

G652 1456

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



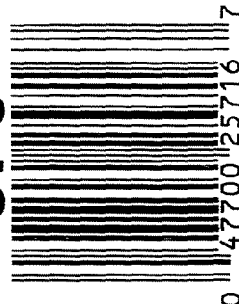
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6521456

UPC



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



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6521456

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		11/11/05	CD
440	PROOF		11/11/05	CD
460	CHECK HEADSPACE	MAGNA-FLUX	11/11/05	CD
470	DIS-ASSEMBLE ACTION	INSPECTED	11/11/05	CD
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 16 2005 C/SO OPERATOR <u>Leunt</u>	11/16/05	<u>Leunt</u>
500	ROLLMARK CALIBER		11-16-05	CW
510	DRILL AND TAP SIGHT HOLES		11-18-05	BR
520	GOFF BLAST BBL / REC		11-18-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		11/23/05	FB
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		12-2-05	BG
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-2-05	BG
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-2-05	BG
	D) OIL FIRING PIN ASSEMBLY		12-2-05	BG
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		12-13-05	BG
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.5</u> <u>7.0</u> <u>7.0</u>	12-13-05	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.0</u> <u>2.0</u>	12-13-05	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.0245</u> <u>.023</u>	12-13-05	TRW
	J) ASSEMBLE STOCK		12-5-05	RT
	K) ASSEMBLE SWIVEL STUDS		12-13-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-7-05	BG
	M) IRON SIGHT ALIGNMENT		12-7-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-7-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	12-8-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		12-8-05	R.P.
670	FINAL INSPECTION A) HEADSPACE		12-13-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.43</u> <u>2.54</u> <u>2.58</u> <u>2.59</u>	12/13/05	R.P.
	C) FUNCTION		12-13-05	BG
690	PACK		1-11-06	RA

25716

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



.MA25716

Shop Order: SW5716DEC2



.ABSW5716DEC2

Start Date: 11/15/2005

Finish Date: 12/16/2005

0470

Disassemble Gun

89SWS1



0004312798

0547

Gray Sandstrom Coat Bolt Assemblies

01PC001



0004312816

0610

Assemble Action to Stock.

89SWS1



0004312804

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

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 11-17-05

TESTER S.F.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.59	2.73		2.52	
PULL #2	2.62	2.72		2.66	
PULL #3	2.59	2.70		2.73	
PULL #4	2.45	2.51		2.65	
PULL #5	2.59	2.66		2.70	
TOTAL	12.84	13.22		13.26	
AVERAGE	2.57	2.66		2.65	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	2.85	2.95		
PULL #2	2.88	2.90		
PULL #3	2.90	3.09		
PULL #4	3.02	3.01		
PULL #5	2.97	3.02		
TOTAL	14.62	14.97		
AVERAGE	2.92	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	3.88	3.96		4.00
PULL #2	3.91	3.96		4.04
PULL #3	3.87	3.92		3.88
PULL #4	4.14	4.15		3.95
PULL #5	4.07	4.22		3.93
TOTAL	19.87	20.21		19.80
AVERAGE	3.97	4.04		3.96

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521456.__0
FILE DATE AND TIME: 12/08/2005 14:48

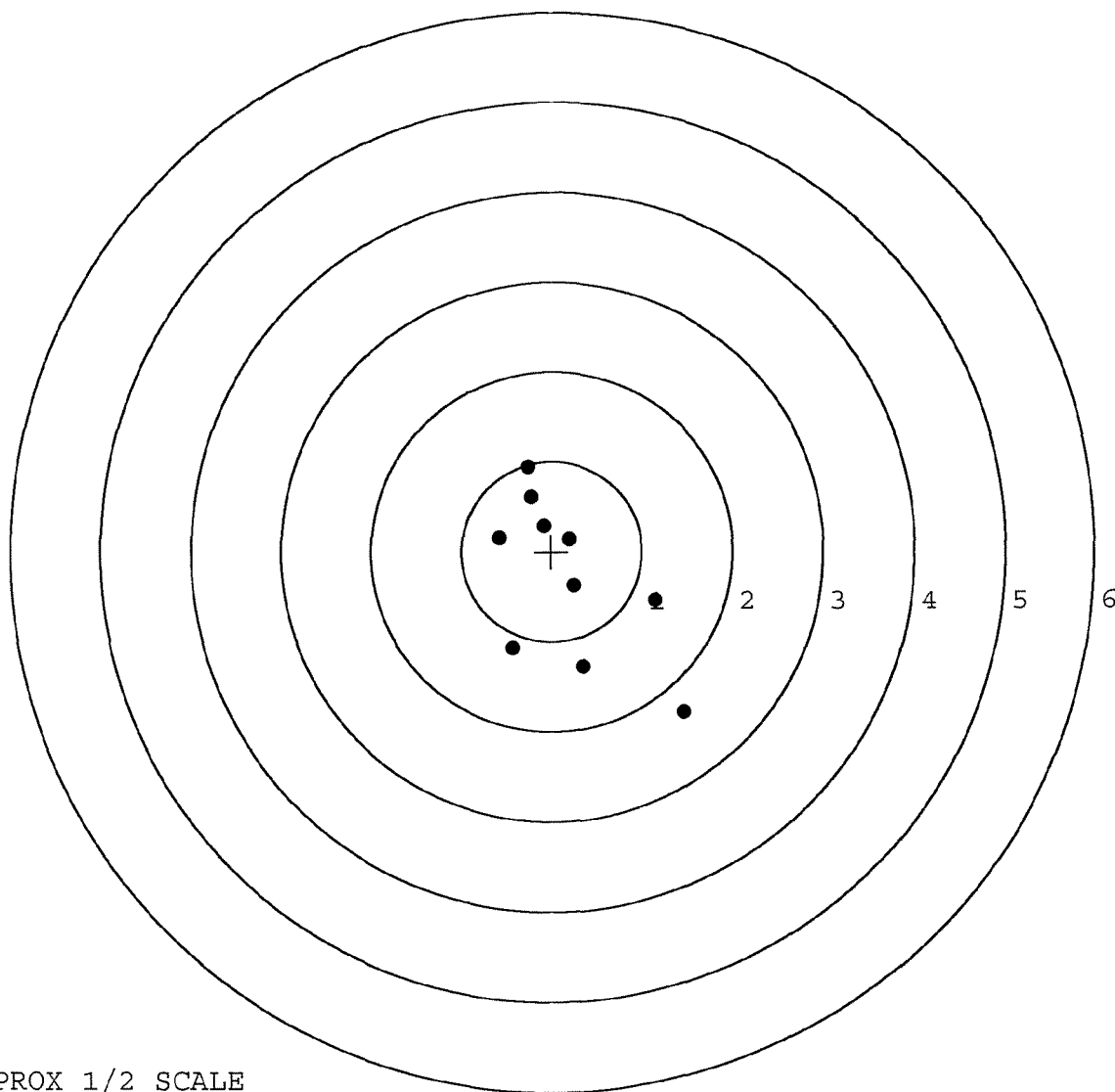
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.034
The Average Y Centroid of the Five Target Set:	-0.214
The Average Point of Impact of the Five Target Set:	0.217
The Average Mean Radius of the Five Target Set:	0.881
The Distance from POA to Centroid Target #1:	0.349
The Distance from Centroid Target #2 to Centroid Target #1:	0.298
The Distance from Centroid Target #3 to Centroid Target #1:	0.259
The Distance from Centroid Target #4 to Centroid Target #1:	0.331
The Distance from Centroid Target #5 to Centroid Target #1:	0.480

SERIAL NUMBER: G6521456. __0
TARGET NUMBER: 1
FILE DATE: 12/08/2005
FILE TIME: 14:48

POINT#	X	Y
1:	1.148	-0.551
2:	0.248	-0.381
3:	0.201	0.137
4:	-0.089	0.280
5:	-0.230	0.602
6:	-0.575	0.159
7:	-0.262	0.934
8:	-0.433	-1.074
9:	0.359	-1.285
10:	1.462	-1.796

X CENTROID: 0.183
Y CENTROID: -0.297
POA TO CENTROID: 0.349
HORZ SPREAD: 2.037
VERT SPREAD: 2.730
GROUP SPREAD: 3.229
MIN RADIUS: 0.106
MAX RADIUS: 1.970
MEAN RADIUS: 0.933
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

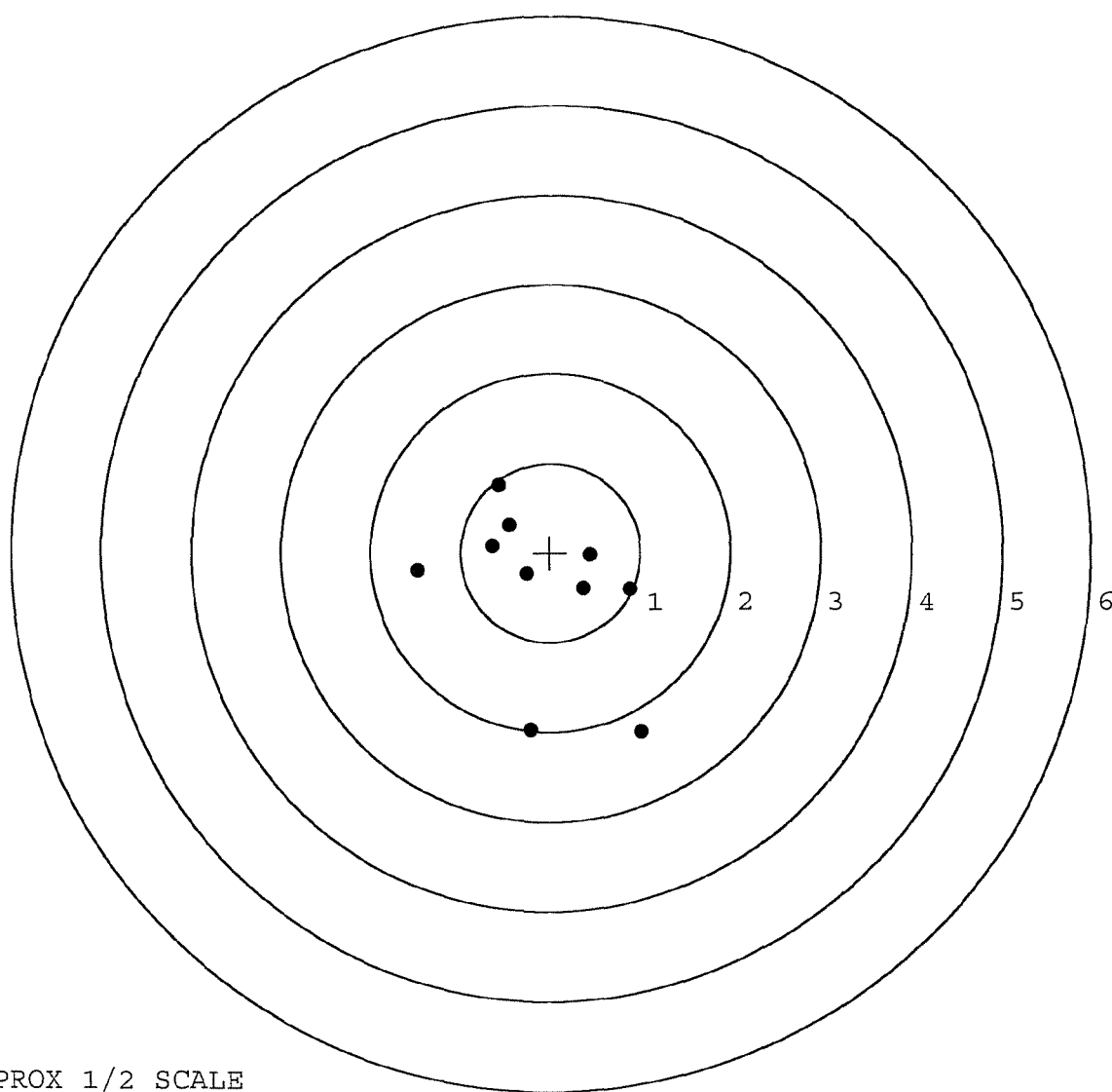


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521456. __0
TARGET NUMBER: 2
FILE DATE: 12/08/2005
FILE TIME: 14:48

POINT#	X	Y
1:	1.020	-2.001
2:	-0.219	-1.981
3:	-1.474	-0.200
4:	-0.576	0.759
5:	-0.465	0.310
6:	-0.641	0.075
7:	-0.264	-0.238
8:	0.445	-0.032
9:	0.370	-0.402
10:	0.883	-0.413

X CENTROID: -0.092
Y CENTROID: -0.412
POA TO CENTROID: 0.422
HORZ SPREAD: 2.494
VERT SPREAD: 2.760
GROUP SPREAD: 3.188
MIN RADIUS: 0.245
MAX RADIUS: 1.939
MEAN RADIUS: 1.007
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

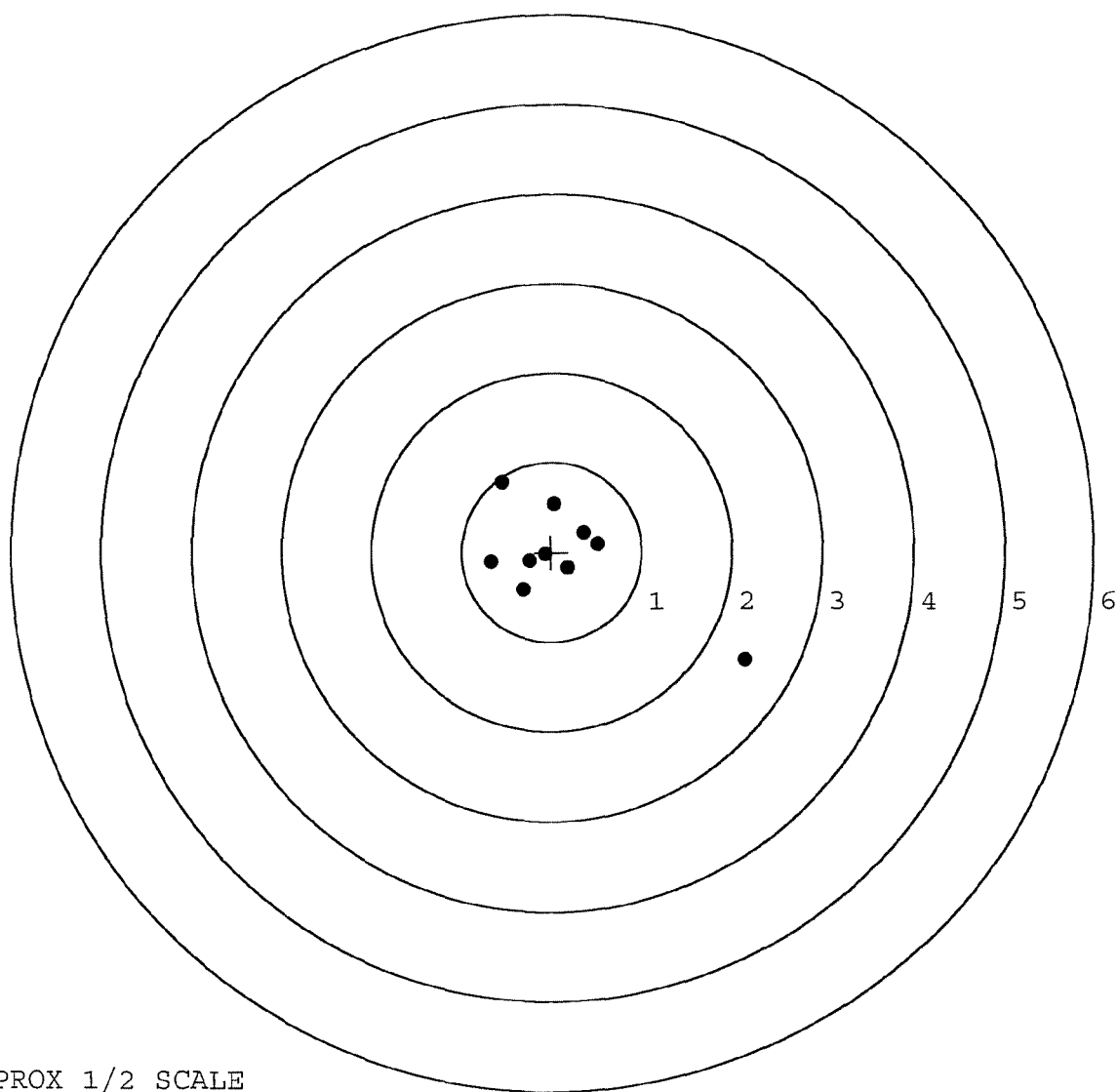


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521456. __0
TARGET NUMBER: 3
FILE DATE: 12/08/2005
FILE TIME: 14:48

POINT#	X	Y
1:	2.145	-1.210
2:	0.033	0.535
3:	-0.551	0.779
4:	-0.672	-0.110
5:	-0.240	-0.098
6:	-0.318	-0.421
7:	-0.072	-0.026
8:	0.185	-0.180
9:	0.517	0.089
10:	0.360	0.215

X CENTROID: 0.139
Y CENTROID: -0.043
POA TO CENTROID: 0.145
HORZ SPREAD: 2.817
VERT SPREAD: 1.989
GROUP SPREAD: 3.350
MIN RADIUS: 0.145
MAX RADIUS: 2.321
MEAN RADIUS: 0.687
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

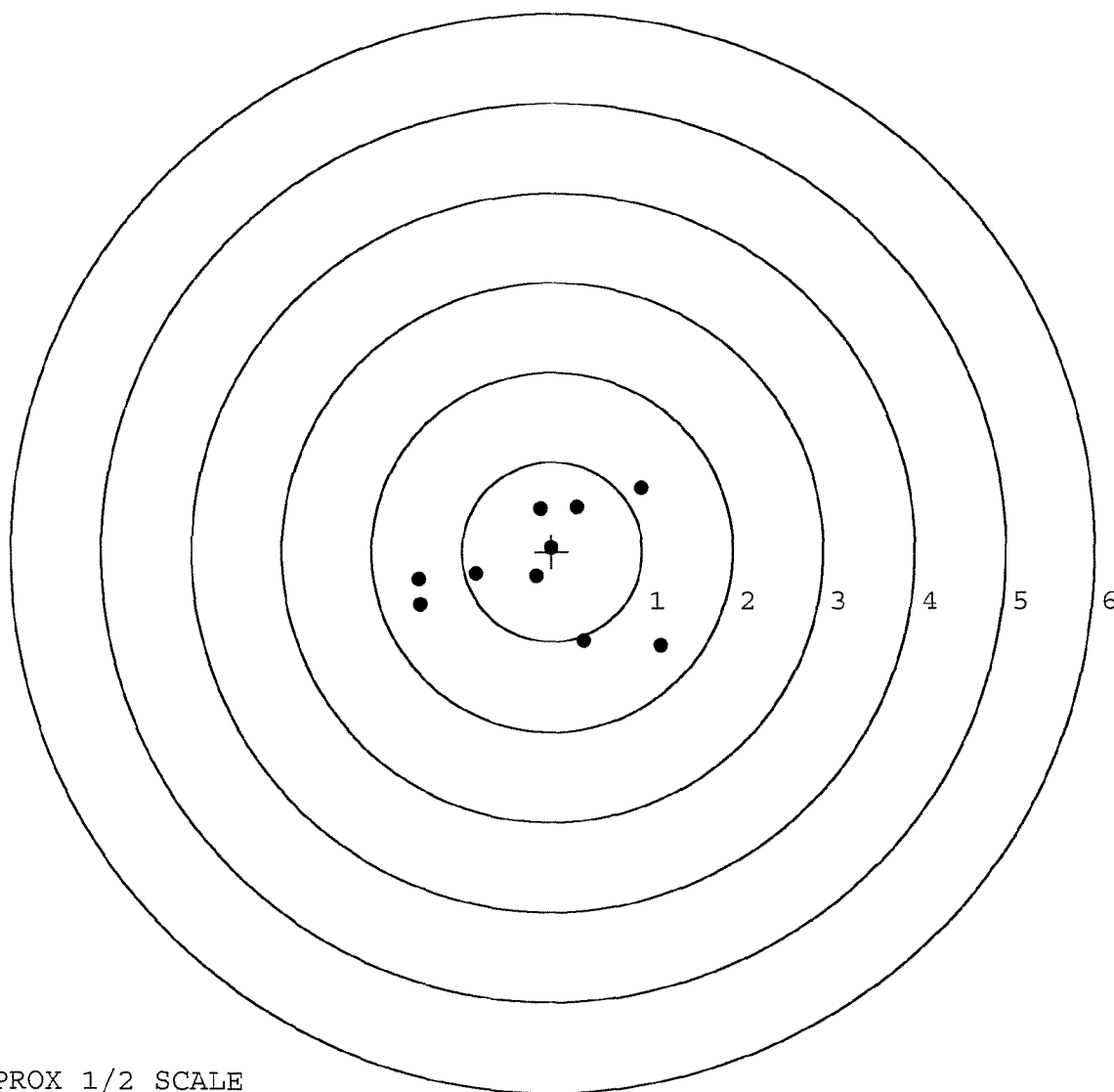


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521456. __0
TARGET NUMBER: 4
FILE DATE: 12/08/2005
FILE TIME: 14:48

X CENTROID: -0.125
Y CENTROID: -0.178
POA TO CENTROID: 0.218
HORZ SPREAD: 2.685
VERT SPREAD: 1.762
GROUP SPREAD: 2.785
MIN RADIUS: 0.111
MAX RADIUS: 1.600
MEAN RADIUS: 0.925
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.211	-1.057
2:	0.359	-1.000
3:	-1.454	-0.598
4:	-1.474	-0.317
5:	-0.845	-0.253
6:	-0.179	-0.275
7:	-0.011	0.043
8:	-0.128	0.478
9:	0.276	0.496
10:	0.991	0.705



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521456. __0

TARGET NUMBER: 5

FILE DATE: 12/08/2005

FILE TIME: 14:48

POINT#	X	Y
1:	0.926	-0.202
2:	0.909	0.142
3:	0.194	0.736
4:	-0.564	0.629
5:	-0.294	-0.024
6:	0.169	-0.222
7:	-0.969	-0.100
8:	-0.900	-0.387
9:	-1.197	-0.909
10:	-0.990	-1.079

X CENTROID: -0.272

Y CENTROID: -0.142

POA TO CENTROID: 0.306

HORZ SPREAD: 2.123

VERT SPREAD: 1.815

GROUP SPREAD: 2.354

MIN RADIUS: 0.120

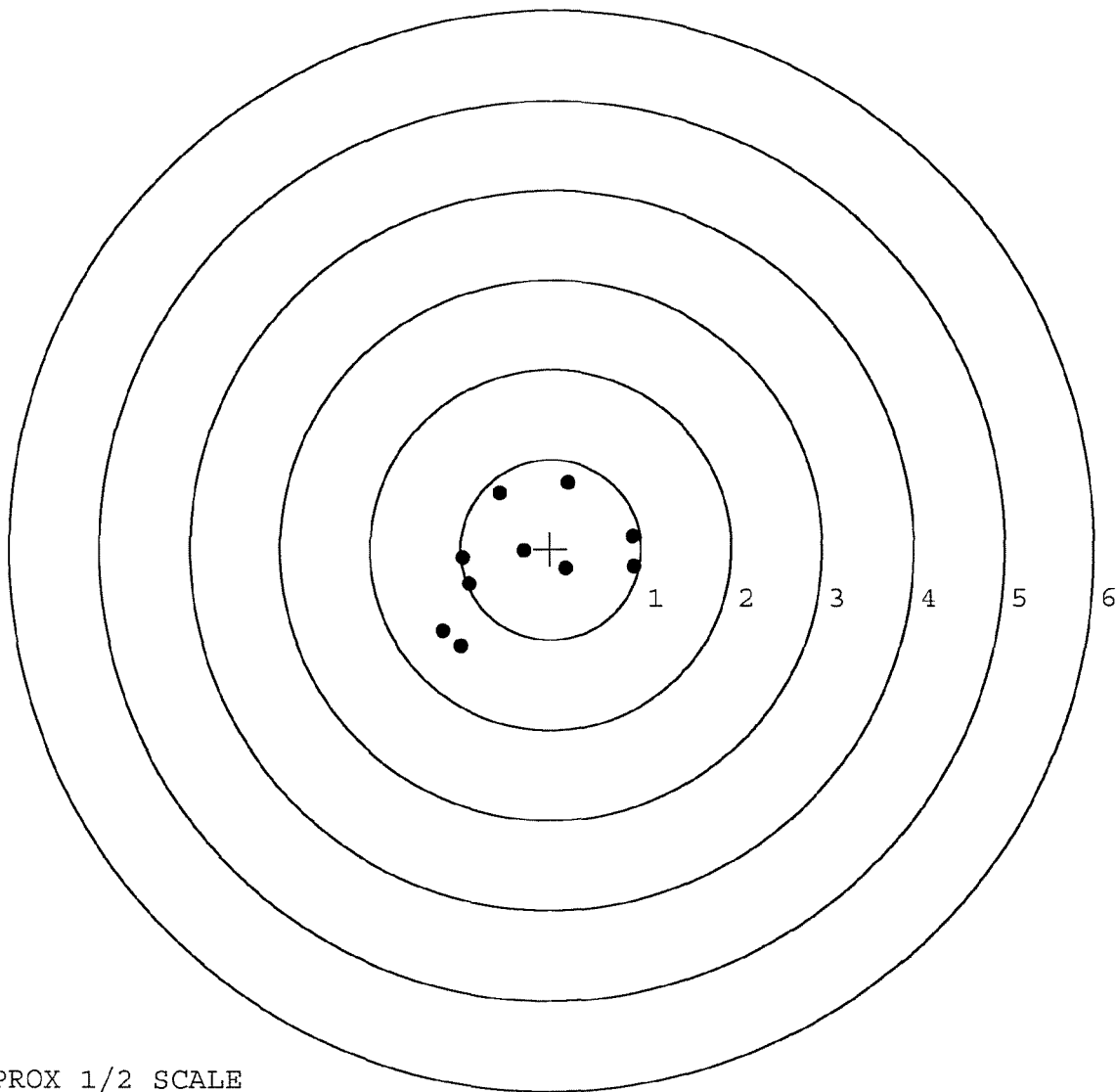
MAX RADIUS: 1.214

MEAN RADIUS: 0.856

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE