

G646 1542

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



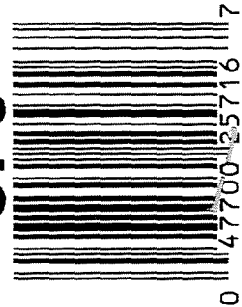
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461542

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC



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ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI
UPC



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SERIAL NO.



66461542

6/17/2005 2:12:04 PM

Original

47

Original

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0004012773

0540

Flat Black Powder Coat, Barrel and

01PC001



0004012763

0560

Reassemble Action.

89SWS1



0004012764

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461542

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTZ
440	PROOF		9-6-05	TRL
460	CHECK HEADSPACE		9-6-05	RTZ
470	DIS-ASSEMBLE ACTION		9-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR units	9/8/05	units
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRL
520	GOFF BLAST BBL / REC		9/12	SS
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HF
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/22/05	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/22/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/22/05	DA
	D) OIL FIRING PIN ASSEMBLY		9-22-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>4 lbs</u> <u>4 lbs</u> <u>4 lbs</u>	10-6-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-6-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	10-6-05	Ac
	J) ASSEMBLE STOCK		9-27-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-6-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-28-05	RTL
	M) IRON SIGHT ALIGNMENT		9-28-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-28-05	RTL
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	9-30-05	TRL
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9/30/05	ST
670	FINAL INSPECTION A) HEADSPACE		10-6-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.73</u> <u>2.94</u> <u>2.32</u> <u>2.44</u>	10/3/05	BC
	C) FUNCTION		10-6-05	Ac
690	PACK		10-7-05	PA

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

TESTER

9/21/05

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.76	2.45		2.15	
PULL #2	2.69	2.28		2.49	
PULL #3	2.66	2.17		2.57	
PULL #4	2.60	2.42		2.24	
PULL #5	2.44	2.19		2.17	
TOTAL	13.15	11.51		11.62	
AVERAGE	2.63	2.30		2.32	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	2.92		
PULL #2	3.30	3.19		
PULL #3	3.31	2.75		
PULL #4	3.21	3.40		
PULL #5	3.31	2.97		
TOTAL	16.36	15.23		
AVERAGE	3.27	3.05		

	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	4.19	4.07		4.01
PULL #2	4.13	4.19		4.13
PULL #3	3.79	4.20		4.19
PULL #4	4.06	3.93		4.13
PULL #5	4.00	3.58		4.11
TOTAL	20.17	19.97		20.57
AVERAGE	4.03	3.99		4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461542.___0

FILE DATE AND TIME: 09/30/2005 15:50

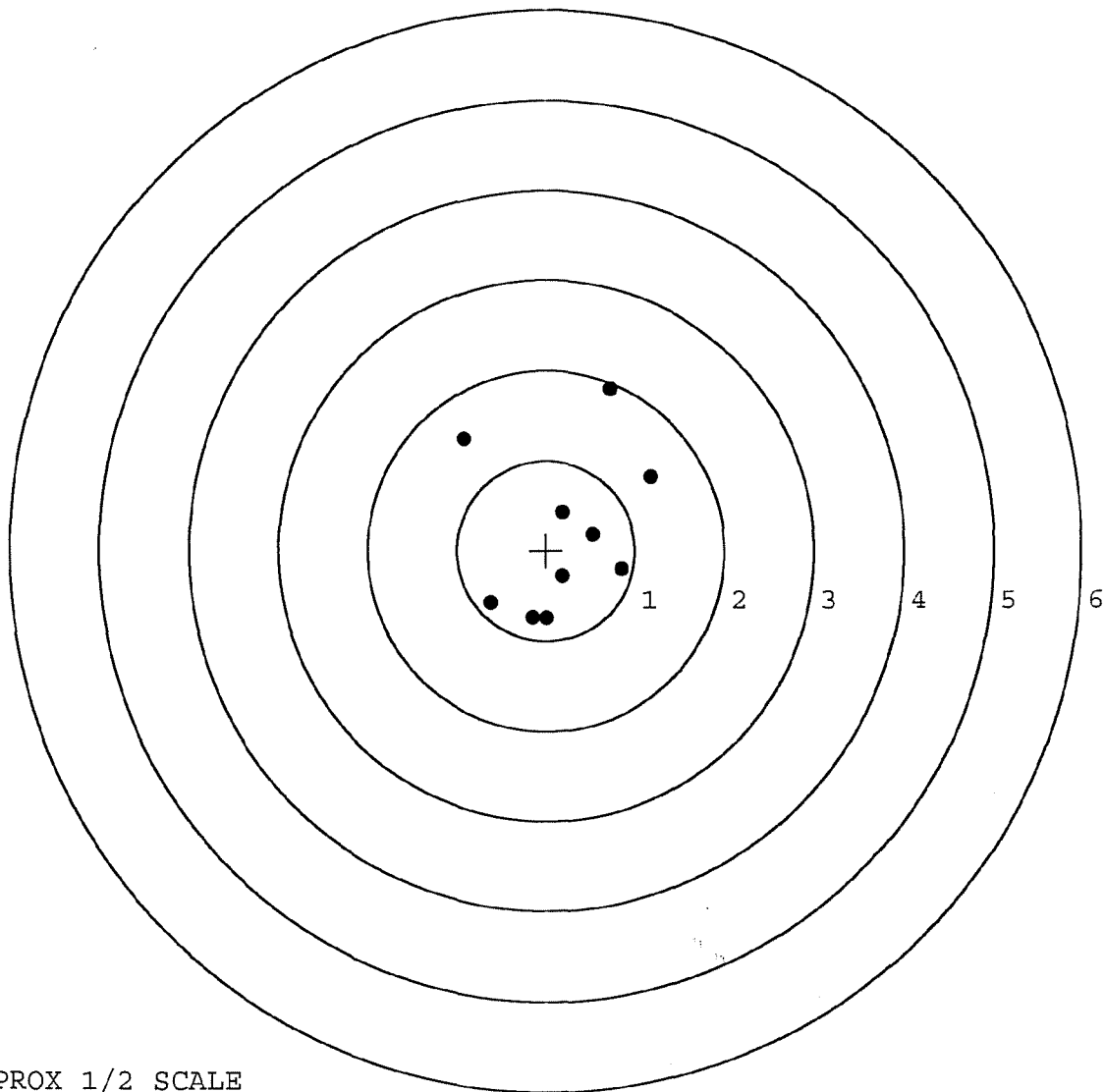
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.107
The Average Y Centroid of the Five Target Set:	0.085
The Average Point of Impact of the Five Target Set:	0.136
The Average Mean Radius of the Five Target Set:	1.075
The Distance from POA to Centroid Target #1:	0.270
The Distance from Centroid Target #2 to Centroid Target #1:	0.400
The Distance from Centroid Target #3 to Centroid Target #1:	0.122
The Distance from Centroid Target #4 to Centroid Target #1:	0.360
The Distance from Centroid Target #5 to Centroid Target #1:	0.234

SERIAL NUMBER: G6461542. 0
TARGET NUMBER: 1
FILE DATE: 09/30/2005
FILE TIME: 15:50

X CENTROID: 0.195
Y CENTROID: 0.187
POA TO CENTROID: 0.270
HORZ SPREAD: 2.095
VERT SPREAD: 2.553
GROUP SPREAD: 2.729
MIN RADIUS: 0.233
MAX RADIUS: 1.690
MEAN RADIUS: 0.930
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.623	-0.582
2:	-0.160	-0.750
3:	-0.004	-0.759
4:	0.183	-0.292
5:	0.186	0.420
6:	0.528	0.184
7:	0.849	-0.207
8:	-0.914	1.246
9:	1.181	0.820
10:	0.720	1.794



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461542. 0

TARGET NUMBER: 2

FILE DATE: 09/30/2005

FILE TIME: 15:50

X CENTROID: -0.164

Y CENTROID: 0.009

POA TO CENTROID: 0.164

HORZ SPREAD: 2.579

VERT SPREAD: 3.702

GROUP SPREAD: 4.000

MIN RADIUS: 0.508

MAX RADIUS: 2.216

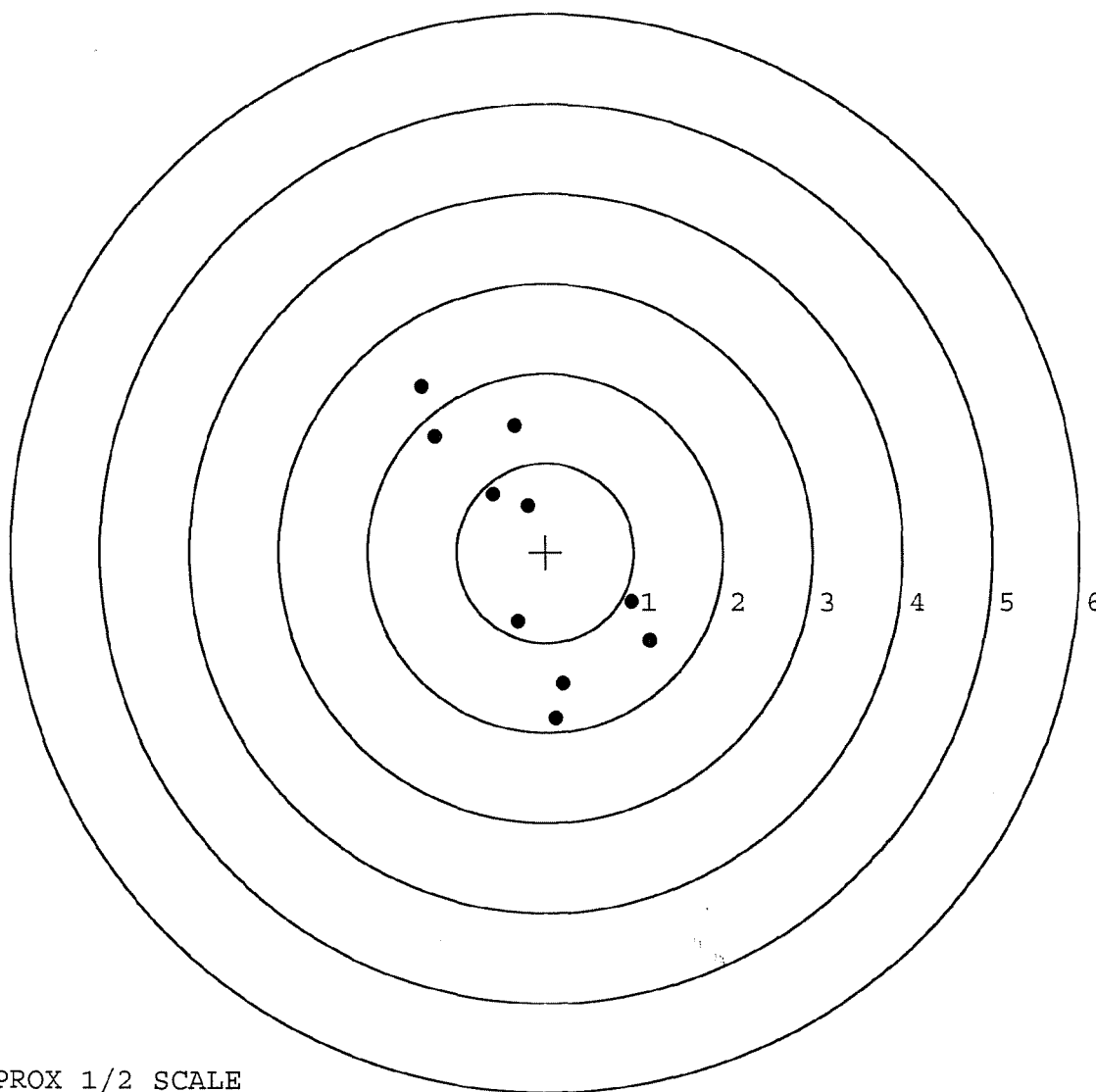
MEAN RADIUS: 1.373

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 5

POINT#	X	Y
1:	-0.204	0.516
2:	-0.596	0.648
3:	-0.353	1.417
4:	-1.246	1.287
5:	-1.396	1.851
6:	-0.314	-0.772
7:	0.971	-0.551
8:	1.183	-0.986
9:	0.197	-1.465
10:	0.120	-1.851

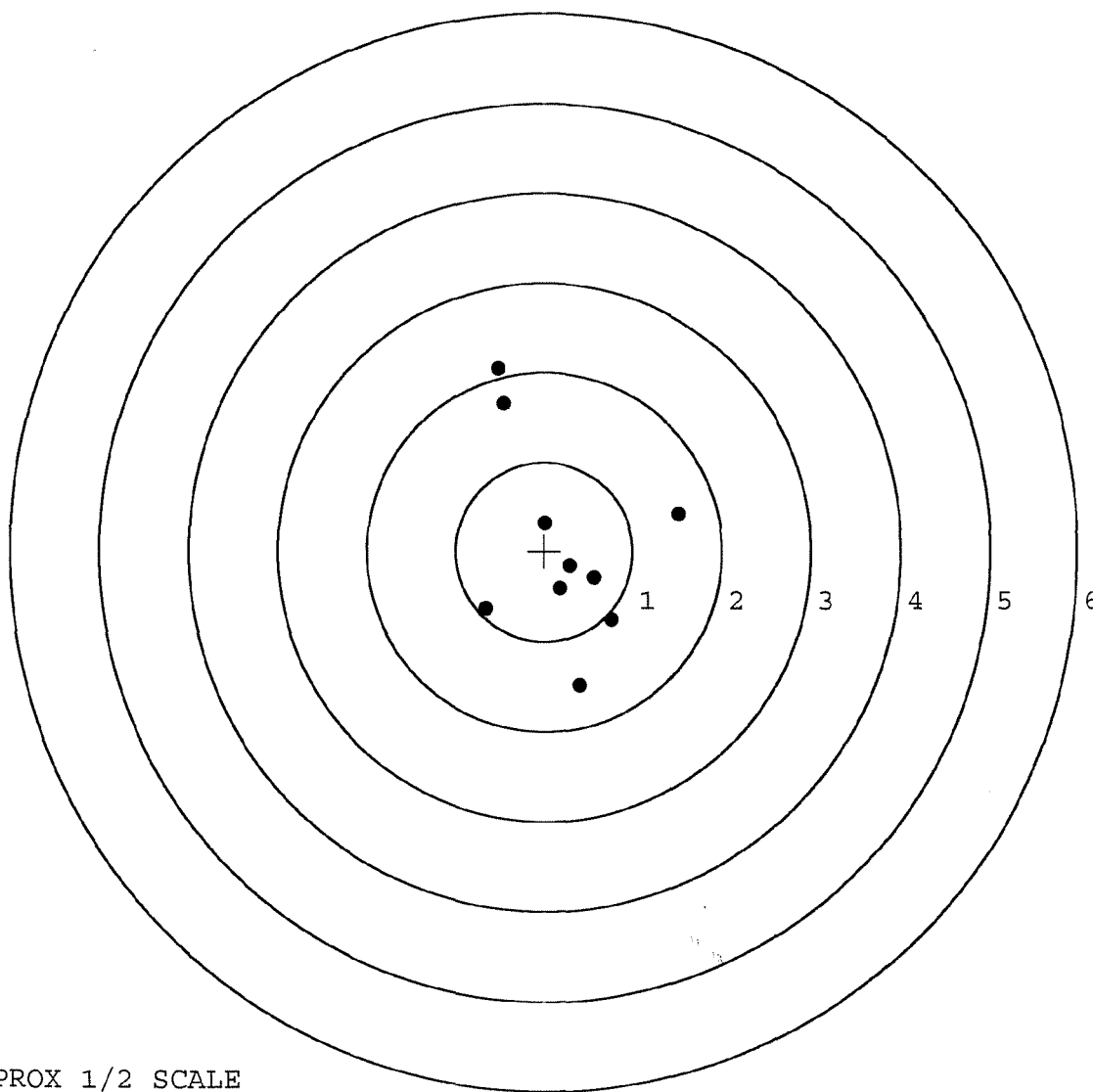


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461542. __0
TARGET NUMBER: 3
FILE DATE: 09/30/2005
FILE TIME: 15:50

X CENTROID: 0.205
Y CENTROID: 0.066
POA TO CENTROID: 0.216
HORZ SPREAD: 2.183
VERT SPREAD: 3.537
GROUP SPREAD: 3.657
MIN RADIUS: 0.246
MAX RADIUS: 2.111
MEAN RADIUS: 1.043
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.006	0.316
2:	-0.666	-0.641
3:	0.175	-0.421
4:	0.287	-0.166
5:	0.562	-0.294
6:	0.755	-0.764
7:	1.517	0.426
8:	-0.462	1.647
9:	-0.525	2.046
10:	0.406	-1.491

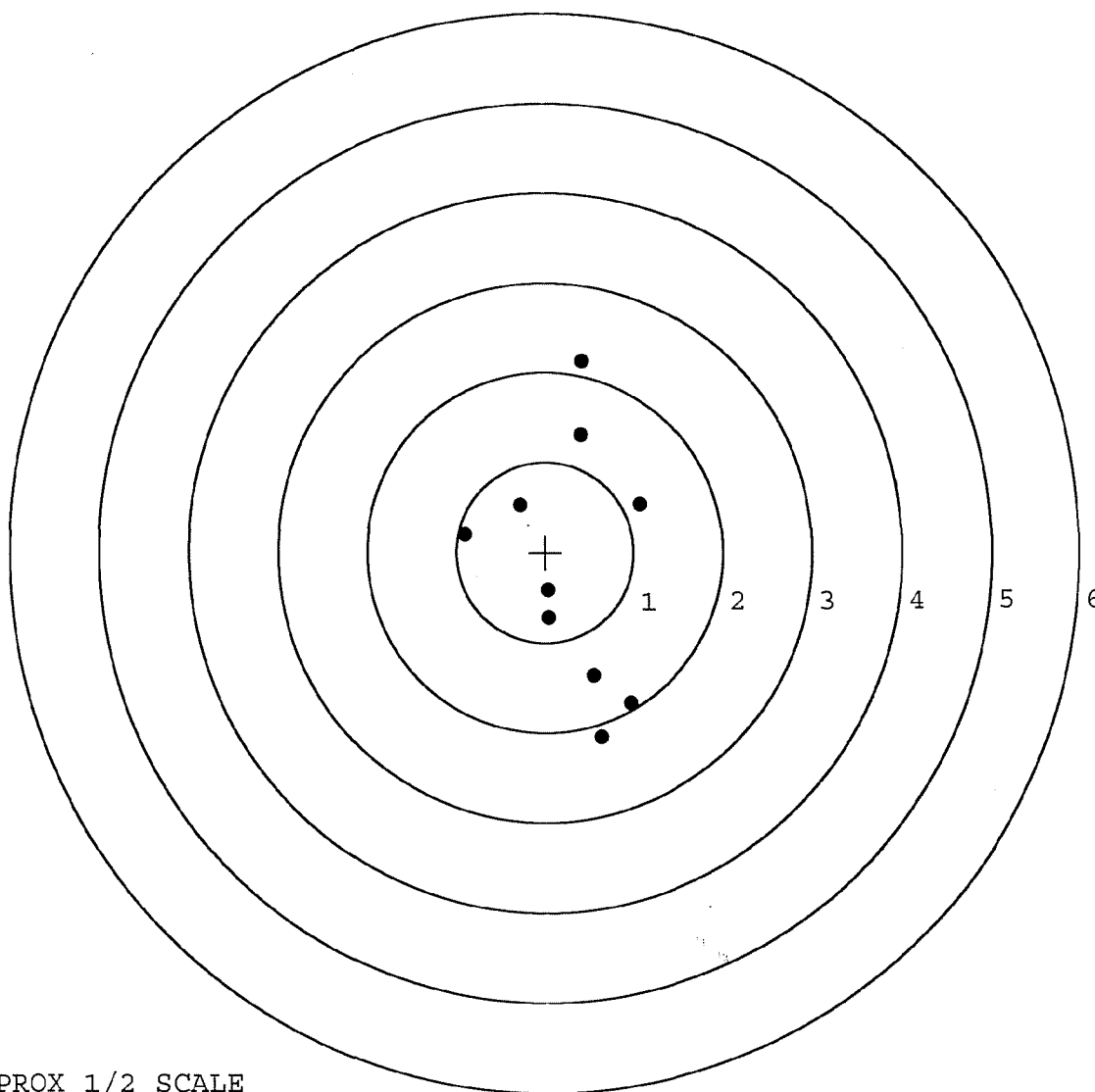


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461542. __0
TARGET NUMBER: 4
FILE DATE: 09/30/2005
FILE TIME: 15:50

X CENTROID: 0.295
Y CENTROID: -0.158
POA TO CENTROID: 0.335
HORZ SPREAD: 1.988
VERT SPREAD: 4.182
GROUP SPREAD: 4.187
MIN RADIUS: 0.376
MAX RADIUS: 2.287
MEAN RADIUS: 1.276
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	-0.279	0.526
2:	-0.904	0.201
3:	0.031	-0.425
4:	0.035	-0.733
5:	0.542	-1.367
6:	0.961	-1.676
7:	0.633	-2.057
8:	1.084	0.532
9:	0.416	1.294
10:	0.432	2.125

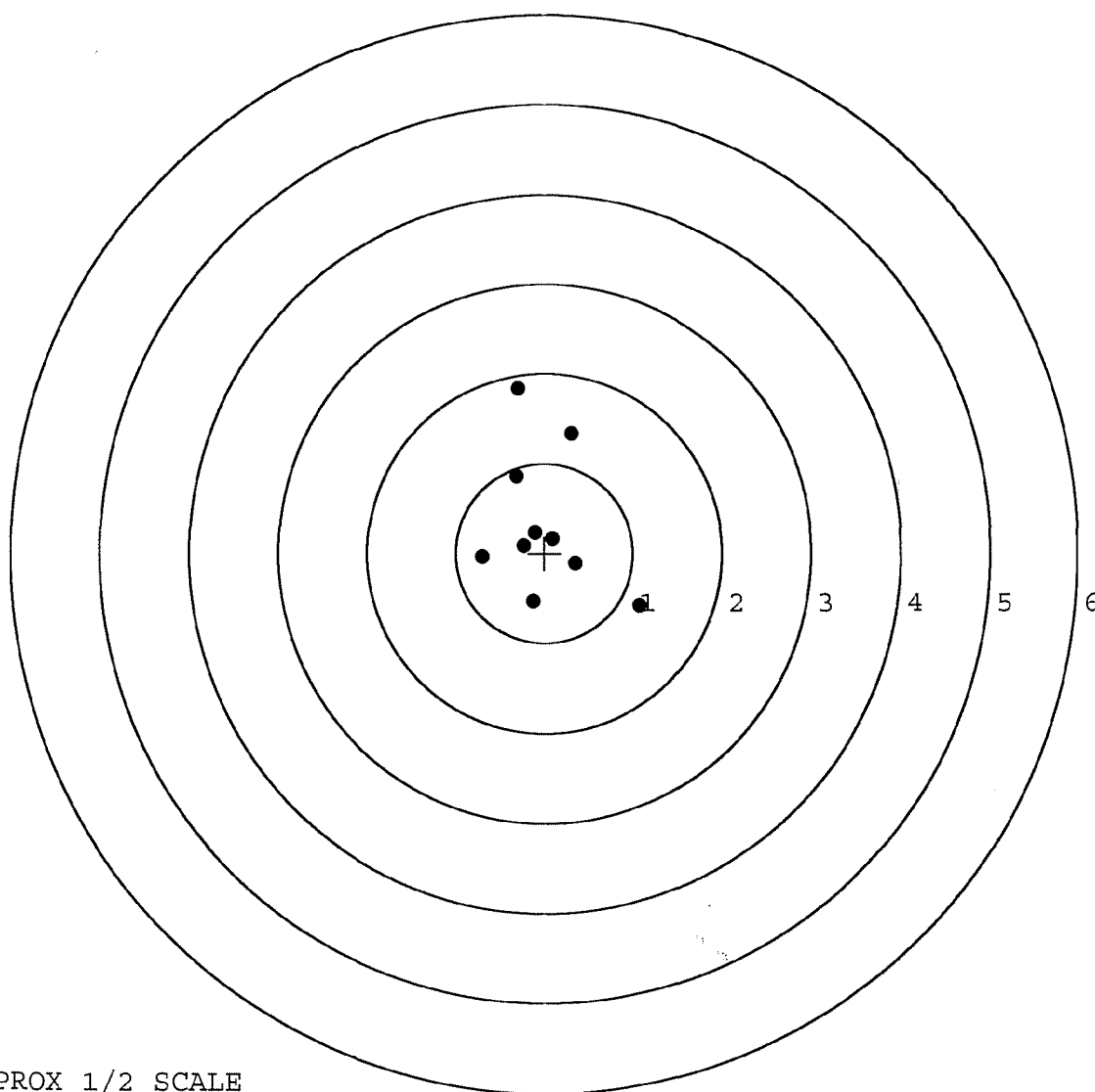


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461542. 0
TARGET NUMBER: 5
FILE DATE: 09/30/2005
FILE TIME: 15:50

X CENTROID: 0.002
Y CENTROID: 0.320
POA TO CENTROID: 0.321
HORZ SPREAD: 1.776
VERT SPREAD: 2.424
GROUP SPREAD: 2.787
MIN RADIUS: 0.143
MAX RADIUS: 1.542
MEAN RADIUS: 0.752
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.129	-0.544
2:	-0.702	-0.040
3:	-0.239	0.081
4:	-0.111	0.233
5:	0.090	0.162
6:	0.350	-0.116
7:	1.074	-0.592
8:	0.302	1.331
9:	-0.316	0.858
10:	-0.301	1.832



TARGET APPROX 1/2 SCALE