

G-6461684

6/17/2005 2:12:04 PM

Crib

14

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

Goff Blast Barrel & Rec Assembly,

78ROT01



0004012773

0540

Flat Black Powder Coat, Barrel and

01PC001



0004012763

0560

Reassemble Action.

89SWS1



0004012764

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

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.



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



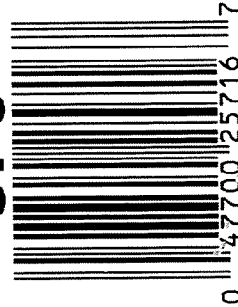
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6461684

UPC



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G60461684

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-14-05	RTZ
440	PROOF		9-20-05	RTZ
460	CHECK HEADSPACE		9-20-05	RTZ
470	DIS-ASSEMBLE ACTION		9-21-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 <i>unus</i>	9/23/05	<i>unus</i>
500	ROLLMARK CALIBER		9-23-05	CW
510	DRILL AND TAP SIGHT HOLES		9-23-05	TRW
520	GOFF BLAST BBL / REC		9-26-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		10/4/05	EB
	(BOLT)		10/4/05	EB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		10/6/05	mom
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/6/05	mom
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/6/05	mom
	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>6 lbs</u> <u>6 lbs</u> <u>5 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>.022</u> <u>.022</u> <u>.023</u>	10-12-05	AC
	J) ASSEMBLE STOCK		10-11-05	RT
	K) ASSEMBLE SWIVEL STUDS		10-12-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-11-05	BC-
	M) IRON SIGHT ALIGNMENT		10-11-05	BC-
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-11-05	BC-
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	10-12-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-12-05	ST
670	FINAL INSPECTION A) HEADSPACE		10-12-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.37</u> <u>2.37</u> <u>2.35</u> <u>2.43</u> <u>2.47</u>	10-12-05	BC-
	C) FUNCTION		10-12-05	AC
690	PACK		10-15-05	RA

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

9/29/05

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.36	2.23		2.09	
PULL #2	2.35	2.46		2.72	
PULL #3	2.58	2.42		2.46	
PULL #4	2.43	2.28		2.52	
PULL #5	2.35	2.36		2.51	
TOTAL	12.07	11.75		12.30	
AVERAGE	2.41	2.35		2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	2.82		
PULL #2	3.09	2.99		
PULL #3	3.76	2.97		
PULL #4	3.05	3.21		
PULL #5	3.07	2.86		
TOTAL	15.65	14.85		
AVERAGE	3.13	2.97		

	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	4.29	3.79		4.25
PULL #2	4.06	4.03		4.23
PULL #3	4.10	3.55		4.36
PULL #4	3.87	3.78		4.21
PULL #5	4.31	3.72		4.38
TOTAL	20.63	18.87		21.43
AVERAGE	4.13	3.77		4.29

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461684.___0
FILE DATE AND TIME: 10/12/2005 10:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.011
The Average Y Centroid of the Five Target Set:	0.138
The Average Point of Impact of the Five Target Set:	0.139
The Average Mean Radius of the Five Target Set:	0.791
The Distance from POA to Centroid Target #1:	0.026
The Distance from Centroid Target #2 to Centroid Target #1:	0.349
The Distance from Centroid Target #3 to Centroid Target #1:	0.461
The Distance from Centroid Target #4 to Centroid Target #1:	0.090
The Distance from Centroid Target #5 to Centroid Target #1:	0.195

SERIAL NUMBER: G6461684. __0

TARGET NUMBER: 1

FILE DATE: 10/12/2005

FILE TIME: 10:10

X CENTROID: 0.002

Y CENTROID: 0.026

POA TO CENTROID: 0.026

HORZ SPREAD: 2.288

VERT SPREAD: 2.631

GROUP SPREAD: 3.099

MIN RADIUS: 0.262

MAX RADIUS: 1.630

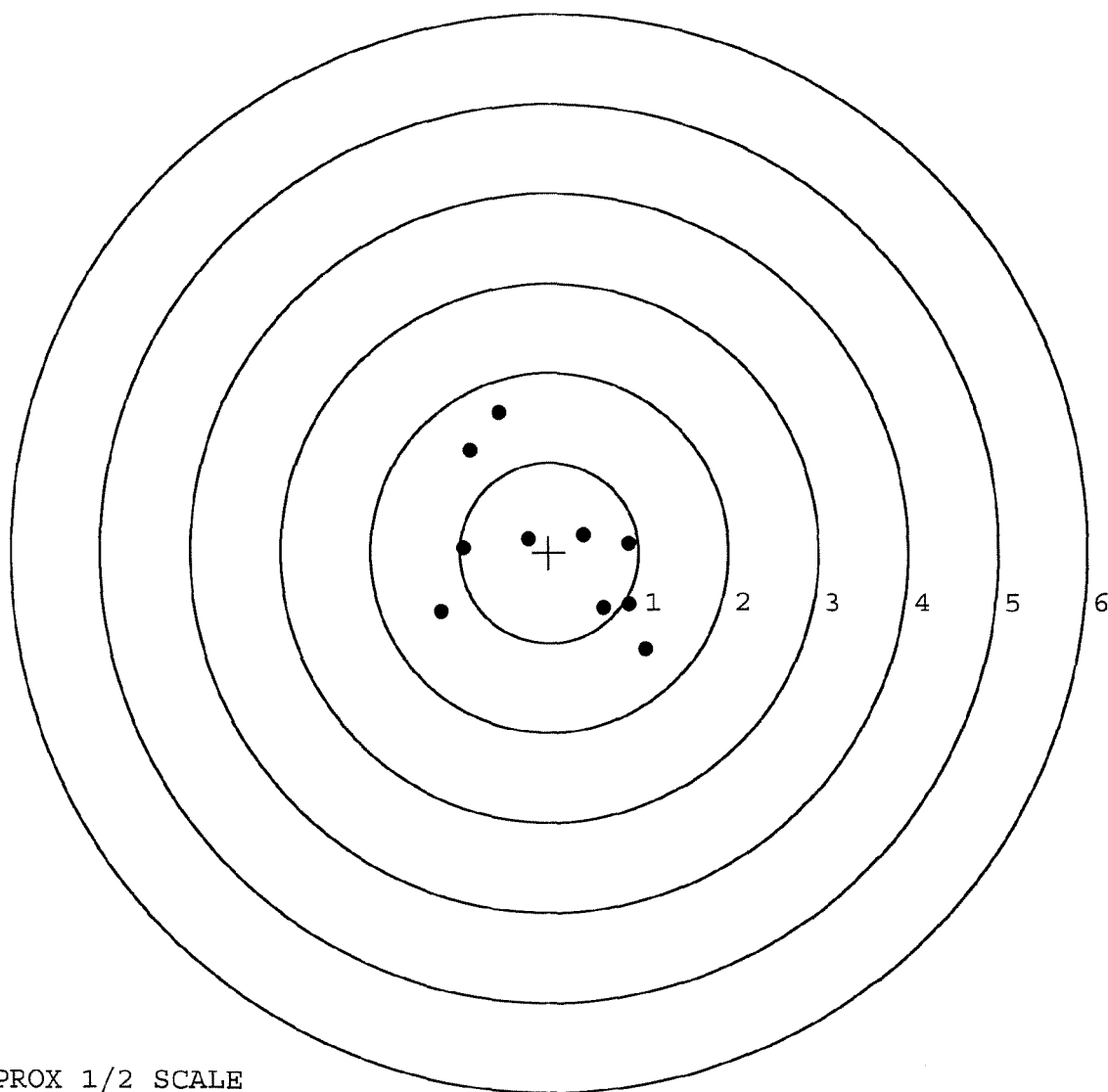
MEAN RADIUS: 1.048

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.078	-1.075
2:	0.898	-0.579
3:	0.613	-0.618
4:	0.889	0.105
5:	0.387	0.199
6:	-0.228	0.151
7:	-0.957	0.050
8:	-1.210	-0.654
9:	-0.887	1.127
10:	-0.560	1.556



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461684. 0

TARGET NUMBER: 2

FILE DATE: 10/12/2005

FILE TIME: 10:10

X CENTROID: 0.111

Y CENTROID: 0.357

POA TO CENTROID: 0.374

HORZ SPREAD: 1.147

VERT SPREAD: 1.936

GROUP SPREAD: 2.250

MIN RADIUS: 0.110

MAX RADIUS: 1.246

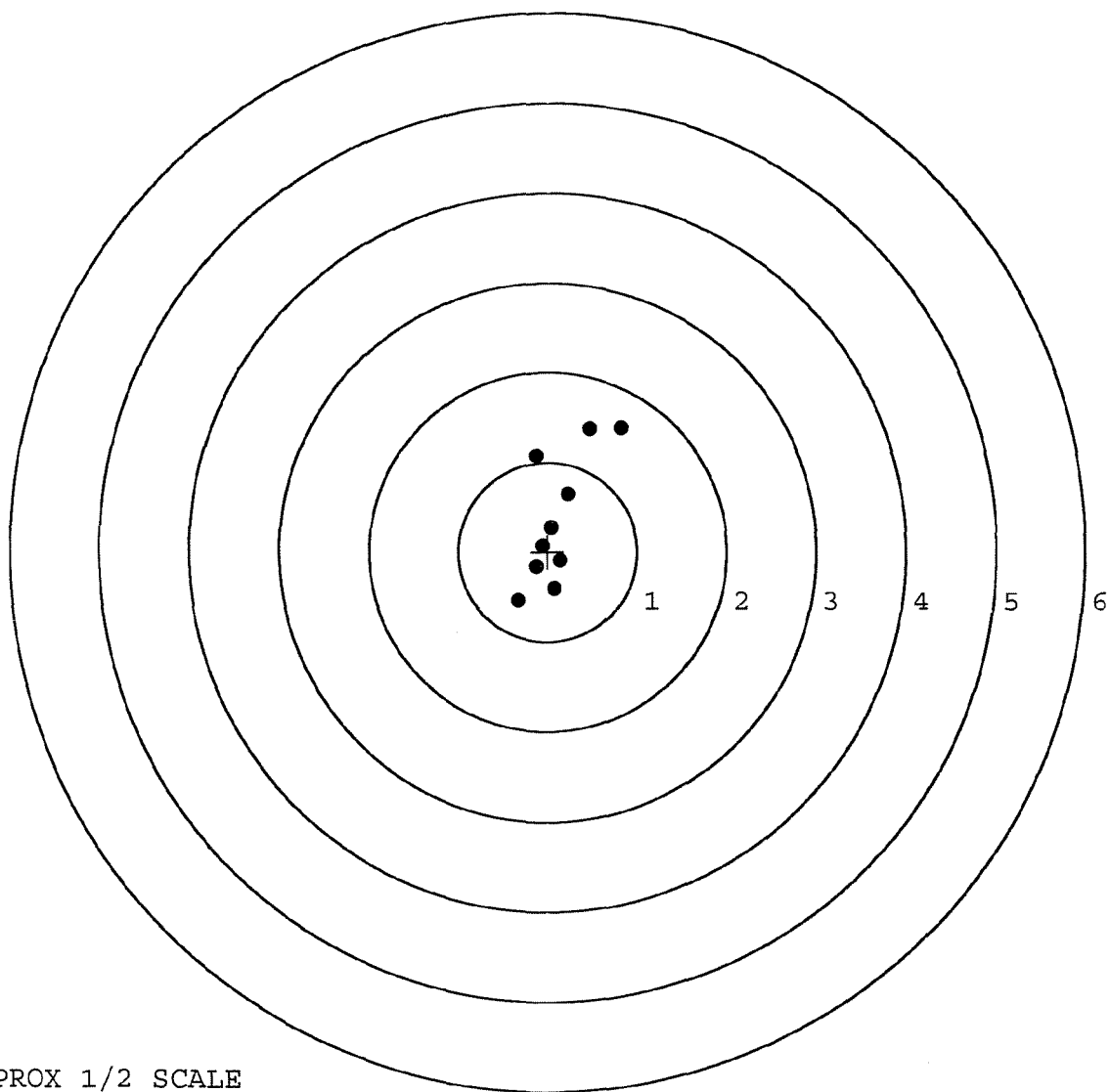
MEAN RADIUS: 0.665

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.814	1.386
2:	0.468	1.370
3:	-0.133	1.071
4:	0.229	0.644
5:	-0.333	-0.550
6:	0.074	-0.416
7:	-0.130	-0.169
8:	0.141	-0.100
9:	-0.057	0.065
10:	0.040	0.273



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461684. 0

TARGET NUMBER: 3

FILE DATE: 10/12/2005

FILE TIME: 10:10

X CENTROID: -0.040

Y CENTROID: 0.485

POA TO CENTROID: 0.487

HORZ SPREAD: 1.446

VERT SPREAD: 3.728

GROUP SPREAD: 3.783

MIN RADIUS: 0.105

MAX RADIUS: 2.802

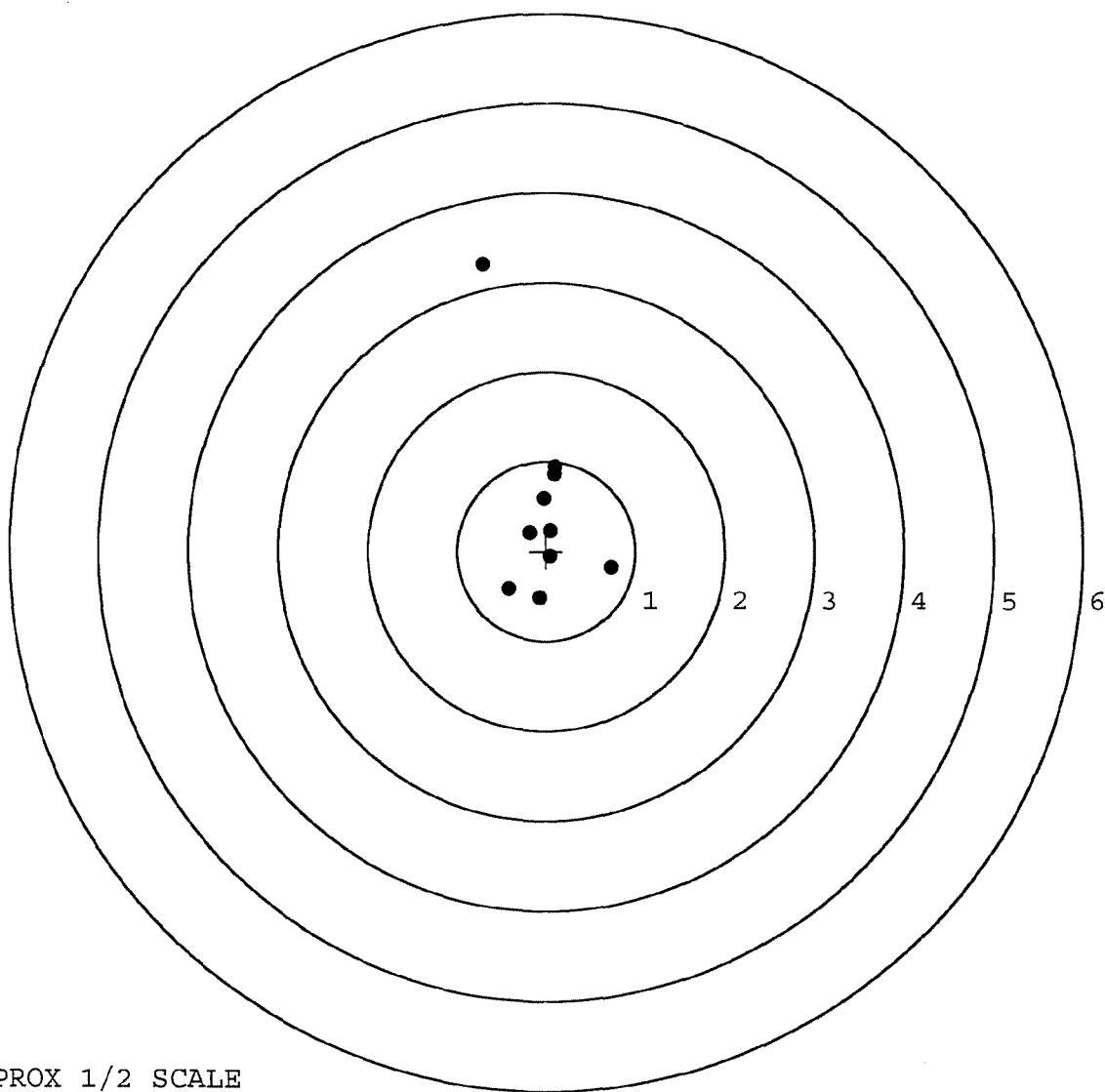
MEAN RADIUS: 0.791

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.728	-0.177
2:	-0.075	-0.524
3:	-0.421	-0.422
4:	0.102	0.936
5:	0.099	0.860
6:	-0.028	0.590
7:	-0.181	0.213
8:	0.051	0.233
9:	0.041	-0.058
10:	-0.718	3.204



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461684. __0

TARGET NUMBER: 4

FILE DATE: 10/12/2005

FILE TIME: 10:10

X CENTROID: 0.009

Y CENTROID: -0.064

POA TO CENTROID: 0.064

HORZ SPREAD: 1.553

VERT SPREAD: 2.006

GROUP SPREAD: 2.061

MIN RADIUS: 0.140

MAX RADIUS: 1.129

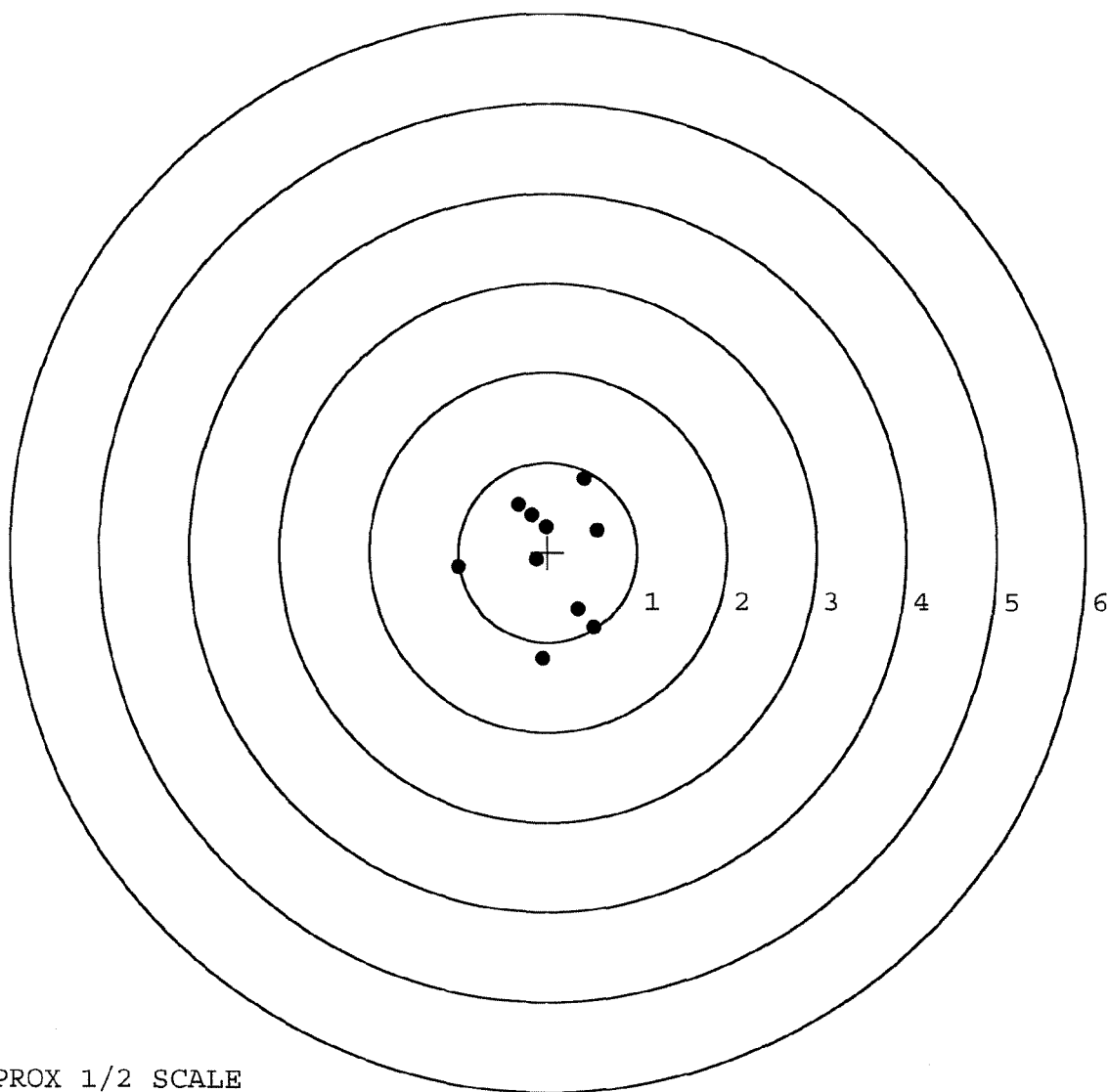
MEAN RADIUS: 0.701

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.059	-1.191
2:	0.517	-0.840
3:	0.337	-0.637
4:	0.550	0.244
5:	0.413	0.815
6:	-0.130	-0.085
7:	-1.003	-0.164
8:	-0.022	0.282
9:	-0.185	0.415
10:	-0.333	0.524



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461684. __0

TARGET NUMBER: 5

FILE DATE: 10/12/2005

FILE TIME: 10:10

POINT#	X	Y
1:	0.021	-1.121
2:	-0.075	-0.856
3:	-1.593	-0.214
4:	-0.650	-0.011
5:	-0.535	0.366
6:	0.669	-0.221
7:	0.095	-0.067
8:	0.659	0.053
9:	0.225	0.401
10:	-0.161	0.541

X CENTROID: -0.135

Y CENTROID: -0.113

POA TO CENTROID: 0.176

HORZ SPREAD: 2.262

VERT SPREAD: 1.662

GROUP SPREAD: 2.268

MIN RADIUS: 0.234

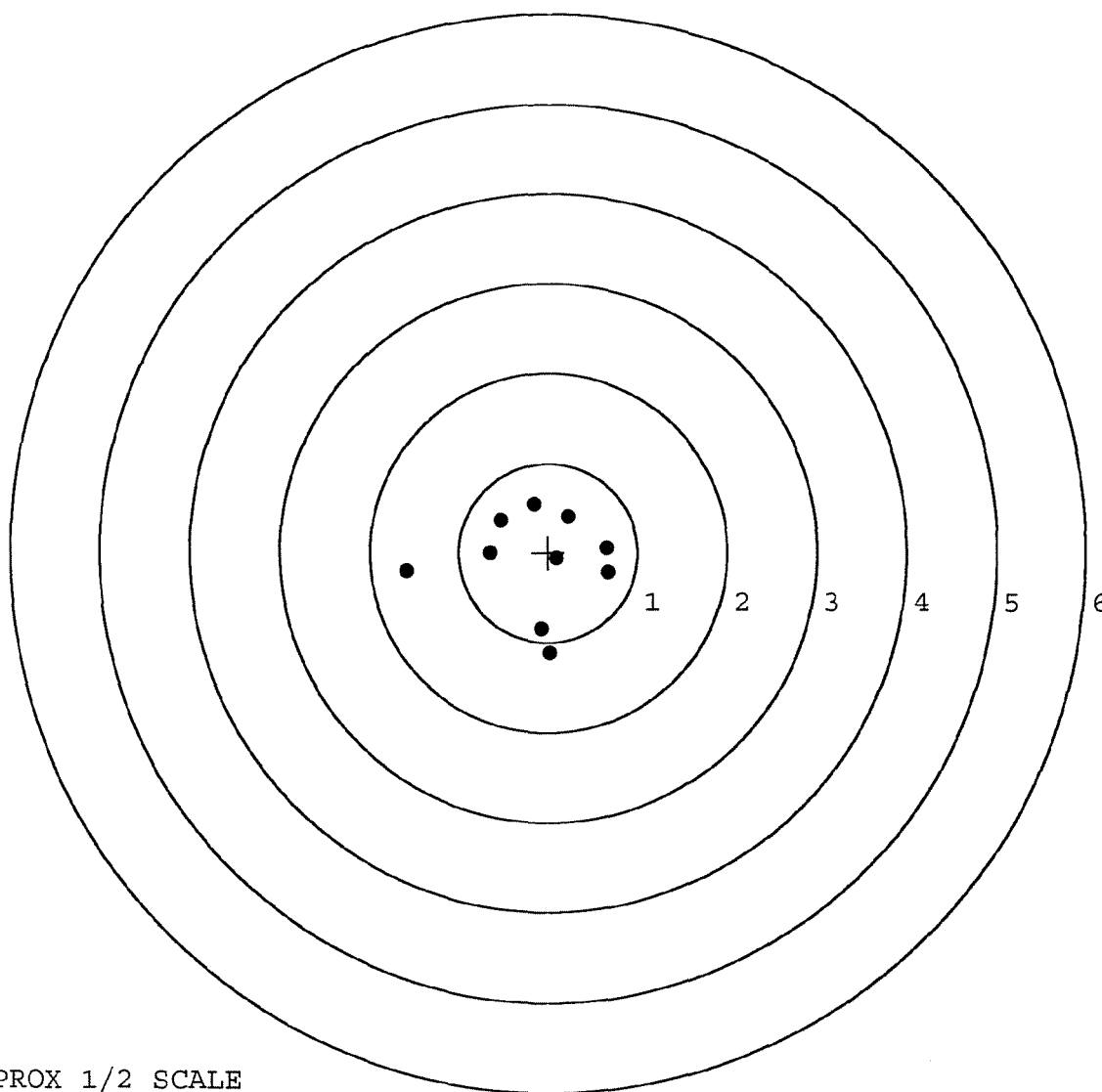
MAX RADIUS: 1.462

MEAN RADIUS: 0.751

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE