

G646 1638

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



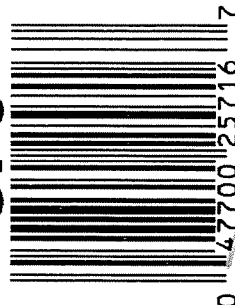
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461638

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.



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 # G6461638

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	APR 21 2005	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>B.J.</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	WR
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-18-05	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 lbs</u> <u>7 lbs</u> <u>7 lbs</u>	5-31-05	<i>A</i>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-31-05	<i>A</i>
	H) TRIGGER PULL TEST AND RETAINABILITY		5-27-05	<i>Ac</i>
	I) FIRING PIN INDENT .020 MIN	<u>.0241</u> <u>.024</u> <u>.024</u>	5-31-05	<i>A</i>
	J) ASSEMBLE STOCK		5-16-05	<i>RT</i>
	K) ASSEMBLE SWIVEL STUDS		5-31-05	<i>A</i>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-16-05	<i>RT</i>
	M) IRON SIGHT ALIGNMENT		5-16-05	<i>RT</i>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-16-05	<i>RT</i>
640	GALLERY TEST AND TARGET	PASS FAIL	5-20-05	<i>A</i>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-20-05	<i>TRW</i>
655	FINAL INSPECTION A) HEADSPACE		5-31-05	<i>Ac</i>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.43</u> <u>2.83</u> <u>2.76</u> <u>2.88</u>	5-27-05	<i>A</i>
	C) FUNCTION		5-31-05	<i>Ac</i>
660	PACK		6-1-05	<i>DA</i>

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	2.27	2.40		2.27	
PULL #2	2.43	2.60		2.12	
PULL #3	2.67	2.35		2.19	
PULL #4	2.86	2.20		2.10	
PULL #5	2.83	2.47		2.04	
TOTAL	13.06	12.02		10.72	
AVERAGE	2.61	2.40		2.14	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.53	3.14		
PULL #2	3.53	3.25		
PULL #3	3.22	3.00		
PULL #4	3.19	3.25		
PULL #5	3.39	3.09		
TOTAL	16.86	15.73		
AVERAGE	3.37	3.14		

	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	4.15	4.08		4.42
PULL #2	4.19	4.06		4.12
PULL #3	4.24	4.01		4.11
PULL #4	4.16	3.94		4.06
PULL #5	4.19	3.90		4.03
TOTAL	20.93	19.99		20.74
AVERAGE	4.18	3.99		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461638.___0
FILE DATE AND TIME: 05/20/2005 06:40

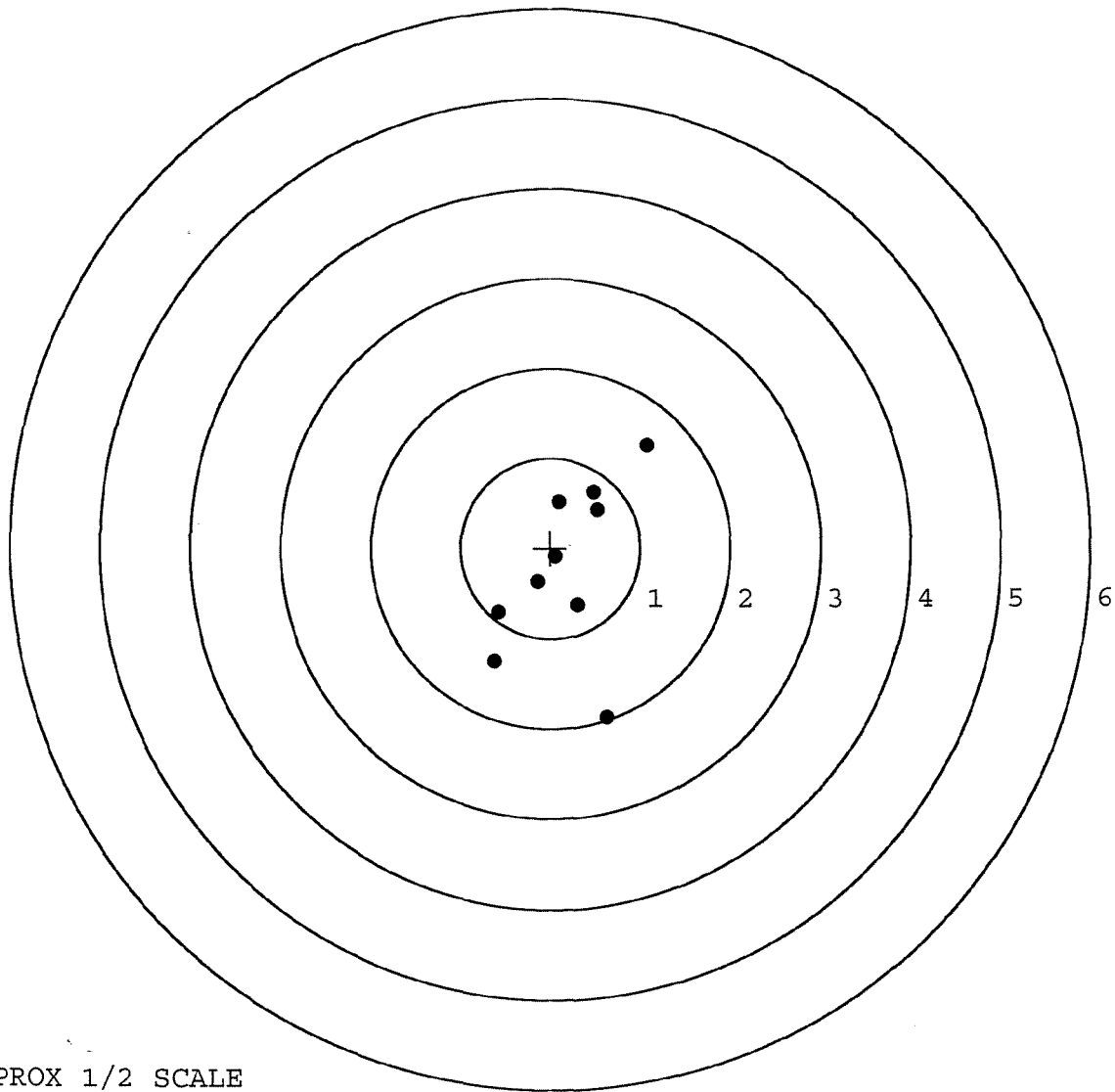
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.078
The Average Y Centroid of the Five Target Set:	0.000
The Average Point of Impact of the Five Target Set:	0.078
The Average Mean Radius of the Five Target Set:	0.768
The Distance from POA to Centroid Target #1:	0.290
The Distance from Centroid Target #2 to Centroid Target #1:	0.395
The Distance from Centroid Target #3 to Centroid Target #1:	0.156
The Distance from Centroid Target #4 to Centroid Target #1:	0.180
The Distance from Centroid Target #5 to Centroid Target #1:	0.545

SERIAL NUMBER: G6461638. 0
TARGET NUMBER: 1
FILE DATE: 05/20/2005
FILE TIME: 06:40

X CENTROID: 0.183
Y CENTROID: -0.225
POA TO CENTROID: 0.290
HORZ SPREAD: 1.700
VERT SPREAD: 3.022
GROUP SPREAD: 3.054
MIN RADIUS: 0.180
MAX RADIUS: 1.713
MEAN RADIUS: 0.890
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.486	0.624
2:	0.526	0.421
3:	0.099	0.513
4:	1.074	1.144
5:	0.056	-0.097
6:	0.306	-0.628
7:	0.631	-1.878
8:	-0.143	-0.380
9:	-0.581	-0.709
10:	-0.626	-1.257



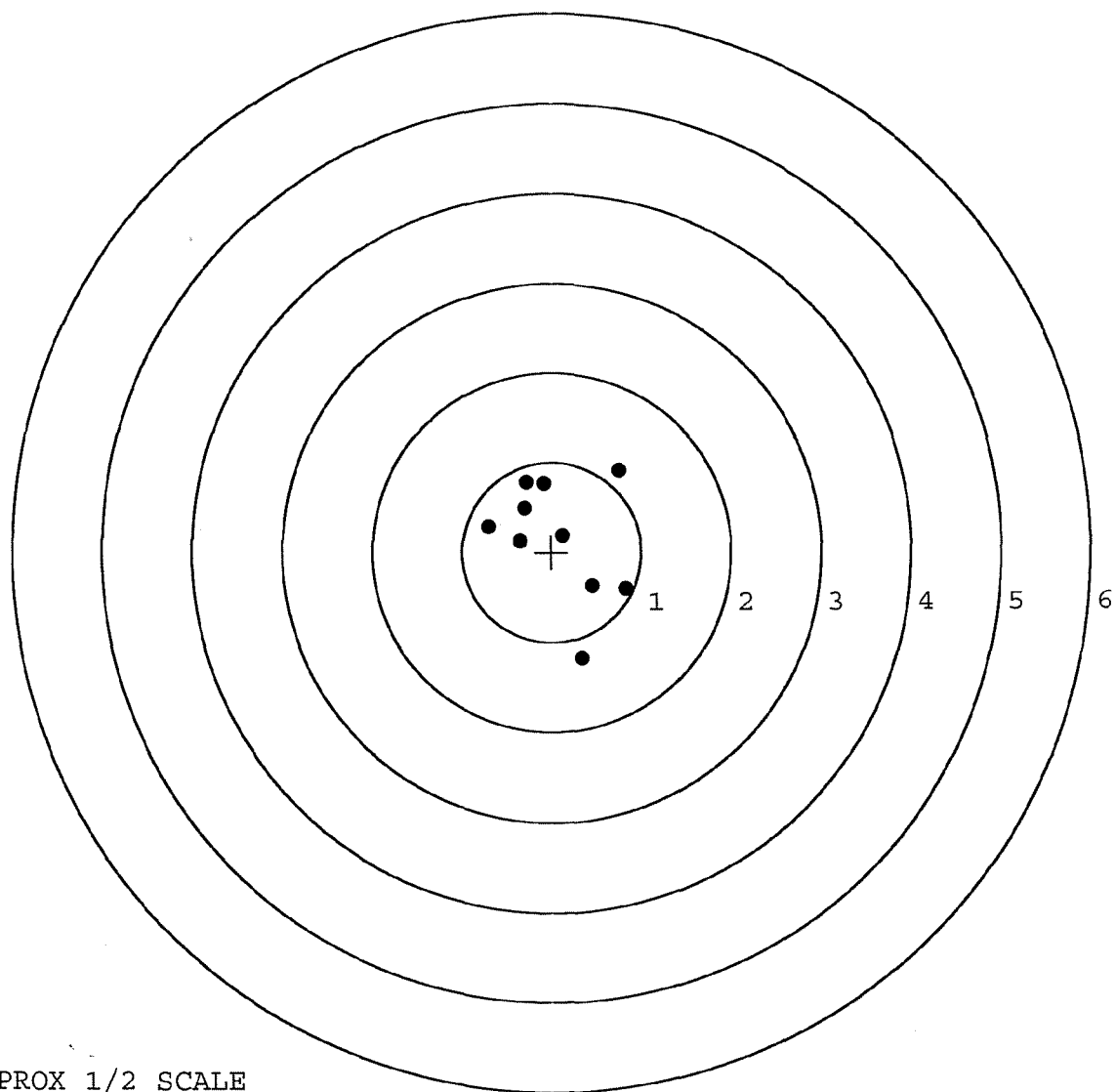
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461638. 0
TARGET NUMBER: 2
FILE DATE: 05/20/2005
FILE TIME: 06:40

X CENTROID: 0.077
Y CENTROID: 0.155
POA TO CENTROID: 0.173
HORZ SPREAD: 1.543
VERT SPREAD: 2.095
GROUP SPREAD: 2.134
MIN RADIUS: 0.053
MAX RADIUS: 1.368
MEAN RADIUS: 0.711

POINT#	X	Y
1:	0.754	0.909
2:	0.124	0.181
3:	-0.090	0.763
4:	-0.280	0.774
5:	-0.304	0.493
6:	-0.356	0.121
7:	-0.710	0.283
8:	0.454	-0.375
9:	0.833	-0.409
10:	0.346	-1.186

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

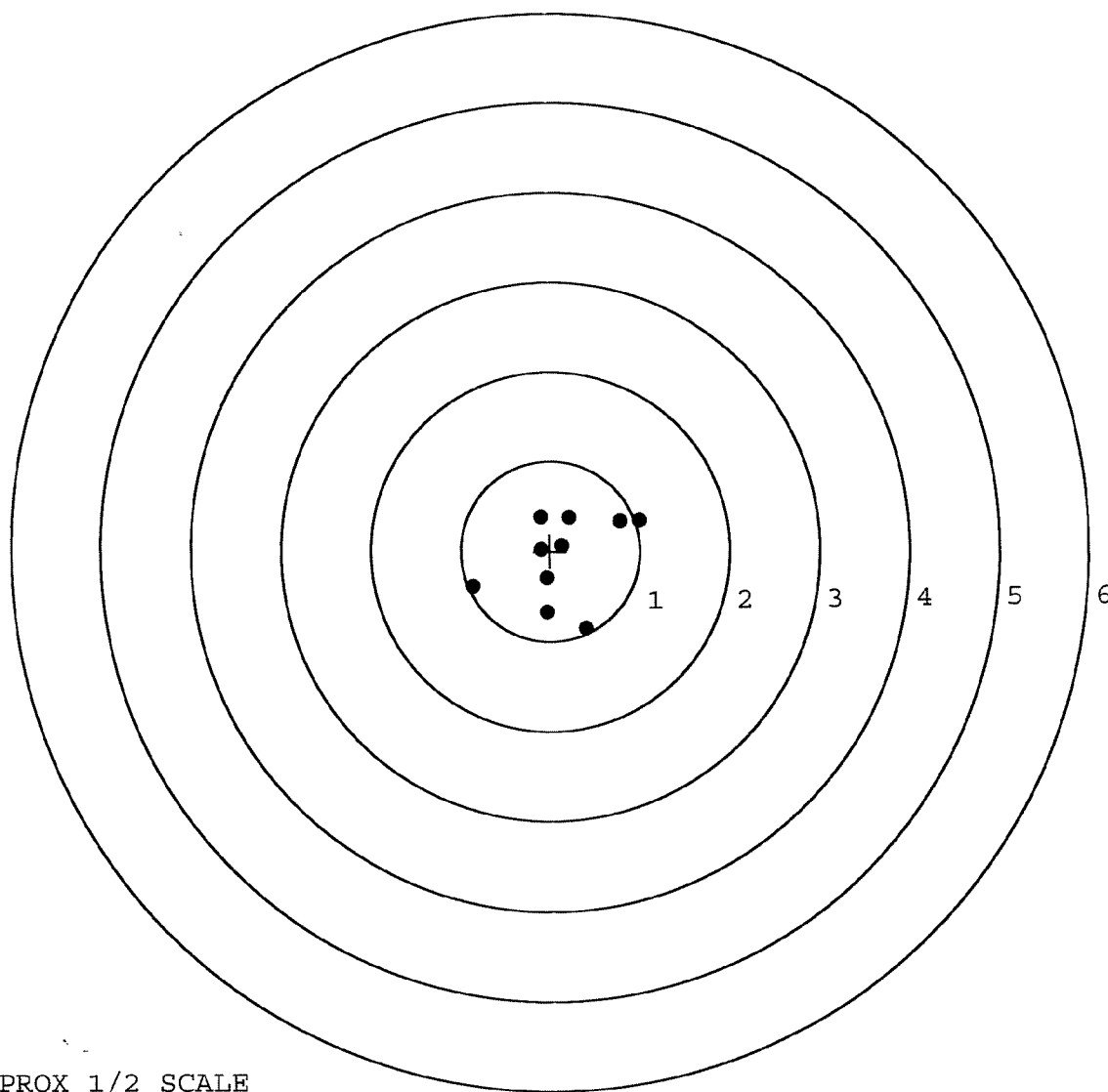


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461638.___0
TARGET NUMBER: 3
FILE DATE: 05/20/2005
FILE TIME: 06:40

X CENTROID: 0.135
Y CENTROID: -0.076
POA TO CENTROID: 0.155
HORZ SPREAD: 1.864
VERT SPREAD: 1.238
GROUP SPREAD: 1.998
MIN RADIUS: 0.133
MAX RADIUS: 1.052
MEAN RADIUS: 0.587
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.395	-0.862
2:	-0.041	-0.682
3:	-0.042	-0.301
4:	-0.869	-0.388
5:	0.782	0.320
6:	0.995	0.331
7:	0.129	0.057
8:	-0.106	0.019
9:	0.216	0.373
10:	-0.105	0.376

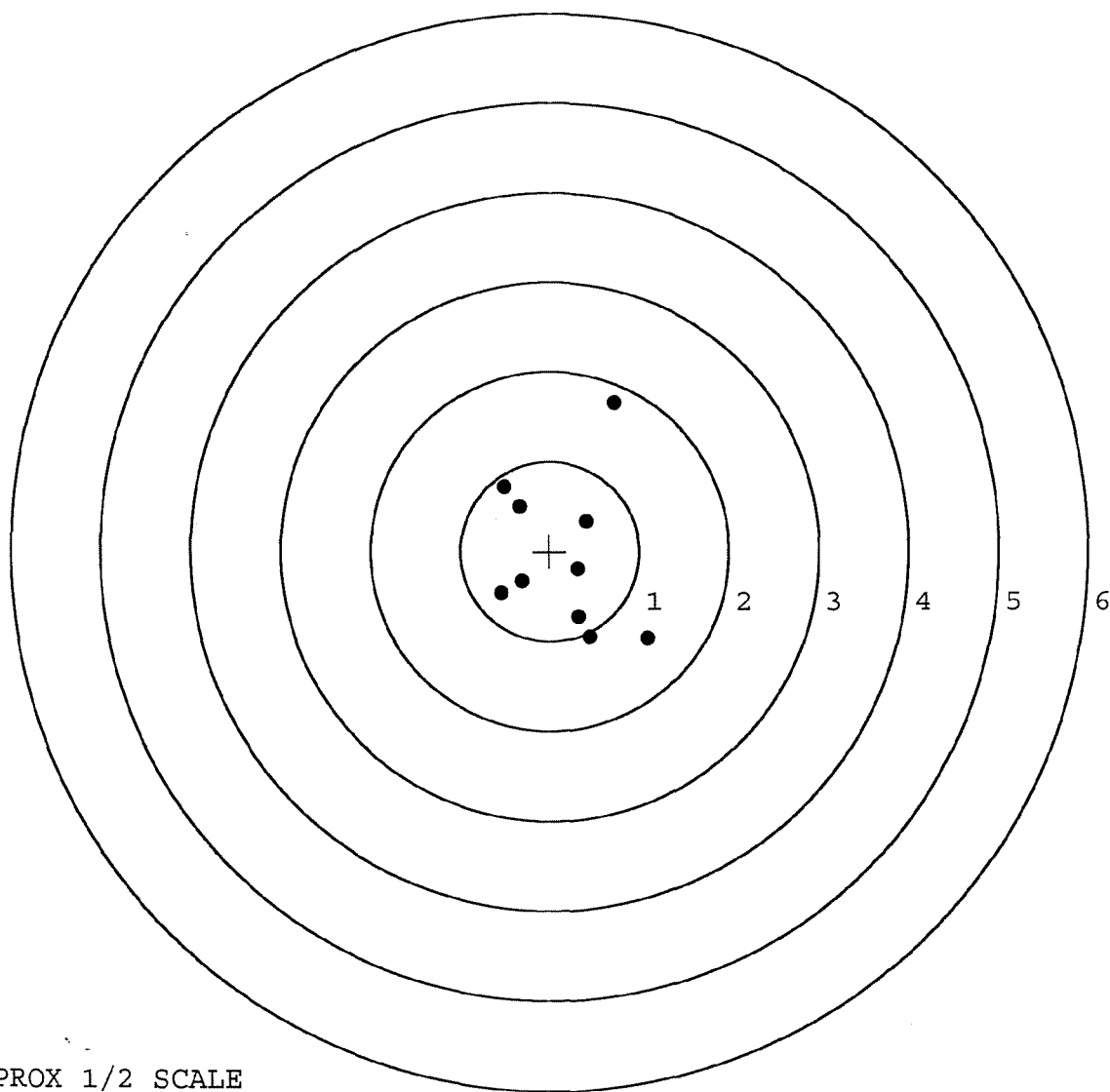


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461638. __0
TARGET NUMBER: 4
FILE DATE: 05/20/2005
FILE TIME: 06:40

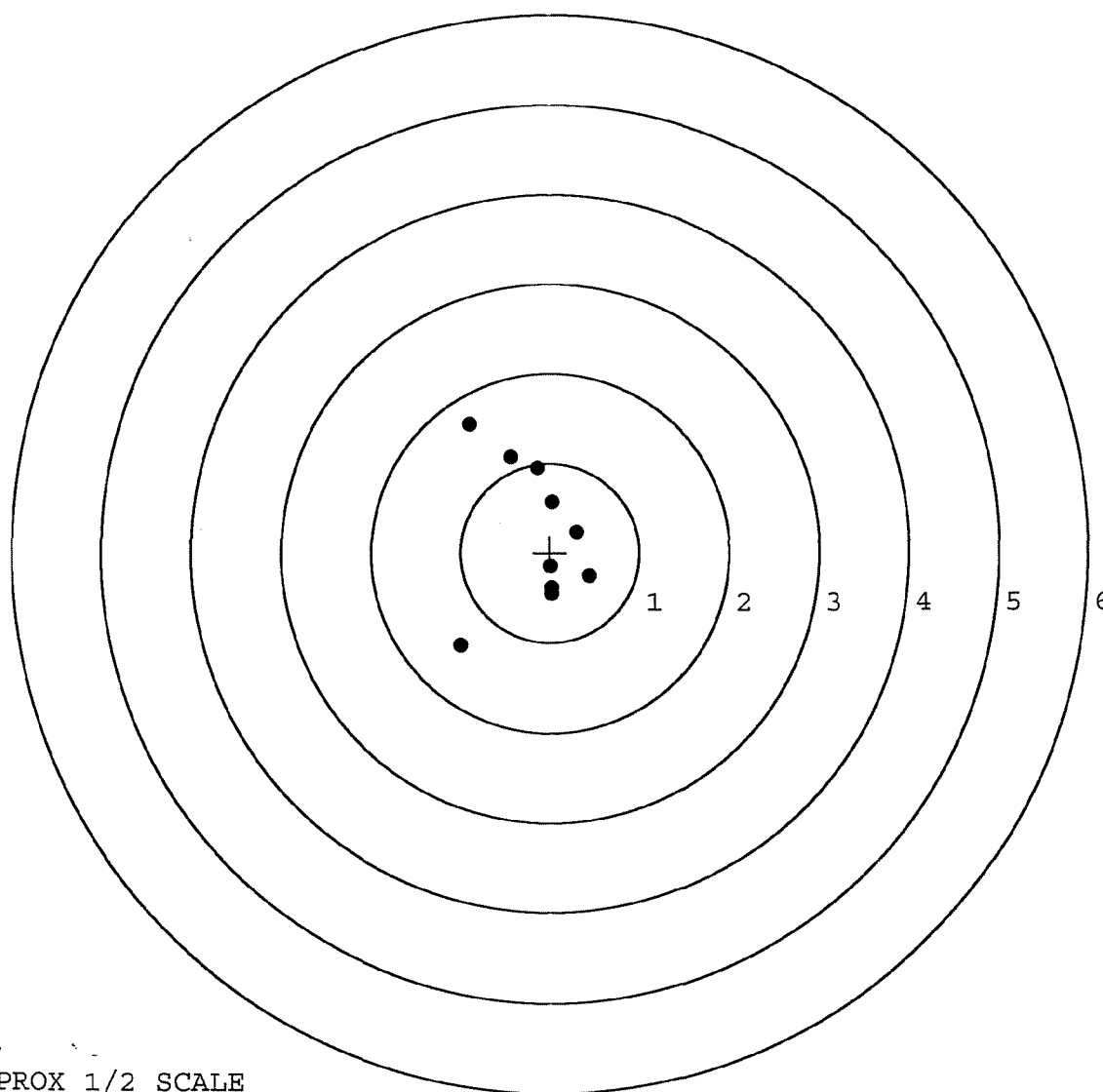
X CENTROID: 0.161
Y CENTROID: -0.046
POA TO CENTROID: 0.168
HORZ SPREAD: 1.639
VERT SPREAD: 2.621
GROUP SPREAD: 2.647
MIN RADIUS: 0.220
MAX RADIUS: 1.785
MEAN RADIUS: 0.857
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.093	-0.973
2:	0.448	-0.956
3:	0.321	-0.733
4:	0.319	-0.199
5:	0.410	0.339
6:	-0.307	-0.339
7:	-0.546	-0.469
8:	-0.339	0.499
9:	-0.511	0.719
10:	0.724	1.648



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461638. __0	POINT#	X	Y
TARGET NUMBER: 5	1:	-0.901	1.440
FILE DATE: 05/20/2005	2:	-0.442	1.072
FILE TIME: 06:40	3:	-0.140	0.947
	4:	0.020	0.570
X CENTROID: -0.167	5:	0.298	0.228
Y CENTROID: 0.194	6:	0.443	-0.266
POA TO CENTROID: 0.256	7:	0.022	-0.463
HORZ SPREAD: 1.446	8:	0.012	-0.156
VERT SPREAD: 2.478	9:	-1.003	-1.038
GROUP SPREAD: 2.480	10:	0.025	-0.395
MIN RADIUS: 0.393			
MAX RADIUS: 1.489			
MEAN RADIUS: 0.795			
# IN 1 IN DIAMETER: 3			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			



TARGET APPROX 1/2 SCALE