

G6361023

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

- INSTRUCTION BOOK 3518

DD FORM

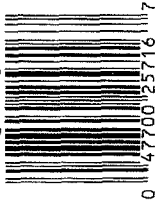
owner registration sticker



proof of purchase



UPC



G6361023

BARREL LENGTH 24"
CAPACITY 9

ORDER NO. 25716

VERY IMPORTANT Instruction Book accompanying this rifle is to be kept with it at all times.		SERIAL NO. G6361023	DD	25716	04WY
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM) BOLT ACTION CENTERFIRE RIFLE 24" BARREL 7.62 NATO					
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7/22/2004 3:19:29 PM

Crib

3

Original

25716

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



.MA25716

Shop Order: SWS628758



.ABWS628758

Start Date: 7/20/2004

Finish Date: 8/19/2004

0630

Flat Black Powder Coat, Barrel and

01PC001



0003338174

0640

Reassemble Action.

89SWS1



0003338175

0685

Attach Front and Rear Sight Assemblies

89SWS1



0003338180

0710

Pack Rifle & Stencil SWS Container

89SWS1



.OP0710

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6361023

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-6-04	RT
600	PROOF		4-6-04	RT
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	4-6-04	RT
610	DIS-ASSEMBLE GUN		4-6-04	RT
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 07 2004 OPERATOR <u>BR</u>		
615	ROLLMARK CALIBER		4/8/04	AB
617	DRILL AND TAP SIGHT HOLES			
620	APPLY COATINGS (BARREL ACTION)		5-7	TA
	(BOLT)		5-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-7-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-7-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-7-04	RW
	D) OIL FIRING PIN ASSEMBLY		6-7-04	RW
	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	<u>9⁰</u> <u>9⁰</u> <u>9⁰</u>	6-21-04	RZ
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.50</u> <u>2.50</u> <u>2.50</u>	6-21-04	RZ
	H) TRIGGER PULL TEST AND RETAINABILITY		6-21-04	RZ
	I) FIRING PIN INDENT .020 MIN	<u>022</u> <u>023</u> <u>022</u>	6-21-04	RZ
	J) ASSEMBLE STOCK		6-7-04	FW
	K) ASSEMBLE SWIVEL STUDS		6-28-04	RZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	6-10-04	AL
	MALFUNCTION	CORRECTION	6-10-04	AL
	MALFUNCTION	CORRECTION	6-10-04	AL
	MALFUNCTION	CORRECTION	6-10-04	AL
	MALFUNCTION	CORRECTION	6-10-04	AL
645	INSPECT FOR LIVE AMMO		6-10-04	AL
655	FINAL INSPECTION A) HEADSPACE		6-28-04	RZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>289</u> <u>286</u> <u>289</u> <u>294</u> <u>288</u>	6-21-04	RZ
	C) FUNCTION			
660	PACK		8-4-04	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 5-4-04

TESTER RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.49		2.45	
PULL #2	2.26	2.38		2.48	
PULL #3	2.23	2.36		2.40	
PULL #4	2.26	2.55		2.58	
PULL #5	2.26	2.46		2.59	
TOTAL	11.38	12.24		12.50	
AVERAGE	2.28	2.45		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.48		
PULL #2	3.43	3.44		
PULL #3	3.36	3.41		
PULL #4	3.27	3.16		
PULL #5	3.43	3.43		
TOTAL	16.90	16.92		
AVERAGE	3.38	3.38		

	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	4.06	4.14		4.02
PULL #2	4.19	4.07		4.26
PULL #3	4.17	4.18		4.36
PULL #4	4.09	4.24		4.39
PULL #5	4.20	4.20		4.17
TOTAL	20.71	20.83		21.20
AVERAGE	4.14	4.17		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361023.__0
FILE DATE AND TIME: 06/10/2004 06:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.067
The Average Y Centroid of the Five Target Set:	-0.155
The Average Point of Impact of the Five Target Set:	0.169
The Average Mean Radius of the Five Target Set:	0.671
The Distance from POA to Centroid Target #1:	0.245
The Distance from Centroid Target #2 to Centroid Target #1:	0.426
The Distance from Centroid Target #3 to Centroid Target #1:	0.260
The Distance from Centroid Target #4 to Centroid Target #1:	0.094
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: G6361023. 0

TARGET NUMBER: 1

FILE DATE: 06/10/2004

FILE TIME: 06:29

X CENTROID: 0.040

Y CENTROID: -0.242

POA TO CENTROID: 0.245

HORZ SPREAD: 1.255

VERT SPREAD: 2.411

GROUP SPREAD: 2.523

MIN RADIUS: 0.254

MAX RADIUS: 1.420

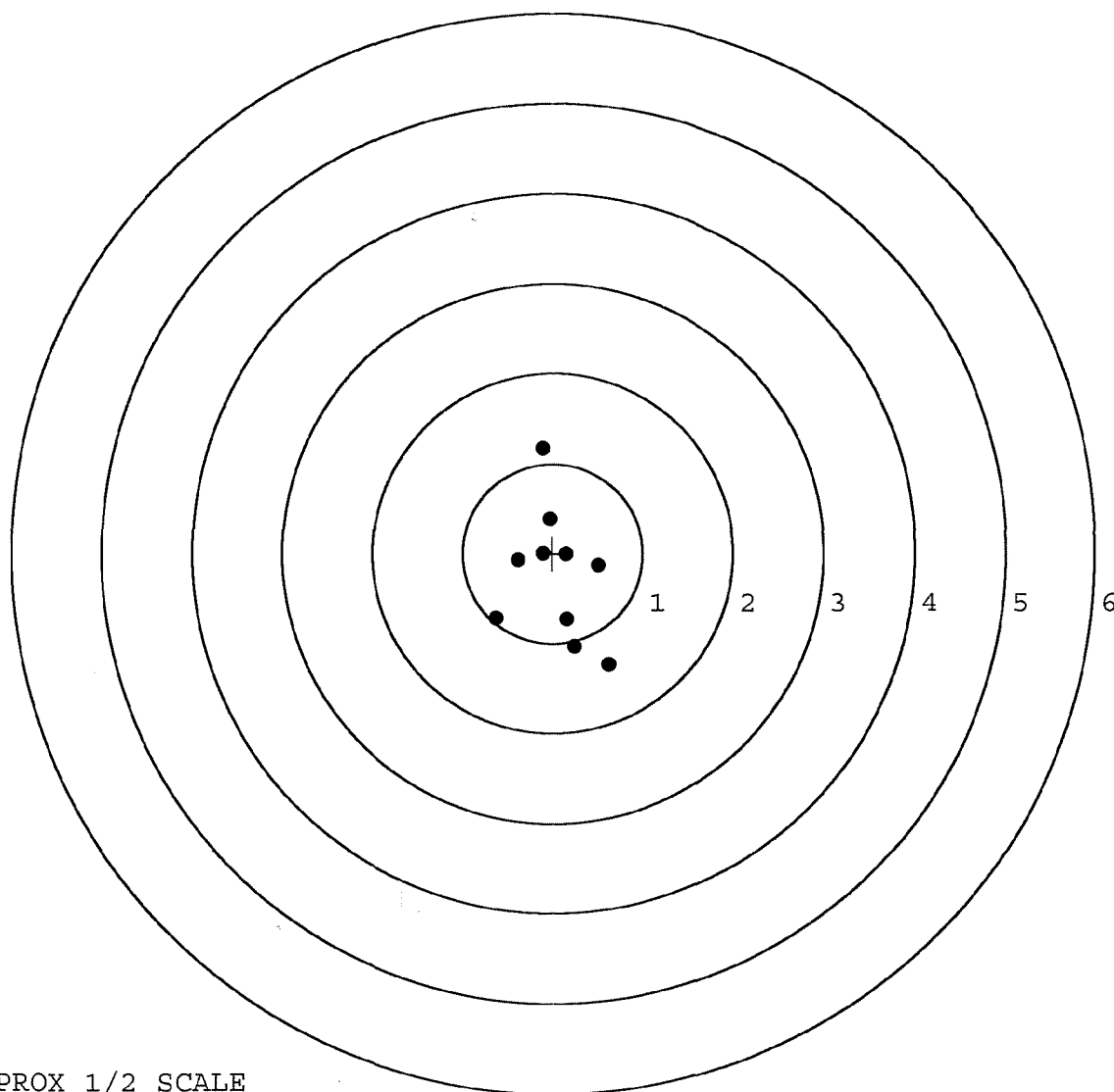
MEAN RADIUS: 0.684

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.116	1.169
2:	0.508	-0.135
3:	-0.038	0.385
4:	-0.391	-0.079
5:	-0.110	-0.004
6:	0.150	-0.013
7:	-0.629	-0.723
8:	0.157	-0.736
9:	0.244	-1.042
10:	0.626	-1.242



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361023. __0

TARGET NUMBER: 2

FILE DATE: 06/10/2004

FILE TIME: 06:29

POINT#	X	Y
1:	-2.097	-1.241
2:	0.560	0.011
3:	0.143	-0.260
4:	0.179	-0.736
5:	-0.288	-0.957
6:	-0.370	0.895
7:	-0.792	0.083
8:	-0.151	0.256
9:	-0.384	0.523
10:	-0.441	0.347

X CENTROID: -0.364

Y CENTROID: -0.108

POA TO CENTROID: 0.380

HORZ SPREAD: 2.657

VERT SPREAD: 2.136

GROUP SPREAD: 2.937

MIN RADIUS: 0.422

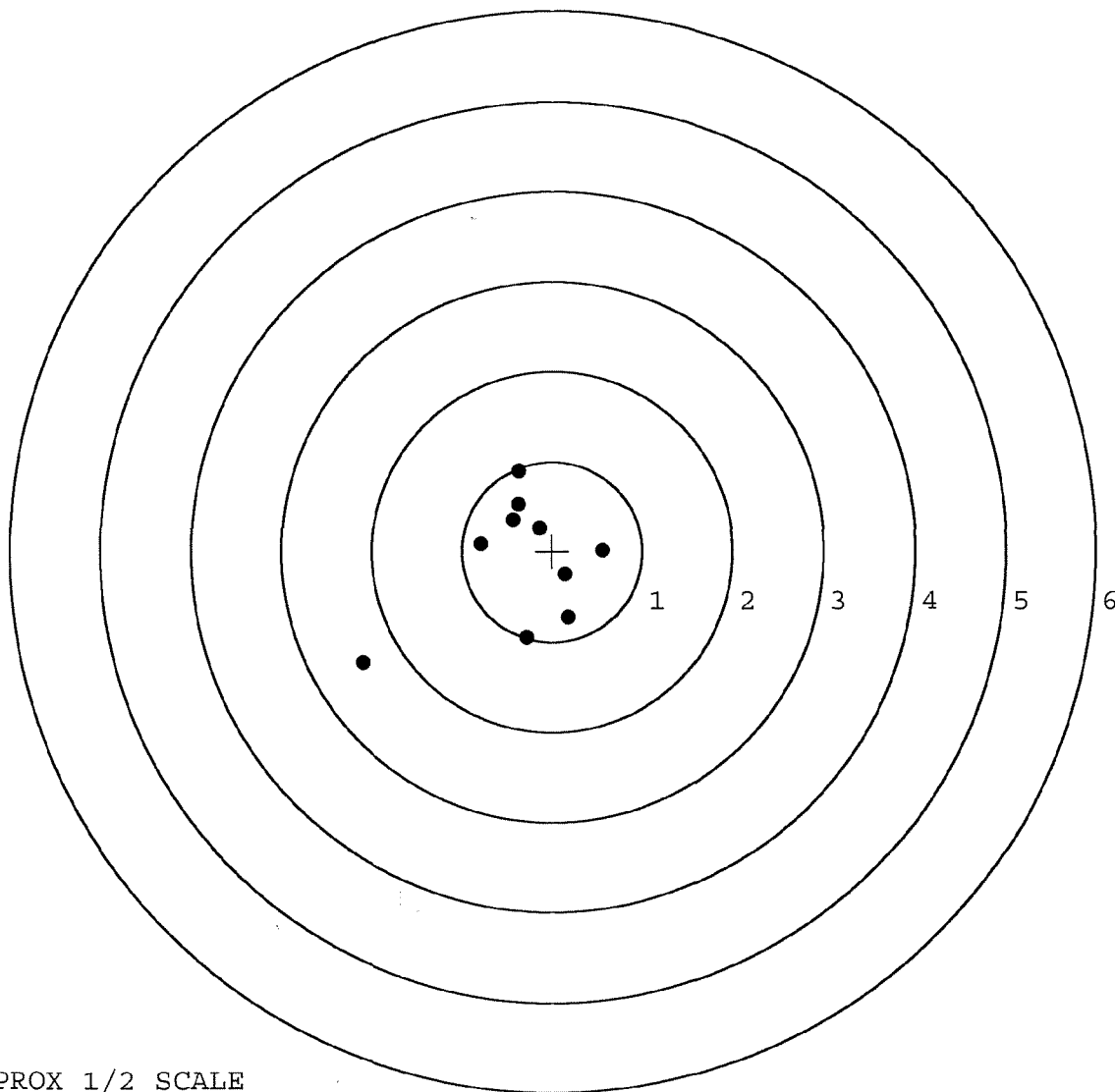
MAX RADIUS: 2.070

MEAN RADIUS: 0.820

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361023._0

TARGET NUMBER: 3

FILE DATE: 06/10/2004

FILE TIME: 06:29

X CENTROID: 0.114

Y CENTROID: 0.007

POA TO CENTROID: 0.114

HORZ SPREAD: 1.156

VERT SPREAD: 2.201

GROUP SPREAD: 2.266

MIN RADIUS: 0.043

MAX RADIUS: 1.222

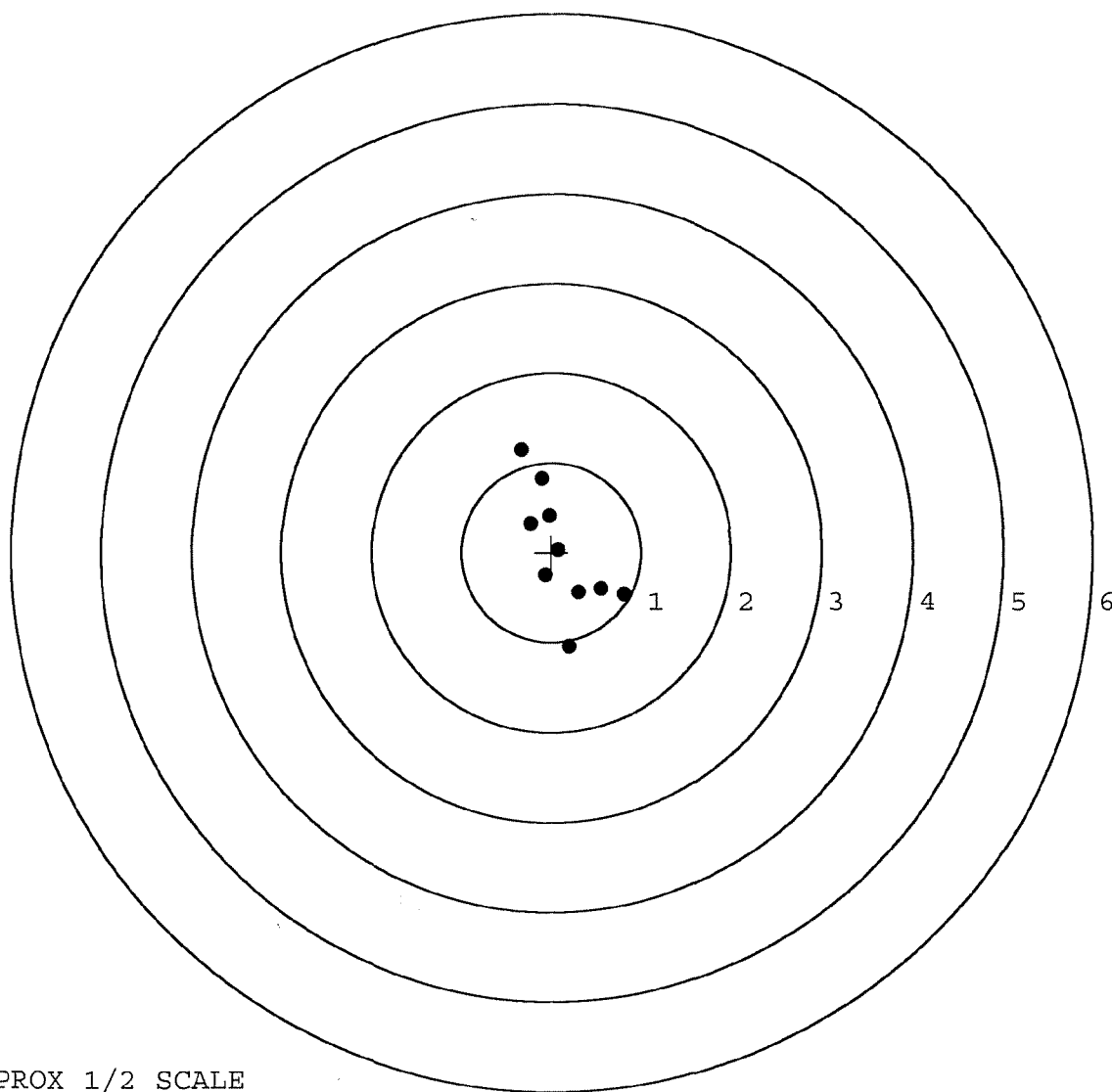
MEAN RADIUS: 0.636

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.343	1.141
2:	-0.115	0.821
3:	-0.243	0.322
4:	-0.030	0.410
5:	0.076	0.027
6:	-0.071	-0.259
7:	0.303	-0.448
8:	0.554	-0.410
9:	0.813	-0.473
10:	0.195	-1.060



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361023. __0

TARGET NUMBER: 4

FILE DATE: 06/10/2004

FILE TIME: 06:29

POINT#	X	Y
1:	-0.319	0.440
2:	-0.779	-0.533
3:	-0.439	-0.664
4:	-0.515	-0.121
5:	-0.305	0.191
6:	0.044	0.015
7:	0.192	-0.384
8:	0.848	-0.375
9:	0.654	-0.178
10:	0.380	-0.117

X CENTROID: -0.024

Y CENTROID: -0.173

POA TO CENTROID: 0.174

HORZ SPREAD: 1.627

VERT SPREAD: 1.104

GROUP SPREAD: 1.635

MIN RADIUS: 0.200

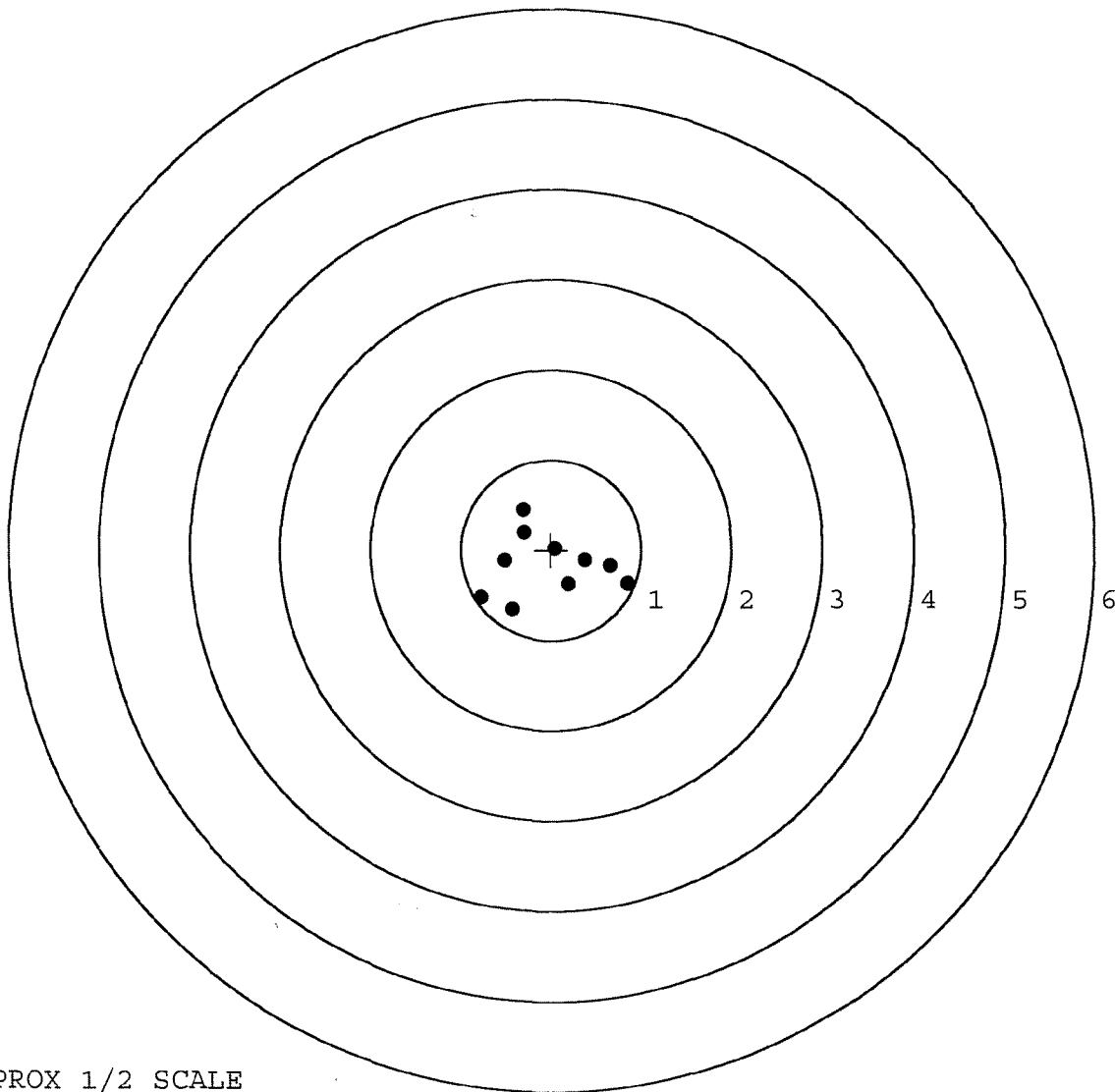
MAX RADIUS: 0.895

MEAN RADIUS: 0.560

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361023. __0

TARGET NUMBER: 5

FILE DATE: 06/10/2004

FILE TIME: 06:29

X CENTROID: -0.101

Y CENTROID: -0.261

POA TO CENTROID: 0.279

HORZ SPREAD: 1.210

VERT SPREAD: 1.707

GROUP SPREAD: 1.850

MIN RADIUS: 0.208

MAX RADIUS: 1.120

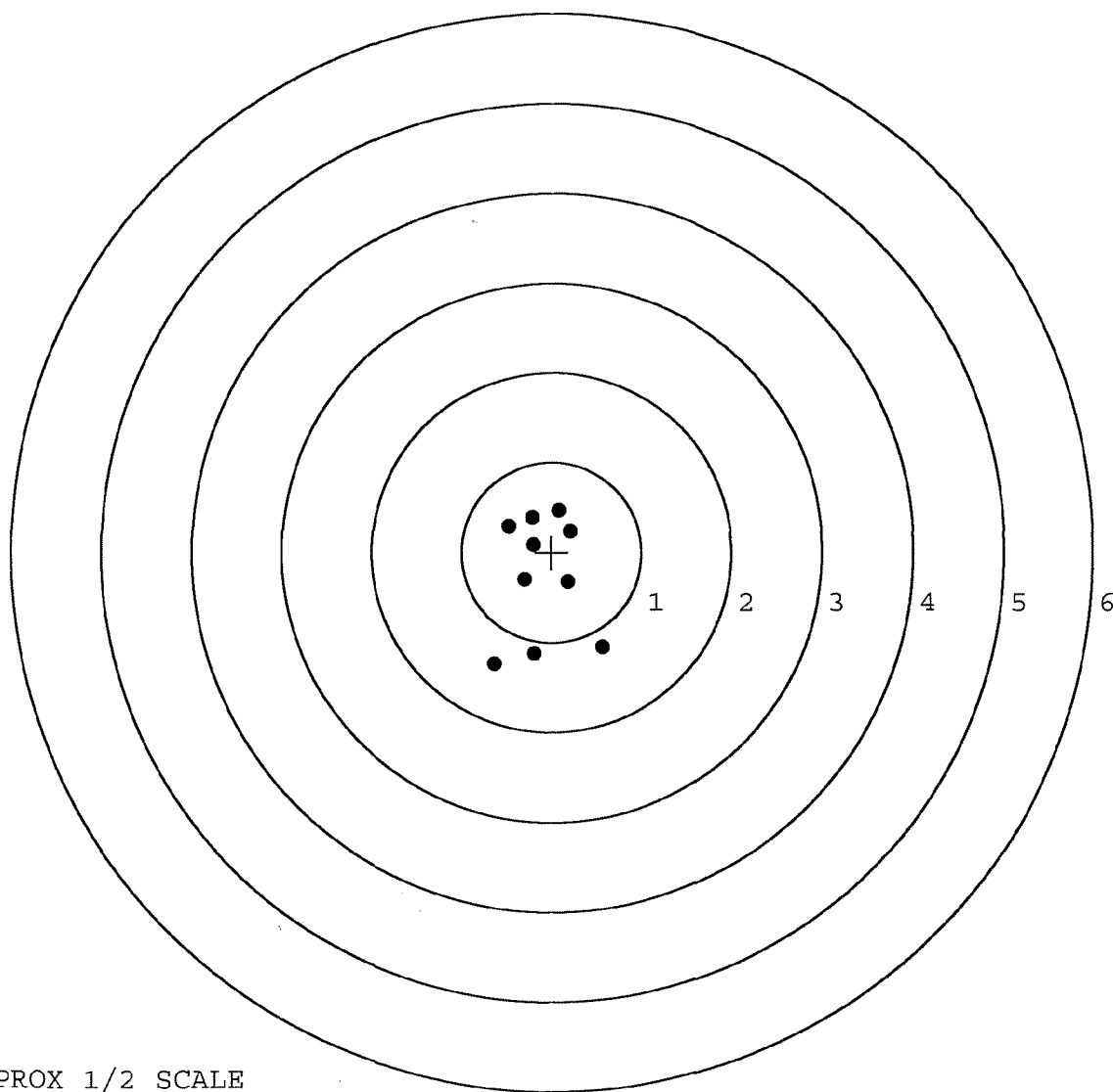
MEAN RADIUS: 0.655

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.572	-1.058
2:	-0.197	-1.127
3:	-0.638	-1.244
4:	0.184	-0.327
5:	0.210	0.229
6:	-0.305	-0.302
7:	-0.206	0.082
8:	-0.486	0.293
9:	-0.221	0.386
10:	0.075	0.463



TARGET APPROX 1/2 SCALE