

G 636/010

25716

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



.MA25716

Shop Order: SWS631059



.ABSW631059

Start Date: 8/9/2004

Finish Date: 10/26/2004

0540

01PC001

Flat Black Powder Coat, Barrel and



0003451403

0560

89SWS1

Reassemble Action.



0003451404

0690

89SWS1

Pack Rifle



0003451397

0700

89SWS1

Stencil SWS Container



.OP0700

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



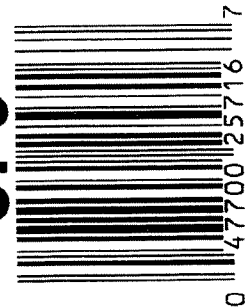
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6361010

UPC



7/22/2004 3:21:04 PM

Crib

32

Original

25716

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



.MA25716

Shop Order: SWS631055



.ABSW631055

Start Date: 7/23/2004

Finish Date: 9/23/2004

0630

01PC001

Flat Black Powder Coat, Barrel and



0003338116

0640

89SWS1

Reassemble Action.



0003338117

0685

89SWS1

Attach Front and Rear Sight Assemblies



0003338122

0710

89SWS1

Pack Rifle & Stencil SWS Container



.OP0710

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G636 1010

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-6-04	RTL
600	PROOF		4-6-04	RTL
607	CHECK HEADSPACE		4-6-04	RTL
610	DIS-ASSEMBLE GUN		4-6-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		4/8/04	RB
617	DRILL AND TAP SIGHT HOLES		4-8-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		5-7	TA
	(BOLT)		5-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-10-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-10-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-10-04	RTL
	D) OIL FIRING PIN ASSEMBLY		6-10-04	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	TRLW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.0</u> <u>7.0</u> <u>7.0</u>	6-21-04	RTL
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.0</u> <u>3.0</u>	6-21-04	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY		6-21-04	RTL
	I) FIRING PIN INDENT .020 MIN	<u>0.21</u> <u>0.21</u> <u>0.21</u>	6-21-04	RTL
	J) ASSEMBLE STOCK		6-21-04	RTL
	K) ASSEMBLE SWIVEL STUDS		6-29-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-29-04	TRW
	M) IRON SIGHT ALIGNMENT		6-29-04	TRW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-29-04	TRW
640	GALLERY TEST AND TARGET	PASS FAIL	6-17-04	AL
	MALFUNCTION	CORRECTION	6-17-04	AL
	MALFUNCTION	CORRECTION	6-17-04	AL
	MALFUNCTION	CORRECTION	6-17-04	AL
	MALFUNCTION	CORRECTION	6-17-04	AL
645	INSPECT FOR LIVE AMMO		6-17-04	AL
655	FINAL INSPECTION A) HEADSPACE		6-29-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.47</u> <u>2.63</u> <u>2.41</u> <u>2.32</u>	6-21-04	RTL
	C) FUNCTION		6-21-04	TRW
660	PACK		9/1/04	QA

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 6-10-04

TESTER TRC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.45	2.75		2.59	
PULL #2	2.53	2.66		2.64	
PULL #3	2.53	2.59		2.78	
PULL #4	2.61	2.56		2.69	
PULL #5	2.53	2.79		2.60	
TOTAL	12.65	13.35		13.30	
AVERAGE	2.53	2.67		2.66	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.08		
PULL #2	2.99	3.11		
PULL #3	3.33	3.17		
PULL #4	3.32	3.15		
PULL #5	3.12	3.26		
TOTAL	16.00	15.77		
AVERAGE	3.20	3.15		

	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	4.33	4.27		4.27
PULL #2	4.24	4.37		4.30
PULL #3	4.18	4.16		4.18
PULL #4	4.46	4.11		4.30
PULL #5	4.18	4.24		4.23
TOTAL	21.39	21.15		21.28
AVERAGE	4.27	4.23		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361010.__0
FILE DATE AND TIME: 06/17/2004 07:04

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.053
The Average Y Centroid of the Five Target Set:	-0.095
The Average Point of Impact of the Five Target Set:	0.109
The Average Mean Radius of the Five Target Set:	1.004
The Distance from POA to Centroid Target #1:	0.127
The Distance from Centroid Target #2 to Centroid Target #1:	0.225
The Distance from Centroid Target #3 to Centroid Target #1:	0.217
The Distance from Centroid Target #4 to Centroid Target #1:	0.493
The Distance from Centroid Target #5 to Centroid Target #1:	0.095

SERIAL NUMBER: G6361010. __0

TARGET NUMBER: 1

FILE DATE: 06/17/2004

FILE TIME: 07:04

POINT#	X	Y
1:	0.939	-1.043
2:	0.612	-0.728
3:	0.355	-0.261
4:	-0.145	-0.402
5:	-0.758	-0.324
6:	0.635	0.360
7:	-0.472	0.469
8:	-0.202	0.233
9:	0.146	0.699
10:	0.021	0.426

X CENTROID: 0.113

Y CENTROID: -0.057

POA TO CENTROID: 0.127

HORZ SPREAD: 1.697

VERT SPREAD: 1.742

GROUP SPREAD: 2.068

MIN RADIUS: 0.316

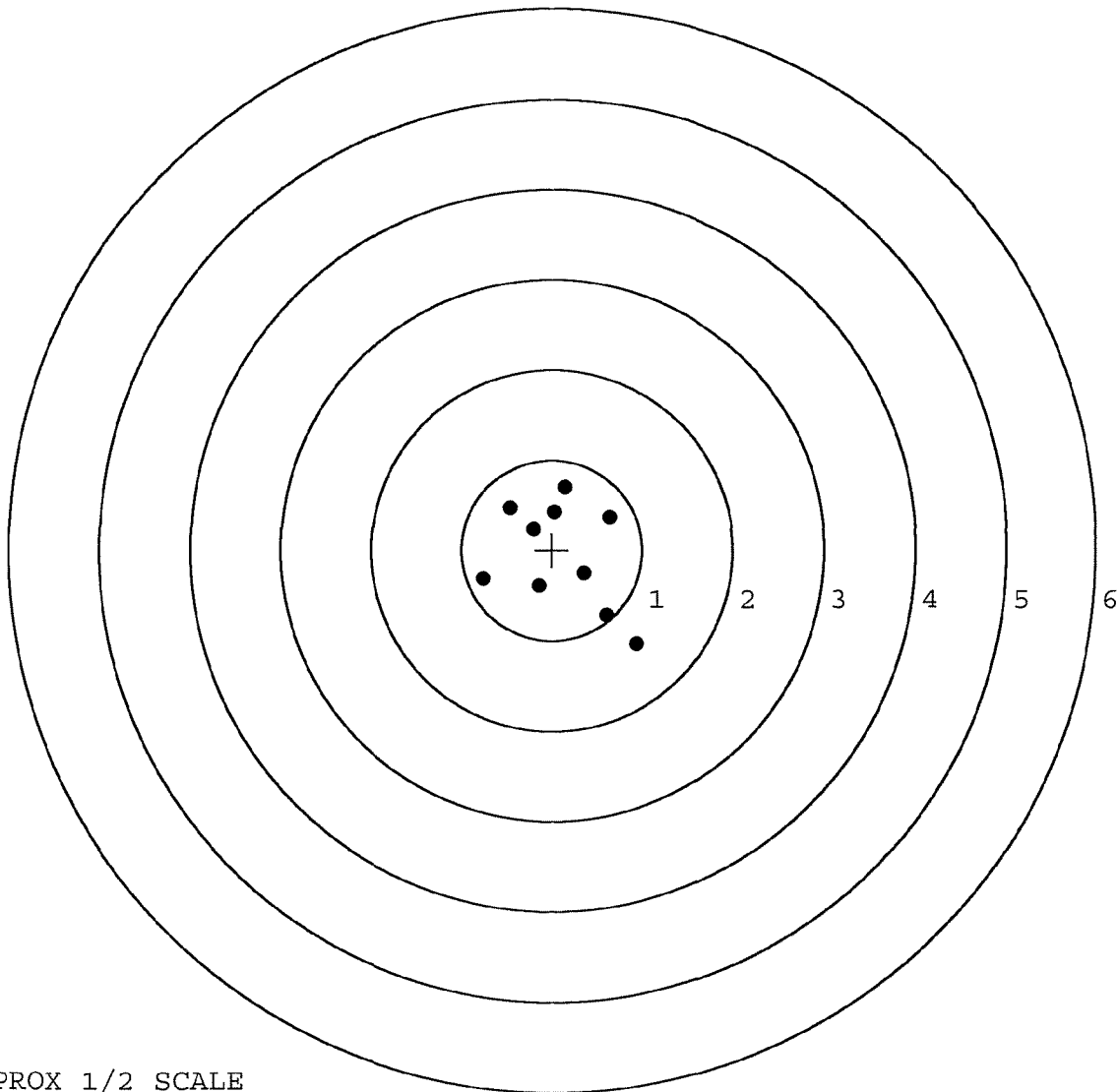
MAX RADIUS: 1.286

MEAN RADIUS: 0.691

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361010. __0

TARGET NUMBER: 2

FILE DATE: 06/17/2004

FILE TIME: 07:04

POINT#	X	Y
1:	0.023	2.580
2:	0.727	2.042
3:	-0.544	0.212
4:	0.071	0.036
5:	-0.317	-0.253
6:	0.159	-0.365
7:	0.548	-0.256
8:	0.720	-1.095
9:	0.637	-1.306
10:	-0.217	-0.021

X CENTROID: 0.181

Y CENTROID: 0.157

POA TO CENTROID: 0.240

HORZ SPREAD: 1.271

VERT SPREAD: 3.886

GROUP SPREAD: 3.934

MIN RADIUS: 0.164

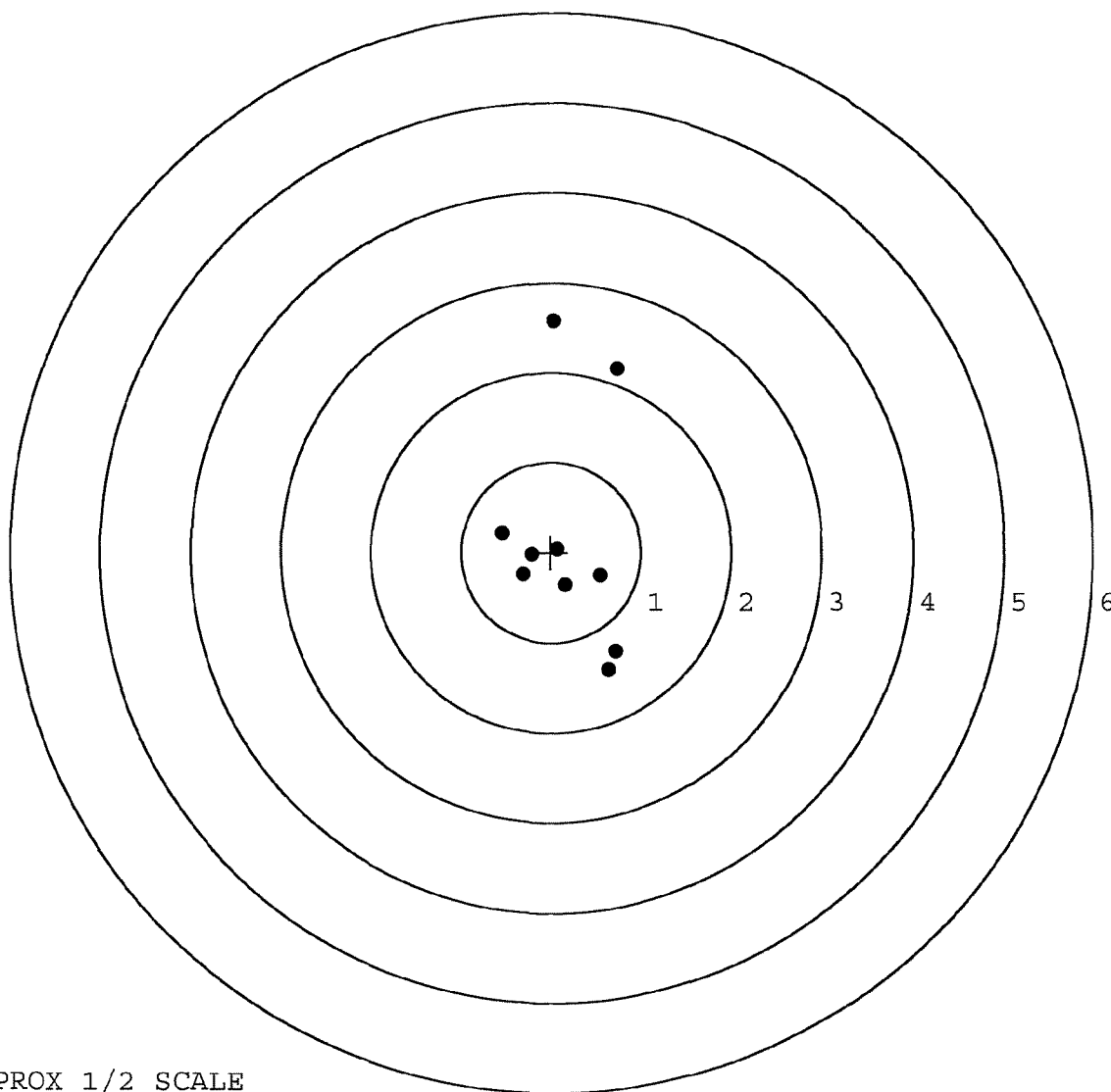
MAX RADIUS: 2.428

MEAN RADIUS: 1.033

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361010. __0

TARGET NUMBER: 3

FILE DATE: 06/17/2004

FILE TIME: 07:04

POINT#	X	Y
1:	0.611	1.124
2:	0.100	1.072
3:	0.521	0.373
4:	-0.527	0.556
5:	-0.594	-0.232
6:	0.196	-0.613
7:	-0.267	-0.946
8:	0.388	-1.674
9:	0.542	-1.739
10:	0.001	-0.657

X CENTROID: 0.097

Y CENTROID: -0.274

POA TO CENTROID: 0.290

HORZ SPREAD: 1.205

VERT SPREAD: 2.863

GROUP SPREAD: 2.864

MIN RADIUS: 0.354

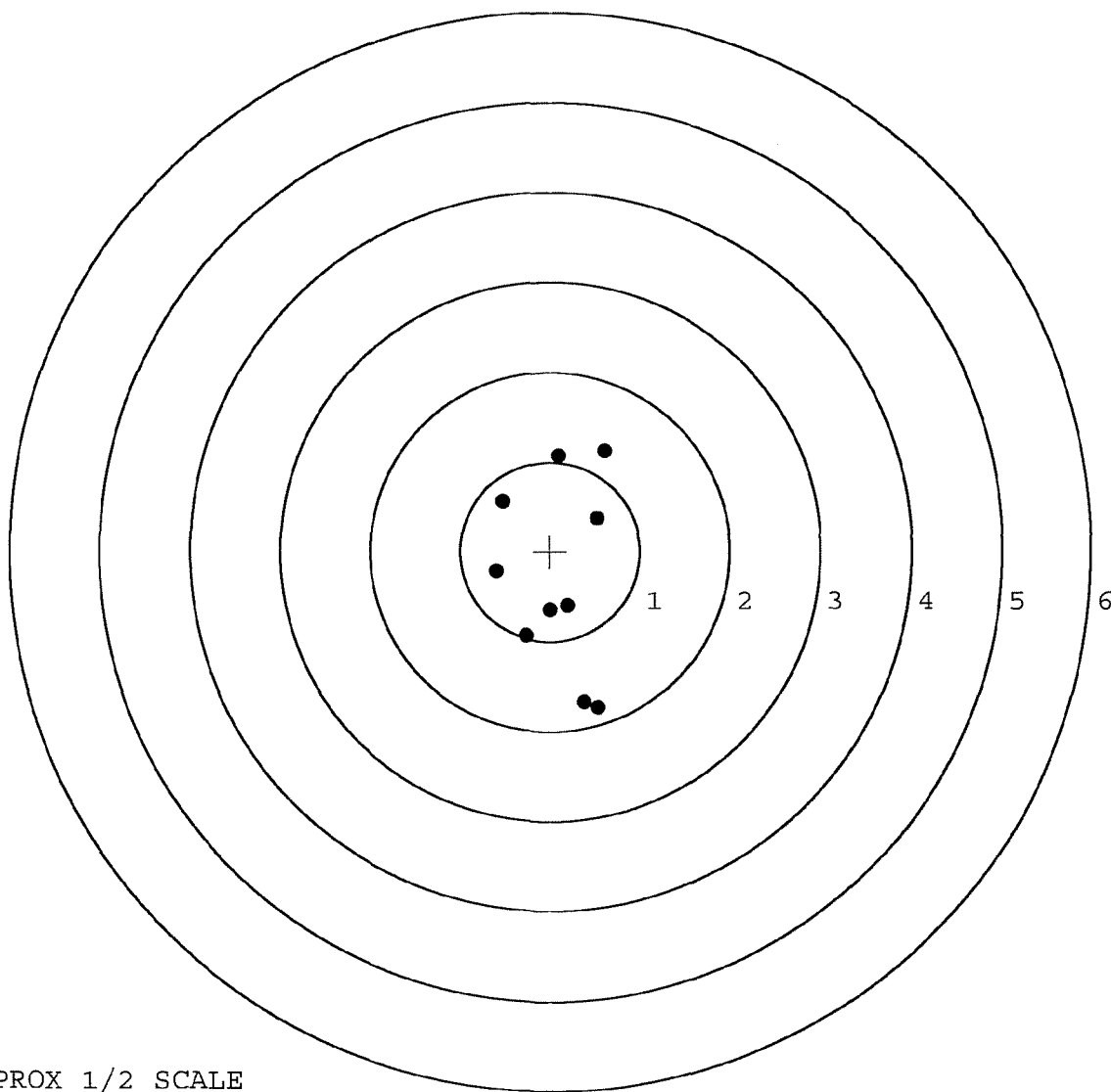
MAX RADIUS: 1.531

MEAN RADIUS: 0.981

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361010. __0

TARGET NUMBER: 4

FILE DATE: 06/17/2004

FILE TIME: 07:04

POINT#	X	Y
1:	-0.666	1.633
2:	-1.435	0.081
3:	-0.730	0.404
4:	-0.543	-0.006
5:	-0.199	0.051
6:	0.063	0.032
7:	0.110	-0.114
8:	0.452	-0.888
9:	0.061	-1.330
10:	-0.451	-2.508

X CENTROID: -0.334

Y CENTROID: -0.264

POA TO CENTROID: 0.426

HORZ SPREAD: 1.887

VERT SPREAD: 4.141

GROUP SPREAD: 4.147

MIN RADIUS: 0.333

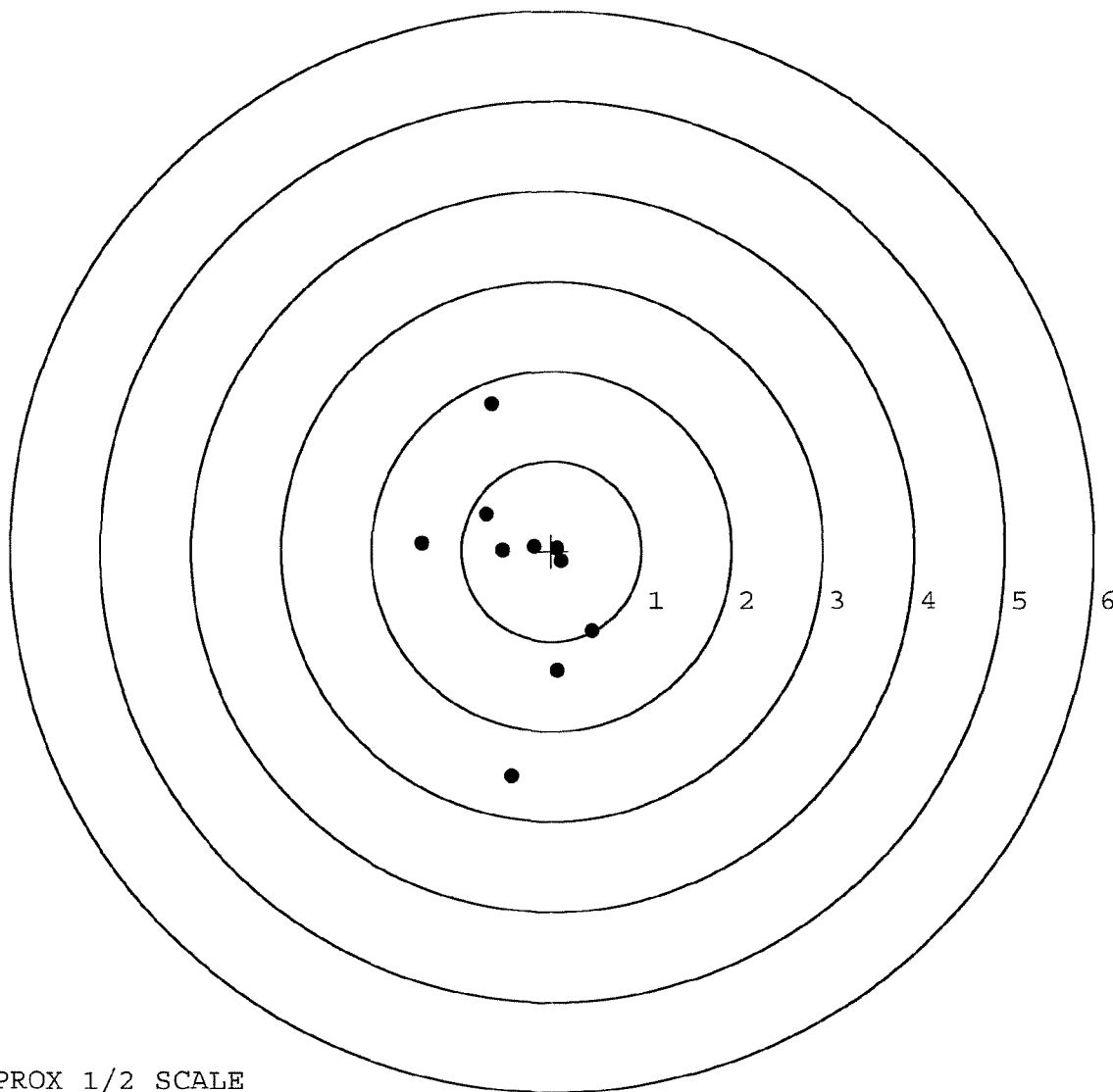
MAX RADIUS: 2.247

MEAN RADIUS: 0.988

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361010. __0

TARGET NUMBER: 5

FILE DATE: 06/17/2004

FILE TIME: 07:04

POINT#	X	Y
1:	0.167	1.947
2:	0.509	1.778
3:	0.006	1.148
4:	0.415	0.737
5:	0.381	0.391
6:	-0.316	-0.176
7:	-0.134	-1.006
8:	1.047	-1.338
9:	0.281	-2.162
10:	-0.291	-1.709

X CENTROID: 0.207

Y CENTROID: -0.039

POA TO CENTROID: 0.210

HORZ SPREAD: 1.363

VERT SPREAD: 4.109

GROUP SPREAD: 4.111

MIN RADIUS: 0.464

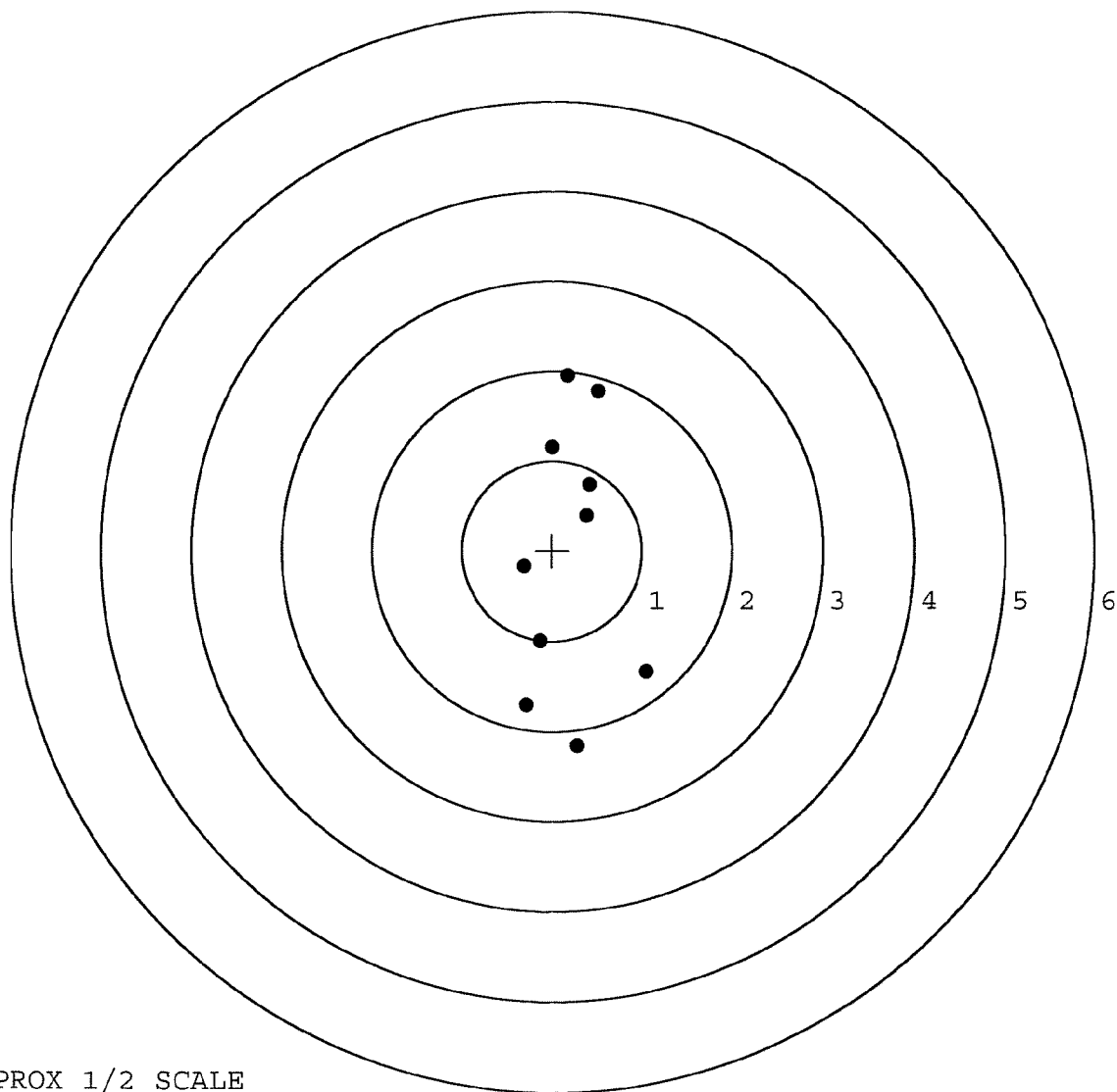
MAX RADIUS: 2.124

MEAN RADIUS: 1.328

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE