

G4461631

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



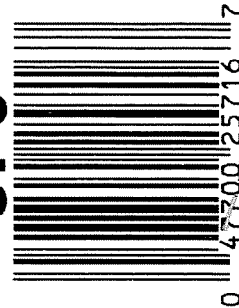
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461631

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.



8/11/2005 9:26:28 AM

Copy

09

Original

25716

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



.MA25716

Shop Order: SW5716 - SEP



.ABSW5716 - SEP

Start Date: 5/27/2005

Finish Date: 9/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004110512

0540

01PC001

Flat Black Powder Coat, Barrel and



0004110502

0560

89SWS1

Reassemble Action.



0004110503

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461631

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-9-05	RTZ
440	PROOF		9-12-05	RTZ
460	CHECK HEADSPACE		9-13-05	RTZ
470	DIS-ASSEMBLE ACTION		9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	1/80	9/14/05	und
500	ROLLMARK CALIBER		9-14-05	CW
510	DRILL AND TAP SIGHT HOLES		9-13-05	TRW
520	GOFF BLAST BBL / REC		9-19-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-28-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-28-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-28-05	DA
	D) OIL FIRING PIN ASSEMBLY		9-30-05	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>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	10-11-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		9-30-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-30-05	RTZ
	M) IRON SIGHT ALIGNMENT		9-30-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-30-05	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS PASS FAIL FAIL	10-5-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION	10-5-05	R.P.
660	INSPECT FOR LIVE AMMO		10-5-05	RP
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u> <u>2.66</u> <u>2.68</u> <u>2.87</u> <u>2.75</u>	10-7-05	BC
	C) FUNCTION		10-11-05	Ac
690	PACK		10-12-05	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 _____

9/28/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.48	2.68		2.40	
PULL #2	2.55	2.77		2.62	
PULL #3	2.57	2.88		2.71	
PULL #4	2.65	2.59		2.64	
PULL #5	2.55	2.83		2.59	
TOTAL	12.80	13.75		12.96	
AVERAGE	2.56	2.75		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.20		
PULL #2	3.11	3.35		
PULL #3	3.49	3.40		
PULL #4	3.20	3.30		
PULL #5	3.47	3.20		
TOTAL	16.60	16.45		
AVERAGE	3.32	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	4.03	3.91		3.97
PULL #2	4.18	4.09		4.02
PULL #3	3.47	4.17		4.20
PULL #4	4.12	4.08		4.29
PULL #5	4.27	4.20		4.19
TOTAL	20.07	20.45		20.67
AVERAGE	4.01	4.09		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461631.___0
FILE DATE AND TIME: 10/05/2005 11:15

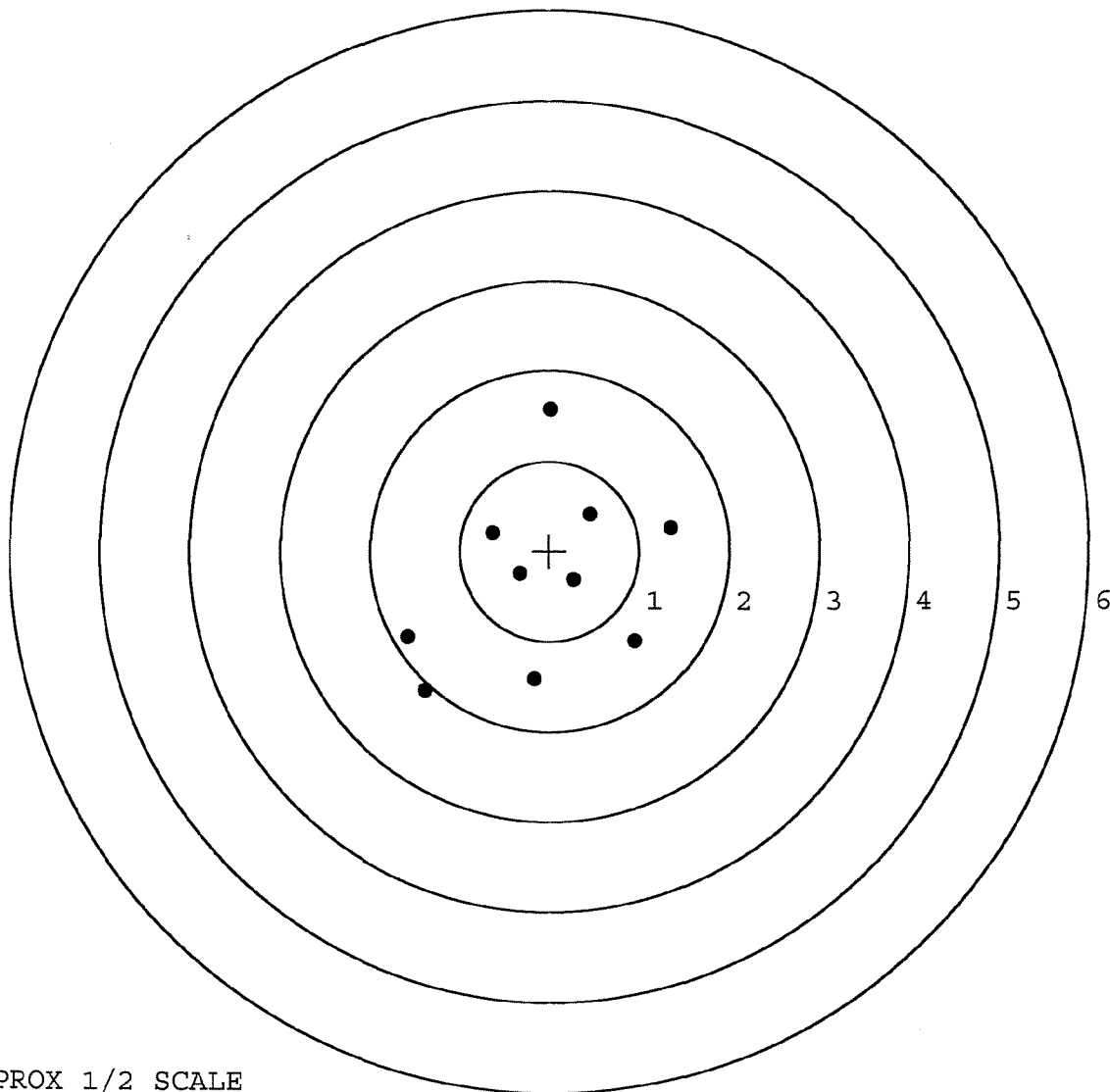
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.094
The Average Y Centroid of the Five Target Set:	-0.132
The Average Point of Impact of the Five Target Set:	0.162
The Average Mean Radius of the Five Target Set:	0.978
The Distance from POA to Centroid Target #1:	0.327
The Distance from Centroid Target #2 to Centroid Target #1:	0.523
The Distance from Centroid Target #3 to Centroid Target #1:	0.262
The Distance from Centroid Target #4 to Centroid Target #1:	0.952
The Distance from Centroid Target #5 to Centroid Target #1:	0.249

SERIAL NUMBER: G6461631. __0
TARGET NUMBER: 1
FILE DATE: 10/05/2005
FILE TIME: 11:15

X CENTROID: -0.109
Y CENTROID: -0.308
POA TO CENTROID: 0.327
HORZ SPREAD: 2.930
VERT SPREAD: 3.121
GROUP SPREAD: 3.423
MIN RADIUS: 0.230
MAX RADIUS: 1.880
MEAN RADIUS: 1.148
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.167	-1.426
2:	0.951	-1.001
3:	0.267	-0.325
4:	-0.333	-0.254
5:	-0.643	0.203
6:	0.453	0.410
7:	1.345	0.258
8:	0.014	1.568
9:	-1.585	-0.959
10:	-1.392	-1.553



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461631. 0

TARGET NUMBER: 2

FILE DATE: 10/05/2005

FILE TIME: 11:15

POINT#	X	Y
1:	1.298	-0.456
2:	0.583	-0.223
3:	0.224	-0.213
4:	-0.580	0.087
5:	-0.052	0.385
6:	0.274	0.901
7:	-0.917	-1.329
8:	-1.399	-2.142
9:	0.448	-2.211
10:	0.891	-2.766

X CENTROID: 0.077

Y CENTROID: -0.797

POA TO CENTROID: 0.800

HORZ SPREAD: 2.697

VERT SPREAD: 3.667

GROUP SPREAD: 3.719

MIN RADIUS: 0.602

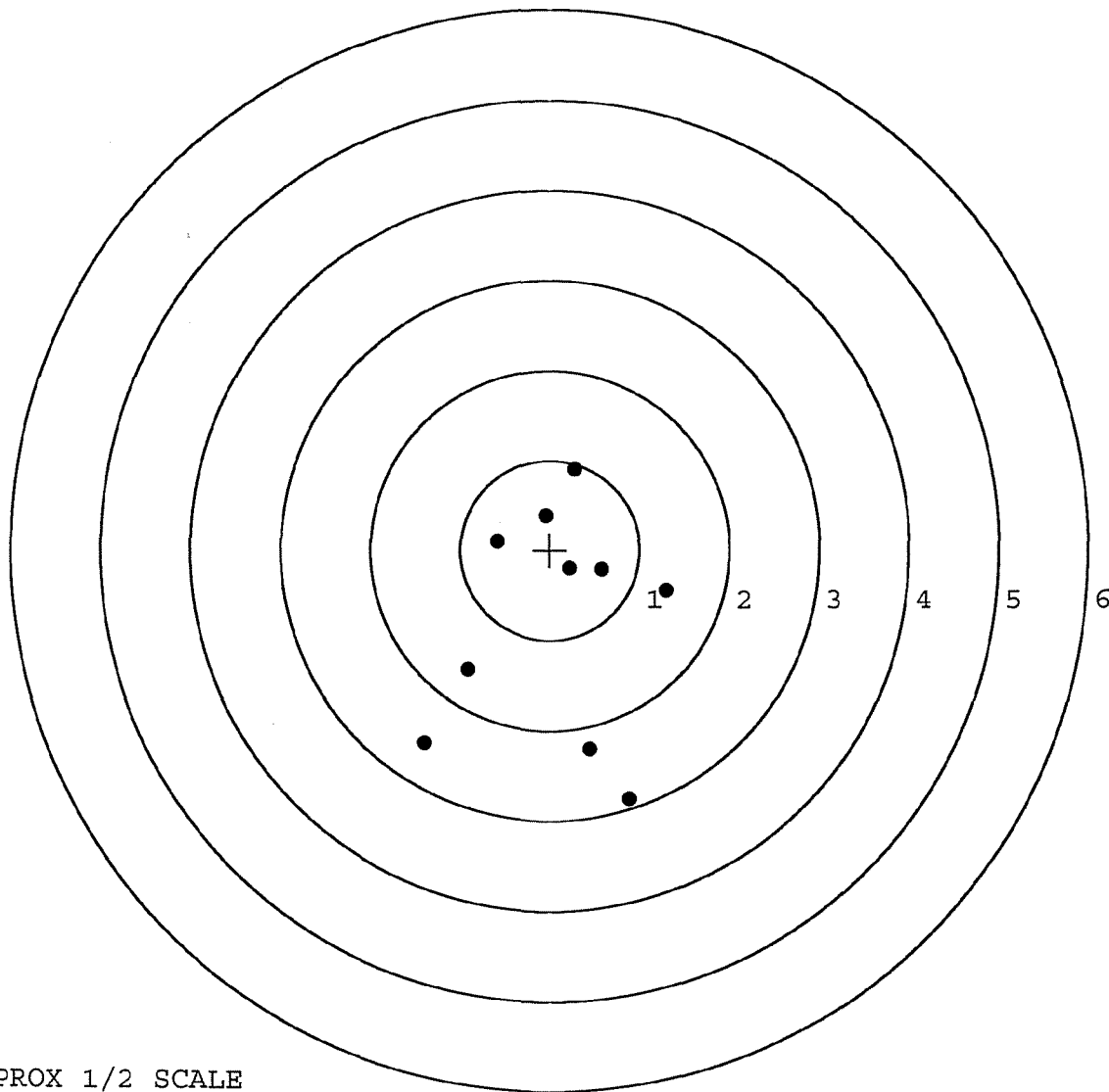
MAX RADIUS: 2.131

MEAN RADIUS: 1.335

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 7

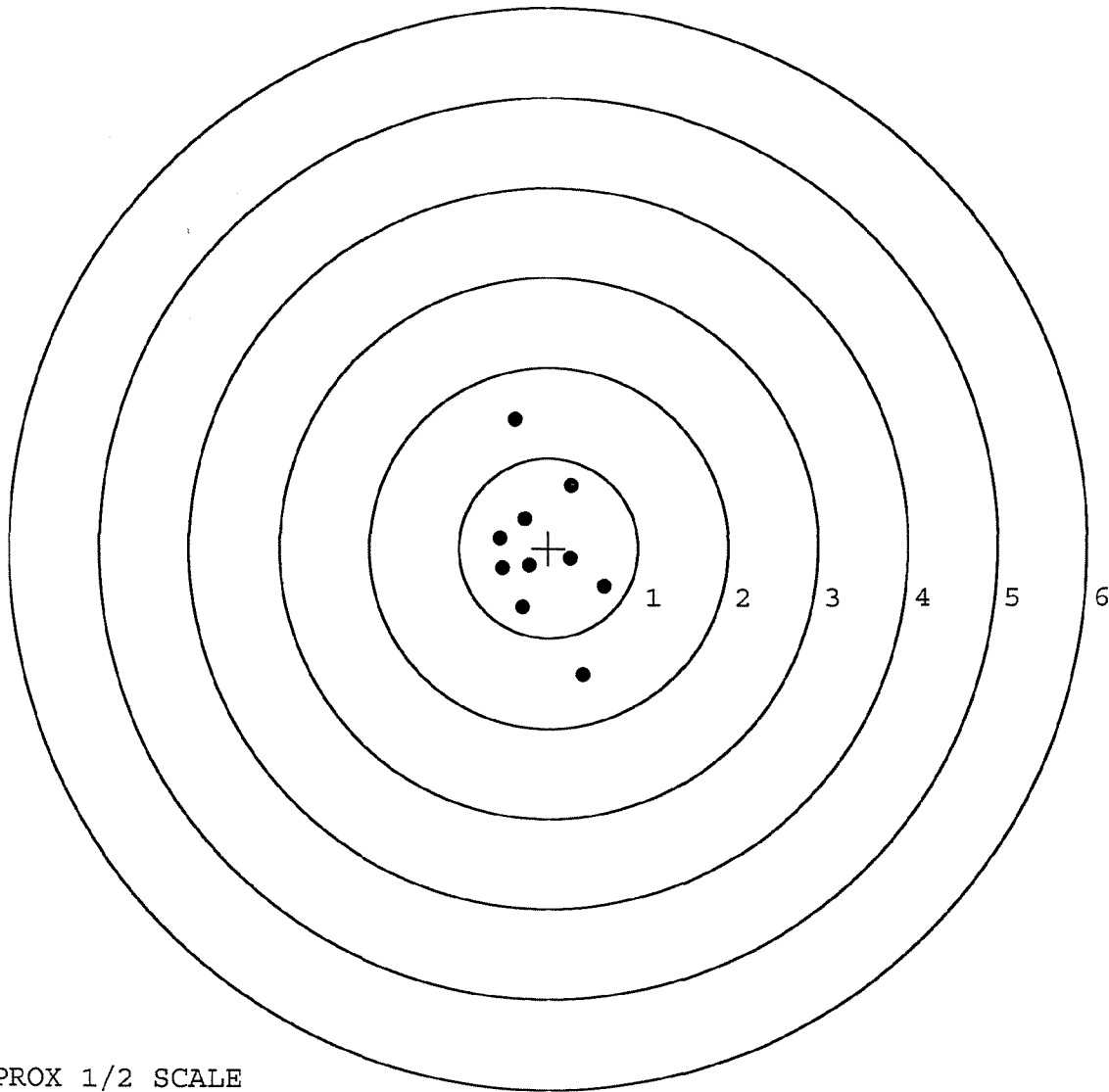


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461631. __0
TARGET NUMBER: 3
FILE DATE: 10/05/2005
FILE TIME: 11:15

X CENTROID: -0.072
Y CENTROID: -0.048
POA TO CENTROID: 0.087
HORZ SPREAD: 1.169
VERT SPREAD: 2.843
GROUP SPREAD: 2.944
MIN RADIUS: 0.208
MAX RADIUS: 1.509
MEAN RADIUS: 0.714
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.386	-1.414
2:	0.623	-0.433
3:	0.242	-0.115
4:	-0.287	-0.662
5:	-0.217	-0.198
6:	-0.516	-0.224
7:	-0.546	0.113
8:	-0.273	0.326
9:	0.249	0.694
10:	-0.380	1.429

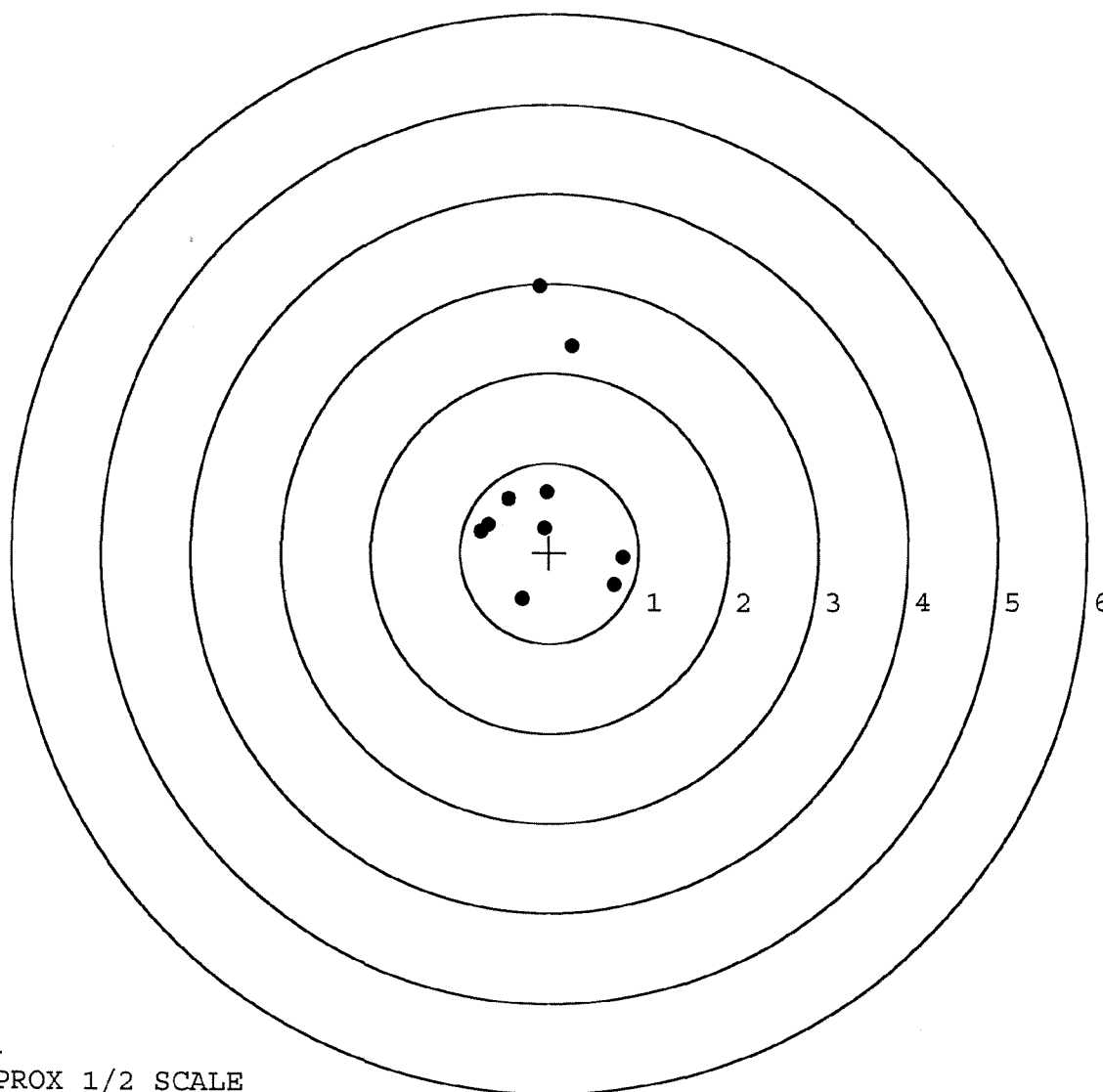


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461631. __0
TARGET NUMBER: 4
FILE DATE: 10/05/2005
FILE TIME: 11:15

X CENTROID: -0.064
Y CENTROID: 0.643
POA TO CENTROID: 0.646
HORZ SPREAD: 1.602
VERT SPREAD: 3.486
GROUP SPREAD: 3.491
MIN RADIUS: 0.044
MAX RADIUS: 2.327
MEAN RADIUS: 0.995
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.725	-0.366
2:	0.825	-0.060
3:	-0.301	-0.517
4:	-0.777	0.239
5:	-0.689	0.316
6:	-0.063	0.267
7:	-0.038	0.678
8:	-0.461	0.602
9:	0.247	2.301
10:	-0.109	2.969

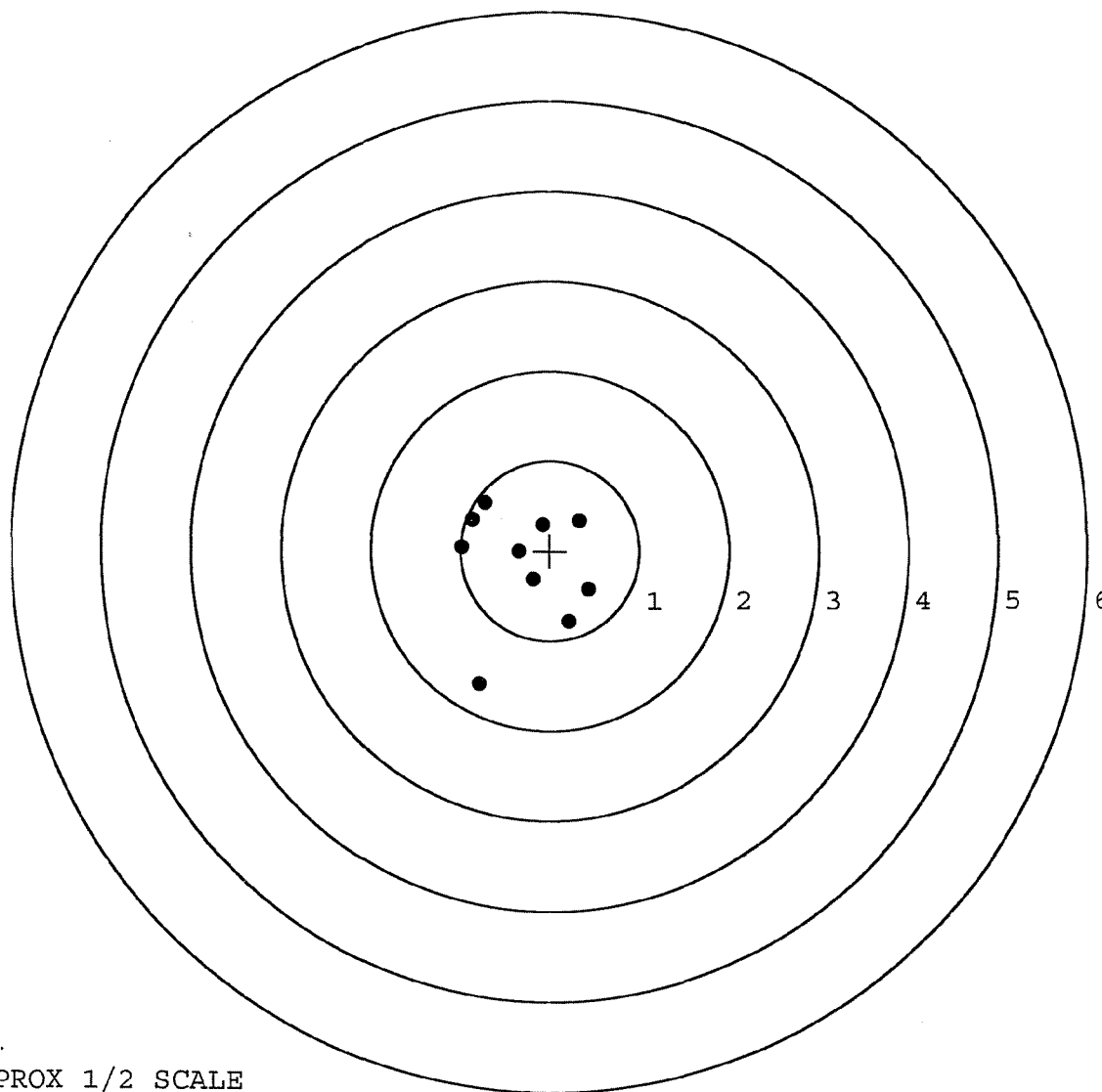


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461631. __0
TARGET NUMBER: 5
FILE DATE: 10/05/2005
FILE TIME: 11:15

X CENTROID: -0.301
Y CENTROID: -0.148
POA TO CENTROID: 0.335
HORZ SPREAD: 1.419
VERT SPREAD: 2.022
GROUP SPREAD: 2.144
MIN RADIUS: 0.145
MAX RADIUS: 1.424
MEAN RADIUS: 0.696
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.789	-1.486
2:	0.219	-0.791
3:	0.431	-0.428
4:	0.338	0.338
5:	-0.076	0.289
6:	-0.348	-0.011
7:	-0.192	-0.323
8:	-0.732	0.536
9:	-0.870	0.347
10:	-0.988	0.045



TARGET APPROX 1/2 SCALE