

G-646 1592

**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



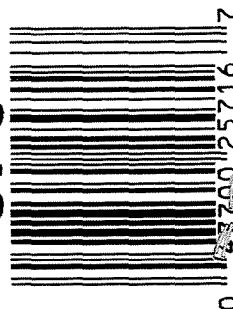
**ORDER NO. 25716**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6461592**

**UPC**



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



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



SERIAL NO.



**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 &amp; Rec Assembly,

78ROT01

**0004012773**

0540

Flat Black Powder Coat, Barrel and

01PC001

**0004012763**

0560

Reassemble Action.

89SWS1

**0004012764**

0690

Pack Rifle &amp; Stencil SWS Container

89SWS1

**.OP0690**

M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6046159Z

| OP #         | OPERATION NAME                                                 | READINGS                   | DATE    | INITIAL  |
|--------------|----------------------------------------------------------------|----------------------------|---------|----------|
| 420 &<br>430 | ASSEMBLE ACTION<br>ASSEMBLE TO STOCK                           |                            | 9-6-05  | RTZ      |
| 440          | PROOF                                                          |                            | 9-6-05  | TRW      |
| 460          | CHECK HEADSPACE                                                | MAGNA-FLUX<br>INSPECTED    | 9-6-05  | RTZ      |
| 470          | DIS-ASSEMBLE ACTION                                            | SEP 24 2005                | 9-6-05  | RTZ      |
| 480 &<br>490 | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                         | 480<br>OPERATOR <u>umg</u> | 9/8/05  | umg      |
| 500          | ROLLMARK CALIBER                                               |                            | 9-8-05  | CW       |
| 510          | DRILL AND TAP<br>SIGHT HOLES                                   |                            | 9-7-05  | TRW      |
| 520          | GOFF BLAST BBL / REC                                           |                            | 9/12    | SW       |
| 530 &<br>540 | APPLY COATINGS<br>(BARREL ACTION)                              |                            | 9/15    | RP<br>HP |
|              | (BOLT)                                                         |                            |         |          |
| 560          | RE-ASSEMBLE ACTION                                             |                            |         |          |
|              | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                            | 9-19-05 | RTZ      |
|              | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                            | 9-19-05 | RTZ      |
|              | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                            | 9-19-05 | RTZ      |
|              | D) OIL FIRING PIN ASSEMBLY                                     |                            | 9-19-05 | RTZ      |
|              | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS        |         |          |

REV-8405

| OP #         | OPERATION NAME                                                           | READINGS                                                    | DATE     | INITIAL |
|--------------|--------------------------------------------------------------------------|-------------------------------------------------------------|----------|---------|
| 560          | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>5.0</u> <u>4.5</u> <u>4.5</u>                            | 10/18/05 | DA      |
| CONT.        | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>2.0</u> <u>2.0</u> <u>2.0</u>                            | 10/18/05 | DA      |
|              | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |          |         |
|              | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.025</u> <u>.024</u> <u>.024</u>                         | 10/18/05 | DA      |
|              | J) ASSEMBLE STOCK                                                        |                                                             | 9-19-05  | RTZ     |
|              | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 10-19-05 | BC      |
|              | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 10-12-05 | AC      |
|              | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 10-12-05 | AC      |
|              | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 10-12-05 | AC      |
| 640 &<br>650 | FUNCTION TEST AND<br>TARGET                                              | <span>PASS</span> FAIL                                      | 10/14/05 | mgj     |
|              |                                                                          | <span>PASS</span> FAIL                                      |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
|              | MALFUNCTION                                                              | CORRECTION                                                  |          |         |
| 660          | INSPECT FOR LIVE AMMO                                                    |                                                             | 10-14-05 | wom     |
| 670          | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 10-19-05 | BC      |
|              | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.68</u> <u>2.74</u> <u>2.75</u> <u>2.86</u> <u>2.83</u> | 10-19-05 | DA      |
|              | C) FUNCTION                                                              |                                                             | 10-19-05 | BC      |
| 690          | PACK                                                                     |                                                             | 10/25/05 | 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

9/13/05

BG

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER<br>50 CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |       | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|-------|----------|
| PULL #1 | 2.62                | 2.33                        |                                   | 2.36  |          |
| PULL #2 | 2.63                | 2.34                        |                                   | 2.39  |          |
| PULL #3 | 2.54                | 2.28                        |                                   | 2.36  |          |
| PULL #4 | 2.51                | 2.49                        |                                   | 2.29  |          |
| PULL #5 | 2.51                | 2.41                        |                                   | 2.31  |          |
| TOTAL   | 12.81               | 11.85                       |                                   | 11.71 |          |
| AVERAGE | 2.56                | 2.37                        |                                   | 2.34  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER<br>20 CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 3.10                | 3.02                        |  |          |
| PULL #2 | 3.11                | 2.87                        |  |          |
| PULL #3 | 2.86                | 2.72                        |  |          |
| PULL #4 | 3.09                | 2.76                        |  |          |
| PULL #5 | 3.07                | 2.90                        |  |          |
| TOTAL   | 15.23               | 14.27                       |  |          |
| AVERAGE | 3.05                | 2.85                        |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER<br>20 CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 4.22                | 4.22                        |                                   | 4.35                                    |
| PULL #2 | 4.31                | 4.12                        |                                   | 4.37                                    |
| PULL #3 | 4.33                | 4.23                        |                                   | 4.40                                    |
| PULL #4 | 4.41                | 4.26                        |                                   | 4.41                                    |
| PULL #5 | 4.41                | 4.30                        |                                   | 4.35                                    |
| TOTAL   | 21.68               | 21.13                       |                                   | 21.88                                   |
| AVERAGE | 4.34                | 4.23                        |                                   | 4.38                                    |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461592.\_\_0  
FILE DATE AND TIME: 10/14/2005 18:13

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.103 |
| The Average Y Centroid of the Five Target Set:              | -0.055 |
| The Average Point of Impact of the Five Target Set:         | 0.117  |
| The Average Mean Radius of the Five Target Set:             | 0.735  |
| The Distance from POA to Centroid Target #1:                | 0.061  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.214  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.202  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.287  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.129  |

SERIAL NUMBER: G6461592. \_\_0

TARGET NUMBER: 1

FILE DATE: 10/14/2005

FILE TIME: 18:13

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.194 | 0.202  |
| 2:     | -0.444 | -0.023 |
| 3:     | -0.206 | 0.836  |
| 4:     | -0.795 | 0.996  |
| 5:     | 0.213  | -0.067 |
| 6:     | 0.690  | -0.111 |
| 7:     | 0.772  | 0.329  |
| 8:     | 0.029  | -1.360 |
| 9:     | -0.794 | -1.162 |
| 10:    | 0.130  | 0.473  |

X CENTROID: -0.060

Y CENTROID: 0.011

POA TO CENTROID: 0.061

HORZ SPREAD: 1.567

VERT SPREAD: 2.356

GROUP SPREAD: 2.162

MIN RADIUS: 0.233

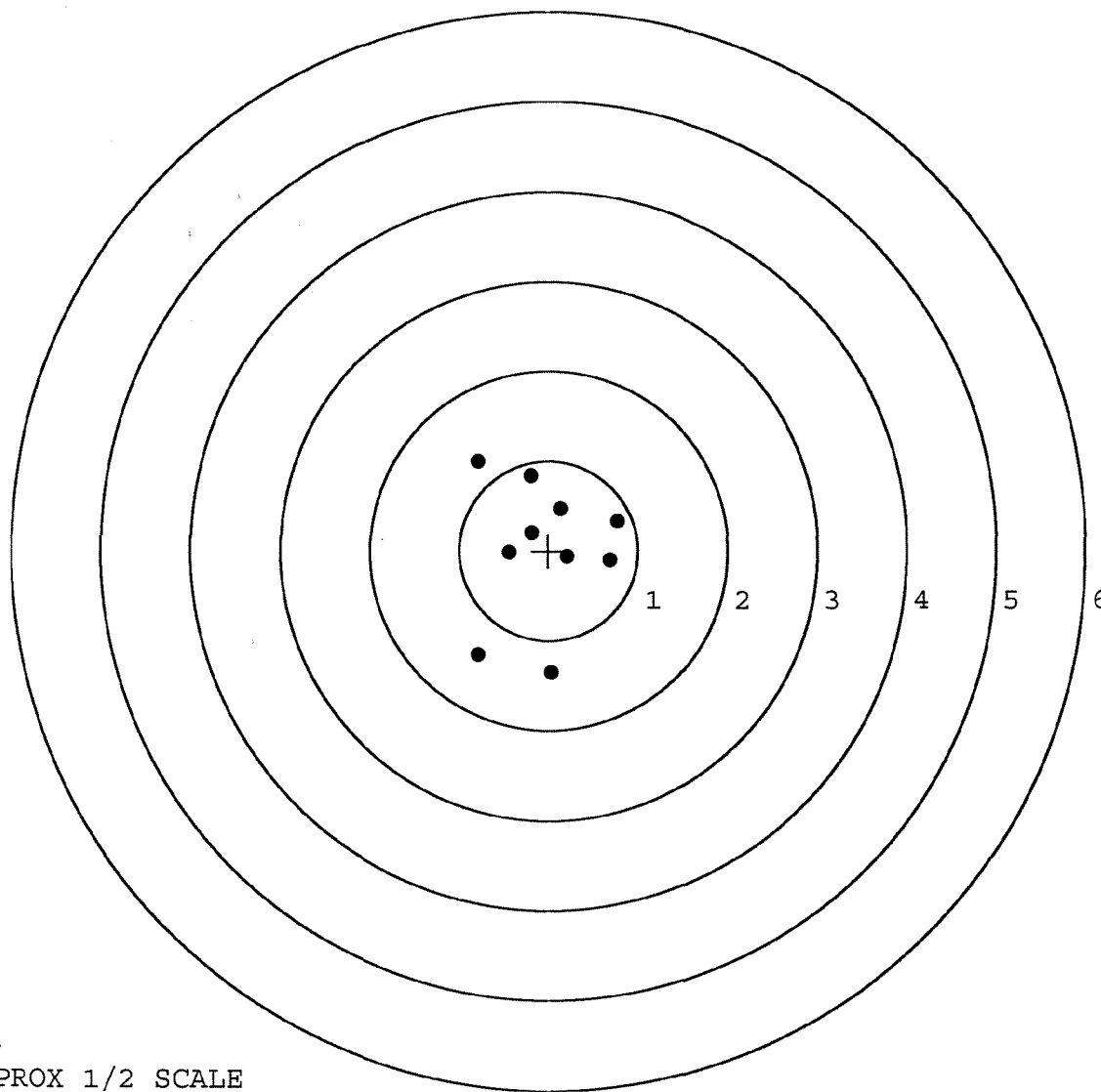
MAX RADIUS: 1.384

MEAN RADIUS: 0.788

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 7

# in 3 IN DIAMETER: 10

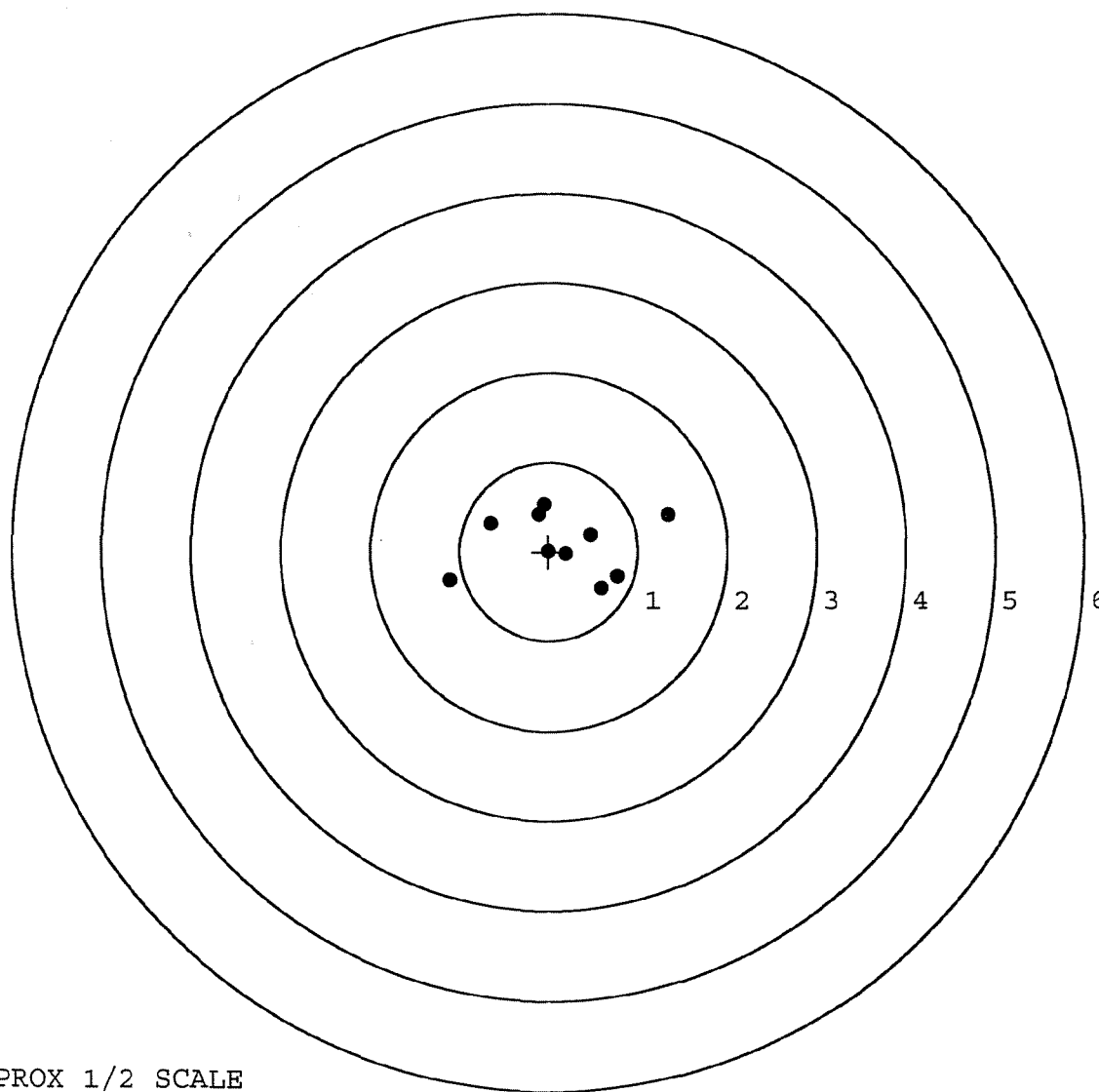


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. \_\_0  
TARGET NUMBER: 2  
FILE DATE: 10/14/2005  
FILE TIME: 18:13

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | -0.005 | 0.000  |
| 2:     | 0.195  | -0.031 |
| 3:     | 0.468  | 0.189  |
| 4:     | 0.778  | -0.281 |
| 5:     | 0.594  | -0.417 |
| 6:     | 1.332  | 0.412  |
| 7:     | -0.120 | 0.415  |
| 8:     | -0.054 | 0.532  |
| 9:     | -0.655 | 0.310  |
| 10:    | -1.109 | -0.327 |

X CENTROID: 0.142  
Y CENTROID: 0.080  
POA TO CENTROID: 0.163  
HORZ SPREAD: 2.441  
VERT SPREAD: 0.949  
GROUP SPREAD: 2.550  
MIN RADIUS: 0.123  
MAX RADIUS: 1.316  
MEAN RADIUS: 0.634  
# IN 1 IN DIAMETER: 5  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 10

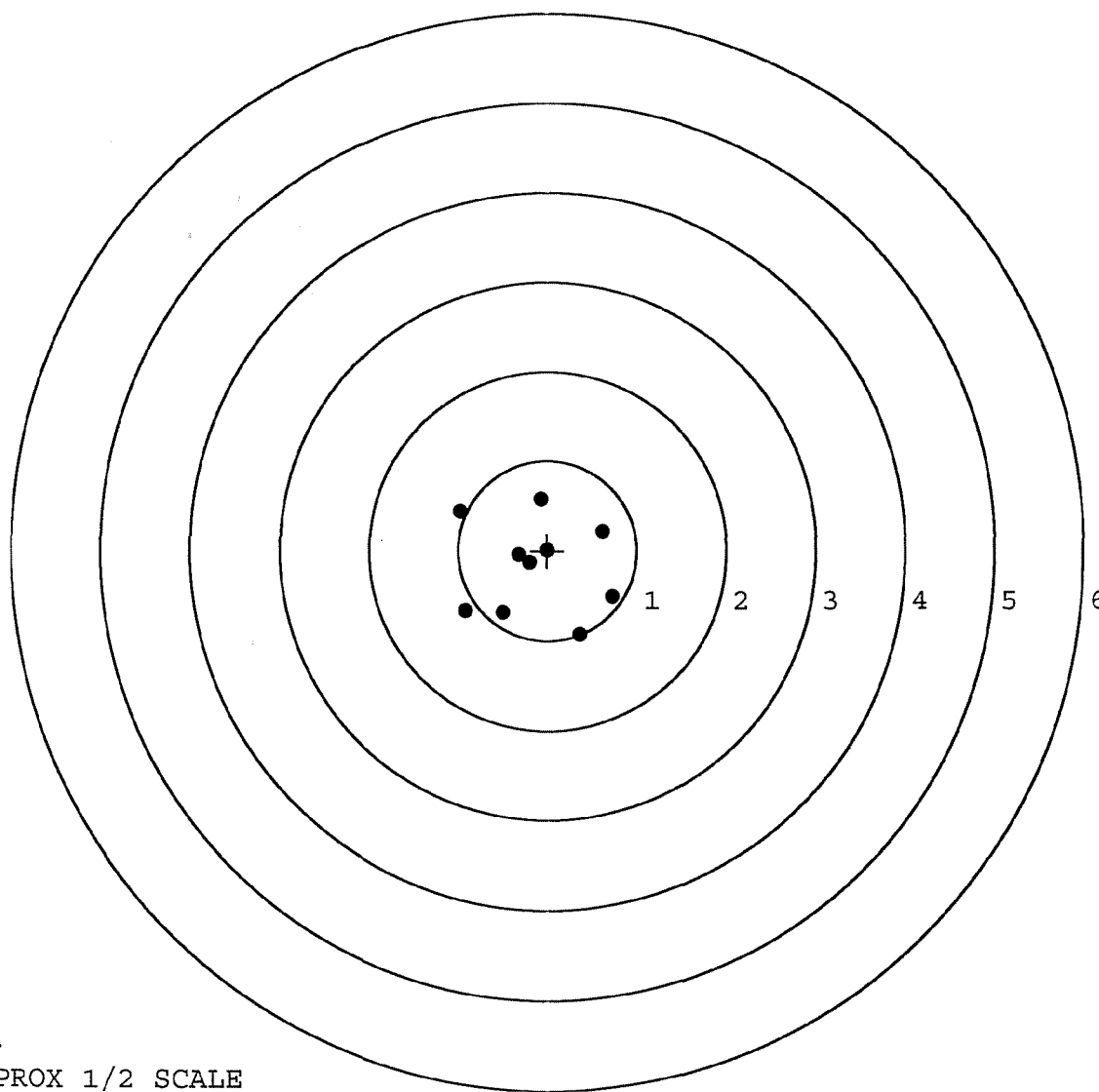


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 10/14/2005  
FILE TIME: 18:13

X CENTROID: -0.128  
Y CENTROID: -0.179  
POA TO CENTROID: 0.220  
HORZ SPREAD: 1.705  
VERT SPREAD: 1.505  
GROUP SPREAD: 1.952  
MIN RADIUS: 0.082  
MAX RADIUS: 1.044  
MEAN RADIUS: 0.656  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.000  | 0.000  |
| 2:     | -0.201 | -0.140 |
| 3:     | -0.320 | -0.050 |
| 4:     | -0.974 | 0.434  |
| 5:     | -0.074 | 0.571  |
| 6:     | 0.614  | 0.207  |
| 7:     | 0.731  | -0.516 |
| 8:     | 0.363  | -0.934 |
| 9:     | -0.500 | -0.691 |
| 10:    | -0.922 | -0.670 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. \_\_0

TARGET NUMBER: 4

FILE DATE: 10/14/2005

FILE TIME: 18:13

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.008  | -0.078 |
| 2:     | -0.014 | 0.168  |
| 3:     | -0.288 | 0.070  |
| 4:     | -0.871 | -0.788 |
| 5:     | -0.974 | -0.531 |
| 6:     | -1.228 | -0.675 |
| 7:     | -0.213 | -1.177 |
| 8:     | 1.197  | -0.006 |
| 9:     | -0.076 | 0.722  |
| 10:    | -0.771 | 1.260  |

X CENTROID: -0.323

Y CENTROID: -0.103

POA TO CENTROID: 0.339

HORZ SPREAD: 2.425

VERT SPREAD: 2.437

GROUP SPREAD: 2.516

MIN RADIUS: 0.177

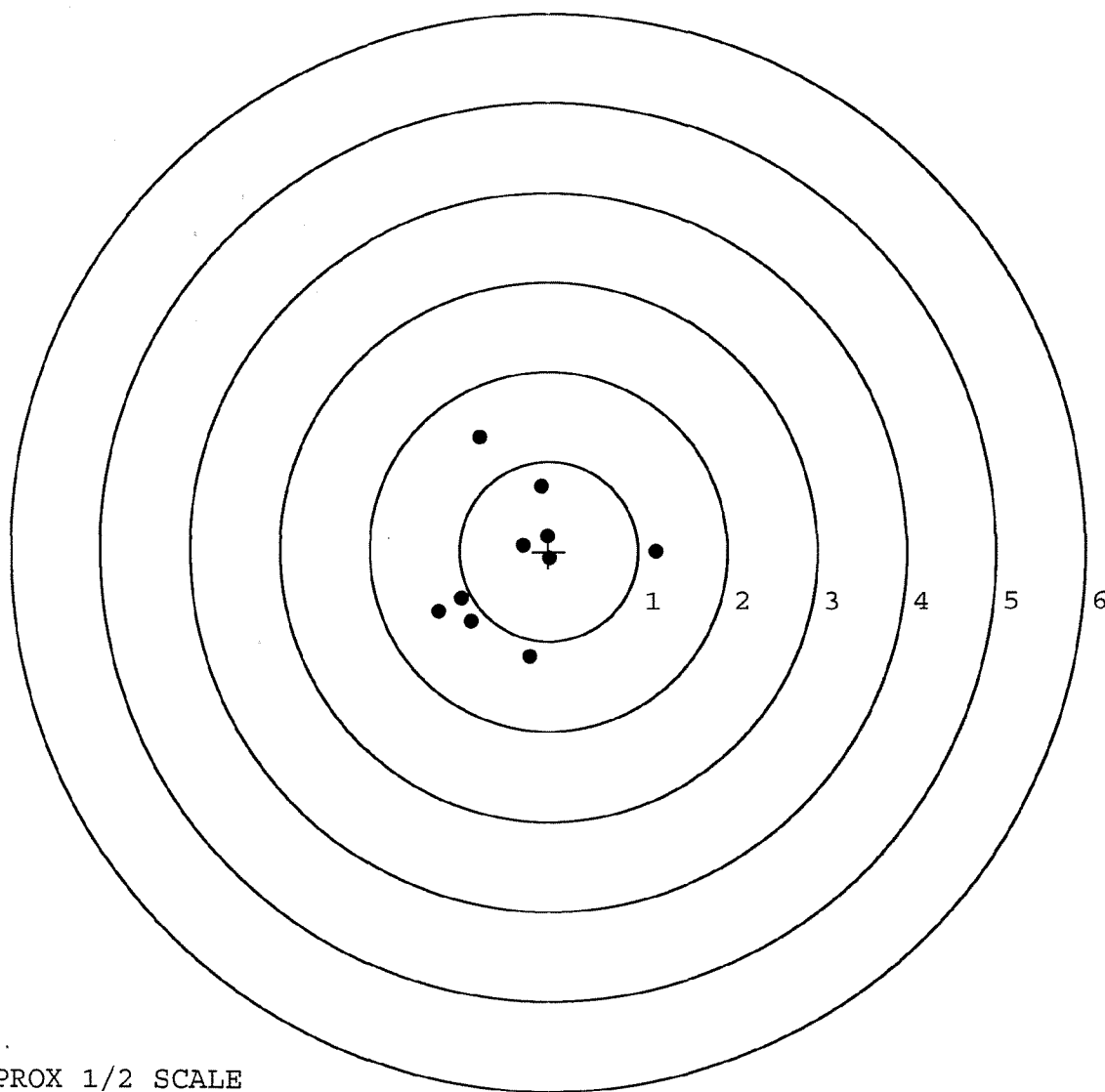
MAX RADIUS: 1.523

MEAN RADIUS: 0.855

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 6

# in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461592. \_\_ 0

TARGET NUMBER: 5

FILE DATE: 10/14/2005

FILE TIME: 18:13

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.334  | 0.111  |
| 2:     | 0.432  | -0.058 |
| 3:     | 0.693  | 0.029  |
| 4:     | 0.021  | 0.535  |
| 5:     | -0.064 | 0.394  |
| 6:     | -0.869 | -0.437 |
| 7:     | -0.973 | -0.492 |
| 8:     | -1.405 | -0.153 |
| 9:     | 0.080  | -0.910 |
| 10:    | 0.309  | 0.124  |

X CENTROID: -0.144

Y CENTROID: -0.086

POA TO CENTROID: 0.168

HORZ SPREAD: 2.098

VERT SPREAD: 1.445

GROUP SPREAD: 2.106

MIN RADIUS: 0.486

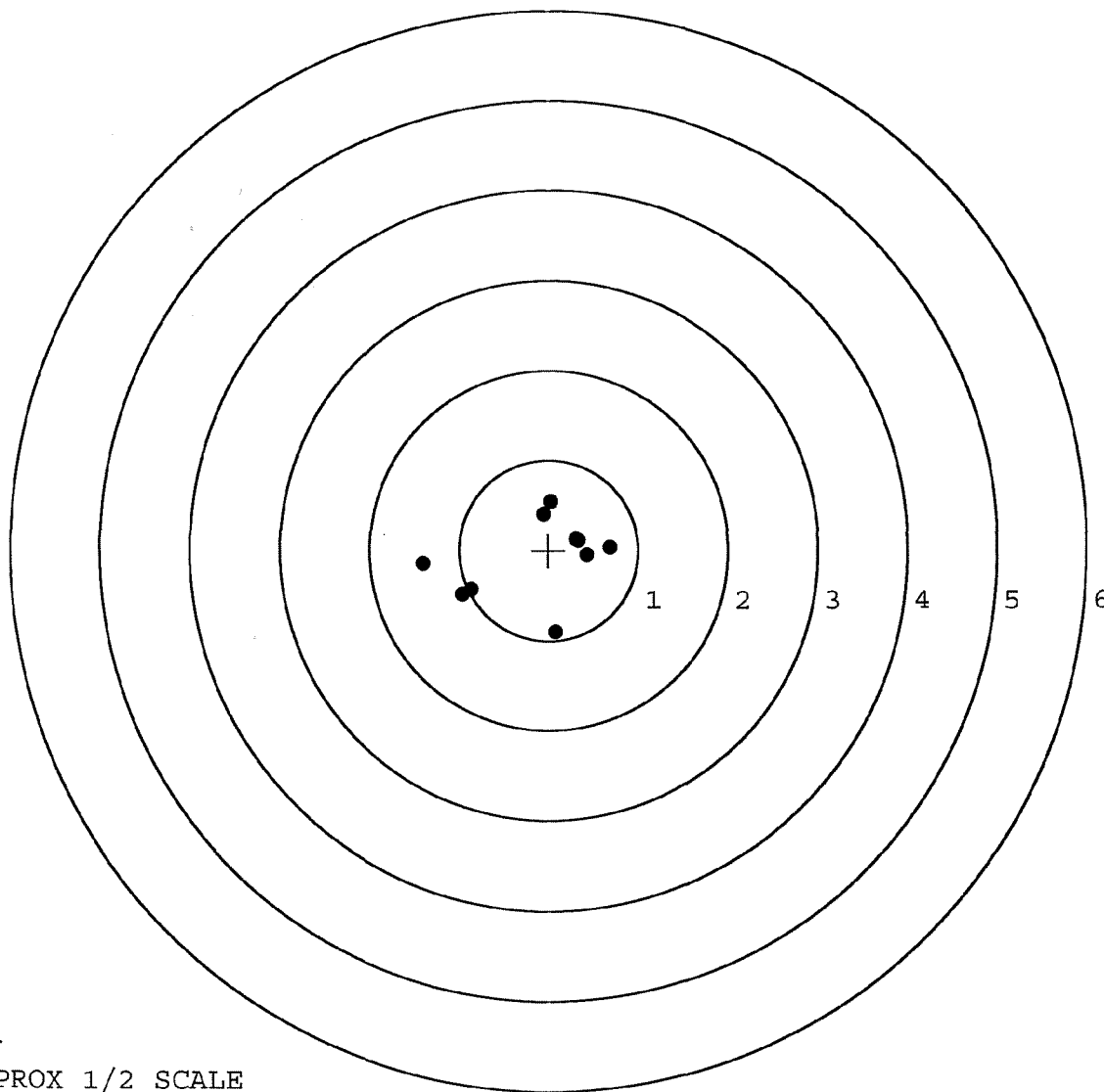
MAX RADIUS: 1.263

MEAN RADIUS: 0.741

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE