

G 641 4362

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



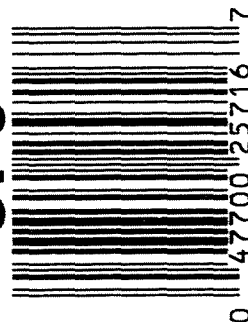
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6414362

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 11:09:26 AM

Crib

L

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

01PC001

Flat Black Powder Coat, Barrel and



0003517903

0560

89SWS1

Reassemble Action.



0003517904

0690

89SWS1

Pack Rifle



0003517897

0700

89SWS1

Stencil SWS Container



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414362

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTZ
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		10/27/04	AB
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRL
620	APPLY COATINGS (BARREL ACTION)		10/30	HP
	(BOLT)			
625	FINAL ASSEMBLY		11-9-04	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-04	DA
	D) OIL FIRING PIN ASSEMBLY		11-9-04	RTZ
	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>7.5</u> <u>7.0</u> <u>7.5</u>	11/16/04	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	11/16/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.023</u> <u>.021</u>	11/14/04	DA
	J) ASSEMBLE STOCK		11-9-04	RTL
	K) ASSEMBLE SWIVEL STUDS		11-29-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		11-29-04	RTL
	M) IRON SIGHT ALIGNMENT		11-29-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		11-29-04	RTL
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	11-15-04	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
645	INSPECT FOR LIVE AMMO		11-15-04	TRW
655	FINAL INSPECTION A) HEADSPACE		11-29-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.32</u> <u>2.35</u> <u>2.39</u> <u>2.32</u> <u>2.49</u>	11/14/04	DA
	C) FUNCTION		11-29-04	RTL
660	PACK		11/16/04	DA

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 6-15-04
 TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.60		2.68	
PULL #2	2.46	2.46		2.82	
PULL #3	2.50	2.88		2.67	
PULL #4	2.53	2.75		2.53	
PULL #5	2.61	2.83		2.52	
TOTAL	12.64	13.52		13.22	
AVERAGE	2.52	2.70		2.64	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.07	3.17		
PULL #2	3.09	3.17		
PULL #3	3.21	3.40		
PULL #4	3.30	3.42		
PULL #5	3.34	3.65		
TOTAL	16.01	16.81		
AVERAGE	3.20	3.36		

	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	4.09	4.18		3.91
PULL #2	4.39	4.08		3.94
PULL #3	4.27	4.03		3.99
PULL #4	4.30	4.10		3.99
PULL #5	4.34	4.19		4.04
TOTAL	21.39	20.58		19.87
AVERAGE	4.27	4.11		3.97

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414362.___0
FILE DATE AND TIME: 11/15/2004 11:10

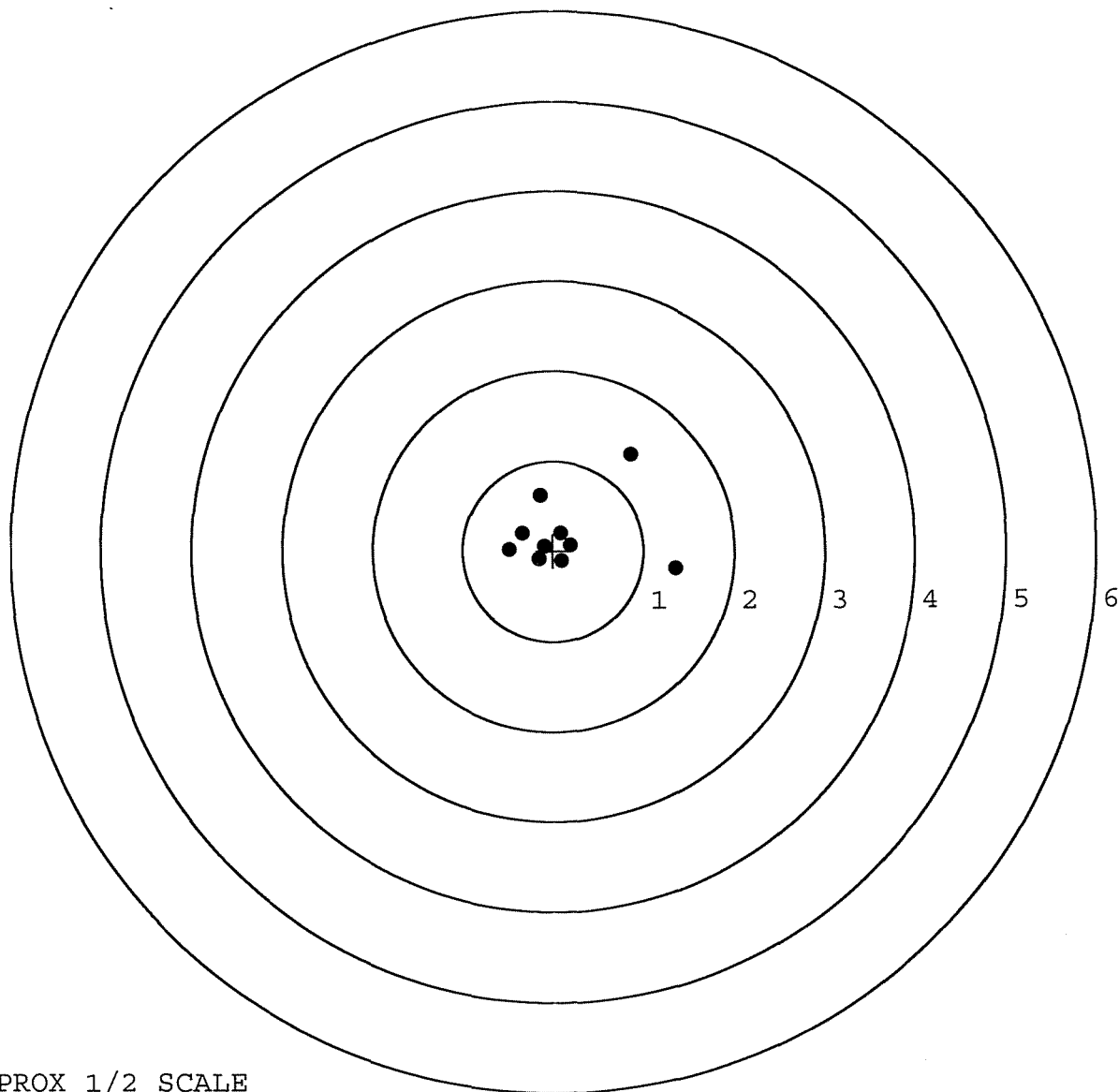
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.087
The Average Y Centroid of the Five Target Set:	0.131
The Average Point of Impact of the Five Target Set:	0.157
The Average Mean Radius of the Five Target Set:	0.752
The Distance from POA to Centroid Target #1:	0.227
The Distance from Centroid Target #2 to Centroid Target #1:	0.409
The Distance from Centroid Target #3 to Centroid Target #1:	0.381
The Distance from Centroid Target #4 to Centroid Target #1:	0.340
The Distance from Centroid Target #5 to Centroid Target #1:	0.118

SERIAL NUMBER: G6414362. __0
TARGET NUMBER: 1
FILE DATE: 11/15/2004
FILE TIME: 11:10

X CENTROID: 0.139
Y CENTROID: 0.180
POA TO CENTROID: 0.227
HORZ SPREAD: 1.831
VERT SPREAD: 1.275
GROUP SPREAD: 1.844
MIN RADIUS: 0.051
MAX RADIUS: 1.270
MEAN RADIUS: 0.521
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.865	1.072
2:	1.350	-0.203
3:	-0.142	0.618
4:	-0.337	0.197
5:	-0.481	0.016
6:	-0.154	-0.095
7:	0.095	-0.118
8:	0.199	0.064
9:	0.091	0.196
10:	-0.098	0.050



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414362. __0

TARGET NUMBER: 2

FILE DATE: 11/15/2004

FILE TIME: 11:10

POINT#	X	Y
1:	-0.517	1.197
2:	-0.143	0.852
3:	-0.632	0.661
4:	-0.787	0.315
5:	-0.280	0.044
6:	0.063	-0.359
7:	0.537	-0.282
8:	0.710	-0.898
9:	-0.438	-0.638
10:	-0.879	-0.728

X CENTROID: -0.237

Y CENTROID: 0.016

POA TO CENTROID: 0.237

HORZ SPREAD: 1.589

VERT SPREAD: 2.095

GROUP SPREAD: 2.428

MIN RADIUS: 0.051

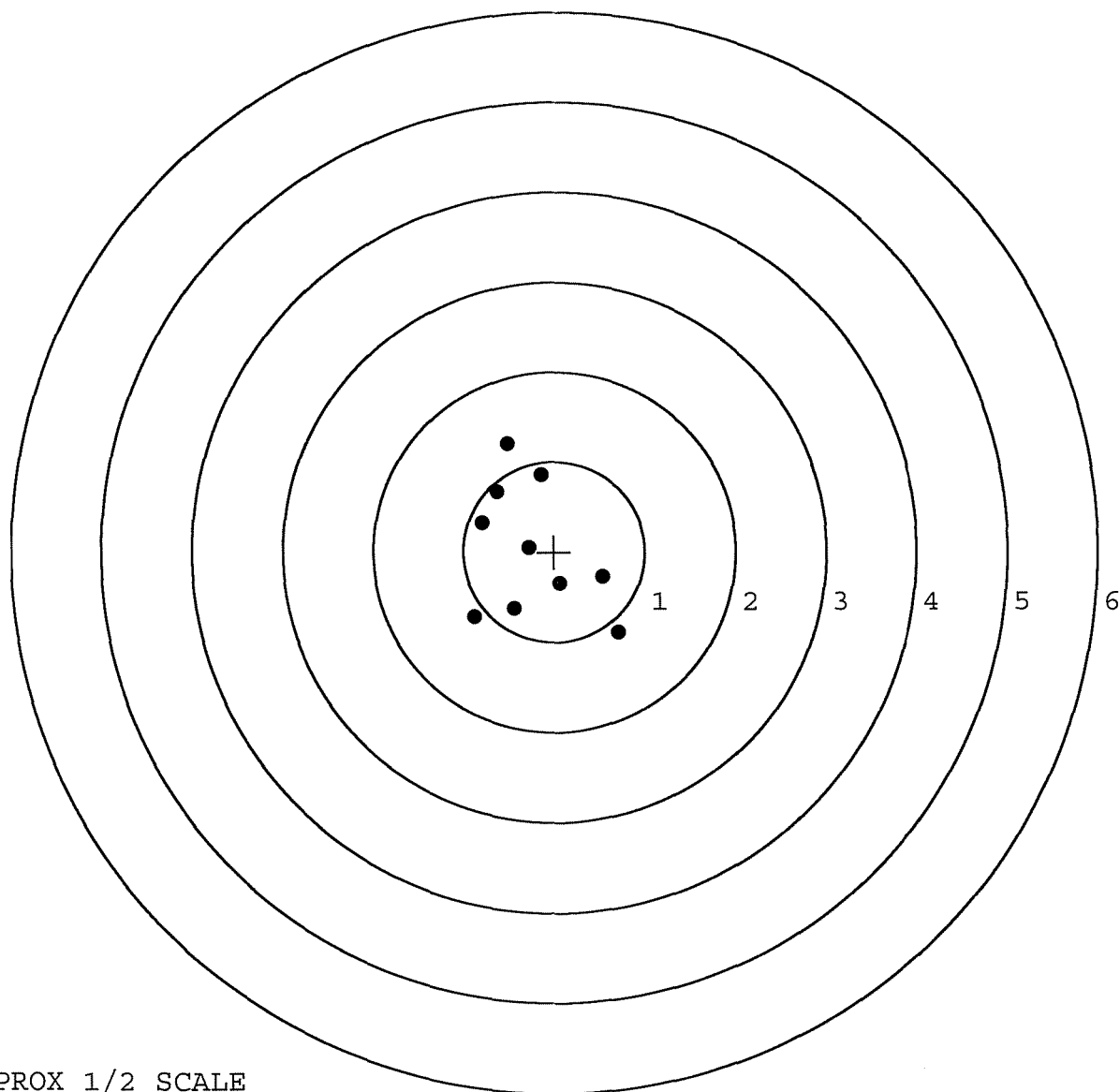
MAX RADIUS: 1.316

MEAN RADIUS: 0.778

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414362. __0

TARGET NUMBER: 3

FILE DATE: 11/15/2004

FILE TIME: 11:10

X CENTROID: -0.220

Y CENTROID: 0.309

POA TO CENTROID: 0.379

HORZ SPREAD: 1.660

VERT SPREAD: 2.993

GROUP SPREAD: 3.381

MIN RADIUS: 0.015

MAX RADIUS: 1.784

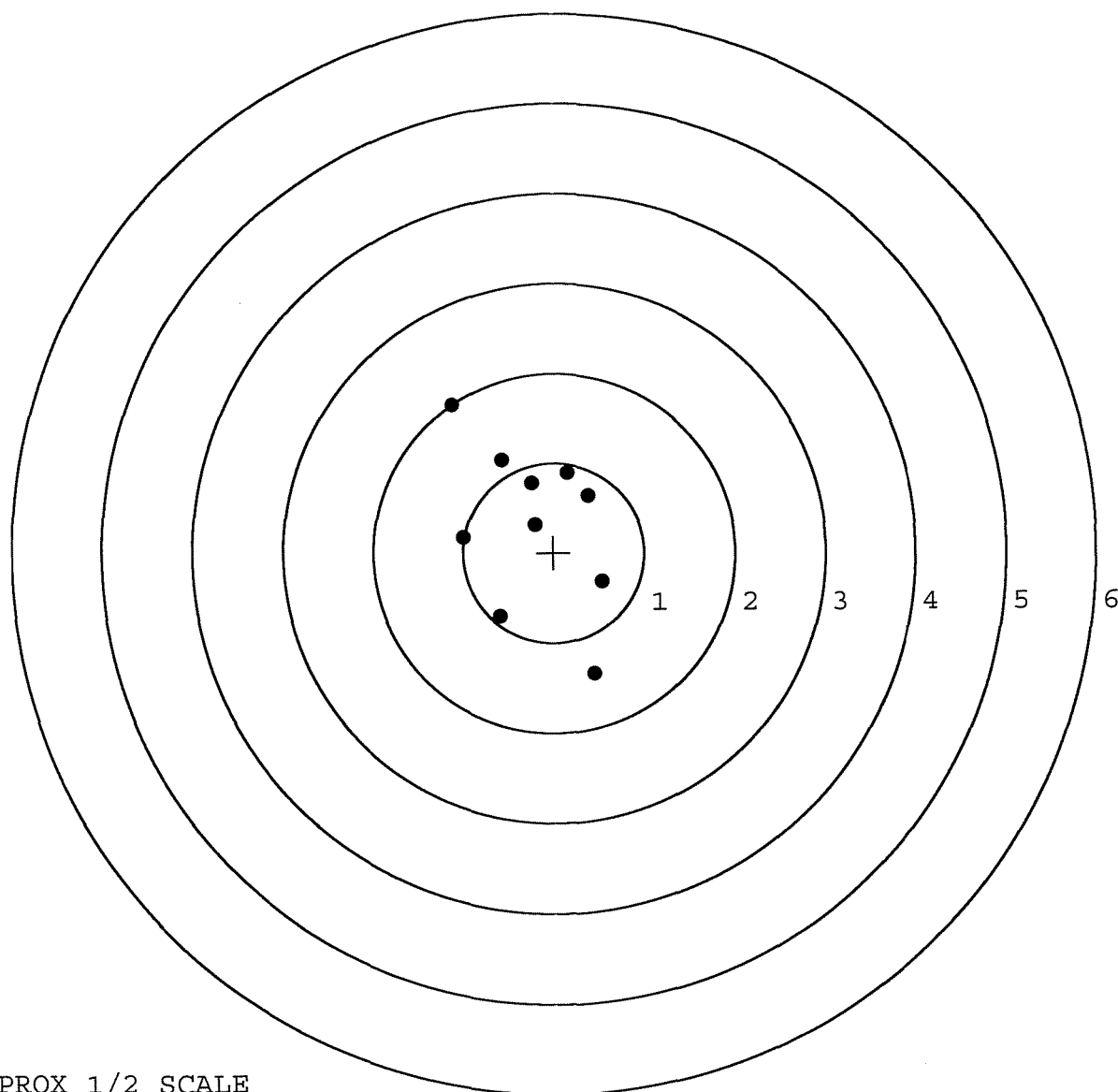
MEAN RADIUS: 0.893

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.156	0.889
2:	0.383	0.638
3:	0.540	-0.320
4:	0.452	-1.343
5:	-0.598	-0.710
6:	-0.996	0.168
7:	-1.120	1.650
8:	-0.571	1.037
9:	-0.241	0.774
10:	-0.205	0.308



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414362. __0

TARGET NUMBER: 4

FILE DATE: 11/15/2004

FILE TIME: 11:10

X CENTROID: -0.181

Y CENTROID: 0.062

POA TO CENTROID: 0.191

HORZ SPREAD: 2.023

VERT SPREAD: 2.792

GROUP SPREAD: 3.165

MIN RADIUS: 0.287

MAX RADIUS: 1.905

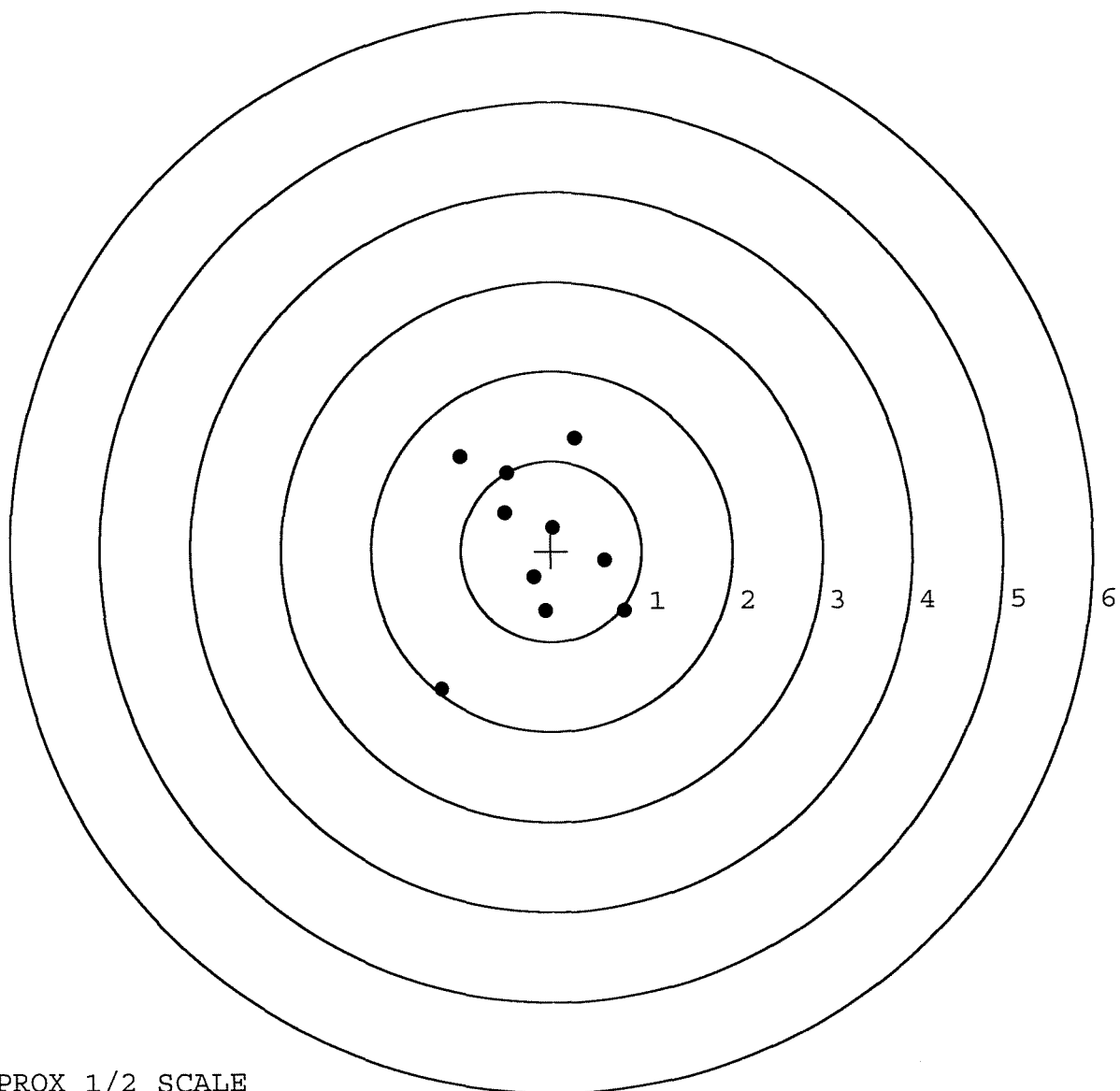
MEAN RADIUS: 0.921

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.268	1.259
2:	-1.001	1.050
3:	-0.487	0.871
4:	-0.514	0.429
5:	0.023	0.265
6:	-0.195	-0.290
7:	0.592	-0.101
8:	0.801	-0.661
9:	-0.072	-0.666
10:	-1.222	-1.533



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414362. __0

TARGET NUMBER: 5

FILE DATE: 11/15/2004

FILE TIME: 11:10

X CENTROID: 0.064

Y CENTROID: 0.089

POA TO CENTROID: 0.110

HORZ SPREAD: 1.876

VERT SPREAD: 1.560

GROUP SPREAD: 2.124

MIN RADIUS: 0.351

MAX RADIUS: 1.213

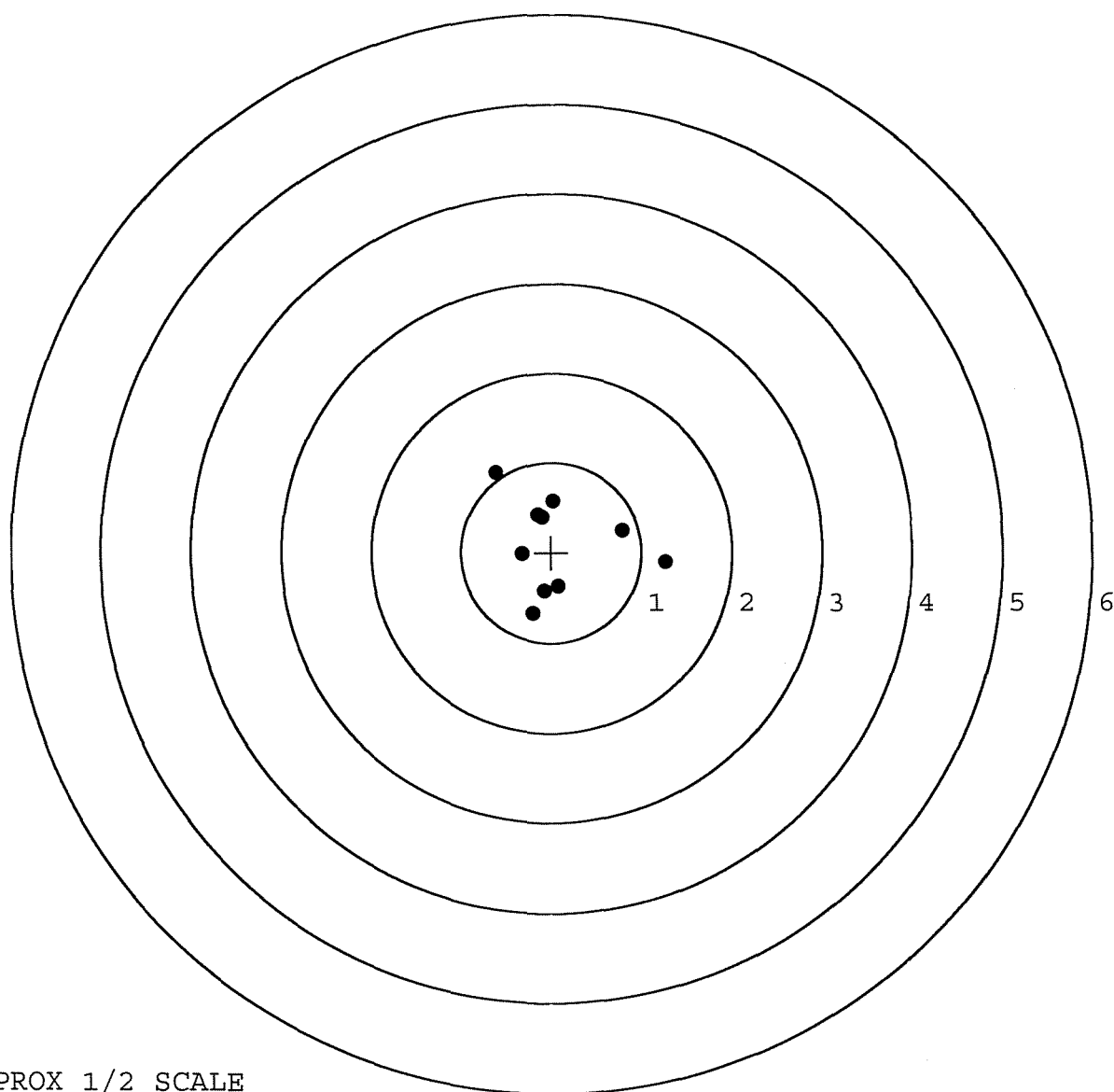
MEAN RADIUS: 0.645

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.790	0.244
2:	1.261	-0.113
3:	0.074	-0.374
4:	-0.085	-0.433
5:	-0.206	-0.677
6:	-0.325	-0.023
7:	-0.113	0.392
8:	0.018	0.570
9:	-0.615	0.883
10:	-0.155	0.418



TARGET APPROX 1/2 SCALE