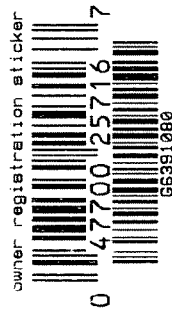


G 64102 P-0

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM

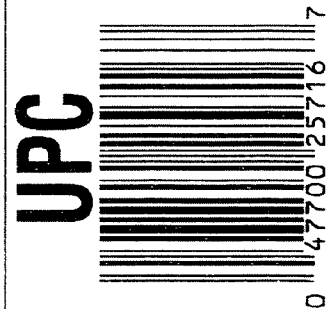


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6391080



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYST
UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYST
UPC



SERIAL NO.



10/27/2004 11:09:26 AM

Crib

6

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 # G6410280

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTL
600	PROOF		8-24-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-04	RTL
610	DIS-ASSEMBLE GUN	AUG 25 2004	8-24-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		8/25/04	JB
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		9/7	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10/5/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/5/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/5/04	DA
	D) OIL FIRING PIN ASSEMBLY		10-11-04	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>	11-15-04	RA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.9</u> <u>2.9</u> <u>2.9</u>	11-15-04	RA
	H) TRIGGER PULL TEST AND RETAINABILITY			D
	I) FIRING PIN INDENT .020 MIN	<u>1024</u> <u>1022</u> <u>1024</u>	11-15-04	RA
	J) ASSEMBLE STOCK		10-11-04	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	10-26-04	RA
	MALFUNCTION	CORRECTION		N/A
	MALFUNCTION	CORRECTION		N/A
	MALFUNCTION	CORRECTION		N/A
	MALFUNCTION	CORRECTION		N/A
645	INSPECT FOR LIVE AMMO		10-26-04	RA
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.86</u> <u>2.94</u> <u>2.93</u> <u>2.86</u>	11-15-04	RA
	C) FUNCTION		11-29-04	RTL
660	PACK		11/29/04	RA

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	2.09	2.26		2.04	
PULL #2	2.39	2.30		2.04	
PULL #3	2.60	2.35		2.08	
PULL #4	2.57	2.29		2.06	
PULL #5	2.71	2.22		2.09	
TOTAL	12.36	11.42		10.31	
AVERAGE	2.47	2.28		2.06	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.03	3.15		
PULL #2	3.10	3.15		
PULL #3	3.12	3.11		
PULL #4	3.12	3.12		
PULL #5	3.10	3.02		
TOTAL	15.47	15.55		
AVERAGE	3.09	3.11		

	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	4.20	4.04		4.49
PULL #2	4.17	3.90		4.50
PULL #3	4.08	4.02		4.49
PULL #4	4.11	3.96		4.45
PULL #5	4.11	4.05		4.48
TOTAL	20.67	19.97		22.41
AVERAGE	4.13	3.99		4.48

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410280.___0
FILE DATE AND TIME: 10/26/2004 08:14

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.015
The Average Y Centroid of the Five Target Set:	0.163
The Average Point of Impact of the Five Target Set:	0.163
The Average Mean Radius of the Five Target Set:	0.728
The Distance from POA to Centroid Target #1:	0.246
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.277
The Distance from Centroid Target #4 to Centroid Target #1:	0.353
The Distance from Centroid Target #5 to Centroid Target #1:	0.224

SERIAL NUMBER: G6410280. 0

TARGET NUMBER: 1

FILE DATE: 10/26/2004

FILE TIME: 08:14

X CENTROID: 0.059

Y CENTROID: 0.239

POA TO CENTROID: 0.246

HORZ SPREAD: 2.016

VERT SPREAD: 2.181

GROUP SPREAD: 2.503

MIN RADIUS: 0.164

MAX RADIUS: 1.486

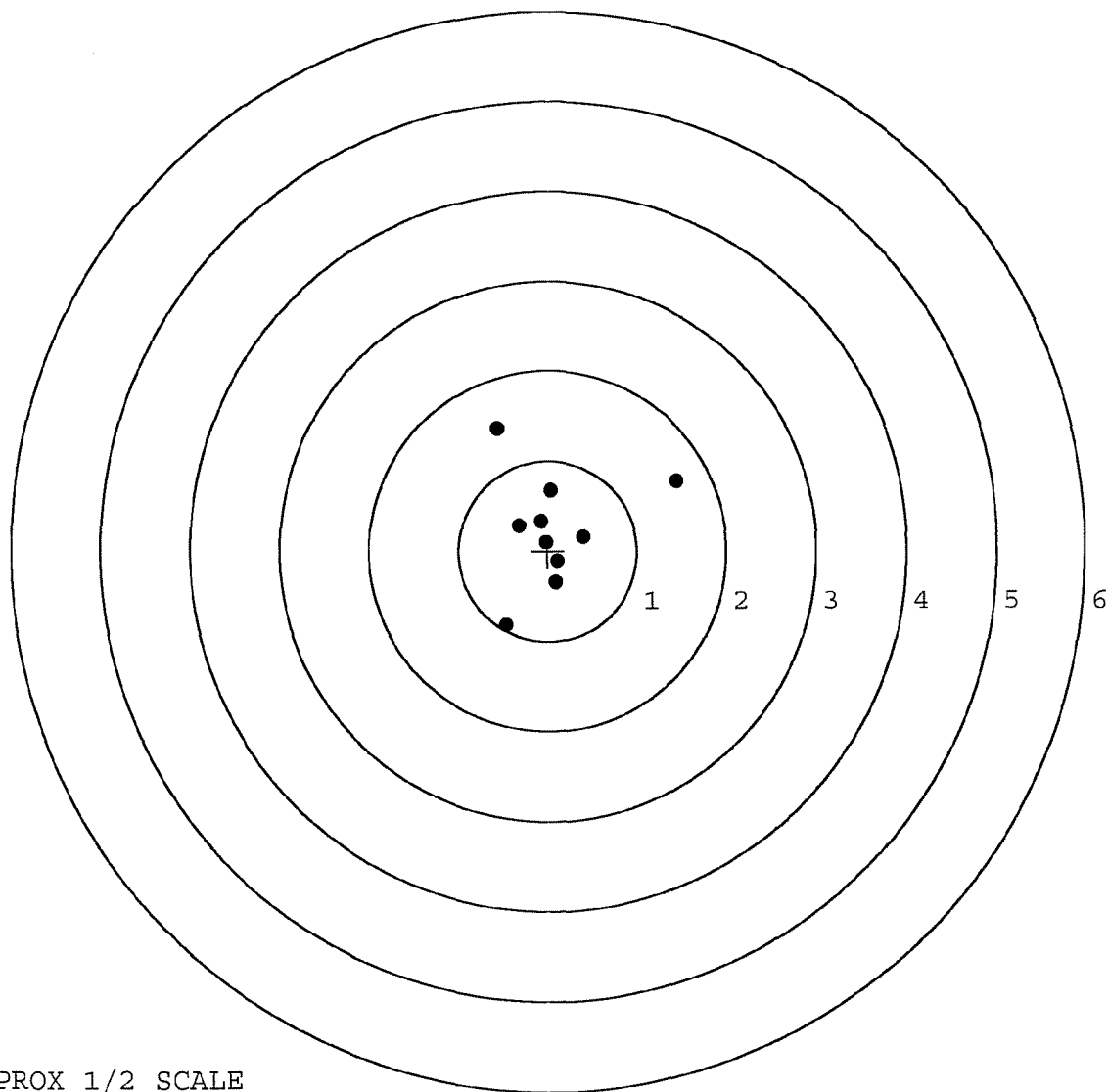
MEAN RADIUS: 0.641

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.443	0.778
2:	-0.573	1.355
3:	0.030	0.673
4:	-0.328	0.283
5:	0.402	0.164
6:	0.089	-0.348
7:	-0.479	-0.826
8:	-0.026	0.099
9:	-0.084	0.329
10:	0.111	-0.114



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410280. __0

TARGET NUMBER: 2

FILE DATE: 10/26/2004

FILE TIME: 08:14

X CENTROID: 0.162

Y CENTROID: 0.199

POA TO CENTROID: 0.256

HORZ SPREAD: 2.263

VERT SPREAD: 1.418

GROUP SPREAD: 2.469

MIN RADIUS: 0.154

MAX RADIUS: 1.307

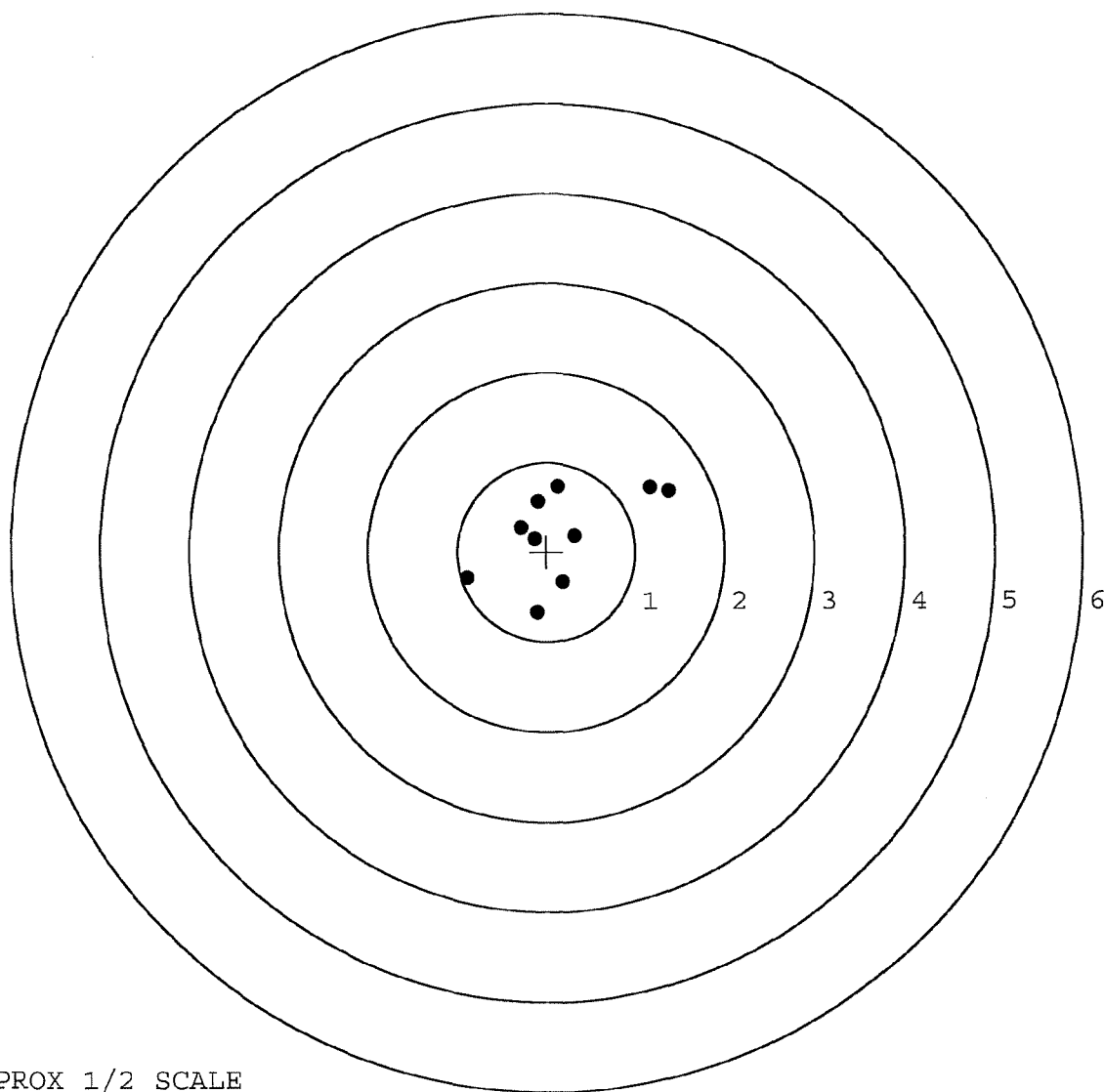
MEAN RADIUS: 0.697

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.373	0.690
2:	1.165	0.724
3:	0.316	0.185
4:	0.183	-0.336
5:	-0.113	-0.686
6:	-0.890	-0.297
7:	-0.137	0.141
8:	-0.294	0.272
9:	0.126	0.732
10:	-0.106	0.561



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410280. 0

TARGET NUMBER: 3

FILE DATE: 10/26/2004

FILE TIME: 08:14

X CENTROID: 0.166

Y CENTROID: -0.016

POA TO CENTROID: 0.167

HORZ SPREAD: 1.511

VERT SPREAD: 2.501

GROUP SPREAD: 2.542

MIN RADIUS: 0.170

MAX RADIUS: 1.453

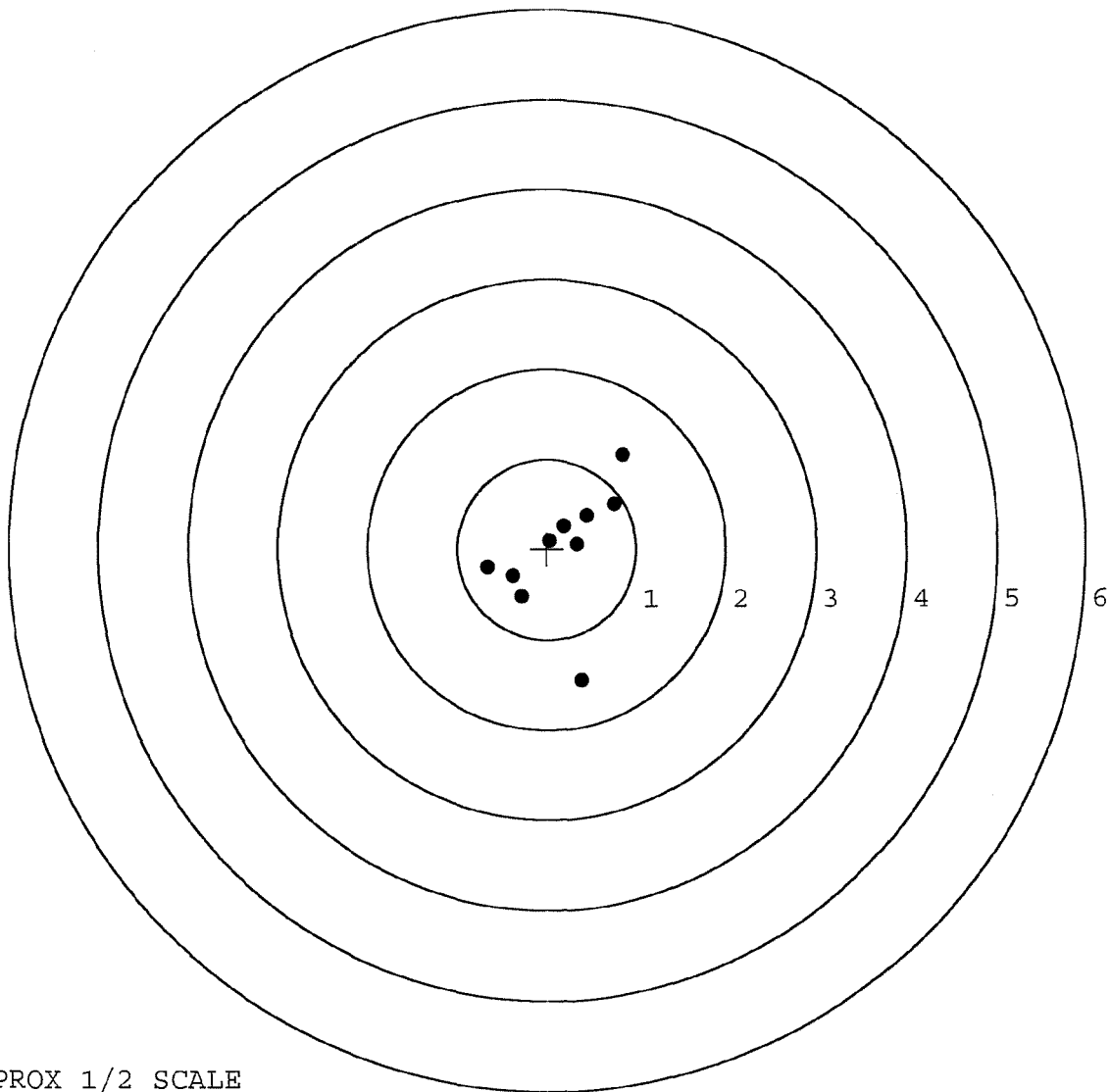
MEAN RADIUS: 0.677

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.393	-1.451
2:	-0.289	-0.531
3:	-0.381	-0.303
4:	-0.661	-0.206
5:	0.033	0.090
6:	0.339	0.054
7:	0.184	0.257
8:	0.442	0.379
9:	0.753	0.501
10:	0.850	1.050



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410280. 0

TARGET NUMBER: 4

FILE DATE: 10/26/2004

FILE TIME: 08:14

X CENTROID: -0.275

Y CENTROID: 0.354

POA TO CENTROID: 0.448

HORZ SPREAD: 2.789

VERT SPREAD: 2.266

GROUP SPREAD: 2.795

MIN RADIUS: 0.244

MAX RADIUS: 1.601

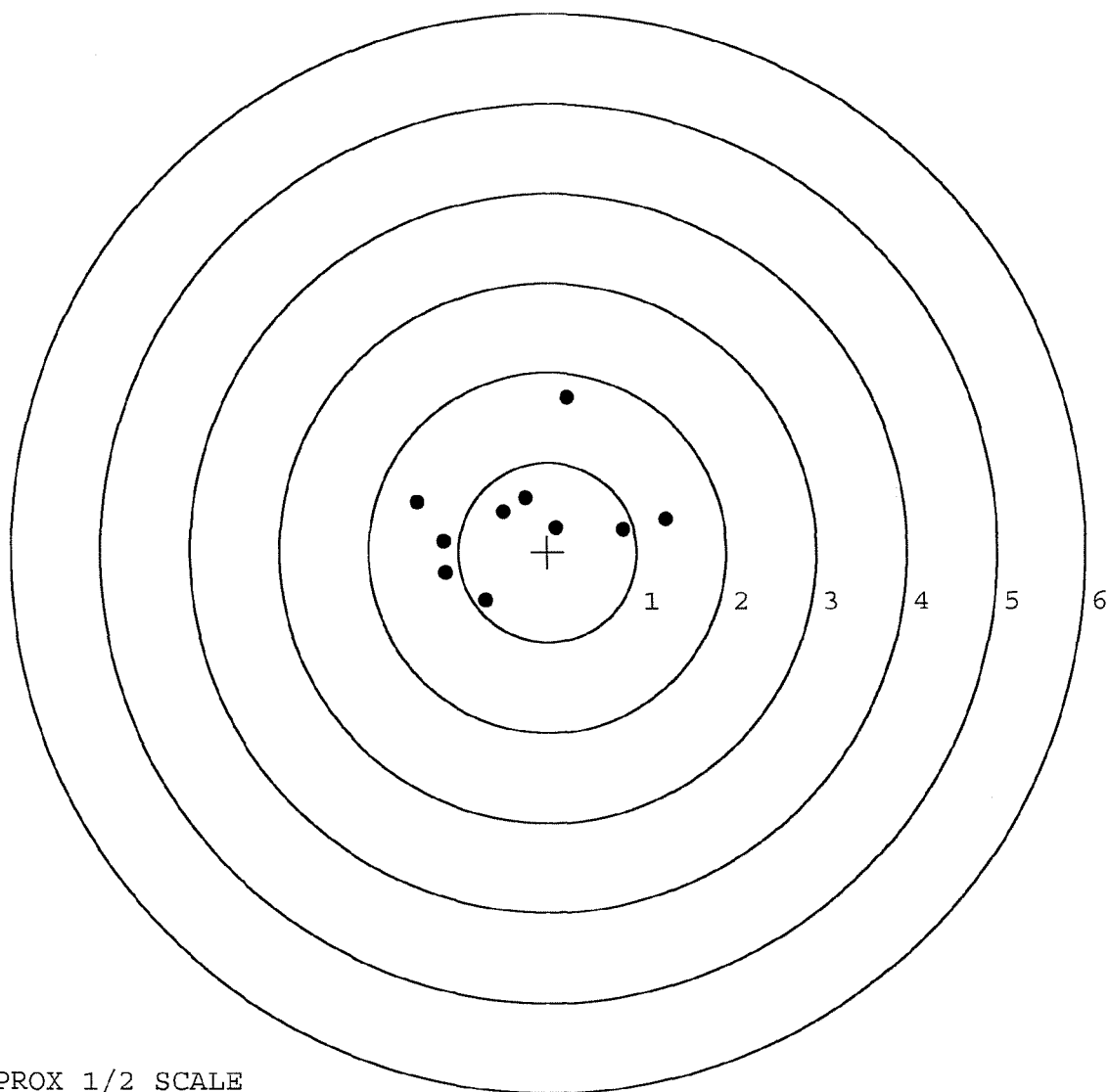
MEAN RADIUS: 0.921

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.326	0.362
2:	0.844	0.257
3:	0.093	0.273
4:	-0.256	0.603
5:	-0.501	0.447
6:	-1.463	0.550
7:	-1.163	0.120
8:	-1.143	-0.246
9:	-0.694	-0.545
10:	0.209	1.721



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410280.___0

TARGET NUMBER: 5

FILE DATE: 10/26/2004

FILE TIME: 08:14

X CENTROID: -0.037

Y CENTROID: 0.036

POA TO CENTROID: 0.052

HORZ SPREAD: 2.256

VERT SPREAD: 1.378

GROUP SPREAD: 2.431

MIN RADIUS: 0.169

MAX RADIUS: 1.354

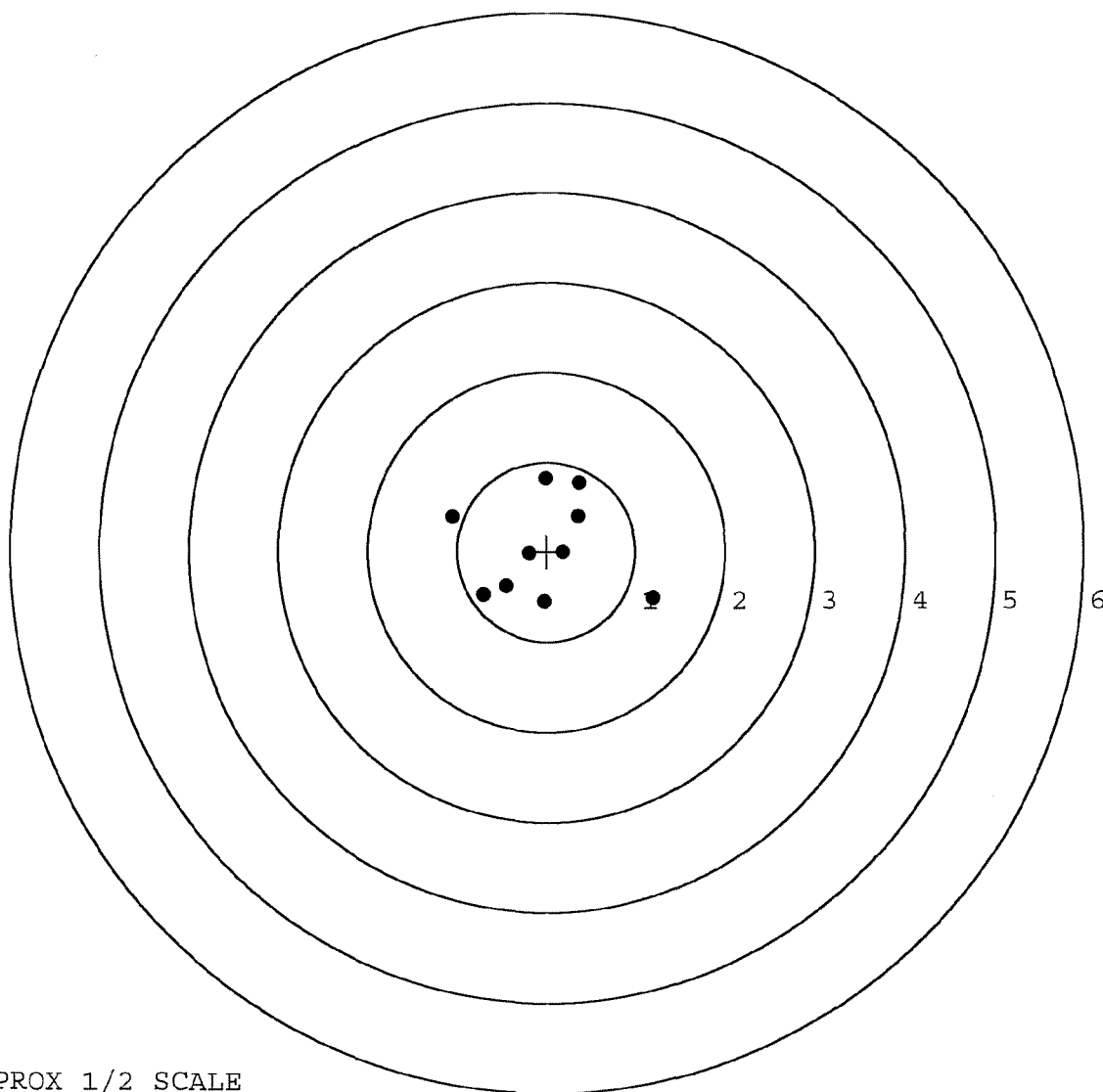
MEAN RADIUS: 0.703

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.365	0.770
2:	-0.019	0.817
3:	-1.059	0.384
4:	-0.709	-0.487
5:	-0.456	-0.398
6:	-0.030	-0.561
7:	-0.194	-0.025
8:	0.186	-0.009
9:	0.350	0.394
10:	1.197	-0.521



TARGET APPROX 1/2 SCALE