

G 646 1623

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

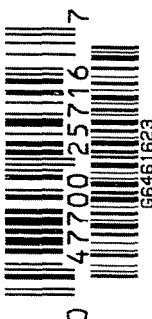
- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



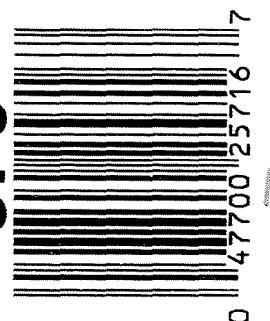
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461623

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.



4/7/2005 2:48:09 PM

Original

8

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 # G6461623

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 INSPECTED	4-18-05	AC
610	DIS-ASSEMBLE GUN		4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 20 2005 OPERATOR <u>BD</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	WJ
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-16-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-16-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-16-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-16-05	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>7 1/2</u> <u>7 1/2</u> <u>7 1/2</u>	5-19-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 1/2</u> <u>3 1/2</u> <u>3 1/2</u>	5-19-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	5-19-05	AC
	J) ASSEMBLE STOCK		5-16-05	RT
	K) ASSEMBLE SWIVEL STUDS		5-19-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-16-05	RT
	M) IRON SIGHT ALIGNMENT		5-16-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-16-05	RT
640	GALLERY TEST AND TARGET	PASS FAIL	5-17-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-17-05	AC
655	FINAL INSPECTION A) HEADSPACE		5-19-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u> <u>2.50</u> <u>2.89</u> <u>2.94</u> <u>2.75</u>	5-19-05	AC
	C) FUNCTION		5-19-05	AC
660	PACK		5/23/05	RT

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	2.32	2.50		2.54	
PULL #2	2.38	2.55		2.69	
PULL #3	2.35	2.64		2.50	
PULL #4	2.32	2.64		2.50	
PULL #5	2.28	2.63		2.52	
TOTAL	11.65	12.96		12.75	
AVERAGE	2.33	2.59		2.55	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.21		
PULL #2	3.01	3.24		
PULL #3	3.35	3.22		
PULL #4	3.25	3.19		
PULL #5	3.29	3.10		
TOTAL	15.94	15.96		
AVERAGE	3.18	3.19		

	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	4.20		4.17
PULL #2	4.19	4.34		4.13
PULL #3	4.22	4.14		4.26
PULL #4	4.30	4.29		4.18
PULL #5	4.31	4.30		4.16
TOTAL	21.20	21.27		20.90
AVERAGE	4.24	4.25		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461623.___0
FILE DATE AND TIME: 05/17/2005 07:15

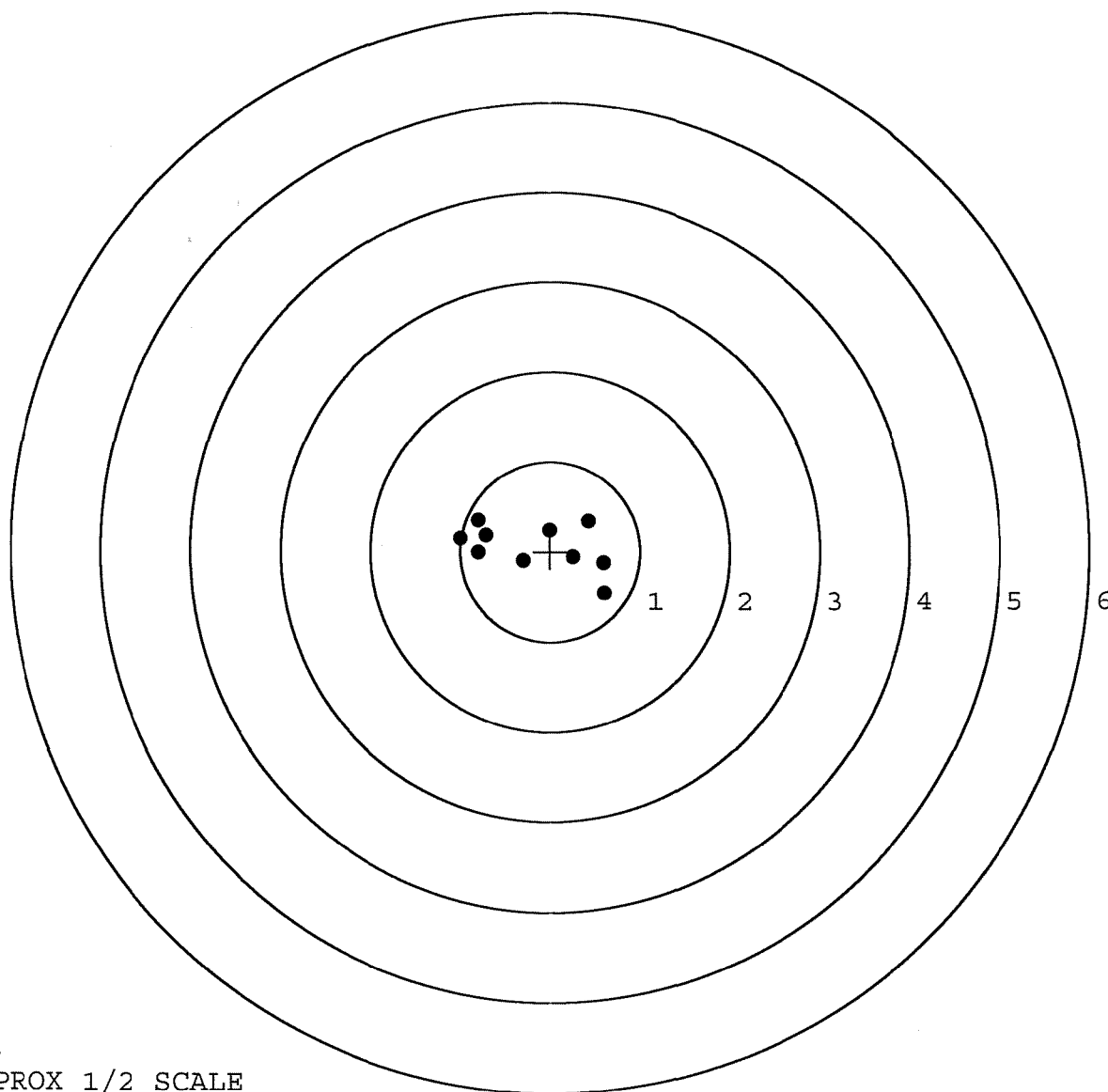
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.060
The Average Y Centroid of the Five Target Set:	0.015
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.658
The Distance from POA to Centroid Target #1:	0.181
The Distance from Centroid Target #2 to Centroid Target #1:	0.217
The Distance from Centroid Target #3 to Centroid Target #1:	0.150
The Distance from Centroid Target #4 to Centroid Target #1:	0.215
The Distance from Centroid Target #5 to Centroid Target #1:	0.053

SERIAL NUMBER: G6461623. 0
TARGET NUMBER: 1
FILE DATE: 05/17/2005
FILE TIME: 07:15

X CENTROID: -0.174
Y CENTROID: 0.048
POA TO CENTROID: 0.181
HORZ SPREAD: 1.607
VERT SPREAD: 0.816
GROUP SPREAD: 1.719
MIN RADIUS: 0.202
MAX RADIUS: 0.933
MEAN RADIUS: 0.601
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.606	-0.463
2:	0.595	-0.133
3:	0.255	-0.061
4:	0.433	0.336
5:	-0.008	0.235
6:	-0.304	-0.106
7:	-0.800	-0.011
8:	-1.001	0.148
9:	-0.802	0.353
10:	-0.716	0.185

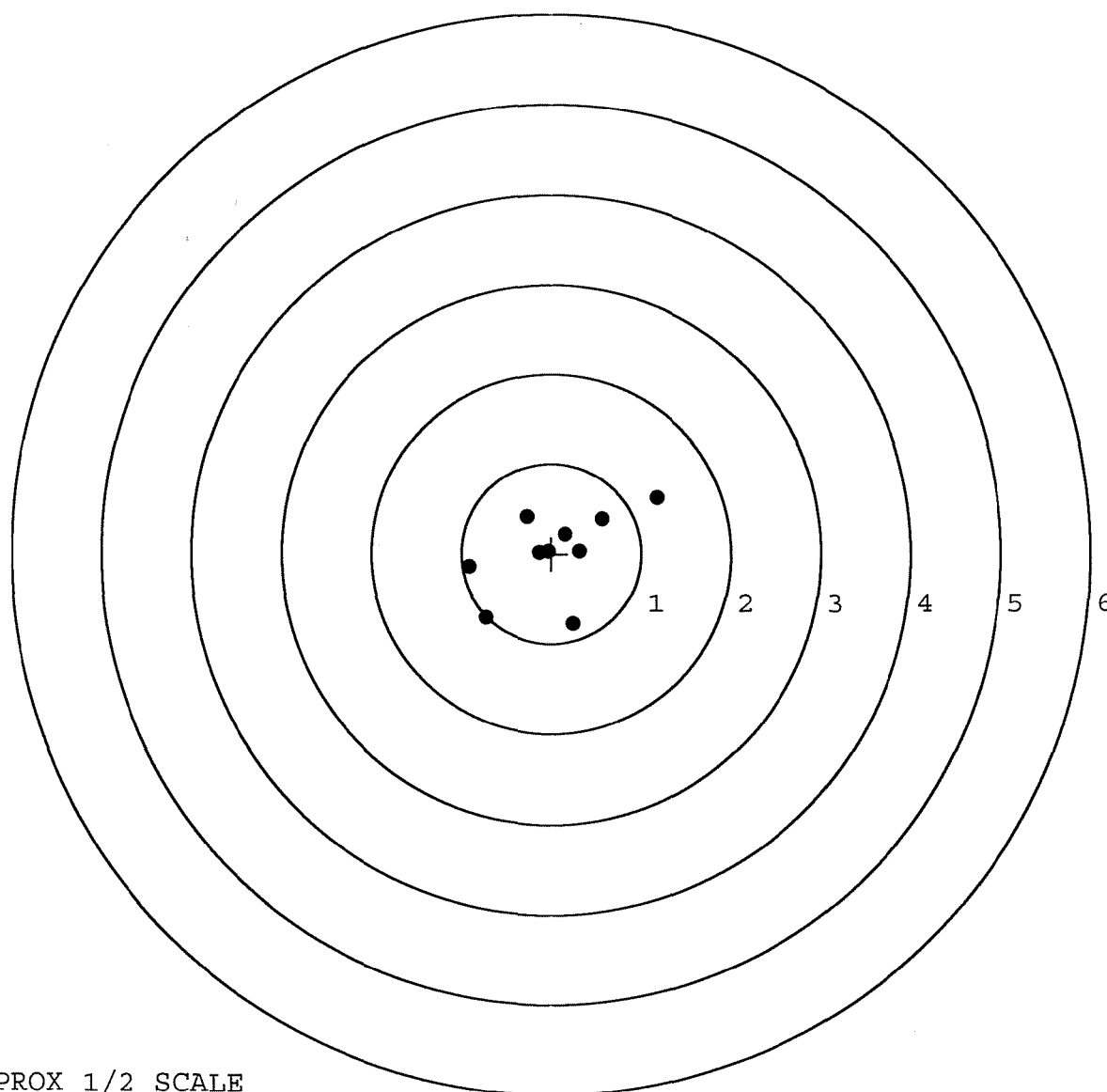


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461623. __0
TARGET NUMBER: 2
FILE DATE: 05/17/2005
FILE TIME: 07:15

POINT#	X	Y
1:	0.156	0.215
2:	0.319	0.033
3:	-0.034	0.028
4:	0.252	-0.784
5:	-0.726	-0.716
6:	-0.918	-0.148
7:	-0.270	0.412
8:	-0.138	0.017
9:	0.570	0.383
10:	1.176	0.619

X CENTROID: 0.039
Y CENTROID: 0.006
POA TO CENTROID: 0.039
HORZ SPREAD: 2.094
VERT SPREAD: 1.403
GROUP SPREAD: 2.324
MIN RADIUS: 0.076
MAX RADIUS: 1.292
MEAN RADIUS: 0.607
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461623. 0

TARGET NUMBER: 3

FILE DATE: 05/17/2005

FILE TIME: 07:15

X CENTROID: -0.062

Y CENTROID: -0.052

POA TO CENTROID: 0.081

HORZ SPREAD: 1.599

VERT SPREAD: 1.848

GROUP SPREAD: 1.976

MIN RADIUS: 0.160

MAX RADIUS: 1.064

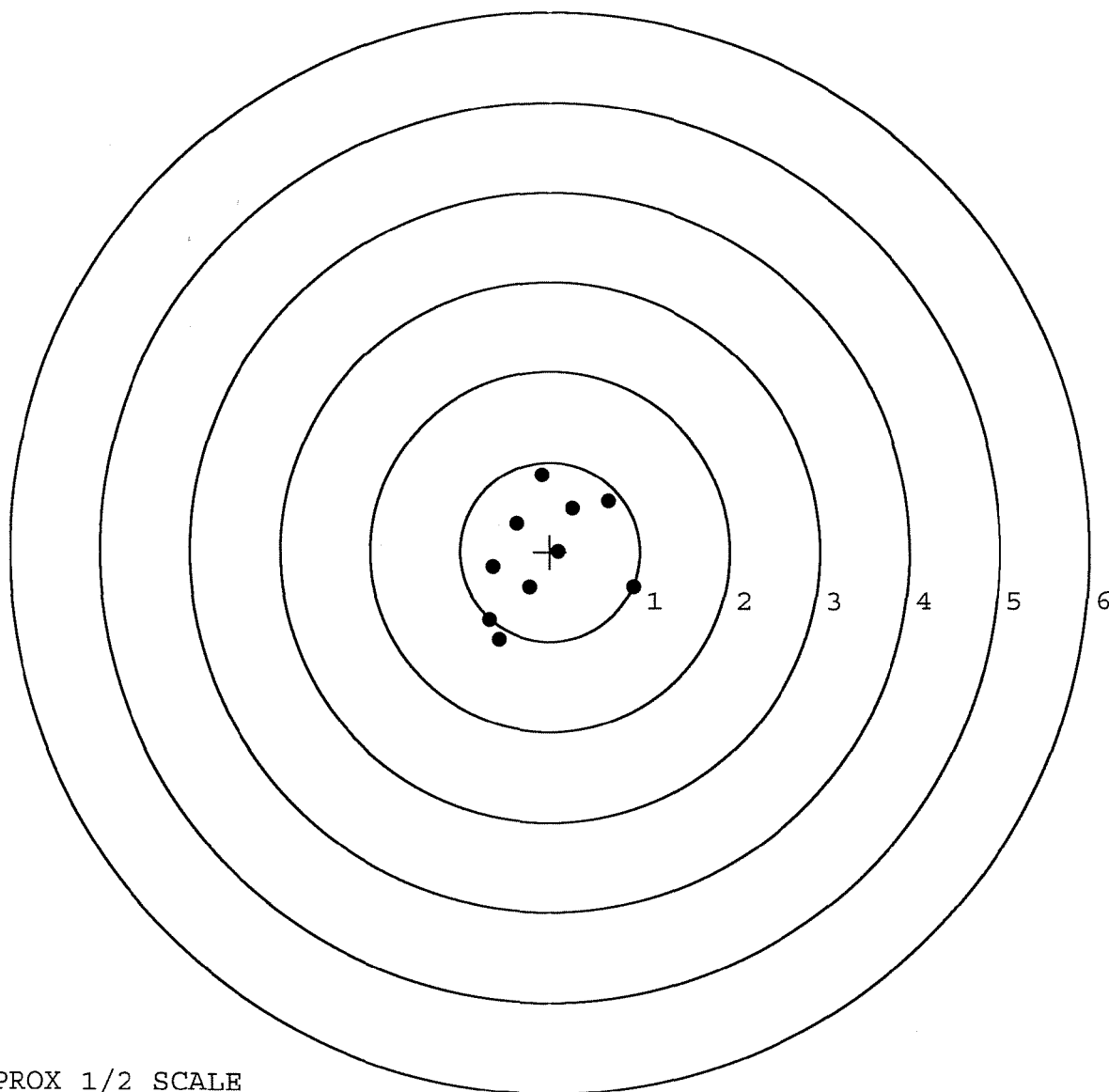
MEAN RADIUS: 0.714

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.931	-0.395
2:	0.658	0.562
3:	0.257	0.484
4:	0.091	-0.004
5:	-0.367	0.313
6:	-0.090	0.859
7:	-0.230	-0.398
8:	-0.634	-0.180
9:	-0.668	-0.769
10:	-0.566	-0.989

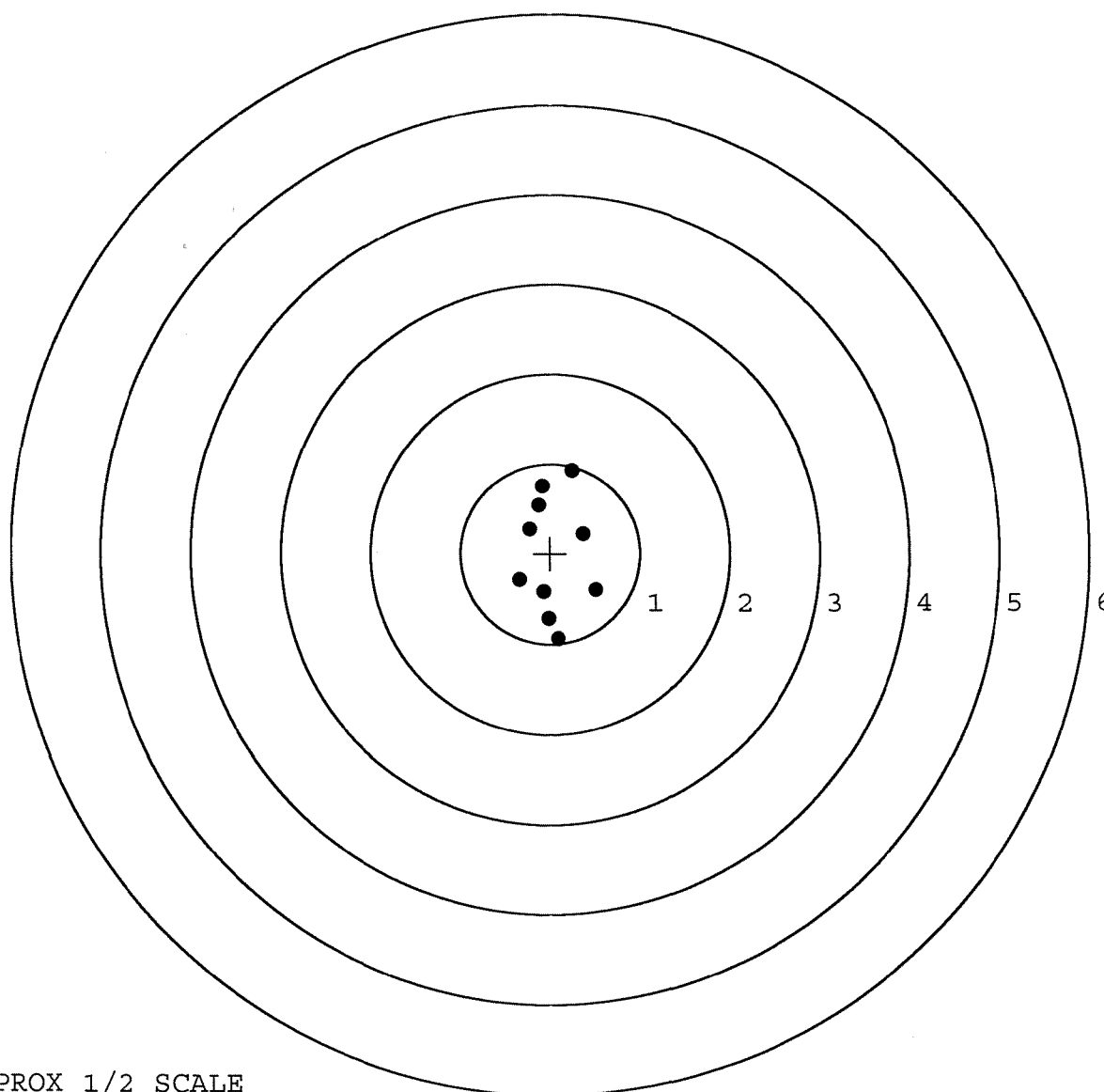


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461623. __0
 TARGET NUMBER: 4
 FILE DATE: 05/17/2005
 FILE TIME: 07:15

X CENTROID: 0.032
 Y CENTROID: -0.012
 POA TO CENTROID: 0.035
 HORZ SPREAD: 0.858
 VERT SPREAD: 1.873
 GROUP SPREAD: 1.880
 MIN RADIUS: 0.388
 MAX RADIUS: 0.958
 MEAN RADIUS: 0.629
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.090	-0.952
2:	0.513	-0.412
3:	-0.345	-0.296
4:	-0.078	-0.430
5:	0.372	0.218
6:	0.250	0.921
7:	-0.090	0.749
8:	-0.129	0.539
9:	-0.233	0.271
10:	-0.026	-0.727

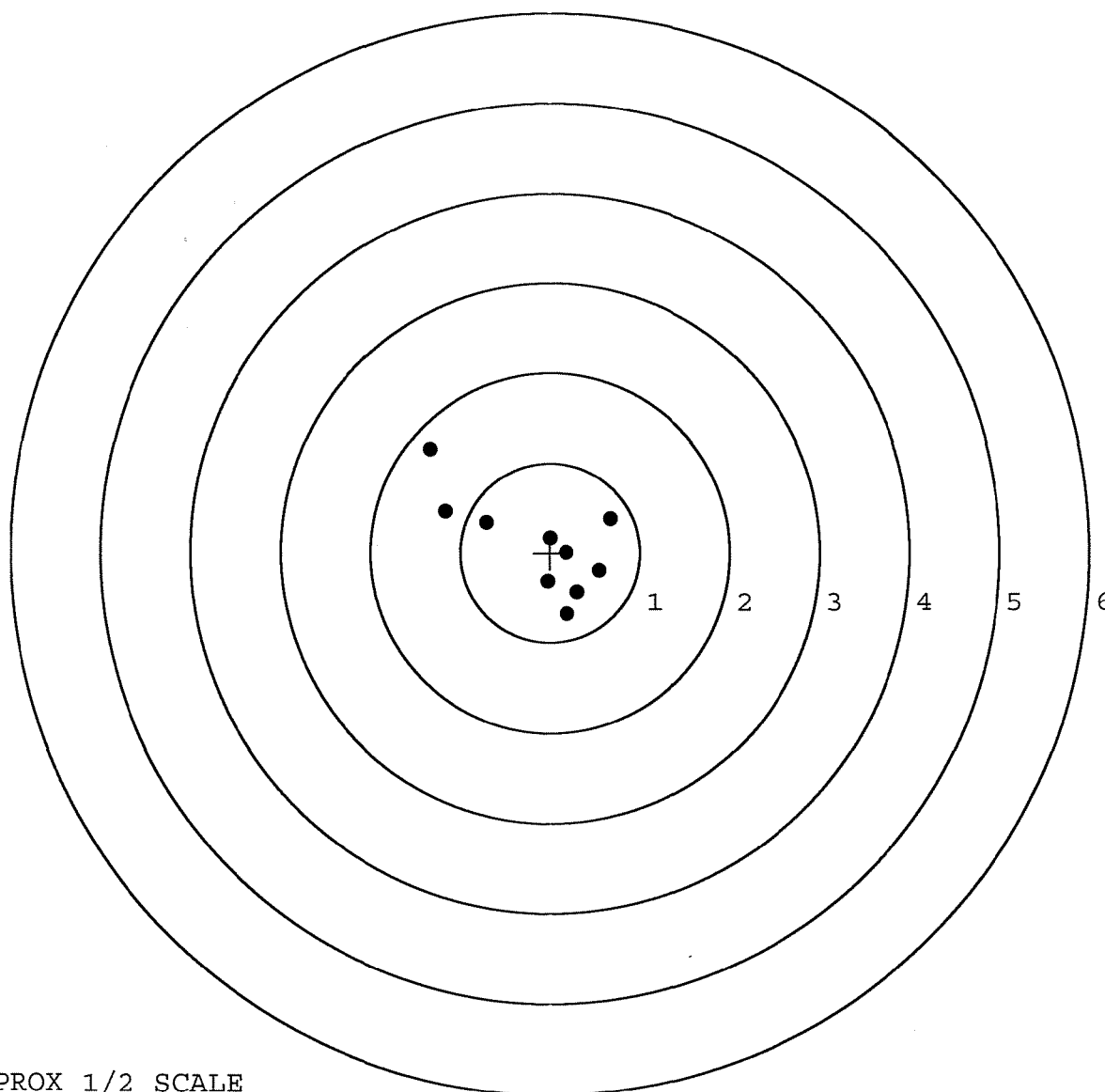


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461623. 0
TARGET NUMBER: 5
FILE DATE: 05/17/2005
FILE TIME: 07:15

X CENTROID: -0.135
Y CENTROID: 0.084
POA TO CENTROID: 0.159
HORZ SPREAD: 2.017
VERT SPREAD: 1.847
GROUP SPREAD: 2.399
MIN RADIUS: 0.153
MAX RADIUS: 1.611
MEAN RADIUS: 0.737
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.338	1.155
2:	-1.171	0.466
3:	-0.708	0.336
4:	-0.004	0.164
5:	0.184	0.000
6:	0.547	-0.204
7:	0.679	0.376
8:	0.193	-0.692
9:	-0.029	-0.321
10:	0.302	-0.441



TARGET APPROX 1/2 SCALE