

G6410315

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



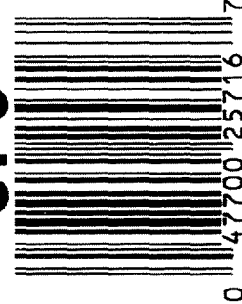
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410315

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.



10/26/2004 7:51:17 AM

Original

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

01PC001

Flat Black Powder Coat, Barrel and



0003512703

0560

89SWS1

Reassemble Action.



0003512704

0690

89SWS1

Pack Rifle



0003512697

0700

89SWS1

Stencil SWS Container



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410315

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	TRL
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		10-5-04	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>7.0</u> <u>7.0</u> <u>7.0</u>	10-9-04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	10-9-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.020</u> <u>.020</u>	10-9-04	DA
	J) ASSEMBLE STOCK		10-5-04	RTL
	K) ASSEMBLE SWIVEL STUDS		10-12-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-5-04	RTL
	M) IRON SIGHT ALIGNMENT		10-5-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-5-04	RTL
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	10-8-04	TKW
	MALFUNCTION <i>MCW</i>	CORRECTION <i>PASS</i>	10-11-04	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		10-8-04	TKW
655	FINAL INSPECTION A) HEADSPACE		10-12-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u> <u>2.84</u> <u>2.89</u> <u>2.75</u> <u>2.88</u>	10-12-04	RTL
	C) FUNCTION		10-12-04	RTL
660	PACK		10/22/04	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)

DATE

9-24-04

TESTER

TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.42	2.10		2.22	
PULL #2	2.72	2.24		2.14	
PULL #3	2.79	2.25		2.13	
PULL #4	2.83	2.09		2.11	
PULL #5	2.63	2.08		2.15	
TOTAL	13.39	10.76		10.75	
AVERAGE	2.67	2.15		2.15	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.28		
PULL #2	3.23	3.26		
PULL #3	3.21	3.19		
PULL #4	3.18	3.19		
PULL #5	3.06	3.20		
TOTAL	15.93	16.12		
AVERAGE	3.18	3.22		

	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	4.44	4.09		4.27
PULL #2	4.36	4.13		4.12
PULL #3	4.11	4.09		4.18
PULL #4	4.31	4.07		4.15
PULL #5	4.29	4.07		4.13
TOTAL	21.51	20.45		20.85
AVERAGE	4.30	4.09		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410315.___0
FILE DATE AND TIME: 10/08/2004 08:15

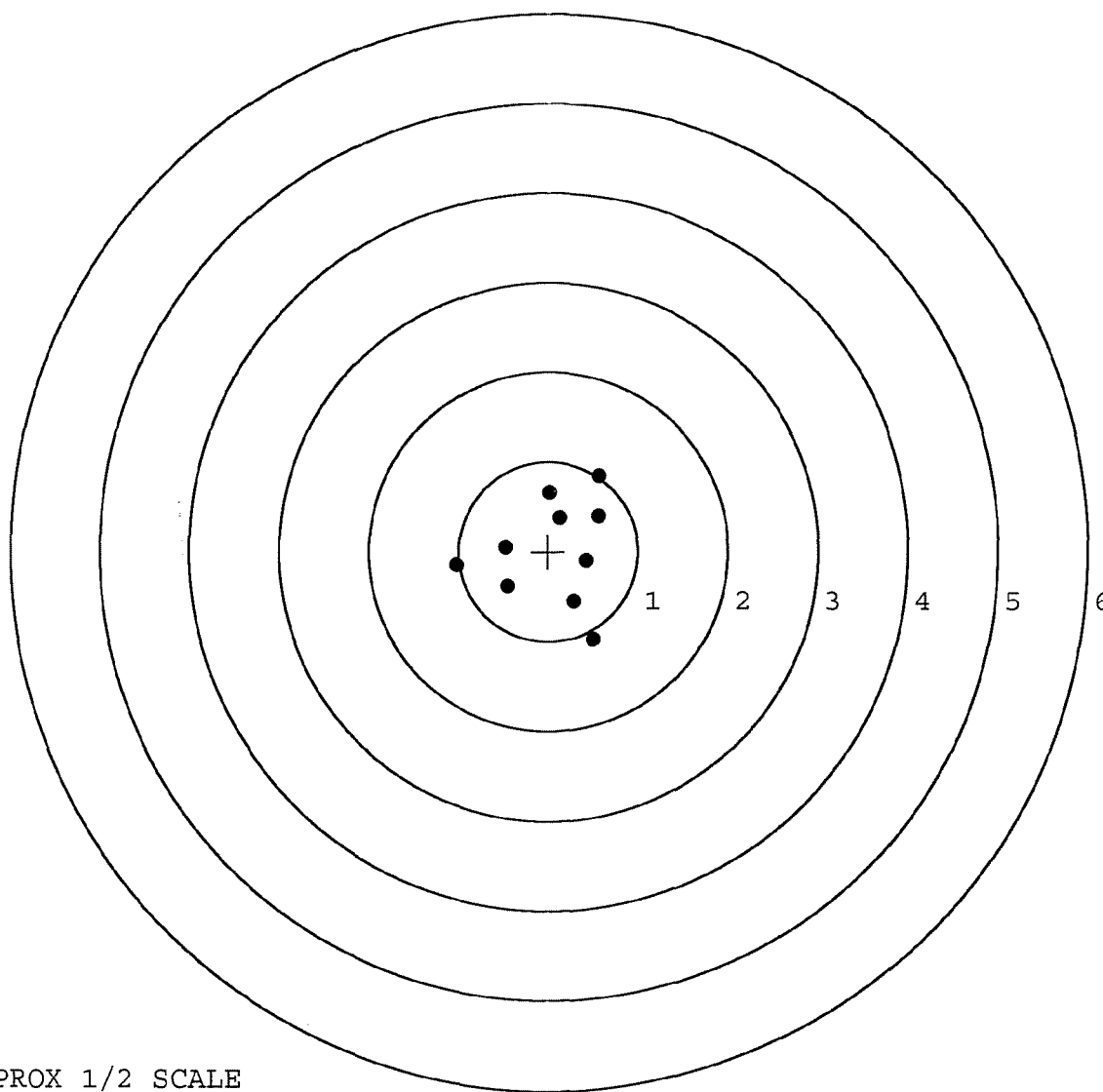
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.010
The Average Y Centroid of the Five Target Set:	0.015
The Average Point of Impact of the Five Target Set:	0.018
The Average Mean Radius of the Five Target Set:	0.823
The Distance from POA to Centroid Target #1:	0.059
The Distance from Centroid Target #2 to Centroid Target #1:	0.174
The Distance from Centroid Target #3 to Centroid Target #1:	0.207
The Distance from Centroid Target #4 to Centroid Target #1:	0.101
The Distance from Centroid Target #5 to Centroid Target #1:	0.403

SERIAL NUMBER: G6410315. __0
TARGET NUMBER: 1
FILE DATE: 10/08/2004
FILE TIME: 08:15

X CENTROID: 0.057
Y CENTROID: 0.015
POA TO CENTROID: 0.059
HORZ SPREAD: 1.593
VERT SPREAD: 1.824
GROUP SPREAD: 1.825
MIN RADIUS: 0.371
MAX RADIUS: 1.091
MEAN RADIUS: 0.699
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.505	-0.980
2:	0.290	-0.554
3:	0.429	-0.100
4:	0.565	0.400
5:	0.573	0.844
6:	0.018	0.660
7:	0.129	0.379
8:	-0.468	0.047
9:	-0.451	-0.392
10:	-1.020	-0.157

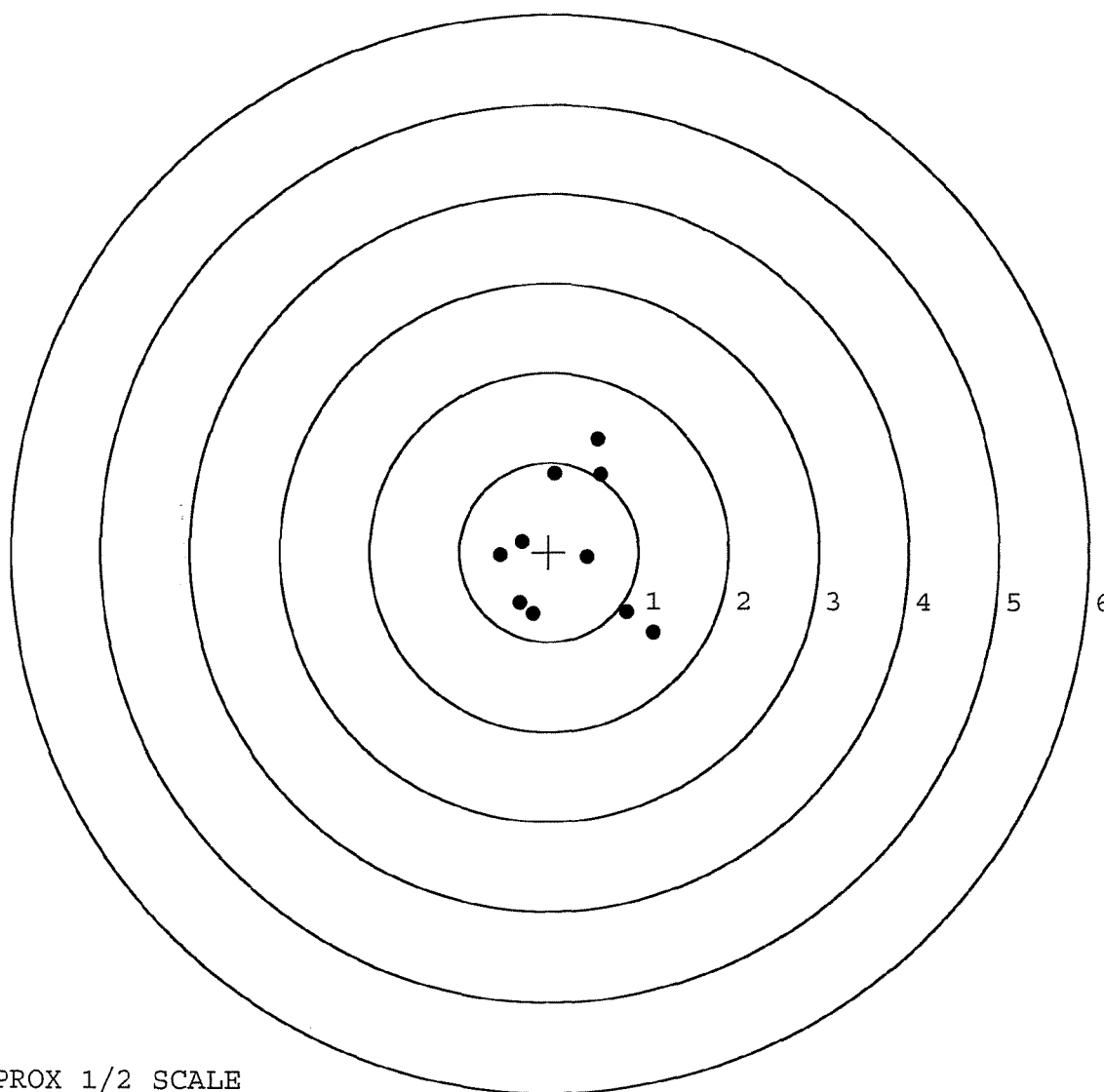


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410315. 0
TARGET NUMBER: 2
FILE DATE: 10/08/2004
FILE TIME: 08:15

X CENTROID: 0.231
Y CENTROID: 0.019
POA TO CENTROID: 0.231
HORZ SPREAD: 1.704
VERT SPREAD: 2.168
GROUP SPREAD: 2.254
MIN RADIUS: 0.216
MAX RADIUS: 1.309
MEAN RADIUS: 0.849
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.160	-0.903
2:	0.870	-0.679
3:	0.433	-0.056
4:	-0.178	-0.694
5:	-0.324	-0.568
6:	-0.544	-0.038
7:	-0.298	0.115
8:	0.065	0.879
9:	0.579	0.868
10:	0.544	1.265



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410315. 0

TARGET NUMBER: 3

FILE DATE: 10/08/2004

FILE TIME: 08:15

POINT#	X	Y
1:	0.350	-1.205
2:	-0.148	-0.490
3:	-0.376	-0.710
4:	-0.910	-0.504
5:	0.374	0.076
6:	0.520	0.353
7:	0.922	0.686
8:	-0.325	0.759
9:	-0.195	0.980
10:	-0.442	2.106

X CENTROID: -0.023

Y CENTROID: 0.205

POA TO CENTROID: 0.206

HORZ SPREAD: 1.832

VERT SPREAD: 3.311

GROUP SPREAD: 3.404

MIN RADIUS: 0.417

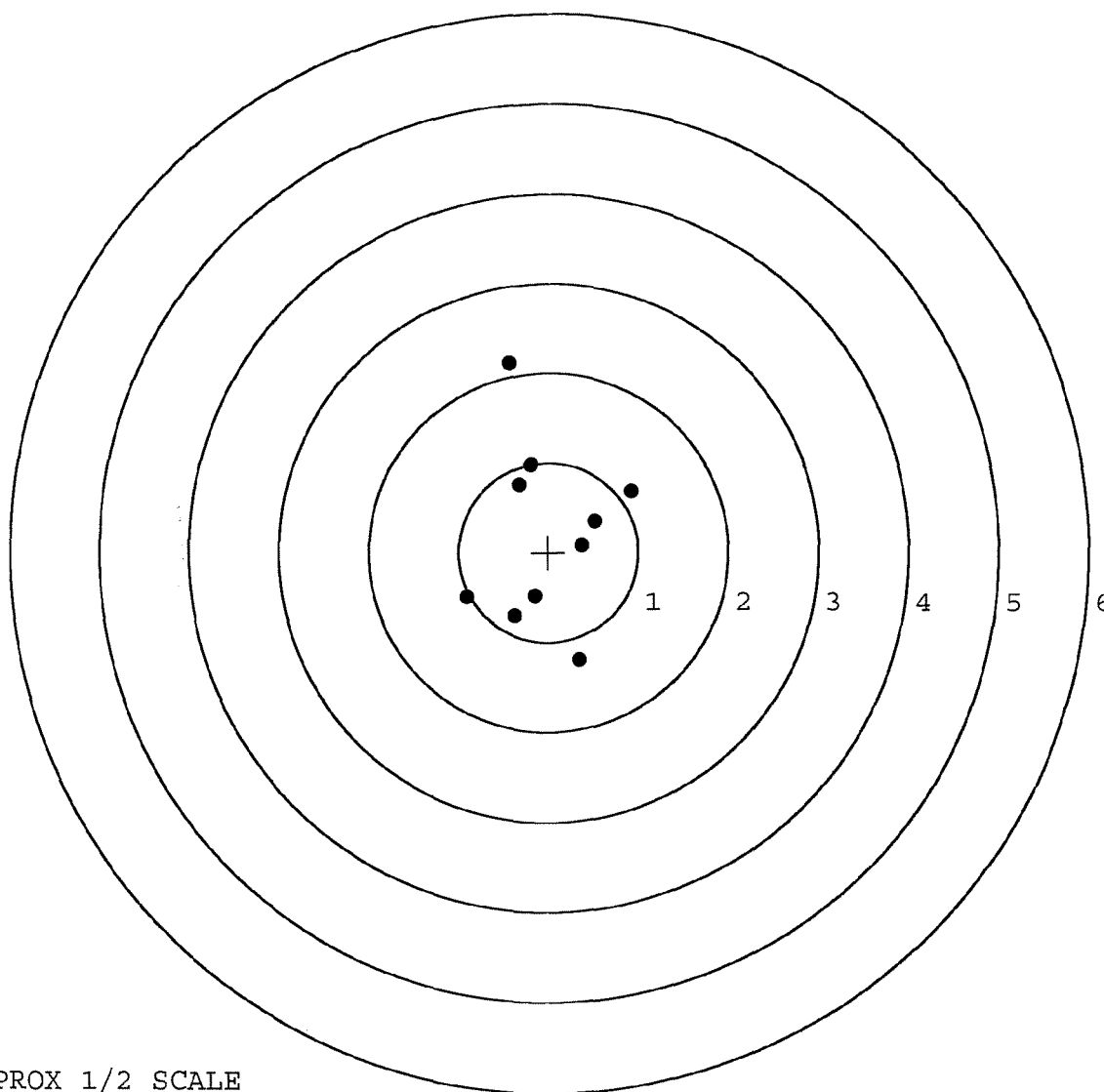
MAX RADIUS: 1.947

MEAN RADIUS: 0.969

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410315. 0

TARGET NUMBER: 4

FILE DATE: 10/08/2004

FILE TIME: 08:15

POINT#	X	Y
1:	1.201	0.743
2:	0.236	0.323
3:	-0.206	0.386
4:	-0.213	0.724
5:	-0.283	1.037
6:	0.267	-0.088
7:	-0.080	-0.370
8:	-0.274	-0.344
9:	-0.250	-0.943
10:	-0.775	-0.968

X CENTROID: -0.038

Y CENTROID: 0.050

POA TO CENTROID: 0.063

HORZ SPREAD: 1.976

VERT SPREAD: 2.005

GROUP SPREAD: 2.614

MIN RADIUS: 0.334

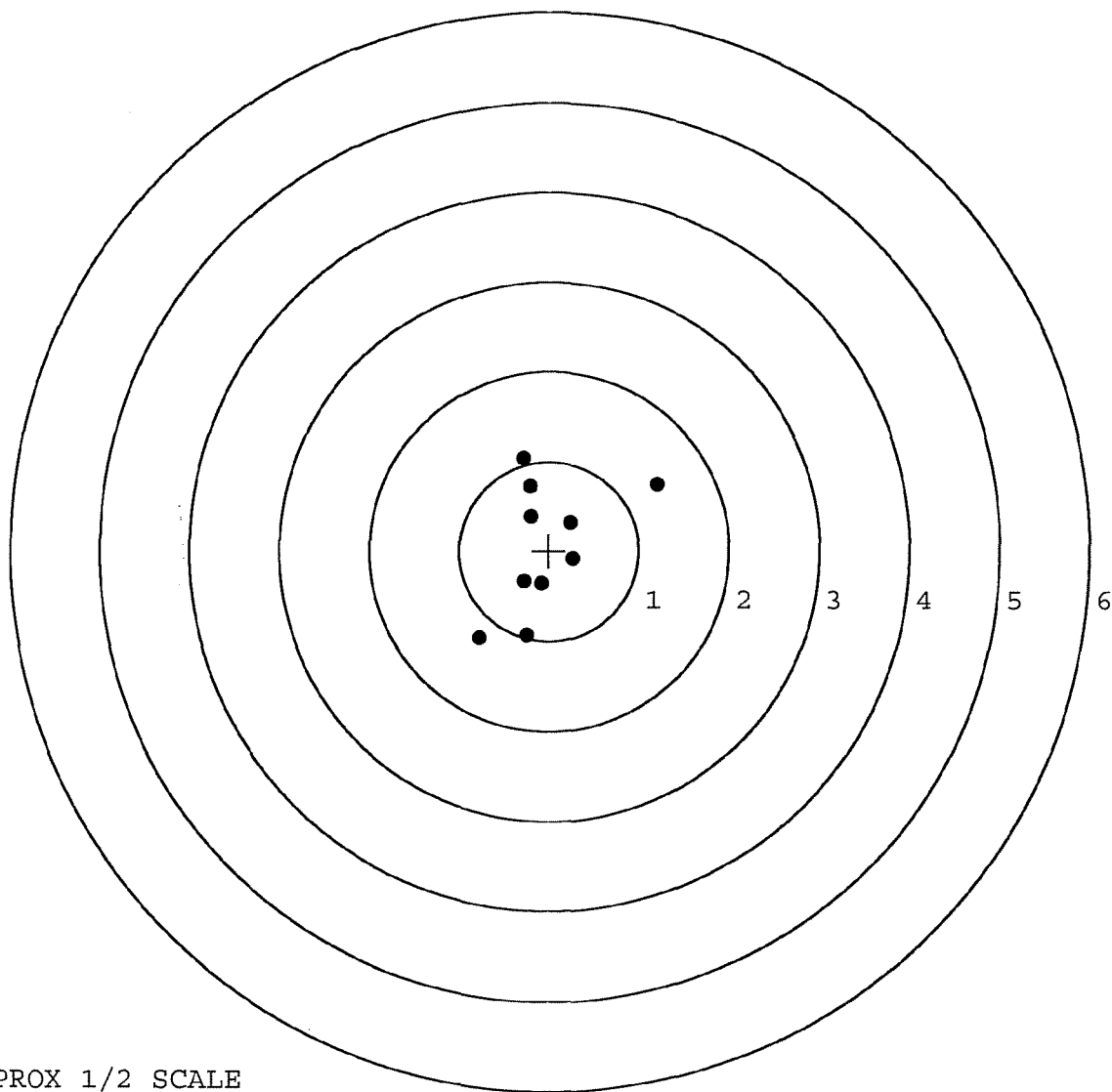
MAX RADIUS: 1.419

MEAN RADIUS: 0.738

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

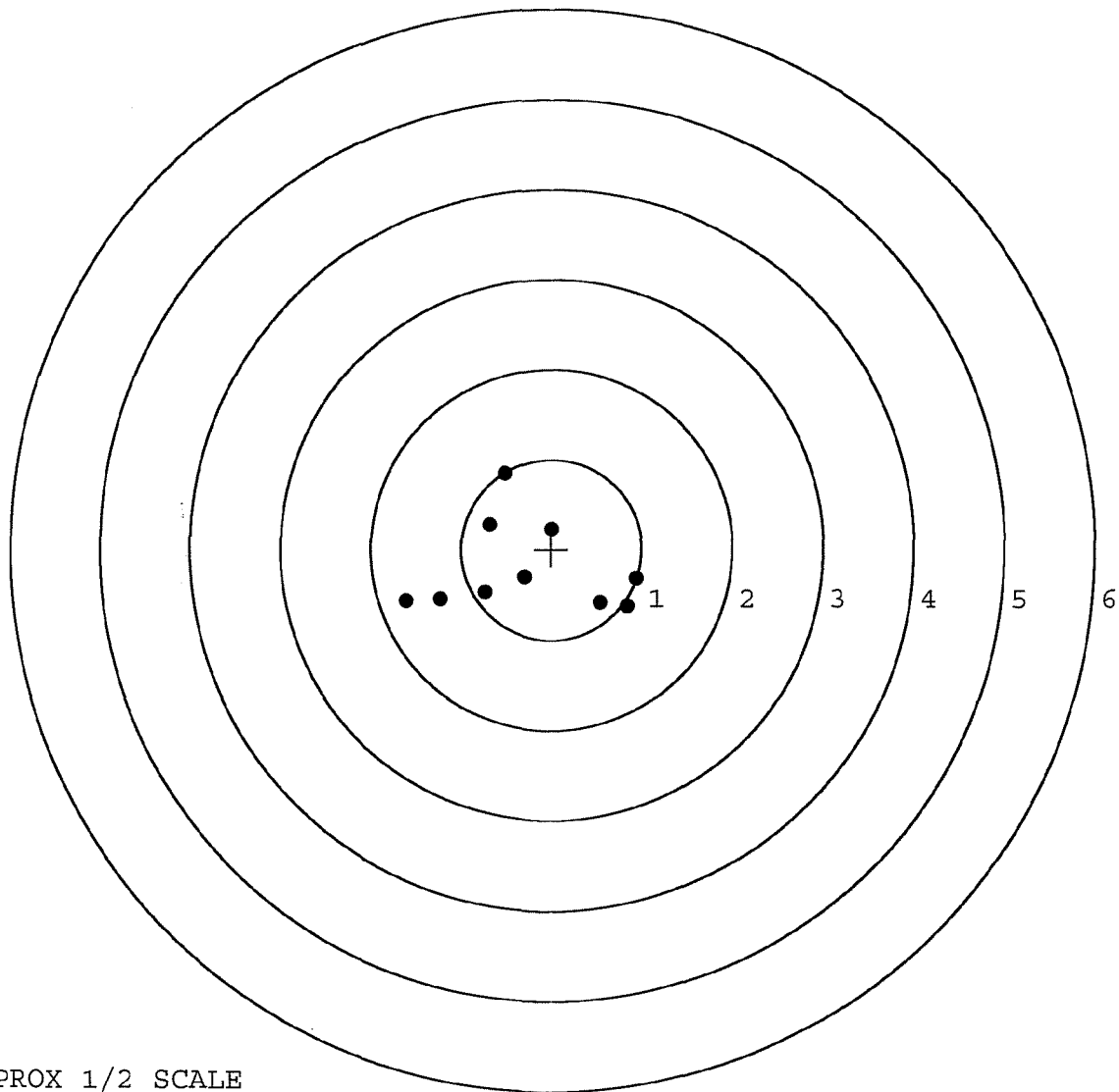


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410315. 0
TARGET NUMBER: 5
FILE DATE: 10/08/2004
FILE TIME: 08:15

X CENTROID: -0.275
Y CENTROID: -0.214
POA TO CENTROID: 0.348
HORZ SPREAD: 2.554
VERT SPREAD: 1.480
GROUP SPREAD: 2.566
MIN RADIUS: 0.096
MAX RADIUS: 1.383
MEAN RADIUS: 0.859
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.843	-0.636
2:	0.944	-0.327
3:	0.542	-0.595
4:	-0.298	-0.307
5:	-0.739	-0.481
6:	-1.610	-0.575
7:	0.010	0.223
8:	-0.691	0.268
9:	-0.515	0.844
10:	-1.232	-0.557



TARGET APPROX 1/2 SCALE