

G-6410505

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



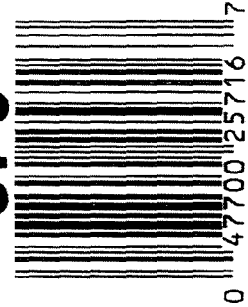
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6410505

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

Crib

2

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

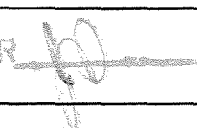
89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410505

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	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	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-5-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-5-04	RTL
	D) OIL FIRING PIN ASSEMBLY		10-12-04	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>6.2</u> <u>5.5</u> <u>5.5</u>	10-9-04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</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>.024</u> <u>.023</u> <u>.023</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	TRL
	MALFUNCTION <i>MCW</i>	CORRECTION <i>FGS</i>	10-11-04	<i>AC</i>
	MALFUNCTION	CORRECTION		<i>N/A</i>
	MALFUNCTION	CORRECTION		<i>N/A</i>
	MALFUNCTION	CORRECTION		<i>N/A</i>
645	INSPECT FOR LIVE AMMO		10-8-04	TRL
655	FINAL INSPECTION A) HEADSPACE		10-12-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.23</u> <u>2.35</u> <u>2.23</u> <u>2.19</u> <u>2.43</u>	10-9-04	DA
	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)

SERIAL NO.

DATE 10-4-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.15	2.29		2.23	
PULL #2	2.21	2.53		2.25	
PULL #3	2.31	2.59		2.25	
PULL #4	2.43	2.56		2.21	
PULL #5	2.31	2.33		2.25	
TOTAL	11.41	12.30		11.19	
AVERAGE	2.28	2.46		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.19		
PULL #2	3.29	3.23		
PULL #3	3.28	3.27		
PULL #4	3.31	3.37		
PULL #5	3.22	3.18		
TOTAL	16.42	16.24		
AVERAGE	3.28	3.24		

	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	4.13	4.08		4.06
PULL #2	4.08	4.09		4.05
PULL #3	4.09	4.07		4.06
PULL #4	4.09	3.81		4.11
PULL #5	4.17	4.07		4.06
TOTAL	20.56	20.12		20.34
AVERAGE	4.11	4.02		4.06

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410505.___0
FILE DATE AND TIME: 10/08/2004 08:01

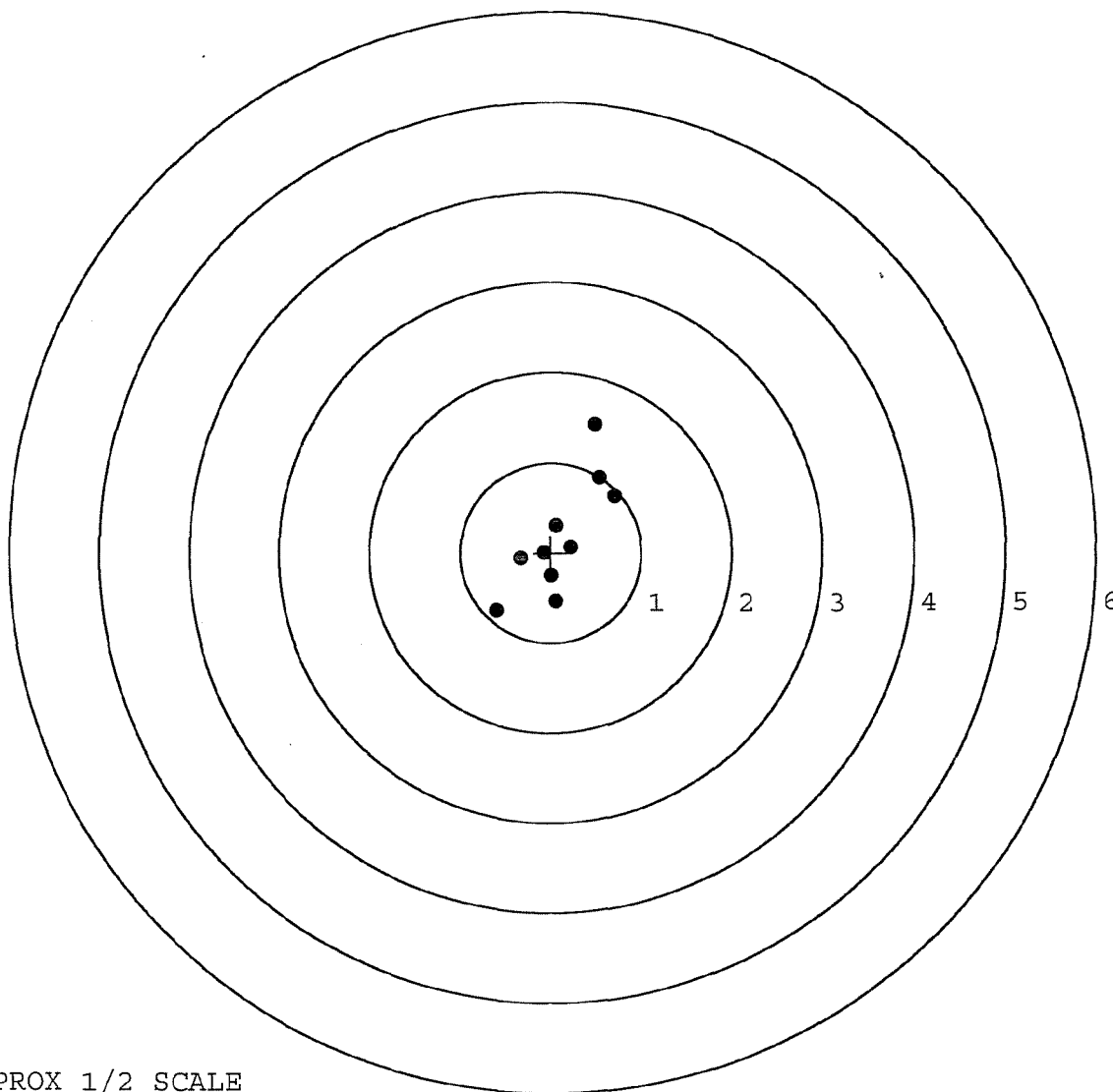
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.075
The Average Y Centroid of the Five Target Set:	0.015
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.602
The Distance from POA to Centroid Target #1:	0.203
The Distance from Centroid Target #2 to Centroid Target #1:	0.186
The Distance from Centroid Target #3 to Centroid Target #1:	0.135
The Distance from Centroid Target #4 to Centroid Target #1:	0.148
The Distance from Centroid Target #5 to Centroid Target #1:	0.352

SERIAL NUMBER: G6410505. __0
TARGET NUMBER: 1
FILE DATE: 10/08/2004
FILE TIME: 08:01

X CENTROID: 0.104
Y CENTROID: 0.175
POA TO CENTROID: 0.203
HORZ SPREAD: 1.308
VERT SPREAD: 2.076
GROUP SPREAD: 2.342
MIN RADIUS: 0.137
MAX RADIUS: 1.304
MEAN RADIUS: 0.615
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.604	-0.653
2:	0.056	-0.545
3:	0.704	0.639
4:	0.539	0.834
5:	0.480	1.423
6:	0.056	0.303
7:	0.221	0.061
8:	-0.076	0.005
9:	-0.334	-0.063
10:	-0.004	-0.255

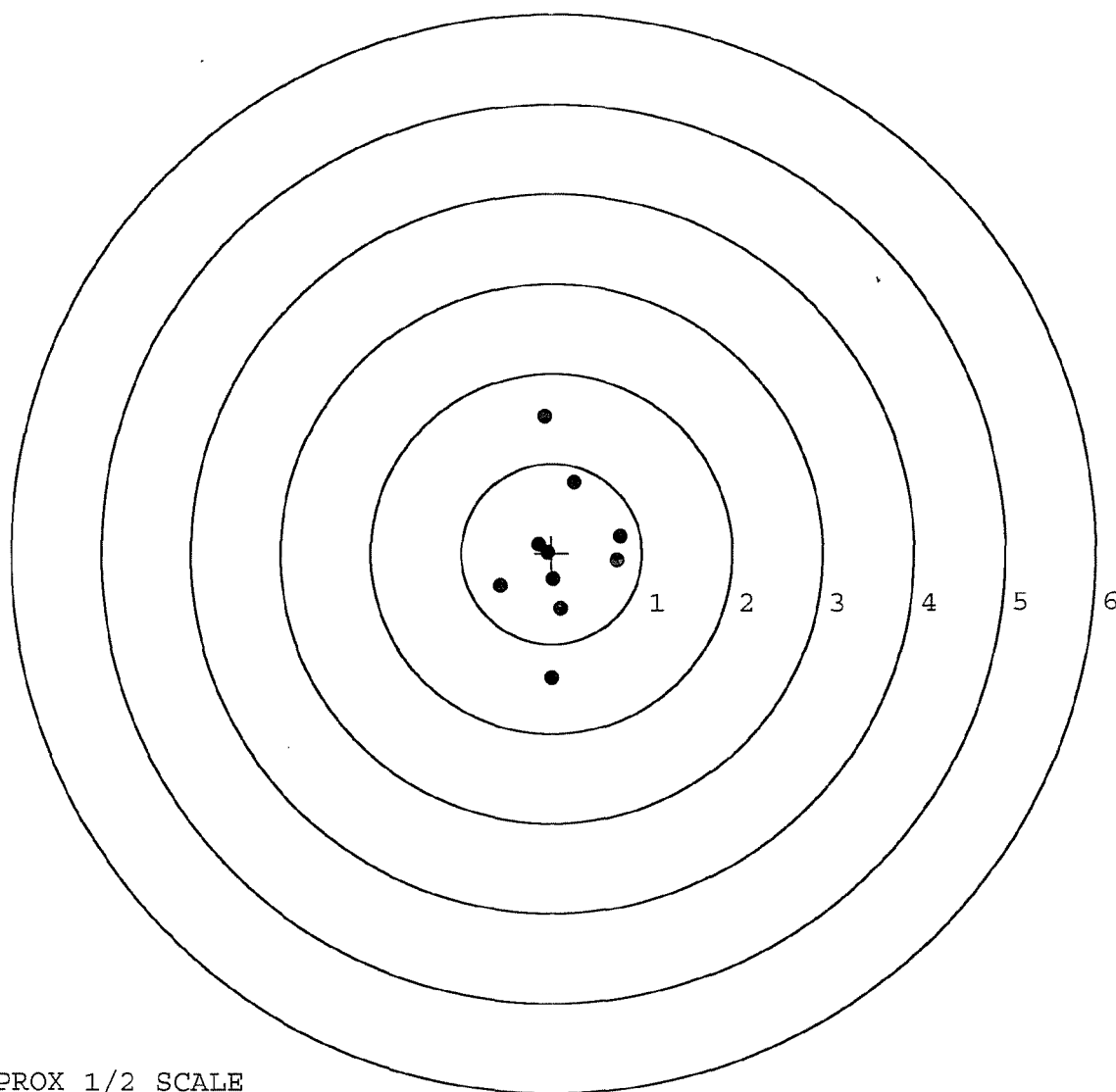


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410505. __0
TARGET NUMBER: 2
FILE DATE: 10/08/2004
FILE TIME: 08:01

X CENTROID: 0.100
Y CENTROID: -0.011
POA TO CENTROID: 0.101
HORZ SPREAD: 1.326
VERT SPREAD: 2.909
GROUP SPREAD: 2.910
MIN RADIUS: 0.152
MAX RADIUS: 1.547
MEAN RADIUS: 0.712
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.004	-1.384
2:	0.722	-0.081
3:	0.757	0.190
4:	0.253	0.793
5:	-0.085	1.525
6:	-0.142	0.099
7:	-0.050	0.012
8:	0.017	-0.287
9:	0.097	-0.617
10:	-0.569	-0.362

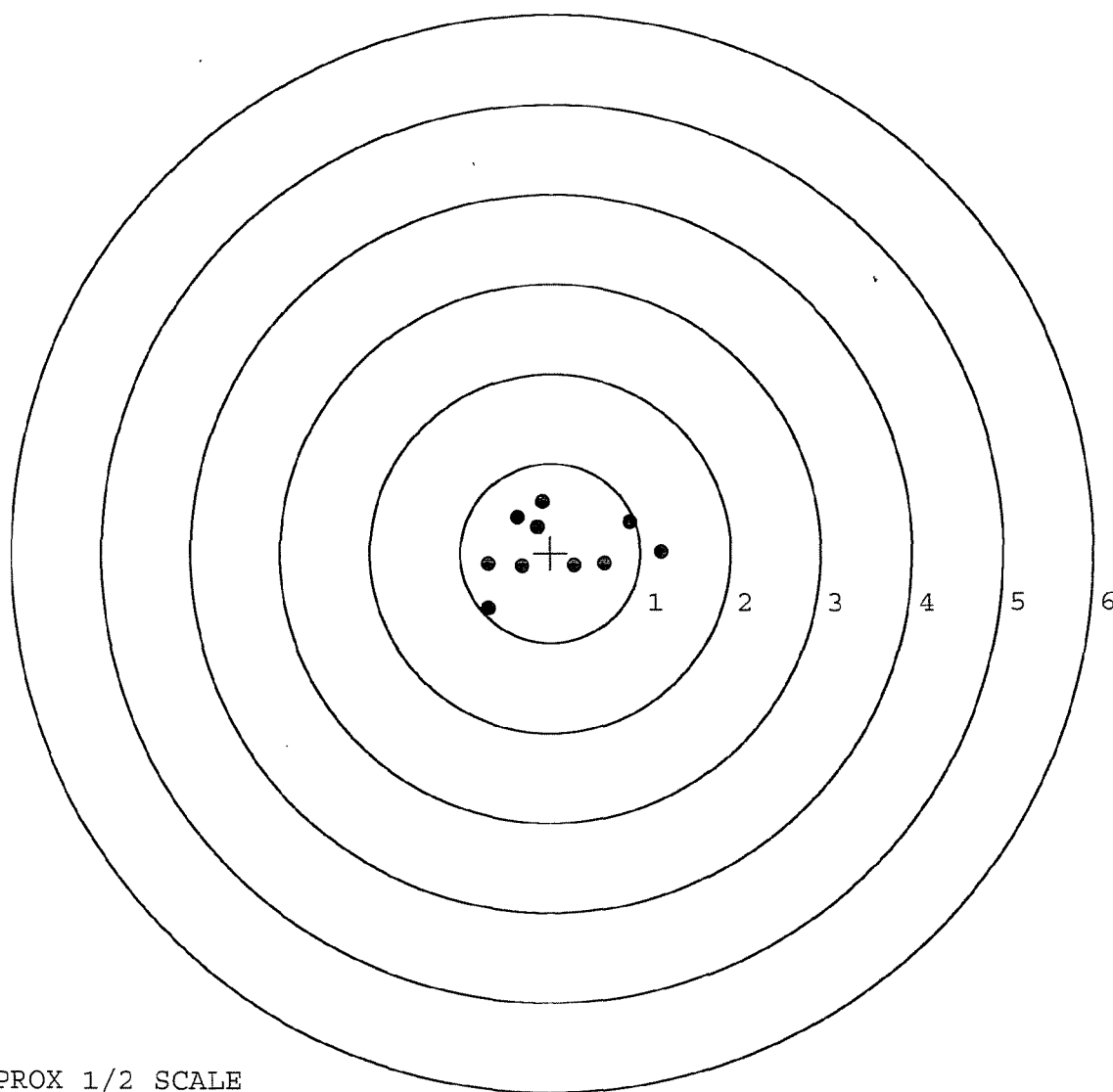


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410505.____0
TARGET NUMBER: 3
FILE DATE: 10/08/2004
FILE TIME: 08:01

POINT#	X	Y
1:	0.260	-0.142
2:	0.603	-0.115
3:	1.235	0.015
4:	0.878	0.349
5:	-0.099	0.568
6:	-0.374	0.396
7:	-0.152	0.290
8:	-0.318	-0.150
9:	-0.690	-0.622
10:	-0.690	-0.129

X CENTROID: 0.065
Y CENTROID: 0.046
POA TO CENTROID: 0.080
HORZ SPREAD: 1.925
VERT SPREAD: 1.190
GROUP SPREAD: 2.028
MIN RADIUS: 0.271
MAX RADIUS: 1.170
MEAN RADIUS: 0.652
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

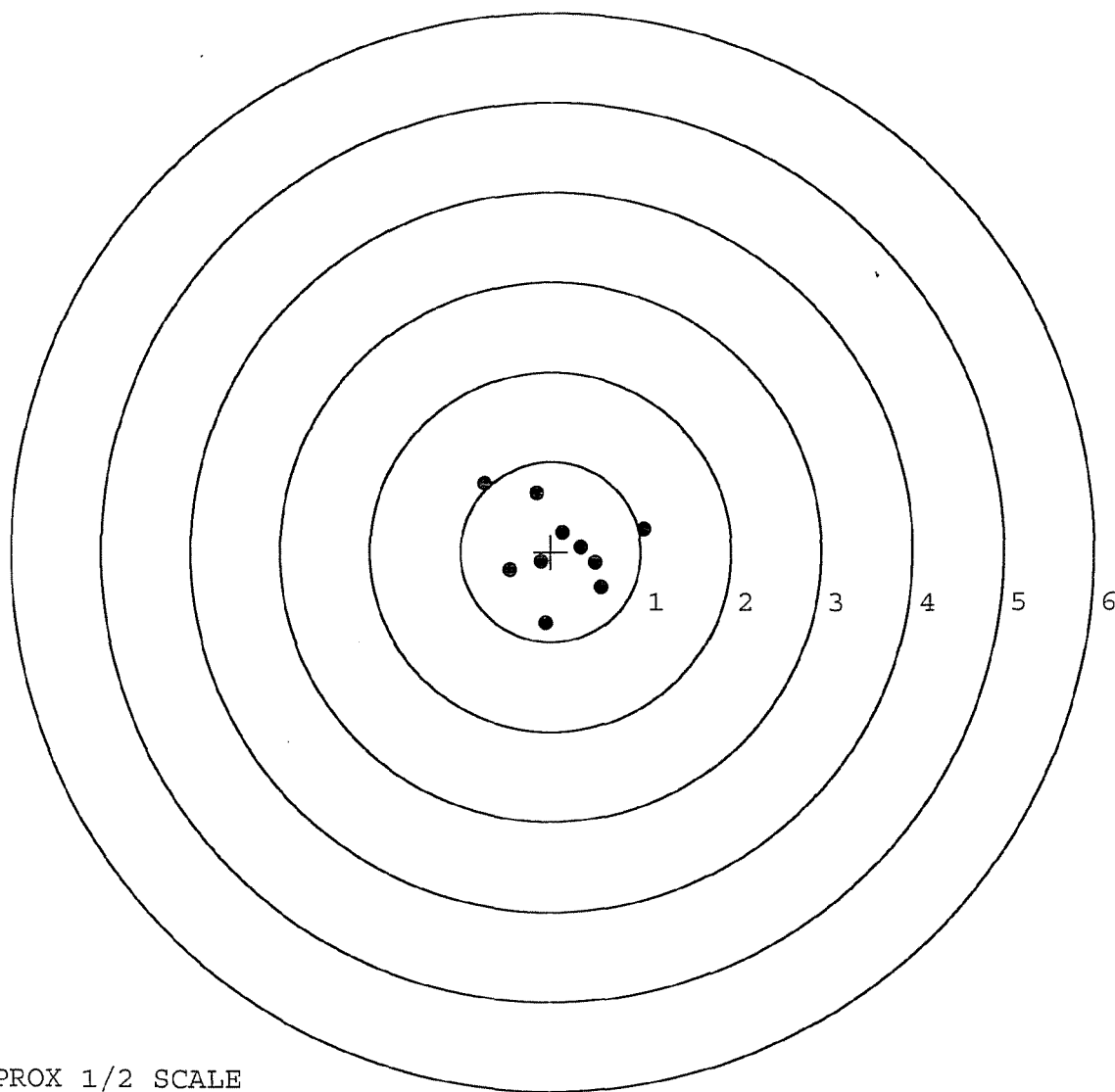


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410505. __0
TARGET NUMBER: 4
FILE DATE: 10/08/2004
FILE TIME: 08:01

POINT#	X	Y
1:	-0.062	-0.799
2:	0.554	-0.396
3:	0.495	-0.126
4:	1.027	0.249
5:	0.339	0.048
6:	0.126	0.211
7:	-0.109	-0.107
8:	-0.454	-0.206
9:	-0.160	0.653
10:	-0.738	0.747

X CENTROID: 0.102
Y CENTROID: 0.027
POA TO CENTROID: 0.105
HORZ SPREAD: 1.765
VERT SPREAD: 1.546
GROUP SPREAD: 1.834
MIN RADIUS: 0.185
MAX RADIUS: 1.106
MEAN RADIUS: 0.590
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

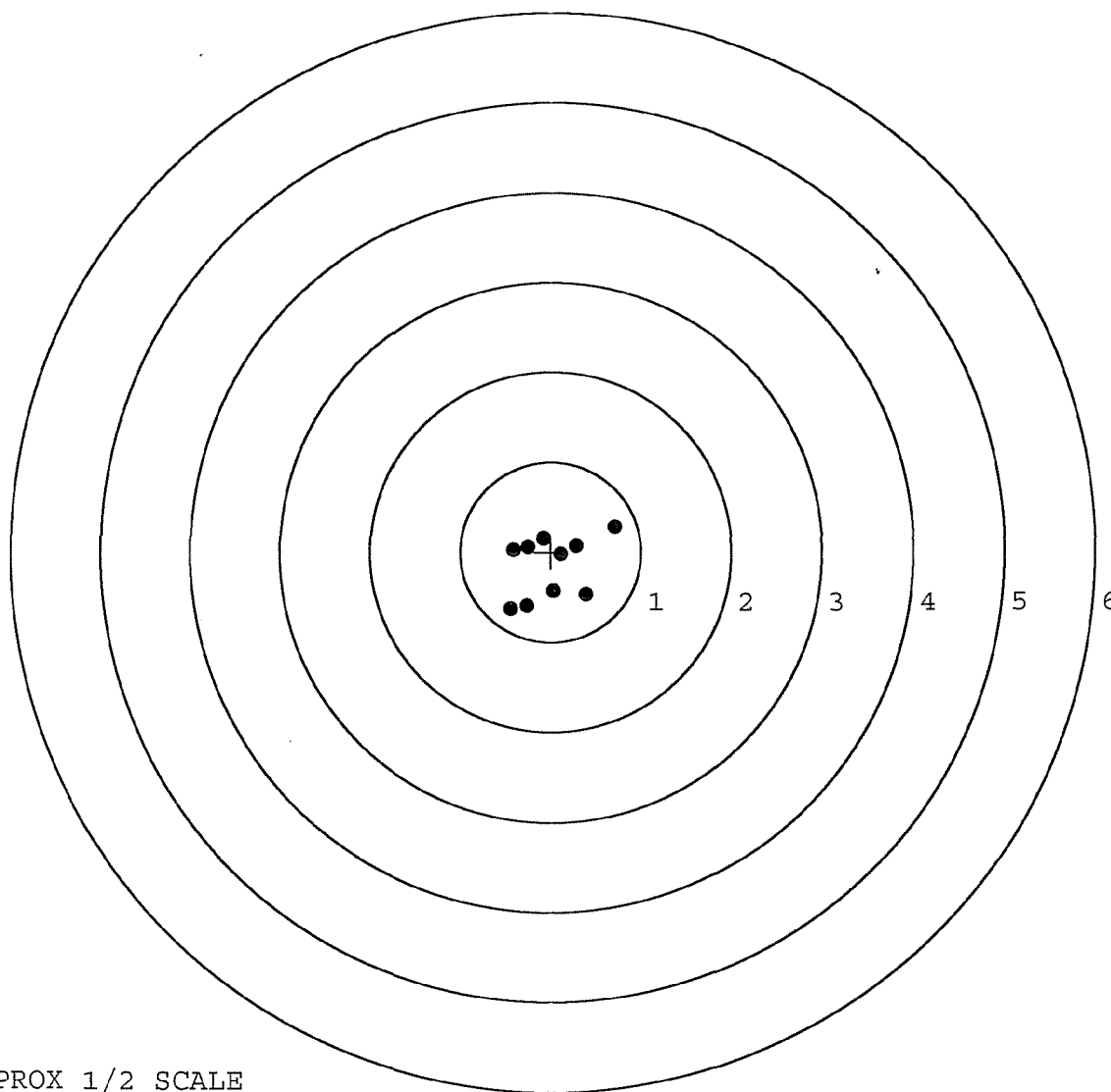


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410505.____0
TARGET NUMBER: 5
FILE DATE: 10/08/2004
FILE TIME: 08:01

X CENTROID: 0.003
Y CENTROID: -0.162
POA TO CENTROID: 0.162
HORZ SPREAD: 1.150
VERT SPREAD: 0.916
GROUP SPREAD: 1.470
MIN RADIUS: 0.167
MAX RADIUS: 0.825
MEAN RADIUS: 0.443
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.448	-0.640
2:	-0.273	-0.604
3:	0.029	-0.439
4:	0.387	-0.479
5:	0.702	0.276
6:	0.281	0.067
7:	-0.083	0.150
8:	-0.420	0.025
9:	-0.256	0.058
10:	0.109	-0.033



TARGET APPROX 1/2 SCALE