac
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRL
520	GOFF BLAST BBL / REC		9-9-05	LIB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	WJ
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10-6-05	MTM
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-05	MTM
	D) OIL FIRING PIN ASSEMBLY		10-11-05	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>4 lb</u>	<u>4 lb</u>	<u>4 lb</u>	10-19-05	BG-		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2 lb</u>	<u>2 lb</u>	<u>2 lb</u>	10-19-05	BG-		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.024</u>	10-19-05	BG-		
	J) ASSEMBLE STOCK					10-11-05	RTZ		
	K) ASSEMBLE SWIVEL STUDS					10-19-05	BG-		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					10-17-05	BG-		
	M) IRON SIGHT ALIGNMENT					10-17-05	BG-		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					10-17-05	BG-		
640 & 650	FUNCTION TEST AND TARGET		<u>PASS</u>	FAIL					
			<u>PASS</u>	FAIL		10-18-05	TRW		
	MALFUNCTION		N/A						
		CORRECTION							
	MALFUNCTION								
	MALFUNCTION								
	MALFUNCTION		N/A						
		CORRECTION							
	MALFUNCTION		N/A						
		CORRECTION							
660	INSPECT FOR LIVE AMMO					10-18-05	R.P.		
670	FINAL INSPECTION A) HEADSPACE					10-19-05	BG-		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u>	<u>2.27</u>	<u>2.40</u>	<u>2.53</u>	<u>2.25</u>	10-19-05	TRW
	C) FUNCTION							10-19-05	BG-
690	PACK							10/05/05	DA

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

10-3-05

TESTER

RC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.23	2.30		2.54	
PULL #2	2.36	2.65		2.90	
PULL #3	2.28	2.18		2.70	
PULL #4	2.86	2.65		2.34	
PULL #5	2.42	2.27		2.40	
TOTAL	12.15	12.05		12.88	
AVERAGE	2.43	2.41		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.26		
PULL #2	3.53	3.41		
PULL #3	2.96	3.32		
PULL #4	3.25	2.68		
PULL #5	2.88	3.48		
TOTAL	15.66	16.15		
AVERAGE	3.13	3.23		

	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	3.93		3.89
PULL #2	4.34	3.60		4.16
PULL #3	4.53	4.28		4.24
PULL #4	3.96	4.55		3.97
PULL #5	4.31	4.22		4.50
TOTAL	21.36	20.58		20.70
AVERAGE	4.27	4.12		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461655.___0
FILE DATE AND TIME: 10/18/2005 09:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.132
The Average Y Centroid of the Five Target Set:	-0.114
The Average Point of Impact of the Five Target Set:	0.175
The Average Mean Radius of the Five Target Set:	1.032
The Distance from POA to Centroid Target #1:	0.269
The Distance from Centroid Target #2 to Centroid Target #1:	0.819
The Distance from Centroid Target #3 to Centroid Target #1:	0.213
The Distance from Centroid Target #4 to Centroid Target #1:	1.109
The Distance from Centroid Target #5 to Centroid Target #1:	0.267

SERIAL NUMBER: G6461655. __0

TARGET NUMBER: 1

FILE DATE: 10/18/2005

FILE TIME: 09:38

POINT#	X	Y
1:	0.714	-0.849
2:	-0.051	-0.633
3:	-0.668	-0.918
4:	0.759	0.495
5:	0.337	0.692
6:	0.229	-0.172
7:	-0.063	-0.022
8:	-0.408	0.438
9:	-1.121	1.055
10:	-2.415	-0.132

X CENTROID: -0.269

Y CENTROID: -0.005

POA TO CENTROID: 0.269

HORZ SPREAD: 3.174

VERT SPREAD: 1.973

GROUP SPREAD: 3.235

MIN RADIUS: 0.206

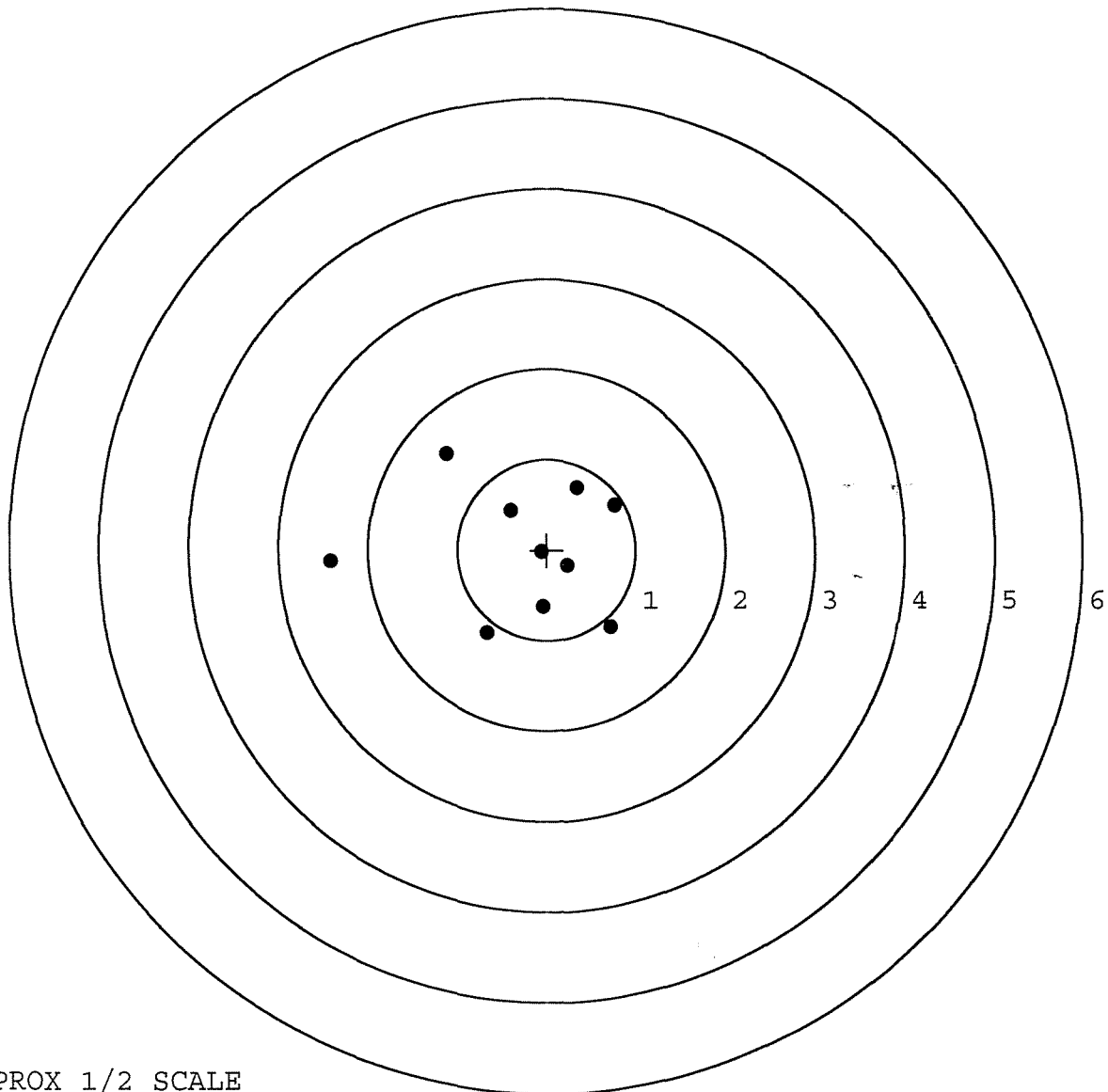
MAX RADIUS: 2.150

MEAN RADIUS: 0.973

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. 0

TARGET NUMBER: 2

FILE DATE: 10/18/2005

FILE TIME: 09:38

POINT#	X	Y
1:	1.569	-1.230
2:	0.305	-1.902
3:	-0.095	-2.109
4:	0.012	-3.066
5:	-0.719	-0.798
6:	0.526	0.329
7:	-0.280	0.383
8:	-0.289	0.851
9:	-0.742	0.616
10:	1.902	0.303

X CENTROID: 0.219

Y CENTROID: -0.662

POA TO CENTROID: 0.698

HORZ SPREAD: 2.644

VERT SPREAD: 3.917

GROUP SPREAD: 3.929

MIN RADIUS: 0.948

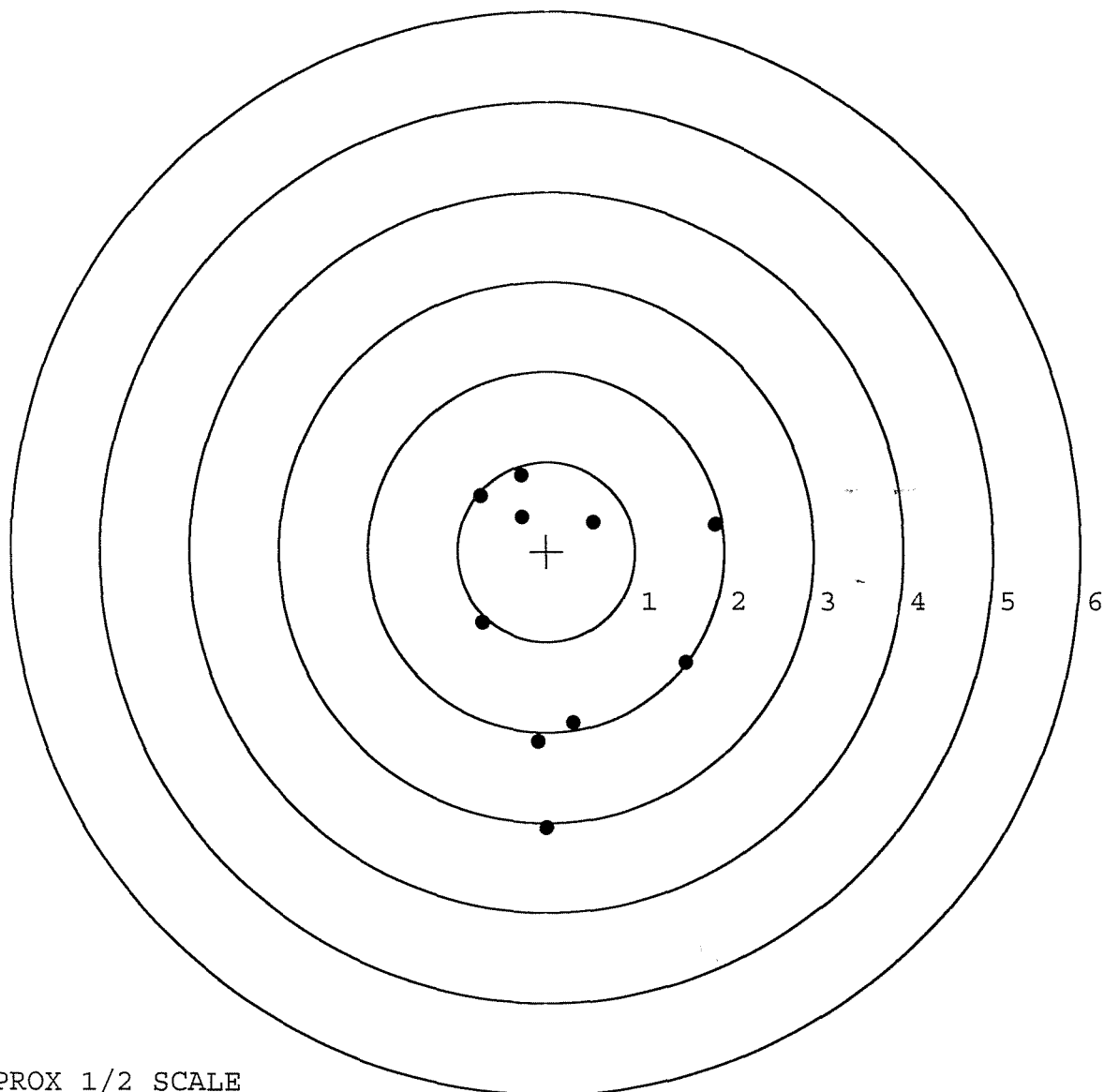
MAX RADIUS: 2.413

MEAN RADIUS: 1.488

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 1

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. __0

POINT# X Y

TARGET NUMBER: 3

1: -0.395 1.494

FILE DATE: 10/18/2005

2: 0.834 0.018

FILE TIME: 09:38

3: 0.609 -0.435

4: 0.263 0.015

X CENTROID: -0.095

5: -0.099 -0.035

Y CENTROID: 0.119

6: -0.503 -0.541

POA TO CENTROID: 0.152

7: -0.275 0.095

HORZ SPREAD: 1.469

8: -0.433 0.297

VERT SPREAD: 2.035

9: -0.635 0.309

GROUP SPREAD: 2.175

10: -0.313 -0.032

MIN RADIUS: 0.154

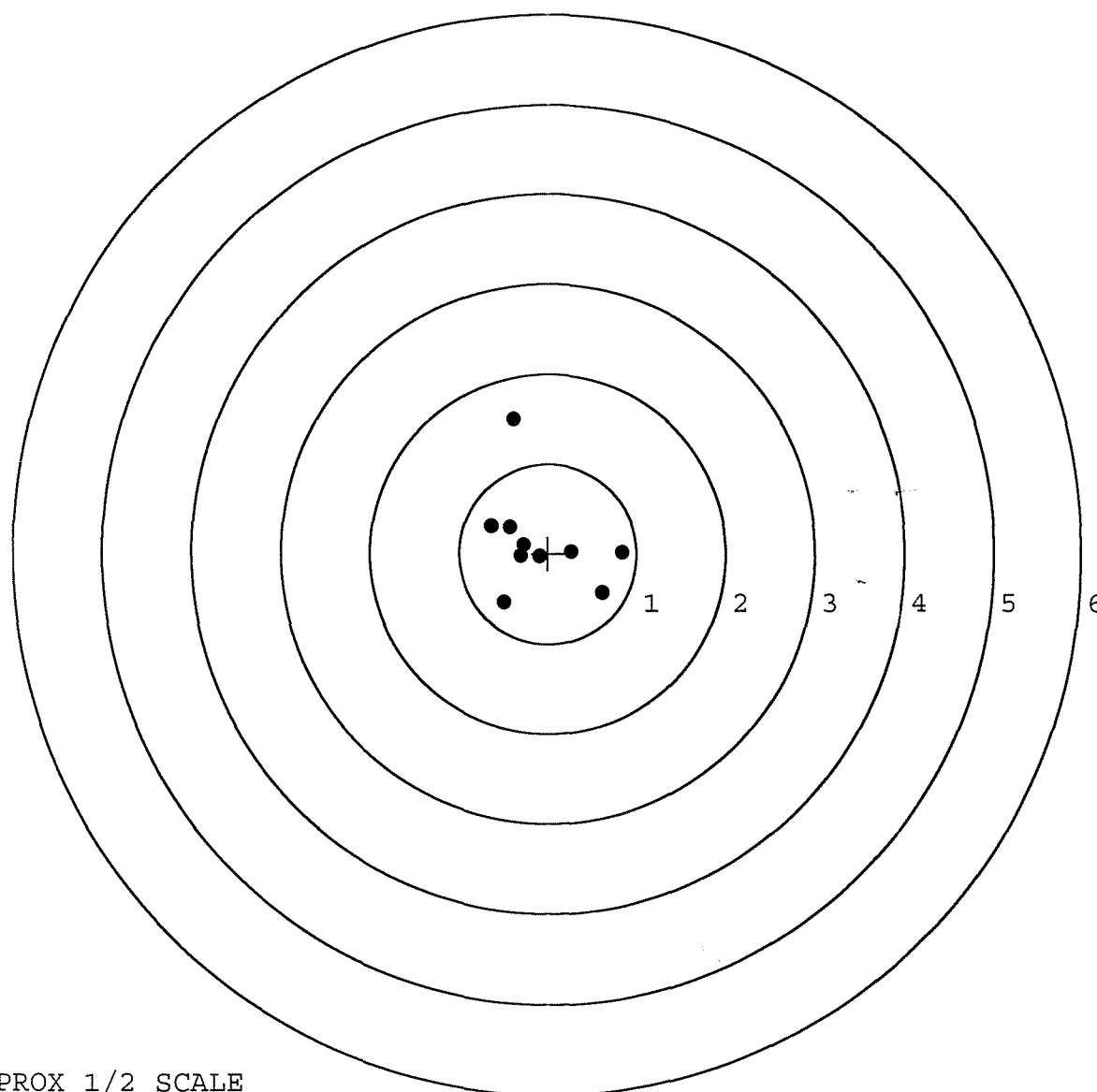
MAX RADIUS: 1.408

MEAN RADIUS: 0.594

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. __0

TARGET NUMBER: 4

FILE DATE: 10/18/2005

FILE TIME: 09:38

POINT#	X	Y
1:	2.276	-0.287
2:	2.373	0.263
3:	2.529	1.080
4:	1.436	-0.332
5:	0.690	-0.806
6:	0.476	-0.266
7:	-0.588	-0.783
8:	-0.156	0.590
9:	0.355	1.010
10:	-1.035	0.527

X CENTROID: 0.836

Y CENTROID: 0.100

POA TO CENTROID: 0.842

HORZ SPREAD: 3.564

VERT SPREAD: 1.886

GROUP SPREAD: 3.631

MIN RADIUS: 0.513

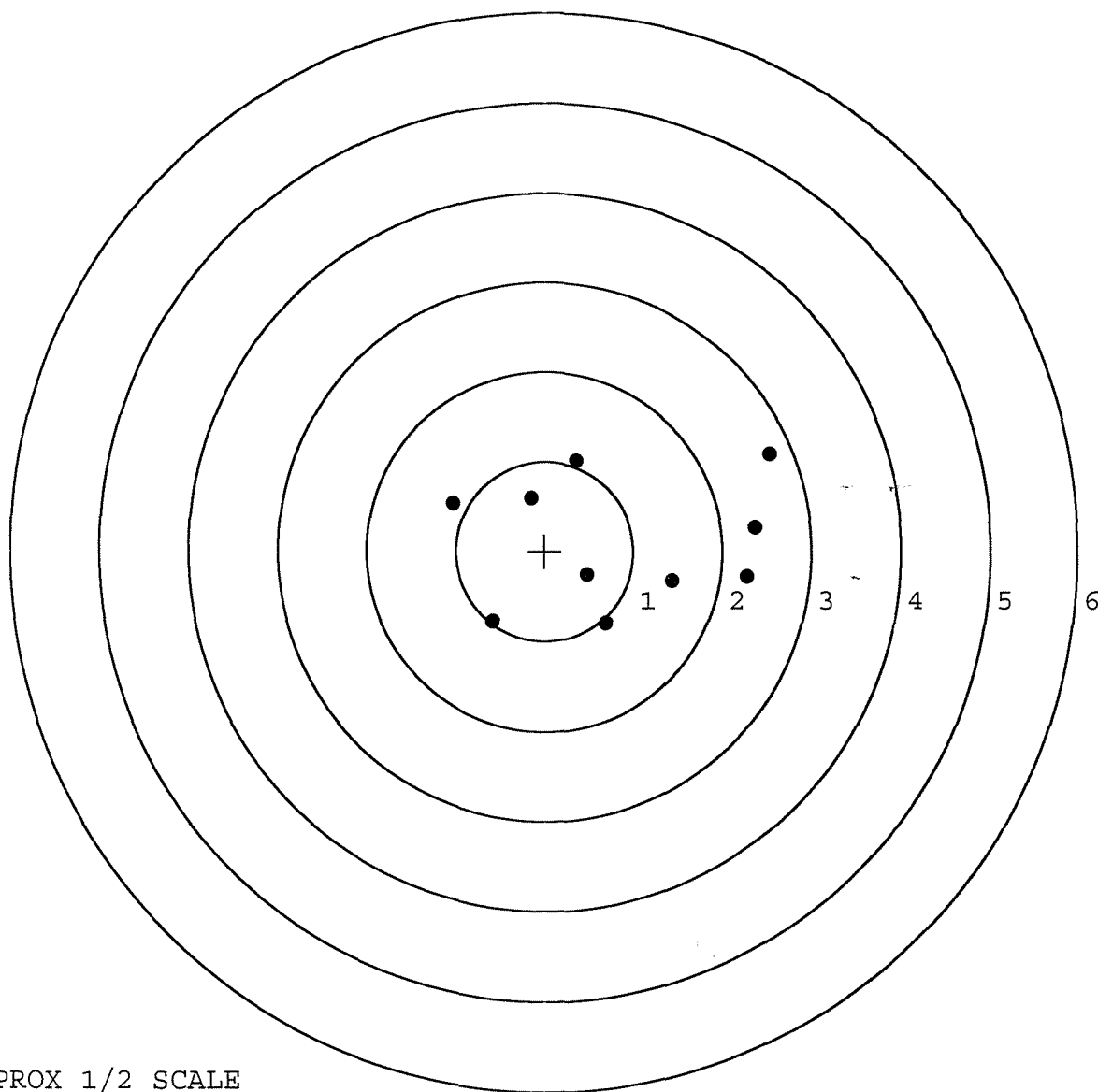
MAX RADIUS: 1.957

MEAN RADIUS: 1.289

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 6

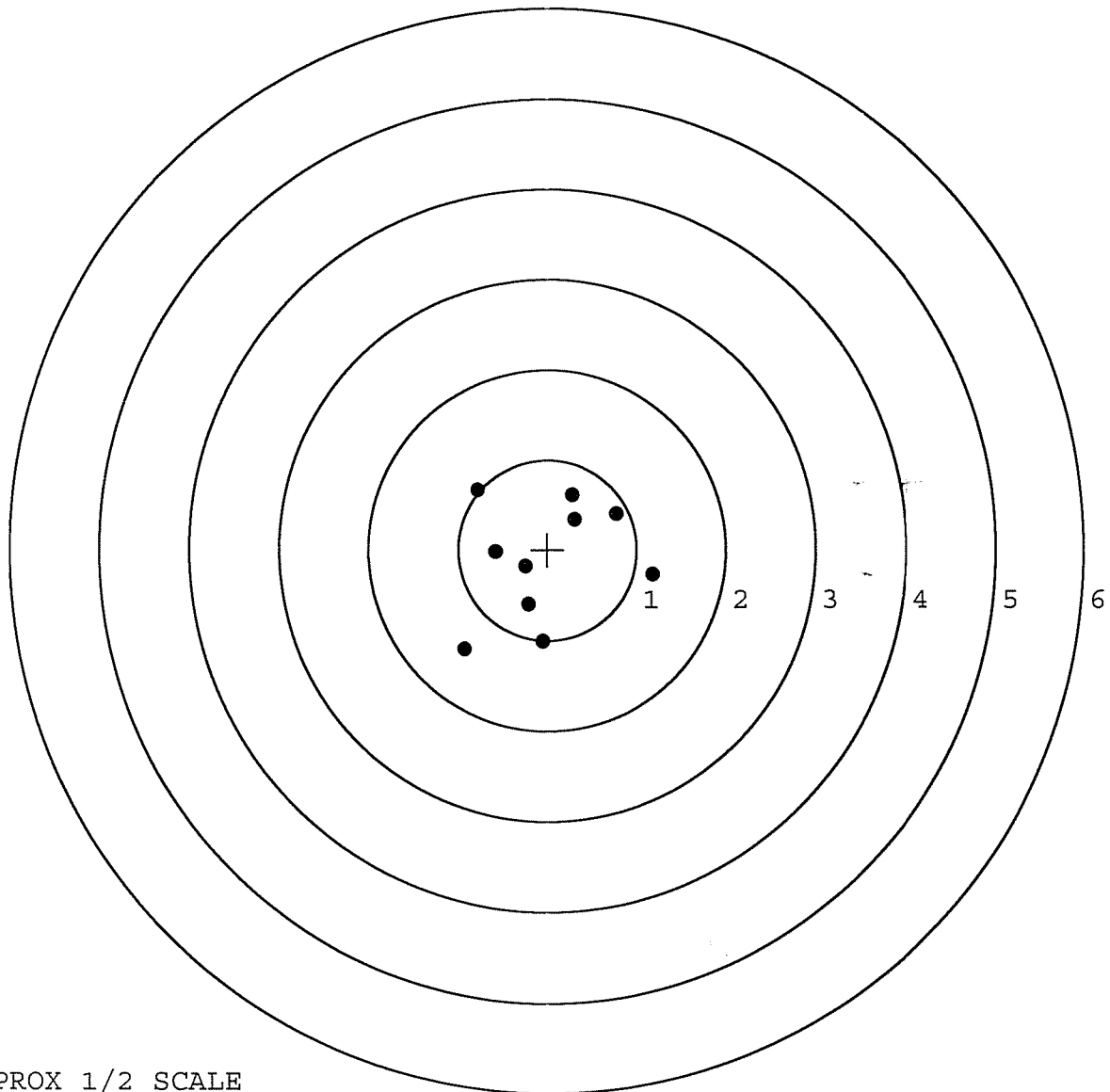


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. __0
 TARGET NUMBER: 5
 FILE DATE: 10/18/2005
 FILE TIME: 09:38

X CENTROID: -0.029
 Y CENTROID: -0.122
 POA TO CENTROID: 0.125
 HORZ SPREAD: 2.108
 VERT SPREAD: 1.766
 GROUP SPREAD: 2.267
 MIN RADIUS: 0.229
 MAX RADIUS: 1.330
 MEAN RADIUS: 0.815
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.181	-0.274
2:	-0.054	-1.019
3:	-0.219	-0.607
4:	-0.927	-1.103
5:	-0.247	-0.190
6:	-0.584	-0.032
7:	0.302	0.336
8:	0.274	0.607
9:	0.768	0.403
10:	-0.781	0.663



TARGET APPROX 1/2 SCALE