

G 646 16 72

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



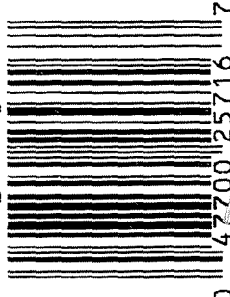
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461672

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.



4/7/2005 2:48:09 PM

Crib

01

Original

25716

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



.MA25716

Shop Order: SW5716 - APR



.ABSW5716 - APR

Start Date: 3/11/2005

Finish Date: 4/14/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0003858612

0540

01PC001

Flat Black Powder Coat, Barrel and



0003858602

0560

89SWS1

Reassemble Action.



0003858603

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461672

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTL
600	PROOF		4-18-05	Ac
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-18-05	Ac
610	DIS-ASSEMBLE GUN		4-18-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 20 2005 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRW
620	APPLY COATINGS (BARREL ACTION)		5-6-05	WJ
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-05	RTL
	D) OIL FIRING PIN ASSEMBLY		5-17-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7 lbs</u> <u>7 lbs</u> <u>7 lbs</u>	5-23-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		5-23-05	AC
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-23-05	AC
	J) ASSEMBLE STOCK		5-17-05	RTL
	K) ASSEMBLE SWIVEL STUDS		5-23-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-17-05	RTL
	M) IRON SIGHT ALIGNMENT		5-17-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-17-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-18-05	AC
	MALFUNCTION	CORRECTION	X	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-18-05	TRW
655	FINAL INSPECTION A) HEADSPACE		5-23-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.90</u> <u>2.94</u> <u>2.89</u> <u>2.98</u> <u>2.89</u>	5-20-05	AC
	C) FUNCTION		5-23-05	A
660	PACK		5-23-05	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 5-16-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.53	2.63		2.58	
PULL #2	2.78	2.57		2.43	
PULL #3	2.82	2.50		2.38	
PULL #4	2.73	2.36		2.35	
PULL #5	2.80	2.47		2.43	
TOTAL	13.66	12.53		12.17	
AVERAGE	2.73	2.50		2.43	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.62		
PULL #2	3.56	3.42		
PULL #3	3.44	3.38		
PULL #4	3.48	3.43		
PULL #5	3.49	3.40		
TOTAL	17.43	17.25		
AVERAGE	3.48	3.45		

	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	4.39		4.14
PULL #2	4.39	4.42		4.19
PULL #3	4.31	4.38		4.12
PULL #4	4.45	4.24		4.39
PULL #5	4.44	4.38		4.33
TOTAL	21.89	21.81		21.17
AVERAGE	4.37	4.36		4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461672.___0
FILE DATE AND TIME: 05/18/2005 10:21

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.111
The Average Y Centroid of the Five Target Set:	0.129
The Average Point of Impact of the Five Target Set:	0.170
The Average Mean Radius of the Five Target Set:	0.908
The Distance from POA to Centroid Target #1:	0.140
The Distance from Centroid Target #2 to Centroid Target #1:	0.249
The Distance from Centroid Target #3 to Centroid Target #1:	0.133
The Distance from Centroid Target #4 to Centroid Target #1:	0.329
The Distance from Centroid Target #5 to Centroid Target #1:	0.306

SERIAL NUMBER: G6461672. 0

TARGET NUMBER: 1

FILE DATE: 05/18/2005

FILE TIME: 10:21

X CENTROID: -0.132

Y CENTROID: -0.045

POA TO CENTROID: 0.140

HORZ SPREAD: 1.684

VERT SPREAD: 2.587

GROUP SPREAD: 2.809

MIN RADIUS: 0.433

MAX RADIUS: 1.513

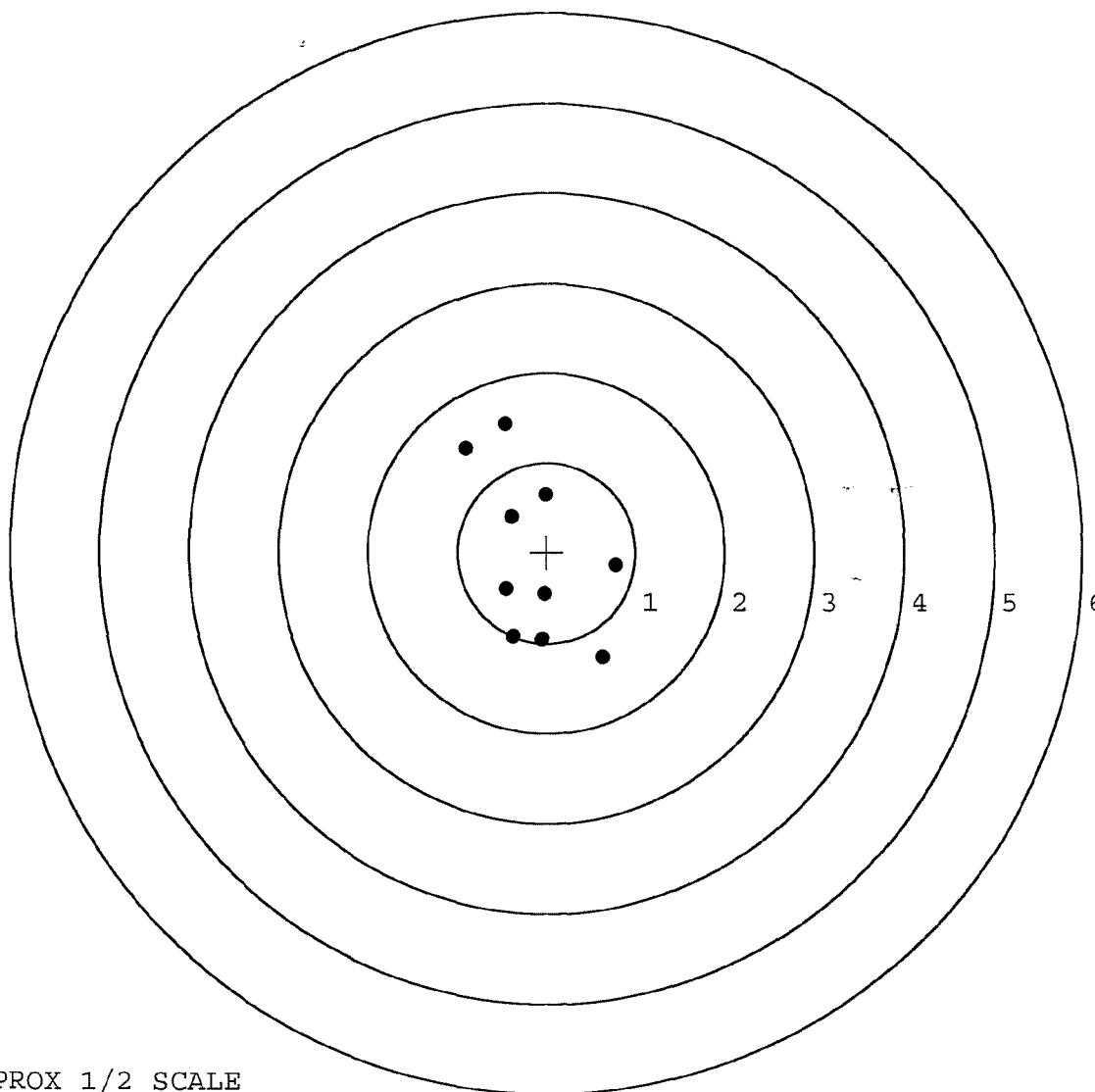
MEAN RADIUS: 0.919

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.017	0.646
2:	-0.403	0.396
3:	0.777	-0.146
4:	-0.029	-0.465
5:	-0.464	-0.412
6:	-0.383	-0.931
7:	-0.057	-0.964
8:	0.627	-1.156
9:	-0.467	1.431
10:	-0.907	1.154



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461672. 0

TARGET NUMBER: 2

FILE DATE: 05/18/2005

FILE TIME: 10:21

POINT#	X	Y
1:	-0.639	1.513
2:	-0.360	0.728
3:	-0.165	0.608
4:	0.361	0.378
5:	0.580	-0.116
6:	0.385	-0.135
7:	0.275	-0.147
8:	-0.236	-0.742
9:	0.311	-1.723
10:	0.357	0.367

X CENTROID: 0.087

Y CENTROID: 0.073

POA TO CENTROID: 0.114

HORZ SPREAD: 1.219

VERT SPREAD: 3.236

GROUP SPREAD: 3.373

MIN RADIUS: 0.290

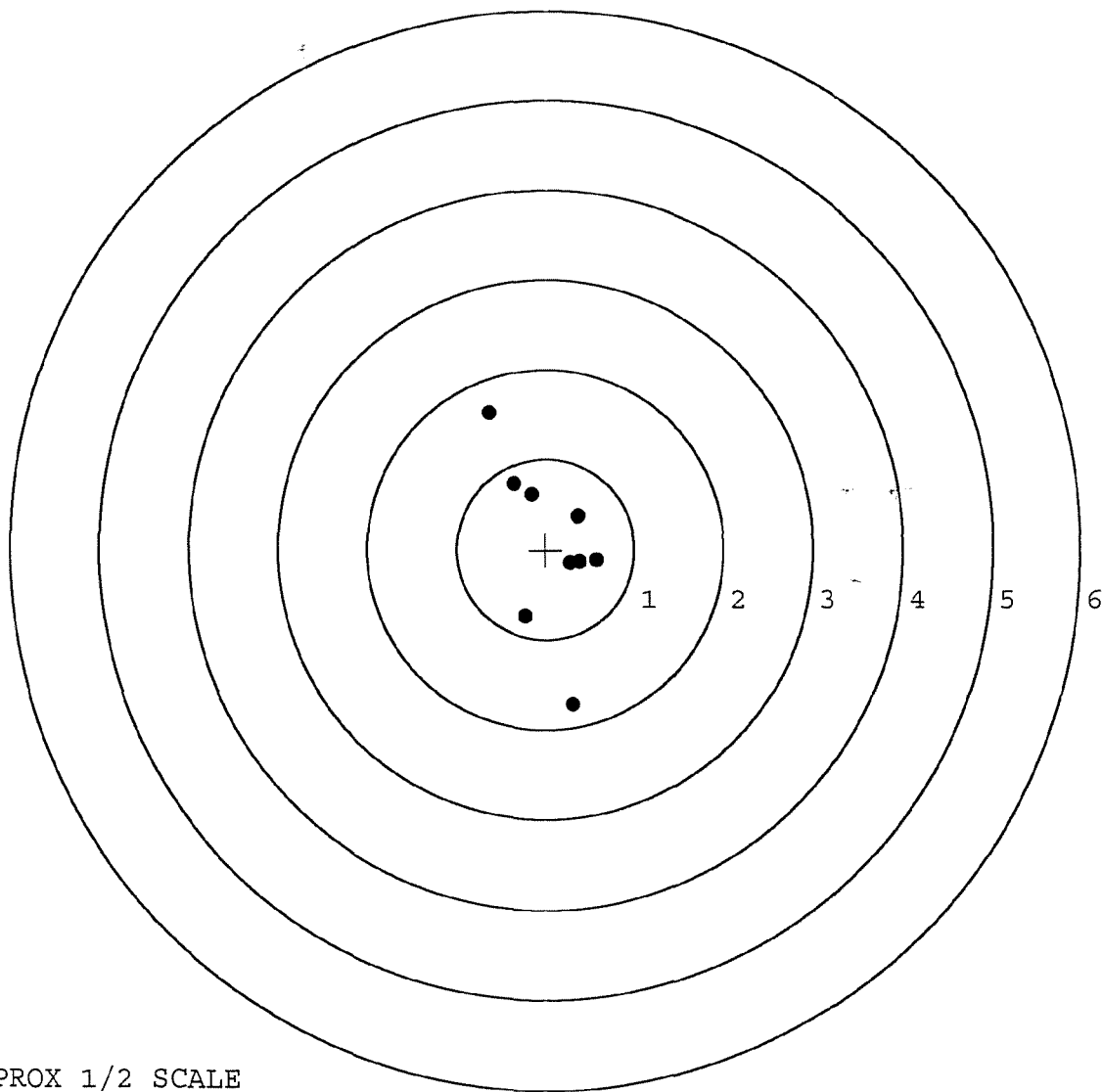
MAX RADIUS: 1.810

MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461672. 0

TARGET NUMBER: 3

FILE DATE: 05/18/2005

FILE TIME: 10:21

POINT#	X	Y
1:	-0.845	1.414
2:	-0.488	1.728
3:	0.446	1.205
4:	0.489	0.662
5:	-0.445	-0.297
6:	-0.640	-0.736
7:	-0.355	-0.836
8:	0.107	-0.604
9:	0.202	-1.496
10:	-0.365	-0.285

X CENTROID: -0.189

Y CENTROID: 0.076

POA TO CENTROID: 0.204

HORZ SPREAD: 1.334

VERT SPREAD: 3.224

GROUP SPREAD: 3.297

MIN RADIUS: 0.401

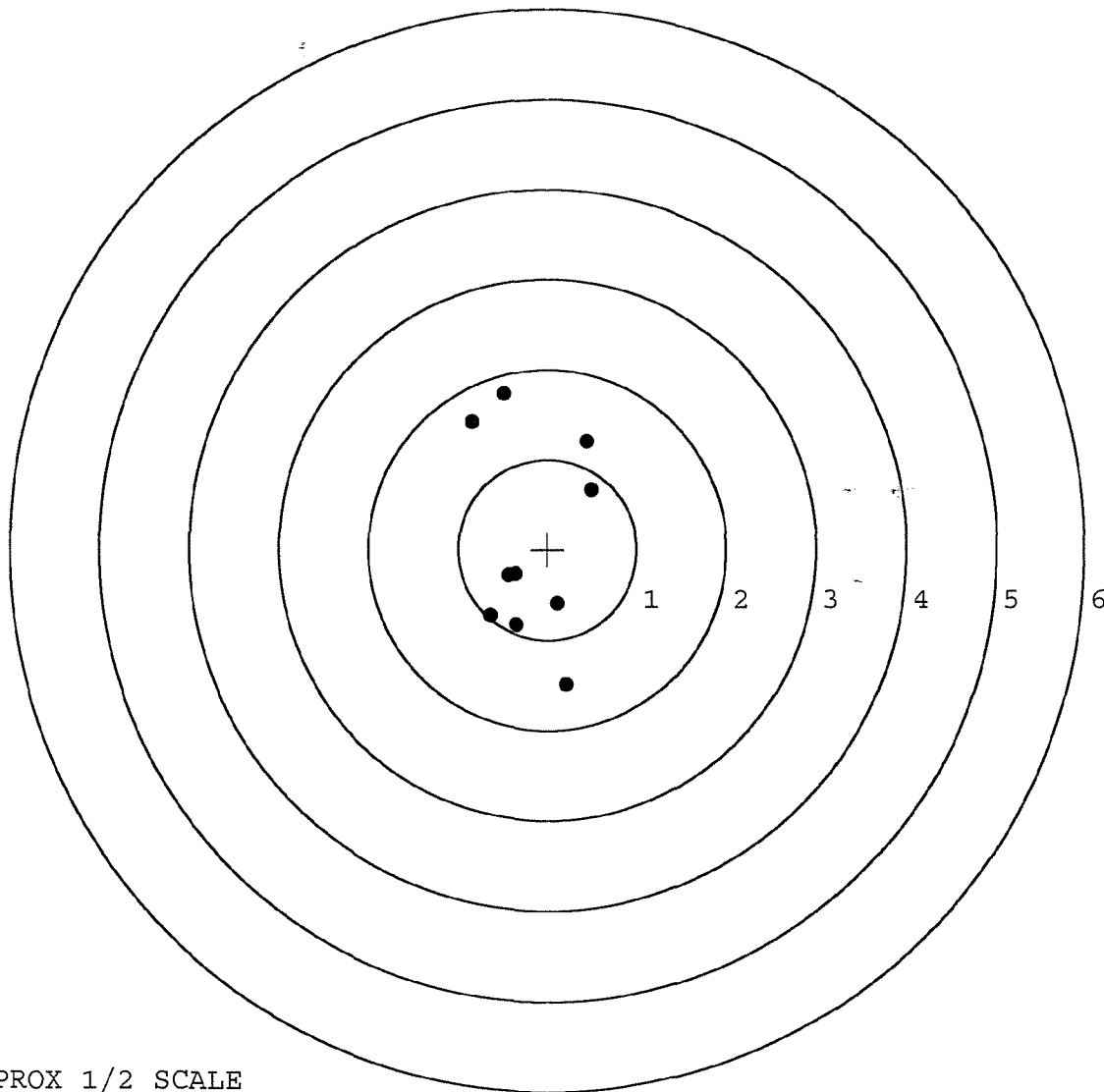
MAX RADIUS: 1.679

MEAN RADIUS: 1.043

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461672. 0

TARGET NUMBER: 4

FILE DATE: 05/18/2005

FILE TIME: 10:21

X CENTROID: -0.150

Y CENTROID: 0.283

POA TO CENTROID: 0.321

HORZ SPREAD: 2.324

VERT SPREAD: 2.887

GROUP SPREAD: 2.887

MIN RADIUS: 0.241

MAX RADIUS: 1.611

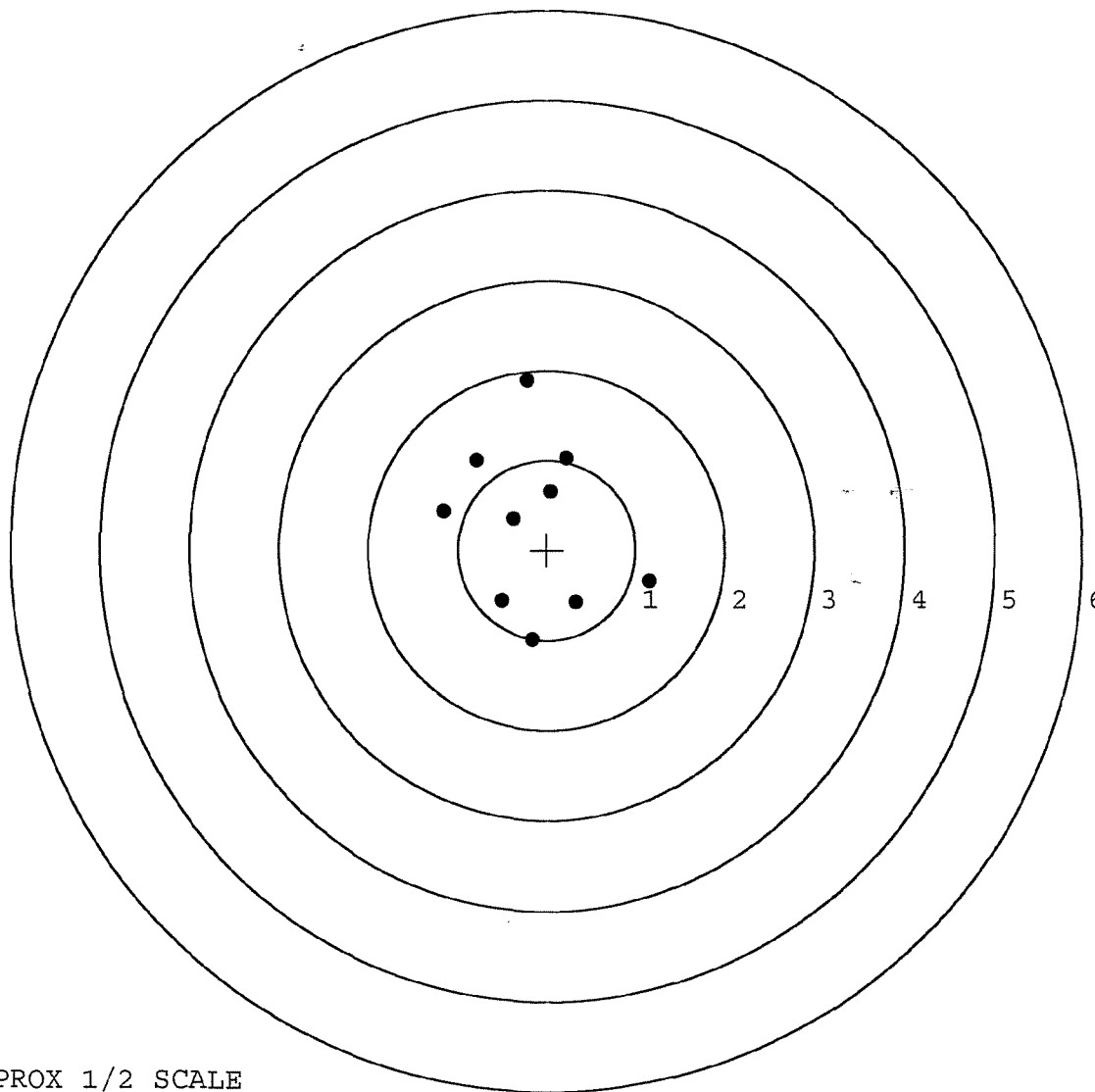
MEAN RADIUS: 0.973

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.220	1.893
2:	-0.791	0.995
3:	-1.165	0.428
4:	-0.382	0.349
5:	0.034	0.652
6:	0.218	1.026
7:	1.159	-0.357
8:	0.325	-0.586
9:	-0.168	-0.994
10:	-0.513	-0.572

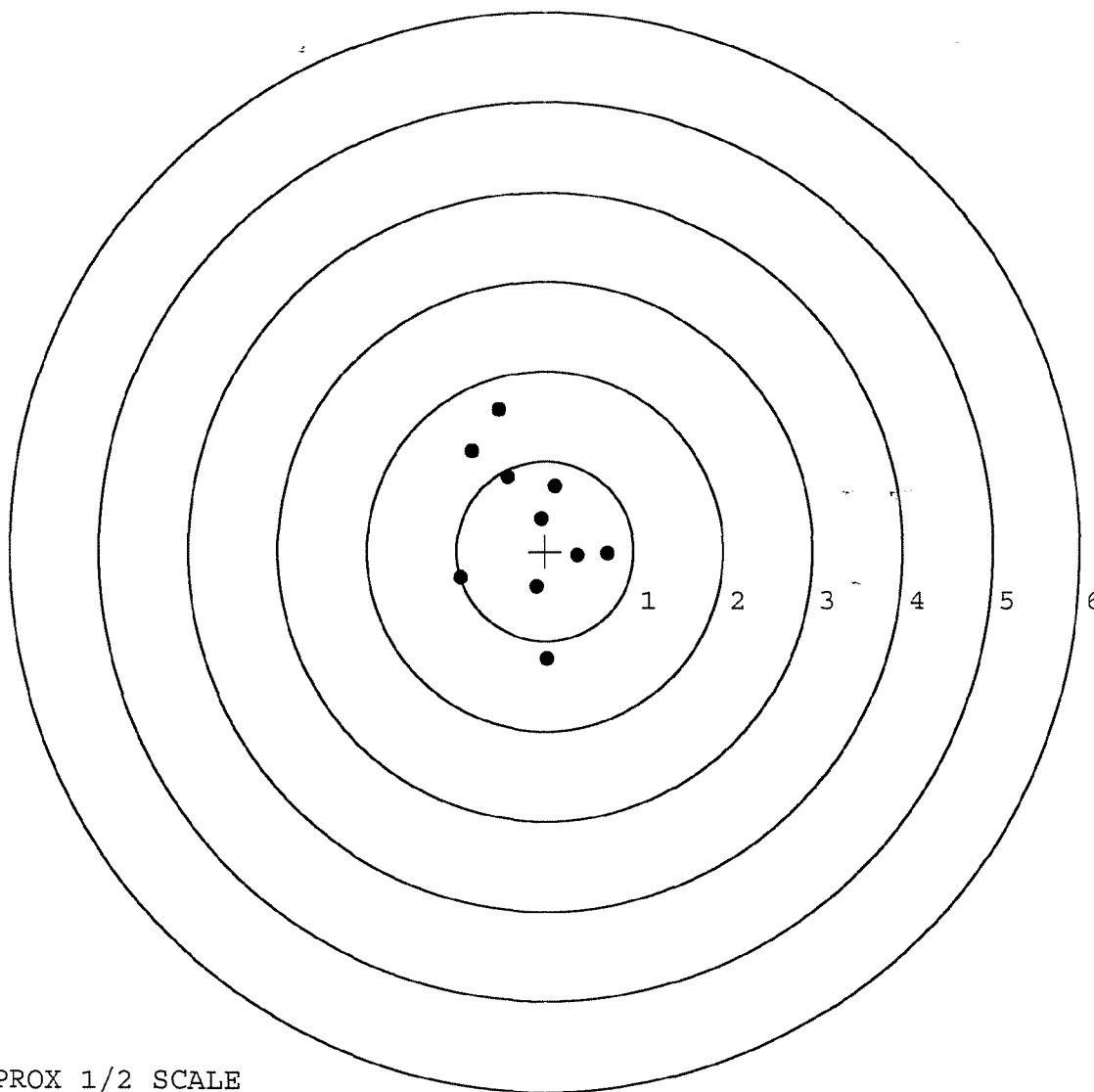


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461672. __0
 TARGET NUMBER: 5
 FILE DATE: 05/18/2005
 FILE TIME: 10:21

X CENTROID: -0.168
 Y CENTROID: 0.259
 POA TO CENTROID: 0.309
 HORZ SPREAD: 1.654
 VERT SPREAD: 2.764
 GROUP SPREAD: 2.817
 MIN RADIUS: 0.156
 MAX RADIUS: 1.473
 MEAN RADIUS: 0.837
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.822	1.105
2:	-0.526	1.562
3:	-0.427	0.825
4:	0.111	0.725
5:	-0.053	0.364
6:	0.363	-0.053
7:	0.705	-0.032
8:	-0.103	-0.397
9:	-0.949	-0.306
10:	0.017	-1.202



TARGET APPROX 1/2 SCALE