

G 6410251

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

Flat Black Powder Coat, Barrel and

01PC001

**0003451403**

0560

Reassemble Action.

89SWS1

**0003451404**

0690

Pack Rifle

89SWS1

**0003451397**

0700

Stencil SWS Container

89SWS1

**.OP0700**

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



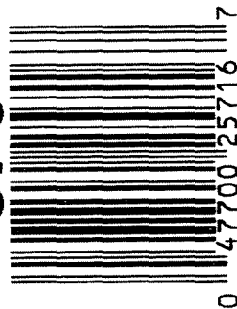
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410251

UPC



7/22/2004 3:21:04 PM

Crib

9

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

Flat Black Powder Coat, Barrel and

01PC001



0003338116

0640

Reassemble Action.

89SWS1



0003338117

0685

Attach Front and Rear Sight Assemblies

89SWS1



0003338122

0710

Pack Rifle & Stencil SWS Container

89SWS1



.OP0710

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410251

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-11-04	RTL
600	PROOF		8-11-04	RTL
607	CHECK HEADSPACE	MAGNA - FLUX	8-11-04	RTL
610	DIS-ASSEMBLE GUN	INSPECTED	8-11-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	AUG 12 2004 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		8-13-04	SB-CW
617	DRILL AND TAP SIGHT HOLES		8-14-04	TRW
620	APPLY COATINGS (BARREL ACTION)		8/25	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-15-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-15-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-15-04	RW
	D) OIL FIRING PIN ASSEMBLY		9-15-04	RW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9</u> <u>9</u> <u>9</u>	9-17-04	RW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>7</u> <u>7</u> <u>7</u>	9-17-04	RW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.025</u>	9-17-04	RW
	J) ASSEMBLE STOCK		9-15-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-20-04	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-15-04	RW
	M) IRON SIGHT ALIGNMENT		9-15-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-15-04	RW
640	GALLERY TEST AND TARGET	PASS FAIL	9-17-04	A
	MALFUNCTION	CORRECTION	9-17-04	A
	MALFUNCTION	CORRECTION	9-17-04	A
	MALFUNCTION	CORRECTION	9-17-04	A
	MALFUNCTION	CORRECTION	9-17-04	A
645	INSPECT FOR LIVE AMMO		9-17-04	A
655	FINAL INSPECTION A) HEADSPACE		9-20-04	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.58</u> <u>2.42</u> <u>2.54</u> <u>2.50</u> <u>2.49</u>	9-17-04	RW
	C) FUNCTION		9-20-04	RW
660	PACK		9-21-04	AL

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 6-10-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.65	2.71		2.23	
PULL #2	2.53	2.60		2.56	
PULL #3	2.60	2.71		2.35	
PULL #4	2.57	2.65		2.57	
PULL #5	2.66	2.85		2.59	
TOTAL	13.01	13.52		12.30	
AVERAGE	2.60	2.70		2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.11		
PULL #2	3.09	3.20		
PULL #3	3.14	3.24		
PULL #4	3.16	3.28		
PULL #5	2.93	3.24		
TOTAL	15.72	16.07		
AVERAGE	3.14	3.21		

	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	4.43	4.26		4.08
PULL #2	4.40	4.21		4.23
PULL #3	4.36	4.16		4.25
PULL #4	4.40	4.04		4.20
PULL #5	4.42	4.03		4.15
TOTAL	22.01	20.70		20.91
AVERAGE	4.40	4.14		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410251.___0

FILE DATE AND TIME: 09/17/2004 09:53

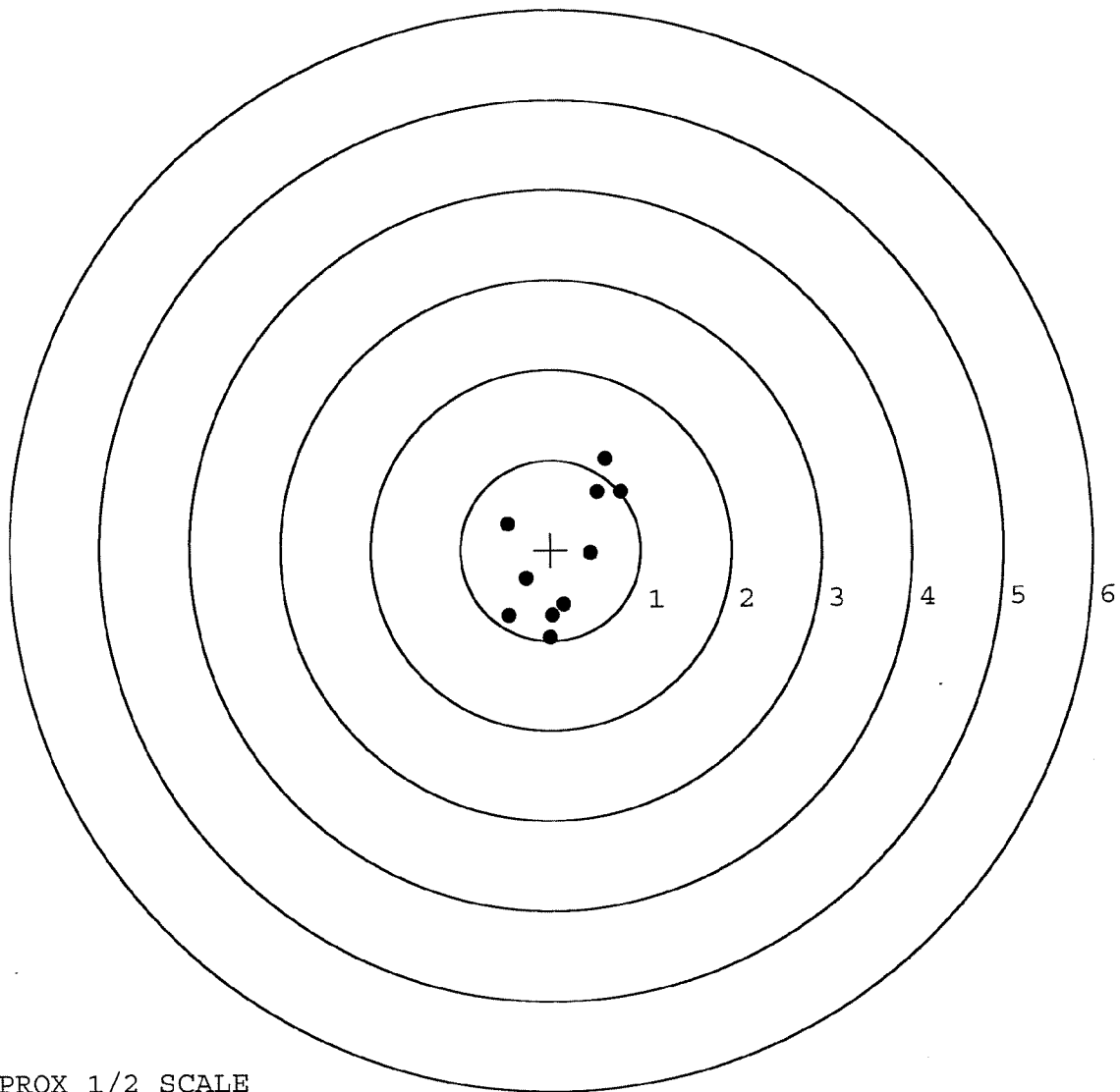
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.002
The Average Y Centroid of the Five Target Set:	-0.066
The Average Point of Impact of the Five Target Set:	0.066
The Average Mean Radius of the Five Target Set:	0.838
The Distance from POA to Centroid Target #1:	0.151
The Distance from Centroid Target #2 to Centroid Target #1:	0.472
The Distance from Centroid Target #3 to Centroid Target #1:	0.169
The Distance from Centroid Target #4 to Centroid Target #1:	0.060
The Distance from Centroid Target #5 to Centroid Target #1:	0.263

SERIAL NUMBER: G6410251. __0
TARGET NUMBER: 1
FILE DATE: 09/17/2004
FILE TIME: 09:53

X CENTROID: 0.128
Y CENTROID: -0.079
POA TO CENTROID: 0.151
HORZ SPREAD: 1.256
VERT SPREAD: 1.979
GROUP SPREAD: 2.077
MIN RADIUS: 0.320
MAX RADIUS: 1.192
MEAN RADIUS: 0.744
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.781	0.643
2:	0.520	0.641
3:	0.616	1.008
4:	0.446	-0.042
5:	0.140	-0.604
6:	-0.016	-0.971
7:	-0.472	-0.722
8:	-0.275	-0.320
9:	-0.475	0.293
10:	0.017	-0.721



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410251. __0

TARGET NUMBER: 2

FILE DATE: 09/17/2004

FILE TIME: 09:53

X CENTROID: -0.308

Y CENTROID: -0.260

POA TO CENTROID: 0.403

HORZ SPREAD: 1.486

VERT SPREAD: 1.953

GROUP SPREAD: 2.155

MIN RADIUS: 0.197

MAX RADIUS: 1.093

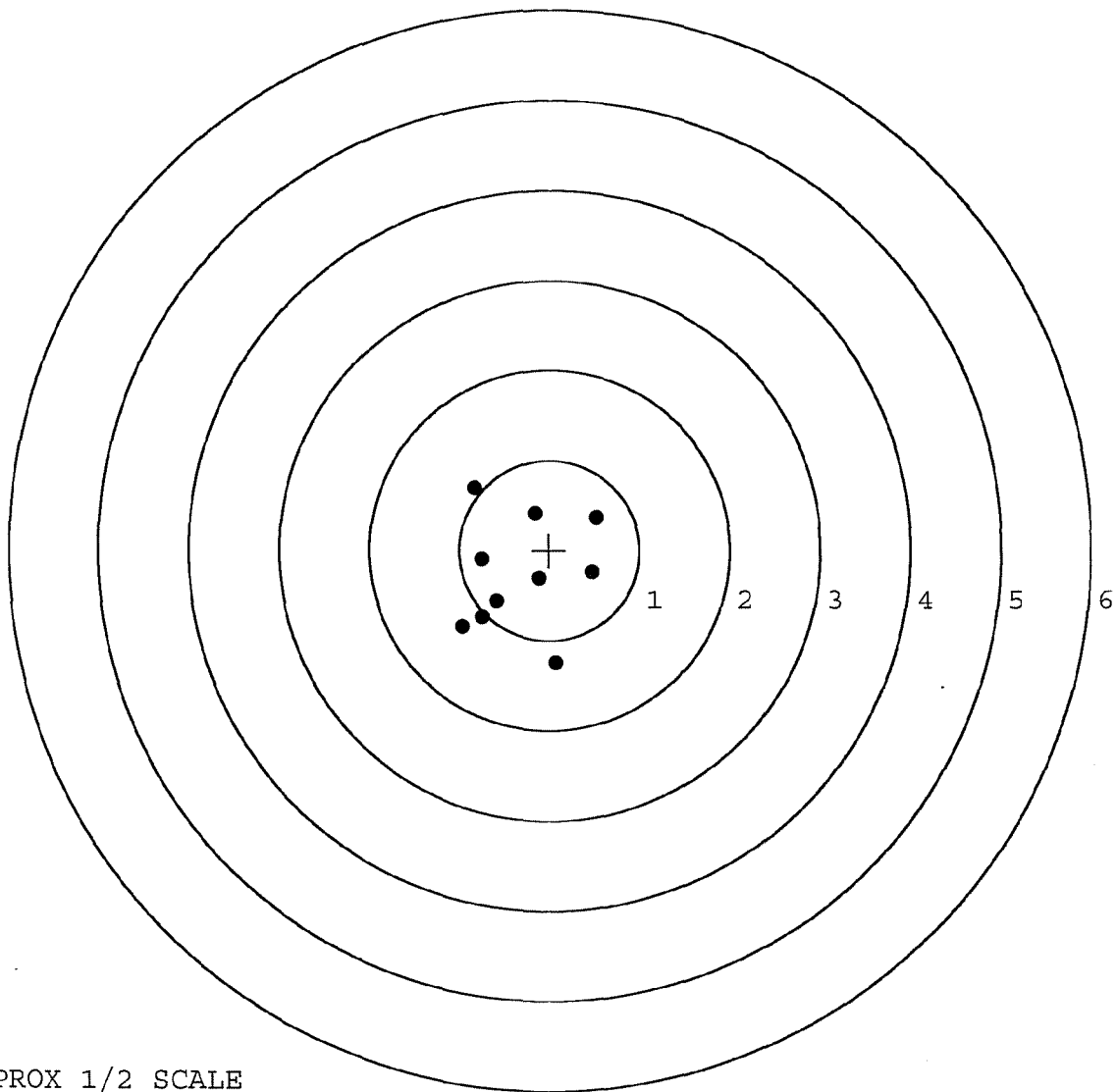
MEAN RADIUS: 0.728

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.079	-1.254
2:	0.474	-0.248
3:	0.523	0.365
4:	-0.119	-0.318
5:	-0.587	-0.572
6:	-0.744	-0.740
7:	-0.963	-0.847
8:	-0.748	-0.100
9:	-0.162	0.411
10:	-0.831	0.699



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410251. 0

TARGET NUMBER: 3

FILE DATE: 09/17/2004

FILE TIME: 09:53

POINT#	X	Y
1:	-1.676	-0.749
2:	-0.526	-0.897
3:	0.472	-0.597
4:	0.158	-0.270
5:	0.610	-0.059
6:	0.227	0.190
7:	0.903	0.399
8:	0.595	0.490
9:	-0.386	0.312
10:	-0.740	-0.019

X CENTROID: -0.036

Y CENTROID: -0.120

POA TO CENTROID: 0.125

HORZ SPREAD: 2.579

VERT SPREAD: 1.387

GROUP SPREAD: 2.823

MIN RADIUS: 0.245

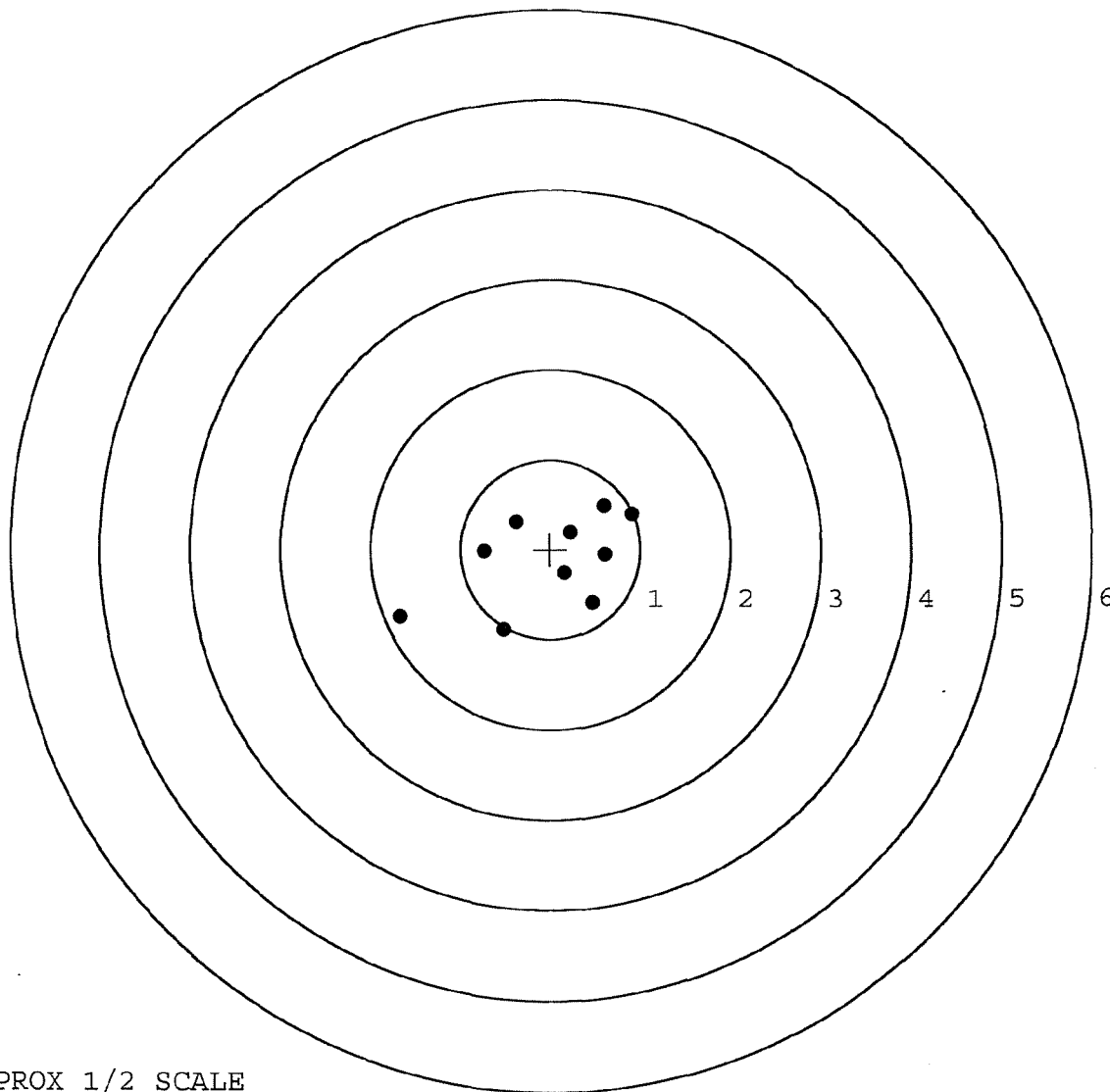
MAX RADIUS: 1.756

MEAN RADIUS: 0.789

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410251. 0

TARGET NUMBER: 4

FILE DATE: 09/17/2004

FILE TIME: 09:53

POINT#	X	Y
1:	1.217	-0.385
2:	1.191	-0.190
3:	1.038	0.186
4:	0.477	-0.526
5:	-0.583	-0.849
6:	-1.353	-0.514
7:	0.068	0.114
8:	-0.282	0.466
9:	0.517	0.674
10:	-0.583	0.646

X CENTROID: 0.171

Y CENTROID: -0.038

POA TO CENTROID: 0.175

HORZ SPREAD: 2.570

VERT SPREAD: 1.523

GROUP SPREAD: 2.573

MIN RADIUS: 0.183

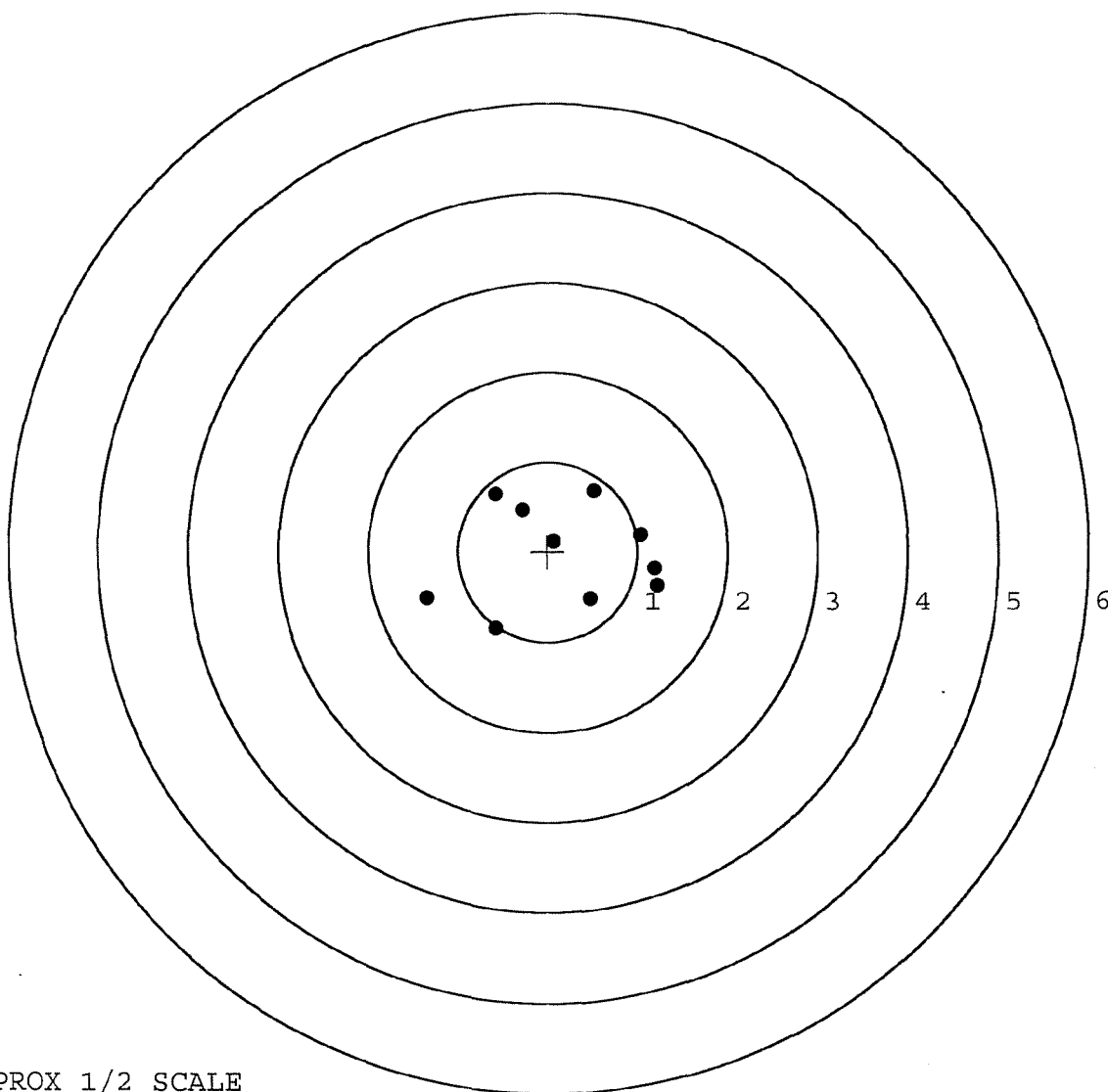
MAX RADIUS: 1.596

MEAN RADIUS: 0.898

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

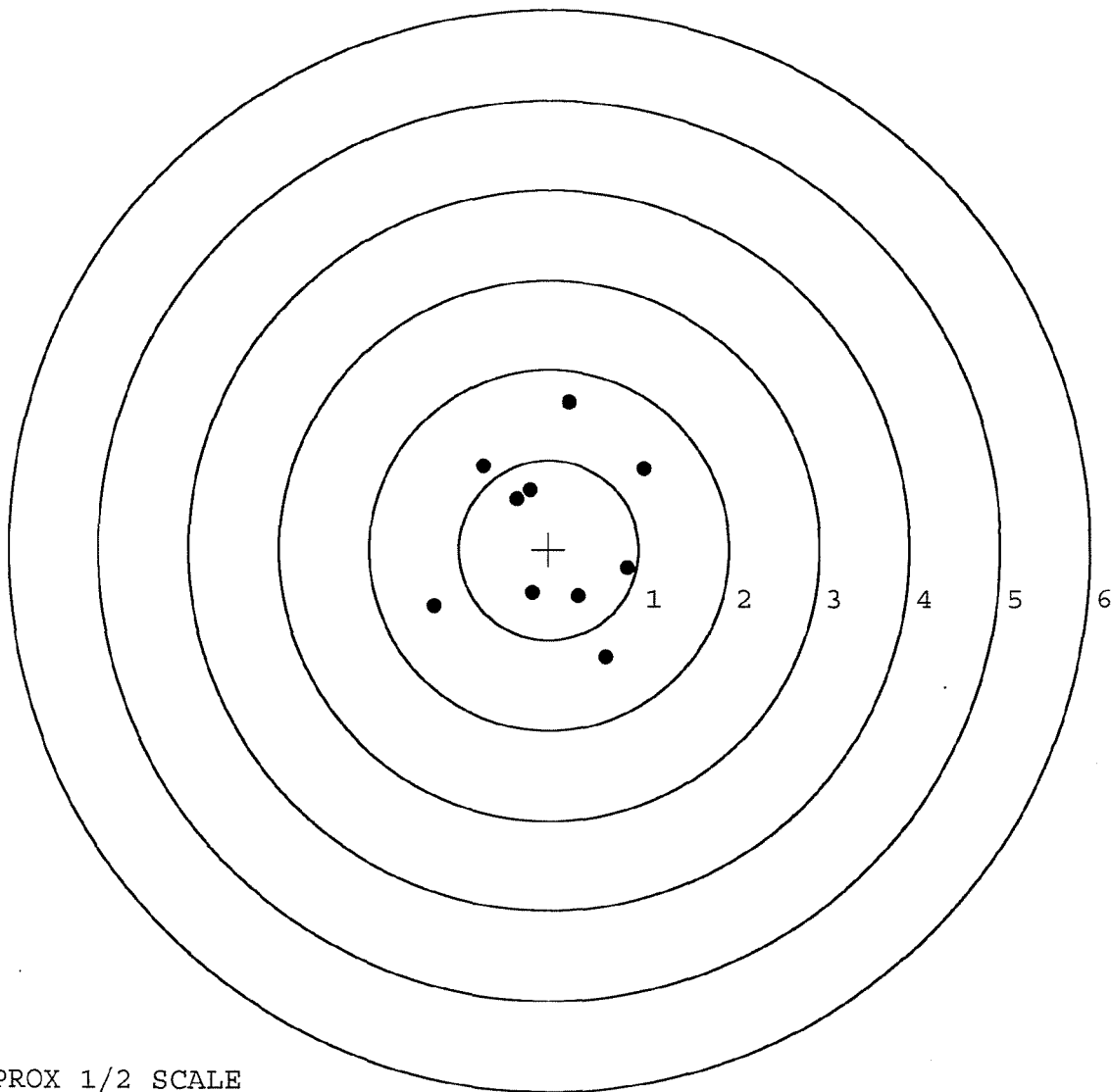


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410251. __0
TARGET NUMBER: 5
FILE DATE: 09/17/2004
FILE TIME: 09:53

X CENTROID: 0.037
Y CENTROID: 0.167
POA TO CENTROID: 0.171
HORZ SPREAD: 2.335
VERT SPREAD: 2.839
GROUP SPREAD: 2.792
MIN RADIUS: 0.553
MAX RADIUS: 1.536
MEAN RADIUS: 1.032
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.637	-1.199
2:	0.874	-0.208
3:	0.329	-0.522
4:	-0.185	-0.480
5:	-1.278	-0.628
6:	1.057	0.902
7:	-0.210	0.662
8:	-0.357	0.562
9:	-0.727	0.939
10:	0.226	1.640



TARGET APPROX 1/2 SCALE