

G6360969

25716

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



.MA25716

Shop Order: SWS631059



.ABSWS631059

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

proof of purchase



owner registration sticker



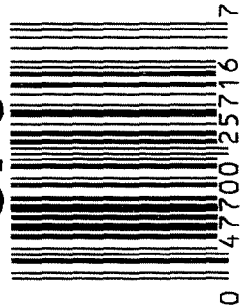
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6360969

UPC



DD FORM

M2400083208

7/22/2004 3:21:04 PM

CRIB

45

Original

25716

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



.MA25716

Shop Order: SWS631055



.ABSWS631055

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 # G6360969

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		3-25-04	RTL
600	PROOF		3-25-04	RTL
607	CHECK HEADSPACE		3-25-04	RTL
610	DIS-ASSEMBLE GUN		3-25-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	BK		
615	ROLLMARK CALIBER		3/25/04	AB
617	DRILL AND TAP SIGHT HOLES		3-25-04	RTL
620	APPLY COATINGS (BARREL ACTION)		4-21	TA
	(BOLT)		4-21	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-20-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-20-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-20-04	RW
	D) OIL FIRING PIN ASSEMBLY		5-20-04	RW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	RW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9.0</u> <u>9.0</u> <u>9.5</u>	6/2/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	6/2/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		6-2-04	RJR
	I) FIRING PIN INDENT .020 MIN	<u>1.020</u> <u>1.020</u> <u>1.020</u>	6/2/04	DA
	J) ASSEMBLE STOCK		5-20-04	RD
	K) ASSEMBLE SWIVEL STUDS		6-22-04	RJR
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-13-04	RJR
	M) IRON SIGHT ALIGNMENT		8-13-04	RJR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-13-04	RJR
640	GALLERY TEST AND TARGET	PASS FAIL	5-27-04	A
	MALFUNCTION	CORRECTION	5-27-04	A
	MALFUNCTION	CORRECTION	5-27-04	A
	MALFUNCTION	CORRECTION	5-27-04	A
	MALFUNCTION	CORRECTION	5-27-04	A
645	INSPECT FOR LIVE AMMO		5-27-04	A
655	FINAL INSPECTION A) HEADSPACE		6-22-04	RJR
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>266</u> <u>265</u> <u>260</u> <u>279</u> <u>288</u>	6/2/04	DA
	C) FUNCTION			
660	PACK		9/6/04	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

6-1-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.42	2.87		2.86	
PULL #2	2.79	2.48		2.86	
PULL #3	2.42	2.82		2.95	
PULL #4	2.58	2.80		2.60	
PULL #5	2.59	2.59		2.55	
TOTAL	12.80	13.56		13.82	
AVERAGE	2.56	2.71		2.76	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.49	3.36		
PULL #2	3.47	3.59		
PULL #3	3.66	3.54		
PULL #4	3.52	3.68		
PULL #5	3.61	3.68		
TOTAL	17.75	17.85		
AVERAGE	3.55	3.57		

	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	4.21	4.23		4.11
PULL #2	4.04	4.20		4.15
PULL #3	4.20	4.18		4.11
PULL #4	4.15	4.17		4.18
PULL #5	4.21	4.32		4.14
TOTAL	20.81	21.10		20.69
AVERAGE	4.16	4.22		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360969.___0
FILE DATE AND TIME: 05/27/2004 06:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.099
The Average Y Centroid of the Five Target Set:	0.023
The Average Point of Impact of the Five Target Set:	0.102
The Average Mean Radius of the Five Target Set:	0.803
The Distance from POA to Centroid Target #1:	0.040
The Distance from Centroid Target #2 to Centroid Target #1:	0.180
The Distance from Centroid Target #3 to Centroid Target #1:	0.234
The Distance from Centroid Target #4 to Centroid Target #1:	0.093
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: G6360969. __0

TARGET NUMBER: 1

FILE DATE: 05/27/2004

FILE TIME: 06:13

POINT#	X	Y
1:	0.886	-1.062
2:	1.115	1.026
3:	0.136	1.524
4:	0.267	0.165
5:	-0.028	0.506
6:	-0.536	0.357
7:	-0.927	-0.694
8:	-0.381	-0.219
9:	-0.381	-0.572
10:	-0.120	-0.628

X CENTROID: 0.003

Y CENTROID: 0.040

POA TO CENTROID: 0.040

HORZ SPREAD: 2.042

VERT SPREAD: 2.586

GROUP SPREAD: 2.693

MIN RADIUS: 0.292

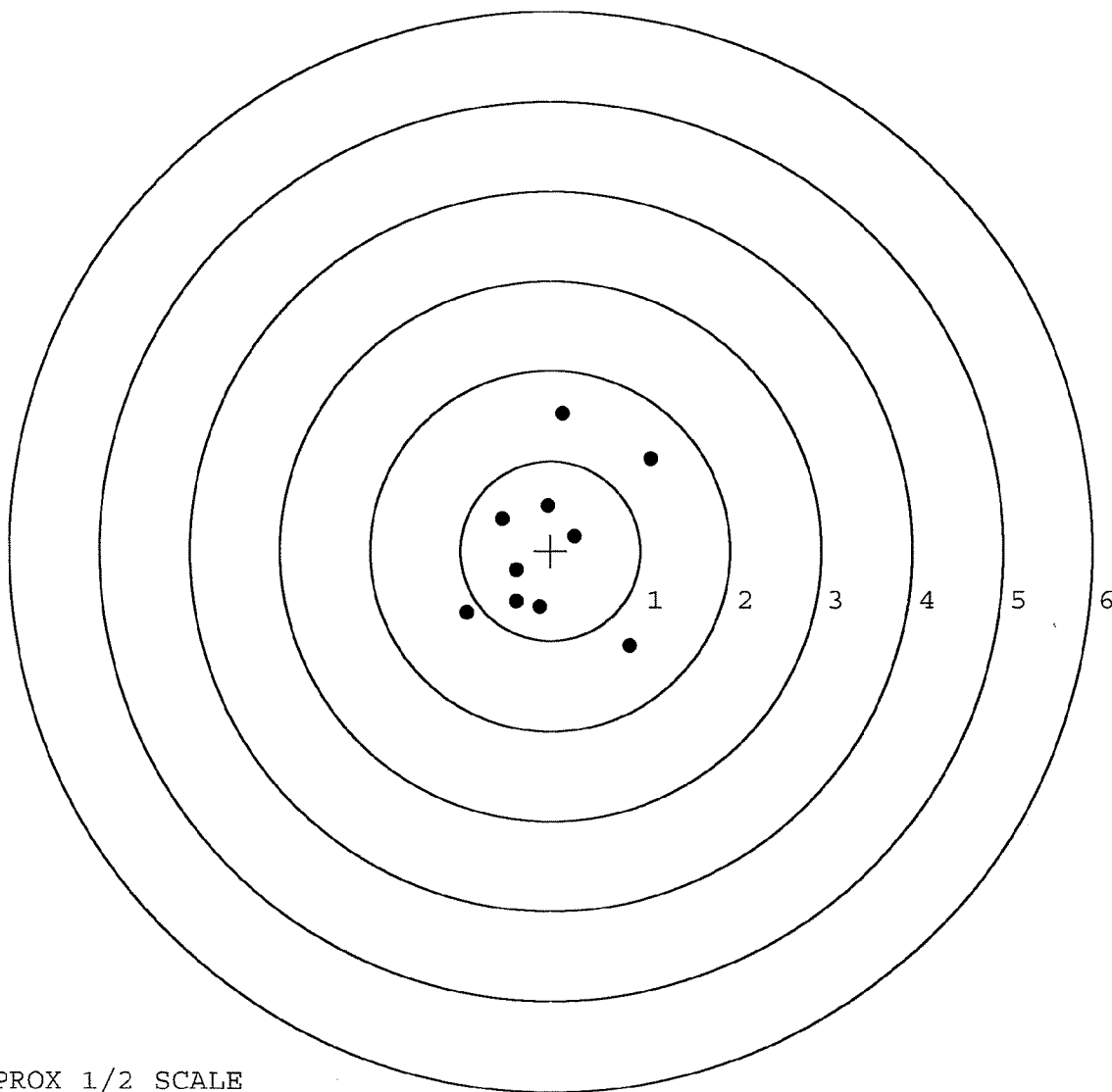
MAX RADIUS: 1.490

MEAN RADIUS: 0.882

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360969. 0

TARGET NUMBER: 2

FILE DATE: 05/27/2004

FILE TIME: 06:13

X CENTROID: -0.048

Y CENTROID: -0.132

POA TO CENTROID: 0.141

HORZ SPREAD: 1.577

VERT SPREAD: 3.254

GROUP SPREAD: 3.508

MIN RADIUS: 0.046

MAX RADIUS: 1.825

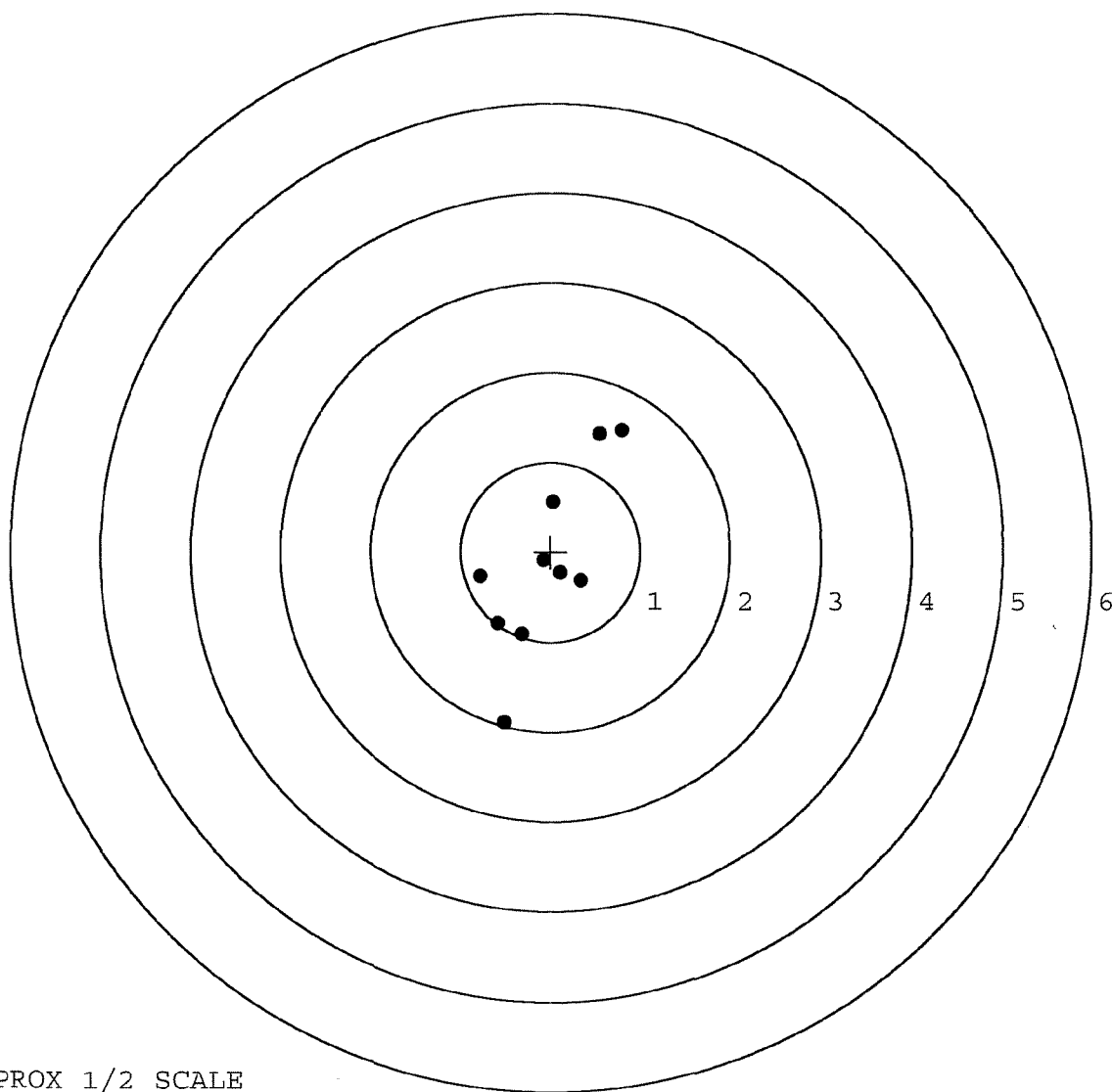
MEAN RADIUS: 0.890

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.792	1.358
2:	0.543	1.316
3:	0.026	0.556
4:	0.338	-0.326
5:	0.111	-0.237
6:	-0.081	-0.100
7:	-0.785	-0.279
8:	-0.587	-0.798
9:	-0.324	-0.919
10:	-0.518	-1.896



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360969. __0

TARGET NUMBER: 3

FILE DATE: 05/27/2004

FILE TIME: 06:13

POINT#	X	Y
1:	-0.151	-1.378
2:	0.200	-0.683
3:	-1.184	-0.199
4:	-0.836	0.639
5:	-0.834	1.577
6:	0.165	0.718
7:	0.451	-0.012
8:	0.181	0.229
9:	-0.085	0.148
10:	-0.170	-0.174

X CENTROID: -0.226

Y CENTROID: 0.086

POA TO CENTROID: 0.242

HORZ SPREAD: 1.635

VERT SPREAD: 2.955

GROUP SPREAD: 3.033

MIN RADIUS: 0.154

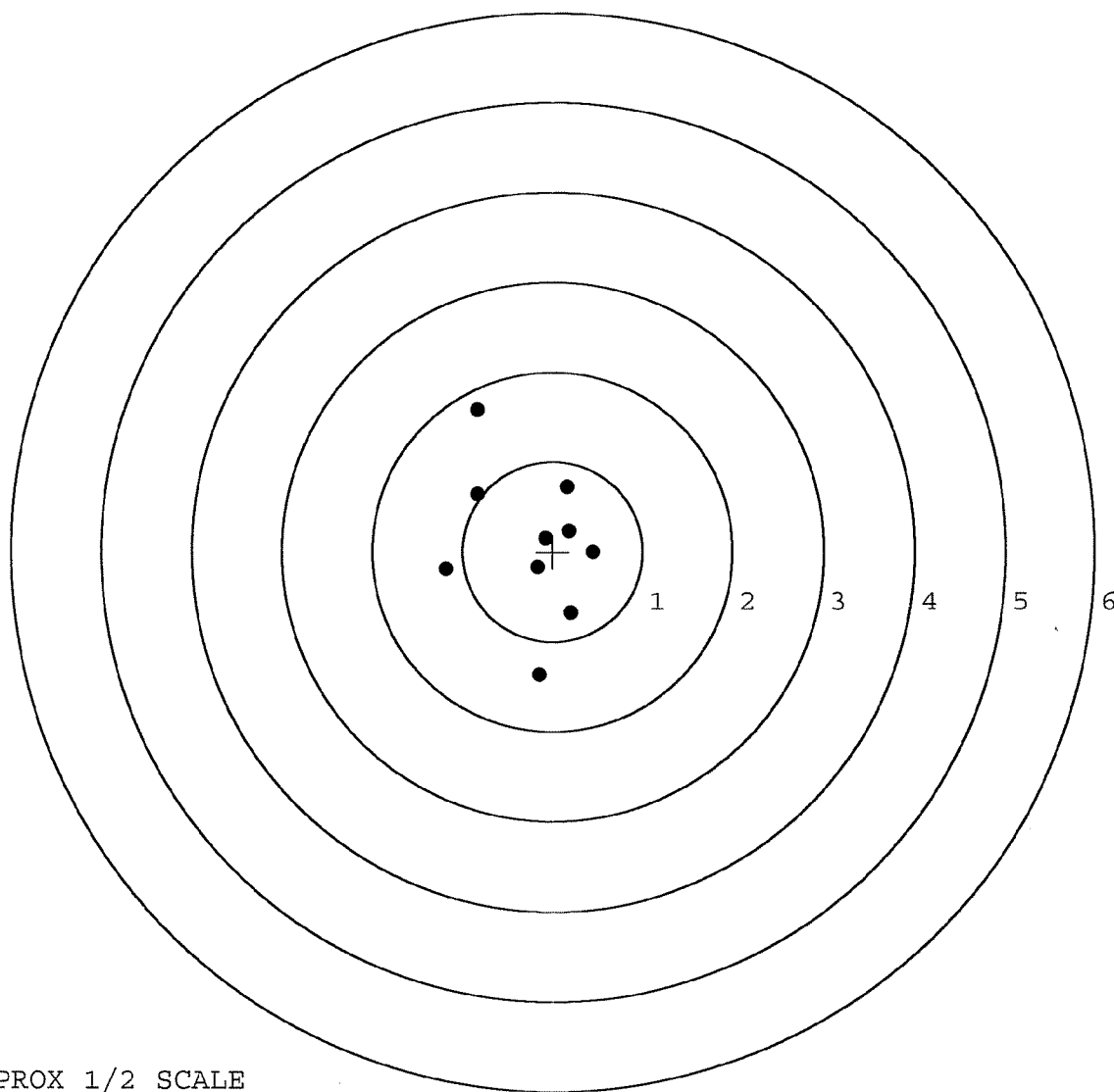
MAX RADIUS: 1.610

MEAN RADIUS: 0.806

IN 1 IN DIAMETER: 3

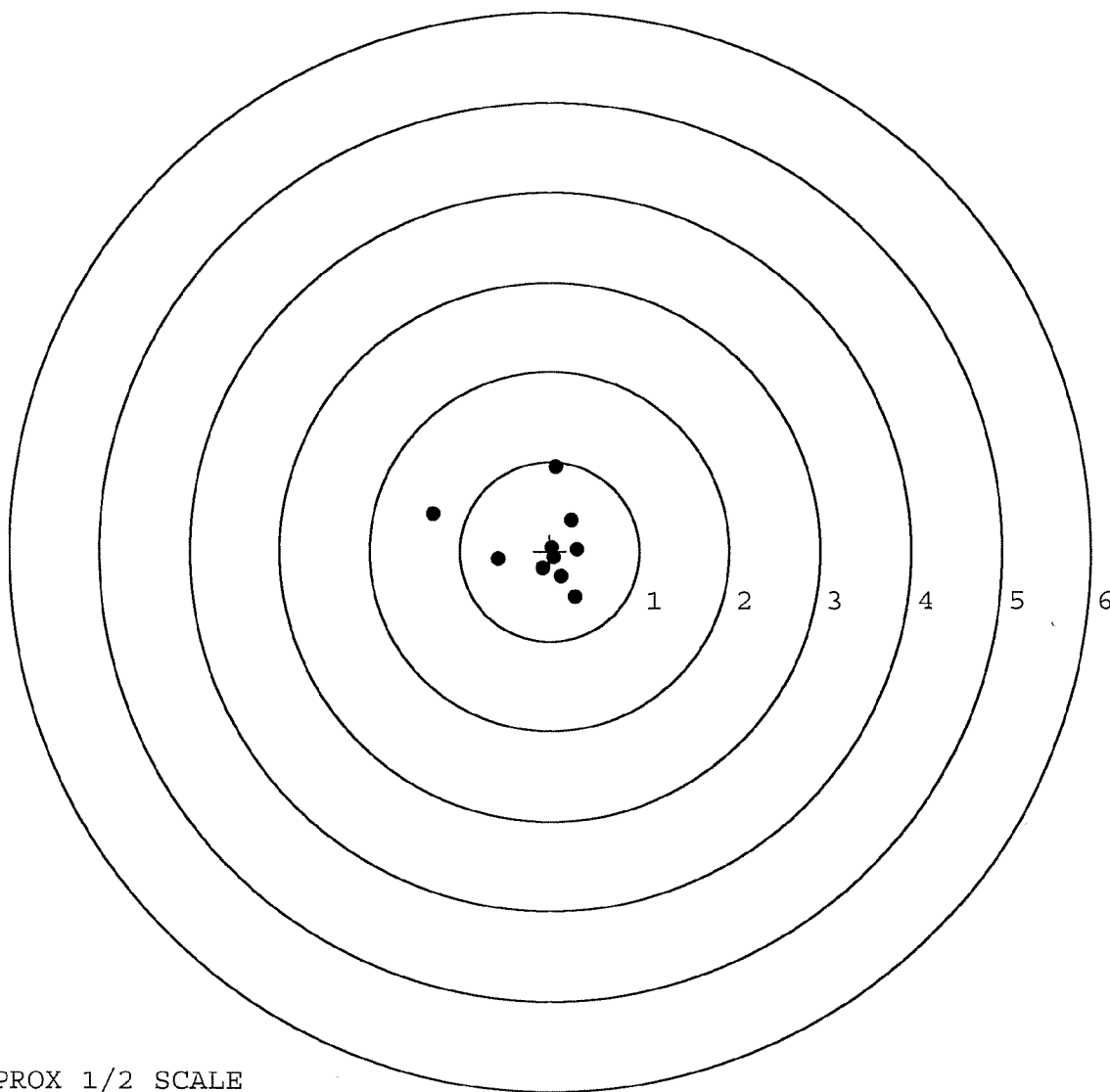
IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360969. 0	POINT#	X	Y
TARGET NUMBER: 4	1:	0.068	0.945
FILE DATE: 05/27/2004	2:	-1.295	0.423
FILE TIME: 06:13	3:	0.283	-0.512
	4:	-0.575	-0.091
X CENTROID: -0.087	5:	0.240	0.353
Y CENTROID: 0.064	6:	0.023	0.041
POA TO CENTROID: 0.108	7:	0.301	0.023
HORZ SPREAD: 1.596	8:	-0.086	-0.190
VERT SPREAD: 1.457	9:	0.131	-0.284
GROUP SPREAD: 1.834	10:	0.040	-0.072
MIN RADIUS: 0.112			
MAX RADIUS: 1.260			
MEAN RADIUS: 0.514			
# IN 1 IN DIAMETER: 6			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360969. 0

TARGET NUMBER: 5

FILE DATE: 05/27/2004

FILE TIME: 06:13

POINT#	X	Y
1:	-0.293	-1.501
2:	0.487	-1.008
3:	0.154	-0.565
4:	0.220	0.124
5:	-0.167	0.033
6:	-0.522	0.033
7:	-1.525	0.048
8:	0.495	0.717
9:	-0.365	1.103
10:	0.133	1.608

X CENTROID: -0.138

Y CENTROID: 0.059

POA TO CENTROID: 0.150

HORZ SPREAD: 2.020

VERT SPREAD: 3.109

GROUP SPREAD: 3.138

MIN RADIUS: 0.039

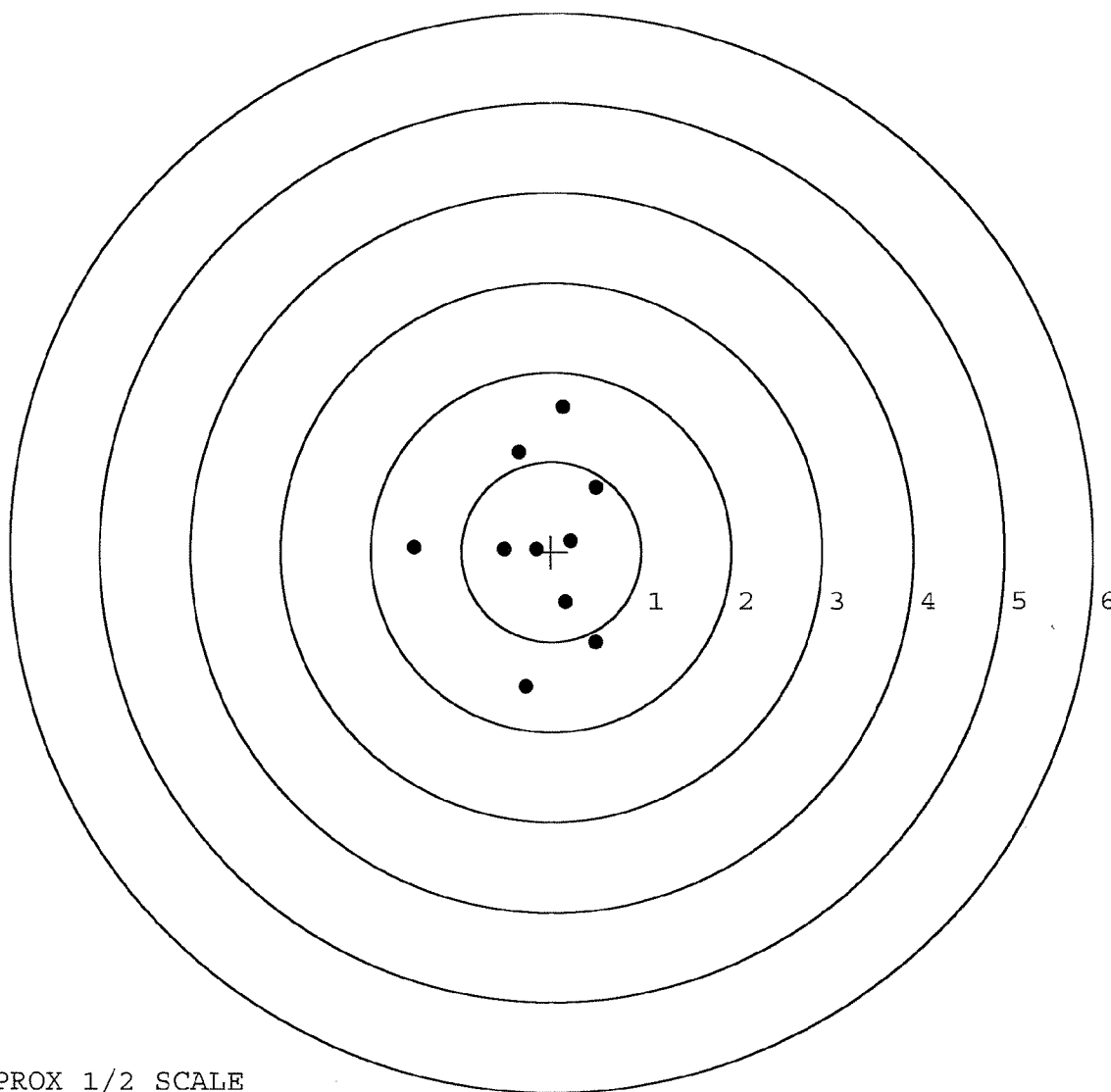
MAX RADIUS: 1.572

MEAN RADIUS: 0.922

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE