

G-646 1614

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

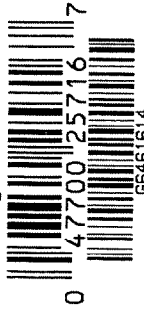
- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



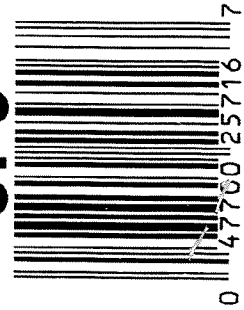
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6461614

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

01

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

Goff Blast Barrel & Rec Assembly,

78ROT01



0004012773

0540

Flat Black Powder Coat, Barrel and

01PC001



0004012763

0560

Reassemble Action.

89SWS1



0004012764

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6460 1614

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AK
460	CHECK HEADSPACE		8-12-05	AK
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	TRLJ
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9-12-05	WT
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	MTM
	D) OIL FIRING PIN ASSEMBLY		10-1-05	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 lb</u> <u>6 lb</u> <u>6 lb</u>	10/25/05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lb</u> <u>3 lb</u> <u>3 lb</u>	10/25/05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10/25/05	BC
	J) ASSEMBLE STOCK		10-12-05	RJL
	K) ASSEMBLE SWIVEL STUDS		10/25/05	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	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/18/05	mgd
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/18/05	S.F.
670	FINAL INSPECTION A) HEADSPACE		10/25/05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.31</u> <u>2.34</u> <u>2.30</u> <u>2.25</u>	10-25-05	TRW
	C) FUNCTION		10/25/05	BC
690	PACK		10/26/05	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 R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.57	2.47		2.49	
PULL #2	2.58	2.45		2.49	
PULL #3	2.50	2.38		2.57	
PULL #4	2.43	2.41		2.26	
PULL #5	2.48	2.30		2.58	
TOTAL	12.56	12.01		12.39	
AVERAGE	2.51	2.40		2.47	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.31		
PULL #2	3.15	3.26		
PULL #3	3.13	2.97		
PULL #4	3.19	3.36		
PULL #5	3.13	3.21		
TOTAL	15.83	16.11		
AVERAGE	3.16	3.22		

	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	4.41	4.44		4.08
PULL #2	4.37	4.21		4.19
PULL #3	4.38	4.38		4.34
PULL #4	4.34	4.38		4.19
PULL #5	4.45	4.28		4.32
TOTAL	21.95	21.69		21.12
AVERAGE	4.39	4.33		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461614.__0
FILE DATE AND TIME: 10/18/2005 18:29

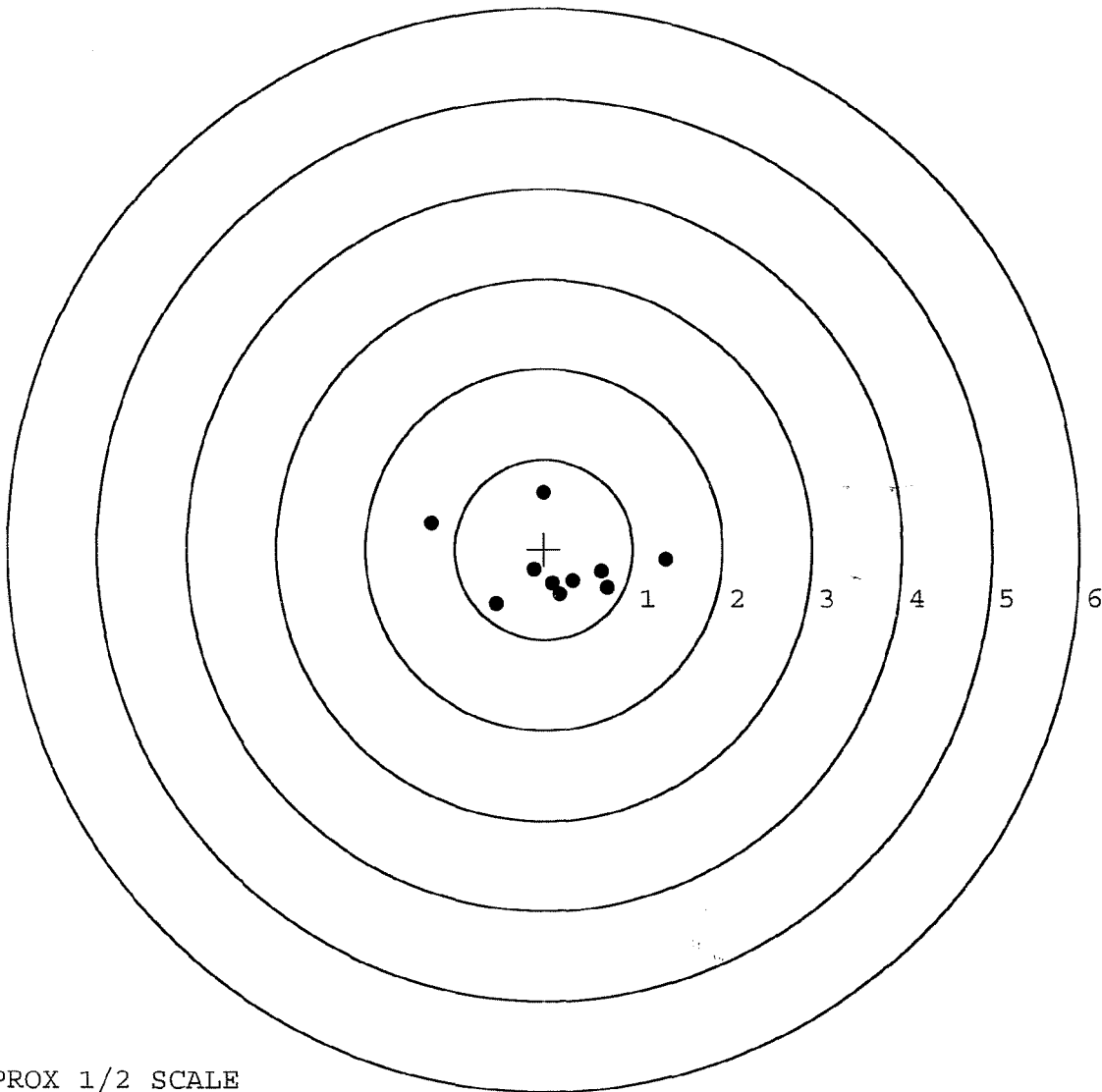
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.081
The Average Y Centroid of the Five Target Set:	-0.190
The Average Point of Impact of the Five Target Set:	0.207
The Average Mean Radius of the Five Target Set:	0.726
The Distance from POA to Centroid Target #1:	0.239
The Distance from Centroid Target #2 to Centroid Target #1:	0.172
The Distance from Centroid Target #3 to Centroid Target #1:	0.038
The Distance from Centroid Target #4 to Centroid Target #1:	0.034
The Distance from Centroid Target #5 to Centroid Target #1:	0.126

SERIAL NUMBER: G6461614. 0
TARGET NUMBER: 1
FILE DATE: 10/18/2005
FILE TIME: 18:29

X CENTROID: 0.138
Y CENTROID: -0.195
POA TO CENTROID: 0.239
HORZ SPREAD: 2.636
VERT SPREAD: 1.242
GROUP SPREAD: 2.668
MIN RADIUS: 0.191
MAX RADIUS: 1.486
MEAN RADIUS: 0.649
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.119	-0.229
2:	0.097	-0.382
3:	0.174	-0.504
4:	0.323	-0.348
5:	0.641	-0.253
6:	0.710	-0.431
7:	1.370	-0.121
8:	-0.543	-0.609
9:	-1.266	0.292
10:	-0.011	0.633



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461614. 0

TARGET NUMBER: 2

FILE DATE: 10/18/2005

FILE TIME: 18:29

X CENTROID: -0.032

Y CENTROID: -0.225

POA TO CENTROID: 0.227

HORZ SPREAD: 2.505

VERT SPREAD: 1.955

GROUP SPREAD: 2.516

MIN RADIUS: 0.347

MAX RADIUS: 1.323

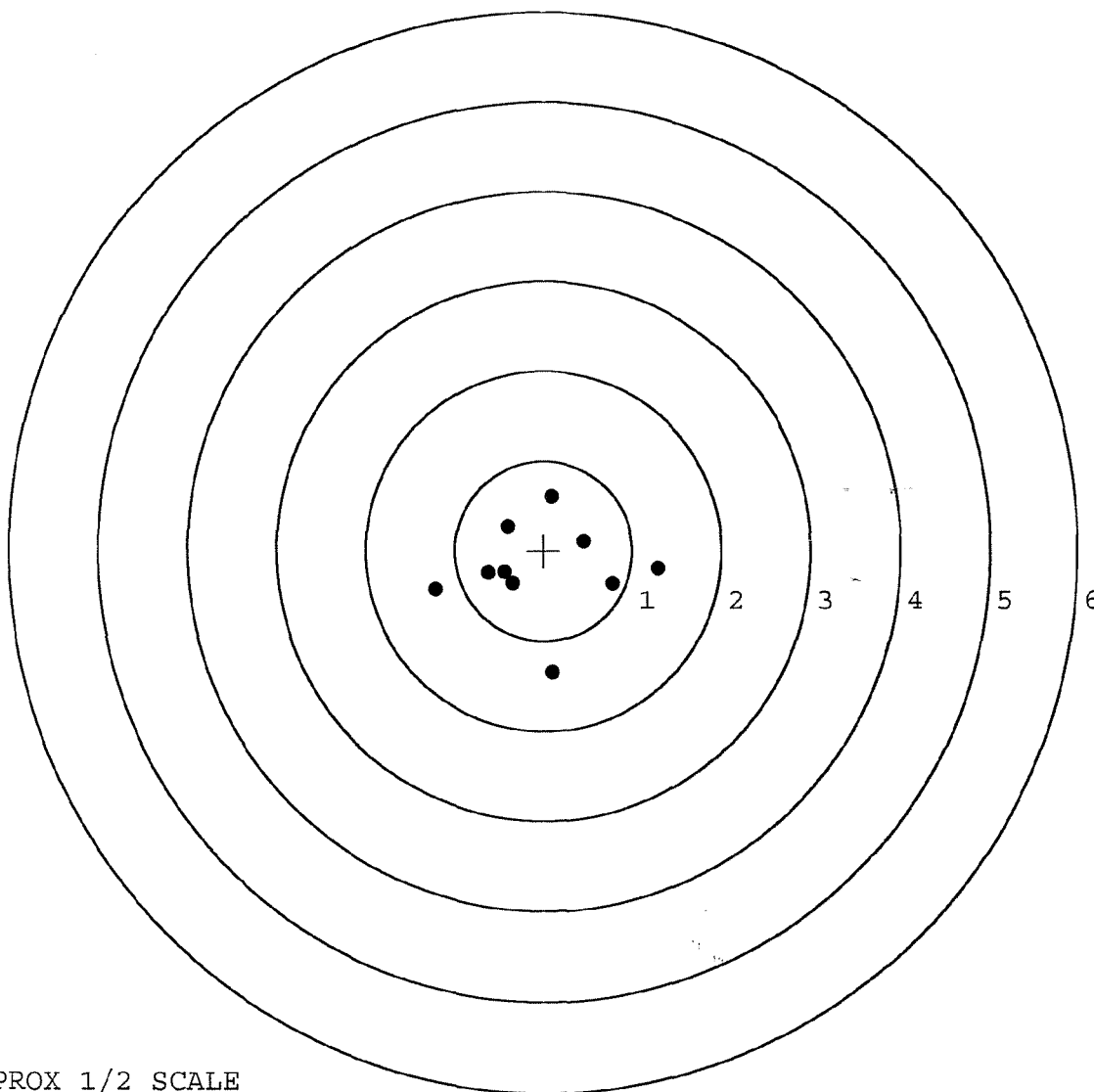
MEAN RADIUS: 0.789

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.090	0.601
2:	-0.408	0.269
3:	0.455	0.109
4:	-0.347	-0.370
5:	-0.446	-0.245
6:	-0.626	-0.249
7:	-1.214	-0.441
8:	0.779	-0.371
9:	1.291	-0.201
10:	0.106	-1.354



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461614. 0

TARGET NUMBER: 3

FILE DATE: 10/18/2005

FILE TIME: 18:29

X CENTROID: 0.099

Y CENTROID: -0.196

POA TO CENTROID: 0.220

HORZ SPREAD: 1.486

VERT SPREAD: 3.007

GROUP SPREAD: 3.125

MIN RADIUS: 0.164

MAX RADIUS: 1.701

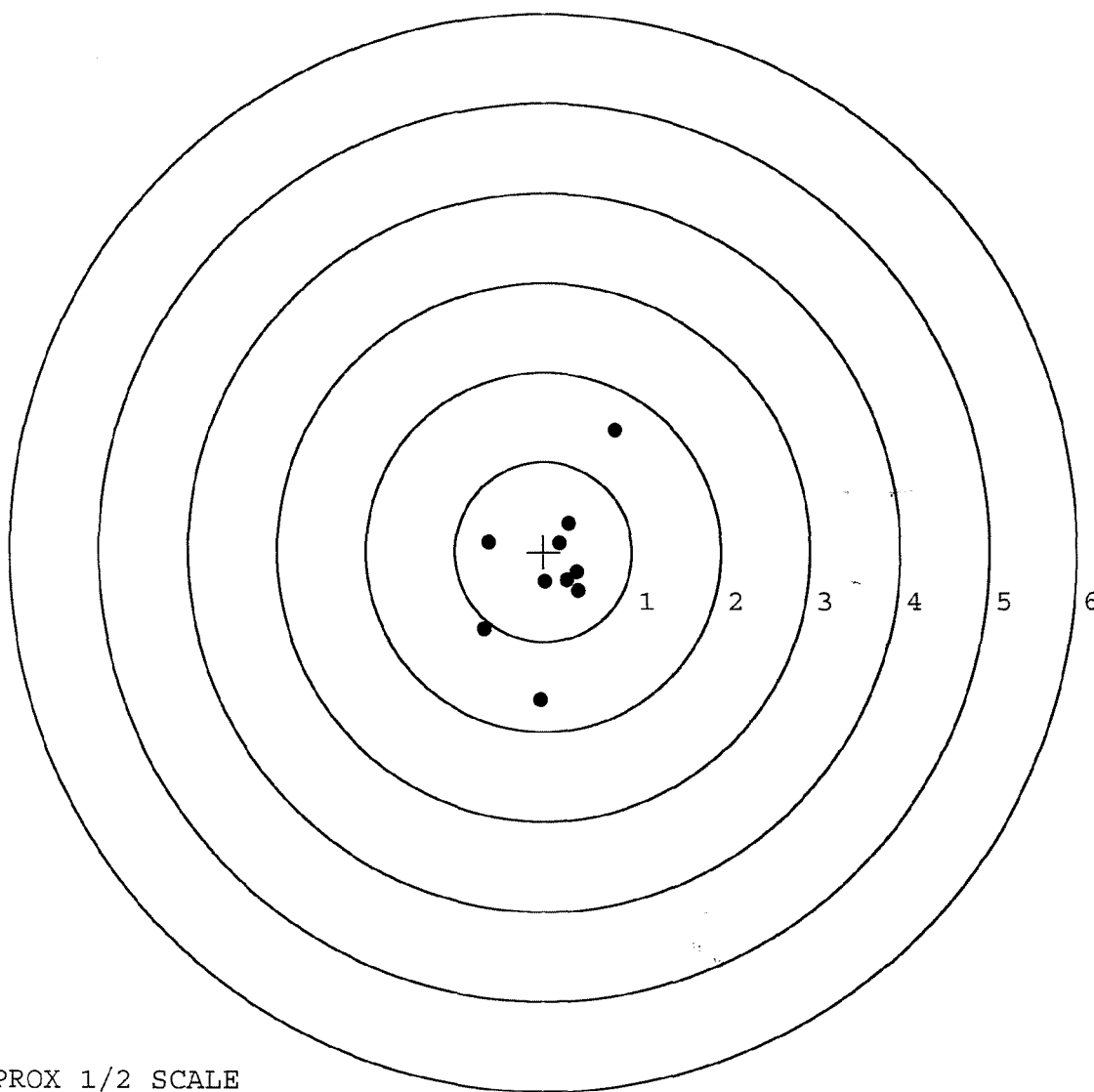
MEAN RADIUS: 0.684

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.280	0.317
2:	0.181	0.099
3:	0.378	-0.220
4:	0.019	-0.339
5:	0.392	-0.439
6:	-0.674	-0.865
7:	-0.616	0.112
8:	0.812	1.348
9:	-0.038	-1.659
10:	0.260	-0.314

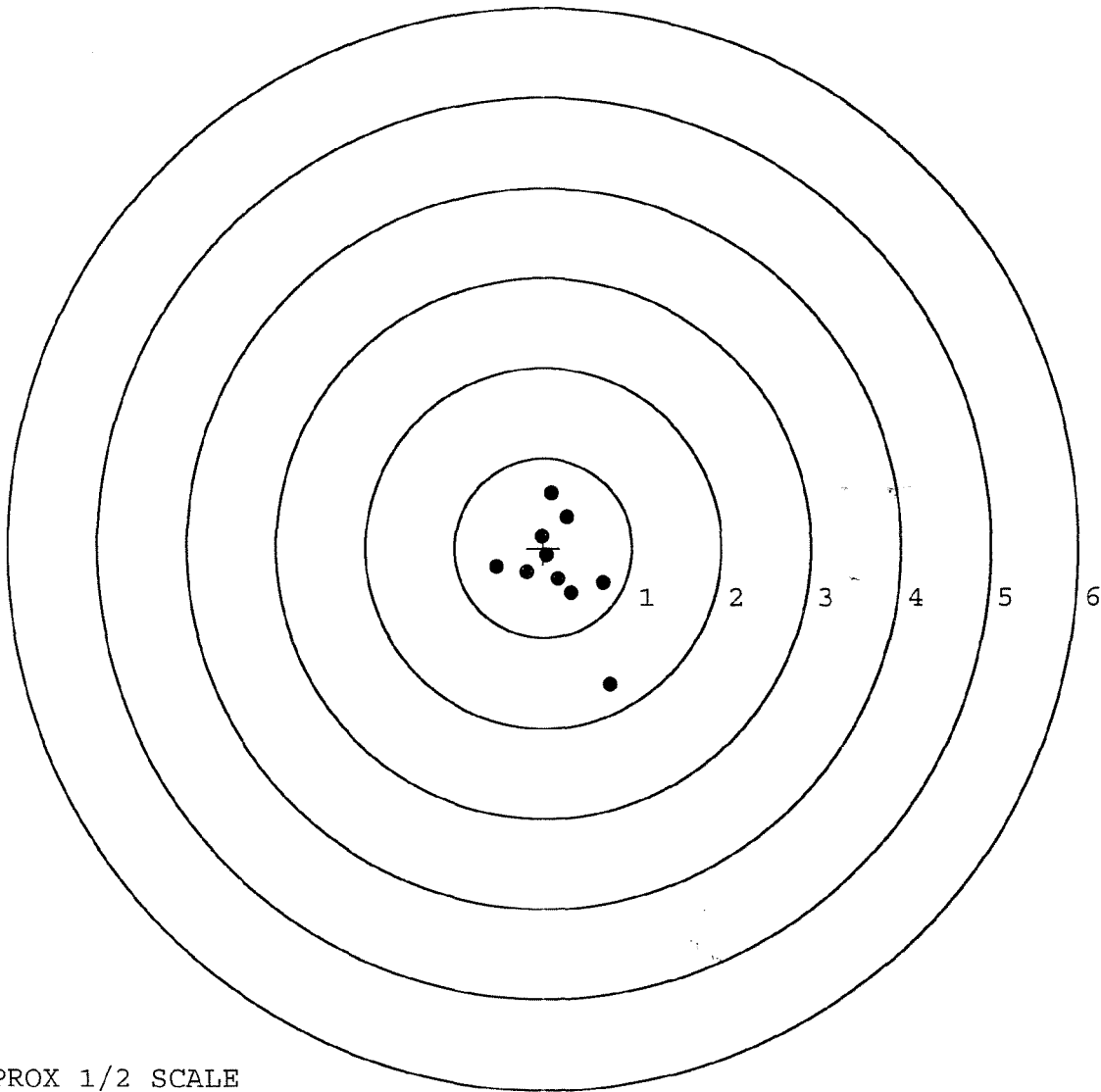


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461614. 0
TARGET NUMBER: 4
FILE DATE: 10/18/2005
FILE TIME: 18:29

X CENTROID: 0.155
Y CENTROID: -0.225
POA TO CENTROID: 0.273
HORZ SPREAD: 1.279
VERT SPREAD: 2.134
GROUP SPREAD: 2.234
MIN RADIUS: 0.127
MAX RADIUS: 1.427
MEAN RADIUS: 0.545
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.528	-0.213
2:	-0.192	-0.280
3:	0.667	-0.389
4:	0.311	-0.504
5:	0.166	-0.351
6:	-0.014	0.128
7:	0.262	0.353
8:	0.091	0.613
9:	0.038	-0.083
10:	0.751	-1.521



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461614. __0

TARGET NUMBER: 5

FILE DATE: 10/18/2005

FILE TIME: 18:29

X CENTROID: 0.044

Y CENTROID: -0.111

POA TO CENTROID: 0.119

HORZ SPREAD: 1.885

VERT SPREAD: 2.576

GROUP SPREAD: 2.754

MIN RADIUS: 0.248

MAX RADIUS: 1.466

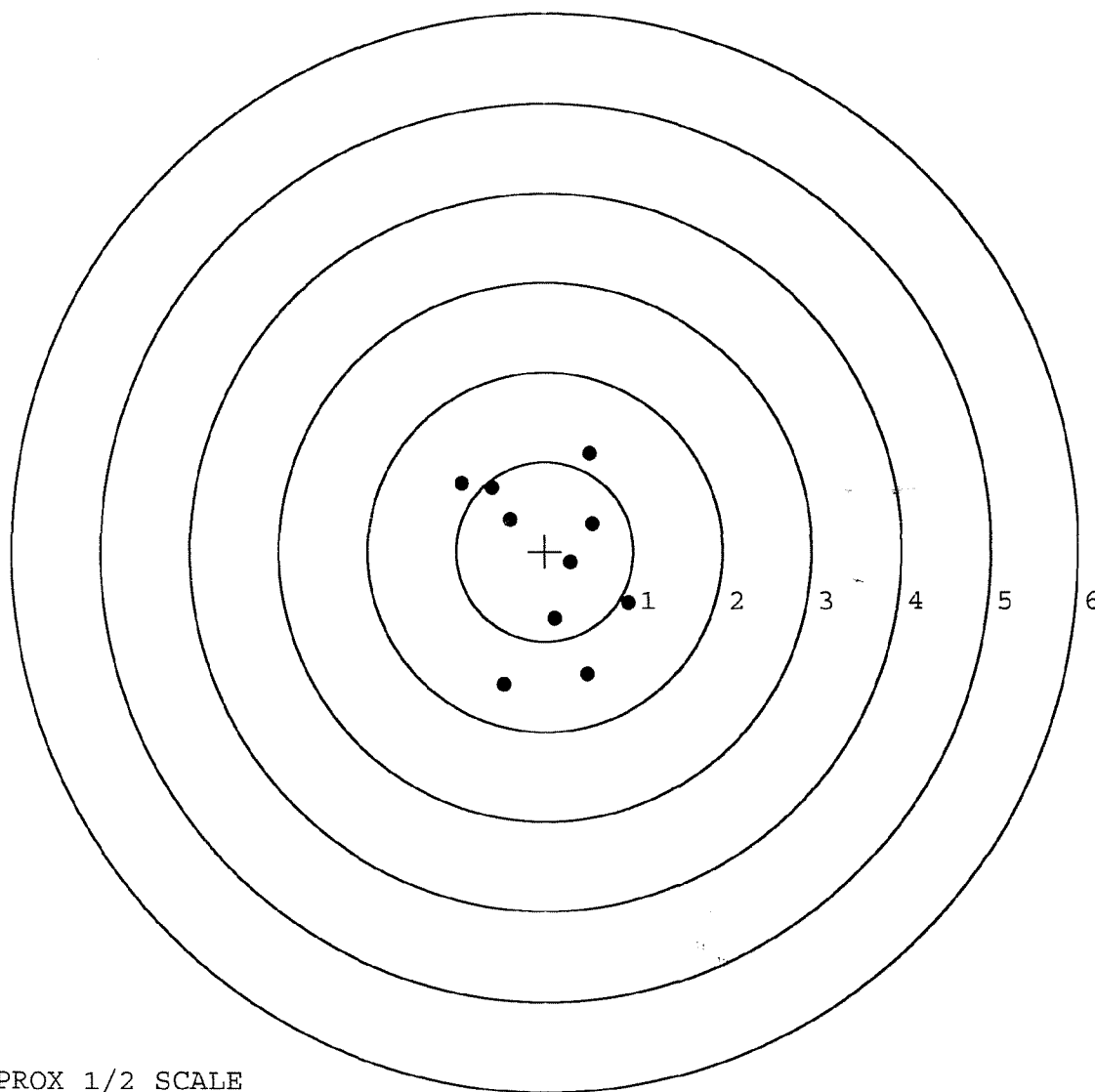
MEAN RADIUS: 0.964

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.291	-0.131
2:	0.533	0.305
3:	-0.406	0.351
4:	-0.599	0.713
5:	-0.944	0.756
6:	0.504	1.092
7:	0.941	-0.586
8:	0.109	-0.754
9:	-0.470	-1.484
10:	0.478	-1.372



TARGET APPROX 1/2 SCALE