

G639 1080

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



0 47700 25716 7

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M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC



0 47700 25716 7

SERIAL NO.



66410280

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



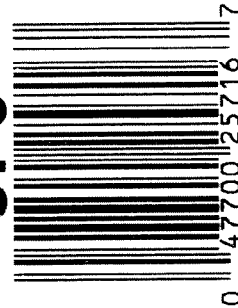
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410280

UPC



10/27/2004 11:09:26 AM

Crib

5

Original

25716

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



.MA25716

Shop Order: SWS10-15-1



.ABSWS10-15-1

Start Date: 10/22/2004

Finish Date: 12/27/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003517903

0560

Reassemble Action.

89SWS1



0003517904

0690

Pack Rifle

89SWS1



0003517897

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G62391080

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		6-15-04	RTL
600	PROOF		6-15-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	6-15-04	RTL
610	DIS-ASSEMBLE GUN	JUN 15 2004	6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		6-16-04	SR
617	DRILL AND TAP SIGHT HOLES		6-15-04	RTL
620	APPLY COATINGS (BARREL ACTION)		6/28	HP
	(BOLT)		6/28	HP
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-12-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-12-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-12-04	RTL
	D) OIL FIRING PIN ASSEMBLY		11-12-04	RTL
	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>6.5</u> <u>6.9</u> <u>6.9</u>	10-20-04	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.9</u> <u>2.9</u> <u>2.9</u>	10-20-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.024</u>	10-20-04	DA
	J) ASSEMBLE STOCK		11-12-04	RTL
	K) ASSEMBLE SWIVEL STUDS		11-29-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-29-04	RTL
	M) IRON SIGHT ALIGNMENT		11-29-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-29-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	10-15-04	TRLW
	MALFUNCTION <i>mcw</i>	CORRECTION <i>OK</i>	10-18-04	TRLW
	MALFUNCTION	CORRECTION	N/A	TRLW
	MALFUNCTION	CORRECTION	N/A	TRLW
	MALFUNCTION	CORRECTION	N/A	TRLW
645	INSPECT FOR LIVE AMMO		10-15-04	TRLW
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u> <u>2.48</u> <u>2.52</u> <u>2.46</u> <u>2.48</u>	10-20-04	DA
	C) FUNCTION		11-29-04	RTL
660	PACK		11/29/04	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 10-11-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.73	2.35		2.13	
PULL #2	2.75	2.32		2.19	
PULL #3	2.77	2.34		2.16	
PULL #4	2.73	2.29		2.13	
PULL #5	2.84	2.29		2.18	
TOTAL	13.82	11.59		10.79	
AVERAGE	2.76	2.31		2.15	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.38	3.22		
PULL #2	3.29	3.18		
PULL #3	3.28	3.17		
PULL #4	3.27	3.20		
PULL #5	3.30	3.16		
TOTAL	16.52	15.93		
AVERAGE	3.30	3.18		

	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	4.10	4.53		4.30
PULL #2	4.43	4.40		4.25
PULL #3	4.32	4.08		4.25
PULL #4	4.43	4.10		4.17
PULL #5	4.54	4.14		4.23
TOTAL	21.82	21.25		21.20
AVERAGE	4.36	4.25		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6391080.__0
FILE DATE AND TIME: 10/15/2004 06:59

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.008
The Average Y Centroid of the Five Target Set:	-0.070
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.890
The Distance from POA to Centroid Target #1:	0.118
The Distance from Centroid Target #2 to Centroid Target #1:	0.169
The Distance from Centroid Target #3 to Centroid Target #1:	0.164
The Distance from Centroid Target #4 to Centroid Target #1:	0.056
The Distance from Centroid Target #5 to Centroid Target #1:	0.144

SERIAL NUMBER: G6391080. 0

TARGET NUMBER: 1

FILE DATE: 10/15/2004

FILE TIME: 06:59

X CENTROID: 0.064

Y CENTROID: -0.099

POA TO CENTROID: 0.118

HORZ SPREAD: 1.823

VERT SPREAD: 1.873

GROUP SPREAD: 1.894

MIN RADIUS: 0.595

MAX RADIUS: 1.253

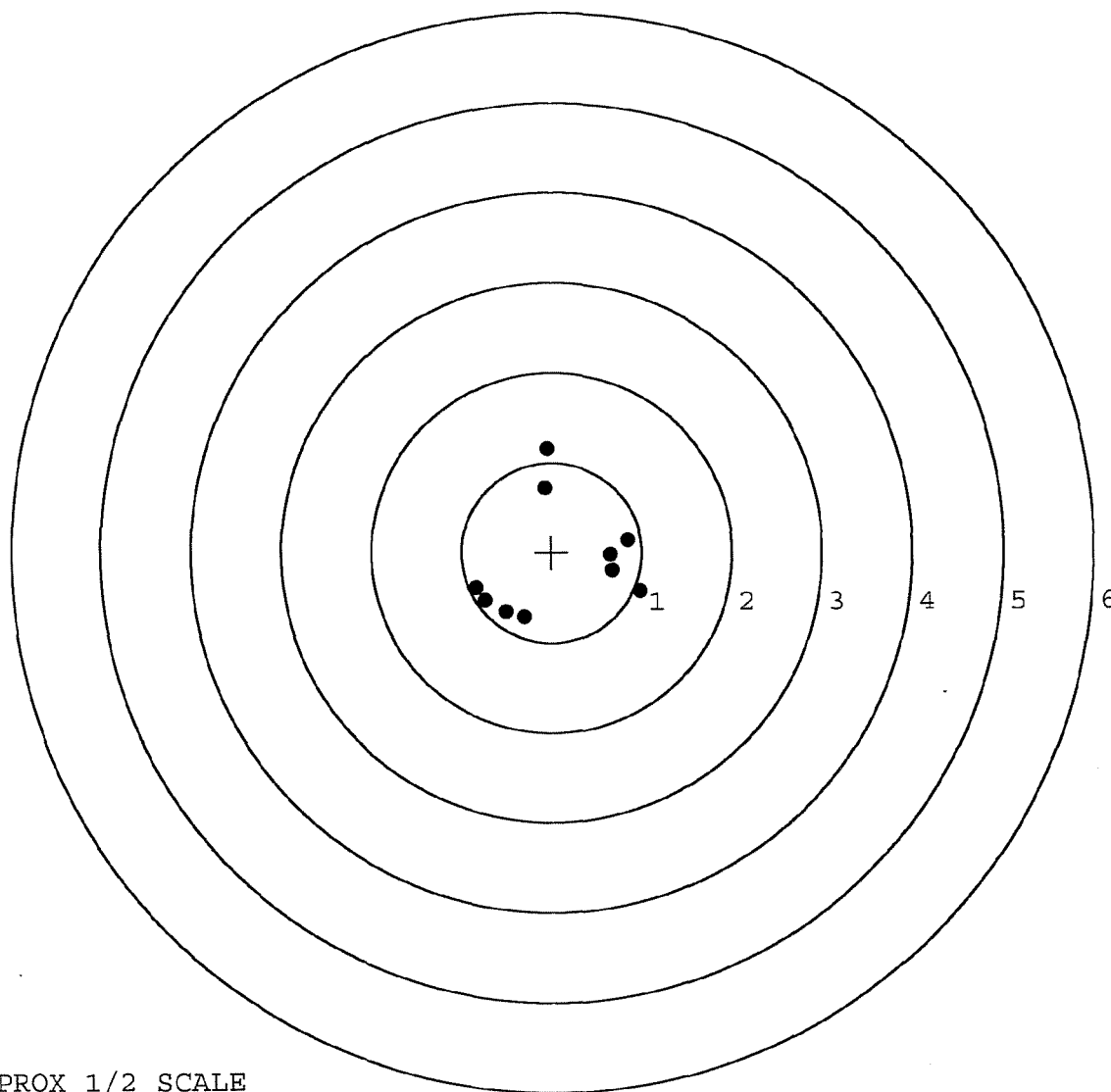
MEAN RADIUS: 0.850

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.986	-0.436
2:	0.677	-0.200
3:	0.655	-0.031
4:	0.850	0.134
5:	-0.079	0.716
6:	-0.052	1.148
7:	-0.307	-0.725
8:	-0.510	-0.665
9:	-0.743	-0.537
10:	-0.837	-0.397

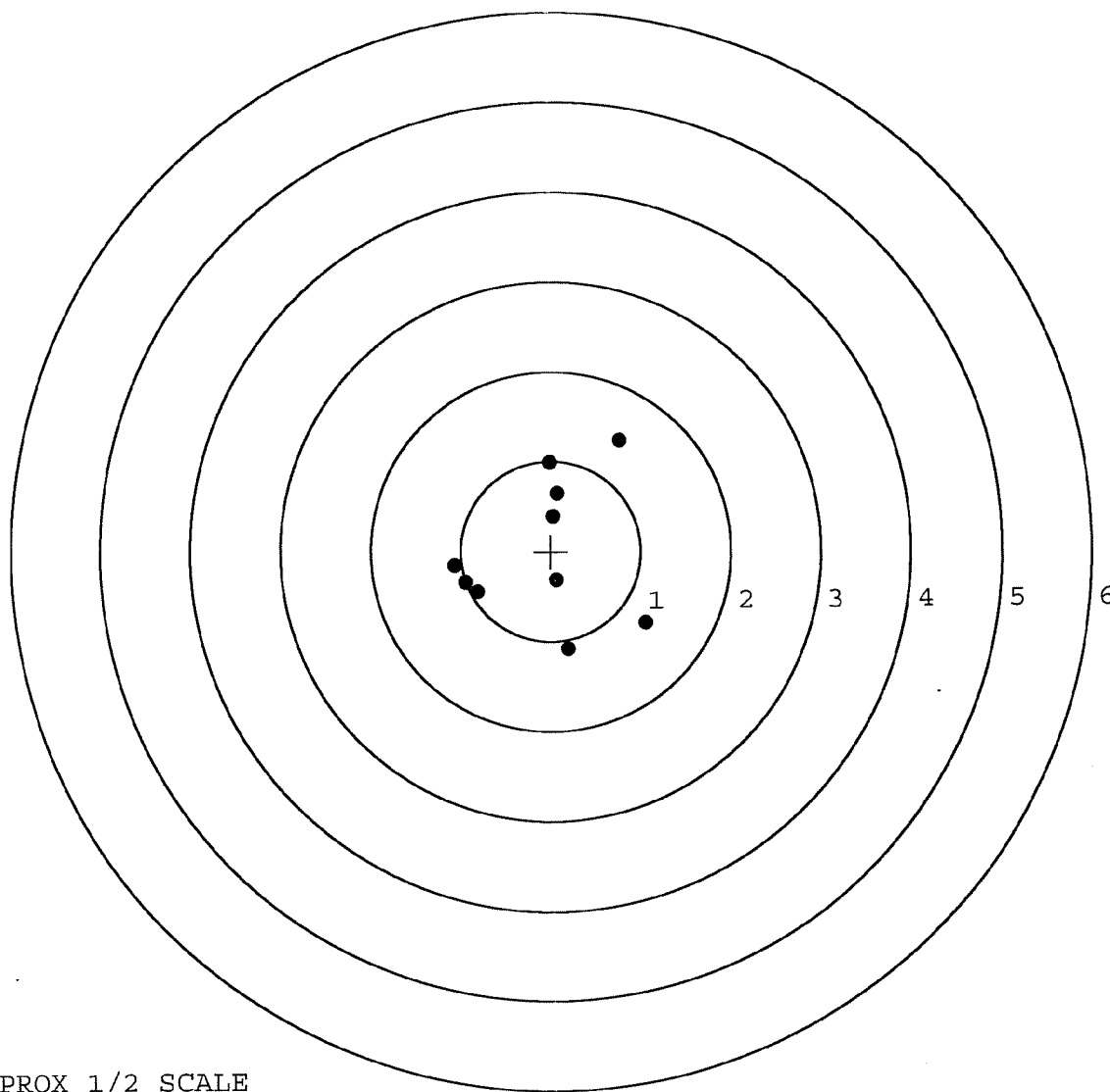


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391080. __0
TARGET NUMBER: 2
FILE DATE: 10/15/2004
FILE TIME: 06:59

POINT#	X	Y
1:	1.049	-0.801
2:	0.193	-1.089
3:	0.063	-0.325
4:	-0.817	-0.447
5:	-0.950	-0.342
6:	-1.073	-0.159
7:	0.032	0.393
8:	0.079	0.642
9:	-0.008	0.982
10:	0.767	1.224

X CENTROID: -0.067
Y CENTROID: 0.008
POA TO CENTROID: 0.067
HORZ SPREAD: 2.122
VERT SPREAD: 2.313
GROUP SPREAD: 2.383
MIN RADIUS: 0.357
MAX RADIUS: 1.474
MEAN RADIUS: 0.921
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391080. __0

TARGET NUMBER: 3

FILE DATE: 10/15/2004

FILE TIME: 06:59

POINT#	X	Y
1:	0.267	-1.488
2:	-1.046	-1.004
3:	0.233	-0.612
4:	0.397	-0.242
5:	0.034	-0.086
6:	0.153	0.405
7:	0.500	0.708
8:	0.043	1.357
9:	-0.232	1.836
10:	0.216	-0.227

X CENTROID: 0.057

Y CENTROID: 0.065

POA TO CENTROID: 0.086

HORZ SPREAD: 1.546

VERT SPREAD: 3.324

GROUP SPREAD: 3.361

MIN RADIUS: 0.152

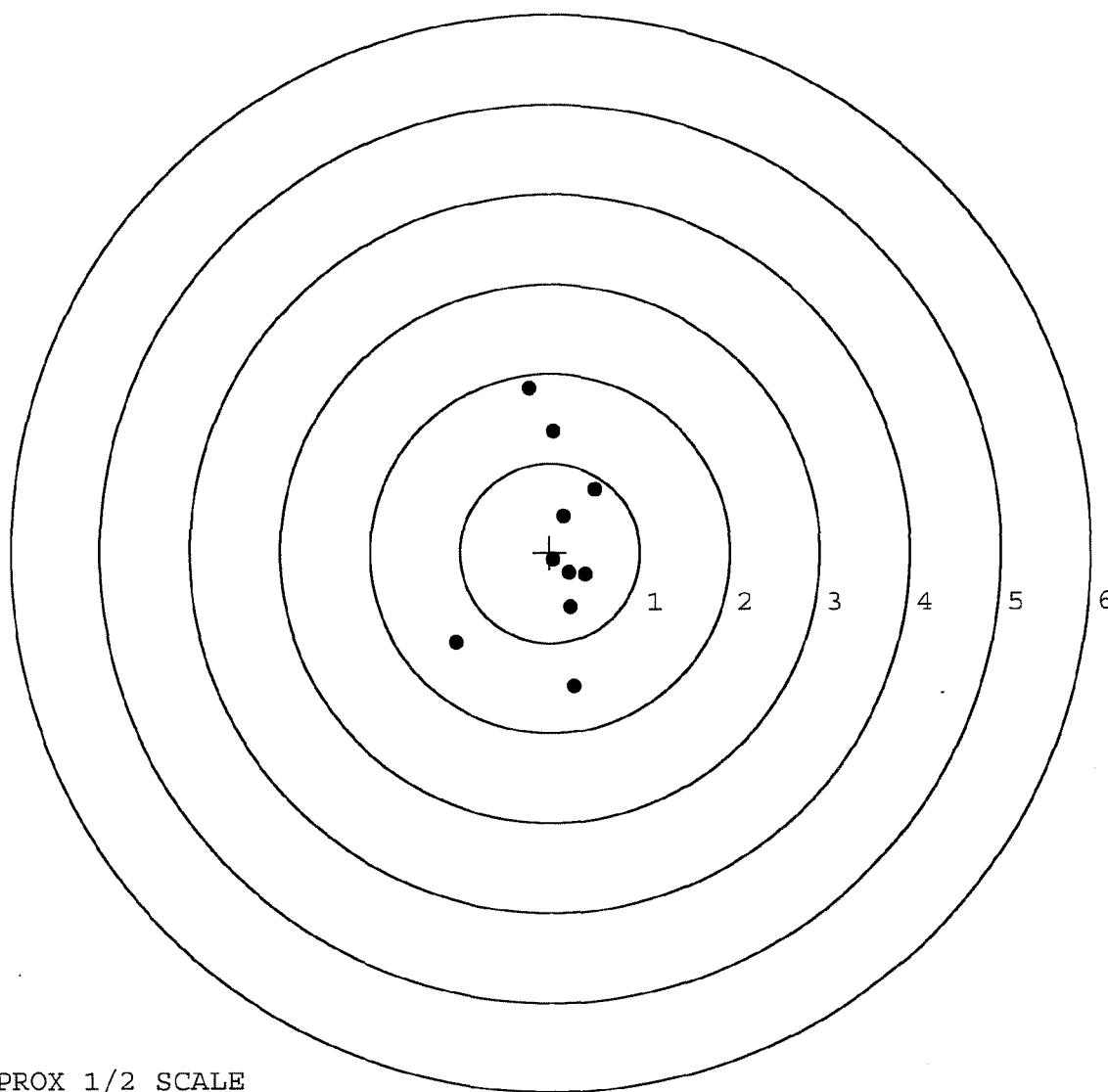
MAX RADIUS: 1.795

MEAN RADIUS: 0.897

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7

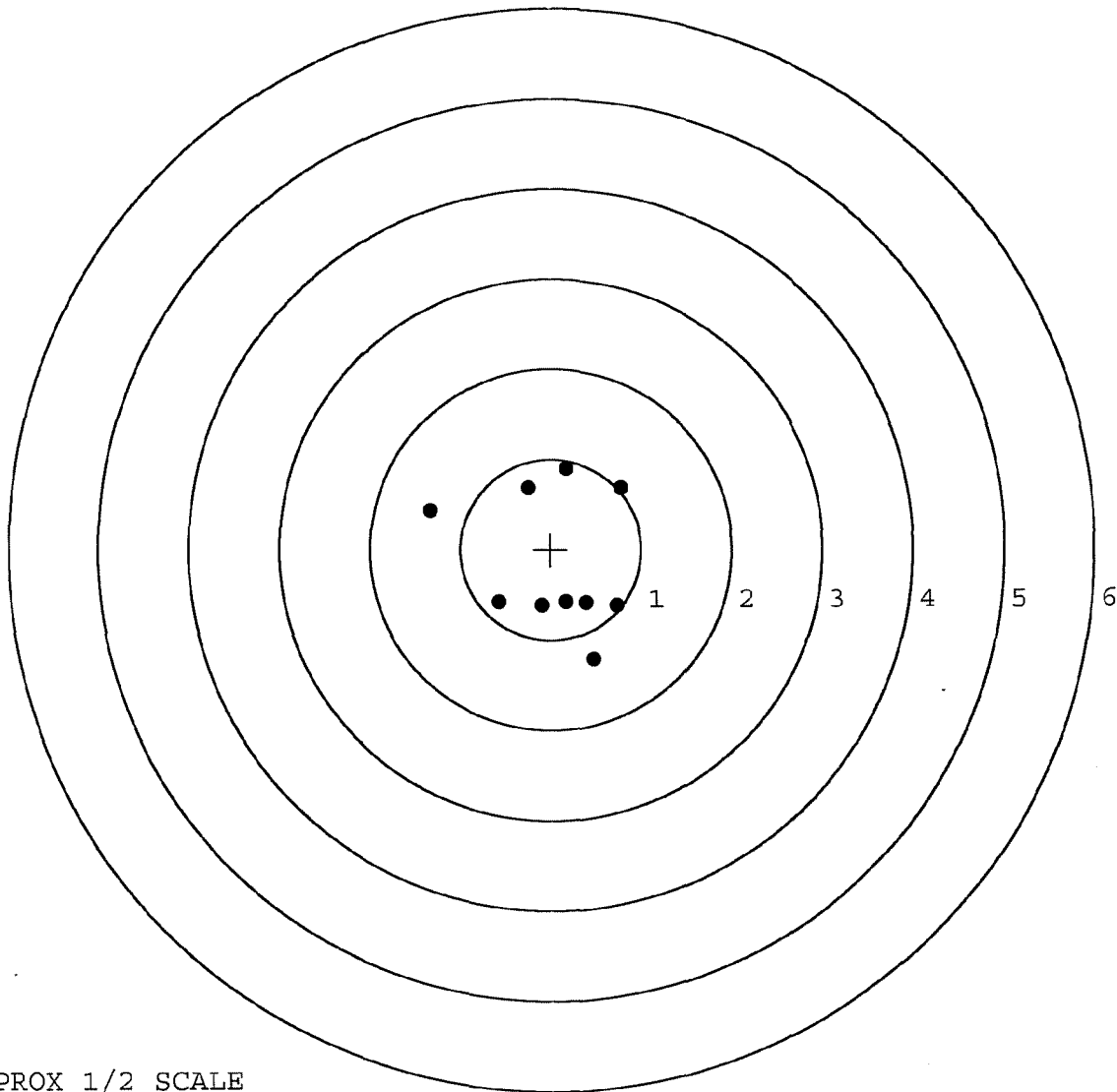


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391080. __0
TARGET NUMBER: 4
FILE DATE: 10/15/2004
FILE TIME: 06:59

X CENTROID: 0.046
Y CENTROID: -0.153
POA TO CENTROID: 0.159
HORZ SPREAD: 2.110
VERT SPREAD: 2.110
GROUP SPREAD: 2.456
MIN RADIUS: 0.450
MAX RADIUS: 1.504
MEAN RADIUS: 0.879
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.478	-1.216
2:	0.774	0.684
3:	0.177	0.894
4:	-0.248	0.682
5:	-1.336	0.440
6:	-0.574	-0.582
7:	-0.104	-0.626
8:	0.171	-0.585
9:	0.392	-0.593
10:	0.732	-0.624

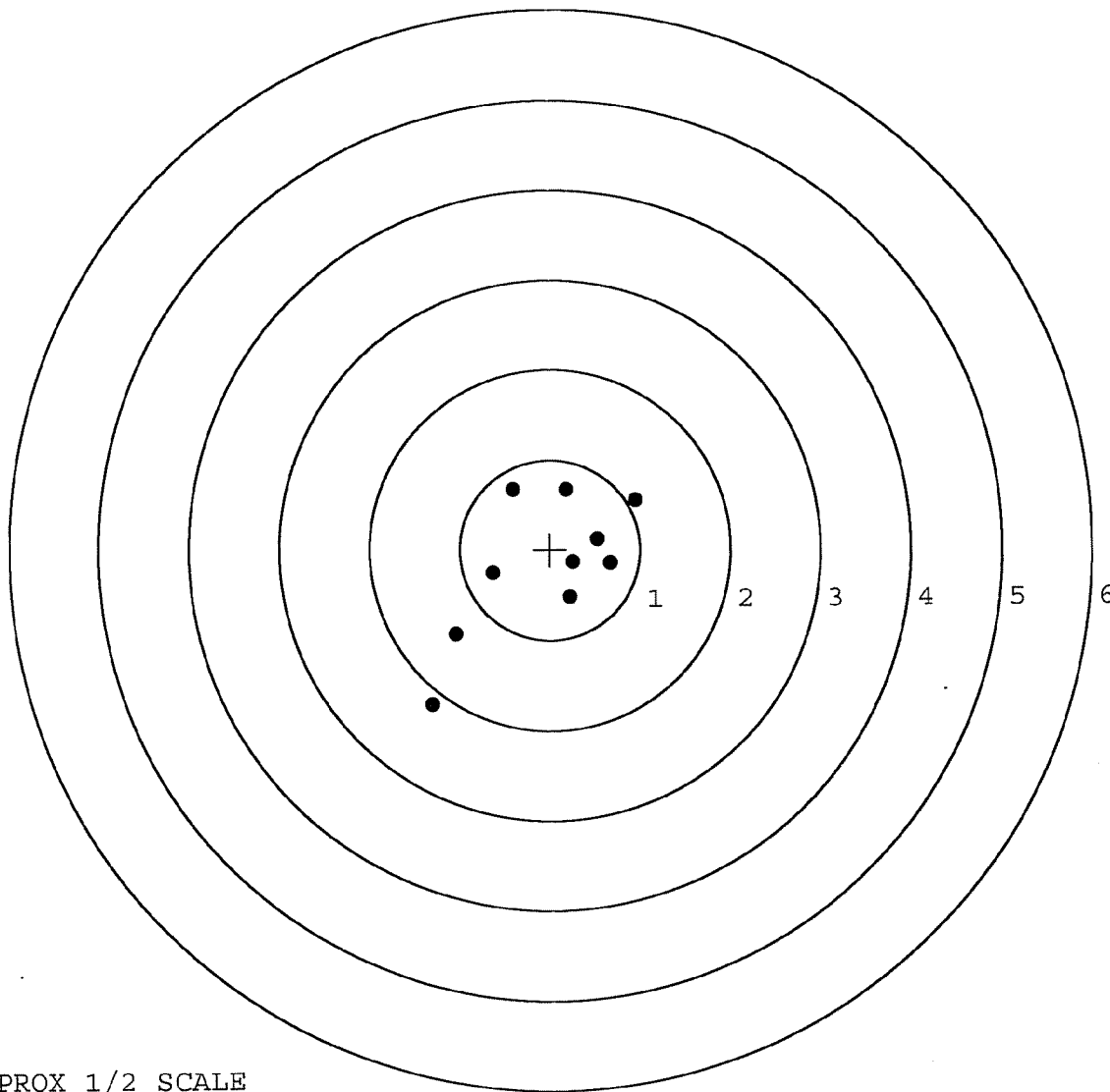


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391080. __0
TARGET NUMBER: 5
FILE DATE: 10/15/2004
FILE TIME: 06:59

X CENTROID: -0.060
Y CENTROID: -0.172
POA TO CENTROID: 0.183
HORZ SPREAD: 2.265
VERT SPREAD: 2.380
GROUP SPREAD: 3.198
MIN RADIUS: 0.318
MAX RADIUS: 1.982
MEAN RADIUS: 0.901
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.315	-1.707
2:	-1.047	-0.936
3:	-0.638	-0.263
4:	-0.413	0.671
5:	0.182	0.673
6:	0.950	0.551
7:	0.527	0.118
8:	0.669	-0.160
9:	0.256	-0.141
10:	0.226	-0.530



TARGET APPROX 1/2 SCALE