

G646 1765

ORDER 25716

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

UPC



0 47700 25716 7

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

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0 47700 25716 7

SERIAL NO.



66461765

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



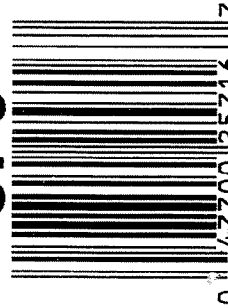
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6461765

UPC



4/7/2005 2:48:09 PM

Original
13
Crib

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

Goff Blast Barrel & Rec Assembly,

78ROT01



0003858612

0540

Flat Black Powder Coat, Barrel and

01PC001



0003858602

0560

Reassemble Action.

89SWS1



0003858603

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461765

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	AC
607	CHECK HEADSPACE	MAGNA-FLUX	4-18-05	AC
610	DIS-ASSEMBLE GUN	INSPECTED	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 20 2005 OPERATOR <u>BJ</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		5-12-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-12-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-12-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-12-05	RTZ
	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	6 lbs	6 lbs	6 lbs	5-23-05	AC
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	3 lbs	3 lbs	3 lbs	5-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY					X	X
	I) FIRING PIN INDENT	.020 MIN	.024	.024	.024	5-23-05	AC
	J) ASSEMBLE STOCK					5-12-05	RT
	K) ASSEMBLE SWIVEL STUDS					5-23-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					5-12-05	RT
	M) IRON SIGHT ALIGNMENT					5-12-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					5-12-05	RT
640	GALLERY TEST AND TARGET		PASS FAIL			5-13-05	AC
	MALFUNCTION		CORRECTION			X	X
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION				
645	INSPECT FOR LIVE AMMO					5-13-05	TRW
655	FINAL INSPECTION A) HEADSPACE					5-23-05	AC
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.46	2.39	2.60 2.54 2.43	5-20-05	AC
	C) FUNCTION					5-23-05	AC
660	PACK					5/24/05	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
BARBER - M24 0155907

SERIAL NO. _____

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)

DATE 5-11-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.70	2.74		2.78	
PULL #2	2.58	2.69		2.53	
PULL #3	2.23	2.64		2.46	
PULL #4	2.37	2.45		2.69	
PULL #5	2.42	2.61		2.47	
TOTAL	12.30	13.13		12.93	
AVERAGE	2.46	2.62		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.01		
PULL #2	3.05	3.00		
PULL #3	3.04	3.02		
PULL #4	3.07	2.95		
PULL #5	3.05	3.00		
TOTAL	15.42	14.98		
AVERAGE	3.08	2.99		

	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	4.14	4.29		4.19
PULL #2	4.35	4.22		4.30
PULL #3	4.58	4.36		4.24
PULL #4	4.68	4.30		4.39
PULL #5	4.67	4.39		4.36
TOTAL	22.42	21.56		21.48
AVERAGE	4.48	4.31		4.29

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461765.___0
FILE DATE AND TIME: 05/13/2005 06:06

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.036
The Average Y Centroid of the Five Target Set:	-0.105
The Average Point of Impact of the Five Target Set:	0.111
The Average Mean Radius of the Five Target Set:	0.676
The Distance from POA to Centroid Target #1:	0.435
The Distance from Centroid Target #2 to Centroid Target #1:	0.385
The Distance from Centroid Target #3 to Centroid Target #1:	0.544
The Distance from Centroid Target #4 to Centroid Target #1:	0.551
The Distance from Centroid Target #5 to Centroid Target #1:	0.493

SERIAL NUMBER: G6461765. __0

TARGET NUMBER: 1

FILE DATE: 05/13/2005

FILE TIME: 06:06

X CENTROID: -0.170

Y CENTROID: -0.401

POA TO CENTROID: 0.435

HORZ SPREAD: 1.547

VERT SPREAD: 1.666

GROUP SPREAD: 1.874

MIN RADIUS: 0.143

MAX RADIUS: 1.287

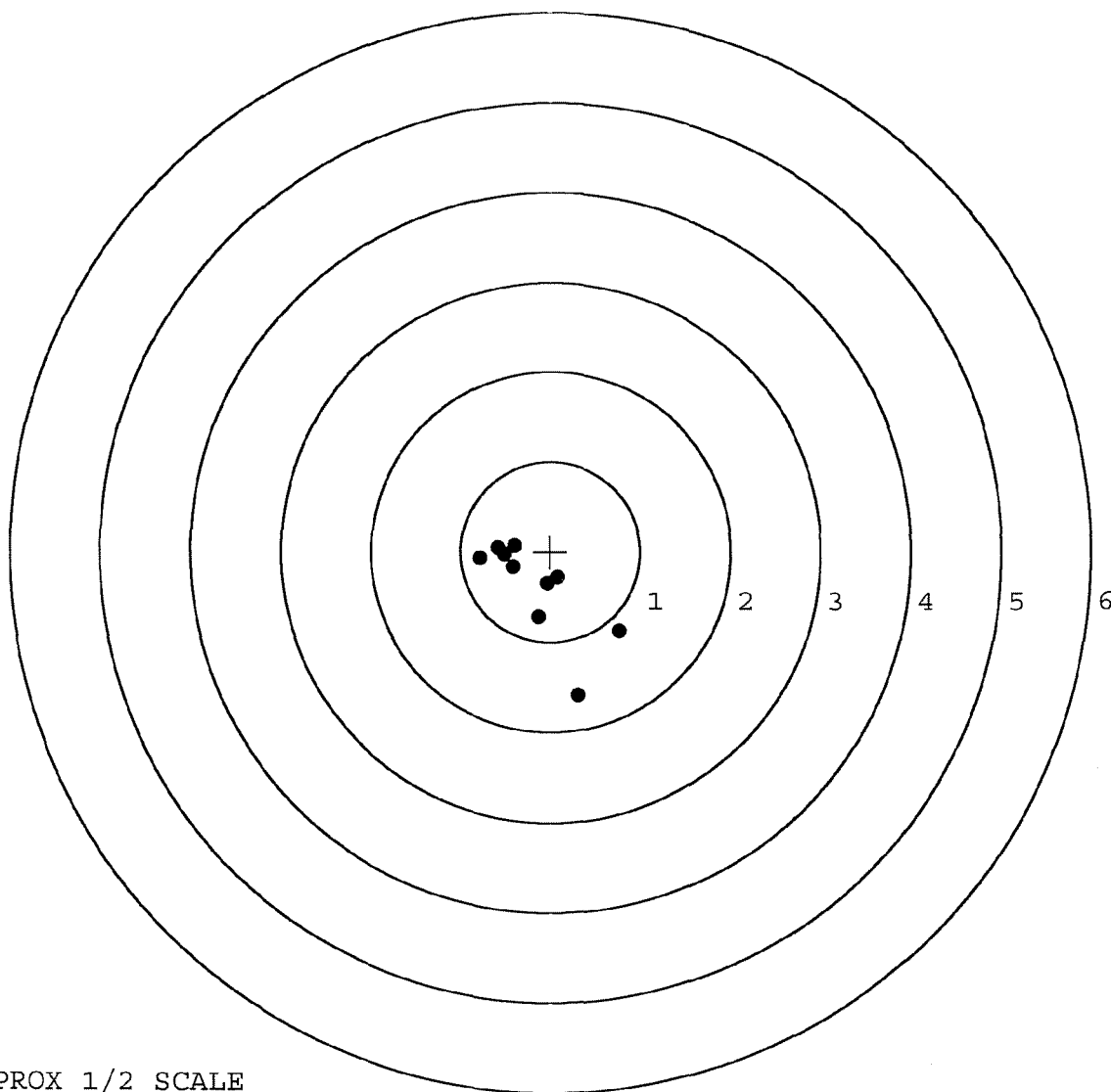
MEAN RADIUS: 0.576

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.394	0.070
2:	-0.512	-0.033
3:	-0.781	-0.072
4:	-0.035	-0.354
5:	0.766	-0.885
6:	0.309	-1.596
7:	0.086	-0.292
8:	-0.134	-0.728
9:	-0.585	0.051
10:	-0.417	-0.171



TARGET APPROX 1/2 SCALE

BARBER - M24 0155910

SERIAL NUMBER: G6461765. __ 0

TARGET NUMBER: 2

FILE DATE: 05/13/2005

FILE TIME: 06:06

POINT#	X	Y
1:	0.807	0.959
2:	0.428	0.489
3:	0.051	0.310
4:	-0.492	0.279
5:	-0.463	-0.411
6:	-0.432	-0.549
7:	0.649	-0.460
8:	0.323	-1.324
9:	0.393	-1.226
10:	0.059	0.311

X CENTROID: 0.132

Y CENTROID: -0.162

POA TO CENTROID: 0.209

HORZ SPREAD: 1.299

VERT SPREAD: 2.283

GROUP SPREAD: 2.334

MIN RADIUS: 0.479

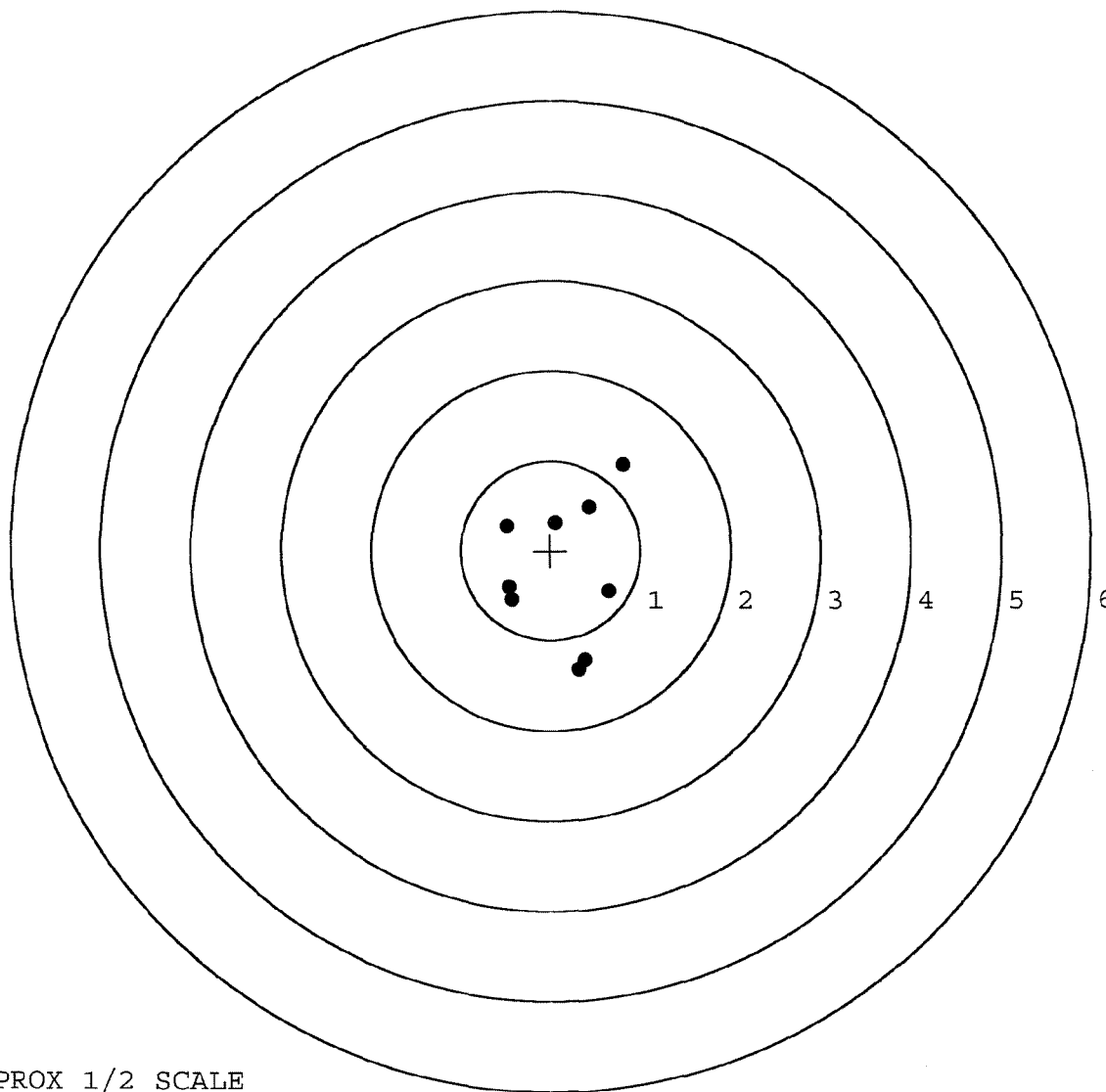
MAX RADIUS: 1.309

MEAN RADIUS: 0.794

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461765. 0

TARGET NUMBER: 3

FILE DATE: 05/13/2005

FILE TIME: 06:06

POINT#	X	Y
1:	1.092	0.949
2:	0.650	0.741
3:	0.377	0.121
4:	0.085	0.206
5:	-0.354	0.305
6:	-0.295	-0.138
7:	-0.348	-0.447
8:	0.189	-1.352
9:	0.874	-1.250
10:	0.984	-0.888

X CENTROID: 0.325

Y CENTROID: -0.175

POA TO CENTROID: 0.370

HORZ SPREAD: 1.446

VERT SPREAD: 2.301

GROUP SPREAD: 2.472

MIN RADIUS: 0.301

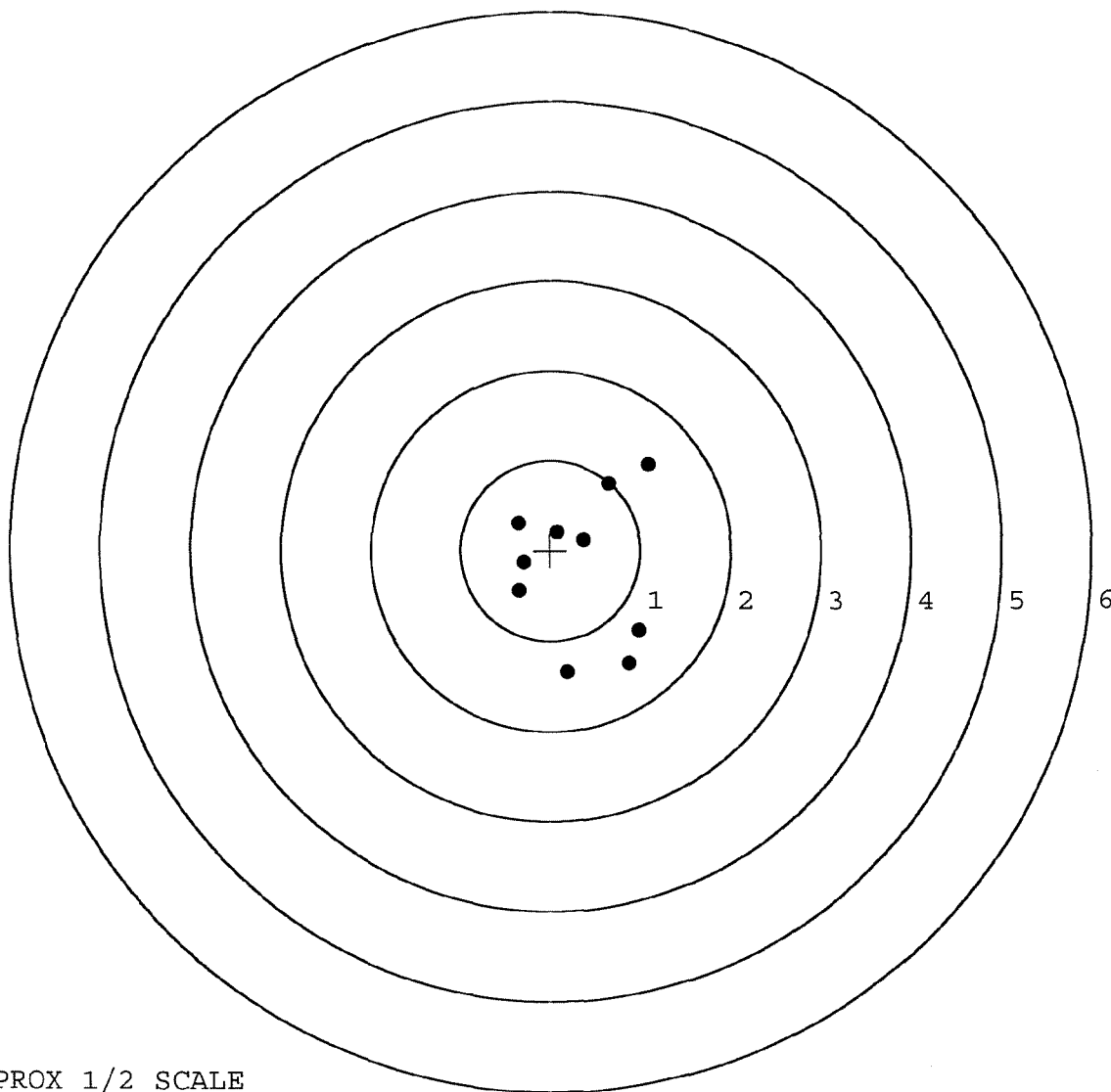
MAX RADIUS: 1.361

MEAN RADIUS: 0.863

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461765. __0

TARGET NUMBER: 4

FILE DATE: 05/13/2005

FILE TIME: 06:06

POINT#	X	Y
1:	0.101	1.119
2:	-1.403	0.490
3:	-0.428	0.132
4:	-0.312	-0.042
5:	0.517	-0.450
6:	0.505	0.043
7:	0.199	-0.145
8:	0.055	0.155
9:	0.184	0.050
10:	0.346	-0.046

X CENTROID: -0.024

Y CENTROID: 0.131

POA TO CENTROID: 0.133

HORZ SPREAD: 1.920

VERT SPREAD: 1.569

GROUP SPREAD: 2.138

MIN RADIUS: 0.082

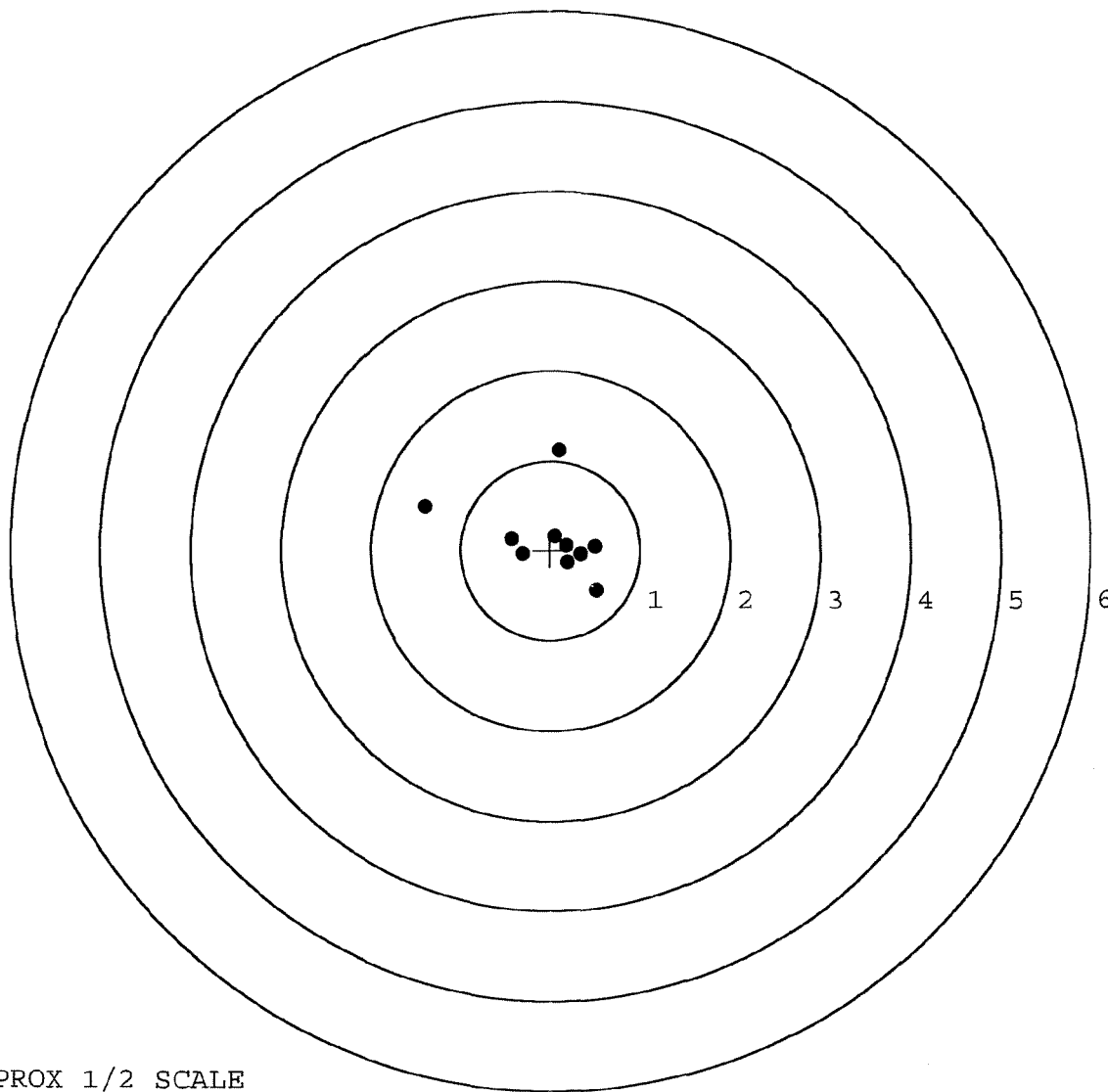
MAX RADIUS: 1.425

MEAN RADIUS: 0.556

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461765. 0

TARGET NUMBER: 5

FILE DATE: 05/13/2005

FILE TIME: 06:06

X CENTROID: -0.086

Y CENTROID: 0.085

POA TO CENTROID: 0.121

HORZ SPREAD: 1.708

VERT SPREAD: 1.919

GROUP SPREAD: 1.824

MIN RADIUS: 0.110

MAX RADIUS: 1.121

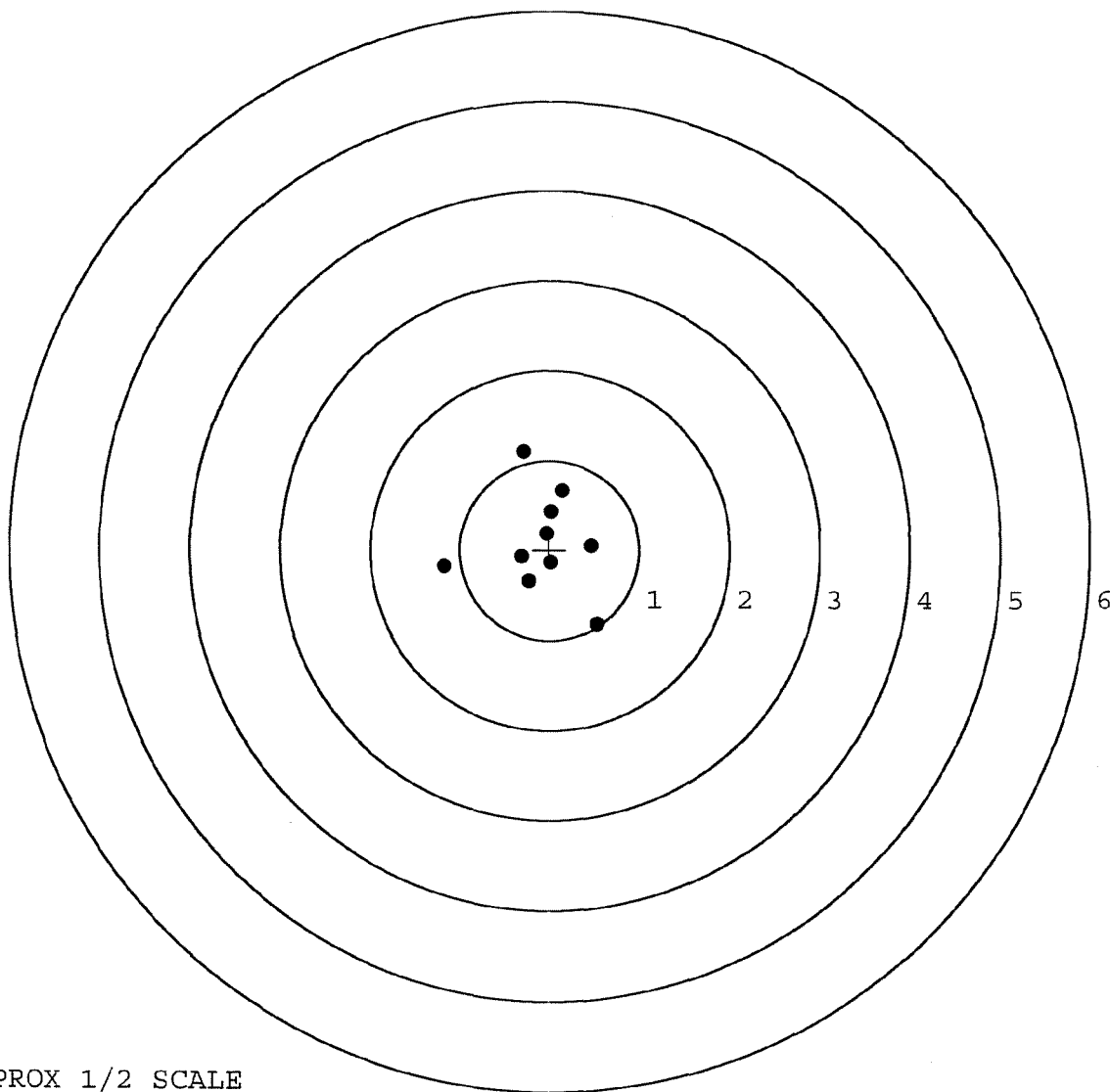
MEAN RADIUS: 0.589

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.287	1.097
2:	-1.175	-0.181
3:	0.145	0.665
4:	0.017	0.430
5:	-0.033	0.181
6:	0.469	0.049
7:	0.015	-0.146
8:	-0.313	-0.076
9:	-0.230	-0.349
10:	0.533	-0.822



TARGET APPROX 1/2 SCALE