

G6461617

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



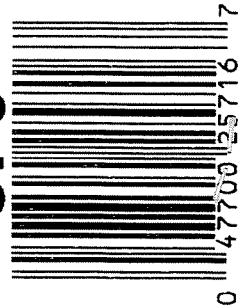
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461617

UPC



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

UPC



0 47700 25716 7

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

UPC



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SERIAL NO.



66461617

4/7/2005 2:48:09 PM

Original

7

Original

25716

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



.MA25716

Shop Order: SW5716 - APR



.ABSW5716 - APR

Start Date: 3/11/2005

Finish Date: 4/14/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0003858612

0540

01PC001

Flat Black Powder Coat, Barrel and



0003858602

0560

89SWS1

Reassemble Action.



0003858603

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G646 1617

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	AC
607	CHECK HEADSPACE	MAGNA-FLUX	4-18-05	AC
610	DIS-ASSEMBLE GUN	INSPECTED	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>B</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRW
620	APPLY COATINGS (BARREL ACTION)		5-6-05	W
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-16-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-16-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-16-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		4-16-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	5-19-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-19-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-19-05	Ac
	J) ASSEMBLE STOCK		4-16-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-19-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-16-05	RTZ
	M) IRON SIGHT ALIGNMENT		4-16-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-16-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-17-05	Ac
	MALFUNCTION	CORRECTION	X	X
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-17-05	TRW
655	FINAL INSPECTION A) HEADSPACE		5-19-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.73</u> <u>2.89</u> <u>2.95</u> <u>2.65</u> <u>2.70</u>	5-19-05	Ac
	C) FUNCTION		5-19-05	Ac
660	PACK		5/23/05	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 5-2-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.59	2.48		2.63	
PULL #2	2.48	2.52		2.46	
PULL #3	2.51	2.81		2.51	
PULL #4	2.65	2.73		2.47	
PULL #5	2.71	2.66		2.45	
TOTAL	12.94	13.20		12.52	
AVERAGE	2.58	2.64		2.50	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.42		
PULL #2	3.53	3.36		
PULL #3	3.37	3.31		
PULL #4	3.44	3.20		
PULL #5	3.26	3.16		
TOTAL	16.84	16.45		
AVERAGE	3.36	3.29		

	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	4.24	4.29		4.14
PULL #2	4.15	4.18		4.22
PULL #3	4.18	4.19		4.18
PULL #4	4.26	4.29		4.24
PULL #5	4.11	4.20		4.20
TOTAL	20.94	21.15		20.98
AVERAGE	4.18	4.23		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461617.___0
FILE DATE AND TIME: 05/17/2005 07:09

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.024
The Average Y Centroid of the Five Target Set:	-0.011
The Average Point of Impact of the Five Target Set:	0.026
The Average Mean Radius of the Five Target Set:	0.609
The Distance from POA to Centroid Target #1:	0.239
The Distance from Centroid Target #2 to Centroid Target #1:	0.232
The Distance from Centroid Target #3 to Centroid Target #1:	0.337
The Distance from Centroid Target #4 to Centroid Target #1:	0.229
The Distance from Centroid Target #5 to Centroid Target #1:	0.350

SERIAL NUMBER: G6461617. __0

TARGET NUMBER: 1

FILE DATE: 05/17/2005

FILE TIME: 07:09

X CENTROID: 0.073

Y CENTROID: -0.228

POA TO CENTROID: 0.239

HORZ SPREAD: 1.842

VERT SPREAD: 3.074

GROUP SPREAD: 3.405

MIN RADIUS: 0.226

MAX RADIUS: 1.881

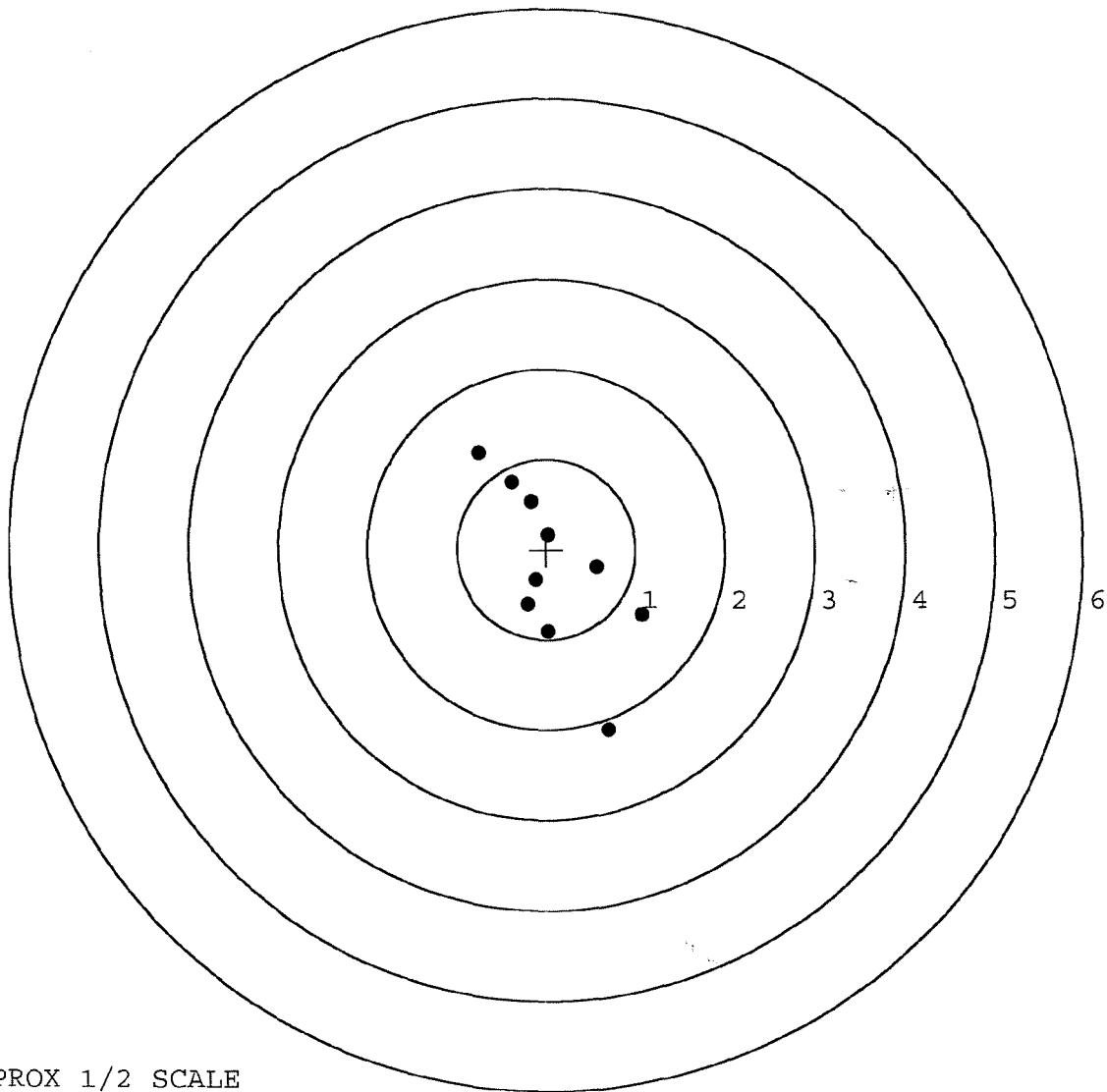
MEAN RADIUS: 0.871

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.080	-0.723
2:	0.702	-2.001
3:	0.562	-0.196
4:	0.026	-0.916
5:	-0.212	-0.617
6:	-0.125	-0.337
7:	0.024	0.166
8:	-0.175	0.532
9:	-0.391	0.741
10:	-0.762	1.073

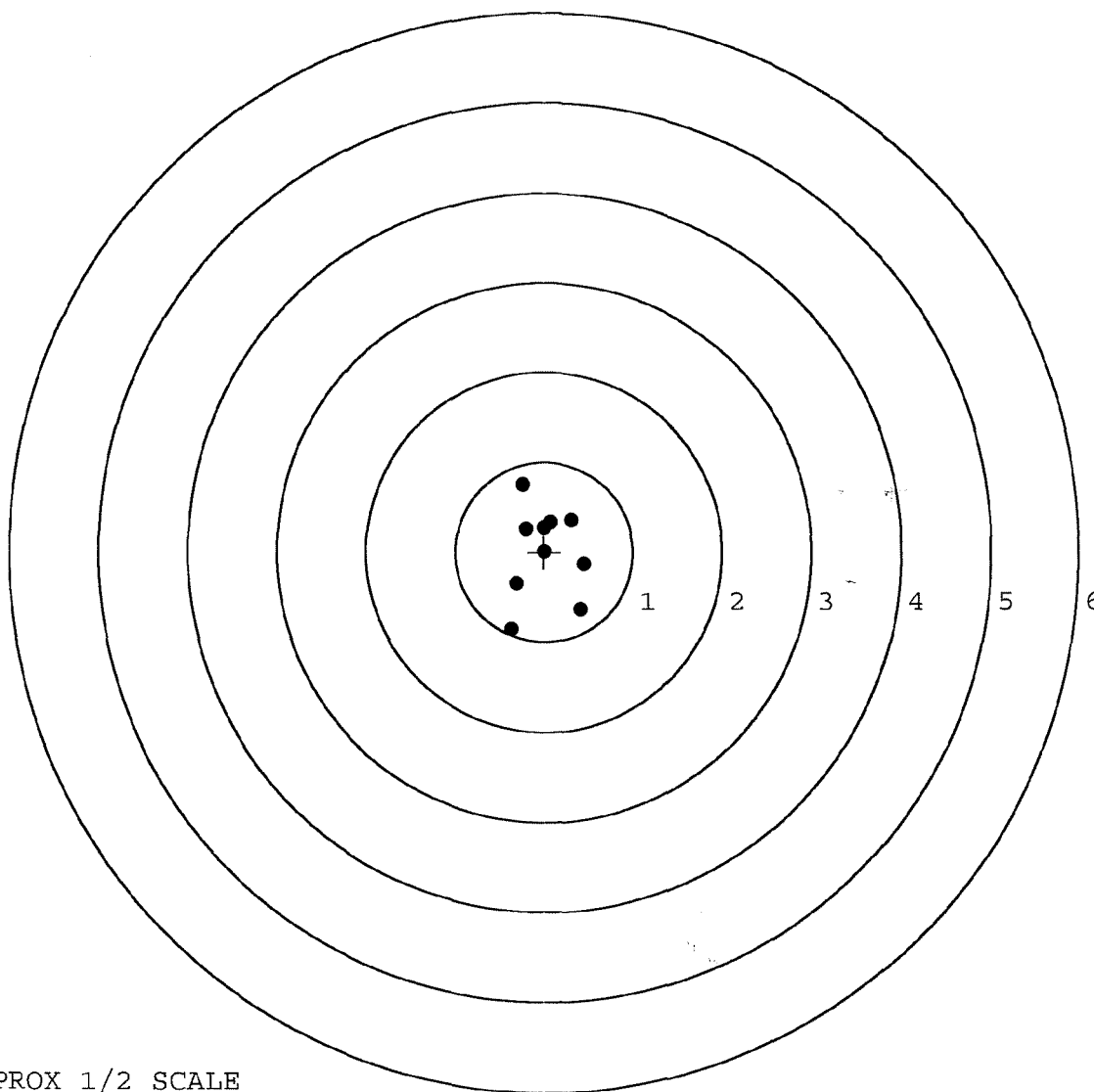


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461617. __0
TARGET NUMBER: 2
FILE DATE: 05/17/2005
FILE TIME: 07:09

X CENTROID: 0.009
Y CENTROID: -0.005
POA TO CENTROID: 0.010
HORZ SPREAD: 0.821
VERT SPREAD: 1.619
GROUP SPREAD: 1.624
MIN RADIUS: 0.009
MAX RADIUS: 0.948
MEAN RADIUS: 0.486
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.002	0.000
2:	0.410	-0.643
3:	-0.374	-0.872
4:	-0.318	-0.354
5:	0.447	-0.138
6:	-0.004	0.267
7:	-0.207	0.258
8:	-0.245	0.747
9:	0.303	0.355
10:	0.074	0.329



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461617. 0

TARGET NUMBER: 3

FILE DATE: 05/17/2005

FILE TIME: 07:09

X CENTROID: 0.117

Y CENTROID: 0.107

POA TO CENTROID: 0.158

HORZ SPREAD: 1.184

VERT SPREAD: 1.202

GROUP SPREAD: 1.325

MIN RADIUS: 0.157

MAX RADIUS: 0.784

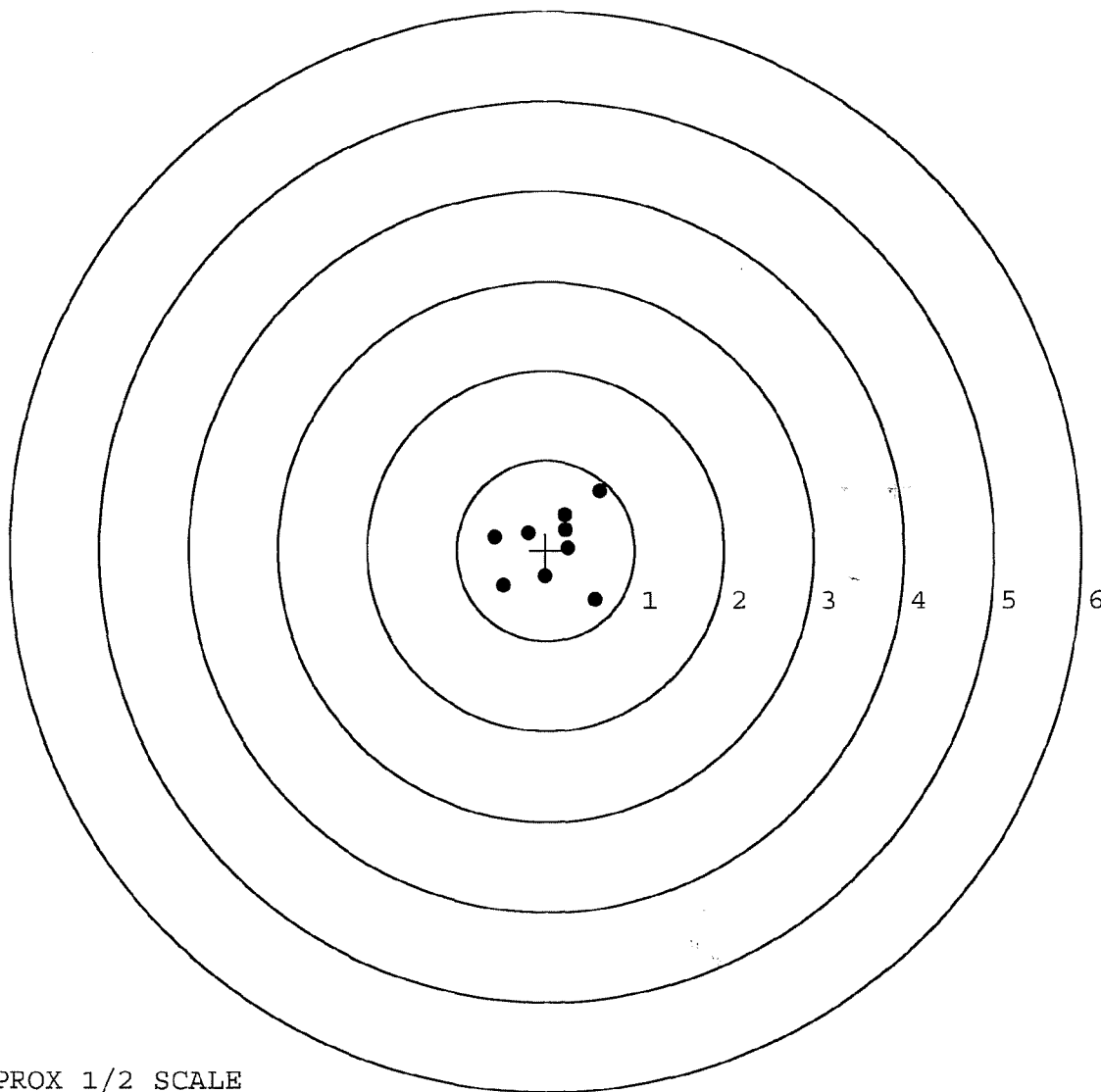
MEAN RADIUS: 0.509

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.551	-0.546
2:	0.606	0.656
3:	0.606	0.656
4:	-0.015	-0.291
5:	-0.482	-0.390
6:	-0.578	0.147
7:	-0.200	0.187
8:	0.210	0.396
9:	0.216	0.228
10:	0.251	0.024

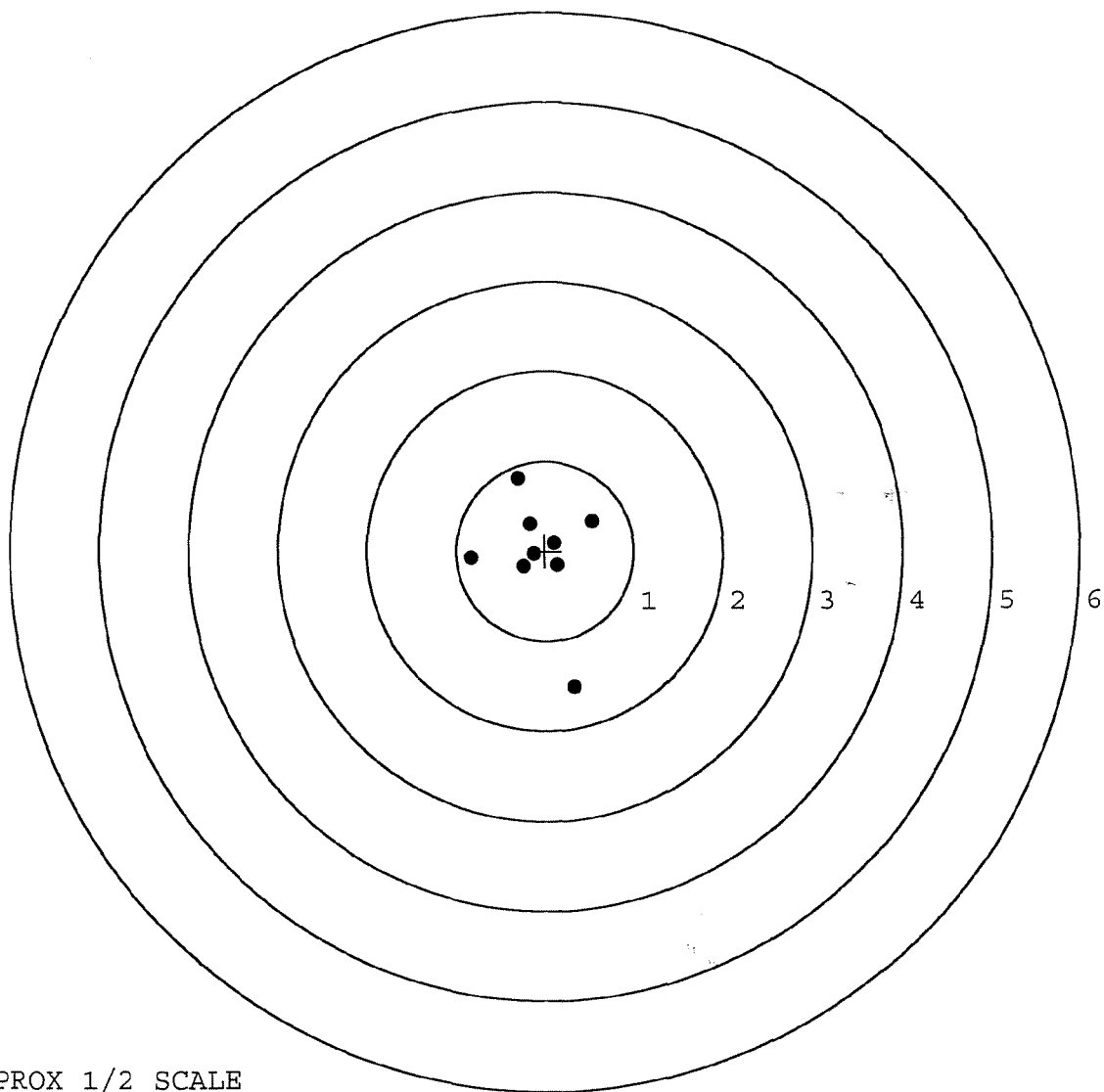


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461617. 0
TARGET NUMBER: 4
FILE DATE: 05/17/2005
FILE TIME: 07:09

X CENTROID: -0.049
Y CENTROID: -0.034
POA TO CENTROID: 0.059
HORZ SPREAD: 1.363
VERT SPREAD: 2.329
GROUP SPREAD: 2.416
MIN RADIUS: 0.084
MAX RADIUS: 1.531
MEAN RADIUS: 0.520
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.330	-1.517
2:	-0.830	-0.077
3:	-0.313	0.812
4:	0.533	0.336
5:	-0.177	0.305
6:	0.139	-0.160
7:	-0.245	-0.178
8:	0.104	0.088
9:	0.104	0.088
10:	-0.133	-0.037



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461617. __0

TARGET NUMBER: 5

FILE DATE: 05/17/2005

FILE TIME: 07:09

X CENTROID: -0.029

Y CENTROID: 0.107

POA TO CENTROID: 0.111

HORZ SPREAD: 1.207

VERT SPREAD: 1.955

GROUP SPREAD: 1.966

MIN RADIUS: 0.226

MAX RADIUS: 1.120

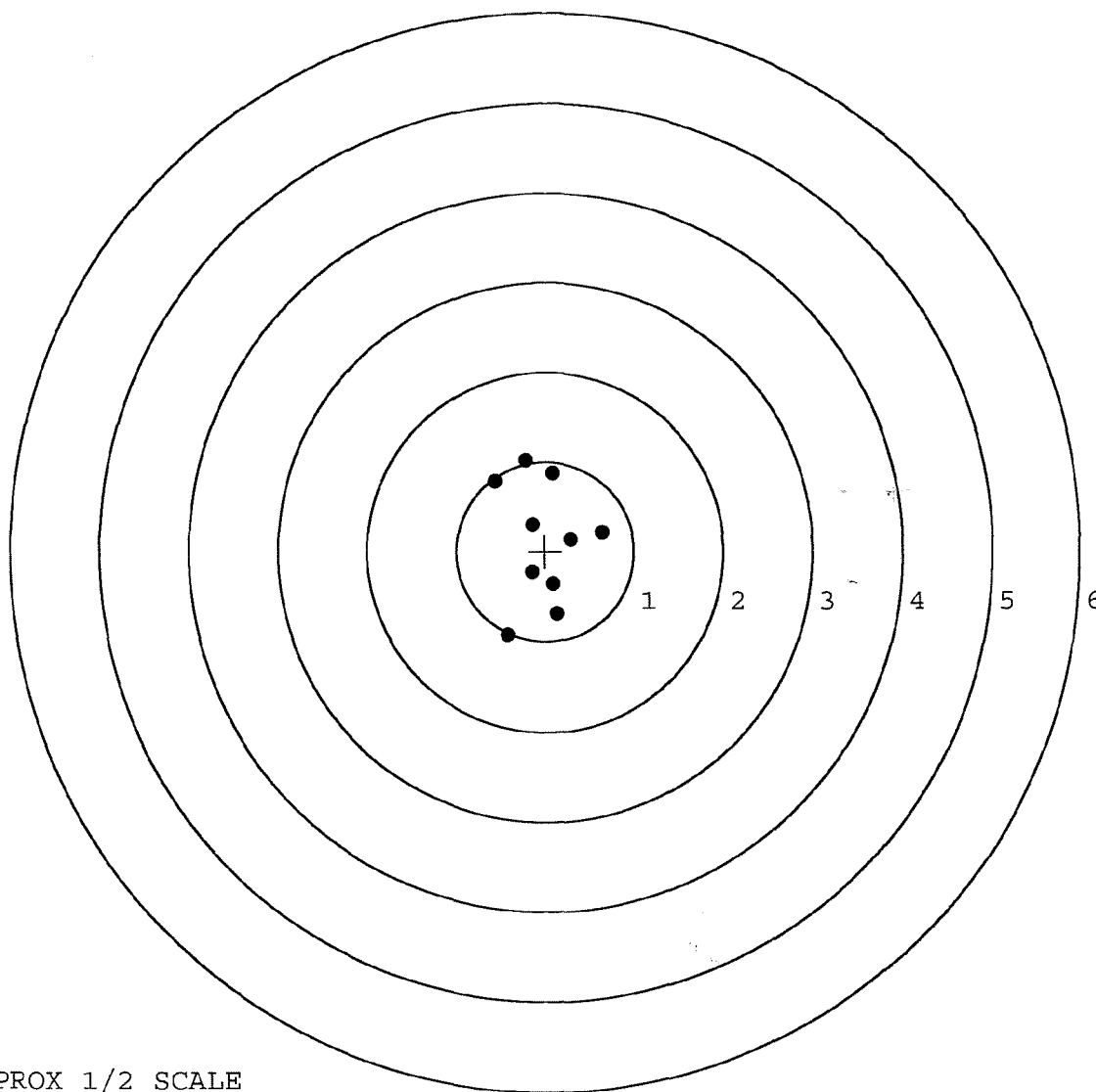
MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.640	0.220
2:	0.293	0.135
3:	-0.151	0.297
4:	-0.153	-0.237
5:	0.089	-0.372
6:	0.129	-0.701
7:	0.084	0.867
8:	-0.225	1.016
9:	-0.567	0.785
10:	-0.429	-0.939



TARGET APPROX 1/2 SCALE