

G-646 1591

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



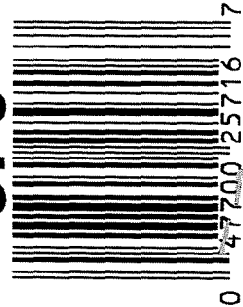
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461591

UPC



DD FORM

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

UPC



0 47700 25716 7

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

UPC



0 47700 25716 7

SERIAL NO.



66461591

6/17/2005 2:12:04 PM

Crib

82

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 # G60461591

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	MAGNA-FLUX INSPECTED	9-6-05	RTL
470	DIS-ASSEMBLE ACTION	SEP 08 2005	9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 OPERATOR <u>unib</u>	9/8/05	unib
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	unib
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(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	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>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	PASS FAIL PASS FAIL	9-29-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-29-05	SH
670	FINAL INSPECTION A) HEADSPACE		10-6-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.63</u> <u>2.78</u> <u>2.84</u> <u>2.84</u>	10-3-05	BC
	C) FUNCTION		10-6-05	Ac
690	PACK		10-8-05	DM

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

9/22/05

TESTER

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.64		2.60	
PULL #2	2.10	2.65		2.69	
PULL #3	2.79	2.60		2.79	
PULL #4	2.69	2.74		2.75	
PULL #5	2.74	2.67		2.81	
TOTAL	12.82	13.30		13.64	
AVERAGE	2.56	2.66		2.73	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	2.56		
PULL #2	3.11	3.13		
PULL #3	3.01	3.31		
PULL #4	3.30	3.36		
PULL #5	3.35	3.34		
TOTAL	16.05	15.70		
AVERAGE	3.21	3.14		

	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	4.45		4.30
PULL #2	3.71	4.49		4.26
PULL #3	4.30	4.68		4.27
PULL #4	4.32	4.72		4.39
PULL #5	4.40	4.45		4.16
TOTAL	20.86	22.79		21.38
AVERAGE	4.17	4.56		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461591.__0
FILE DATE AND TIME: 09/29/2005 11:16

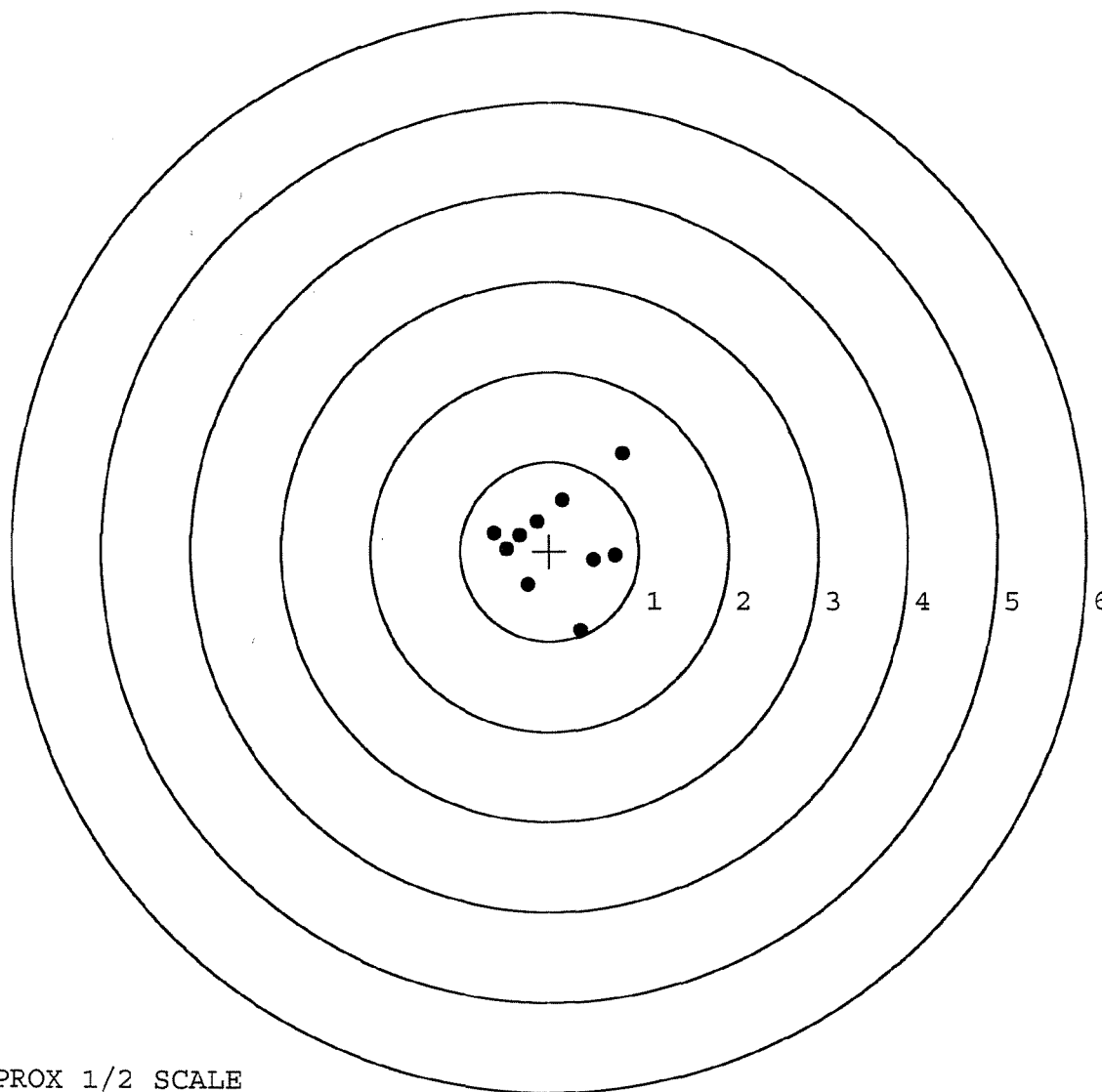
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.012
The Average Y Centroid of the Five Target Set:	0.059
The Average Point of Impact of the Five Target Set:	0.060
The Average Mean Radius of the Five Target Set:	0.882
The Distance from POA to Centroid Target #1:	0.122
The Distance from Centroid Target #2 to Centroid Target #1:	0.171
The Distance from Centroid Target #3 to Centroid Target #1:	0.192
The Distance from Centroid Target #4 to Centroid Target #1:	0.465
The Distance from Centroid Target #5 to Centroid Target #1:	0.324

SERIAL NUMBER: G6461591. __0
TARGET NUMBER: 1
FILE DATE: 09/29/2005
FILE TIME: 11:16

X CENTROID: 0.070
Y CENTROID: 0.100
POA TO CENTROID: 0.122
HORZ SPREAD: 1.450
VERT SPREAD: 1.982
GROUP SPREAD: 2.037
MIN RADIUS: 0.315
MAX RADIUS: 1.247
MEAN RADIUS: 0.647
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.817	1.098
2:	0.738	-0.049
3:	0.495	-0.096
4:	0.348	-0.884
5:	-0.243	-0.378
6:	-0.481	0.023
7:	-0.633	0.206
8:	-0.143	0.333
9:	0.141	0.573
10:	-0.343	0.177



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461591. __0

TARGET NUMBER: 2

FILE DATE: 09/29/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.951	-1.257
2:	0.392	-0.614
3:	0.502	0.109
4:	-0.198	-0.397
5:	-0.337	-0.601
6:	-0.528	-0.712
7:	-0.959	-0.144
8:	0.257	1.033
9:	-0.573	2.025
10:	-0.254	2.482

X CENTROID: -0.075

Y CENTROID: 0.192

POA TO CENTROID: 0.206

HORZ SPREAD: 1.910

VERT SPREAD: 3.739

GROUP SPREAD: 3.928

MIN RADIUS: 0.583

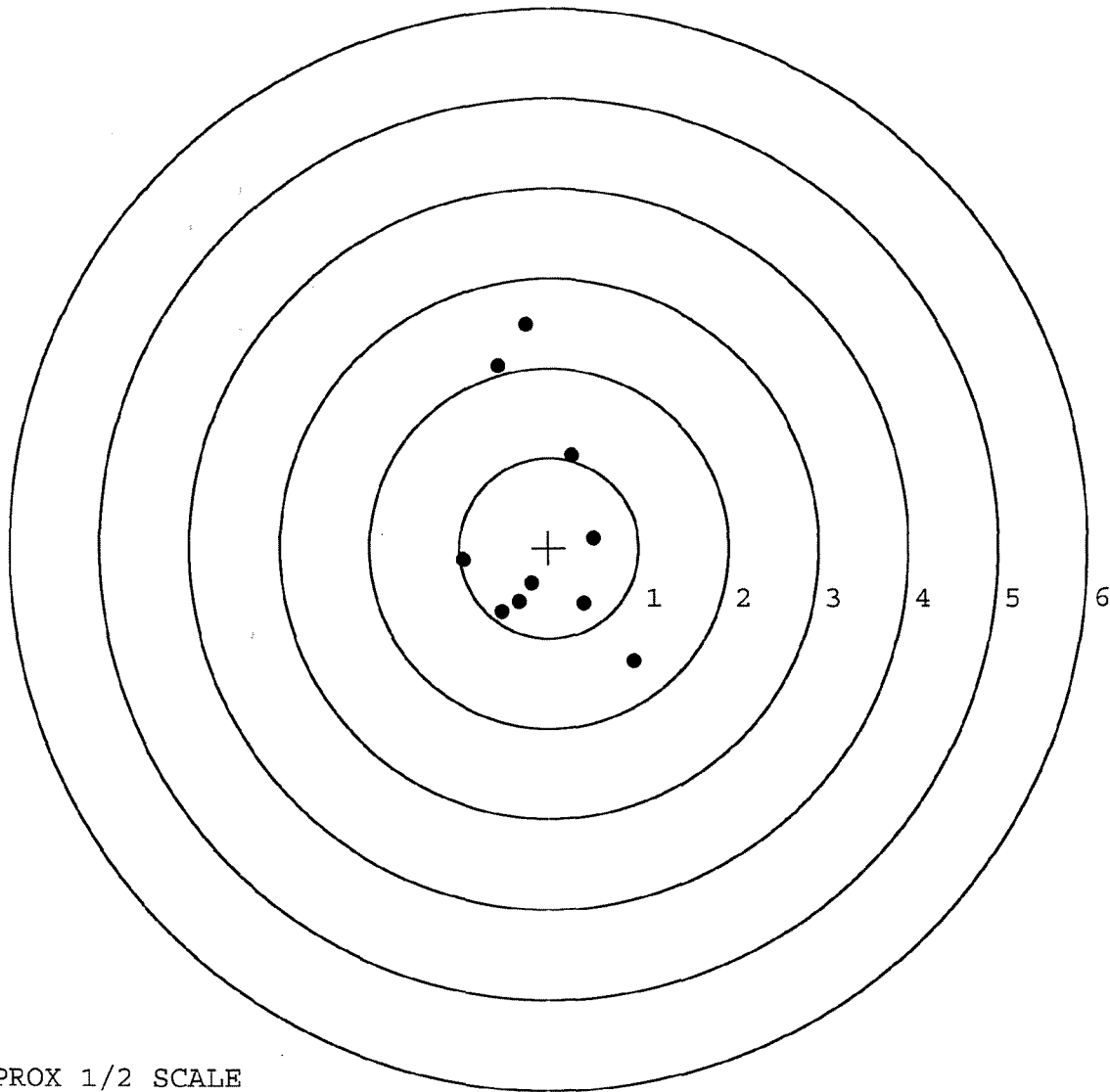
MAX RADIUS: 2.297

MEAN RADIUS: 1.179

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461591. __0

TARGET NUMBER: 3

FILE DATE: 09/29/2005

FILE TIME: 11:16

X CENTROID: -0.010

Y CENTROID: 0.275

POA TO CENTROID: 0.275

HORZ SPREAD: 2.778

VERT SPREAD: 1.989

GROUP SPREAD: 2.816

MIN RADIUS: 0.350

MAX RADIUS: 1.663

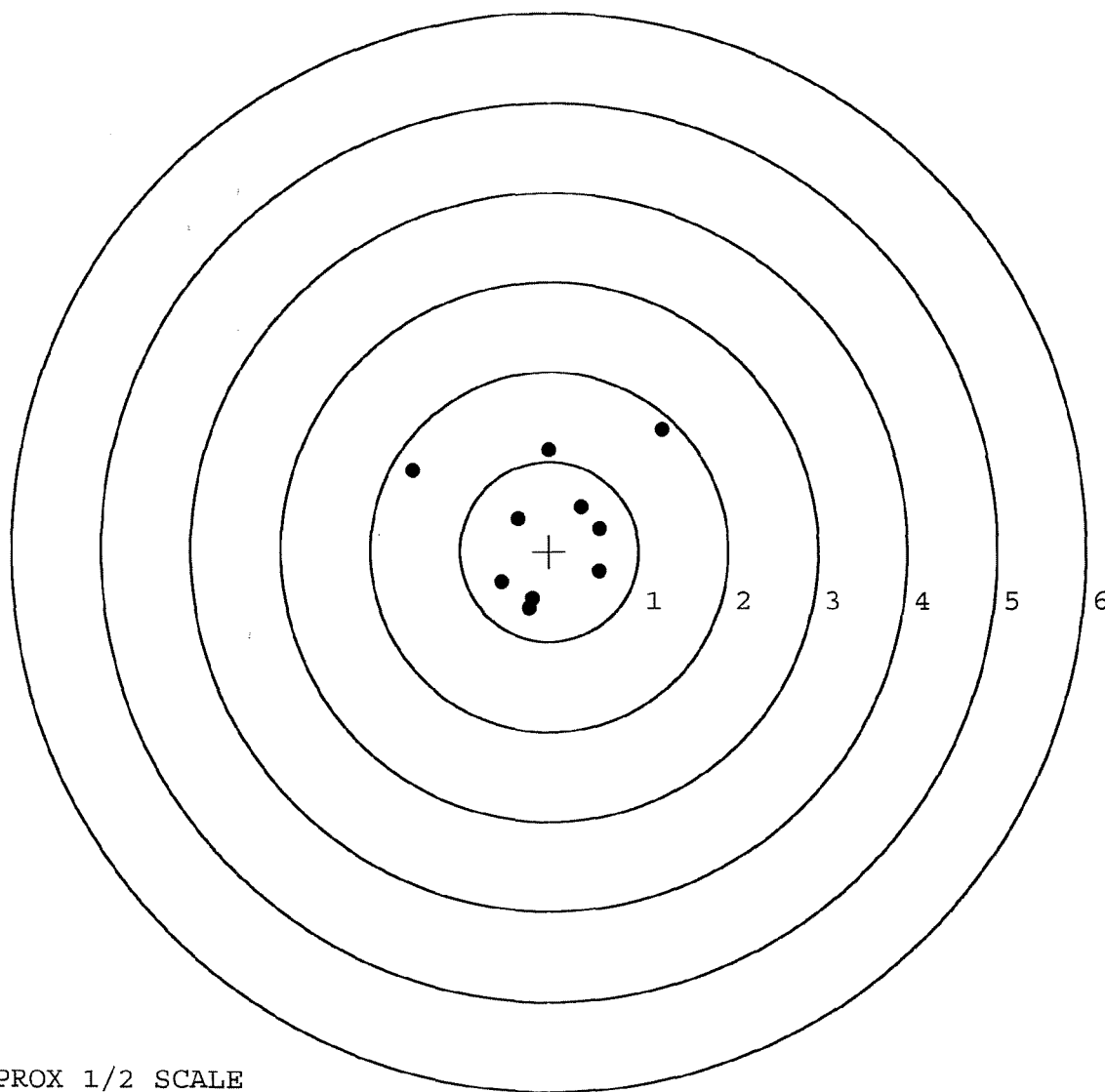
MEAN RADIUS: 0.884

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.256	1.354
2:	-0.013	1.129
3:	0.355	0.488
4:	0.565	0.255
5:	0.566	-0.225
6:	-0.347	0.366
7:	-0.189	-0.531
8:	-0.233	-0.635
9:	-0.534	-0.347
10:	-1.522	0.894



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461591. __0

TARGET NUMBER: 4

FILE DATE: 09/29/2005

FILE TIME: 11:16

X CENTROID: 0.319

Y CENTROID: -0.292

POA TO CENTROID: 0.432

HORZ SPREAD: 2.107

VERT SPREAD: 1.862

GROUP SPREAD: 2.514

MIN RADIUS: 0.511

MAX RADIUS: 1.473

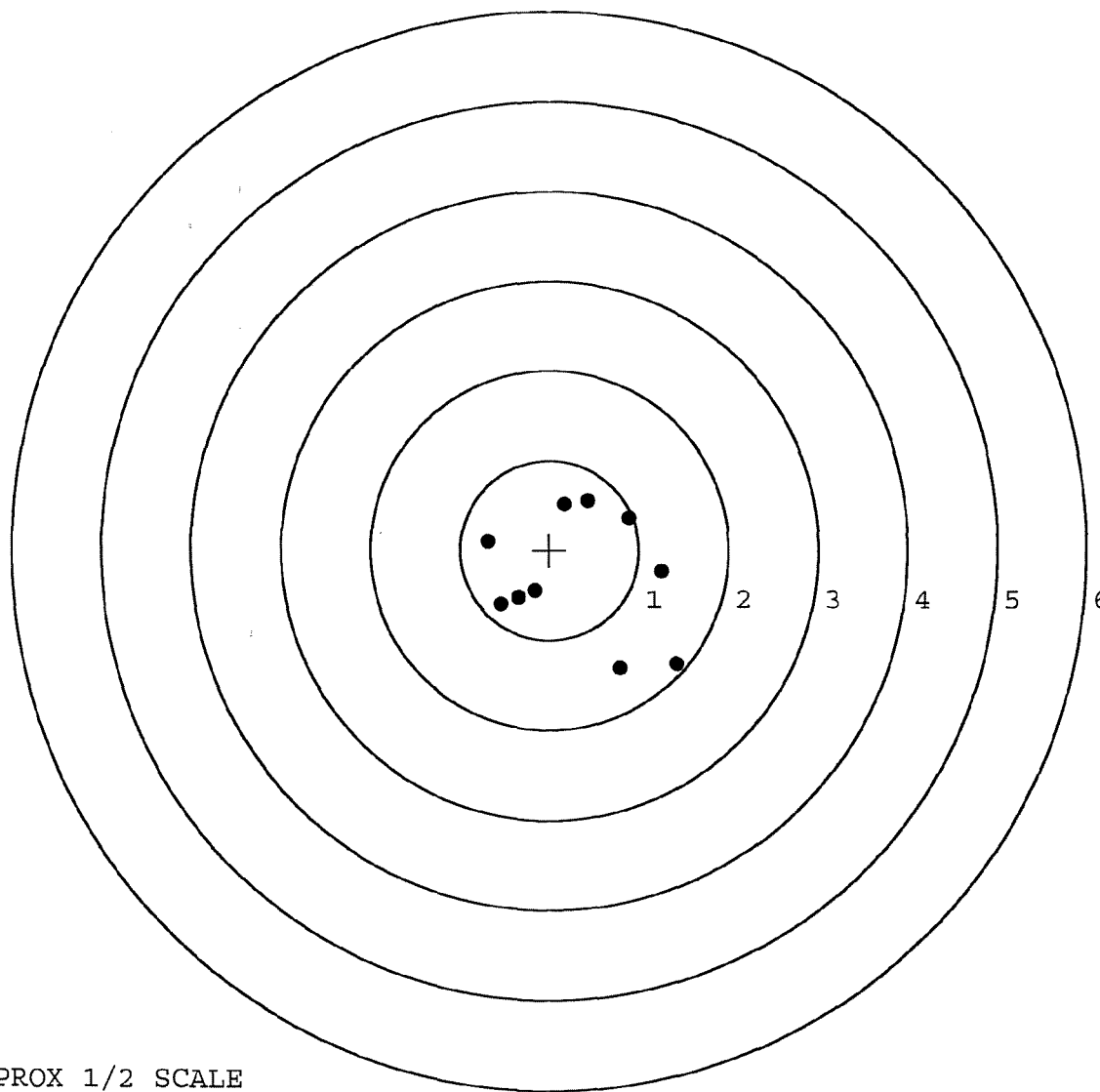
MEAN RADIUS: 0.928

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.788	-1.314
2:	1.418	-1.272
3:	1.249	-0.246
4:	0.887	0.355
5:	0.432	0.548
6:	0.168	0.509
7:	-0.165	-0.455
8:	-0.547	-0.613
9:	-0.352	-0.528
10:	-0.689	0.099



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461591. 0

TARGET NUMBER: 5

FILE DATE: 09/29/2005

FILE TIME: 11:16

X CENTROID: -0.243

Y CENTROID: 0.018

POA TO CENTROID: 0.244

HORZ SPREAD: 1.711

VERT SPREAD: 1.802

GROUP SPREAD: 2.414

MIN RADIUS: 0.439

MAX RADIUS: 1.229

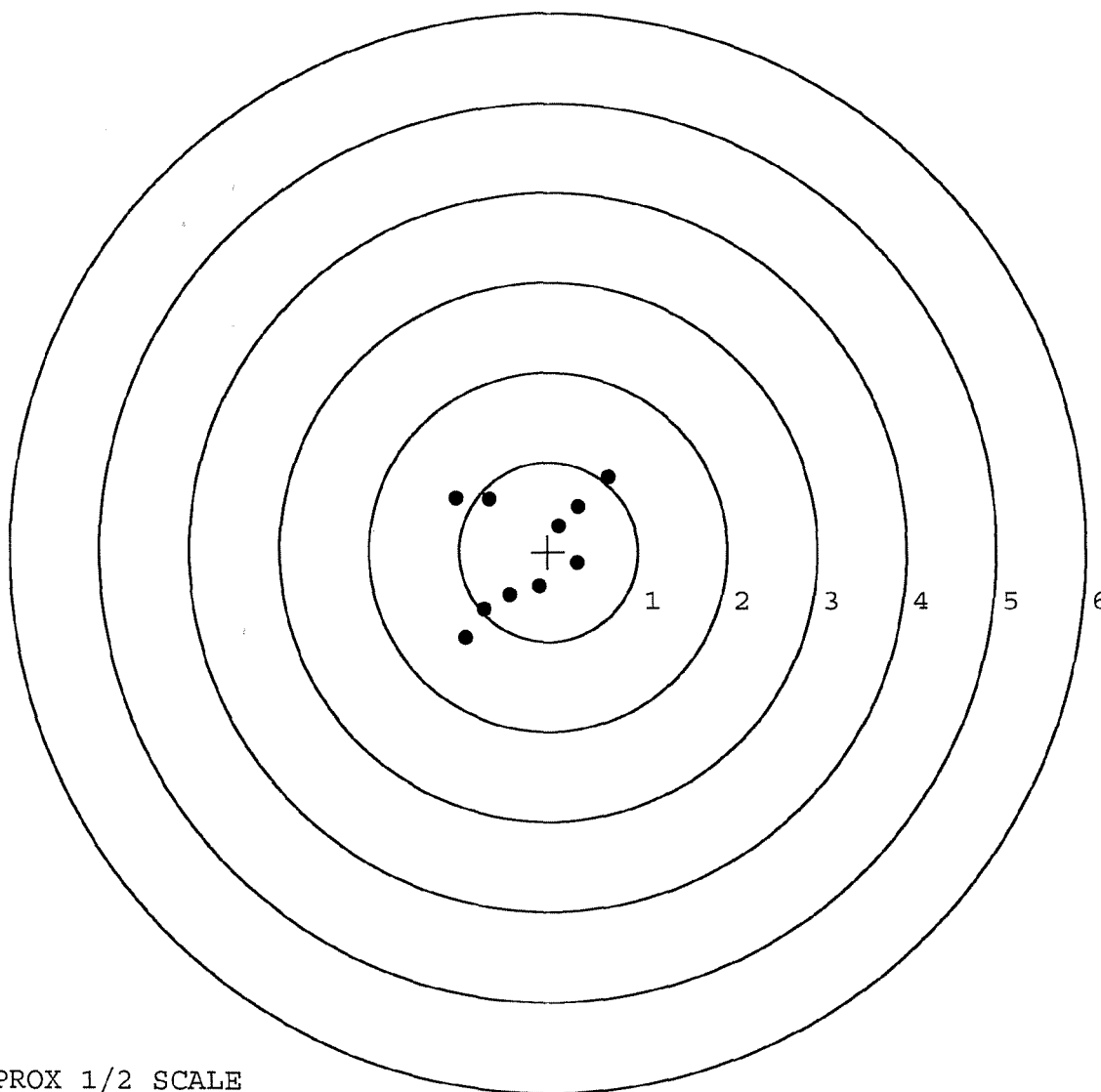
MEAN RADIUS: 0.770

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.675	0.834
2:	0.332	0.502
3:	0.114	0.288
4:	0.323	-0.127
5:	-0.101	-0.398
6:	-0.428	-0.488
7:	-0.714	-0.651
8:	-0.931	-0.968
9:	-0.666	0.590
10:	-1.036	0.594



TARGET APPROX 1/2 SCALE