

G-646 1566

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

proof of purchase



owner registration sticker



DD FORM

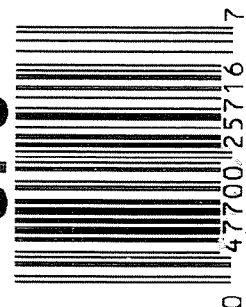
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461566

UPC



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



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



SERIAL NO.



6/17/2005 2:12:04 PM

Ctrl

29

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 # 66461566

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTL
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTL
470	DIS-ASSEMBLE ACTION	INSPECTED	9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 SEP 20 11:11 AM 2005	9/8/05	unus
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	unus
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/22/05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/22/05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/22/05	RA
	D) OIL FIRING PIN ASSEMBLY		9-27-05	RTL
	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>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	10-3-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-3-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	10-3-05	Ac
	J) ASSEMBLE STOCK		9-22-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-3-05	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	PASS FAIL PASS FAIL	9-29-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-29-05	TRW
670	FINAL INSPECTION A) HEADSPACE		10-3-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.67</u> <u>2.59</u> <u>2.59</u> <u>2.57</u>	10-3-05	RG
	C) FUNCTION		10-3-05	Ac
690	PACK		10-7-05	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

TESTER

9/22/05

RG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.20	2.45	2.40	
PULL #2	2.51	2.80	2.71	
PULL #3	2.84	2.68	2.30	
PULL #4	2.63	2.72	2.82	
PULL #5	2.85	2.77	2.67	
TOTAL	13.03	13.42	12.90	
AVERAGE	2.61	2.68	2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.27	3.36	
PULL #2	3.14	3.64	
PULL #3	2.46	3.20	
PULL #4	3.41	3.52	
PULL #5	3.48	3.27	
TOTAL	15.76	16.99	
AVERAGE	3.15	3.40	

	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	4.32	4.08		4.04
PULL #2	4.35	4.76		4.02
PULL #3	4.32	3.85		3.99
PULL #4	4.02	4.32		3.93
PULL #5	4.24	4.74		4.12
TOTAL	21.25	21.75		20.10
AVERAGE	4.25	4.35		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461566.___0
FILE DATE AND TIME: 09/29/2005 11:06

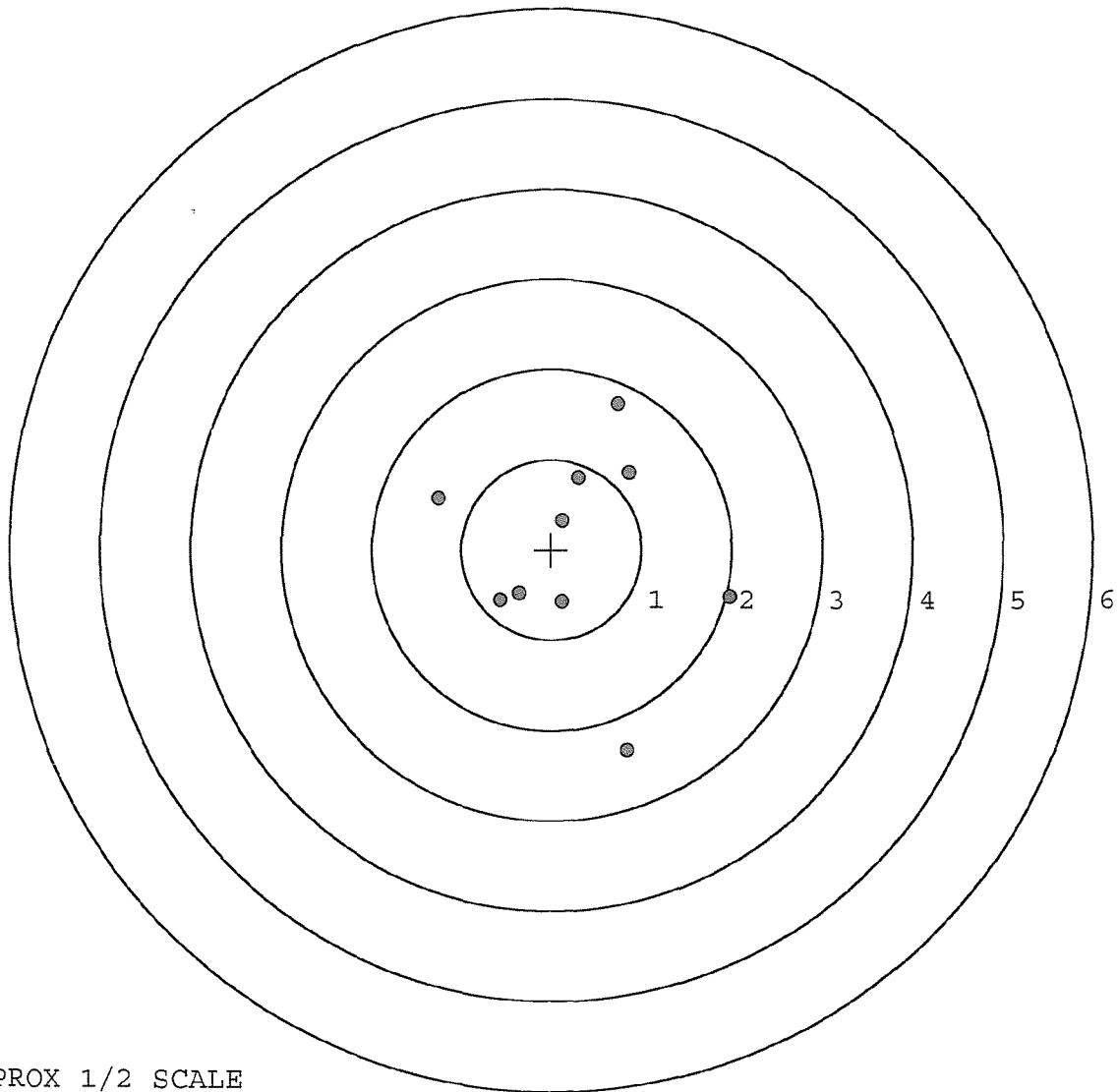
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.123
The Average Y Centroid of the Five Target Set:	-0.184
The Average Point of Impact of the Five Target Set:	0.221
The Average Mean Radius of the Five Target Set:	0.992
The Distance from POA to Centroid Target #1:	0.280
The Distance from Centroid Target #2 to Centroid Target #1:	0.471
The Distance from Centroid Target #3 to Centroid Target #1:	0.434
The Distance from Centroid Target #4 to Centroid Target #1:	0.349
The Distance from Centroid Target #5 to Centroid Target #1:	0.148

SERIAL NUMBER: G6461566.___0
TARGET NUMBER: 1
FILE DATE: 09/29/2005
FILE TIME: 11:06

X CENTROID: 0.279
Y CENTROID: -0.023
POA TO CENTROID: 0.280
HORZ SPREAD: 3.238
VERT SPREAD: 3.838
GROUP SPREAD: 3.840
MIN RADIUS: 0.376
MAX RADIUS: 2.271
MEAN RADIUS: 1.203
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.843	-2.223
2:	1.978	-0.526
3:	0.864	0.857
4:	0.735	1.615
5:	0.305	0.801
6:	0.126	0.321
7:	0.124	-0.585
8:	-0.356	-0.493
9:	-0.573	-0.564
10:	-1.260	0.568

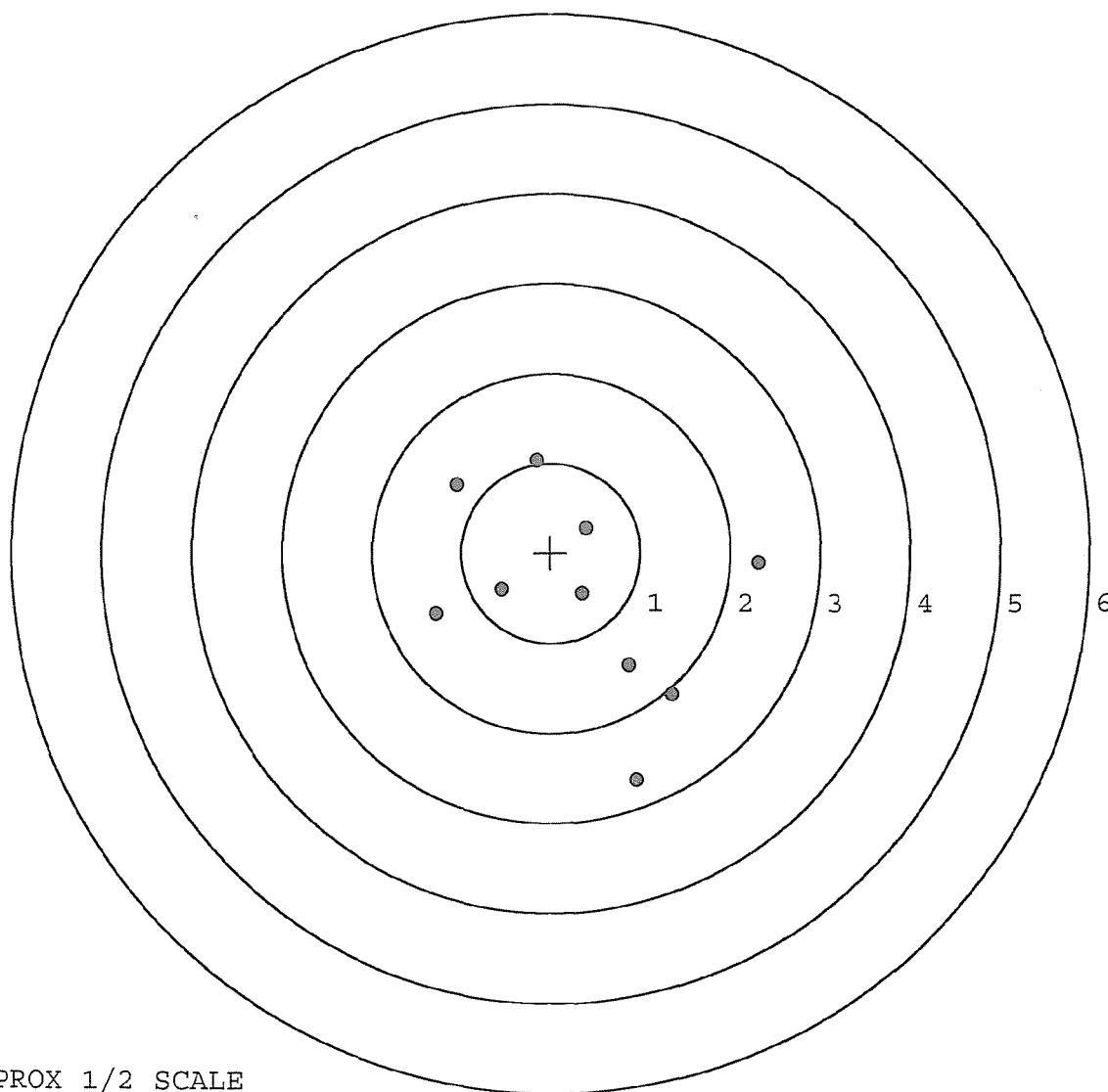


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461566. __0
TARGET NUMBER: 2
FILE DATE: 09/29/2005
FILE TIME: 11:06

X CENTROID: 0.319
Y CENTROID: -0.492
POA TO CENTROID: 0.587
HORZ SPREAD: 3.593
VERT SPREAD: 3.558
GROUP SPREAD: 3.850
MIN RADIUS: 0.052
MAX RADIUS: 2.132
MEAN RADIUS: 1.335
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	0.961	-2.525
2:	1.350	-1.567
3:	0.878	-1.244
4:	2.308	-0.107
5:	0.353	-0.452
6:	0.388	0.275
7:	-0.547	-0.408
8:	-1.285	-0.683
9:	-1.053	0.756
10:	-0.159	1.033

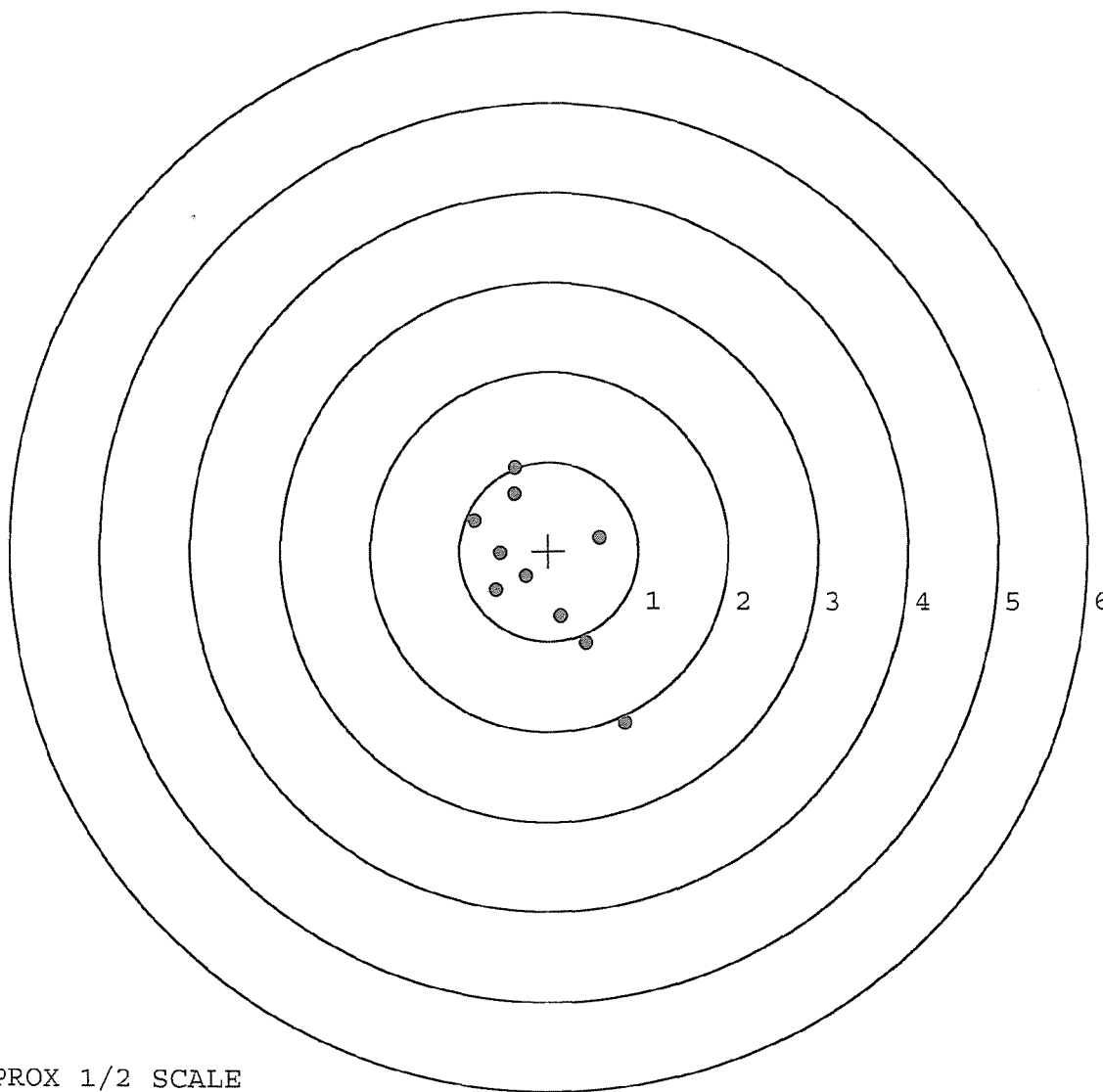


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461566. __0
TARGET NUMBER: 3
FILE DATE: 09/29/2005
FILE TIME: 11:06

X CENTROID: -0.103
Y CENTROID: -0.231
POA TO CENTROID: 0.253
HORZ SPREAD: 1.696
VERT SPREAD: 2.841
GROUP SPREAD: 3.100
MIN RADIUS: 0.165
MAX RADIUS: 1.927
MEAN RADIUS: 0.844
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.858	-1.901
2:	0.418	-1.025
3:	0.137	-0.728
4:	-0.260	-0.281
5:	-0.590	-0.436
6:	-0.543	-0.020
7:	-0.838	0.342
8:	0.564	0.154
9:	-0.391	0.644
10:	-0.382	0.940

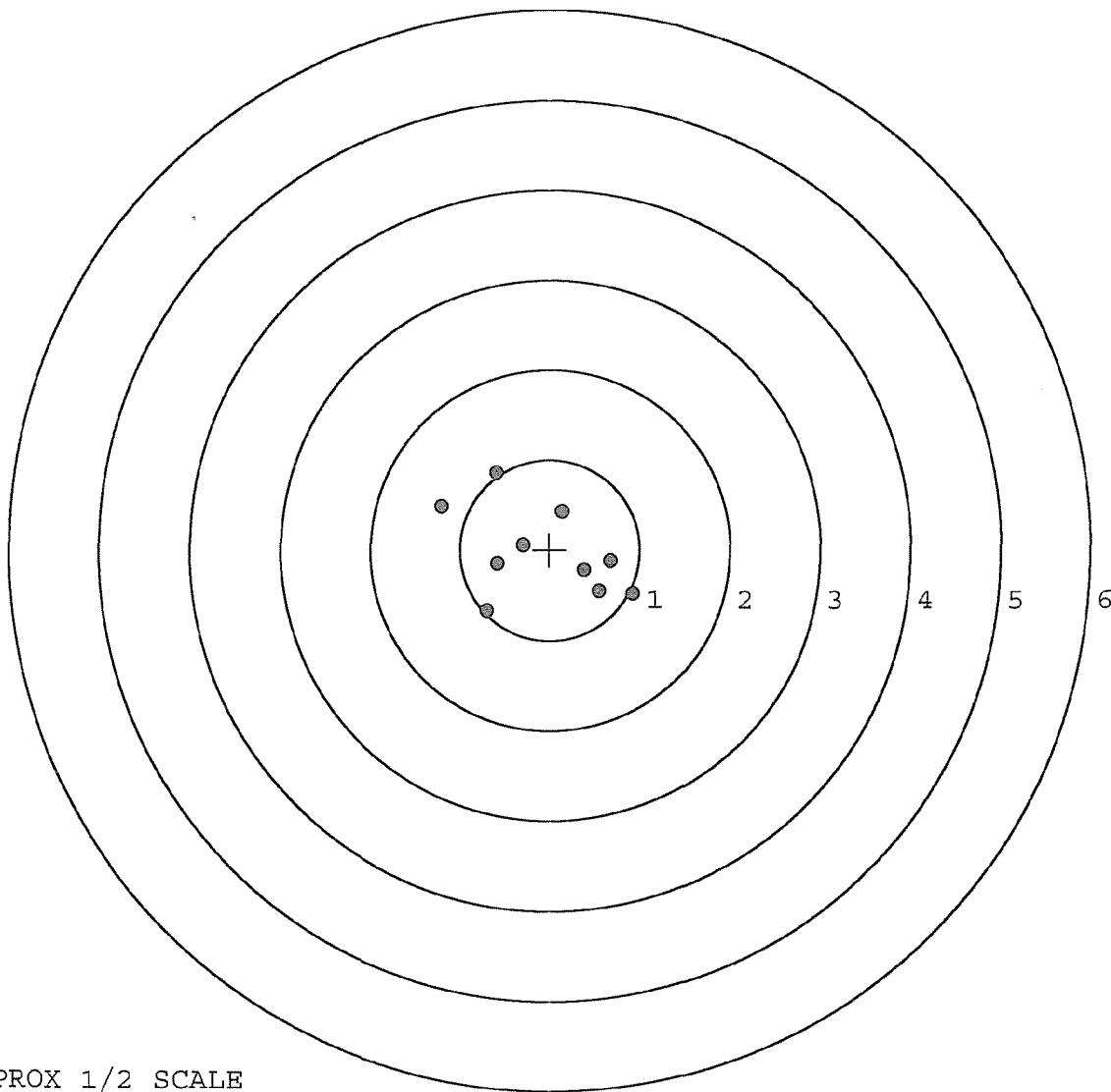


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461566. __0
TARGET NUMBER: 4
FILE DATE: 09/29/2005
FILE TIME: 11:06

X CENTROID: -0.070
Y CENTROID: -0.033
POA TO CENTROID: 0.077
HORZ SPREAD: 2.130
VERT SPREAD: 1.535
GROUP SPREAD: 2.342
MIN RADIUS: 0.243
MAX RADIUS: 1.250
MEAN RADIUS: 0.755
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.921	-0.490
2:	0.551	-0.461
3:	0.677	-0.128
4:	0.384	-0.227
5:	0.140	0.426
6:	-0.298	0.053
7:	-0.580	-0.159
8:	-0.700	-0.679
9:	-1.209	0.483
10:	-0.587	0.856

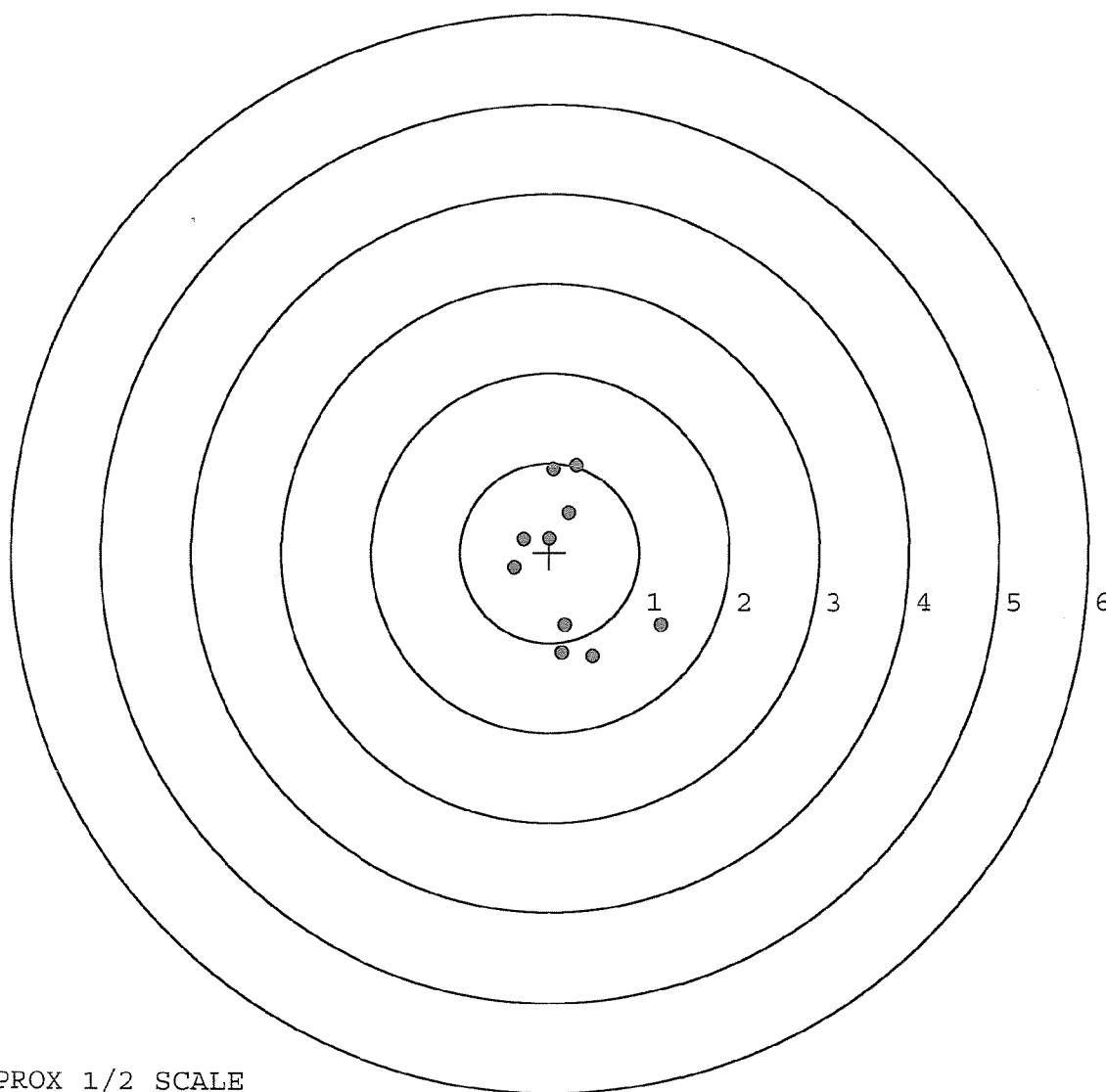


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461566. __0
TARGET NUMBER: 5
FILE DATE: 09/29/2005
FILE TIME: 11:06

POINT#	X	Y
1:	1.240	-0.808
2:	0.477	-1.155
3:	0.135	-1.117
4:	0.167	-0.808
5:	-0.397	-0.167
6:	-0.296	0.147
7:	0.002	0.160
8:	0.211	0.444
9:	0.050	0.927
10:	0.301	0.972

X CENTROID: 0.189
Y CENTROID: -0.141
POA TO CENTROID: 0.236
HORZ SPREAD: 1.637
VERT SPREAD: 2.127
GROUP SPREAD: 2.104
MIN RADIUS: 0.354
MAX RADIUS: 1.245
MEAN RADIUS: 0.823
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE