

G-6461648

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



G6461648

owner registration sticker



G6461648

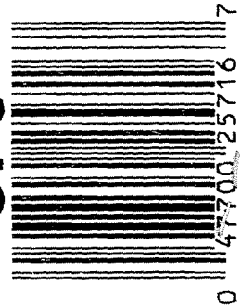
ORDER NO. **25716**

BARREL LENGTH 24"

CAPACITY 6

G6461648

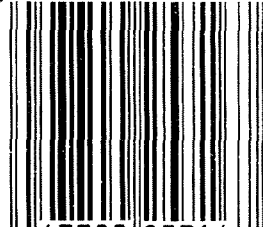
UPC



ORDER 25716

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

UPC



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ORDER 25716

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

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SERIAL NO.



G6461648

4/7/2005 2:48:09 PM

Chb

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

Goff Blast Barrel & Rec Assembly,

78ROT01



0003858612

0540

Flat Black Powder Coat, Barrel and

01PC001



0003858602

0560

Reassemble Action.

89SWS1



0003858603

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461648

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 11 2005	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</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		5-11-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-11-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-11-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-11-05	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>	5-23-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		5-23-05	AC
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	5-23-05	AC
	J) ASSEMBLE STOCK		5-11-05	RTL
	K) ASSEMBLE SWIVEL STUDS		5-23-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-11-05	RTL
	M) IRON SIGHT ALIGNMENT		5-11-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-11-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-16-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-16-05	TRLW
655	FINAL INSPECTION A) HEADSPACE		5-23-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.57</u> <u>2.41</u> <u>2.36</u> <u>2.77</u> <u>2.12</u>	5-20-05	AC
	C) FUNCTION		5-23-05	AC
660	PACK		5/23/05	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

5-10-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.65	2.48		2.29	
PULL #2	2.73	2.68		2.26	
PULL #3	2.70	2.67		2.41	
PULL #4	2.49	2.86		2.12	
PULL #5	2.52	2.91		2.26	
TOTAL	13.09	13.60		11.34	
AVERAGE	2.61	2.72		2.26	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.39		
PULL #2	3.32	3.42		
PULL #3	3.35	3.40		
PULL #4	3.52	3.47		
PULL #5	3.37	3.27		
TOTAL	16.75	16.95		
AVERAGE	3.35	3.39		

	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	4.37	4.27		4.11
PULL #2	4.39	4.34		4.26
PULL #3	4.48	4.39		4.16
PULL #4	4.37	4.21		4.16
PULL #5	4.38	4.38		4.07
TOTAL	21.99	21.59		20.76
AVERAGE	4.39	4.31		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461648. __0
FILE DATE AND TIME: 05/16/2005 06:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.032
The Average Y Centroid of the Five Target Set:	0.083
The Average Point of Impact of the Five Target Set:	0.089
The Average Mean Radius of the Five Target Set:	0.945
The Distance from POA to Centroid Target #1:	0.347
The Distance from Centroid Target #2 to Centroid Target #1:	0.431
The Distance from Centroid Target #3 to Centroid Target #1:	0.441
The Distance from Centroid Target #4 to Centroid Target #1:	1.160
The Distance from Centroid Target #5 to Centroid Target #1:	0.748

SERIAL NUMBER: G6461648. 0

TARGET NUMBER: 1

FILE DATE: 05/16/2005

FILE TIME: 06:23

X CENTROID: -0.346

Y CENTROID: 0.030

POA TO CENTROID: 0.347

HORZ SPREAD: 2.896

VERT SPREAD: 2.107

GROUP SPREAD: 2.914

MIN RADIUS: 0.105

MAX RADIUS: 1.565

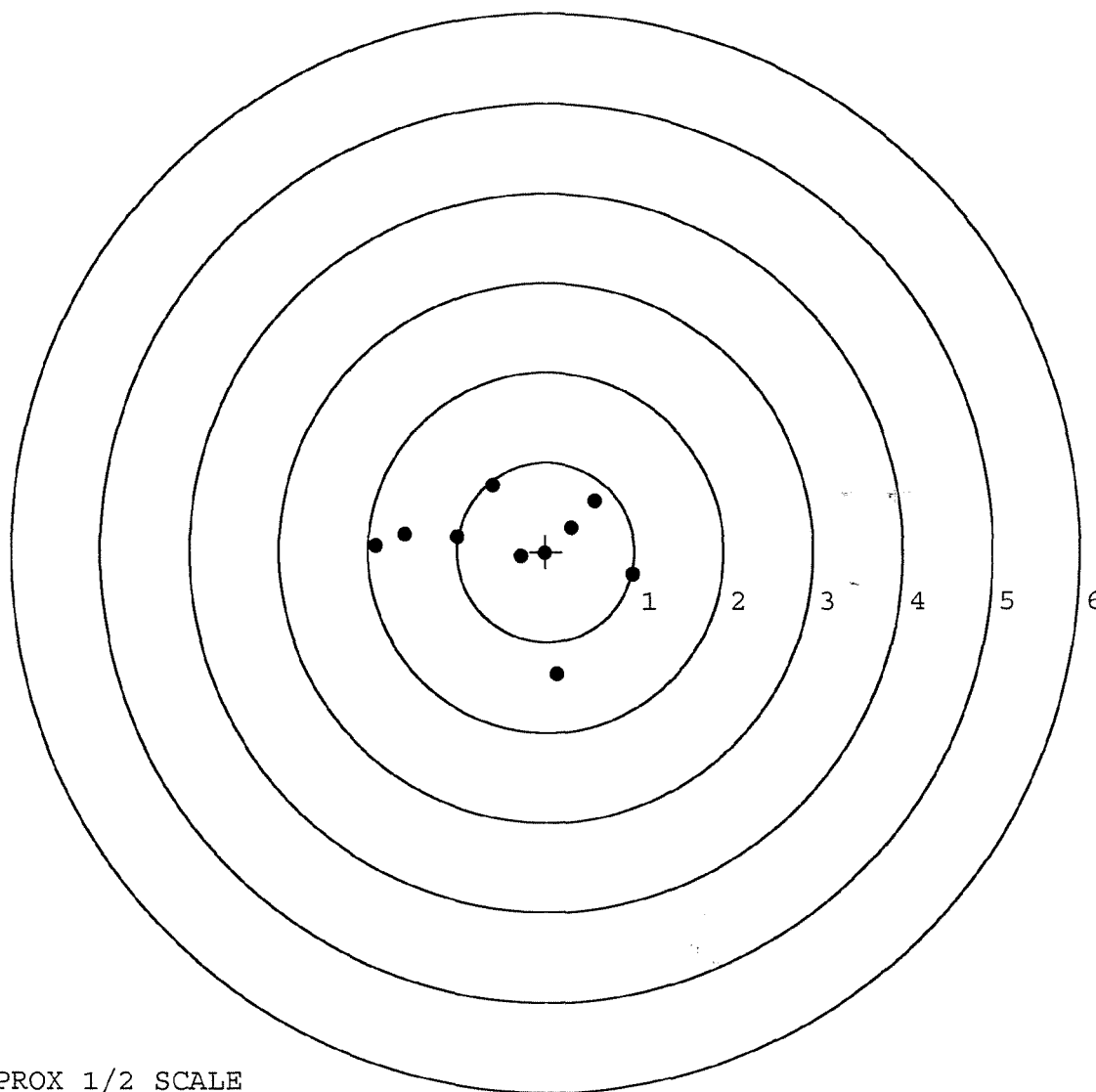
MEAN RADIUS: 0.923

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.123	-1.366
2:	0.986	-0.257
3:	0.551	0.567
4:	0.286	0.269
5:	-0.019	-0.024
6:	-0.282	-0.054
7:	-0.601	0.741
8:	-0.999	0.161
9:	-1.591	0.191
10:	-1.910	0.068



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461648. 0

TARGET NUMBER: 2

FILE DATE: 05/16/2005

FILE TIME: 06:23

X CENTROID: 0.024

Y CENTROID: -0.193

POA TO CENTROID: 0.194

HORZ SPREAD: 1.161

VERT SPREAD: 1.437

GROUP SPREAD: 1.609

MIN RADIUS: 0.183

MAX RADIUS: 0.816

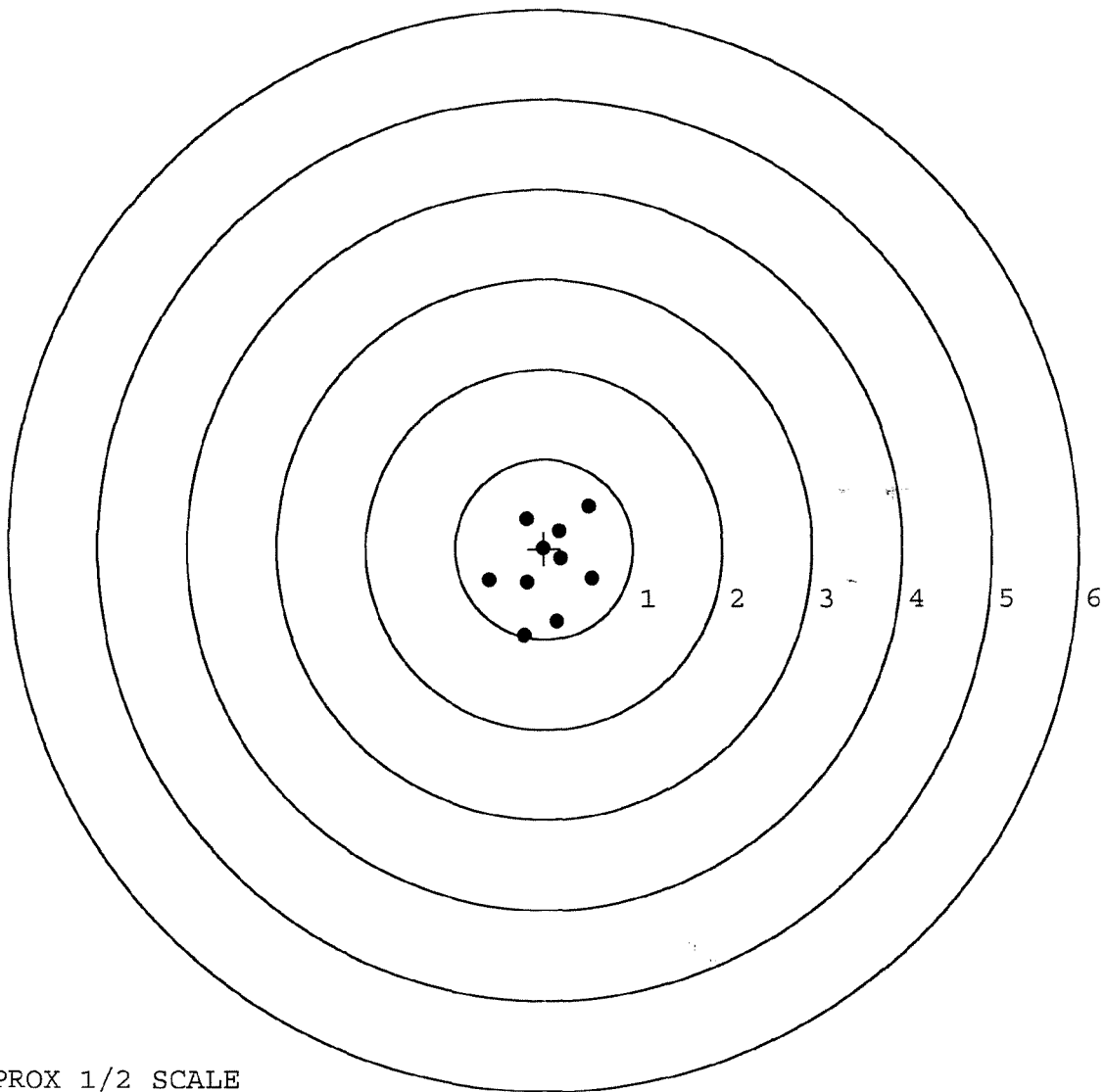
MEAN RADIUS: 0.510

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.229	-0.963
2:	0.134	-0.807
3:	0.536	-0.327
4:	-0.197	-0.374
5:	-0.625	-0.348
6:	0.495	0.474
7:	-0.205	0.329
8:	0.162	0.198
9:	0.186	-0.107
10:	-0.019	0.000



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461648. __0

TARGET NUMBER: 3

FILE DATE: 05/16/2005

FILE TIME: 06:23

X CENTROID: 0.094

Y CENTROID: 0.054

POA TO CENTROID: 0.109

HORZ SPREAD: 1.156

VERT SPREAD: 1.476

GROUP SPREAD: 1.846

MIN RADIUS: 0.110

MAX RADIUS: 1.034

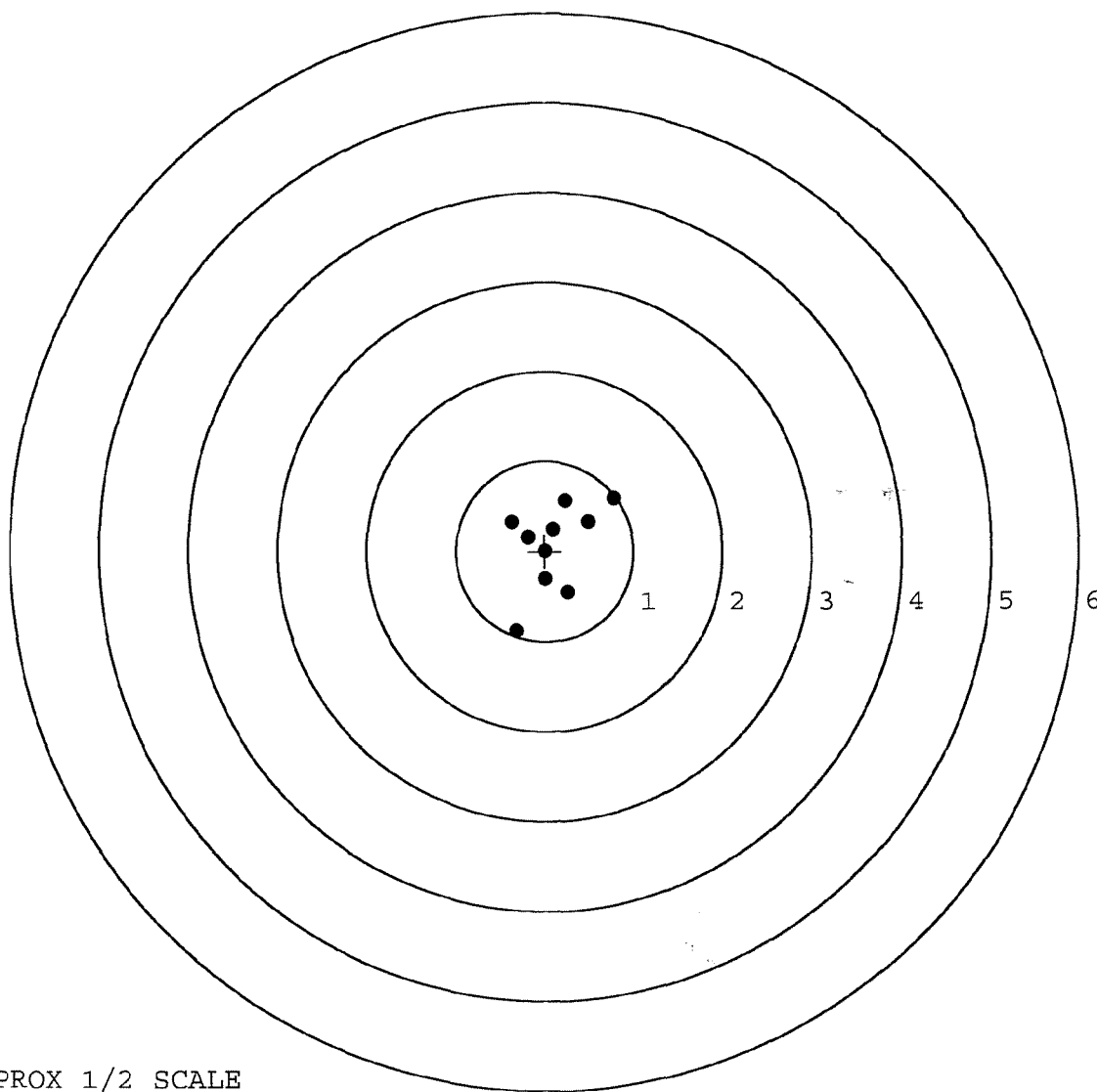
MEAN RADIUS: 0.497

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.000	-0.002
2:	0.256	-0.460
3:	0.003	-0.313
4:	-0.331	-0.889
5:	0.778	0.587
6:	0.491	0.333
7:	0.229	0.560
8:	0.089	0.244
9:	-0.193	0.154
10:	-0.378	0.322



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461648. __0

TARGET NUMBER: 4

FILE DATE: 05/16/2005

FILE TIME: 06:23

X CENTROID: 0.221

Y CENTROID: 1.042

POA TO CENTROID: 1.065

HORZ SPREAD: 1.451

VERT SPREAD: 4.348

GROUP SPREAD: 4.436

MIN RADIUS: 0.667

MAX RADIUS: 2.398

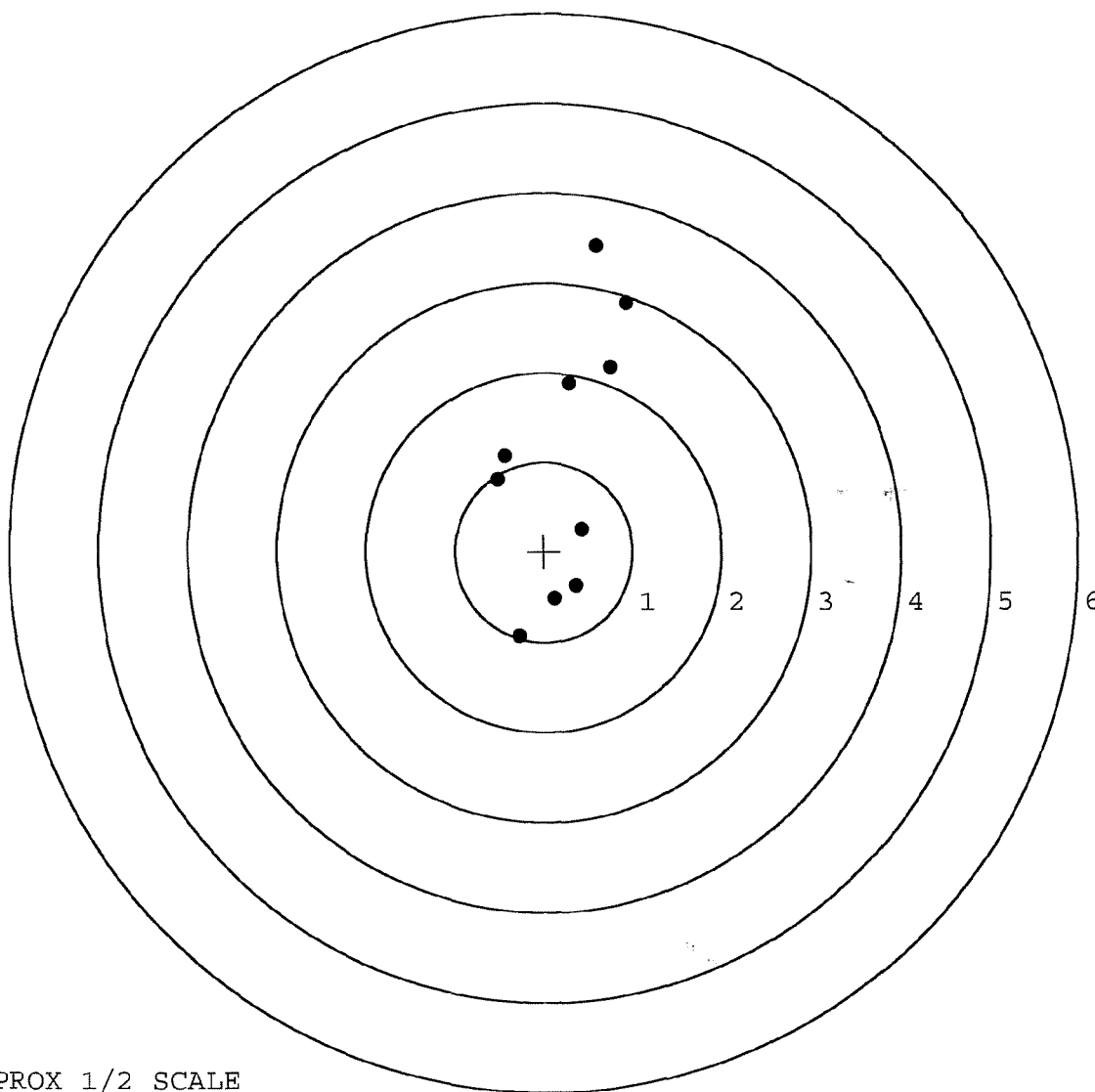
MEAN RADIUS: 1.357

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.425	0.251
2:	0.361	-0.377
3:	0.114	-0.523
4:	-0.282	-0.938
5:	-0.522	0.805
6:	-0.445	1.068
7:	0.286	1.880
8:	0.750	2.065
9:	0.929	2.778
10:	0.596	3.410



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461648. 0

TARGET NUMBER: 5

FILE DATE: 05/16/2005

FILE TIME: 06:23

X CENTROID: 0.167

Y CENTROID: -0.515

POA TO CENTROID: 0.542

HORZ SPREAD: 1.372

VERT SPREAD: 5.355

GROUP SPREAD: 5.355

MIN RADIUS: 0.341

MAX RADIUS: 2.916

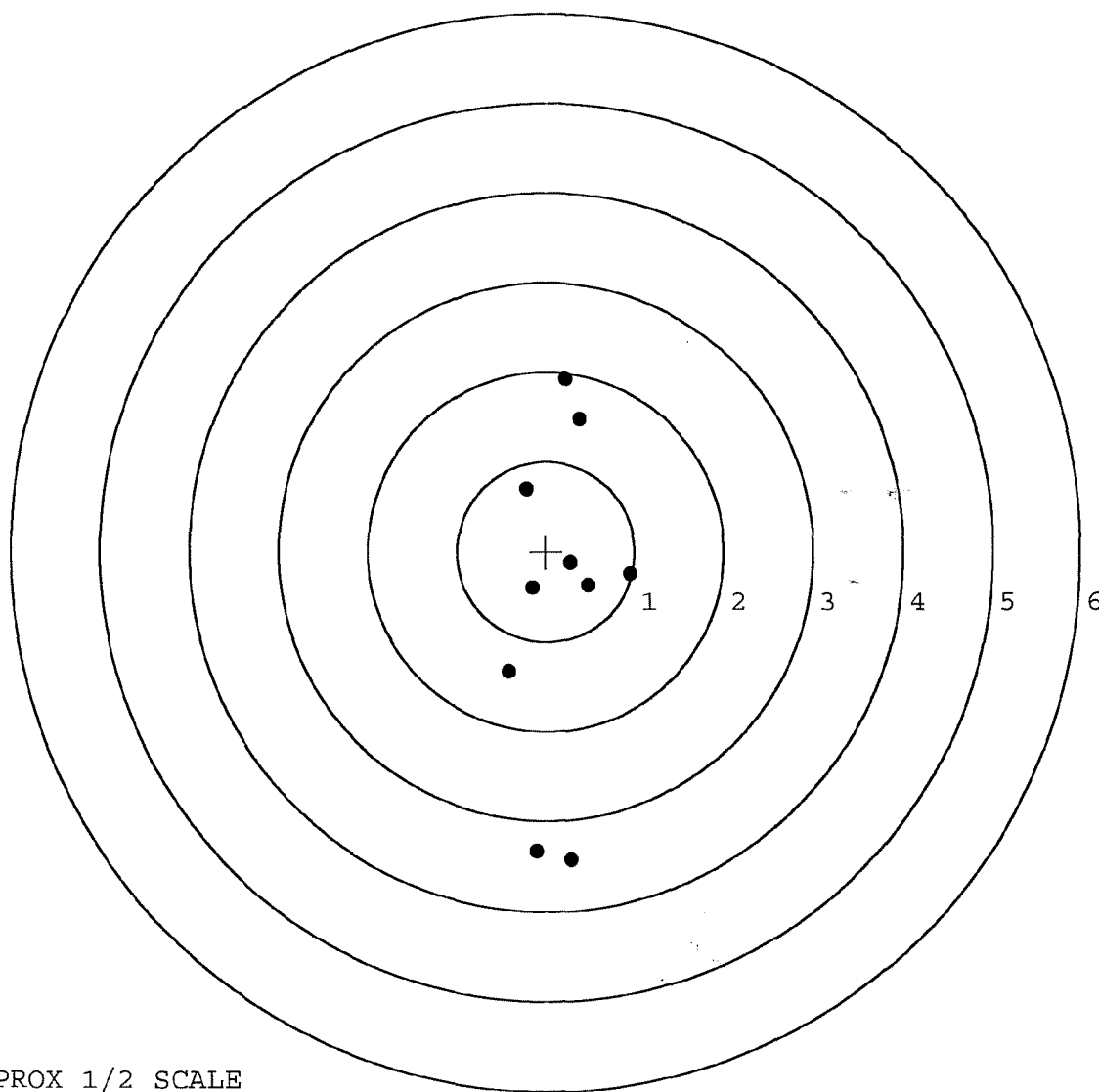
MEAN RADIUS: 1.440

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.949	-0.244
2:	0.478	-0.372
3:	0.276	-0.124
4:	-0.154	-0.401
5:	-0.423	-1.334
6:	-0.225	0.694
7:	0.374	1.477
8:	0.215	1.926
9:	0.288	-3.429
10:	-0.108	-3.346



TARGET APPROX 1/2 SCALE