

G-6# 1657

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



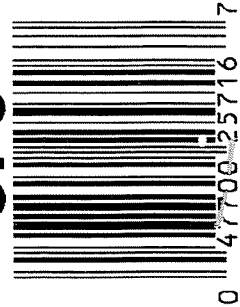
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6461657

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

UPC



SERIAL NO.



6/17/2005 2:12:04 PM

Original
24
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 #

G6461657

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RJL
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RJL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
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	CB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	W7
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	WTH
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	WTH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	WTH
	D) OIL FIRING PIN ASSEMBLY		10-5-05	
	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>2 lbs</u>	<u>2 lbs</u>	<u>2 lbs</u>	10-12-05	Ac
CONT.						
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u>	<u>2 lbs</u>	<u>2 lbs</u>	10-12-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT .020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	10-12-05	Ac
	J) ASSEMBLE STOCK				10-5-05	RT
	K) ASSEMBLE SWIVEL STUDS				10-12-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				10-5-05	RT
	M) IRON SIGHT ALIGNMENT				10-5-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				10-5-05	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u>	FAIL		10/5/05	MJP
		PASS	FAIL			
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
	MALFUNCTION	CORRECTION				
660	INSPECT FOR LIVE AMMO				10-5/05	MJM
670	FINAL INSPECTION A) HEADSPACE				10-12-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.65</u>	<u>2.51</u>	<u>2.65</u>	10-10-05	BC
	C) FUNCTION				10-12-05	Ac
690	PACK				10-10-05	RA

BARBER - M24 0154395

 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

9-28-05

TESTER

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.63	2.24	2.60	
PULL #2	2.33	2.71	2.36	
PULL #3	2.59	2.62	2.57	
PULL #4	2.60	2.35	2.35	
PULL #5	2.74	2.42	2.36	
TOTAL	12.89	12.34	12.24	
AVERAGE	2.57	2.46	2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.41	3.05	
PULL #2	2.90	3.05	
PULL #3	3.18	2.96	
PULL #4	2.96	2.97	
PULL #5	3.27	3.20	
TOTAL	15.72	15.23	
AVERAGE	3.14	3.04	

	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	4.16	4.22		4.30
PULL #2	4.21	3.86		4.25
PULL #3	4.41	3.88		4.42
PULL #4	4.32	4.26		4.43
PULL #5	4.28	4.27		4.26
TOTAL	21.38	20.49		21.66
AVERAGE	4.27	4.09		4.33

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461657.___1
FILE DATE AND TIME: 10/05/2005 18:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.177
The Average Y Centroid of the Five Target Set:	-0.065
The Average Point of Impact of the Five Target Set:	0.188
The Average Mean Radius of the Five Target Set:	0.904
The Distance from POA to Centroid Target #1:	0.597
The Distance from Centroid Target #2 to Centroid Target #1:	0.426
The Distance from Centroid Target #3 to Centroid Target #1:	0.676
The Distance from Centroid Target #4 to Centroid Target #1:	0.515
The Distance from Centroid Target #5 to Centroid Target #1:	0.529

SERIAL NUMBER: G6461657. 1

TARGET NUMBER: 1

FILE DATE: 10/05/2005

FILE TIME: 18:48

X CENTROID: 0.583

Y CENTROID: -0.129

POA TO CENTROID: 0.597

HORZ SPREAD: 2.892

VERT SPREAD: 1.504

GROUP SPREAD: 2.953

MIN RADIUS: 0.149

MAX RADIUS: 1.575

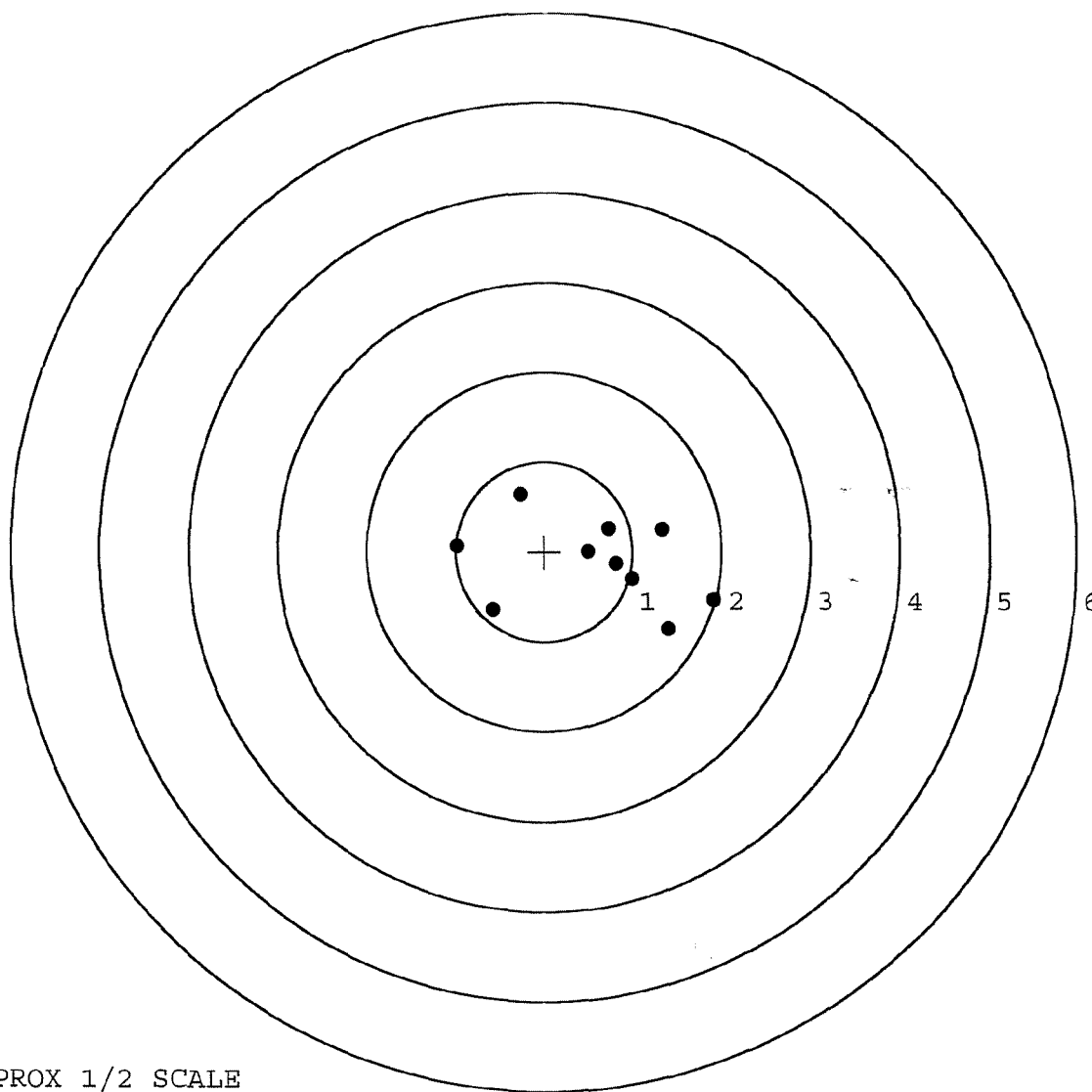
MEAN RADIUS: 0.859

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.497	-0.006
2:	0.722	0.263
3:	0.997	-0.306
4:	1.330	0.250
5:	-0.588	-0.653
6:	-0.278	0.638
7:	-0.981	0.062
8:	1.403	-0.866
9:	1.911	-0.537
10:	0.812	-0.131



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461657. 1

TARGET NUMBER: 2

FILE DATE: 10/05/2005

FILE TIME: 18:48

X CENTROID: 0.196

Y CENTROID: 0.050

POA TO CENTROID: 0.202

HORZ SPREAD: 2.117

VERT SPREAD: 2.521

GROUP SPREAD: 2.848

MIN RADIUS: 0.256

MAX RADIUS: 1.668

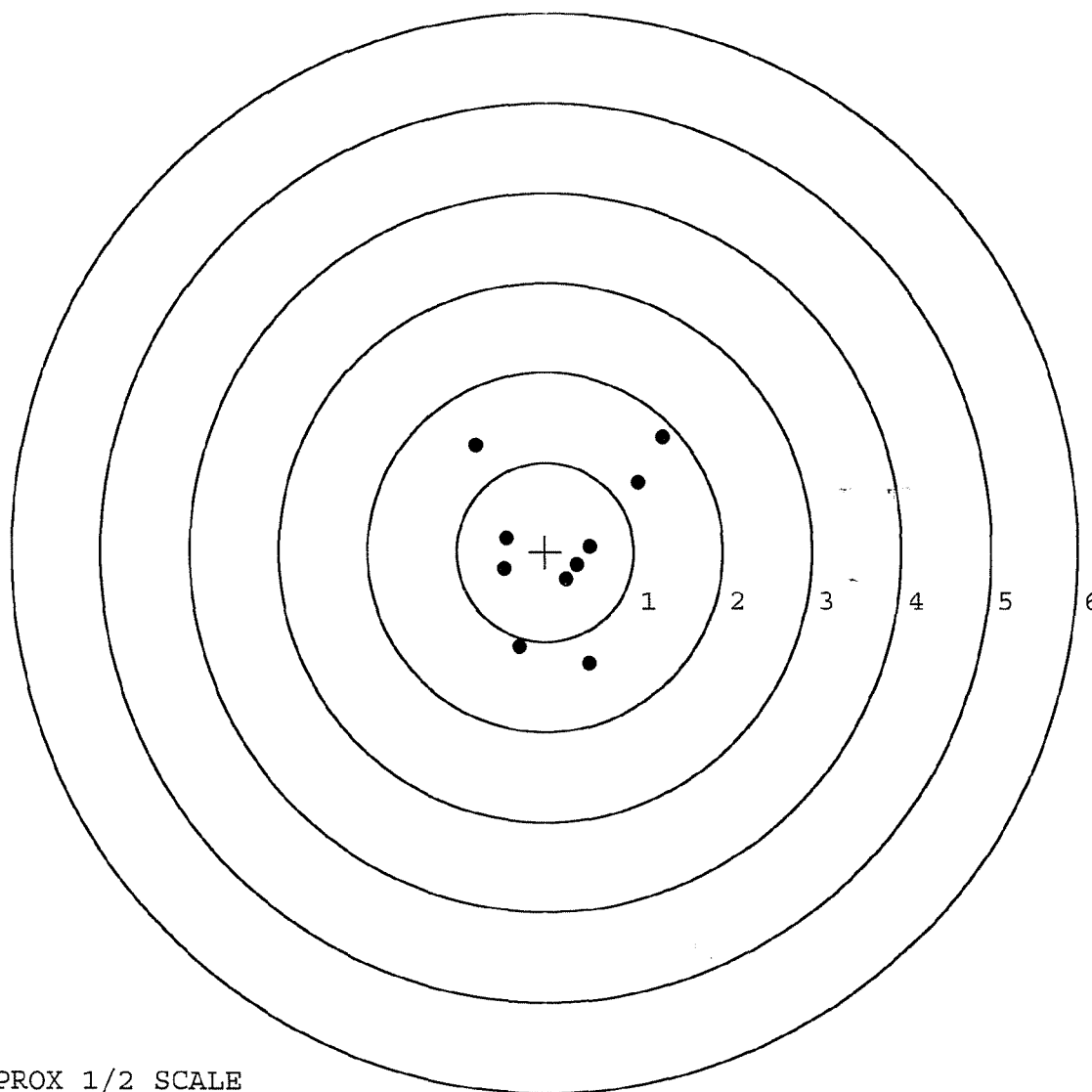
MEAN RADIUS: 0.913

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.300	-1.061
2:	0.495	-1.242
3:	0.234	-0.312
4:	0.355	-0.151
5:	0.505	0.064
6:	-0.441	0.148
7:	-0.471	-0.194
8:	1.049	0.777
9:	1.324	1.279
10:	-0.793	1.191



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461657. 1

TARGET NUMBER: 3

FILE DATE: 10/05/2005

FILE TIME: 18:48

X CENTROID: -0.043

Y CENTROID: 0.127

POA TO CENTROID: 0.134

HORZ SPREAD: 2.581

VERT SPREAD: 2.567

GROUP SPREAD: 3.226

MIN RADIUS: 0.333

MAX RADIUS: 1.722

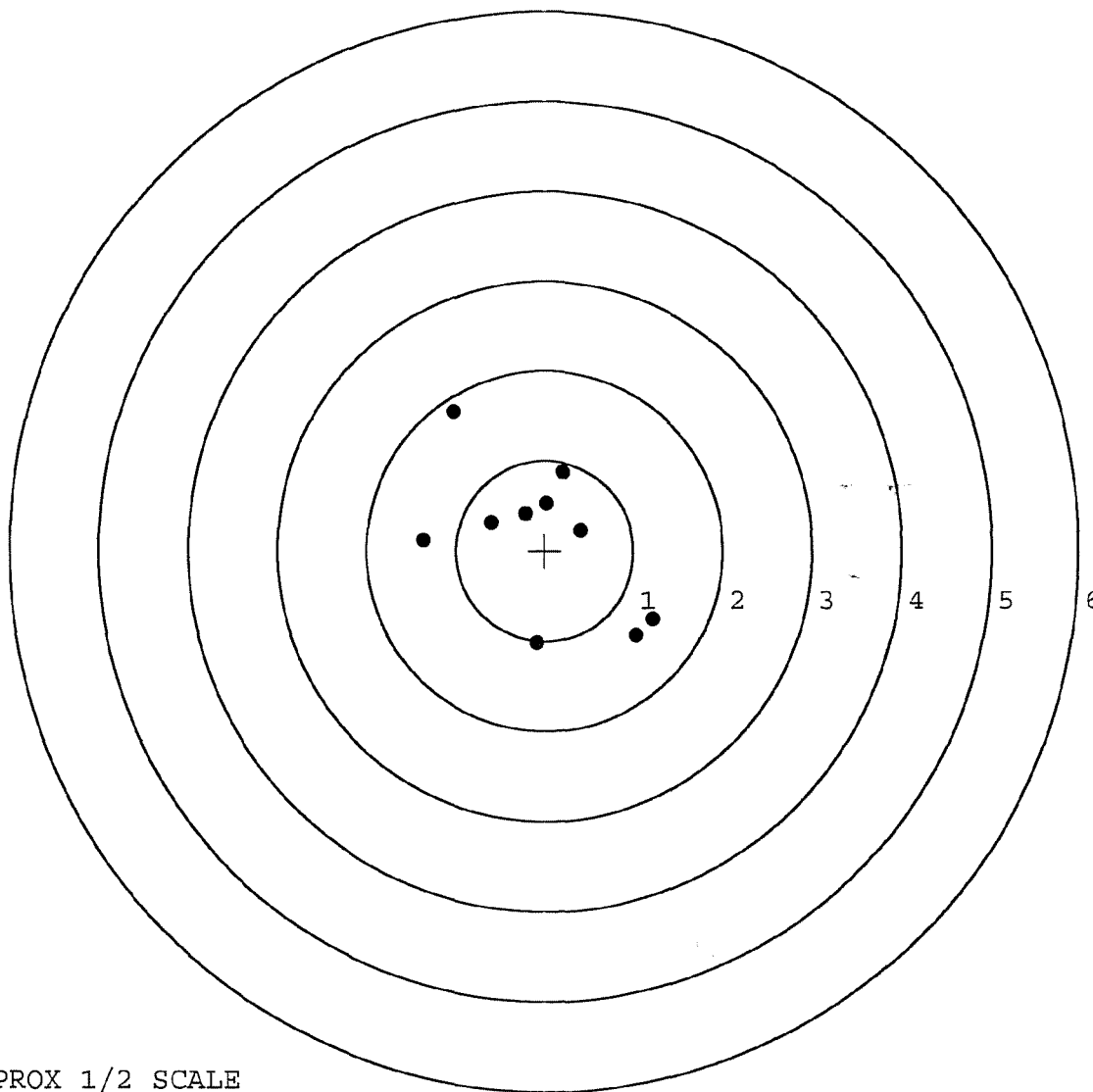
MEAN RADIUS: 0.984

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.088	-1.029
2:	1.032	-0.942
3:	1.218	-0.765
4:	0.413	0.232
5:	0.015	0.525
6:	-0.608	0.316
7:	0.201	0.871
8:	-1.031	1.538
9:	-1.363	0.117
10:	-0.224	0.407



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461657. __1

TARGET NUMBER: 4

FILE DATE: 10/05/2005

FILE TIME: 18:48

X CENTROID: 0.070

Y CENTROID: -0.079

POA TO CENTROID: 0.105

HORZ SPREAD: 2.370

VERT SPREAD: 2.179

GROUP SPREAD: 2.551

MIN RADIUS: 0.659

MAX RADIUS: 1.391

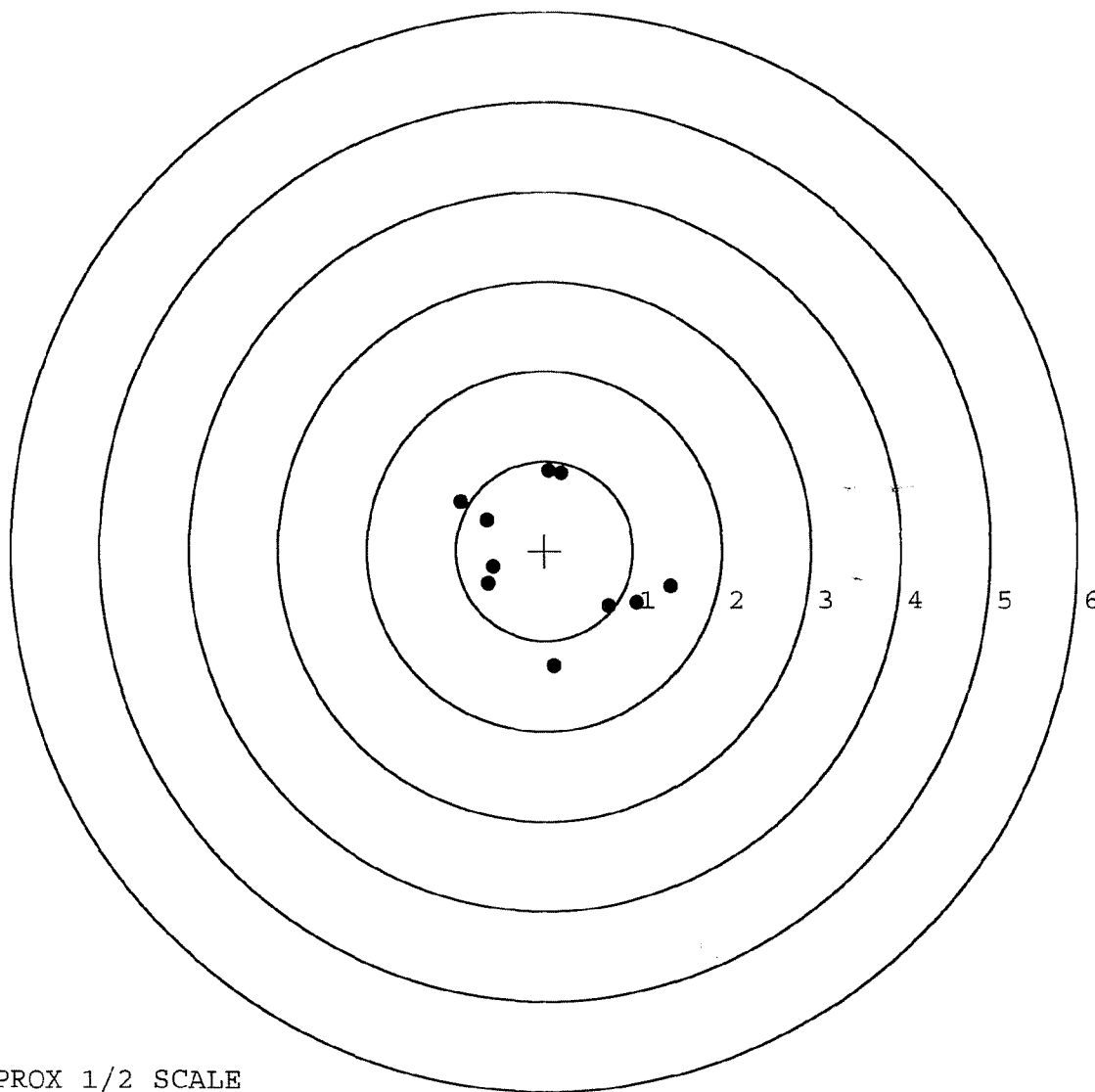
MEAN RADIUS: 0.993

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.638	-0.367
2:	-0.581	-0.181
3:	-0.657	0.338
4:	-0.947	0.541
5:	0.044	0.897
6:	0.182	0.872
7:	0.722	-0.620
8:	1.044	-0.586
9:	1.423	-0.403
10:	0.106	-1.282



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461657. __1

TARGET NUMBER: 5

FILE DATE: 10/05/2005

FILE TIME: 18:48

X CENTROID: 0.080

Y CENTROID: -0.294

POA TO CENTROID: 0.304

HORZ SPREAD: 2.995

VERT SPREAD: 1.350

GROUP SPREAD: 3.005

MIN RADIUS: 0.101

MAX RADIUS: 1.964

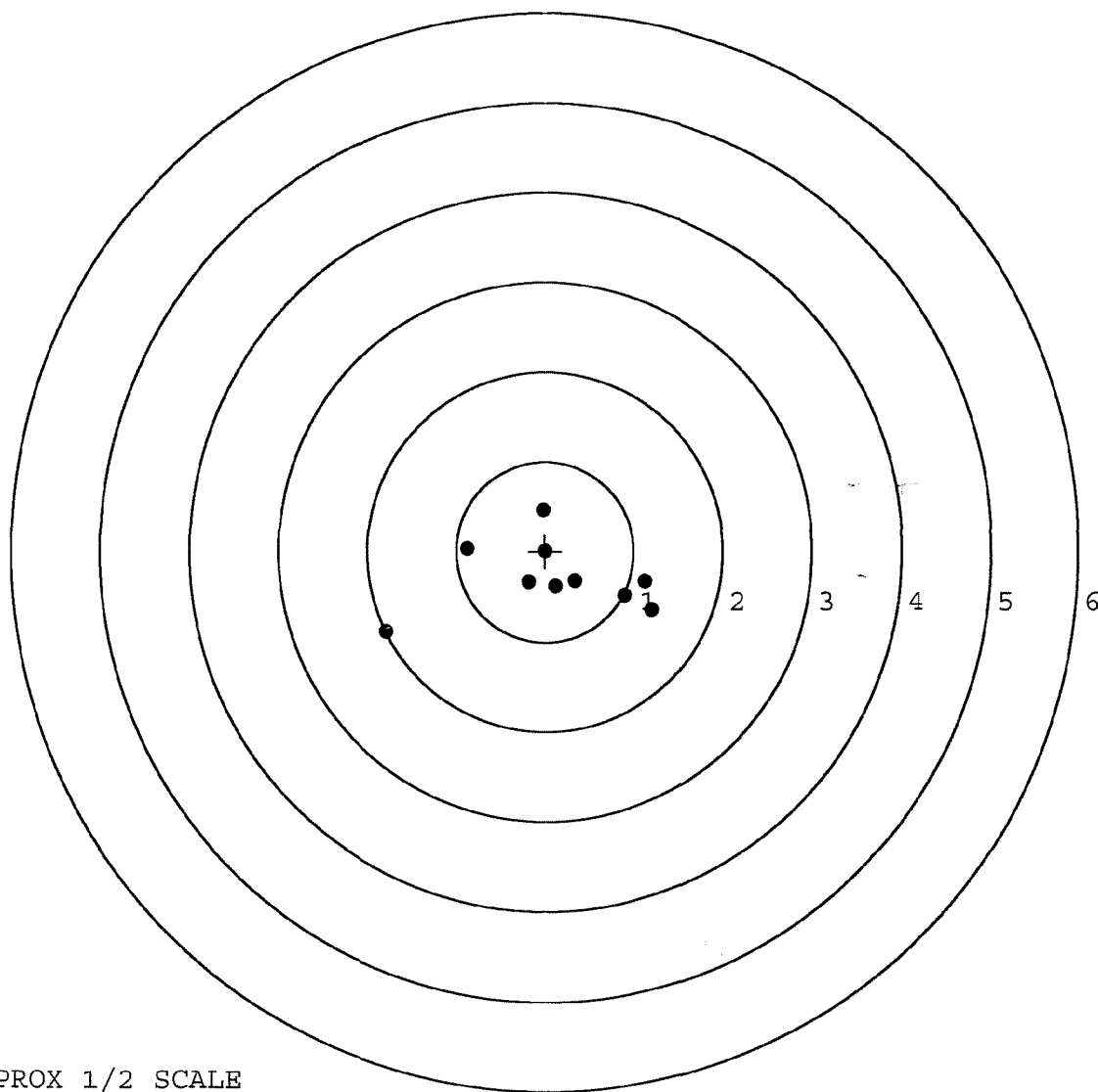
MEAN RADIUS: 0.774

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.002	0.000
2:	-1.791	-0.891
3:	-0.880	0.028
4:	-0.187	-0.340
5:	0.118	-0.387
6:	0.337	-0.332
7:	0.895	-0.487
8:	1.204	-0.649
9:	1.128	-0.337
10:	-0.030	0.459



TARGET APPROX 1/2 SCALE