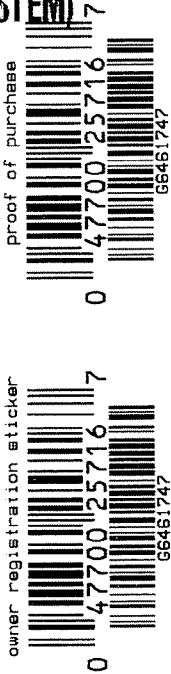


G-646 1747

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

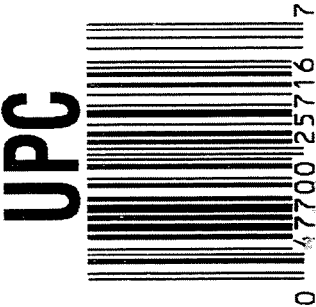
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461747



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

Original

71

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 # G6461747

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	APR 18 2005	4-18-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRL
620	APPLY COATINGS (BARREL ACTION)		5-6-05	CW
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-12-05	RL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-12-05	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-12-05	RL
	D) OIL FIRING PIN ASSEMBLY		5-12-05	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

BARBER - M24 0155625 OP # OPERATION NAME			READINGS			DATE	INITIAL		
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	6 lbs	6 lbs	6 lbs	5-31-05	AC		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	4 lbs	4 lbs	4 lbs	5-31-05	AC		
	H) TRIGGER PULL TEST AND RETAINABILITY					5-23-05	AC		
	I) FIRING PIN INDENT	.020 MIN	.024	.024	.024	5-31-05	AC		
	J) ASSEMBLE STOCK					5-12-05	RTZ		
	K) ASSEMBLE SWIVEL STUDS					5-31-05	AC		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					5-12-05	RTZ		
	M) IRON SIGHT ALIGNMENT					5-12-05	RTZ		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					5-12-05	RTZ		
640	GALLERY TEST AND TARGET		PASS FAIL			5-12-05	RTZ TKW		
	MALFUNCTION		CORRECTION			3			
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
645	INSPECT FOR LIVE AMMO					5-13-05	AC		
655	FINAL INSPECTION A) HEADSPACE					5-31-05	AC		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.82	2.85	2.68	2.99	2.95	5-23-05	AC
	C) FUNCTION					5-31-05	AC		
660	PACK					5-31-05	RTZ		

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

INITIAL & CYCLE TESTS
BARBER - M24 0155636

2.50 LBS (plus or minus 0.50 LBS)

DATE 5-3-05

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.33	2.41		2.65	
PULL #2	2.23	2.71		2.35	
PULL #3	2.49	2.90		2.71	
PULL #4	2.60	2.72		2.58	
PULL #5	2.71	2.39		2.64	
TOTAL	12.36	13.13		12.93	
AVERAGE	2.47	2.62		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.26		
PULL #2	3.16	3.40		
PULL #3	3.19	3.34		
PULL #4	3.17	3.33		
PULL #5	3.09	3.29		
TOTAL	15.72	16.62		
AVERAGE	3.14	3.32		

	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	4.46	4.61		4.50
PULL #2	4.34	4.45		4.42
PULL #3	4.51	4.42		4.28
PULL #4	4.46	4.42		4.32
PULL #5	4.33	4.39		4.38
TOTAL	22.10	22.29		21.90
AVERAGE	4.42	4.45		4.38

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461747.___0

FILE DATE AND TIME: 05/13/2005 06:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

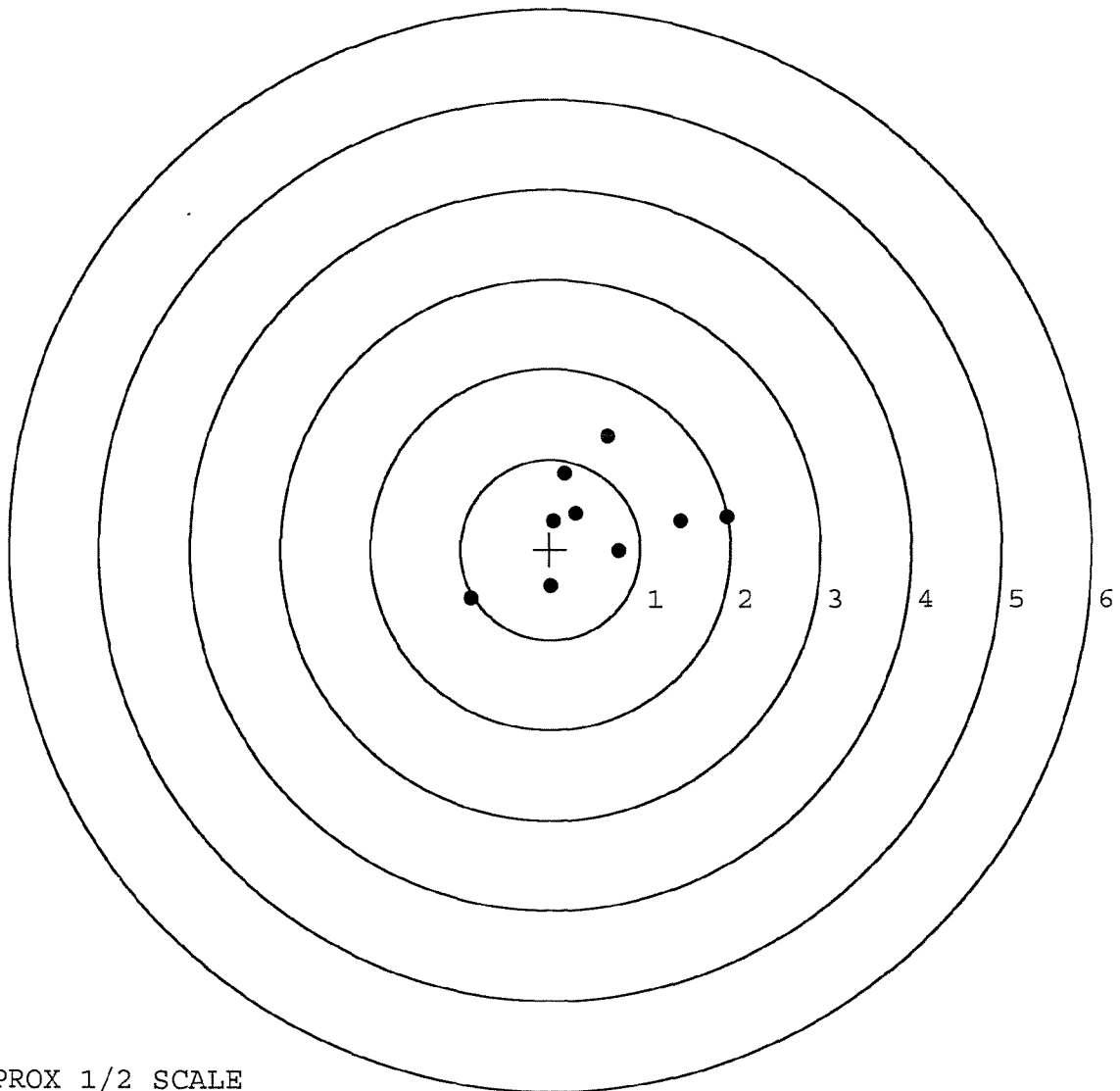
The Average X Centroid of the Five Target Set:	-0.016
The Average Y Centroid of the Five Target Set:	0.124
The Average Point of Impact of the Five Target Set:	0.125
The Average Mean Radius of the Five Target Set:	0.800
The Distance from POA to Centroid Target #1:	0.553
The Distance from Centroid Target #2 to Centroid Target #1:	0.488
The Distance from Centroid Target #3 to Centroid Target #1:	0.687
The Distance from Centroid Target #4 to Centroid Target #1:	0.951
The Distance from Centroid Target #5 to Centroid Target #1:	0.495

BARBER - M24 0155638

SERIAL NUMBER: G6461747. __0
 TARGET NUMBER: 1
 FILE DATE: 05/13/2005
 FILE TIME: 06:22

POINT#	X	Y
1:	0.640	1.257
2:	1.957	0.365
3:	1.441	0.323
4:	0.162	0.840
5:	0.284	0.403
6:	0.285	0.400
7:	0.036	0.316
8:	0.760	-0.014
9:	0.007	-0.411
10:	-0.886	-0.543

X CENTROID: 0.469
 Y CENTROID: 0.294
 POA TO CENTROID: 0.553
 HORZ SPREAD: 2.843
 VERT SPREAD: 1.800
 GROUP SPREAD: 2.984
 MIN RADIUS: 0.212
 MAX RADIUS: 1.592
 MEAN RADIUS: 0.779
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



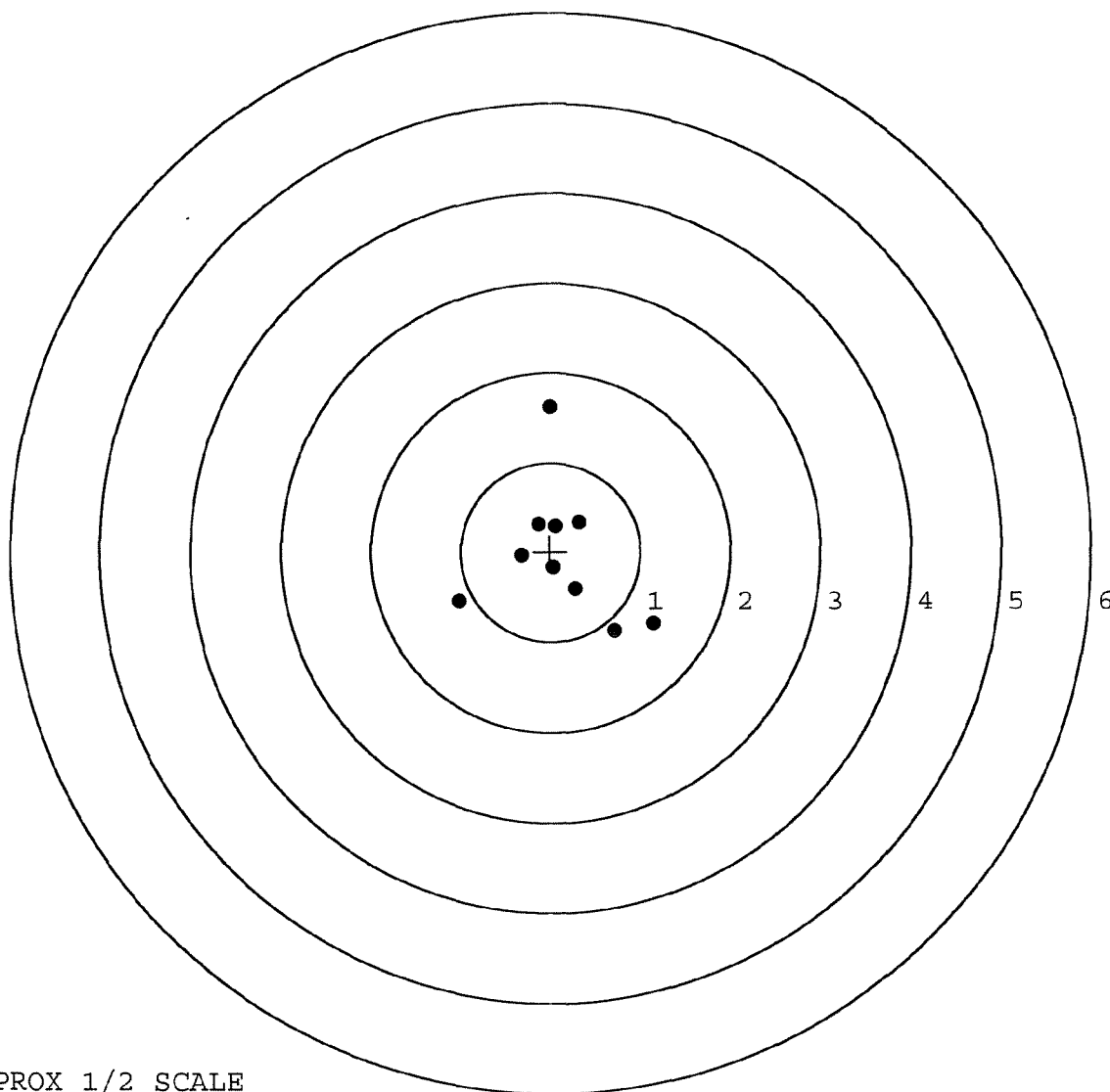
TARGET APPROX 1/2 SCALE

BARBER - M24 0155639

SERIAL NUMBER: G6461747. __0
 TARGET NUMBER: 2
 FILE DATE: 05/13/2005
 FILE TIME: 06:22

POINT#	X	Y
1:	-0.011	1.618
2:	-0.324	-0.046
3:	-0.134	0.311
4:	-1.015	-0.555
5:	1.144	-0.804
6:	0.709	-0.885
7:	0.276	-0.415
8:	0.037	-0.178
9:	0.315	0.339
10:	0.057	0.287

X CENTROID: 0.105
 Y CENTROID: -0.033
 POA TO CENTROID: 0.110
 HORZ SPREAD: 2.159
 VERT SPREAD: 2.503
 GROUP SPREAD: 2.683
 MIN RADIUS: 0.161
 MAX RADIUS: 1.655
 MEAN RADIUS: 0.741
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



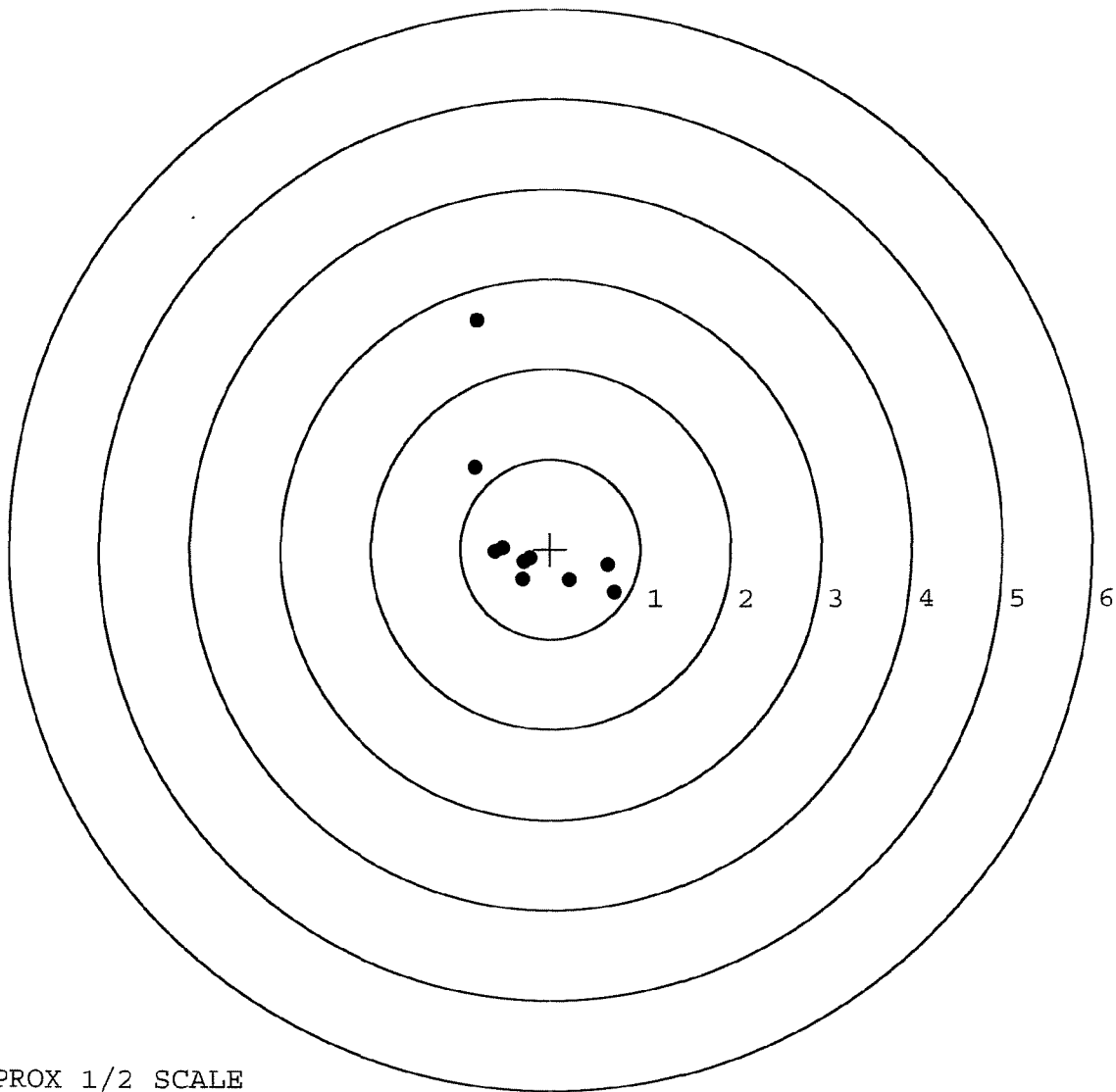
TARGET APPROX 1/2 SCALE

BARBER - M24 0155640

SERIAL NUMBER: G6461747. __0
 TARGET NUMBER: 3
 FILE DATE: 05/13/2005
 FILE TIME: 06:22

POINT#	X	Y
1:	0.634	-0.178
2:	0.712	-0.483
3:	0.208	-0.345
4:	-0.230	-0.105
5:	-0.309	-0.338
6:	-0.530	0.017
7:	-0.844	0.909
8:	-0.818	2.539
9:	-0.619	-0.030
10:	-0.296	-0.142

X CENTROID: -0.209
 Y CENTROID: 0.184
 POA TO CENTROID: 0.279
 HORZ SPREAD: 1.556
 VERT SPREAD: 3.022
 GROUP SPREAD: 3.387
 MIN RADIUS: 0.290
 MAX RADIUS: 2.432
 MEAN RADIUS: 0.811
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0155641

SERIAL NUMBER: G6461747. 0

TARGET NUMBER: 4

FILE DATE: 05/13/2005

FILE TIME: 06:22

POINT#	X	Y
1:	-0.909	-0.150
2:	-0.643	-0.141
3:	-0.383	-0.454
4:	0.484	-0.148
5:	-1.352	-0.249
6:	-1.292	-0.132
7:	-0.152	0.878
8:	-0.773	0.781
9:	0.053	0.047
10:	0.408	0.267

X CENTROID: -0.456

Y CENTROID: 0.070

POA TO CENTROID: 0.461

HORZ SPREAD: 1.836

VERT SPREAD: 1.332

GROUP SPREAD: 1.839

MIN RADIUS: 0.282

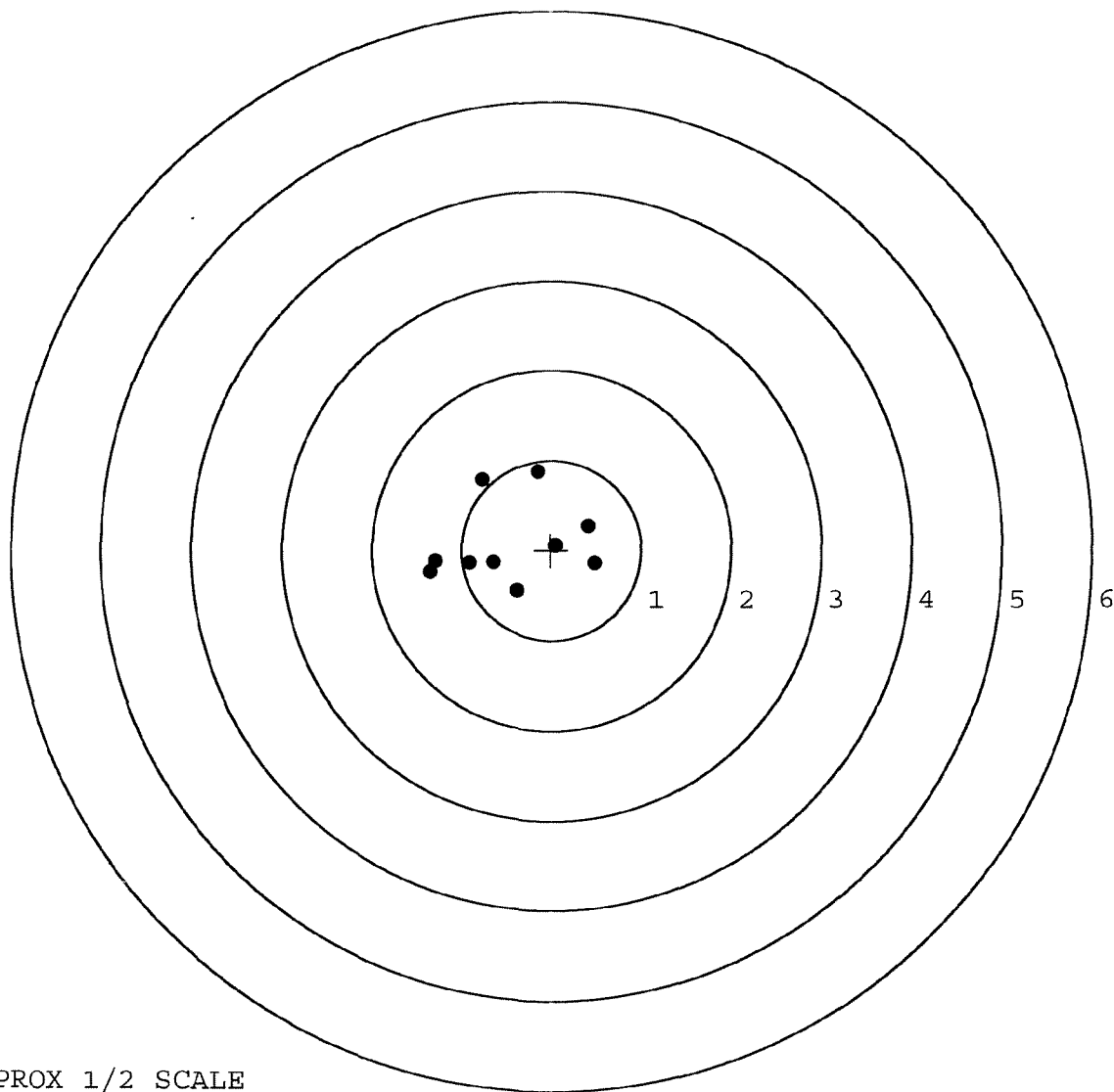
MAX RADIUS: 0.965

MEAN RADIUS: 0.713

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



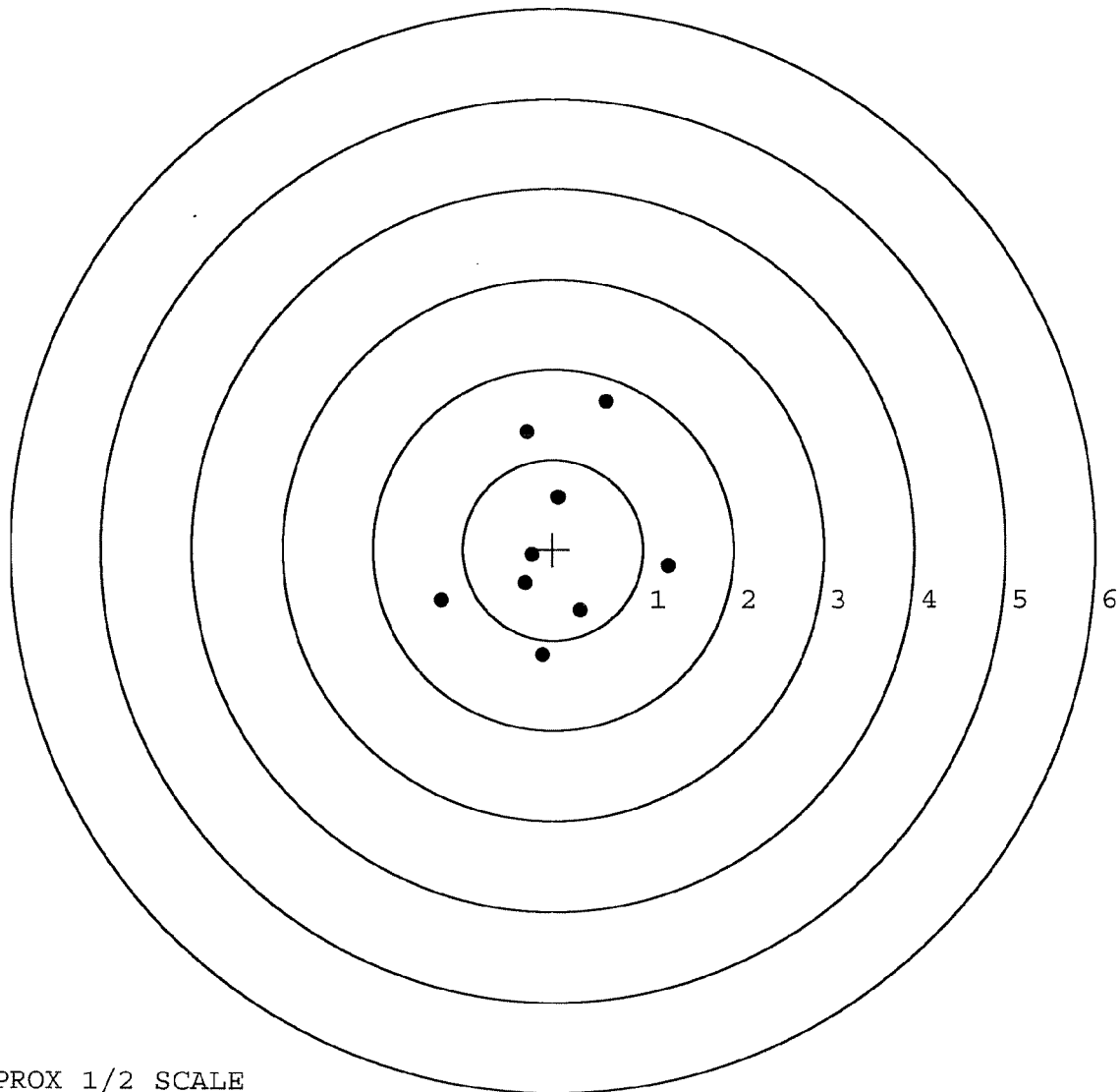
TARGET APPROX 1/2 SCALE

BARBER - M24 0155642

SERIAL NUMBER: G6461747. __0
 TARGET NUMBER: 5
 FILE DATE: 05/13/2005
 FILE TIME: 06:22

POINT#	X	Y
1:	1.279	-0.184
2:	0.304	-0.676
3:	-0.115	-1.167
4:	-1.237	-0.568
5:	-0.313	-0.378
6:	-0.234	-0.066
7:	0.592	1.646
8:	-0.293	1.300
9:	0.060	0.583
10:	0.059	0.580

X CENTROID: 0.010
 Y CENTROID: 0.107
 POA TO CENTROID: 0.107
 HORZ SPREAD: 2.516
 VERT SPREAD: 2.813
 GROUP SPREAD: 2.900
 MIN RADIUS: 0.299
 MAX RADIUS: 1.645
 MEAN RADIUS: 0.955
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE