

G 646 1612

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



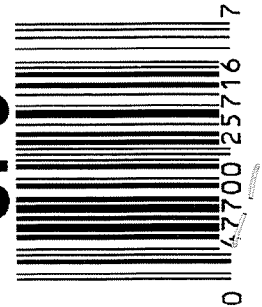
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461612

UPC



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

UPC



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

UPC



SERIAL NO.



6/17/2005 2:12:04 PM

Crib

27

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 # G 60461612

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTZ
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTZ
470	DIS-ASSEMBLE ACTION		9-6-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	9/8/05	und
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	und
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		9-27-05	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>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	10-11-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-11-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		9-27-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-11-05	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 <u>PASS</u> FAIL	10/4/05	mfg
	MALFUNCTION <i>Feeds Hand from Mag</i>	CORRECTION <u>OK</u>	10-6-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION <i>N/A</i>		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/4/05	mm
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.92</u> <u>2.67</u> <u>2.89</u> <u>2.90</u> <u>2.87</u>	10-7-05	BG
	C) FUNCTION		10-11-05	Ac
690	PACK		10-12-05	RA

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

RG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.20	2.20		2.58	
PULL #2	2.54	2.39		2.65	
PULL #3	2.56	2.16		2.75	
PULL #4	2.06	2.69		2.73	
PULL #5	2.60	2.33		2.76	
TOTAL	11.96	11.77		13.47	
AVERAGE	2.39	2.35		2.69	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.04		
PULL #2	3.34	3.16		
PULL #3	3.30	3.19		
PULL #4	3.47	3.25		
PULL #5	3.29	3.11		
TOTAL	16.62	15.75		
AVERAGE	3.32	3.15		

	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	4.18	4.19		4.41
PULL #2	4.21	4.40		3.95
PULL #3	4.22	4.34		4.39
PULL #4	4.42	4.46		4.33
PULL #5	4.32	4.58		4.18
TOTAL	21.35	21.97		21.26
AVERAGE	4.27	4.39		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461612.__0

FILE DATE AND TIME: 10/04/2005 18:29

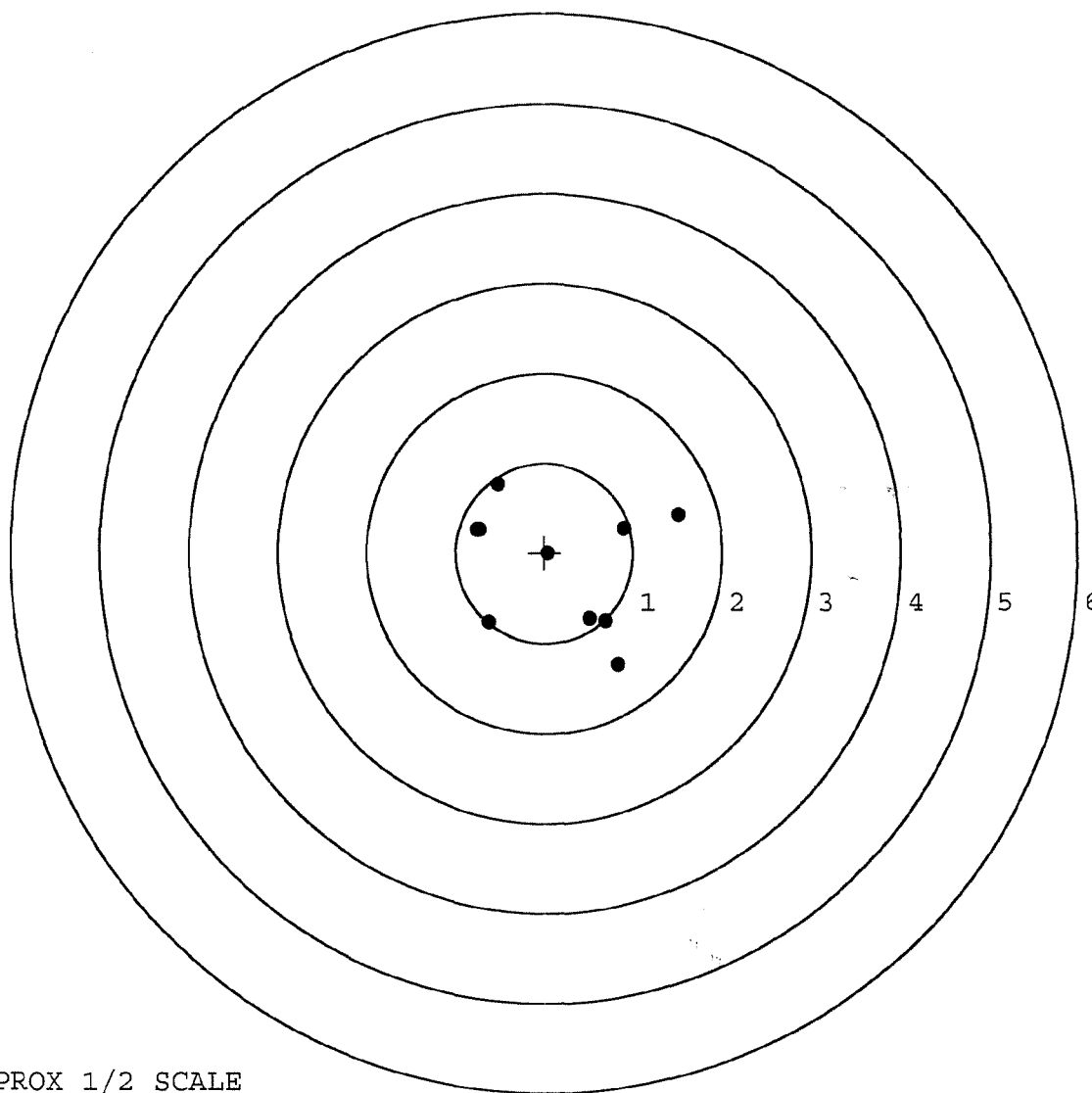
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.116
The Average Y Centroid of the Five Target Set:	0.090
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	1.042
The Distance from POA to Centroid Target #1:	0.233
The Distance from Centroid Target #2 to Centroid Target #1:	0.996
The Distance from Centroid Target #3 to Centroid Target #1:	0.382
The Distance from Centroid Target #4 to Centroid Target #1:	0.359
The Distance from Centroid Target #5 to Centroid Target #1:	0.513

SERIAL NUMBER: G6461612. 0
TARGET NUMBER: 1
FILE DATE: 10/04/2005
FILE TIME: 18:29

X CENTROID: 0.178
Y CENTROID: -0.150
POA TO CENTROID: 0.233
HORZ SPREAD: 2.277
VERT SPREAD: 2.007
GROUP SPREAD: 2.463
MIN RADIUS: 0.198
MAX RADIUS: 1.455
MEAN RADIUS: 0.943
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.766	0.263
2:	-0.531	0.770
3:	0.894	0.275
4:	1.511	0.432
5:	0.827	-1.237
6:	0.682	-0.760
7:	-0.637	-0.773
8:	0.037	-0.011
9:	0.505	-0.727
10:	-0.744	0.264

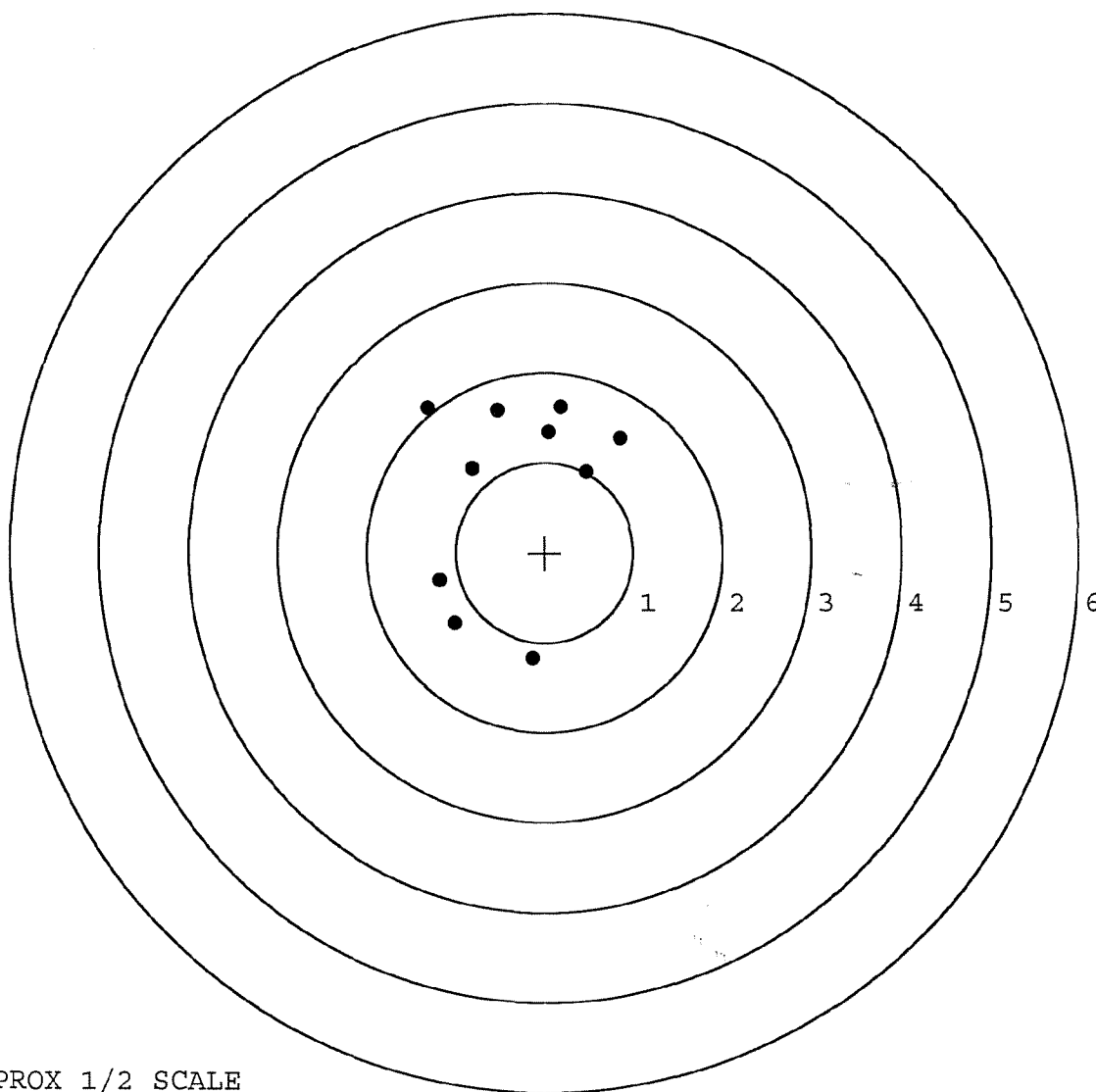


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. __ 0
TARGET NUMBER: 2
FILE DATE: 10/04/2005
FILE TIME: 18:29

X CENTROID: -0.347
Y CENTROID: 0.696
POA TO CENTROID: 0.777
HORZ SPREAD: 2.166
VERT SPREAD: 2.793
GROUP SPREAD: 3.013
MIN RADIUS: 0.527
MAX RADIUS: 1.880
MEAN RADIUS: 1.155
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.818	0.932
2:	-1.318	1.602
3:	-0.534	1.579
4:	0.182	1.619
5:	0.043	1.334
6:	0.848	1.268
7:	0.470	0.899
8:	-0.146	-1.174
9:	-1.015	-0.790
10:	-1.181	-0.312

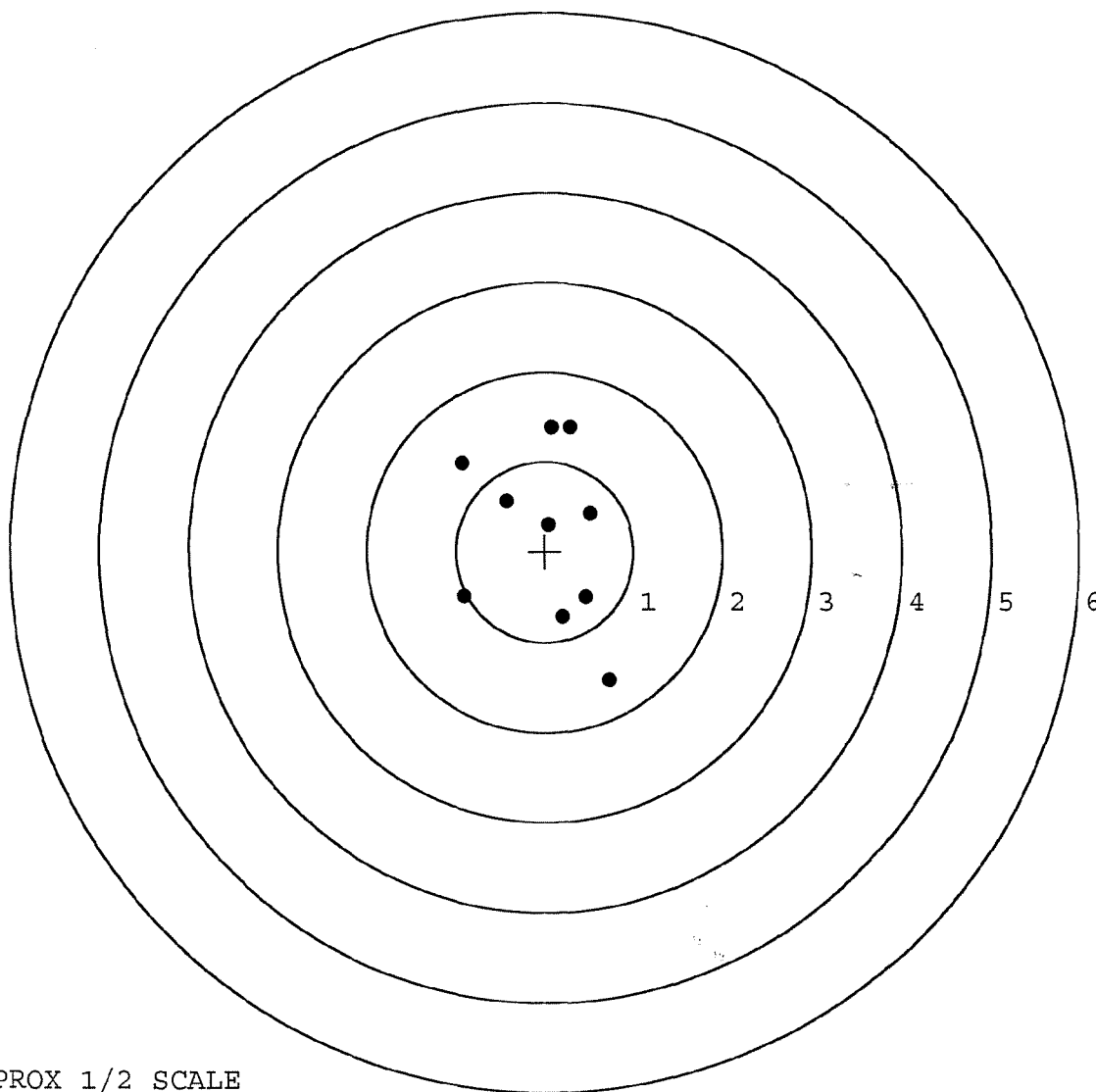


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. __0
TARGET NUMBER: 3
FILE DATE: 10/04/2005
FILE TIME: 18:29

X CENTROID: 0.002
Y CENTROID: 0.189
POA TO CENTROID: 0.189
HORZ SPREAD: 1.664
VERT SPREAD: 2.812
GROUP SPREAD: 2.925
MIN RADIUS: 0.112
MAX RADIUS: 1.769
MEAN RADIUS: 0.957
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.035	0.296
2:	-0.440	0.555
3:	-0.932	0.984
4:	0.075	1.384
5:	0.291	1.390
6:	0.460	-0.502
7:	0.199	-0.722
8:	0.732	-1.422
9:	-0.909	-0.498
10:	0.507	0.423



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612.___0

TARGET NUMBER: 4

FILE DATE: 10/04/2005

FILE TIME: 18:29

X CENTROID: -0.114

Y CENTROID: 0.058

POA TO CENTROID: 0.128

HORZ SPREAD: 2.388

VERT SPREAD: 2.647

GROUP SPREAD: 2.680

MIN RADIUS: 0.219

MAX RADIUS: 1.483

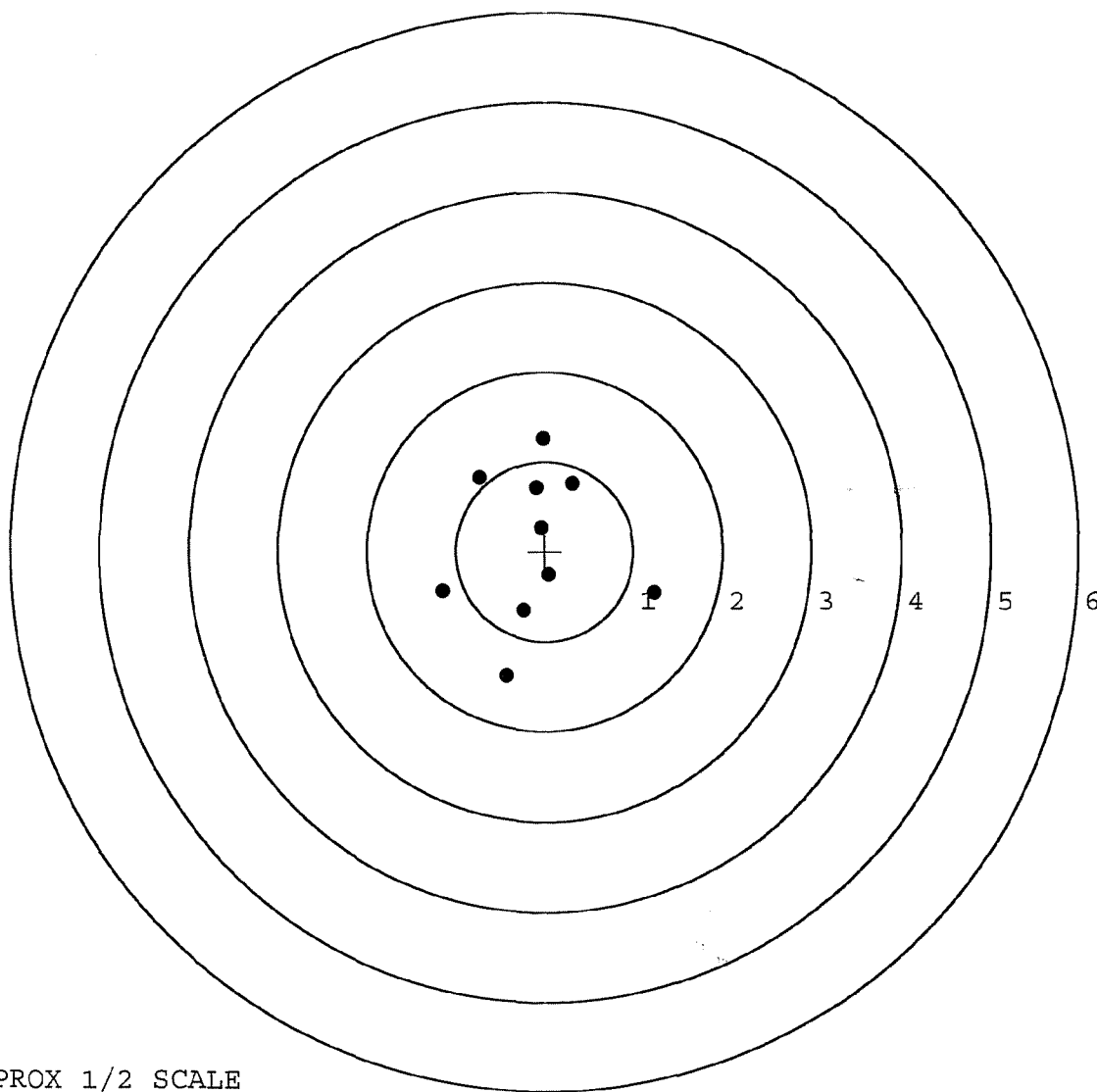
MEAN RADIUS: 0.905

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.041	-0.263
2:	-0.243	-0.660
3:	-1.152	-0.451
4:	-0.734	0.817
5:	-0.041	0.265
6:	-0.103	0.711
7:	0.312	0.757
8:	-0.022	1.258
9:	1.236	-0.463
10:	-0.439	-1.389



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461612. __0

TARGET NUMBER: 5

FILE DATE: 10/04/2005

FILE TIME: 18:29

X CENTROID: -0.297

Y CENTROID: -0.345

POA TO CENTROID: 0.455

HORZ SPREAD: 3.019

VERT SPREAD: 3.347

GROUP SPREAD: 3.716

MIN RADIUS: 0.442

MAX RADIUS: 2.323

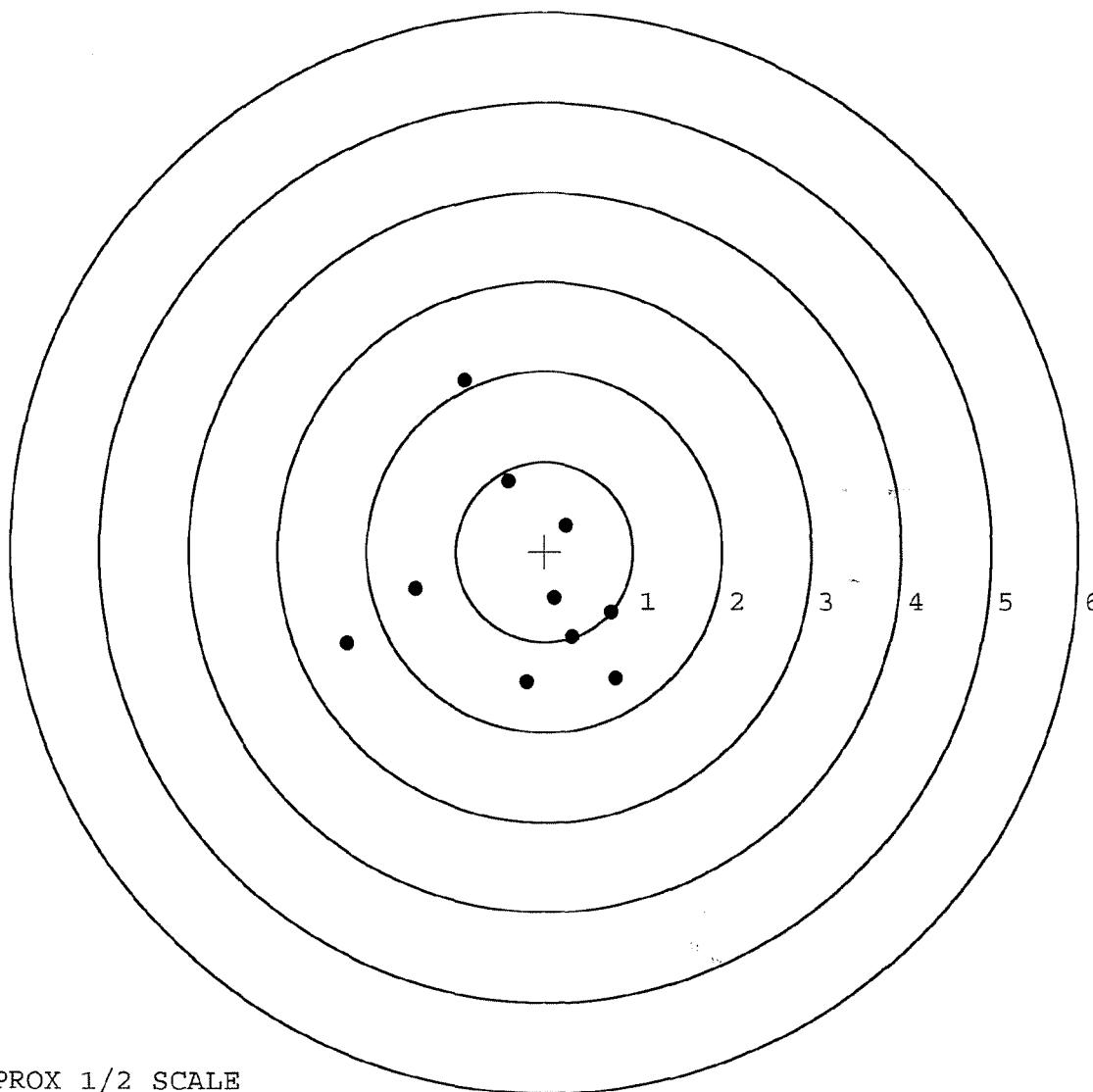
MEAN RADIUS: 1.251

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.238	0.299
2:	-0.416	0.785
3:	-0.905	1.898
4:	-1.447	-0.421
5:	-2.214	-1.031
6:	-0.206	-1.449
7:	0.308	-0.943
8:	0.805	-1.401
9:	0.111	-0.515
10:	0.753	-0.667



TARGET APPROX 1/2 SCALE