

G 6461755

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

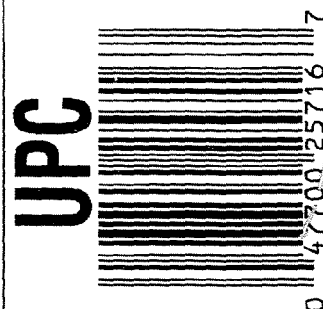
- INSTRUCTION BOOK 3518

DD FORM



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461755



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTE
UPC

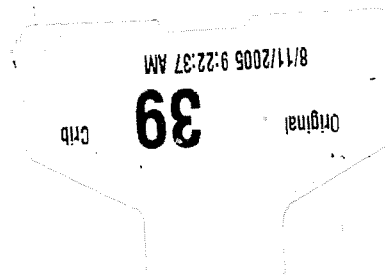


ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTE
UPC



SERIAL NO.





25716

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



.MA25716

Shop Order: SW5716 - SEP



.ABSW5716 - SEP

Start Date: 5/27/2005

Finish Date: 9/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004110512

0540

01PC001

Flat Black Powder Coat, Barrel and



0004110502

0560

89SWS1

Reassemble Action.



0004110503

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # C6646 1755

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-9-05	RTZ
440	PROOF		9-12-05	RTZ
460	CHECK HEADSPACE		9-13-05	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	9/14/05	unint
500	ROLLMARK CALIBER		9-14-05	CW
510	DRILL AND TAP SIGHT HOLES		9-13-05	TRW
520	GOFF BLAST BBL / REC		9-19-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	unint
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9-28-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-28-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-28-05	DA
	D) OIL FIRING PIN ASSEMBLY		10-10-05	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>6 lbs</u>	10-11-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-11-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		10-10-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-10-05	RTL
	M) IRON SIGHT ALIGNMENT		10-10-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-10-05	RTL
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	10/10/05	mgj
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	OK	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/10/05	WJM
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.74</u> <u>2.96</u> <u>2.46</u> <u>2.70</u> <u>2.72</u>	10-11-05	BC-
	C) FUNCTION		10-11-05	Ac
690	PACK		10-12-05	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

TESTER

10/4/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.58	2.16		2.01	
PULL #2	2.74	2.25		2.15	
PULL #3	2.54	2.37		2.34	
PULL #4	2.51	2.34		2.24	
PULL #5	2.58	2.36		2.13	
TOTAL	12.95	11.48		10.87	
AVERAGE	2.59	2.30		2.17	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.99	2.77		
PULL #2	3.21	2.91		
PULL #3	3.15	2.67		
PULL #4	3.10	2.91		
PULL #5	3.19	2.81		
TOTAL	15.64	14.07		
AVERAGE	3.13	2.81		

	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	4.32		4.33
PULL #2	4.14	4.08		4.08
PULL #3	4.06	3.81		4.16
PULL #4	3.70	3.68		4.22
PULL #5	4.15	4.23		4.27
TOTAL	20.35	20.12		21.06
AVERAGE	4.07	4.02		4.21

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461755.__0
FILE DATE AND TIME: 10/10/2005 18:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.028
The Average Y Centroid of the Five Target Set:	0.022
The Average Point of Impact of the Five Target Set:	0.036
The Average Mean Radius of the Five Target Set:	0.684
The Distance from POA to Centroid Target #1:	0.170
The Distance from Centroid Target #2 to Centroid Target #1:	0.377
The Distance from Centroid Target #3 to Centroid Target #1:	0.112
The Distance from Centroid Target #4 to Centroid Target #1:	0.045
The Distance from Centroid Target #5 to Centroid Target #1:	0.373

SERIAL NUMBER: G6461755. 0

TARGET NUMBER: 1

FILE DATE: 10/10/2005

FILE TIME: 18:16

X CENTROID: -0.038

Y CENTROID: 0.165

POA TO CENTROID: 0.170

HORZ SPREAD: 1.702

VERT SPREAD: 2.067

GROUP SPREAD: 2.110

MIN RADIUS: 0.108

MAX RADIUS: 1.188

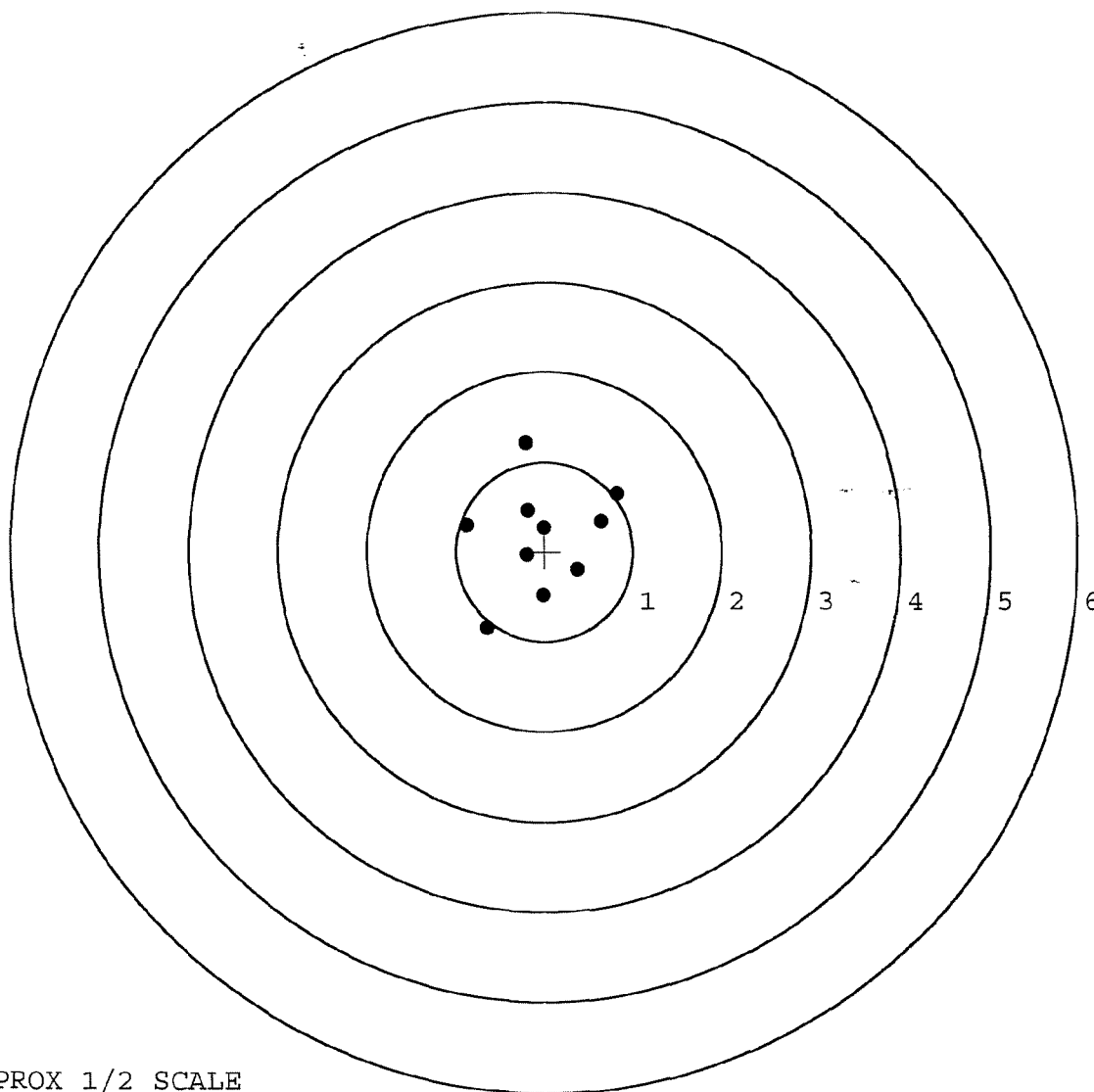
MEAN RADIUS: 0.671

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.025	-0.488
2:	-0.647	-0.855
3:	0.372	-0.206
4:	0.634	0.342
5:	0.816	0.652
6:	-0.012	0.270
7:	-0.205	-0.039
8:	-0.197	0.465
9:	-0.225	1.212
10:	-0.886	0.300



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461755. 0

TARGET NUMBER: 2

FILE DATE: 10/10/2005

FILE TIME: 18:16

X CENTROID: 0.120

Y CENTROID: -0.177

POA TO CENTROID: 0.214

HORZ SPREAD: 1.579

VERT SPREAD: 2.668

GROUP SPREAD: 2.887

MIN RADIUS: 0.183

MAX RADIUS: 1.697

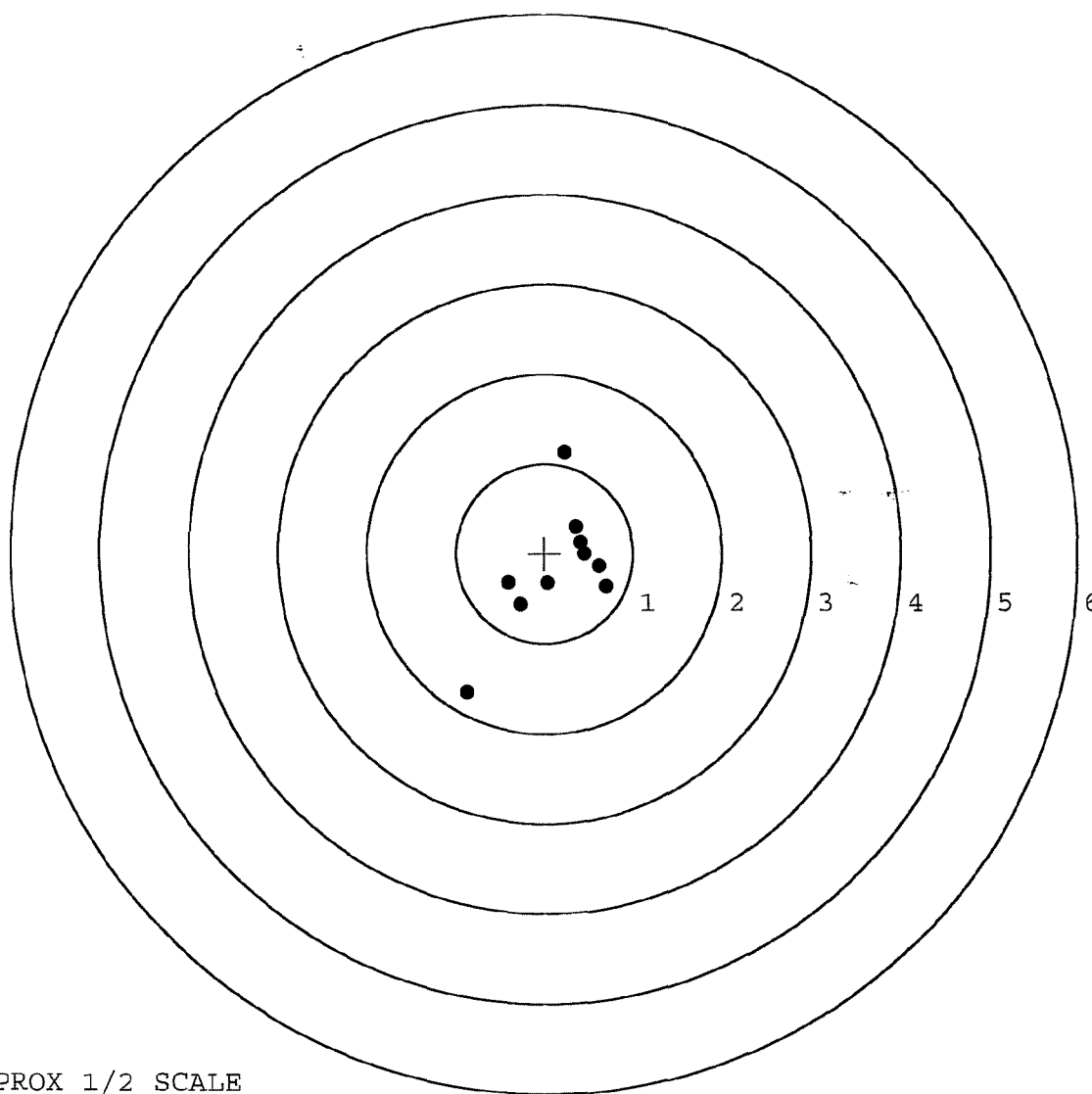
MEAN RADIUS: 0.674

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.284	-0.578
2:	-0.417	-0.331
3:	0.031	-0.338
4:	0.696	-0.373
5:	0.618	-0.140
6:	0.452	-0.009
7:	0.411	0.126
8:	0.350	0.294
9:	0.221	1.122
10:	-0.883	-1.546



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461755. __0

TARGET NUMBER: 3

FILE DATE: 10/10/2005

FILE TIME: 18:16

X CENTROID: -0.130

Y CENTROID: 0.103

POA TO CENTROID: 0.166

HORZ SPREAD: 1.451

VERT SPREAD: 2.054

GROUP SPREAD: 2.121

MIN RADIUS: 0.220

MAX RADIUS: 1.242

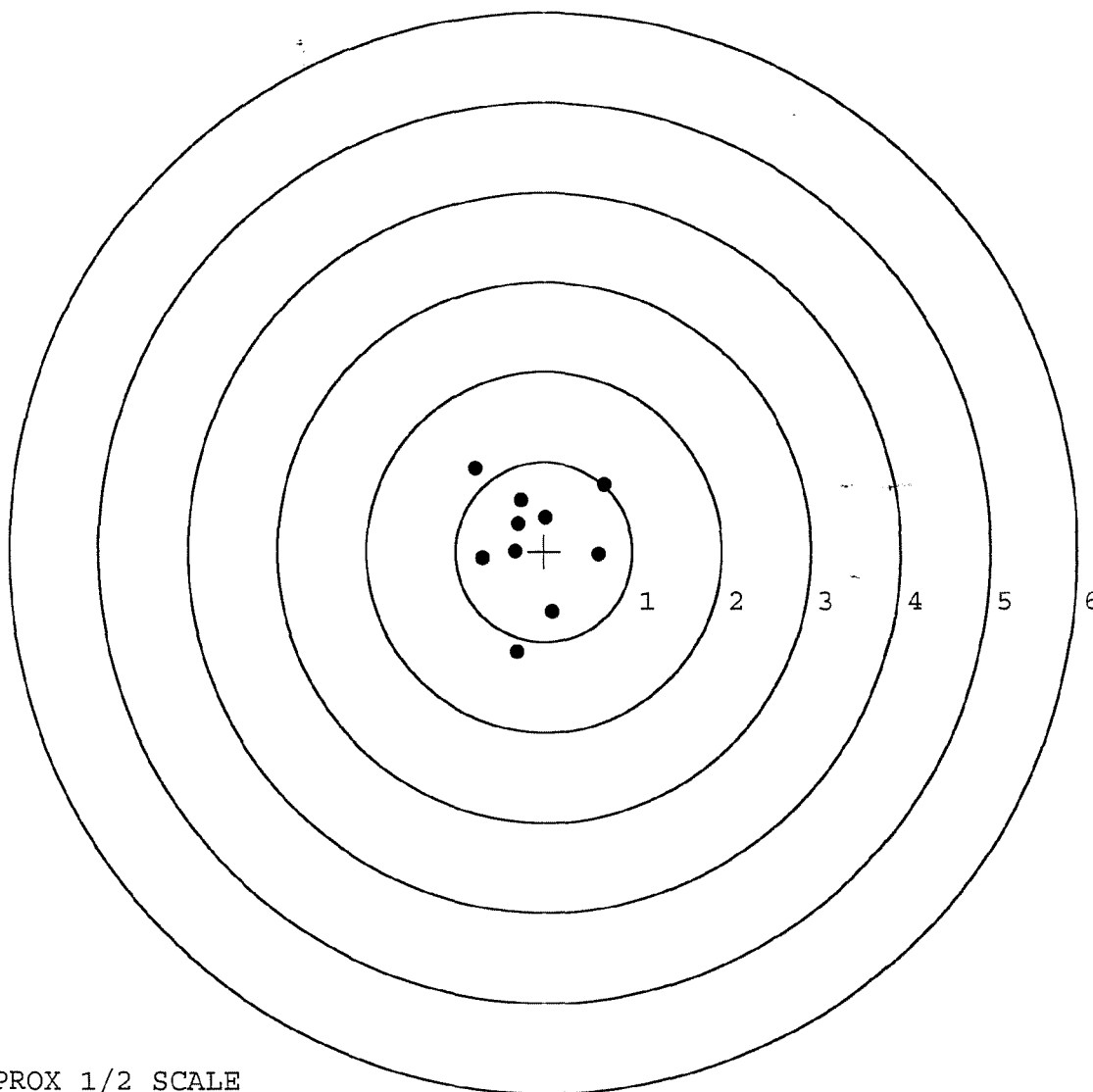
MEAN RADIUS: 0.677

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.676	0.752
2:	0.009	0.374
3:	-0.273	0.567
4:	-0.304	0.313
5:	-0.328	0.006
6:	-0.698	-0.078
7:	-0.775	0.928
8:	-0.309	-1.126
9:	0.087	-0.676
10:	0.614	-0.030



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461755. 0

TARGET NUMBER: 4

FILE DATE: 10/10/2005

FILE TIME: 18:16

X CENTROID: 0.007

Y CENTROID: 0.158

POA TO CENTROID: 0.158

HORZ SPREAD: 1.359

VERT SPREAD: 3.016

GROUP SPREAD: 3.090

MIN RADIUS: 0.257

MAX RADIUS: 1.784

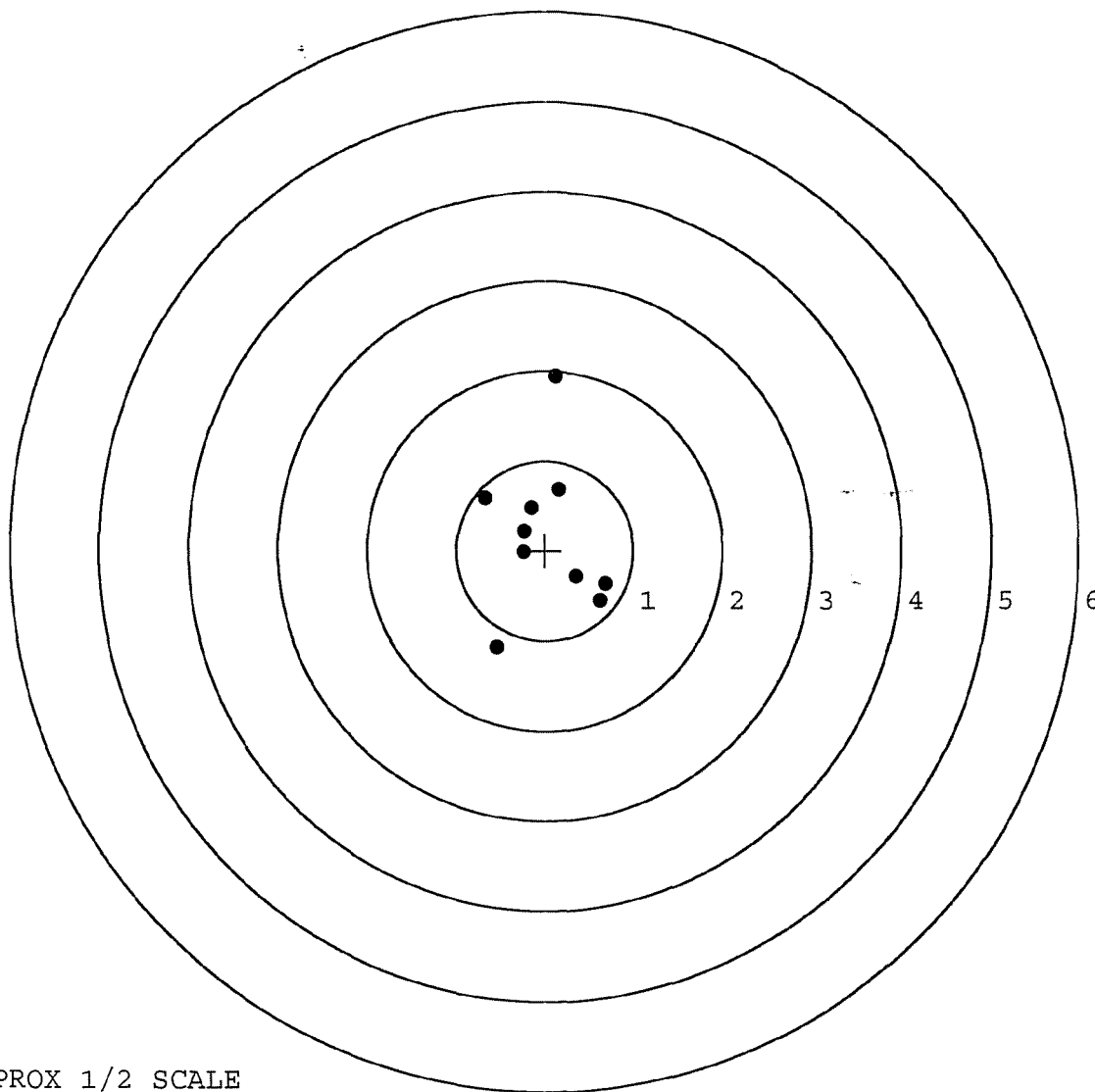
MEAN RADIUS: 0.778

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.350	-0.291
2:	0.681	-0.369
3:	0.622	-0.557
4:	-0.544	-1.078
5:	-0.245	-0.025
6:	-0.243	0.218
7:	-0.160	0.476
8:	0.158	0.682
9:	-0.678	0.587
10:	0.126	1.938



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461755. 0

TARGET NUMBER: 5

FILE DATE: 10/10/2005

FILE TIME: 18:16

X CENTROID: 0.181

Y CENTROID: -0.137

POA TO CENTROID: 0.226

HORZ SPREAD: 1.422

VERT SPREAD: 1.758

GROUP SPREAD: 1.805

MIN RADIUS: 0.250

MAX RADIUS: 0.961

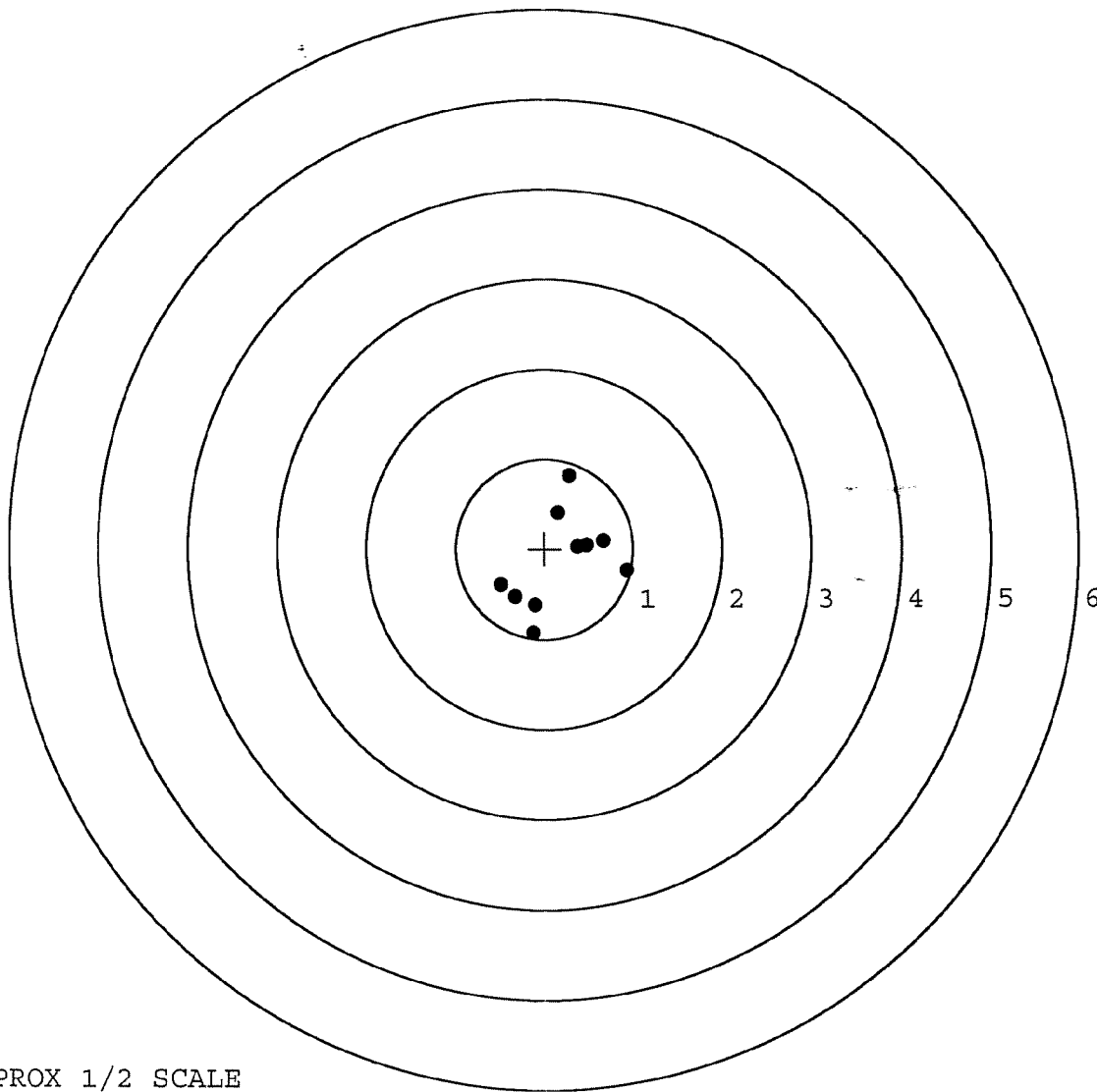
MEAN RADIUS: 0.620

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.927	-0.242
2:	0.666	0.087
3:	0.479	0.044
4:	0.370	0.026
5:	0.153	0.405
6:	0.278	0.819
7:	-0.495	-0.405
8:	-0.335	-0.536
9:	-0.108	-0.627
10:	-0.130	-0.939



TARGET APPROX 1/2 SCALE