

G-6410311

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.



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

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



ORDER NO.

25716

BARREL LENGTH

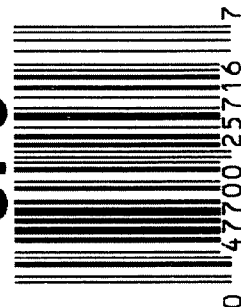
24"

CAPACITY

6

G6410311

UPC



DD FORM

10/26/2004 7:51:17 AM

CHB

L

Original

25716

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



.MA25716

Shop Order: SWS10-15-5



.ABSWS10-15-5

Start Date: 9/20/2004

Finish Date: 10/15/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003512703

0560

Reassemble Action.

89SWS1



0003512704

0690

Pack Rifle

89SWS1



0003512697

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 641 0311

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	AB
617	DRILL AND TAP SIGHT HOLES		8-24-04	RTL
620	APPLY COATINGS (BARREL ACTION)		9/7	MP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-04	RTL
	D) OIL FIRING PIN ASSEMBLY		9-27-04	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>8.0</u> <u>7.5</u> <u>8.0</u>	10/8/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.5</u>	10/8/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.022</u>	10/8/04	DA
	J) ASSEMBLE STOCK		9-27-04	RP
	K) ASSEMBLE SWIVEL STUDS		10-12-04	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-27-04	RTZ
	M) IRON SIGHT ALIGNMENT		9-27-04	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-27-04	RTZ
640	GALLERY TEST AND TARGET	<i>Pass</i> <i>FAIL</i> PASS FAIL	9-28-04	TRC
	MALFUNCTION <i>BAC</i>	CORRECTION <i>Pass</i>	10-1-04	Ac
	MALFUNCTION <i>Bolt release sticks</i>	CORRECTION <i>Pass</i>	10-1-04	Ac
	MALFUNCTION	CORRECTION	NA	NA
	MALFUNCTION	CORRECTION	NA	NA
645	INSPECT FOR LIVE AMMO		9-24-04	TRC
655	FINAL INSPECTION A) HEADSPACE		10-12-04	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.73</u> <u>2.60</u> <u>2.60</u> <u>2.64</u>	10/8/04	DA
	C) FUNCTION		10-12-04	RTZ
660	PACK		10/8/04	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 7-14-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.17	2.50		2.28	
PULL #2	2.15	2.69		2.24	
PULL #3	2.23	2.63		2.40	
PULL #4	2.19	2.59		2.25	
PULL #5	2.15	2.66		2.27	
TOTAL	10.89	13.07		11.44	
AVERAGE	2.17	2.61		2.28	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.14		
PULL #2	3.25	3.36		
PULL #3	3.19	3.21		
PULL #4	3.32	3.43		
PULL #5	3.35	3.41		
TOTAL	16.43	16.55		
AVERAGE	3.28	3.31		

	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	4.26	4.13		4.35
PULL #2	4.13	4.11		4.31
PULL #3	4.27	4.13		4.31
PULL #4	4.28	4.01		4.29
PULL #5	4.40	4.12		4.32
TOTAL	21.34	20.50		21.58
AVERAGE	4.26	4.10		4.31

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410311.___0
FILE DATE AND TIME: 09/28/2004 08:08

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.069
The Average Y Centroid of the Five Target Set:	-0.075
The Average Point of Impact of the Five Target Set:	0.102
The Average Mean Radius of the Five Target Set:	0.859
The Distance from POA to Centroid Target #1:	0.103
The Distance from Centroid Target #2 to Centroid Target #1:	0.278
The Distance from Centroid Target #3 to Centroid Target #1:	0.597
The Distance from Centroid Target #4 to Centroid Target #1:	0.157
The Distance from Centroid Target #5 to Centroid Target #1:	0.219

SERIAL NUMBER: G6410311.___0

TARGET NUMBER: 1

FILE DATE: 09/28/2004

FILE TIME: 08:08

X CENTROID: 0.021

Y CENTROID: 0.101

POA TO CENTROID: 0.103

HORZ SPREAD: 0.982

VERT SPREAD: 3.971

GROUP SPREAD: 3.972

MIN RADIUS: 0.177

MAX RADIUS: 2.117

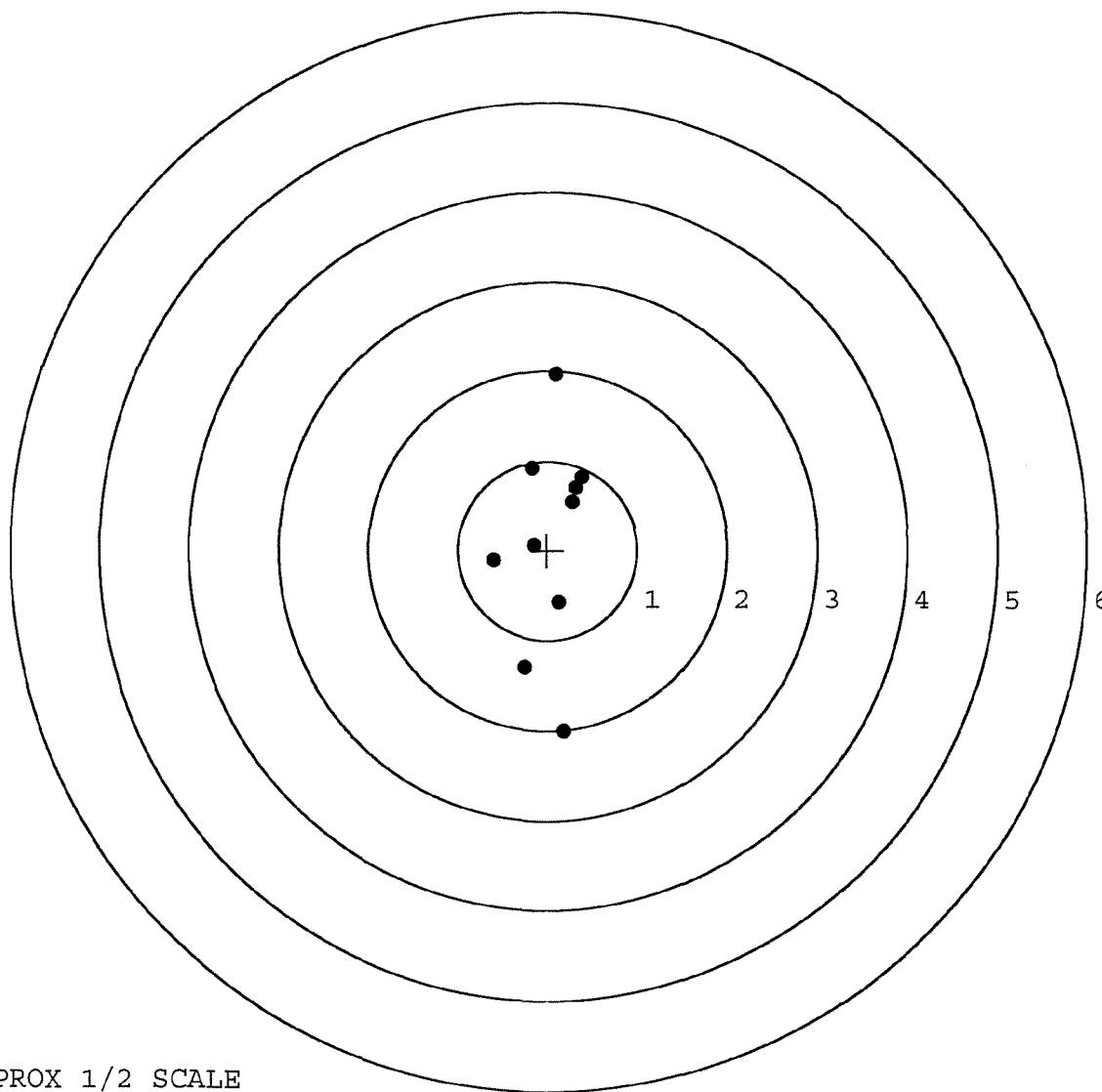
MEAN RADIUS: 0.978

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.192	-2.009
2:	-0.259	-1.300
3:	0.127	-0.583
4:	-0.601	-0.118
5:	-0.151	0.059
6:	-0.176	0.924
7:	0.098	1.962
8:	0.381	0.822
9:	0.319	0.706
10:	0.279	0.543

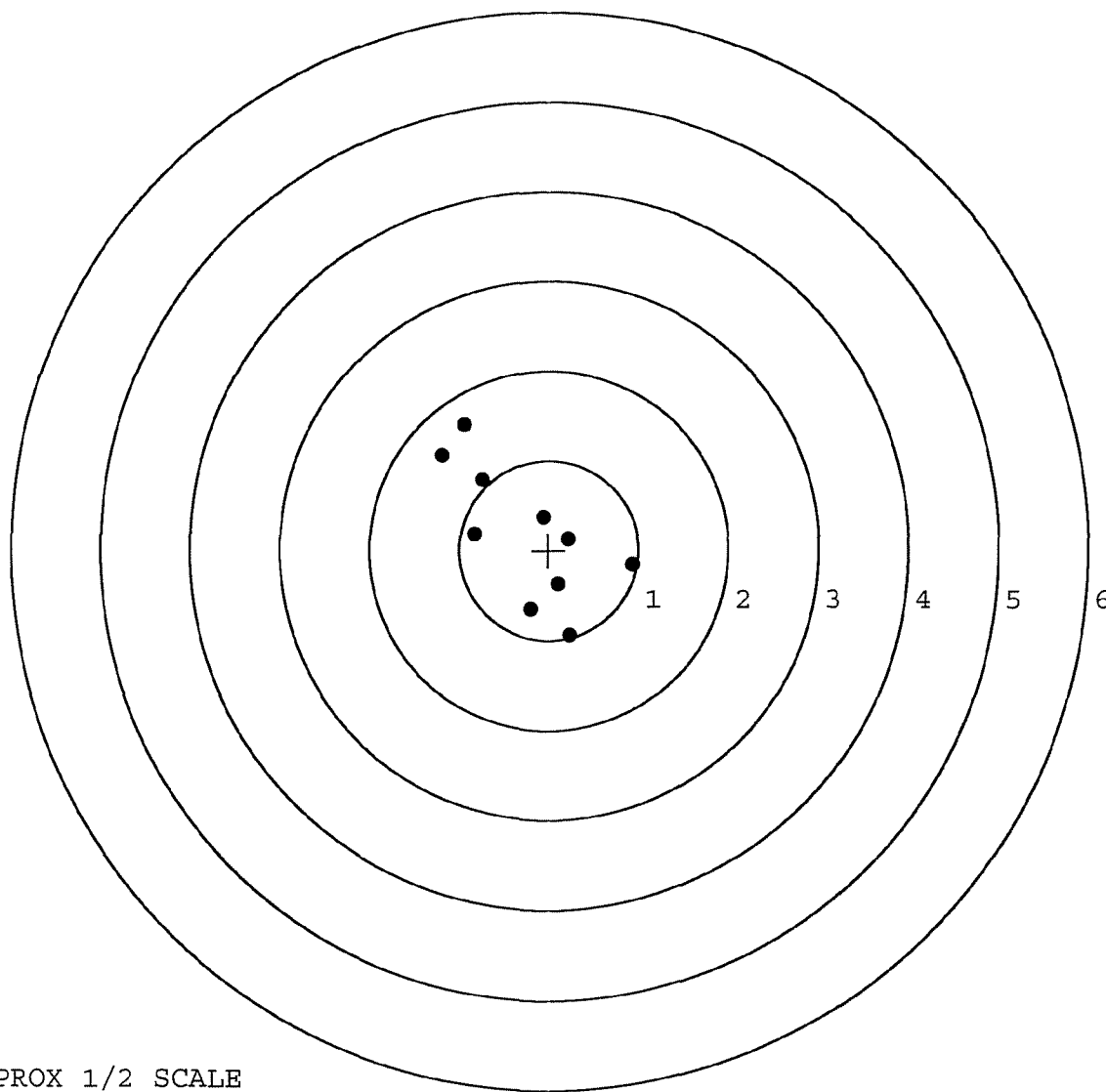


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410311.____0
TARGET NUMBER: 2
FILE DATE: 09/28/2004
FILE TIME: 08:08

X CENTROID: -0.247
Y CENTROID: 0.173
POA TO CENTROID: 0.302
HORZ SPREAD: 2.129
VERT SPREAD: 2.349
GROUP SPREAD: 2.627
MIN RADIUS: 0.265
MAX RADIUS: 1.408
MEAN RADIUS: 0.877
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.936	-0.169
2:	0.235	-0.951
3:	-0.835	0.176
4:	-0.742	0.782
5:	-1.193	1.058
6:	-0.942	1.398
7:	-0.066	0.367
8:	0.223	0.120
9:	0.111	-0.385
10:	-0.202	-0.662

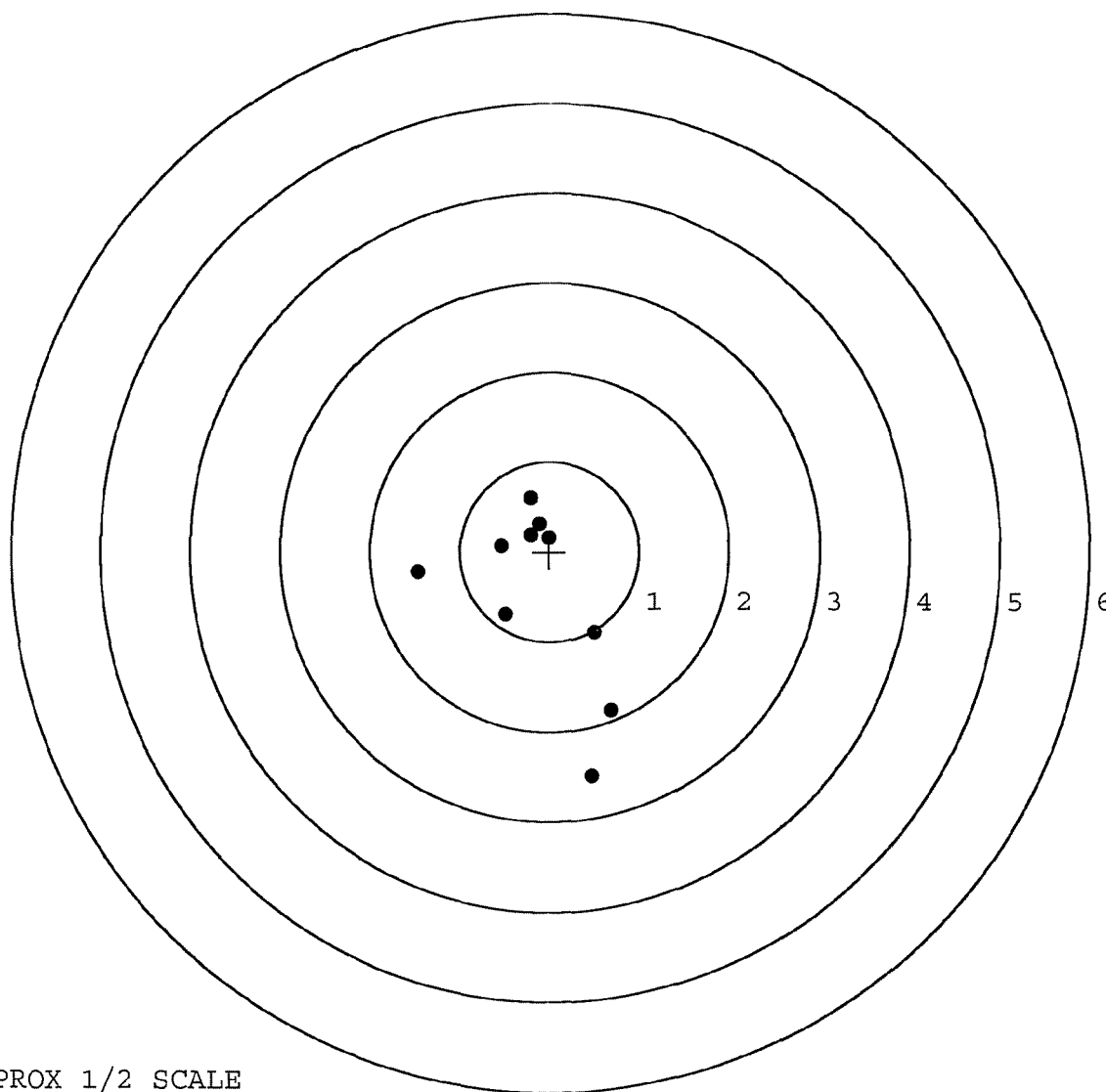


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410311. __0
TARGET NUMBER: 3
FILE DATE: 09/28/2004
FILE TIME: 08:08

X CENTROID: -0.135
Y CENTROID: -0.475
POA TO CENTROID: 0.494
HORZ SPREAD: 2.159
VERT SPREAD: 3.093
GROUP SPREAD: 3.169
MIN RADIUS: 0.421
MAX RADIUS: 2.112
MEAN RADIUS: 1.004
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.482	-2.495
2:	0.694	-1.763
3:	0.502	-0.896
4:	-0.492	-0.699
5:	-1.465	-0.227
6:	-0.537	0.072
7:	-0.208	0.598
8:	-0.118	0.310
9:	0.005	0.159
10:	-0.212	0.189



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410311. __0

TARGET NUMBER: 4

FILE DATE: 09/28/2004

FILE TIME: 08:08

POINT#	X	Y
1:	0.329	-0.990
2:	-0.322	-0.927
3:	0.472	-0.508
4:	-0.860	1.132
5:	0.321	0.552
6:	-0.369	0.288
7:	0.052	0.260
8:	-0.135	-0.049
9:	0.267	0.004
10:	0.202	-0.304

X CENTROID: -0.004

Y CENTROID: -0.054

POA TO CENTROID: 0.054

HORZ SPREAD: 1.332

VERT SPREAD: 2.122

GROUP SPREAD: 2.432

MIN RADIUS: 0.131

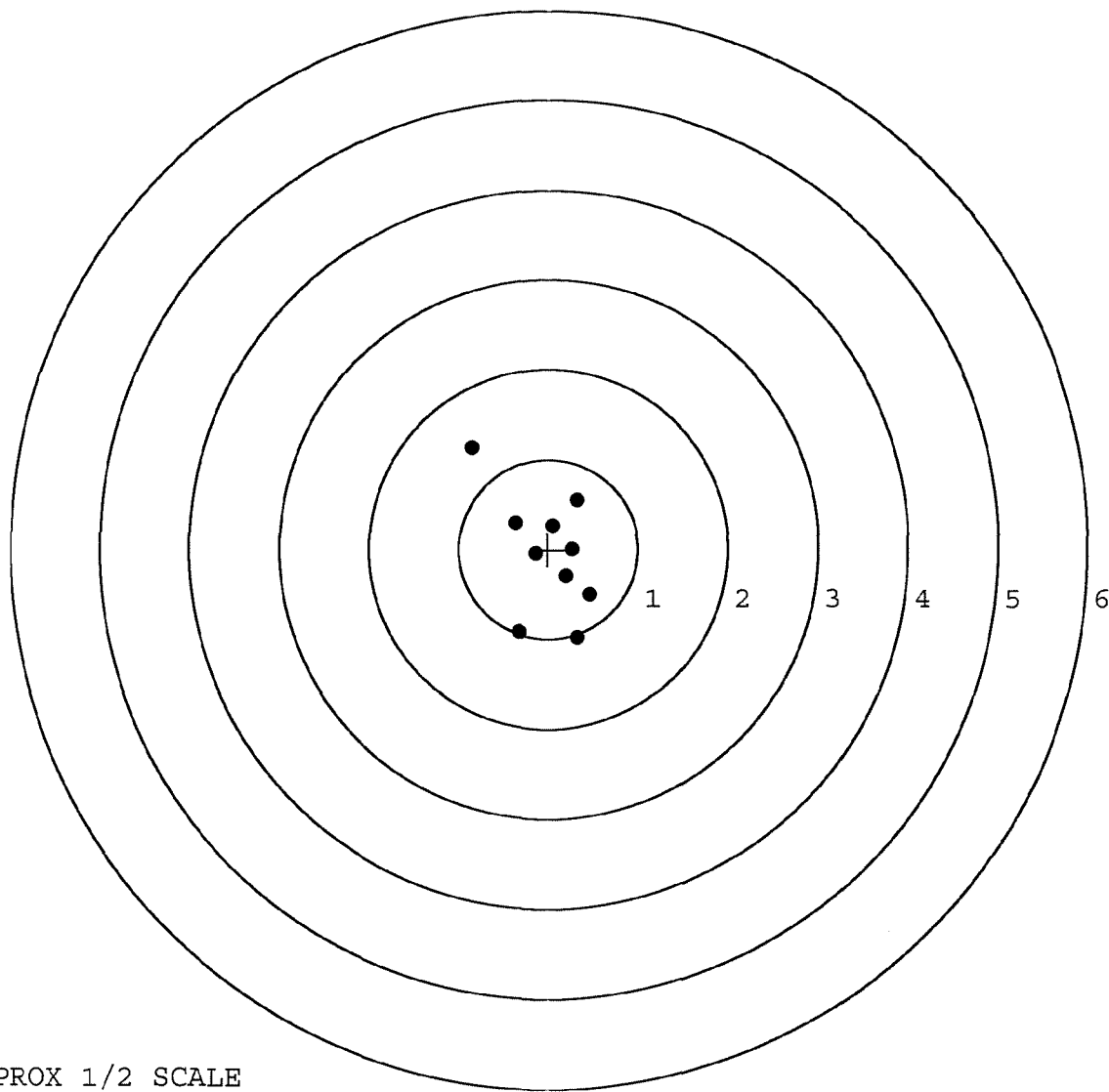
MAX RADIUS: 1.463

MEAN RADIUS: 0.628

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

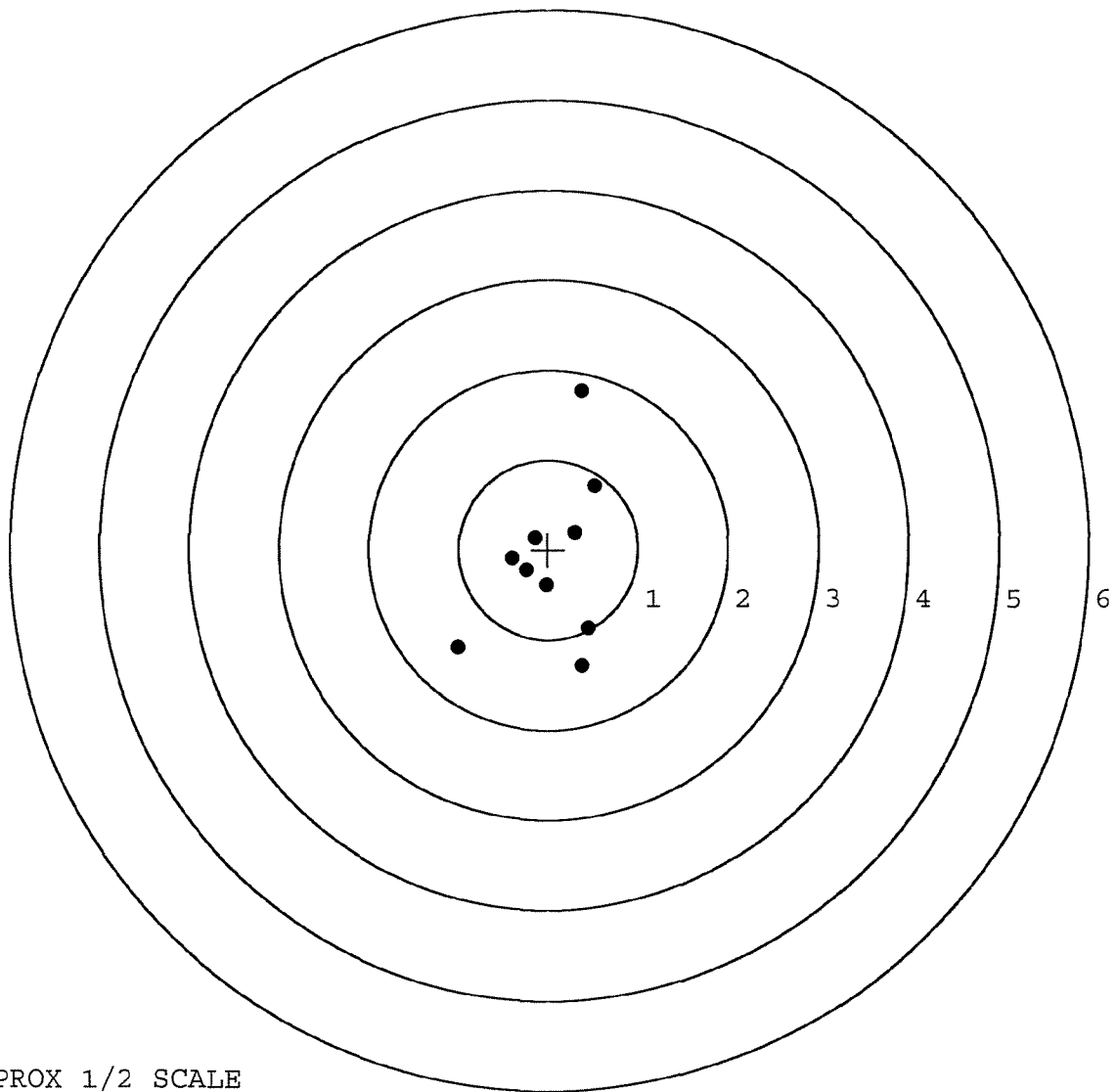


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410311. __0
TARGET NUMBER: 5
FILE DATE: 09/28/2004
FILE TIME: 08:08

X CENTROID: 0.020
Y CENTROID: -0.118
POA TO CENTROID: 0.120
HORZ SPREAD: 1.523
VERT SPREAD: 3.059
GROUP SPREAD: 3.182
MIN RADIUS: 0.282
MAX RADIUS: 1.923
MEAN RADIUS: 0.810
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.374	-1.288
2:	0.451	-0.877
3:	-1.009	-1.093
4:	0.378	1.771
5:	0.514	0.711
6:	0.297	0.192
7:	-0.141	0.130
8:	-0.401	-0.102
9:	-0.245	-0.228
10:	-0.016	-0.398



TARGET APPROX 1/2 SCALE