

G6410306

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



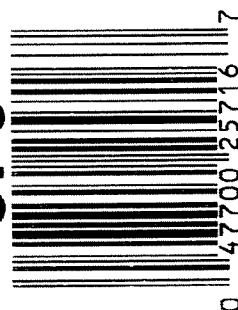
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410306

UPC



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 1:09:25 AM

Original

4

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 # G6410306

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	B
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		9/7	AD
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/23/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/23/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/23/04	DA
	D) OIL FIRING PIN ASSEMBLY		10-11-04	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		10-15-04	TRLW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7.0</u> <u>6.0</u> <u>6.0</u>	10-13-04	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	10-13-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	10-13-04	DA
	J) ASSEMBLE STOCK		10-11-04	RT
	K) ASSEMBLE SWIVEL STUDS		11-29-04	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-29-04	RT
	M) IRON SIGHT ALIGNMENT		11-29-04	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-29-04	RT
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	10-12-04	AC
	MALFUNCTION	CORRECTION		N/A
	MALFUNCTION	CORRECTION		N/A
	MALFUNCTION	CORRECTION		N/A
	MALFUNCTION	CORRECTION		N/A
645	INSPECT FOR LIVE AMMO		10-12-04	AC
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.40</u> <u>2.44</u> <u>2.54</u> <u>2.50</u>	10-13-04	DA
	C) FUNCTION		11-29-04	RT
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 10-9-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.42	2.38		2.15	
PULL #2	2.65	2.50		2.21	
PULL #3	2.72	2.50		2.15	
PULL #4	2.53	2.73		2.19	
PULL #5	2.55	2.57		2.15	
TOTAL	12.87	12.68		10.85	
AVERAGE	2.57	2.53		2.17	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.06		
PULL #2	3.13	3.17		
PULL #3	3.13	3.15		
PULL #4	3.11	3.11		
PULL #5	3.14	2.88		
TOTAL	15.61	15.37		
AVERAGE	3.12	3.07		

	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	4.21	4.01		3.98
PULL #2	4.00	4.09		3.95
PULL #3	4.05	4.03		4.08
PULL #4	4.07	4.01		4.08
PULL #5	4.05	3.99		4.07
TOTAL	20.38	20.13		20.16
AVERAGE	4.07	4.02		4.03

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410306.___0
FILE DATE AND TIME: 10/12/2004 10:01

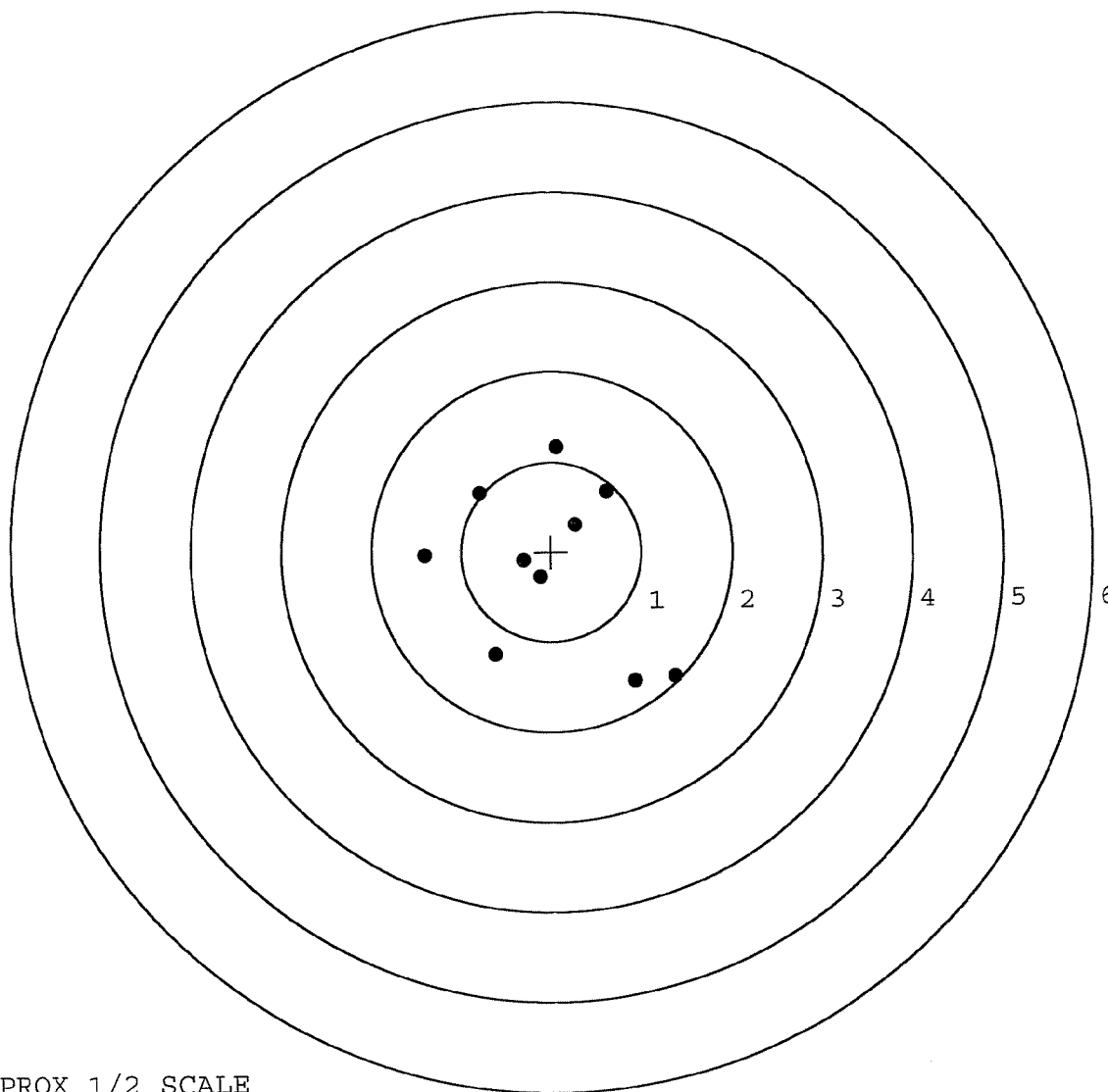
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.140
The Average Y Centroid of the Five Target Set:	-0.027
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.874
The Distance from POA to Centroid Target #1:	0.159
The Distance from Centroid Target #2 to Centroid Target #1:	0.382
The Distance from Centroid Target #3 to Centroid Target #1:	0.317
The Distance from Centroid Target #4 to Centroid Target #1:	0.236
The Distance from Centroid Target #5 to Centroid Target #1:	0.242

SERIAL NUMBER: G6410306. 0
TARGET NUMBER: 1
FILE DATE: 10/12/2004
FILE TIME: 10:01

POINT#	X	Y
1:	0.070	1.161
2:	0.620	0.672
3:	0.268	0.305
4:	-0.790	0.661
5:	-1.411	-0.031
6:	-0.309	-0.095
7:	-0.122	-0.281
8:	-0.633	-1.141
9:	1.365	-1.394
10:	0.926	-1.442

X CENTROID: -0.002
Y CENTROID: -0.159
POA TO CENTROID: 0.159
HORZ SPREAD: 2.776
VERT SPREAD: 2.603
GROUP SPREAD: 3.093
MIN RADIUS: 0.172
MAX RADIUS: 1.842
MEAN RADIUS: 1.053
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 8



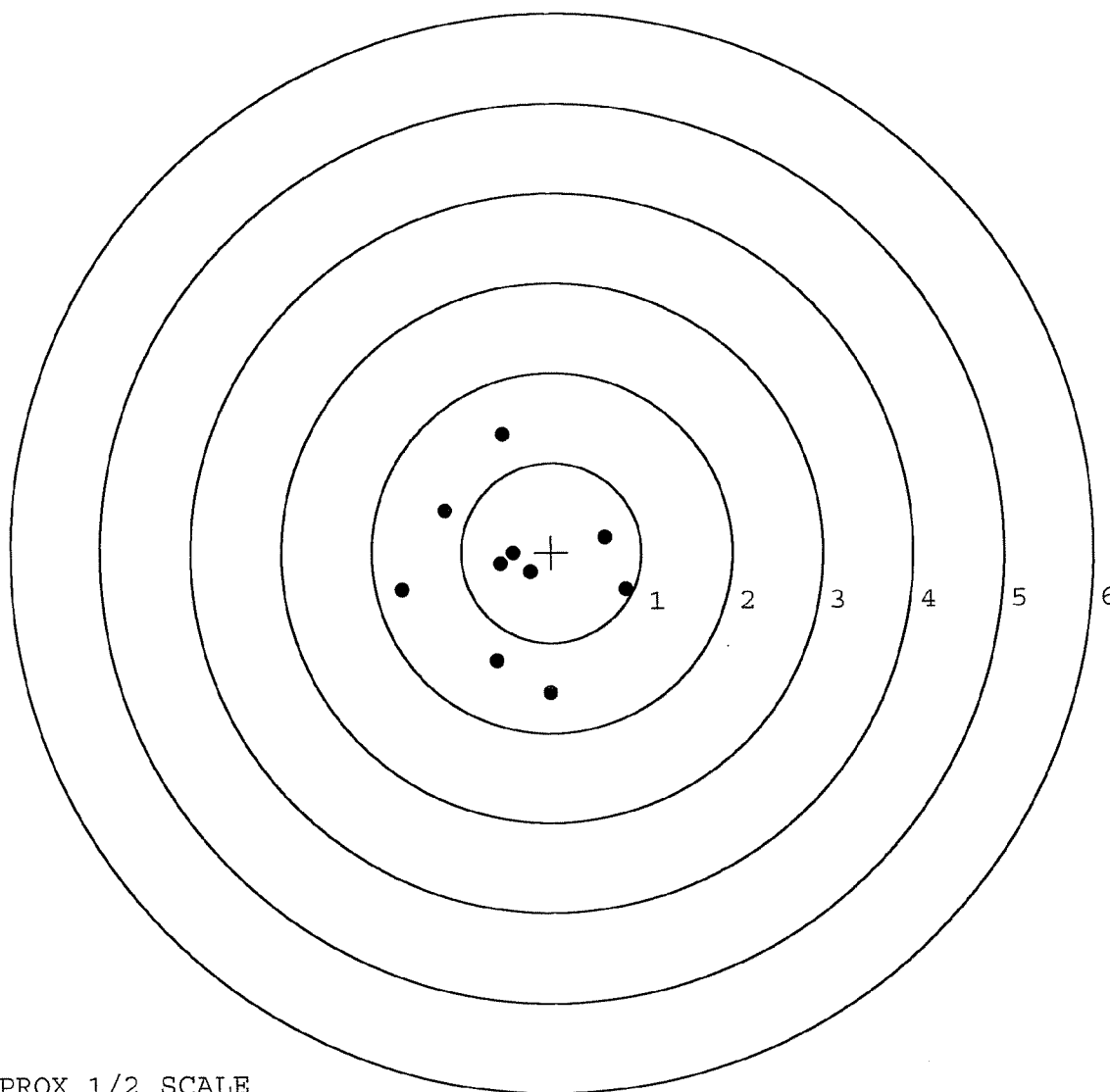
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410306. __0
TARGET NUMBER: 2
FILE DATE: 10/12/2004
FILE TIME: 10:01

X CENTROID: -0.381
Y CENTROID: -0.200
POA TO CENTROID: 0.430
HORZ SPREAD: 2.487
VERT SPREAD: 2.872
GROUP SPREAD: 2.916
MIN RADIUS: 0.145
MAX RADIUS: 1.523
MEAN RADIUS: 0.910

POINT#	X	Y
1:	-0.529	1.316
2:	-1.174	0.476
3:	-1.666	-0.408
4:	-0.566	-0.133
5:	-0.423	-0.010
6:	-0.237	-0.221
7:	0.597	0.162
8:	0.821	-0.422
9:	-0.608	-1.201
10:	-0.024	-1.556

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 9

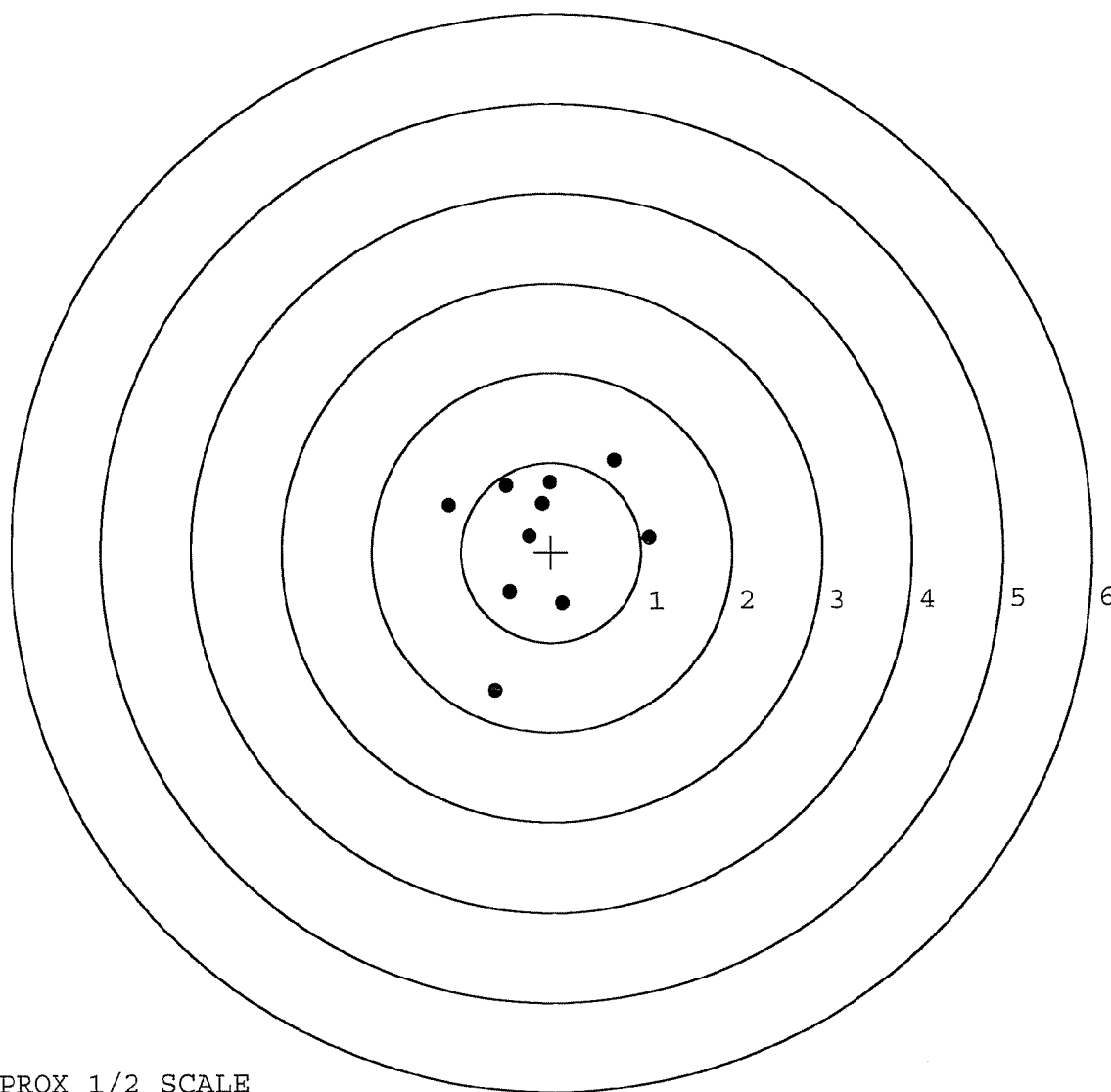


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410306. __0
TARGET NUMBER: 3
FILE DATE: 10/12/2004
FILE TIME: 10:01

X CENTROID: -0.115
Y CENTROID: 0.138
POA TO CENTROID: 0.180
HORZ SPREAD: 2.227
VERT SPREAD: 2.557
GROUP SPREAD: 2.889
MIN RADIUS: 0.133
MAX RADIUS: 1.755
MEAN RADIUS: 0.859
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.711	1.018
2:	-0.011	0.775
3:	-0.499	0.743
4:	-1.134	0.533
5:	-0.095	0.537
6:	-0.243	0.175
7:	1.093	0.151
8:	0.125	-0.571
9:	-0.466	-0.443
10:	-0.634	-1.539



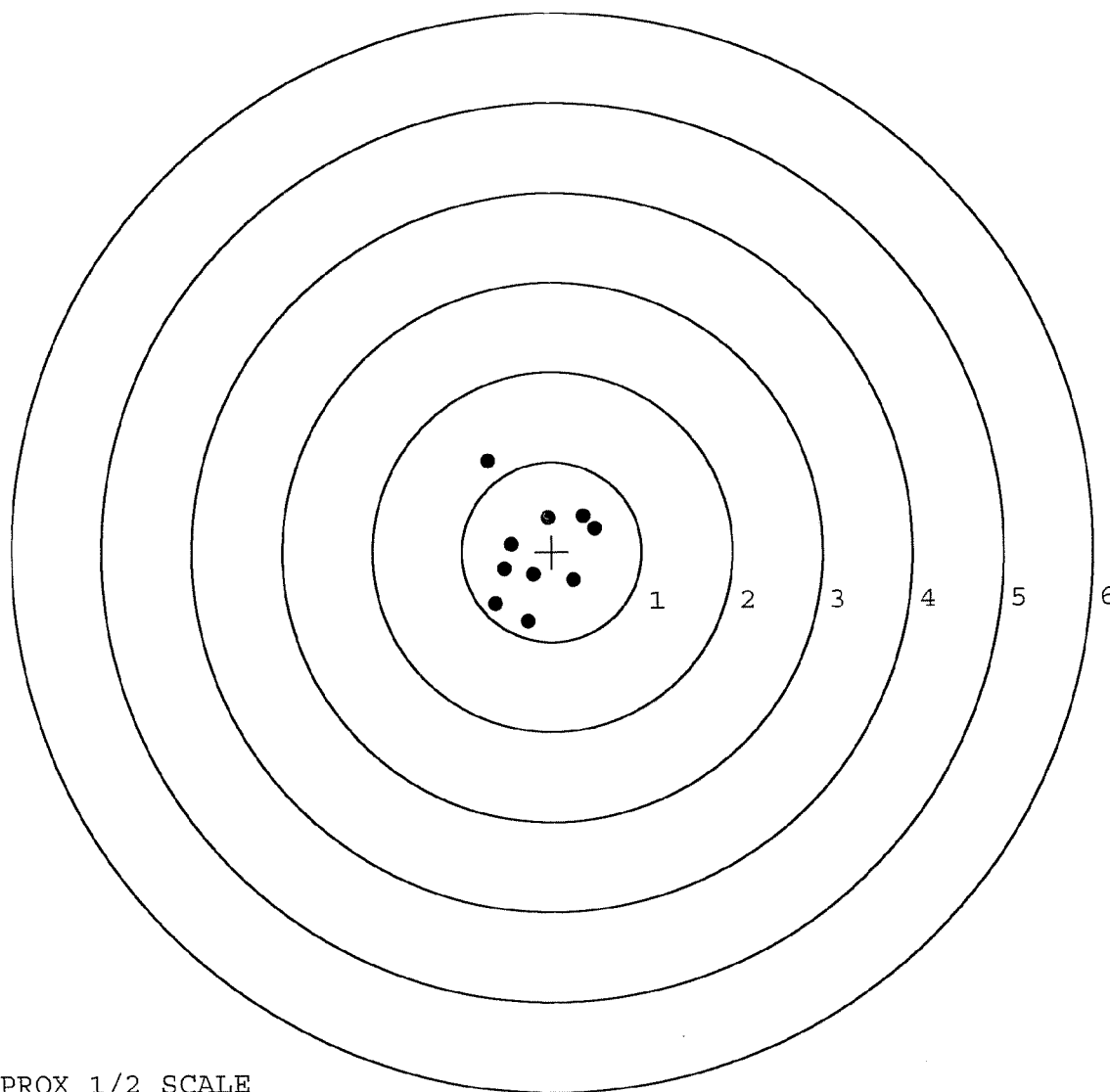
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410306. __0
TARGET NUMBER: 4
FILE DATE: 10/12/2004
FILE TIME: 10:01

X CENTROID: -0.175
Y CENTROID: 0.002
POA TO CENTROID: 0.175
HORZ SPREAD: 1.186
VERT SPREAD: 1.791
GROUP SPREAD: 1.842
MIN RADIUS: 0.258
MAX RADIUS: 1.143
MEAN RADIUS: 0.589

POINT#	X	Y
1:	-0.701	1.016
2:	0.485	0.254
3:	0.354	0.394
4:	-0.043	0.377
5:	-0.451	0.084
6:	-0.531	-0.187
7:	-0.207	-0.255
8:	0.240	-0.314
9:	-0.270	-0.775
10:	-0.627	-0.579

IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410306. __0

TARGET NUMBER: 5

FILE DATE: 10/12/2004

FILE TIME: 10:01

POINT#	X	Y
1:	-0.898	1.059
2:	-0.342	1.037
3:	-0.004	0.976
4:	0.605	1.138
5:	-0.693	-0.049
6:	0.563	-0.073
7:	0.008	-0.445
8:	0.238	-0.434
9:	0.582	-0.927
10:	-0.306	-1.459

X CENTROID: -0.025

Y CENTROID: 0.082

POA TO CENTROID: 0.086

HORZ SPREAD: 1.503

VERT SPREAD: 2.597

GROUP SPREAD: 2.752

MIN RADIUS: 0.528

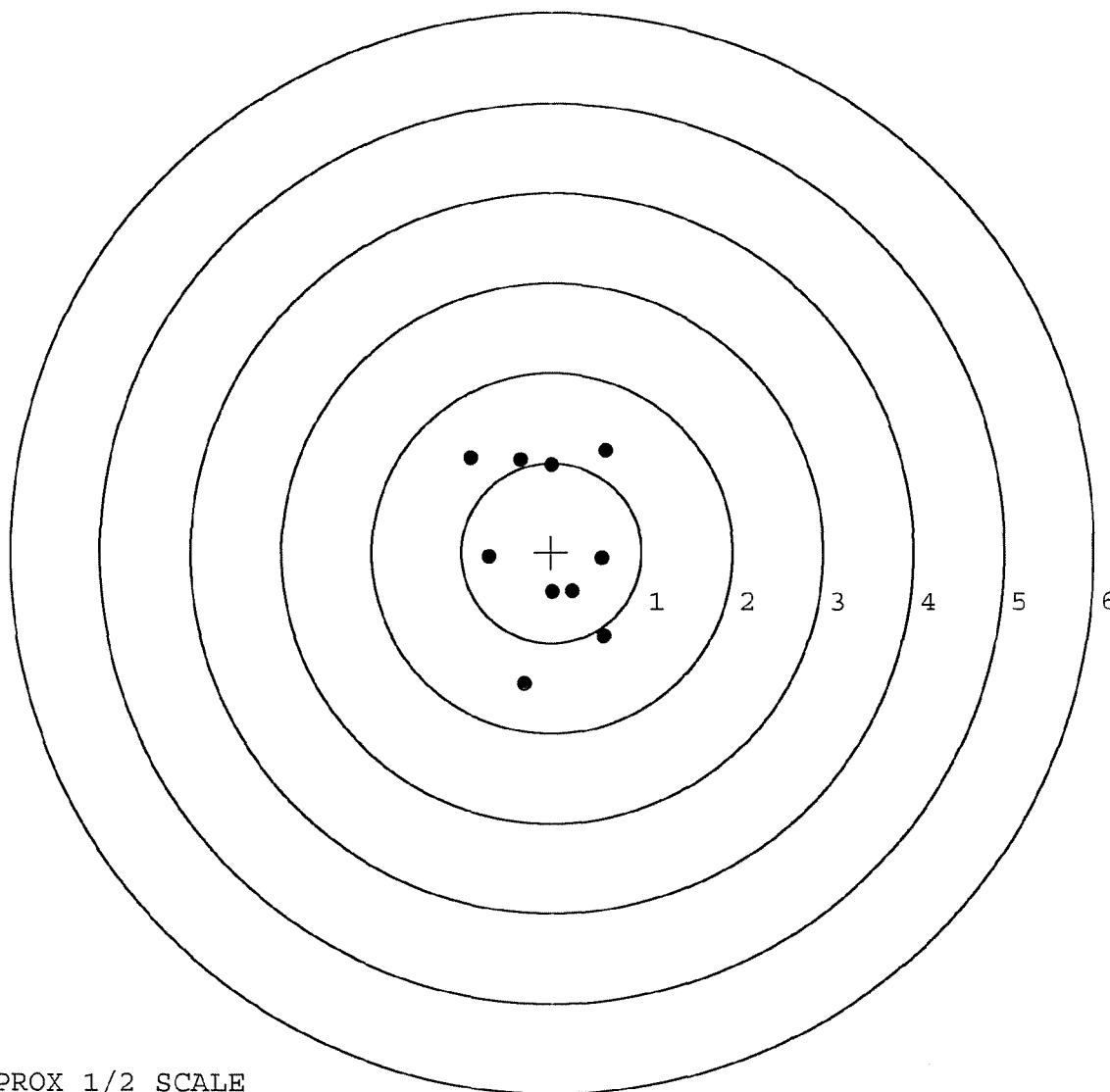
MAX RADIUS: 1.567

MEAN RADIUS: 0.958

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE