

644 1560

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



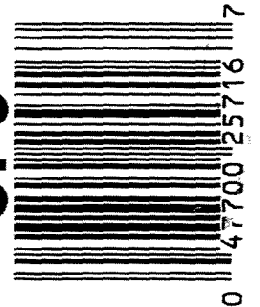
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461560

UPC



ORDER 25716

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

UPC



0 47700 25716 7

ORDER 25716

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

UPC



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SERIAL NO.



66461580

Original

6/17/2005 2:12:04 PM

4

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

78ROT01

Goff Blast Barrel & Rec Assembly,



0004012773

0540

01PC001

Flat Black Powder Coat, Barrel and



0004012763

0560

89SWS1

Reassemble Action.



0004012764

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461560

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	WJ
	(BOLT)			
560	RE-ASSEMBLE ACTION		10-6-05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-05	MTM
	D) OIL FIRING PIN ASSEMBLY		10-11-05	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>516</u> <u>516</u> <u>516</u>	10-19-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>216</u> <u>216</u> <u>216</u>	10-19-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	10-19-05	BC
	J) ASSEMBLE STOCK		10-11-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-19-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-17-05	BC
	M) IRON SIGHT ALIGNMENT		10-17-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-17-05	BC
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	10-18-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-18-05	R.P
670	FINAL INSPECTION A) HEADSPACE		10-19-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.13</u> <u>2.03</u> <u>2.33</u> <u>2.25</u> <u>2.32</u>	10-19-05	TRW
	C) FUNCTION		10-19-05	BC
690	PACK		10/21/05	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

10/4/05

TESTER

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.81	2.89		2.14	
PULL #2	2.61	2.98		2.26	
PULL #3	2.60	2.89		2.09	
PULL #4	2.94	2.90		2.33	
PULL #5	2.77	2.77		2.42	
TOTAL	13.73	14.43		11.24	
AVERAGE	2.75	2.89		2.25	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.35	3.33		
PULL #2	3.29	3.44		
PULL #3	3.50	3.56		
PULL #4	3.53	3.59		
PULL #5	3.62	3.54		
TOTAL	17.29	17.46		
AVERAGE	3.46	3.49		

	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	4.43	4.40		4.30
PULL #2	4.10	4.22		4.29
PULL #3	4.52	4.55		4.30
PULL #4	4.31	4.46		4.54
PULL #5	4.67	4.18		4.61
TOTAL	22.03	21.81		22.04
AVERAGE	4.41	4.36		4.41

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461560.__0
FILE DATE AND TIME: 10/18/2005 09:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.095
The Average Y Centroid of the Five Target Set:	-0.152
The Average Point of Impact of the Five Target Set:	0.179
The Average Mean Radius of the Five Target Set:	0.929
The Distance from POA to Centroid Target #1:	0.403
The Distance from Centroid Target #2 to Centroid Target #1:	0.049
The Distance from Centroid Target #3 to Centroid Target #1:	0.286
The Distance from Centroid Target #4 to Centroid Target #1:	0.601
The Distance from Centroid Target #5 to Centroid Target #1:	0.321

SERIAL NUMBER: G6461560. __ 0

TARGET NUMBER: 1

FILE DATE: 10/18/2005

FILE TIME: 09:42

X CENTROID: 0.059

Y CENTROID: -0.399

POA TO CENTROID: 0.403

HORZ SPREAD: 1.825

VERT SPREAD: 3.227

GROUP SPREAD: 3.301

MIN RADIUS: 0.300

MAX RADIUS: 2.245

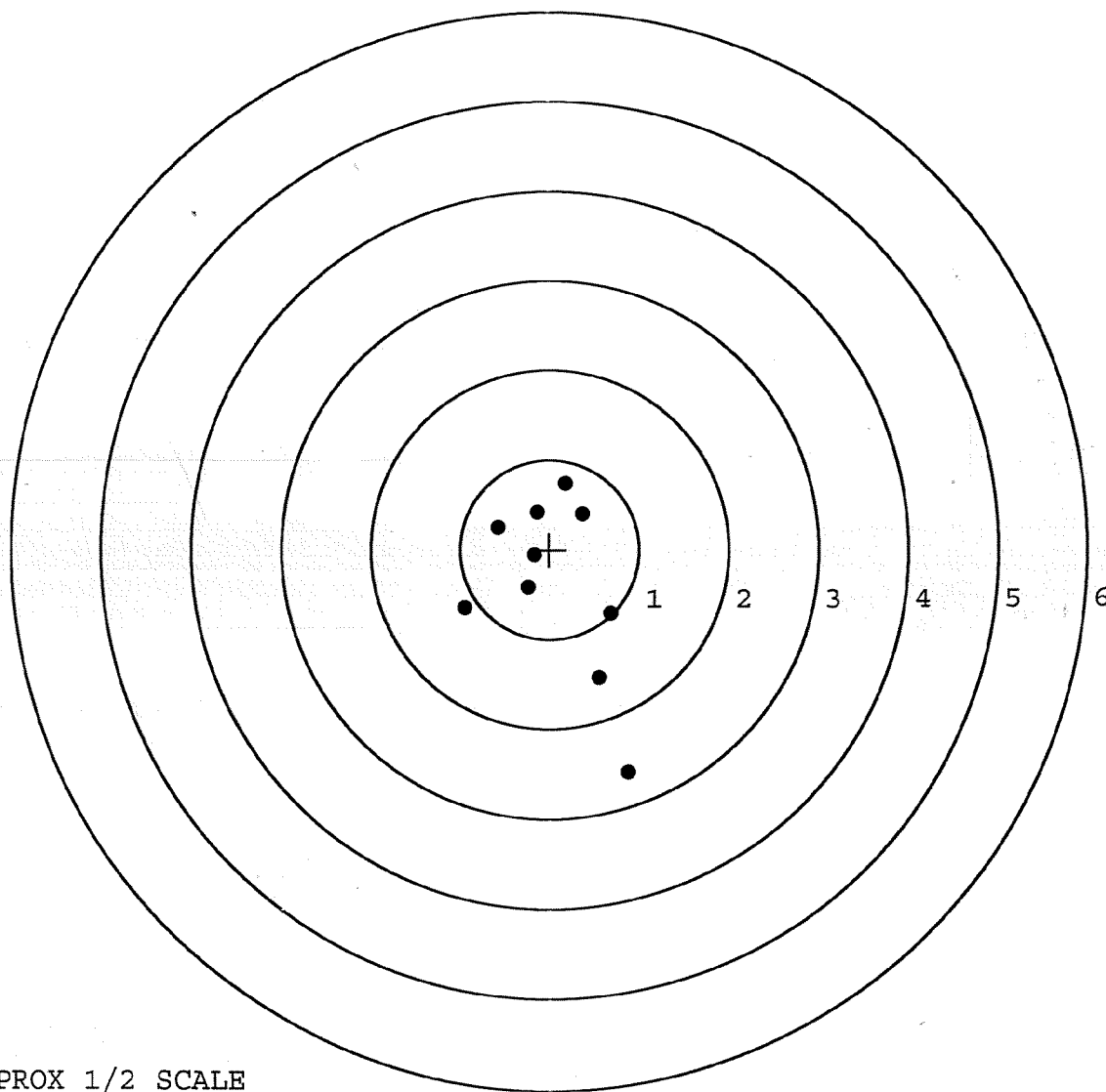
MEAN RADIUS: 0.958

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.878	-2.489
2:	0.553	-1.439
3:	0.685	-0.720
4:	-0.947	-0.652
5:	-0.240	-0.422
6:	-0.170	-0.063
7:	-0.574	0.249
8:	0.368	0.395
9:	0.181	0.738
10:	-0.139	0.416

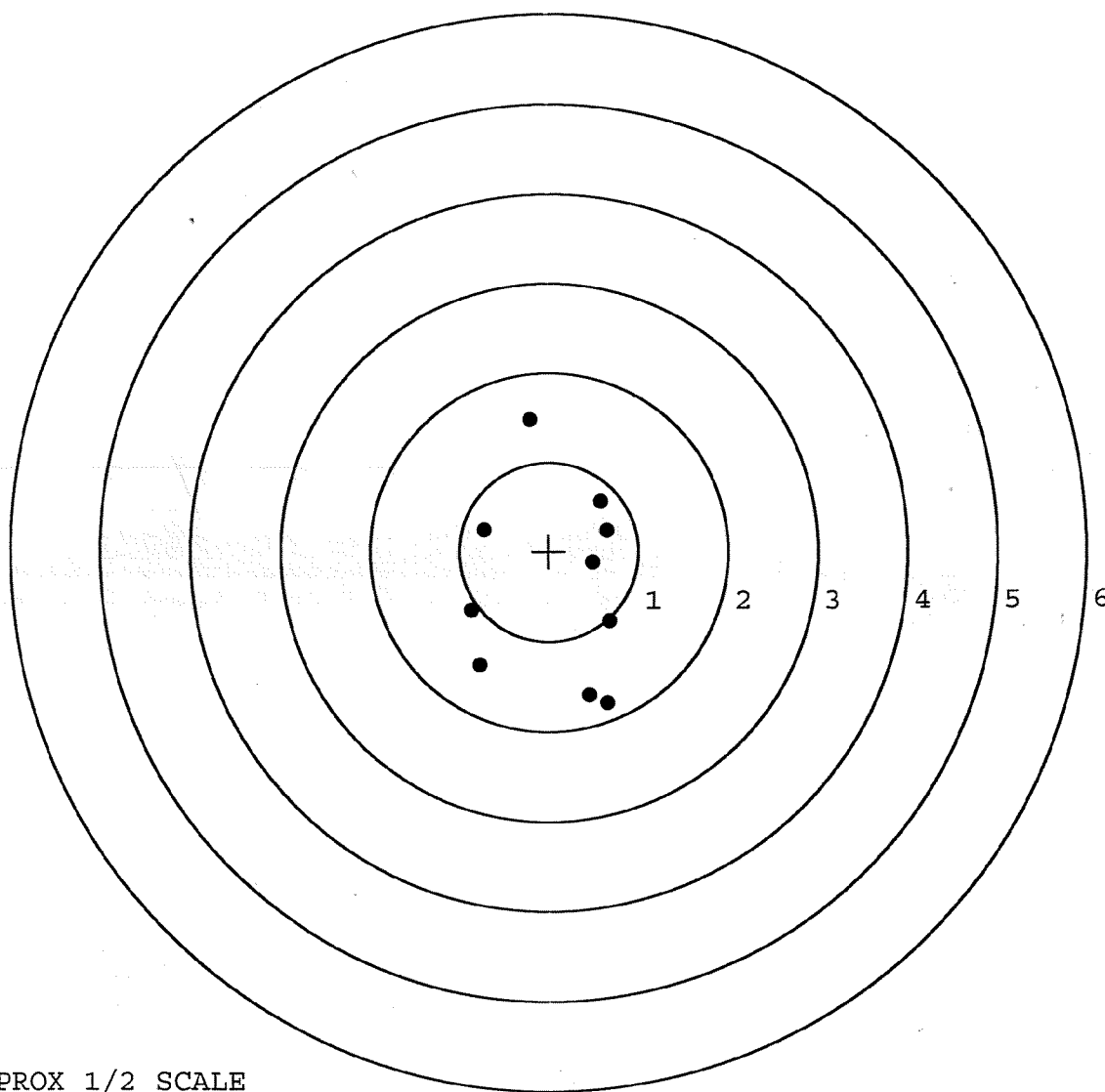


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461560. __0
TARGET NUMBER: 2
FILE DATE: 10/18/2005
FILE TIME: 09:42

X CENTROID: 0.093
Y CENTROID: -0.362
POA TO CENTROID: 0.374
HORZ SPREAD: 1.545
VERT SPREAD: 3.166
GROUP SPREAD: 3.282
MIN RADIUS: 0.459
MAX RADIUS: 1.863
MEAN RADIUS: 1.090
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.653	-1.691
2:	0.452	-1.601
3:	-0.774	-1.263
4:	-0.868	-0.654
5:	0.677	-0.784
6:	0.490	-0.133
7:	0.653	0.228
8:	0.582	0.557
9:	-0.724	0.242
10:	-0.213	1.475

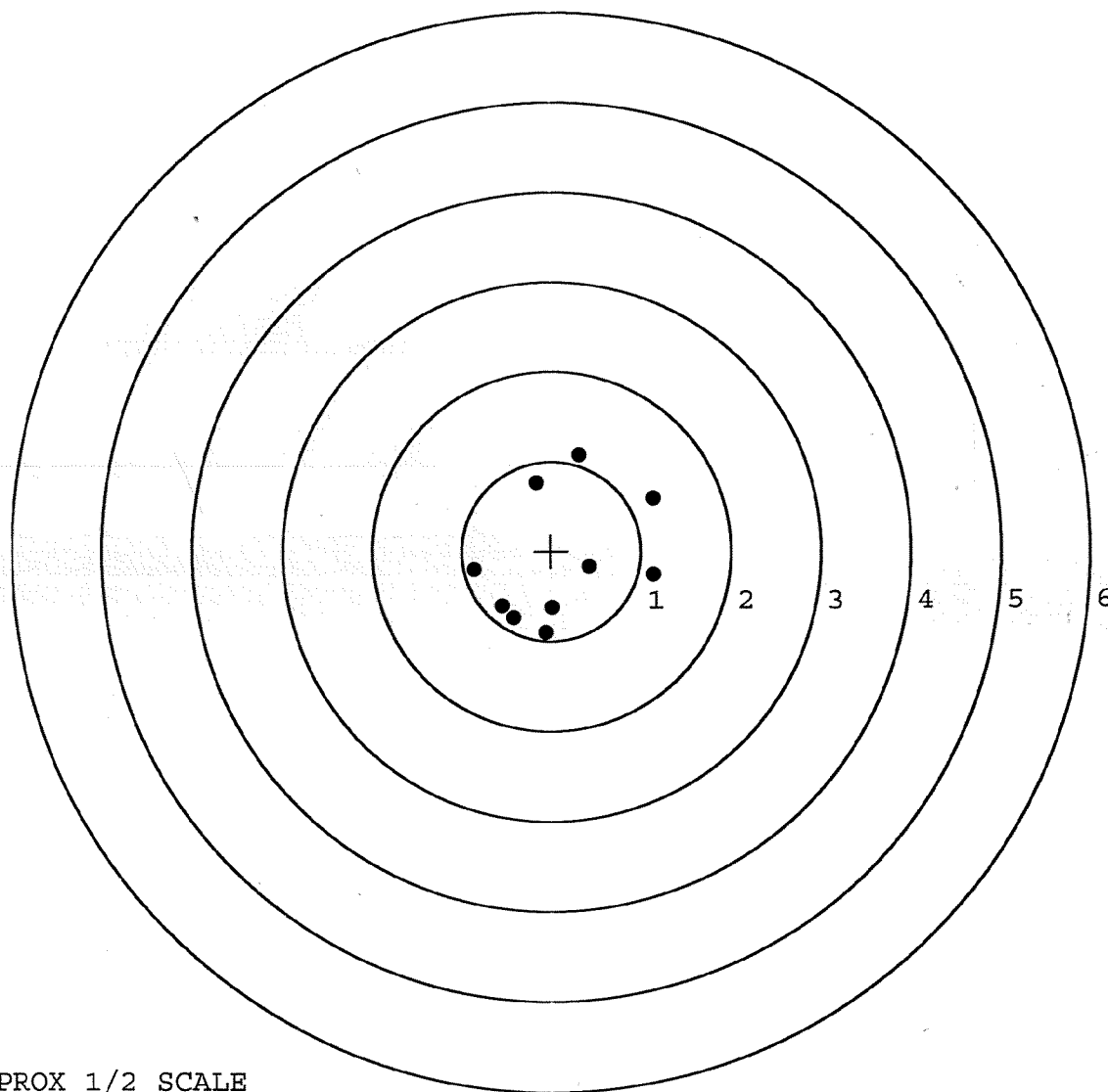


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461560. __0
TARGET NUMBER: 3
FILE DATE: 10/18/2005
FILE TIME: 09:42

X CENTROID: 0.097
Y CENTROID: -0.115
POA TO CENTROID: 0.150
HORZ SPREAD: 1.999
VERT SPREAD: 1.987
GROUP SPREAD: 2.154
MIN RADIUS: 0.331
MAX RADIUS: 1.258
MEAN RADIUS: 0.871
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.138	-0.267
2:	0.422	-0.175
3:	1.138	0.591
4:	0.315	1.071
5:	-0.165	0.762
6:	-0.861	-0.212
7:	0.020	-0.639
8:	-0.065	-0.916
9:	-0.422	-0.748
10:	-0.552	-0.616

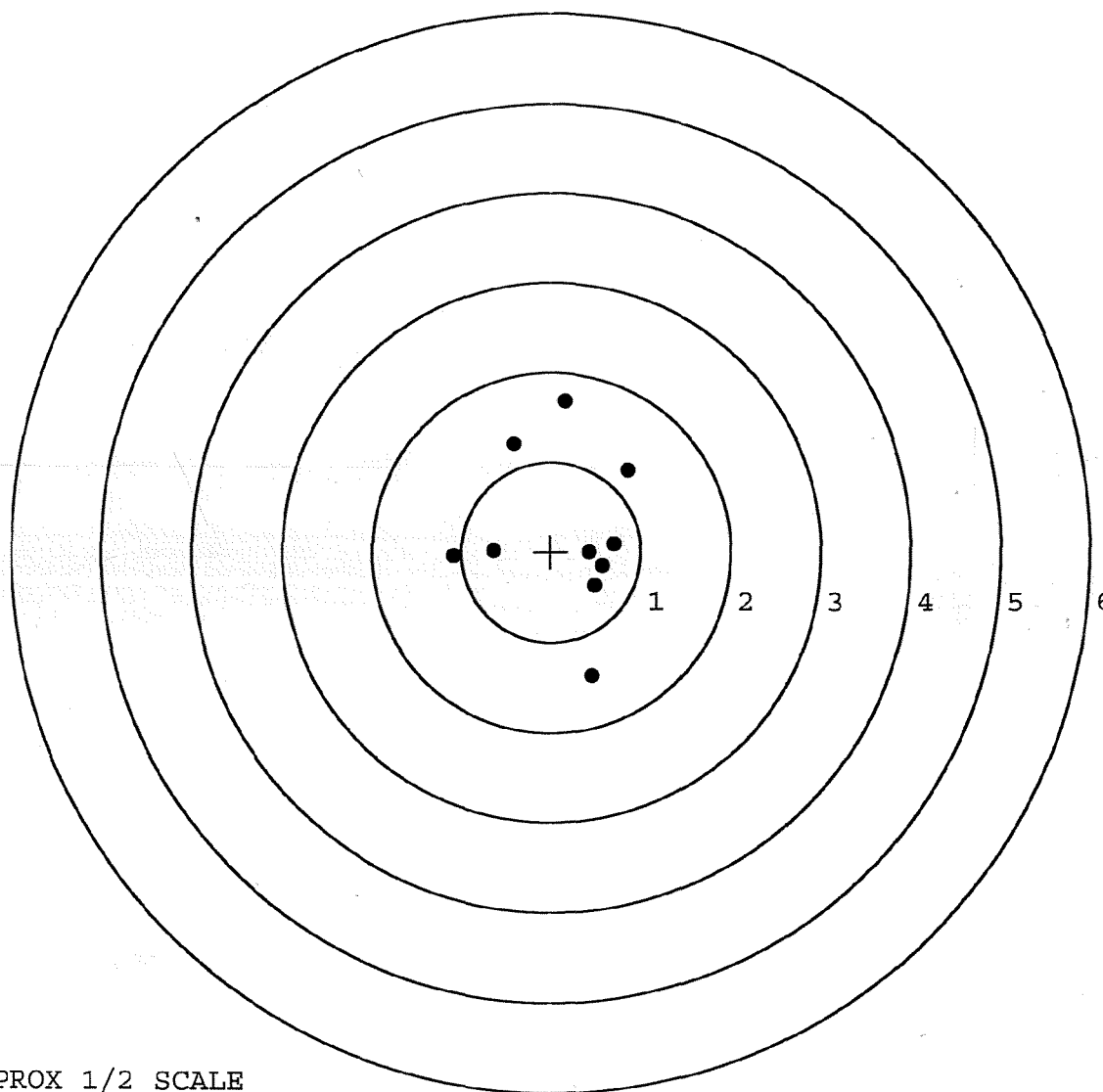


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461560. 0
TARGET NUMBER: 4
FILE DATE: 10/18/2005
FILE TIME: 09:42

X CENTROID: 0.155
Y CENTROID: 0.194
POA TO CENTROID: 0.249
HORZ SPREAD: 1.936
VERT SPREAD: 3.048
GROUP SPREAD: 3.063
MIN RADIUS: 0.341
MAX RADIUS: 1.595
MEAN RADIUS: 0.941
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.465	-1.370
2:	-0.638	0.020
3:	-1.082	-0.051
4:	0.854	0.913
5:	-0.411	1.201
6:	0.164	1.678
7:	0.433	-0.002
8:	0.696	0.089
9:	0.490	-0.378
10:	0.578	-0.155

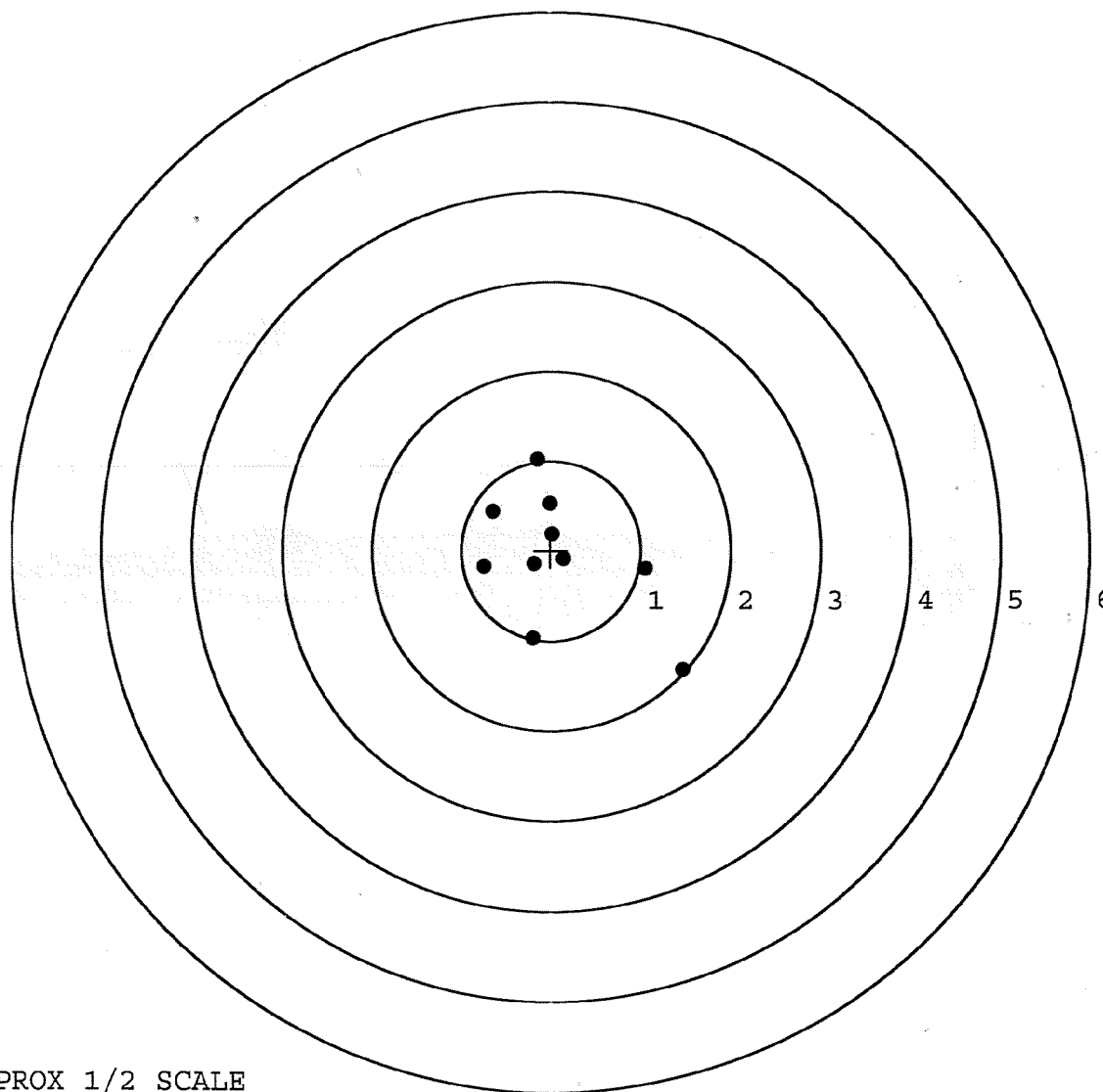


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461560. __0
TARGET NUMBER: 5
FILE DATE: 10/18/2005
FILE TIME: 09:42

X CENTROID: 0.072
Y CENTROID: -0.078
POA TO CENTROID: 0.106
HORZ SPREAD: 2.208
VERT SPREAD: 2.344
GROUP SPREAD: 2.844
MIN RADIUS: 0.073
MAX RADIUS: 1.869
MEAN RADIUS: 0.784
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.460	-1.329
2:	-0.206	-0.977
3:	1.050	-0.206
4:	-0.150	1.015
5:	-0.007	0.523
6:	-0.648	0.439
7:	-0.748	-0.174
8:	0.143	-0.095
9:	-0.189	-0.153
10:	0.017	0.182



TARGET APPROX 1/2 SCALE