

G 646 1650

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

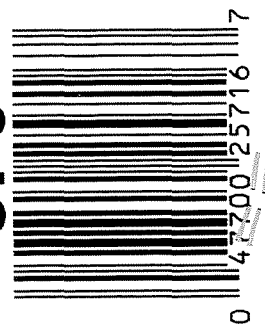
24"

CAPACITY

6

G6461650

UPC



ORDER **25716**
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC



ORDER **25716**
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC



SERIAL NO.



6/17/2005 2:12:04 PM

Crib

48

Original

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004012773

0540

01PC001

Flat Black Powder Coat, Barrel and



0004012763

0560

89SWS1

Reassemble Action.



0004012764

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G64611050

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTL
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE		9-6-05	RTL
470	DIS-ASSEMBLE ACTION		9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480	9/8/05	umg
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	umg
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9/21/05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/21/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/21/05	DA
	D) OIL FIRING PIN ASSEMBLY		9-20-05	RTL
	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>	10-3-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	10-3-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	10-3-05	Ac
	J) ASSEMBLE STOCK		9-27-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		10-3-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-28-05	RTZ
	M) IRON SIGHT ALIGNMENT		9-28-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-28-05	RTZ
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	9-29-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/29/05	ST
670	FINAL INSPECTION A) HEADSPACE		10-3-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.51</u> <u>2.35</u> <u>2.45</u> <u>2.35</u> <u>2.56</u>	10/3/05	FG
	C) FUNCTION		10-3-05	Ac
690	PACK		10-2-05	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

9/22/05

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.45	2.20		2.73	
PULL #2	2.56	2.65		2.69	
PULL #3	2.84	2.42		2.62	
PULL #4	2.68	2.79		2.64	
PULL #5	2.74	2.33		2.68	
TOTAL	13.27	12.19		13.36	
AVERAGE	2.65	2.44		2.67	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.39		
PULL #2	3.15	3.06		
PULL #3	3.14	3.50		
PULL #4	3.27	3.56		
PULL #5	3.08	3.35		
TOTAL	15.92	16.86		
AVERAGE	3.18	3.37		

	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	4.36	4.04		4.07
PULL #2	4.04	4.07		4.00
PULL #3	4.43	4.32		3.99
PULL #4	3.84	4.45		4.11
PULL #5	4.07	4.27		4.34
TOTAL	20.74	21.15		20.51
AVERAGE	4.15	4.23		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461650.___0

FILE DATE AND TIME: 09/29/2005 11:25

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:	-0.039
The Average Point of Impact of the Five Target Set:	0.051
The Average Mean Radius of the Five Target Set:	1.110
The Distance from POA to Centroid Target #1:	0.347
The Distance from Centroid Target #2 to Centroid Target #1:	1.115
The Distance from Centroid Target #3 to Centroid Target #1:	0.441
The Distance from Centroid Target #4 to Centroid Target #1:	0.280
The Distance from Centroid Target #5 to Centroid Target #1:	0.469

SERIAL NUMBER: G6461650. __0

TARGET NUMBER: 1

FILE DATE: 09/29/2005

FILE TIME: 11:25

POINT#	X	Y
1:	1.395	-1.548
2:	1.437	-1.012
3:	-0.084	-1.491
4:	-0.497	-1.104
5:	-0.168	-0.386
6:	-0.436	-0.033
7:	-0.189	0.106
8:	-1.036	0.481
9:	-0.505	0.619
10:	0.635	0.947

X CENTROID: 0.055

Y CENTROID: -0.342

POA TO CENTROID: 0.347

HORZ SPREAD: 2.473

VERT SPREAD: 2.495

GROUP SPREAD: 3.166

MIN RADIUS: 0.227

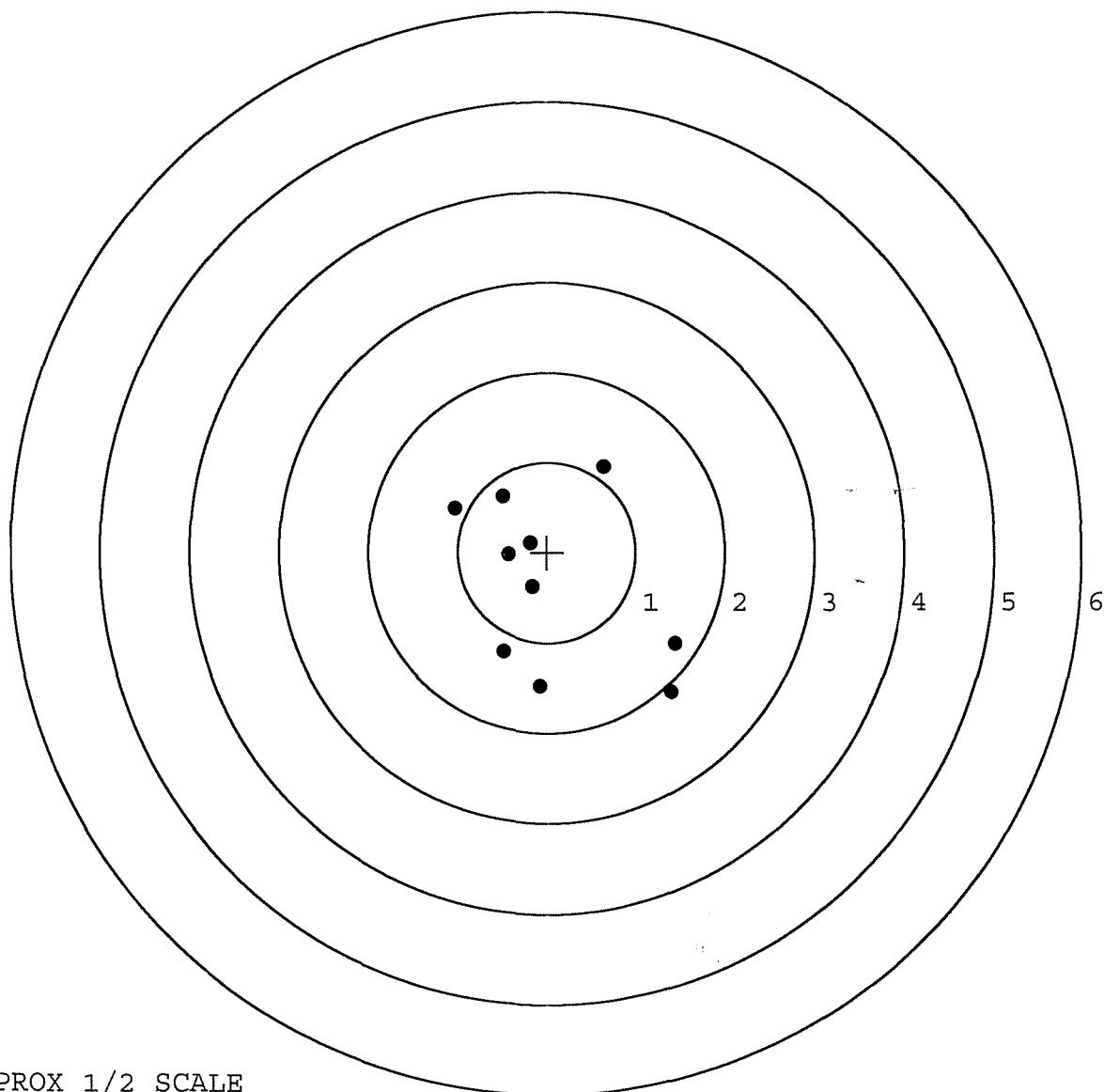
MAX RADIUS: 1.803

MEAN RADIUS: 1.065

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461650. __0

TARGET NUMBER: 2

FILE DATE: 09/29/2005

FILE TIME: 11:25

POINT#	X	Y
1:	2.246	0.017
2:	1.629	1.501
3:	0.500	2.363
4:	0.562	3.177
5:	0.825	-0.861
6:	0.301	0.529
7:	-0.280	0.787
8:	-0.727	0.086
9:	-0.190	-0.760
10:	-1.661	0.572

X CENTROID: 0.320

Y CENTROID: 0.741

POA TO CENTROID: 0.807

HORZ SPREAD: 3.907

VERT SPREAD: 4.038

GROUP SPREAD: 4.047

MIN RADIUS: 0.213

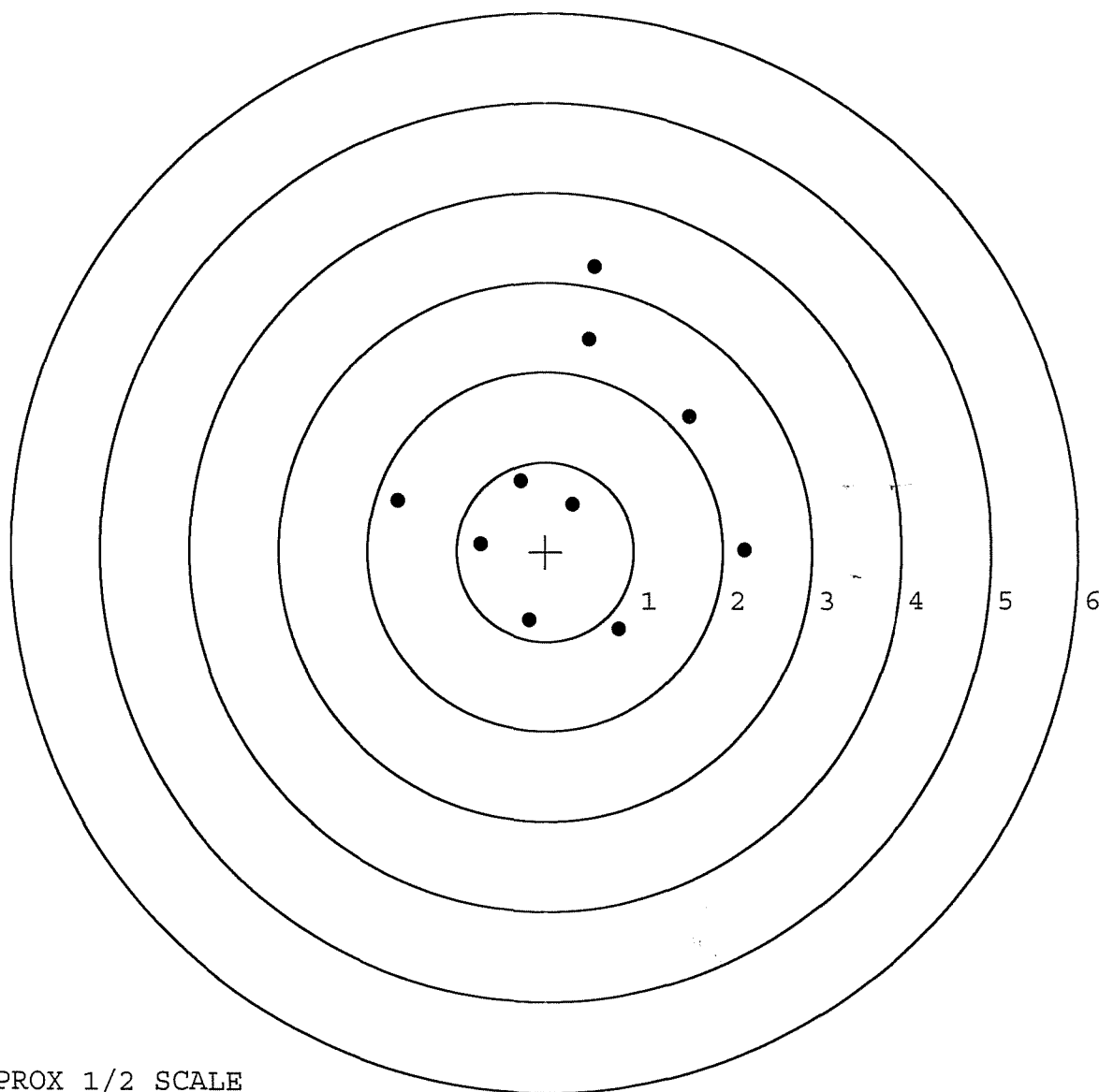
MAX RADIUS: 2.448

MEAN RADIUS: 1.495

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 3

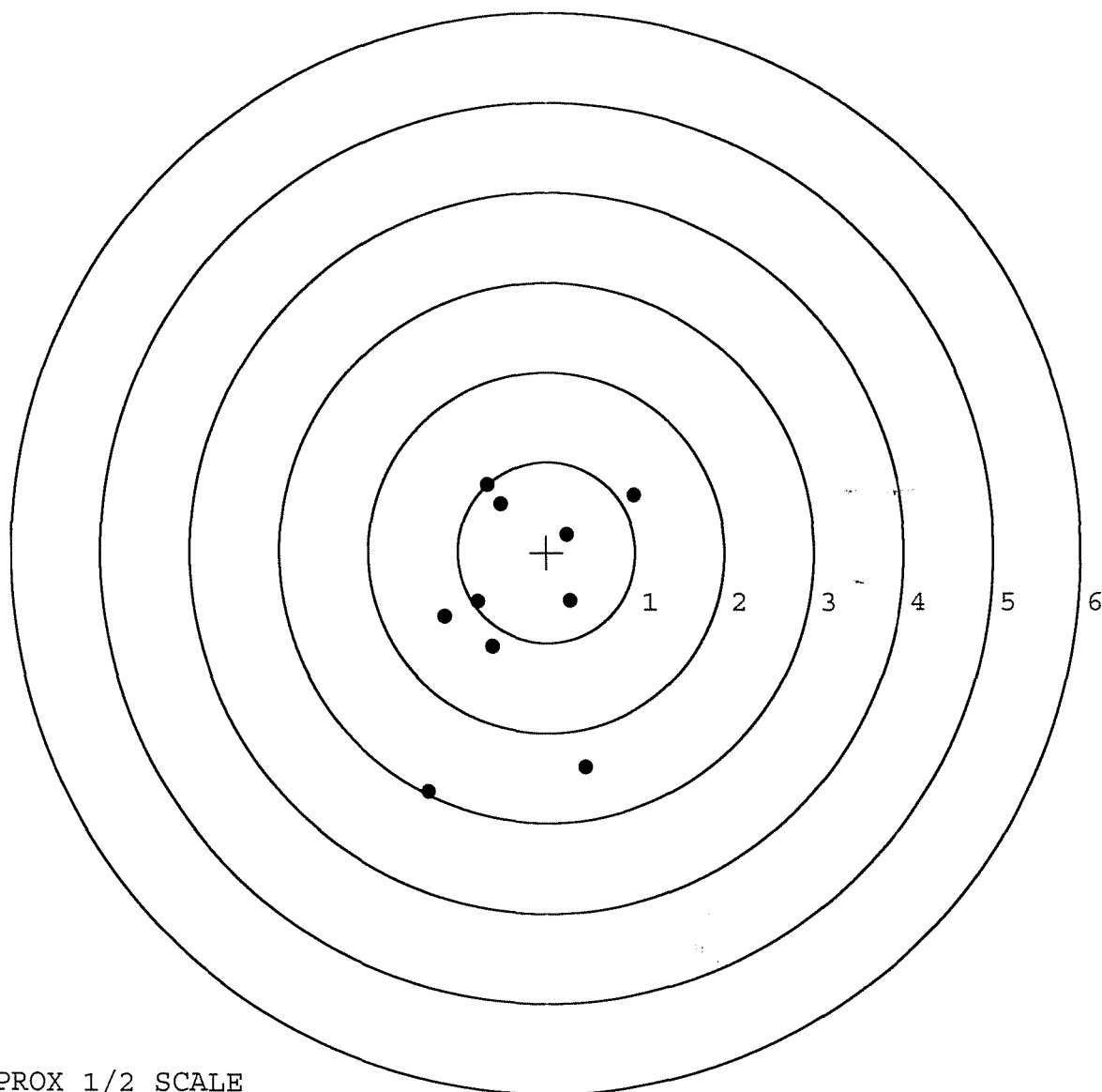


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461650. __0
TARGET NUMBER: 3
FILE DATE: 09/29/2005
FILE TIME: 11:25

POINT#	X	Y
1:	0.434	-2.385
2:	-1.332	-2.665
3:	-0.620	-1.047
4:	-1.147	-0.717
5:	-0.778	-0.552
6:	0.264	-0.539
7:	0.228	0.194
8:	0.982	0.633
9:	-0.521	0.532
10:	-0.670	0.741

X CENTROID: -0.316
Y CENTROID: -0.581
POA TO CENTROID: 0.661
HORZ SPREAD: 2.314
VERT SPREAD: 3.406
GROUP SPREAD: 4.029
MIN RADIUS: 0.463
MAX RADIUS: 2.319
MEAN RADIUS: 1.194
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 4

FILE DATE: 09/29/2005

FILE TIME: 11:25

POINT#	X	Y
1:	-0.418	-1.952
2:	-1.515	-0.891
3:	0.695	-0.706
4:	-0.178	-0.537
5:	0.048	-0.509
6:	0.390	0.135
7:	-0.530	0.229
8:	-0.781	0.297
9:	1.149	1.047
10:	0.679	2.078

X CENTROID: -0.046

Y CENTROID: -0.081

POA TO CENTROID: 0.093

HORZ SPREAD: 2.664

VERT SPREAD: 4.030

GROUP SPREAD: 4.177

MIN RADIUS: 0.438

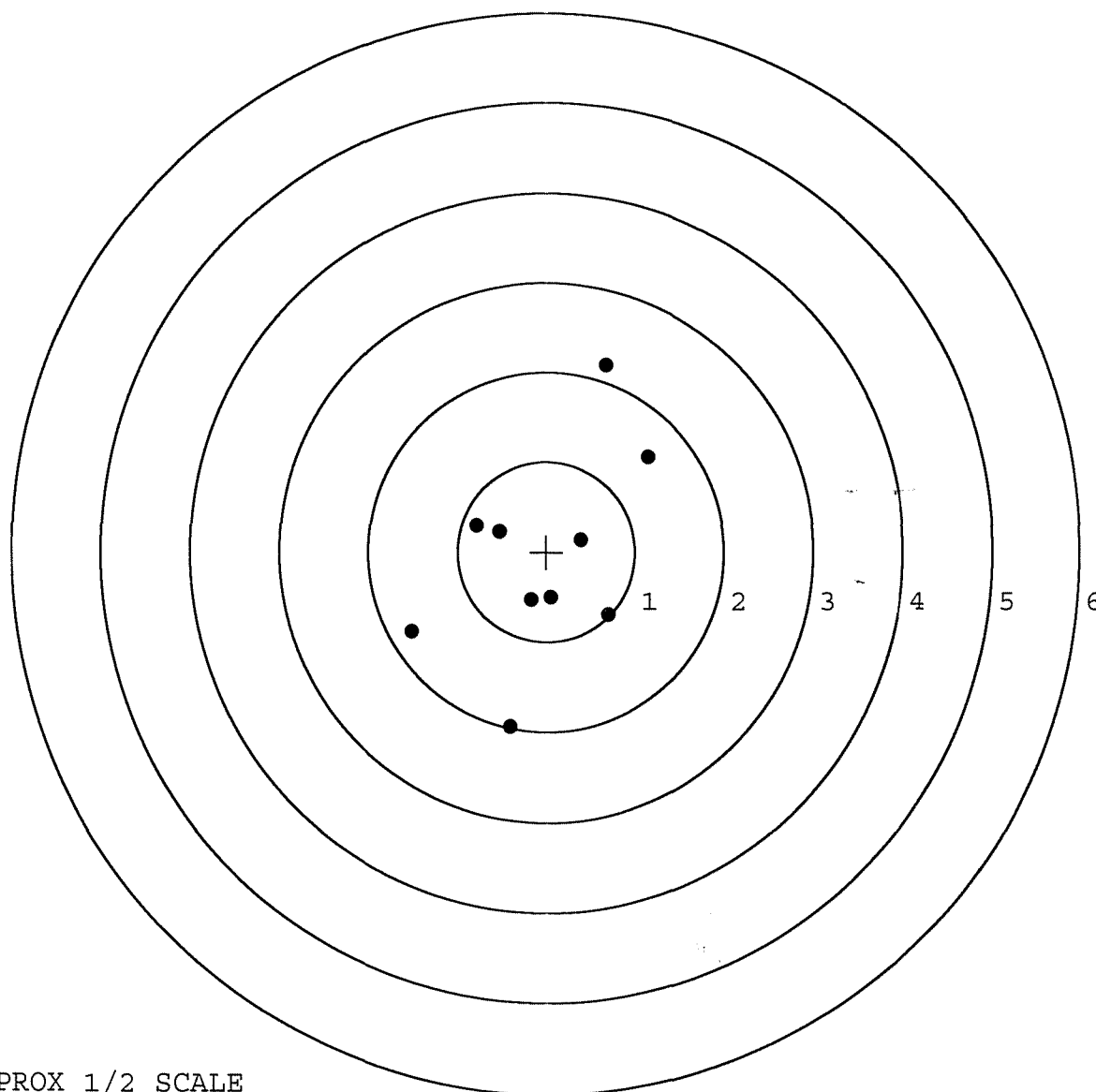
MAX RADIUS: 2.277

MEAN RADIUS: 1.128

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461650. 0

TARGET NUMBER: 5

FILE DATE: 09/29/2005

FILE TIME: 11:25

POINT#	X	Y
1:	-0.183	-1.011
2:	-0.900	-0.569
3:	-0.619	-0.548
4:	0.452	0.036
5:	0.291	0.291
6:	0.036	0.067
7:	-0.218	0.076
8:	-0.046	-0.037
9:	-0.583	0.814
10:	0.010	1.540

X CENTROID: -0.176

Y CENTROID: 0.066

POA TO CENTROID: 0.188

HORZ SPREAD: 1.352

VERT SPREAD: 2.551

GROUP SPREAD: 2.558

MIN RADIUS: 0.043

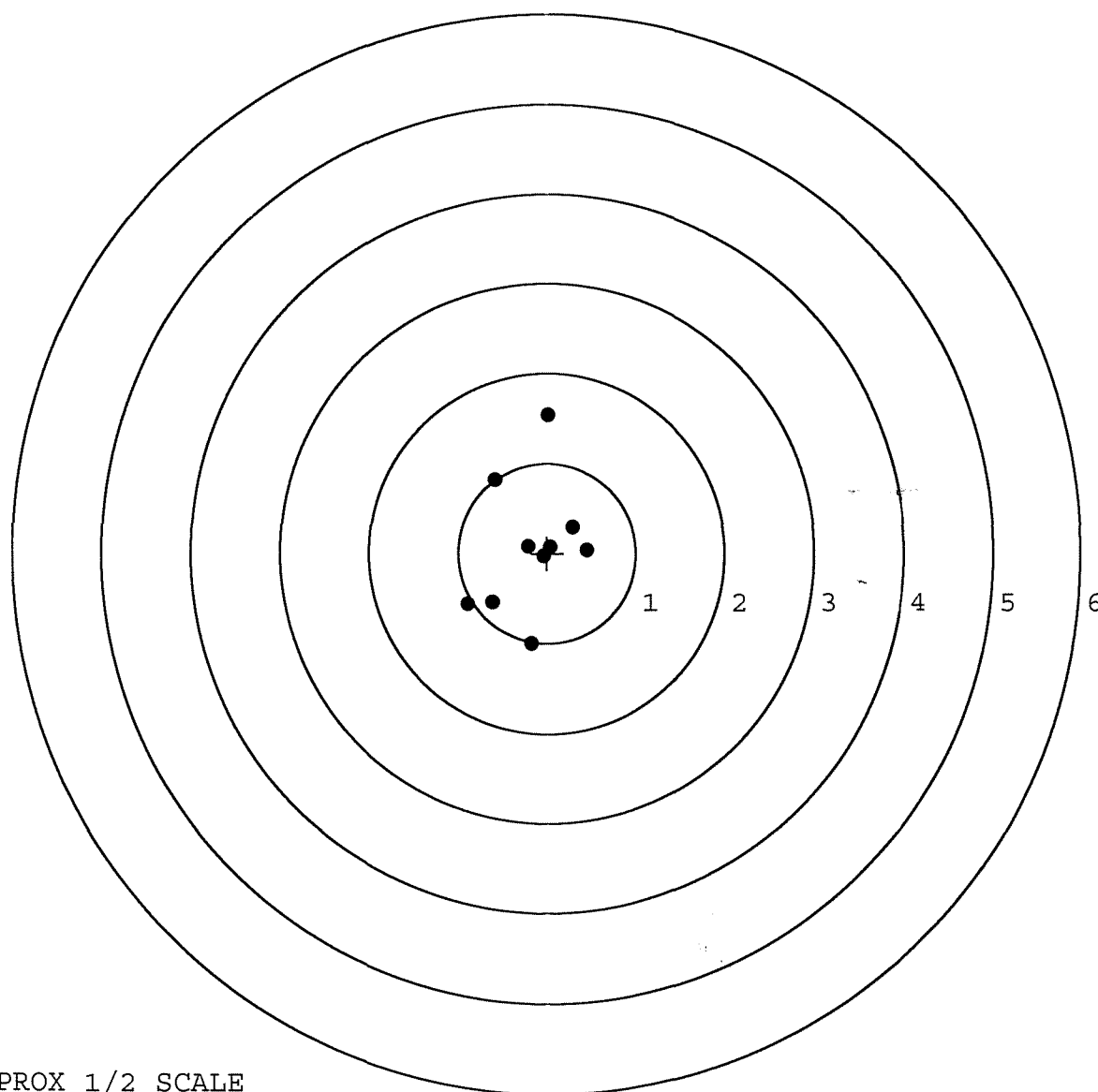
MAX RADIUS: 1.486

MEAN RADIUS: 0.670

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE