

G6360899

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

— INSTRUCTION BOOK 3518

DD FORM 1651



ORDER NO. 25727

BARREL LENGTH 24"

CAPACITY 5

G6360899



ORDER 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)

UPC



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M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)

UPC



SERIAL NO.



25727

M/24 7.62 NATO (RIFLE W/SCOPE&SIGHTS)

**.MA25727**

Shop Order: SWS667663A

**.ABSWS667663A**

Start Date: 12/17/2004

Finish Date: 1/12/2005

0540

01PC001

Flat Black Powder Coat, Barrel and

**0003592015**

0560

89SWS1

Reassemble Action.

**0003592016**

0690

89SWS1

Pack Rifle

**0003592027**

0700

89SWS1

Stencil SWS Container

**.OP0700**

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 636 0899

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-1-04	RJL
600	PROOF		4-1-04	RJL
607	CHECK HEADSPACE		4-1-04	RJL
610	DIS-ASSEMBLE GUN		4-1-04	RJL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	MAGNAFLUX INSPECTED APR 03 2004 OPERATOR RJL		
615	ROLLMARK CALIBER		4/5/04	LB
617	DRILL AND TAP SIGHT HOLES		4-2-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		4-7	TA
	(BOLT)		4-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-28-04	RJL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-28-04	RJL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-28-04	RJL
	D) OIL FIRING PIN ASSEMBLY		4-28-04	RJL
	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>5.5</u> <u>5.5</u> <u>5.5</u>	6/1/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	4/1/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.023</u> <u>1.022</u> <u>1.022</u>	4/1/04	DA
	J) ASSEMBLE STOCK		4-28-04	RTL
	K) ASSEMBLE SWIVEL STUDS		6-9-04	KW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-28-04	RTL
	M) IRON SIGHT ALIGNMENT		4-28-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-28-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-25-04	TRW
	MALFUNCTION	CORRECTION	5-25-04	TRW
	MALFUNCTION	CORRECTION	5-25-04	TRW
	MALFUNCTION	CORRECTION	5-25-04	TRW
	MALFUNCTION	CORRECTION	5-25-04	TRW
645	INSPECT FOR LIVE AMMO		5-25-04	TRW
655	FINAL INSPECTION A) HEADSPACE		6-9-04	KW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u> <u>2.82</u> <u>2.81</u> <u>2.88</u> <u>2.84</u>	6/1/04	DA
	C) FUNCTION		6-9-04	KW
660	PACK		12/17/04	DA

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE

4-20-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER

LW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.39	2.43		2.45	
PULL #2	2.23	2.39		2.44	
PULL #3	2.19	2.41		2.43	
PULL #4	2.22	2.37		2.47	
PULL #5	2.23	2.40		2.40	
TOTAL	11.26	12.00		12.19	
AVERAGE	2.25	2.40		2.44	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.05	3.00		
PULL #2	3.00	3.02		
PULL #3	3.02	3.03		
PULL #4	3.02	3.06		
PULL #5	3.04	3.04		
TOTAL	15.13	15.15		
AVERAGE	3.03	3.03		

	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	4.29	4.13		4.27
PULL #2	4.31	4.19		4.32
PULL #3	4.31	4.20		4.17
PULL #4	4.36	4.15		4.30
PULL #5	4.26	4.10		4.16
TOTAL	21.53	20.77		21.22
AVERAGE	4.31	4.15		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360899.___0
FILE DATE AND TIME: 05/25/2004 07:01

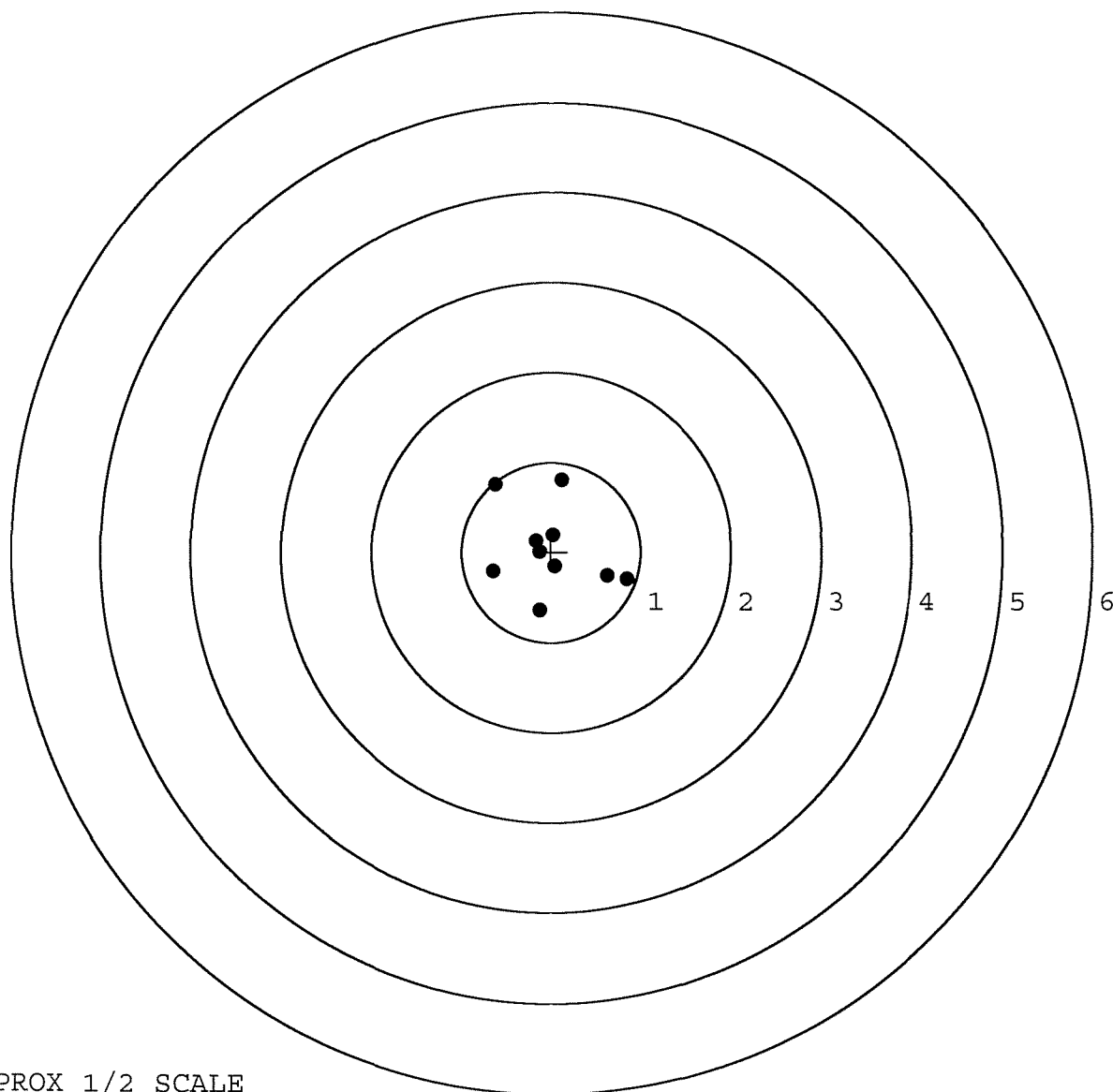
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.012
The Average Y Centroid of the Five Target Set:	-0.063
The Average Point of Impact of the Five Target Set:	0.064
The Average Mean Radius of the Five Target Set:	0.663
The Distance from POA to Centroid Target #1:	0.028
The Distance from Centroid Target #2 to Centroid Target #1:	0.208
The Distance from Centroid Target #3 to Centroid Target #1:	0.235
The Distance from Centroid Target #4 to Centroid Target #1:	0.058
The Distance from Centroid Target #5 to Centroid Target #1:	0.054

SERIAL NUMBER: G6360899.____0
 TARGET NUMBER: 1
 FILE DATE: 05/25/2004
 FILE TIME: 07:01

X CENTROID: -0.004
 Y CENTROID: 0.027
 POA TO CENTROID: 0.028
 HORZ SPREAD: 1.503
 VERT SPREAD: 1.457
 GROUP SPREAD: 1.821
 MIN RADIUS: 0.130
 MAX RADIUS: 0.958
 MEAN RADIUS: 0.542
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.851	-0.311
2:	0.628	-0.267
3:	-0.127	-0.651
4:	-0.652	-0.214
5:	0.116	0.806
6:	-0.623	0.759
7:	0.025	0.190
8:	-0.167	0.125
9:	0.041	-0.162
10:	-0.131	-0.002

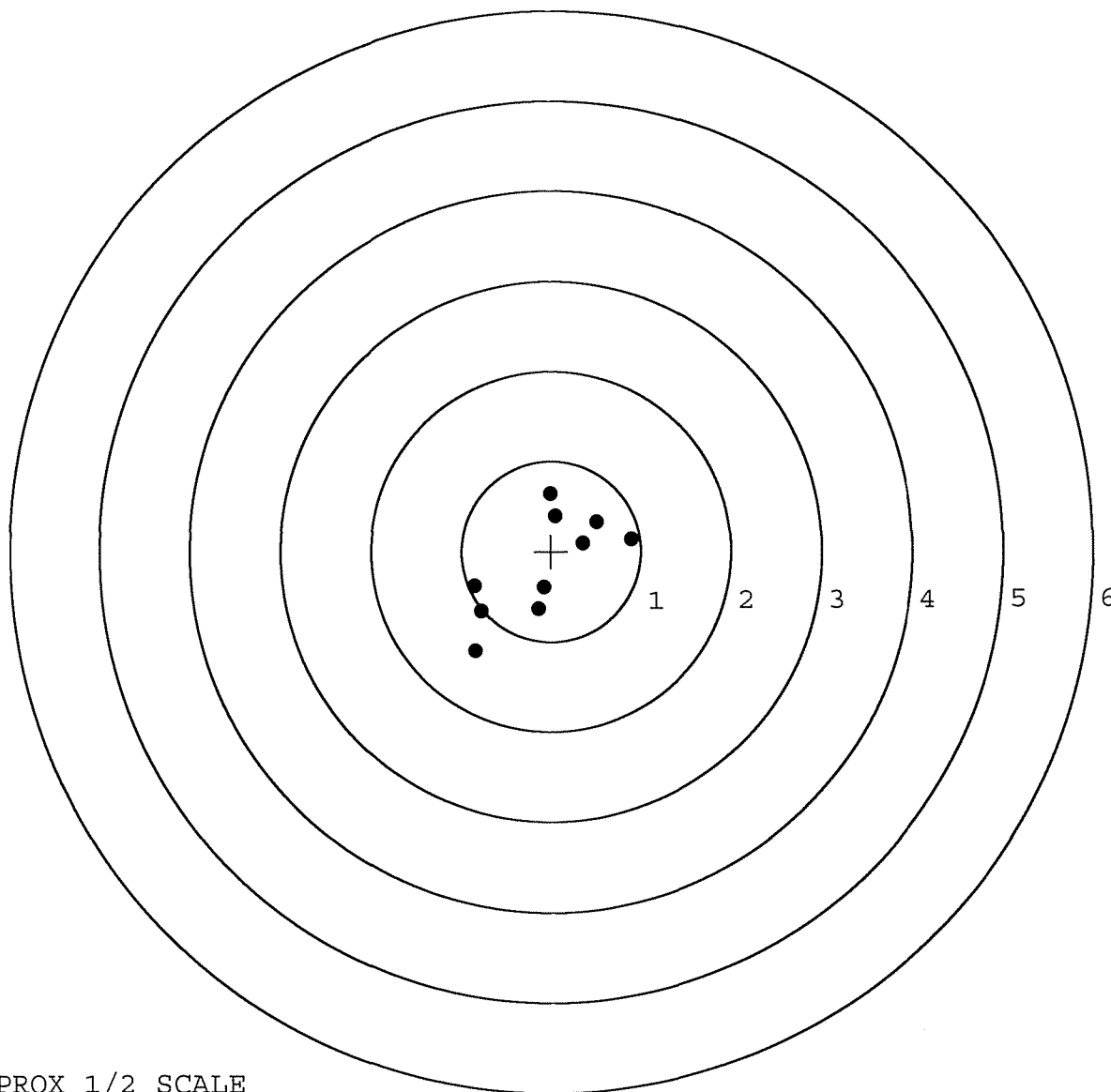


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360899. __0
TARGET NUMBER: 2
FILE DATE: 05/25/2004
FILE TIME: 07:01

X CENTROID: -0.089
Y CENTROID: -0.163
POA TO CENTROID: 0.185
HORZ SPREAD: 1.754
VERT SPREAD: 1.740
GROUP SPREAD: 2.143
MIN RADIUS: 0.239
MAX RADIUS: 1.211
MEAN RADIUS: 0.729
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.899	0.133
2:	0.517	0.326
3:	0.359	0.091
4:	0.054	0.388
5:	0.002	0.636
6:	-0.085	-0.402
7:	-0.145	-0.646
8:	-0.855	-0.385
9:	-0.786	-0.664
10:	-0.851	-1.104

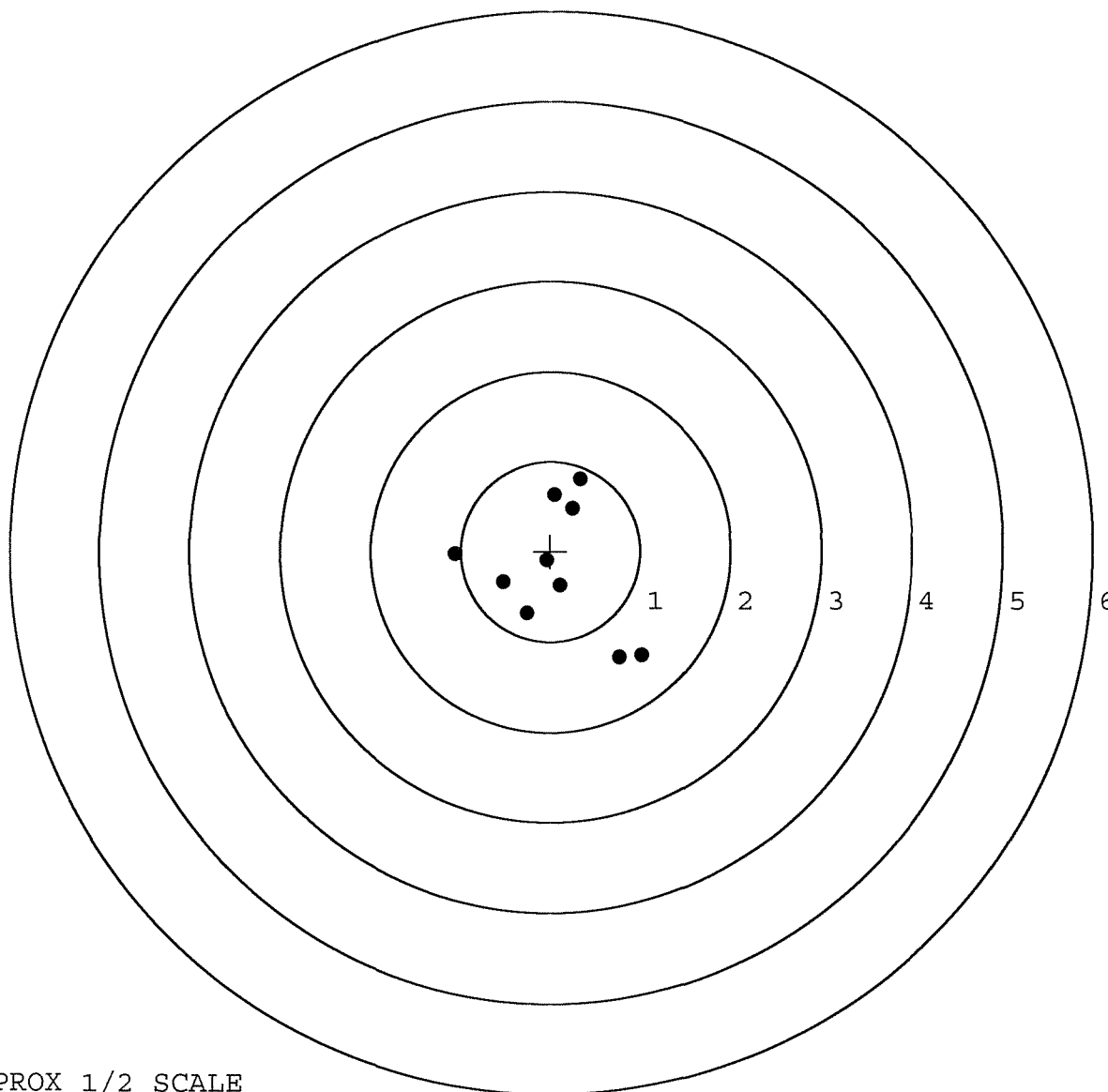


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360899. __0
TARGET NUMBER: 3
FILE DATE: 05/25/2004
FILE TIME: 07:01

X CENTROID: 0.061
Y CENTROID: -0.198
POA TO CENTROID: 0.207
HORZ SPREAD: 2.082
VERT SPREAD: 1.985
GROUP SPREAD: 2.368
MIN RADIUS: 0.145
MAX RADIUS: 1.356
MEAN RADIUS: 0.780
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.019	-1.158
2:	0.773	-1.180
3:	-1.063	-0.030
4:	-0.528	-0.345
5:	-0.266	-0.693
6:	0.107	-0.383
7:	-0.046	-0.101
8:	0.246	0.474
9:	0.328	0.805
10:	0.041	0.630



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360899. __0

TARGET NUMBER: 4

FILE DATE: 05/25/2004

FILE TIME: 07:01

X CENTROID: -0.061

Y CENTROID: 0.029

POA TO CENTROID: 0.068

HORZ SPREAD: 1.082

VERT SPREAD: 1.808

GROUP SPREAD: 1.841

MIN RADIUS: 0.203

MAX RADIUS: 1.142

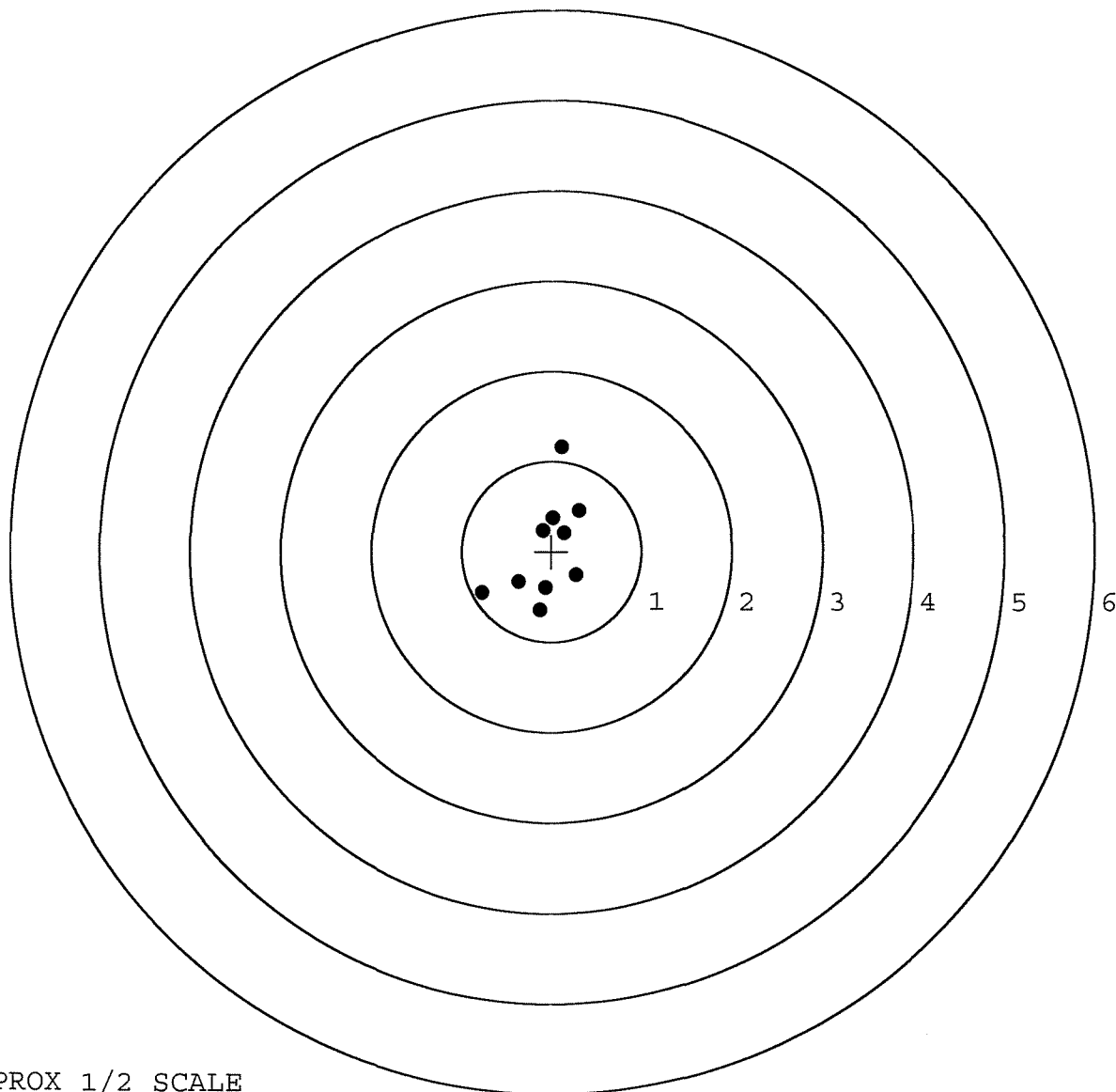
MEAN RADIUS: 0.541

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.110	1.158
2:	0.304	0.448
3:	0.134	0.202
4:	0.007	0.368
5:	-0.104	0.228
6:	-0.778	-0.455
7:	0.274	-0.266
8:	-0.368	-0.339
9:	-0.067	-0.404
10:	-0.127	-0.650

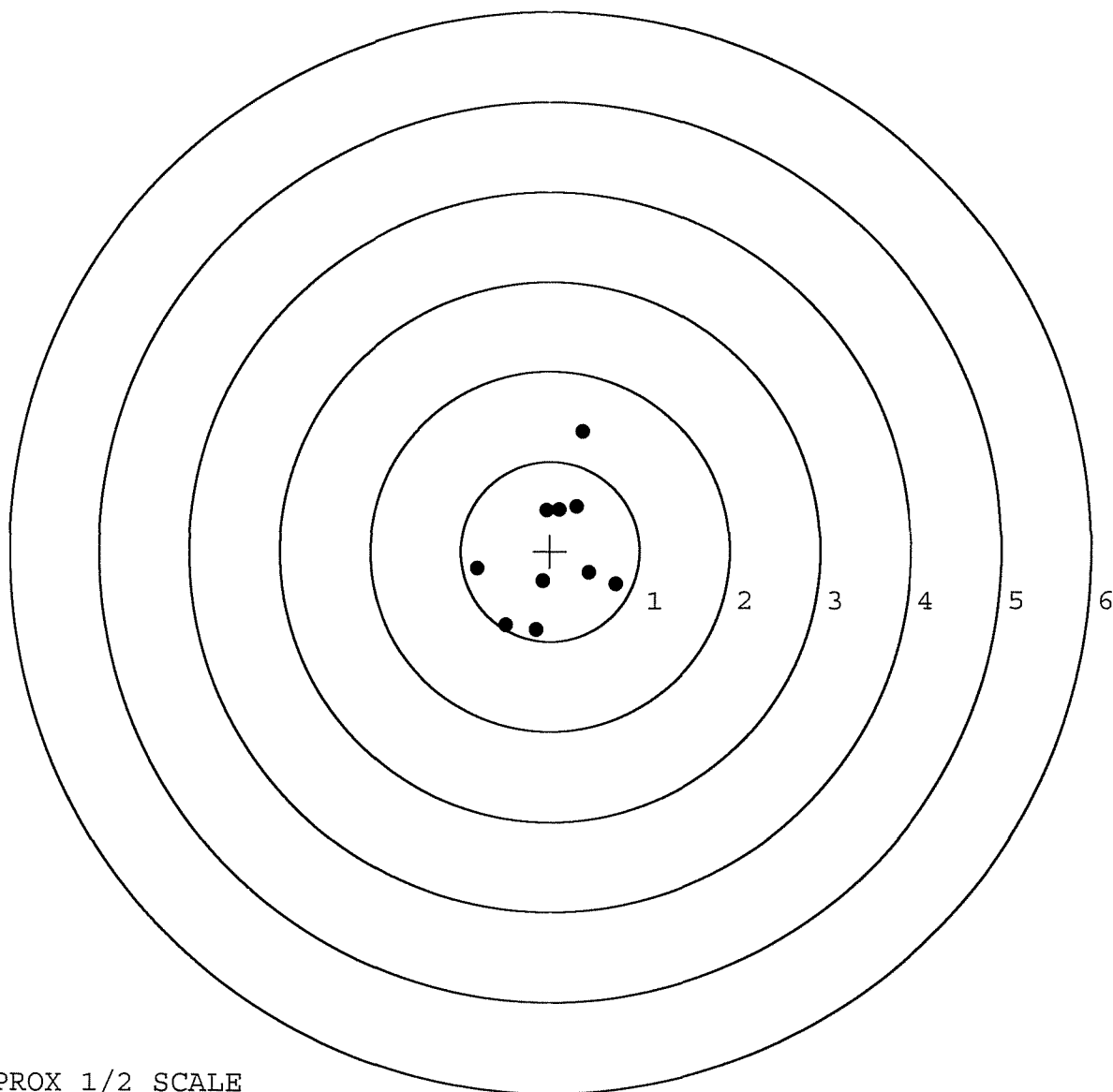


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360899. __0
TARGET NUMBER: 5
FILE DATE: 05/25/2004
FILE TIME: 07:01

X CENTROID: 0.036
Y CENTROID: -0.010
POA TO CENTROID: 0.037
HORZ SPREAD: 1.550
VERT SPREAD: 2.210
GROUP SPREAD: 2.322
MIN RADIUS: 0.348
MAX RADIUS: 1.381
MEAN RADIUS: 0.724
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.734	-0.370
2:	0.438	-0.242
3:	-0.083	-0.337
4:	-0.155	-0.879
5:	-0.500	-0.823
6:	-0.816	-0.196
7:	-0.037	0.455
8:	0.110	0.465
9:	0.300	0.498
10:	0.368	1.331



TARGET APPROX 1/2 SCALE