

G 6410293

9/27/2004 10:33:18 AM

Chib

19

Original

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

01PC001

Flat Black Powder Coat, Barrel and



0003451403

0560

89SWS1

Reassemble Action.



0003451404

0690

89SWS1

Pack Rifle



0003451397

0700

89SWS1

Stencil SWS Container



.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



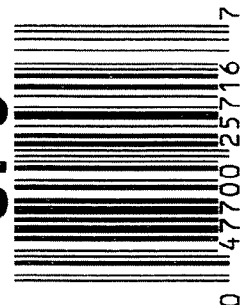
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410293

UPC



M2400149815

7/22/2004 3:21:04 PM

Chb

2

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 # G6410293

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 <i>BS</i>		
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)		8	
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-1-04	<i>Ru</i>
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-1-04	<i>Ru</i>
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-1-04	<i>Ru</i>
	D) OIL FIRING PIN ASSEMBLY		9-1-04	<i>Ru</i>
	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>6.0</u> <u>6.25</u> <u>6.2</u>	9-20-04	RTL
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.5</u> <u>3.0</u>	9-20-04	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.024</u> <u>.025</u>	9-20-04	RTL
	J) ASSEMBLE STOCK		9-1-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-20-04	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-1-04	RW
	M) IRON SIGHT ALIGNMENT		9-1-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-1-04	RW
640	GALLERY TEST AND TARGET	PASS FAIL	9-15-04	TRW
	MALFUNCTION	CORRECTION	9-15-04	TRW
	MALFUNCTION	CORRECTION	9-15-04	TRW
	MALFUNCTION	CORRECTION	9-15-04	TRW
	MALFUNCTION	CORRECTION	9-15-04	TRW
645	INSPECT FOR LIVE AMMO		9-15-04	TRW
655	FINAL INSPECTION A) HEADSPACE		9-20-04	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.97</u> <u>2.84</u> <u>2.64</u> <u>2.98</u>	9-20-04	RTL
	C) FUNCTION		9-20-04	RW
660	PACK		9-21-04	Ac

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 9-1-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.26	2.87	2.35	
PULL #2	2.32	2.89	2.54	
PULL #3	2.50	2.83	2.53	
PULL #4	2.25	2.85	2.39	
PULL #5	2.73	2.81	2.23	
TOTAL	12.06	14.25	12.04	
AVERAGE	2.41	2.85	2.40	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.07	
PULL #2	3.17	3.09	
PULL #3	3.18	3.10	
PULL #4	3.19	3.13	
PULL #5	3.07	3.24	
TOTAL	15.85	15.63	
AVERAGE	3.17	3.12	

	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	4.12	4.07		4.03
PULL #2	4.12	4.12		4.08
PULL #3	4.16	4.16		4.01
PULL #4	4.09	3.93		3.92
PULL #5	4.22	4.08		4.01
TOTAL	20.71	20.36		20.05
AVERAGE	4.14	4.07		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410293.___0

FILE DATE AND TIME: 09/15/2004 10:33

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.101
The Average Y Centroid of the Five Target Set:	-0.107
The Average Point of Impact of the Five Target Set:	0.147
The Average Mean Radius of the Five Target Set:	0.798
The Distance from POA to Centroid Target #1:	0.240
The Distance from Centroid Target #2 to Centroid Target #1:	0.236
The Distance from Centroid Target #3 to Centroid Target #1:	0.219
The Distance from Centroid Target #4 to Centroid Target #1:	0.416
The Distance from Centroid Target #5 to Centroid Target #1:	0.285

SERIAL NUMBER: G6410293. __0

TARGET NUMBER: 1

FILE DATE: 09/15/2004

FILE TIME: 10:33

X CENTROID: -0.237

Y CENTROID: 0.040

POA TO CENTROID: 0.240

HORZ SPREAD: 1.710

VERT SPREAD: 3.037

GROUP SPREAD: 3.047

MIN RADIUS: 0.285

MAX RADIUS: 1.888

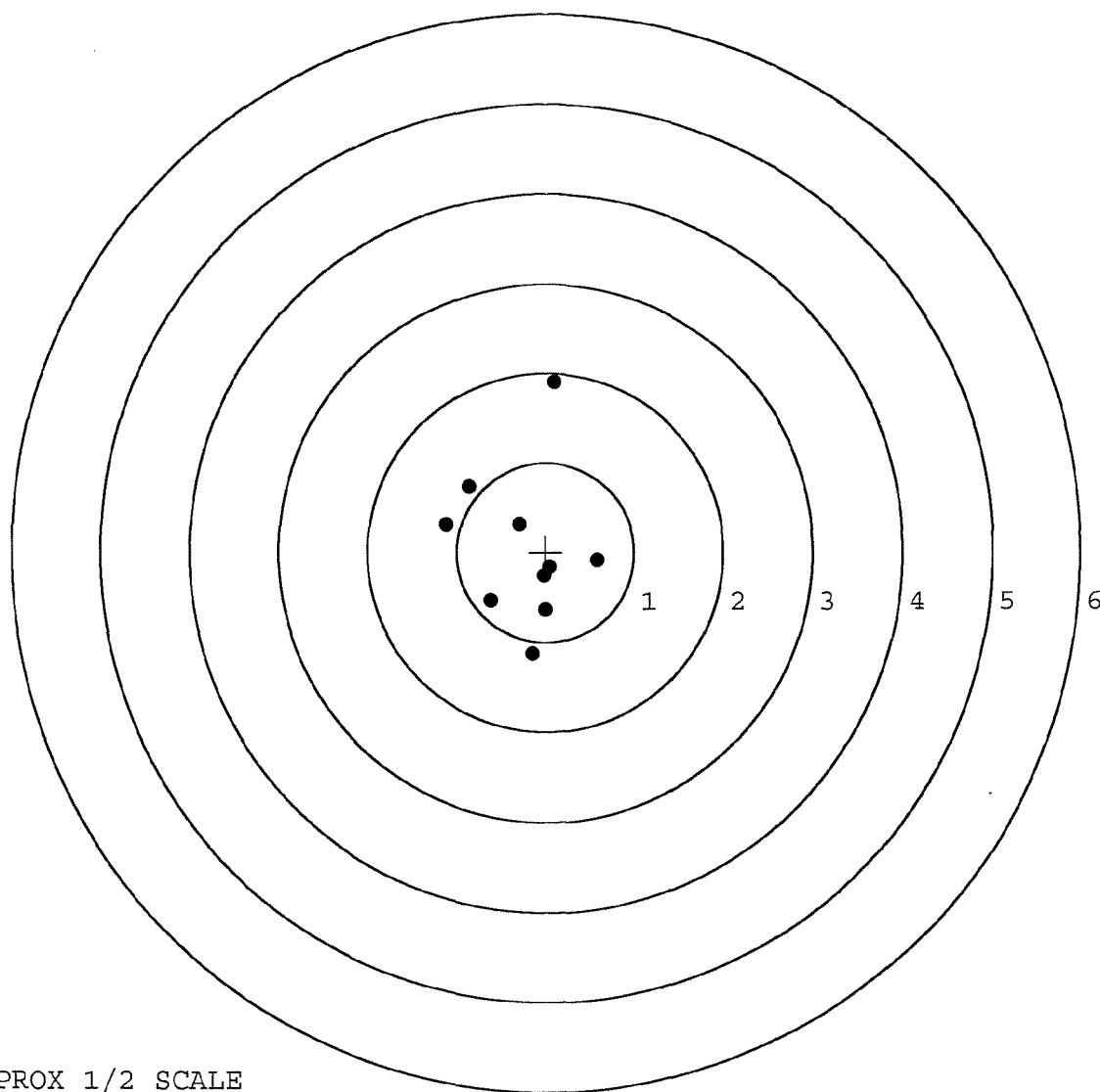
MEAN RADIUS: 0.820

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.148	-1.139
2:	-0.007	-0.648
3:	0.584	-0.087
4:	-0.022	-0.270
5:	-0.622	-0.542
6:	-0.304	0.317
7:	-1.126	0.307
8:	-0.862	0.738
9:	0.096	1.898
10:	0.041	-0.173



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410293. __0

TARGET NUMBER: 2

FILE DATE: 09/15/2004

FILE TIME: 10:33

X CENTROID: -0.002

Y CENTROID: 0.018

POA TO CENTROID: 0.018

HORZ SPREAD: 2.527

VERT SPREAD: 1.411

GROUP SPREAD: 2.626

MIN RADIUS: 0.176

MAX RADIUS: 1.499

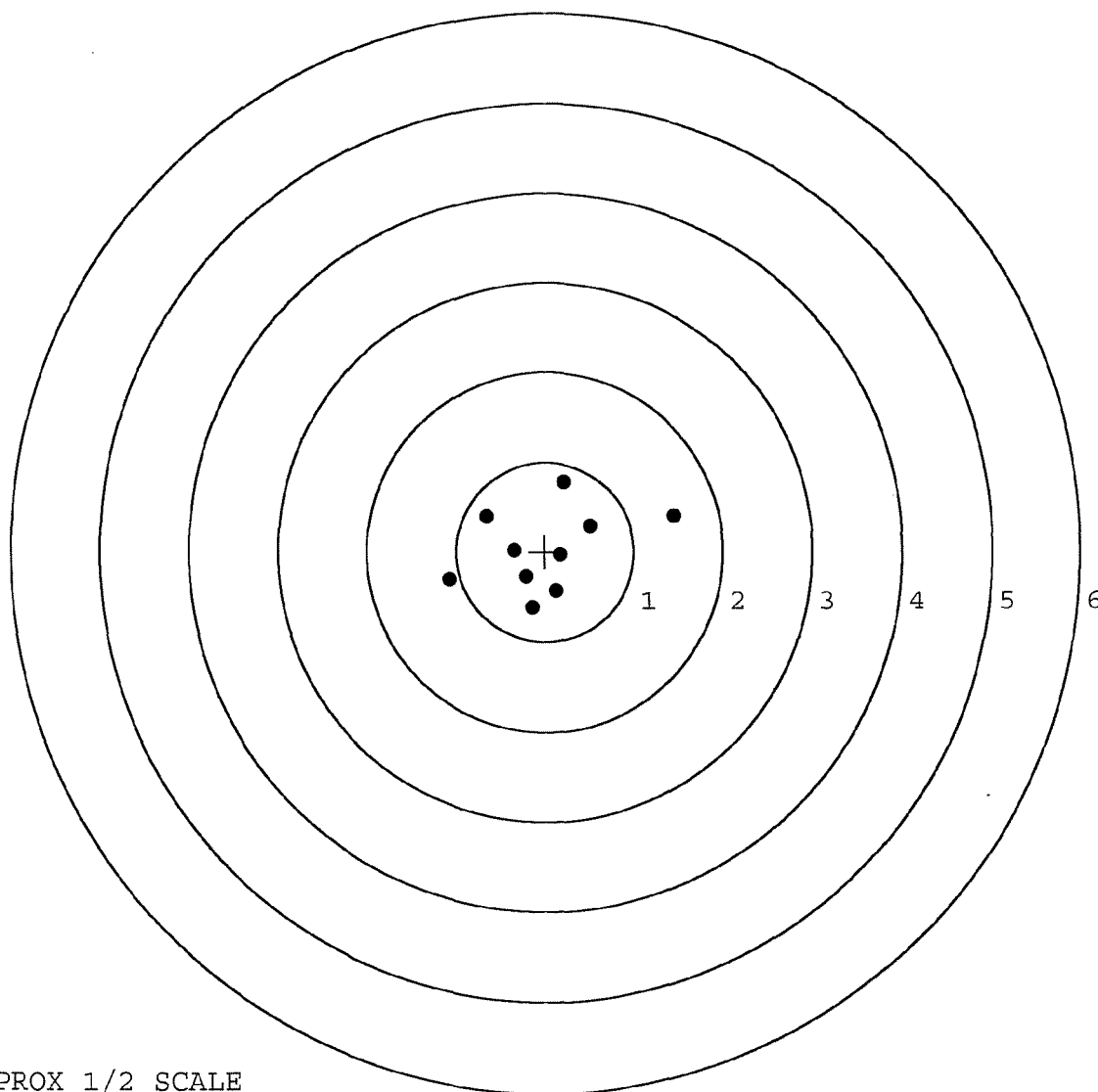
MEAN RADIUS: 0.680

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.448	0.401
2:	0.210	0.781
3:	0.503	0.293
4:	-0.666	0.398
5:	-1.079	-0.315
6:	0.167	-0.034
7:	-0.353	0.015
8:	0.123	-0.444
9:	-0.152	-0.630
10:	-0.217	-0.283



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410293. __0

TARGET NUMBER: 3

FILE DATE: 09/15/2004

FILE TIME: 10:33

X CENTROID: -0.025

Y CENTROID: -0.015

POA TO CENTROID: 0.029

HORZ SPREAD: 1.806

VERT SPREAD: 2.424

GROUP SPREAD: 2.430

MIN RADIUS: 0.455

MAX RADIUS: 1.330

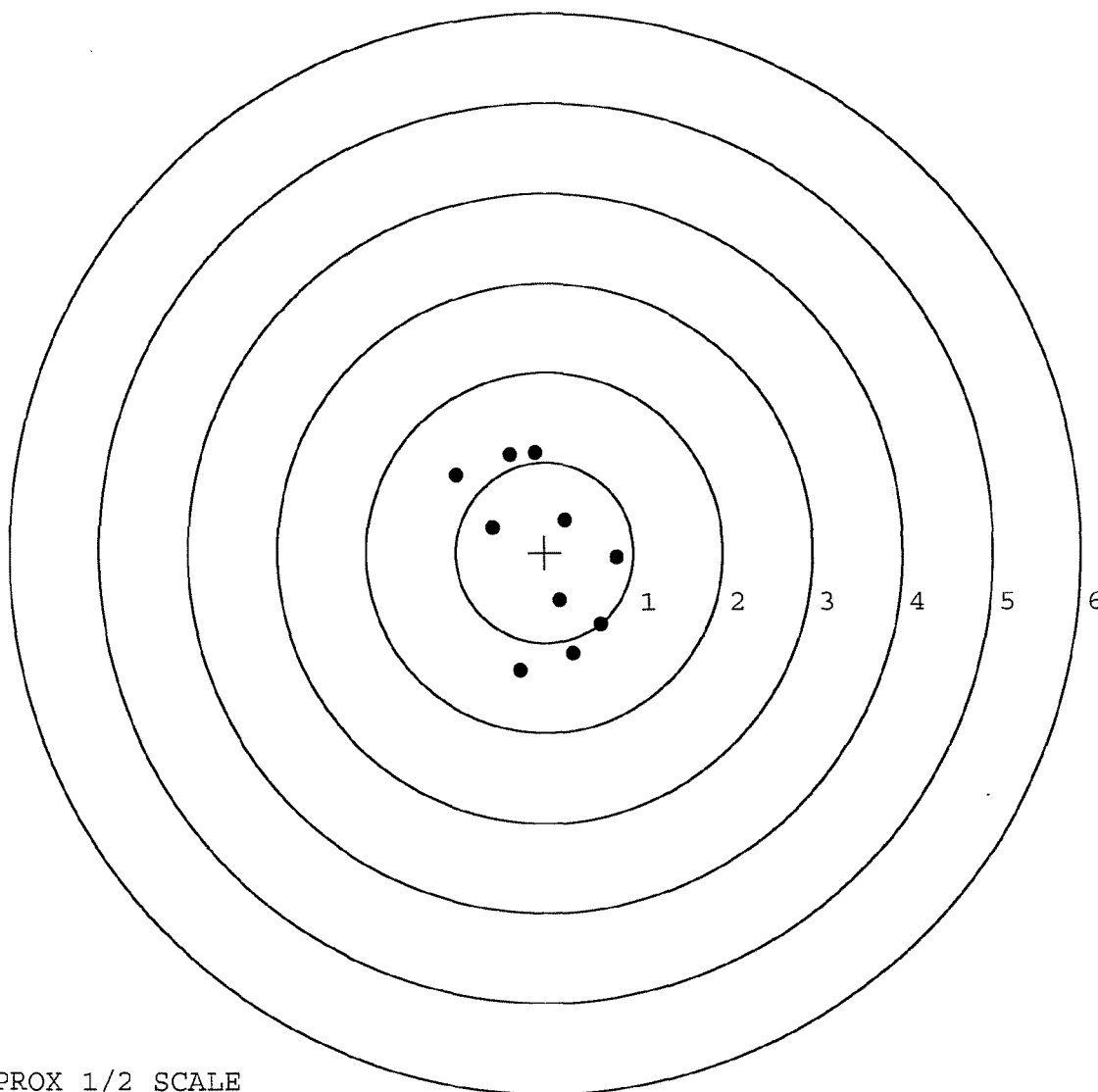
MEAN RADIUS: 0.958

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.811	-0.055
2:	0.624	-0.800
3:	0.318	-1.125
4:	0.162	-0.536
5:	-0.282	-1.320
6:	0.224	0.365
7:	-0.597	0.275
8:	-0.116	1.104
9:	-0.400	1.080
10:	-0.995	0.857

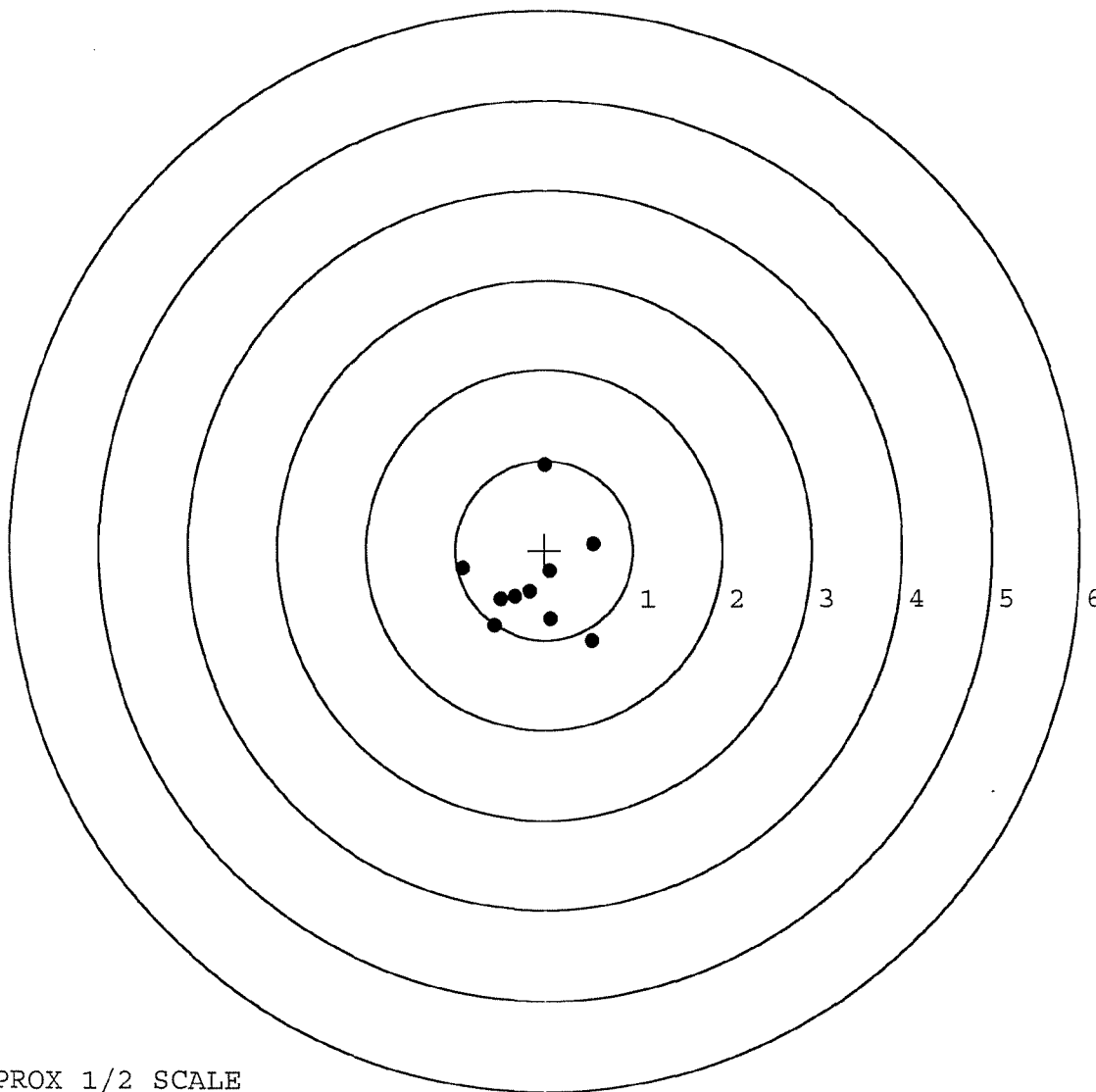


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410293. __0
TARGET NUMBER: 4
FILE DATE: 09/15/2004
FILE TIME: 10:33

X CENTROID: -0.128
Y CENTROID: -0.362
POA TO CENTROID: 0.383
HORZ SPREAD: 1.468
VERT SPREAD: 1.973
GROUP SPREAD: 2.044
MIN RADIUS: 0.109
MAX RADIUS: 1.324
MEAN RADIUS: 0.599
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.533	-1.017
2:	0.063	-0.772
3:	0.552	0.068
4:	-0.001	0.956
5:	0.057	-0.237
6:	-0.170	-0.462
7:	-0.335	-0.532
8:	-0.495	-0.558
9:	-0.567	-0.851
10:	-0.916	-0.210



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410293. __0

TARGET NUMBER: 5

FILE DATE: 09/15/2004

FILE TIME: 10:33

X CENTROID: -0.111

Y CENTROID: -0.216

POA TO CENTROID: 0.243

HORZ SPREAD: 2.072

VERT SPREAD: 2.694

GROUP SPREAD: 3.227

MIN RADIUS: 0.519

MAX RADIUS: 2.123

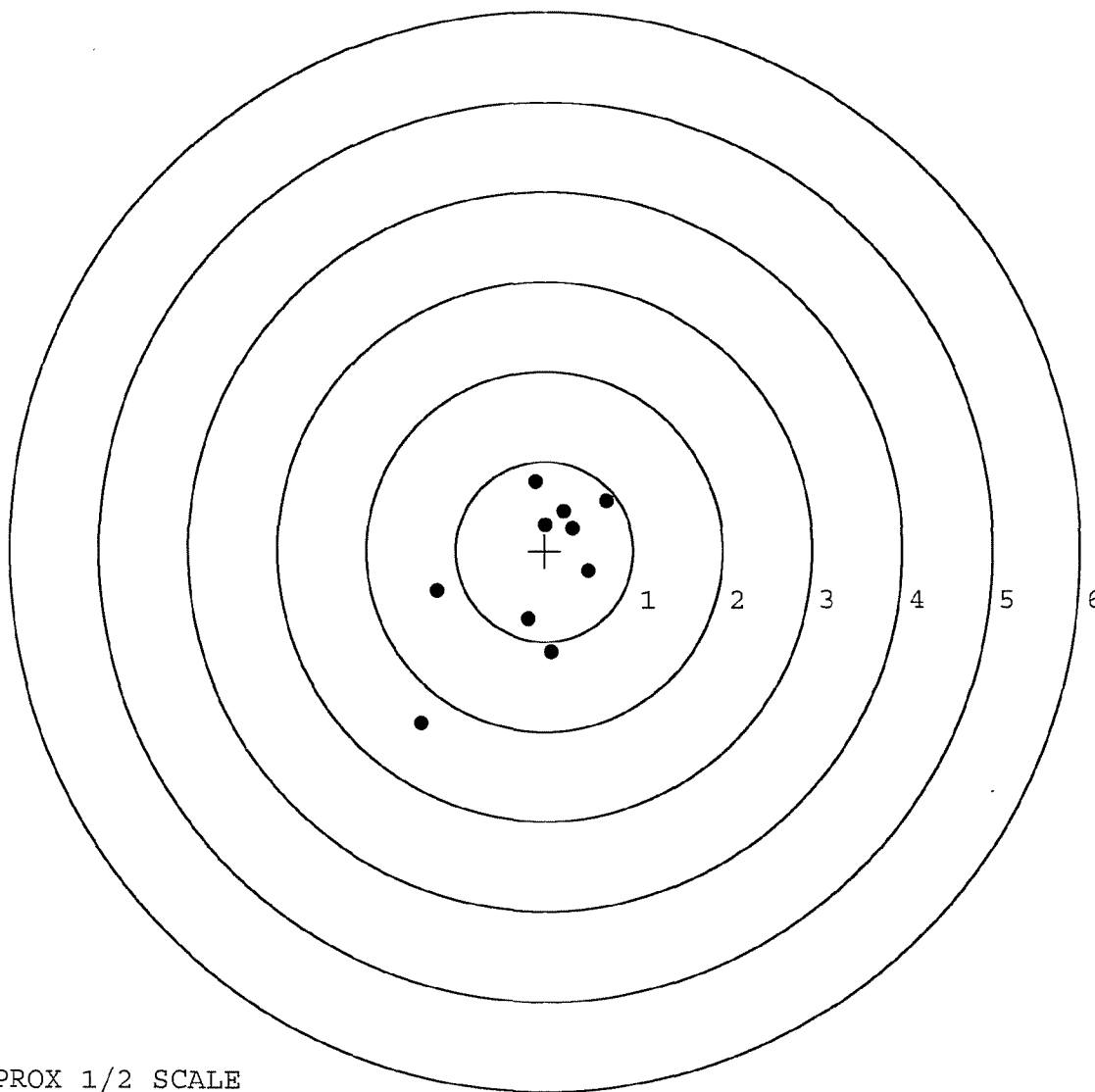
MEAN RADIUS: 0.932

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.070	-1.125
2:	-0.192	-0.756
3:	-1.211	-0.450
4:	-1.383	-1.915
5:	0.489	-0.232
6:	0.689	0.559
7:	0.318	0.251
8:	0.209	0.444
9:	-0.107	0.779
10:	0.004	0.290



TARGET APPROX 1/2 SCALE