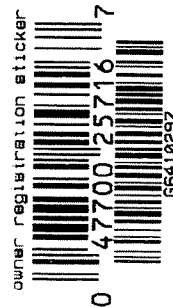


G-641 0297

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

- INSTRUCTION BOOK 3518

DD FORM

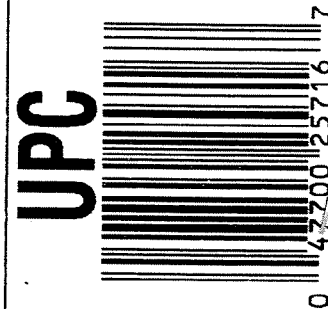


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6410297



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



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



SERIAL NO.



1/10/2005 2:46:09 PM

Original

03

Original

25716

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



.MA25716

Shop Order: SWS10-15-6



.ABSWS10-15-6

Start Date: 1/10/2005

Finish Date: 2/15/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0003662183

0540

01PC001

Flat Black Powder Coat, Barrel and



0003662173

0560

89SWS1

Reassemble Action.



0003662174

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G641 0297

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTZ
600	PROOF		1-25-05	RTZ
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-25-05	RTZ
610	DIS-ASSEMBLE GUN	JAN 26 2005	1-26-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1/31/05	RTZ
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-9-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-9-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-9-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-9-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS	3-29-05	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	3-29-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	3-29-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	3-29-05	Ac
	J) ASSEMBLE STOCK		2-9-05	RTL
	K) ASSEMBLE SWIVEL STUDS		3-29-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-9-05	RTL
	M) IRON SIGHT ALIGNMENT		2-9-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-9-05	RTL
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	2-14-05	TRW
	MALFUNCTION <u>OH BAC</u>	CORRECTION <u>OK</u>	2-16-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-14-05	Ac
655	FINAL INSPECTION A) HEADSPACE		3-29-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u> <u>2.67</u> <u>2.71</u> <u>2.96</u> <u>2.91</u>	3-29-05	TRW
	C) FUNCTION		3-29-05	Ac
660	PACK		3-30-05	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. G6410297

DATE 1-31-05

TESTER TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.27	2.22		2.11	
PULL #2	2.37	2.30		2.24	
PULL #3	2.37	2.42		2.11	
PULL #4	2.39	2.22		2.13	
PULL #5	2.45	2.27		2.08	
TOTAL	11.85	11.43		10.67	
AVERAGE	2.37	2.28		2.13	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.27	3.24		
PULL #2	3.32	3.37		
PULL #3	3.29	3.35		
PULL #4	3.20	3.34		
PULL #5	3.09	3.31		
TOTAL	16.17	16.61		
AVERAGE	3.23	3.32		

	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	4.52	4.04		4.24
PULL #2	4.21	4.23		4.23
PULL #3	4.21	4.29		4.18
PULL #4	4.12	4.16		4.10
PULL #5	4.19	4.08		4.20
TOTAL	21.25	20.80		20.95
AVERAGE	4.25	4.16		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410297.__0
FILE DATE AND TIME: 02/14/2005 07:45

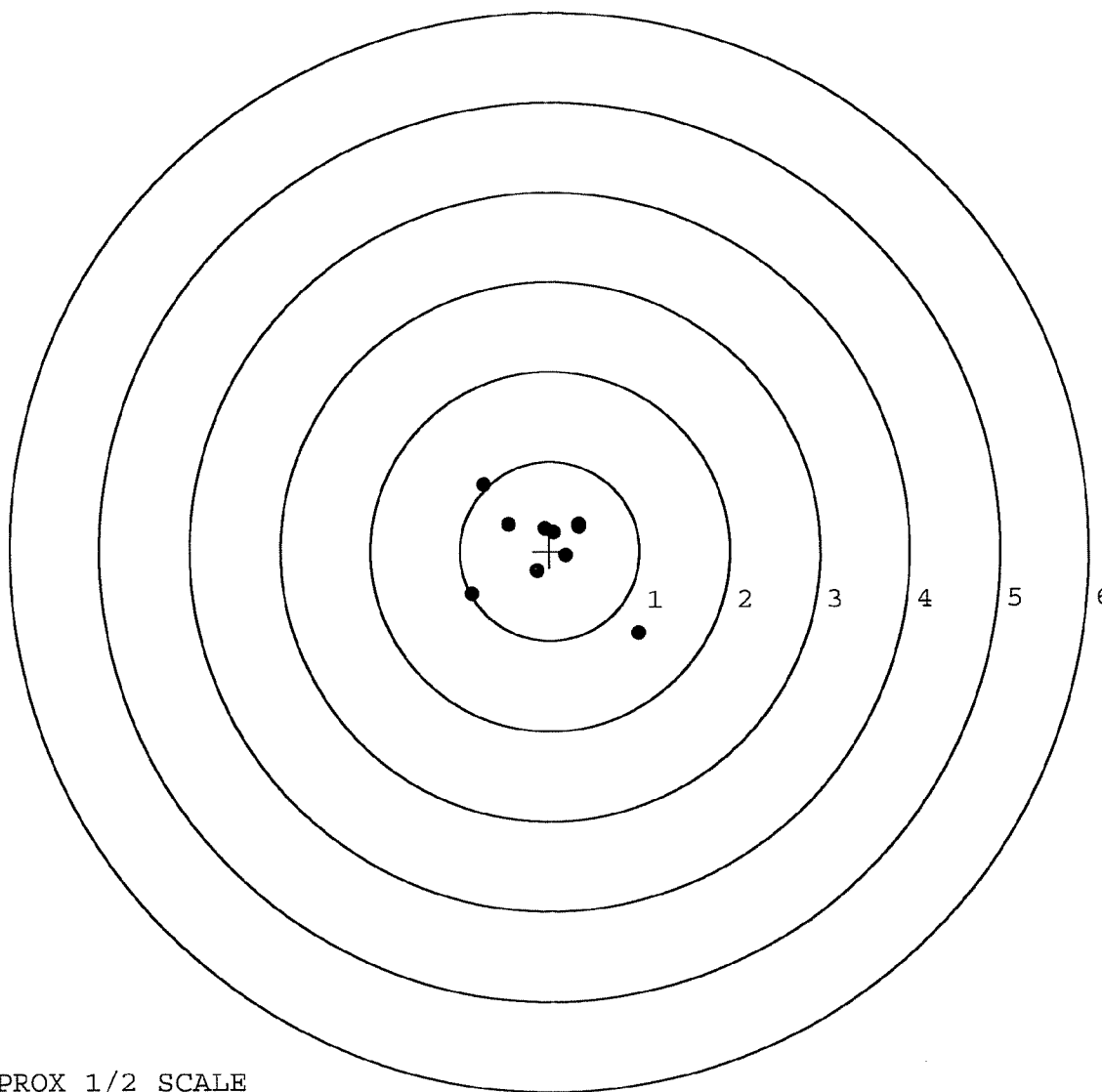
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.070
The Average Y Centroid of the Five Target Set:	0.009
The Average Point of Impact of the Five Target Set:	0.070
The Average Mean Radius of the Five Target Set:	0.703
The Distance from POA to Centroid Target #1:	0.057
The Distance from Centroid Target #2 to Centroid Target #1:	0.126
The Distance from Centroid Target #3 to Centroid Target #1:	0.121
The Distance from Centroid Target #4 to Centroid Target #1:	0.162
The Distance from Centroid Target #5 to Centroid Target #1:	0.130

SERIAL NUMBER: G6410297. __0
TARGET NUMBER: 1
FILE DATE: 02/14/2005
FILE TIME: 07:45

X CENTROID: -0.038
Y CENTROID: 0.043
POA TO CENTROID: 0.057
HORZ SPREAD: 1.856
VERT SPREAD: 1.683
GROUP SPREAD: 2.401
MIN RADIUS: 0.187
MAX RADIUS: 1.414
MEAN RADIUS: 0.569
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.986	-0.933
2:	-0.144	-0.222
3:	-0.870	-0.476
4:	-0.454	0.306
5:	-0.727	0.750
6:	0.331	0.301
7:	-0.059	0.260
8:	0.182	-0.047
9:	0.052	0.207
10:	0.327	0.280



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410297. __0

TARGET NUMBER: 2

FILE DATE: 02/14/2005

FILE TIME: 07:45

POINT#	X	Y
1:	1.026	-0.702
2:	0.644	-0.520
3:	0.344	-0.398
4:	0.495	-0.130
5:	0.216	0.811
6:	-0.734	1.292
7:	-1.384	-0.065
8:	-1.413	-1.042
9:	-0.129	0.232
10:	-0.139	-0.104

X CENTROID: -0.107

Y CENTROID: -0.063

POA TO CENTROID: 0.124

HORZ SPREAD: 2.439

VERT SPREAD: 2.334

GROUP SPREAD: 2.467

MIN RADIUS: 0.052

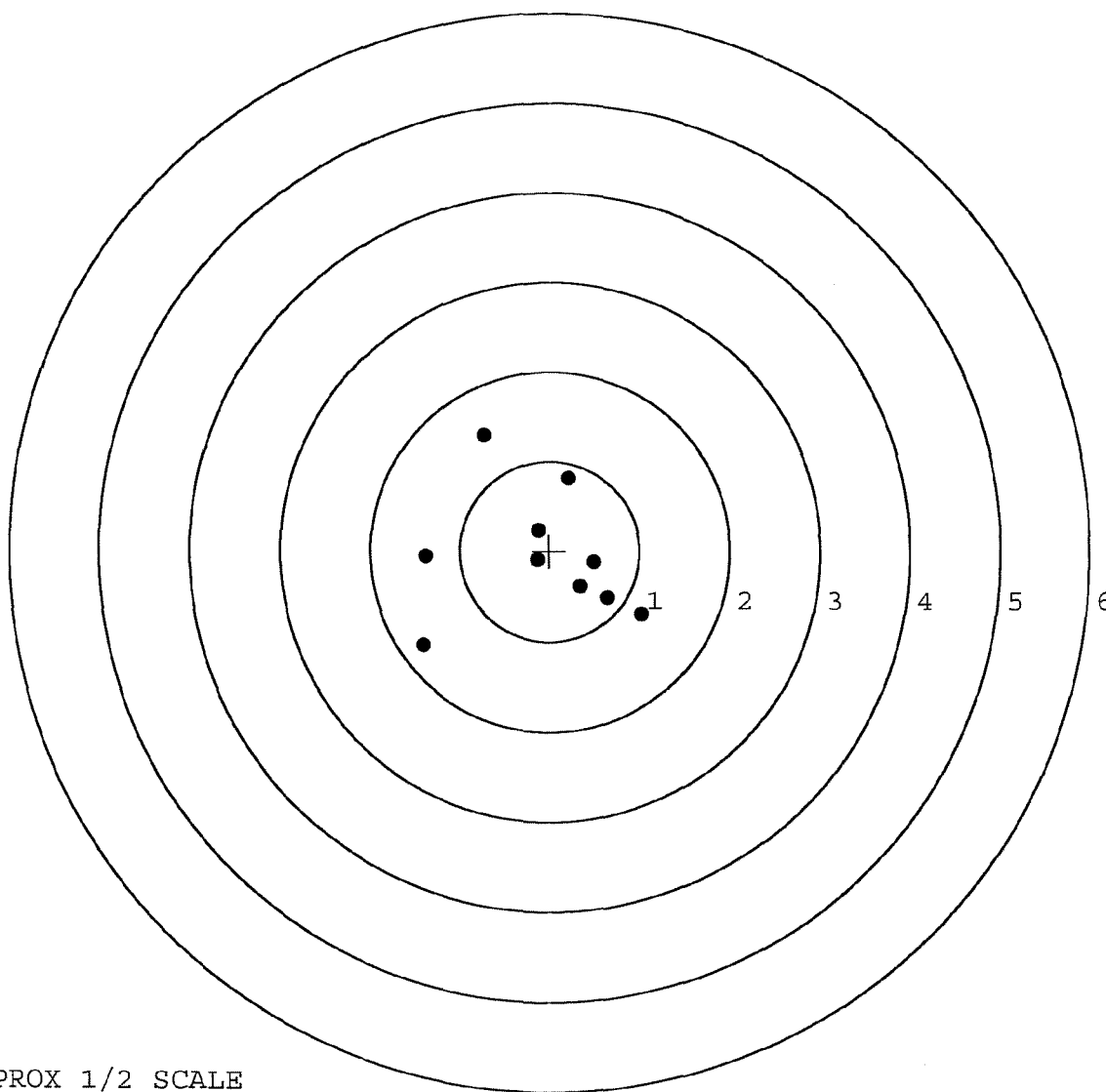
MAX RADIUS: 1.632

MEAN RADIUS: 0.903

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

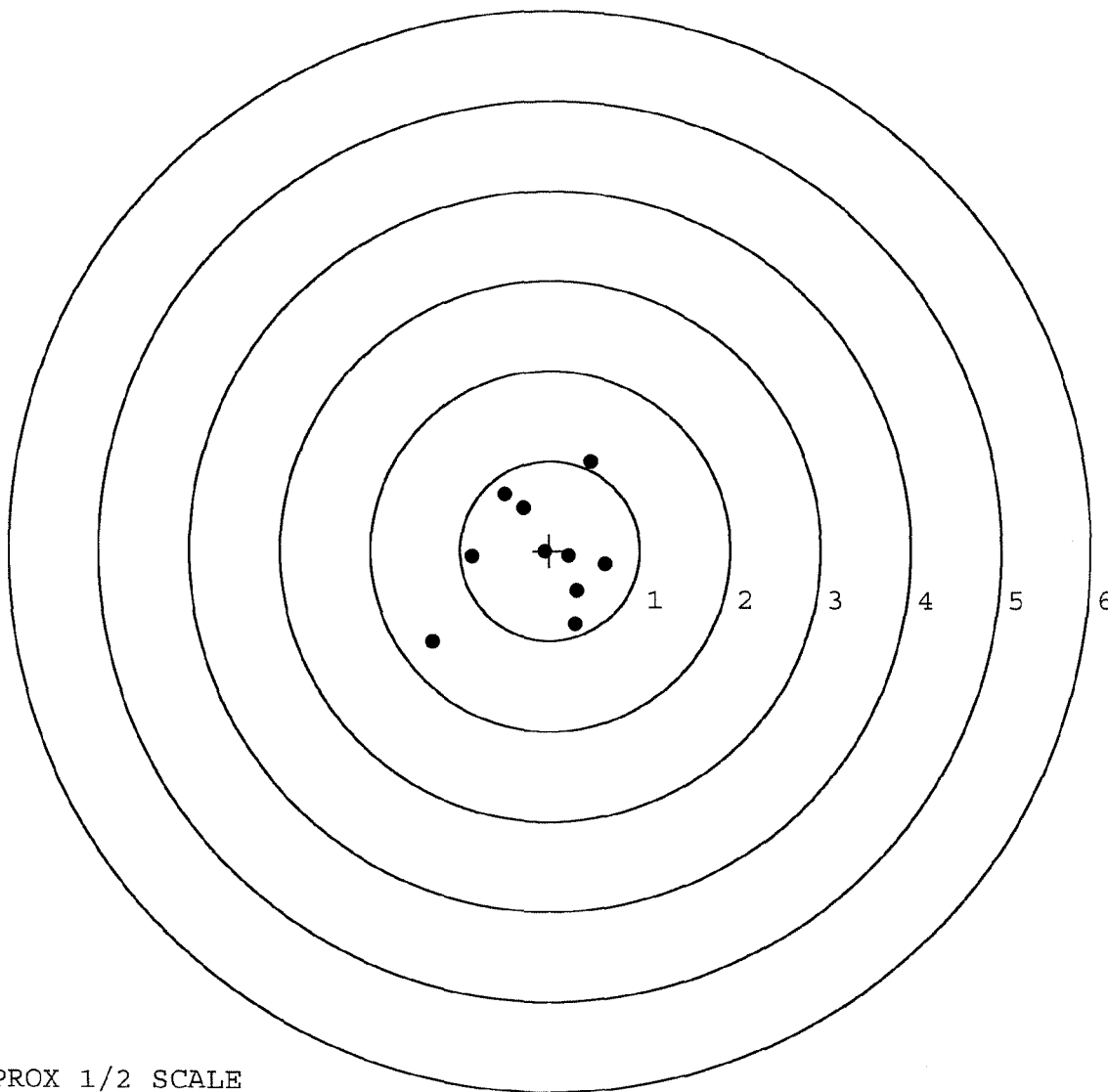


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410297. __0
TARGET NUMBER: 3
FILE DATE: 02/14/2005
FILE TIME: 07:45

POINT#	X	Y
1:	0.620	-0.156
2:	0.304	-0.456
3:	0.290	-0.825
4:	-1.305	-1.022
5:	-0.863	-0.068
6:	0.217	-0.065
7:	-0.055	-0.014
8:	-0.294	0.473
9:	-0.502	0.623
10:	0.456	0.992

X CENTROID: -0.113
Y CENTROID: -0.052
POA TO CENTROID: 0.124
HORZ SPREAD: 1.925
VERT SPREAD: 2.014
GROUP SPREAD: 2.675
MIN RADIUS: 0.069
MAX RADIUS: 1.537
MEAN RADIUS: 0.740
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410297. 0

TARGET NUMBER: 4

FILE DATE: 02/14/2005

FILE TIME: 07:45

POINT#	X	Y
1:	0.414	2.059
2:	0.365	0.336
3:	0.166	0.476
4:	0.110	0.215
5:	0.385	-0.262
6:	0.018	-0.523
7:	-0.421	-0.680
8:	-0.220	-0.116
9:	-0.473	0.168
10:	-0.818	0.371

X CENTROID: -0.047

Y CENTROID: 0.204

POA TO CENTROID: 0.210

HORZ SPREAD: 1.232

VERT SPREAD: 2.739

GROUP SPREAD: 2.863

MIN RADIUS: 0.158

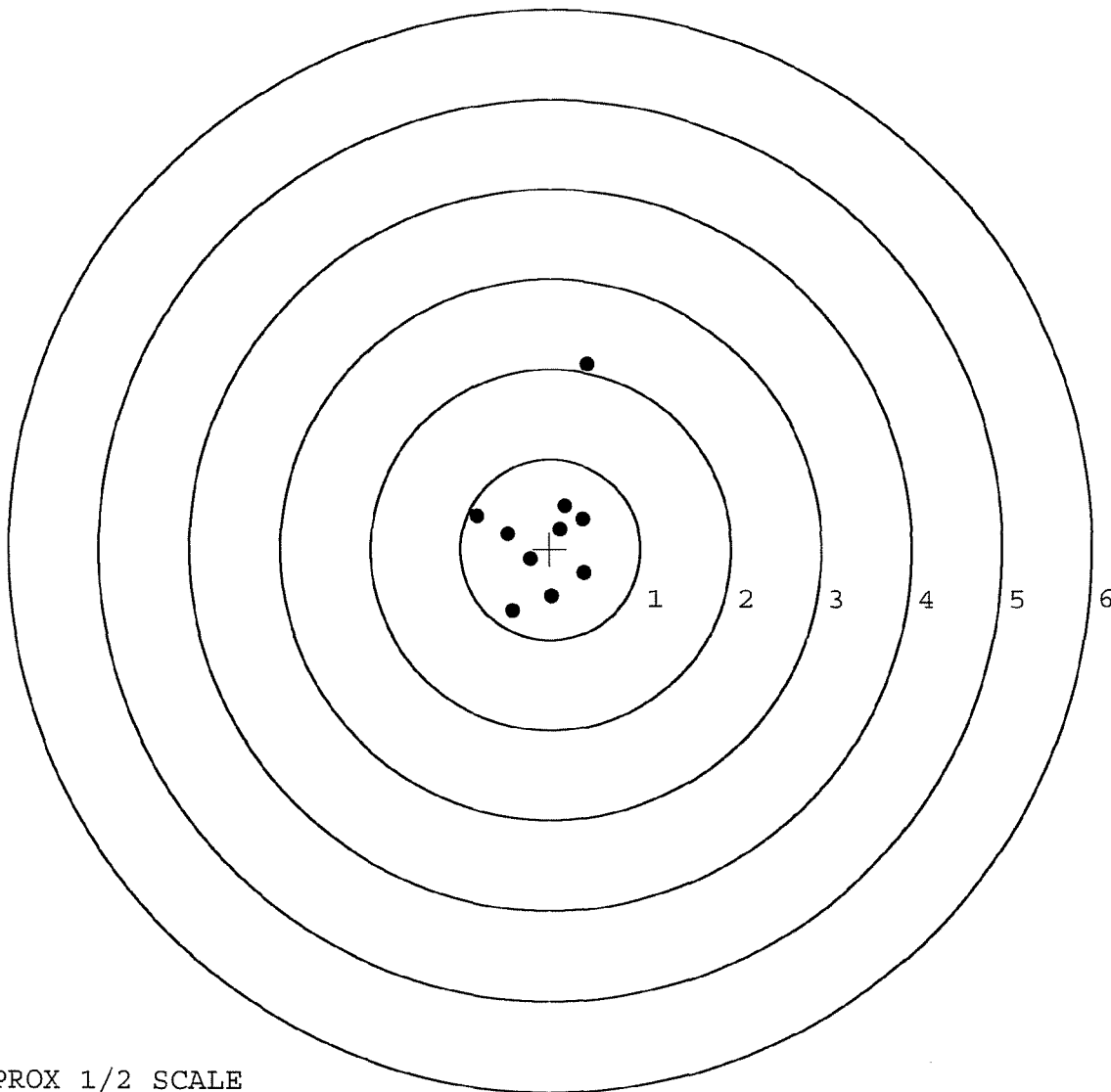
MAX RADIUS: 1.911

MEAN RADIUS: 0.675

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410297. __0

TARGET NUMBER: 5

FILE DATE: 02/14/2005

FILE TIME: 07:45

POINT#	X	Y
1:	0.471	-0.679
2:	-0.317	-0.667
3:	-0.441	-0.482
4:	-0.991	-0.628
5:	-0.254	-0.078
6:	0.127	-0.012
7:	0.349	0.083
8:	0.775	0.576
9:	0.187	0.541
10:	-0.332	0.473

X CENTROID: -0.043

Y CENTROID: -0.087

POA TO CENTROID: 0.097

HORZ SPREAD: 1.766

VERT SPREAD: 1.255

GROUP SPREAD: 2.137

MIN RADIUS: 0.186

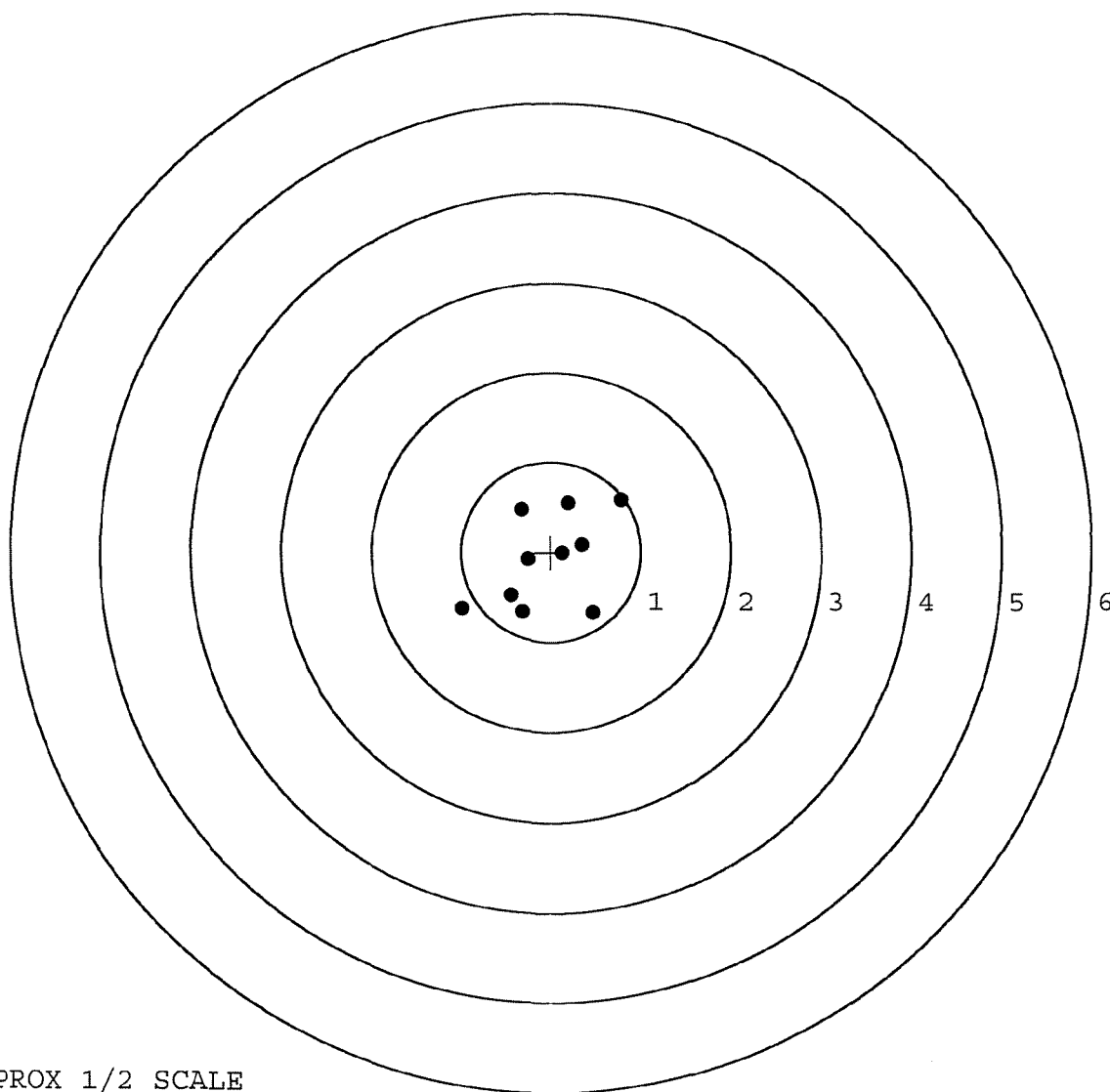
MAX RADIUS: 1.092

MEAN RADIUS: 0.625

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE