

G646 1655

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



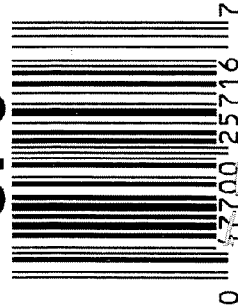
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461655

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

UPC



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SERIAL NO.



66461655

6/17/2005 2:12:04 PM

Ctrl

77

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

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66461655

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTL
440	PROOF		8-12-05	Ac
460	CHECK HEADSPACE		8-20-05	Ac
470	DIS-ASSEMBLE ACTION		8-15-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			RTL
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRL
520	GOFF BLAST BBL / REC		9-9-05	LIZ
530 & 540	APPLY COATINGS (BARREL ACTION)		9-17-05	WT
	(BOLT)			
560	RE-ASSEMBLE ACTION		10-6-05	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-6-05	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-6-05	MTM
	D) OIL FIRING PIN ASSEMBLY		10-11-05	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>4 1/6</u> <u>4 1/6</u> <u>4 1/6</u>	10-19-05	BG
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 1/6</u> <u>2 1/6</u> <u>2 1/6</u>	10-19-05	BG
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-19-05	BG
	J) ASSEMBLE STOCK		10-11-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-19-05	BG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-17-05	BG
	M) IRON SIGHT ALIGNMENT		10-17-05	BG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-17-05	BG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-18-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-18-05	R.P.
670	FINAL INSPECTION A) HEADSPACE		10-19-05	BG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.27</u> <u>2.40</u> <u>2.53</u> <u>2.25</u>	10-19-05	TRW
	C) FUNCTION		10-19-05	BG
690	PACK		10/25/05	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

10-3-05

RC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.23	2.30		2.54	
PULL #2	2.36	2.65		2.90	
PULL #3	2.28	2.18		2.70	
PULL #4	2.86	2.65		2.34	
PULL #5	2.42	2.27		2.40	
TOTAL	12.15	12.05		12.88	
AVERAGE	2.43	2.41		2.58	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.26		
PULL #2	3.53	3.41		
PULL #3	2.96	3.32		
PULL #4	3.25	2.68		
PULL #5	2.88	3.48		
TOTAL	15.66	16.15		
AVERAGE	3.13	3.23		

	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	4.22	3.93		3.89
PULL #2	4.34	3.60		4.16
PULL #3	4.53	4.28		4.24
PULL #4	3.96	4.55		3.91
PULL #5	4.31	4.22		4.50
TOTAL	21.36	20.58		20.70
AVERAGE	4.27	4.12		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461655.__0
FILE DATE AND TIME: 10/18/2005 09:38

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.132
The Average Y Centroid of the Five Target Set:	-0.114
The Average Point of Impact of the Five Target Set:	0.175
The Average Mean Radius of the Five Target Set:	1.032
The Distance from POA to Centroid Target #1:	0.269
The Distance from Centroid Target #2 to Centroid Target #1:	0.819
The Distance from Centroid Target #3 to Centroid Target #1:	0.213
The Distance from Centroid Target #4 to Centroid Target #1:	1.109
The Distance from Centroid Target #5 to Centroid Target #1:	0.267

SERIAL NUMBER: G6461655. 0

TARGET NUMBER: 1

FILE DATE: 10/18/2005

FILE TIME: 09:38

X CENTROID: -0.269

Y CENTROID: -0.005

POA TO CENTROID: 0.269

HORZ SPREAD: 3.174

VERT SPREAD: 1.973

GROUP SPREAD: 3.235

MIN RADIUS: 0.206

MAX RADIUS: 2.150

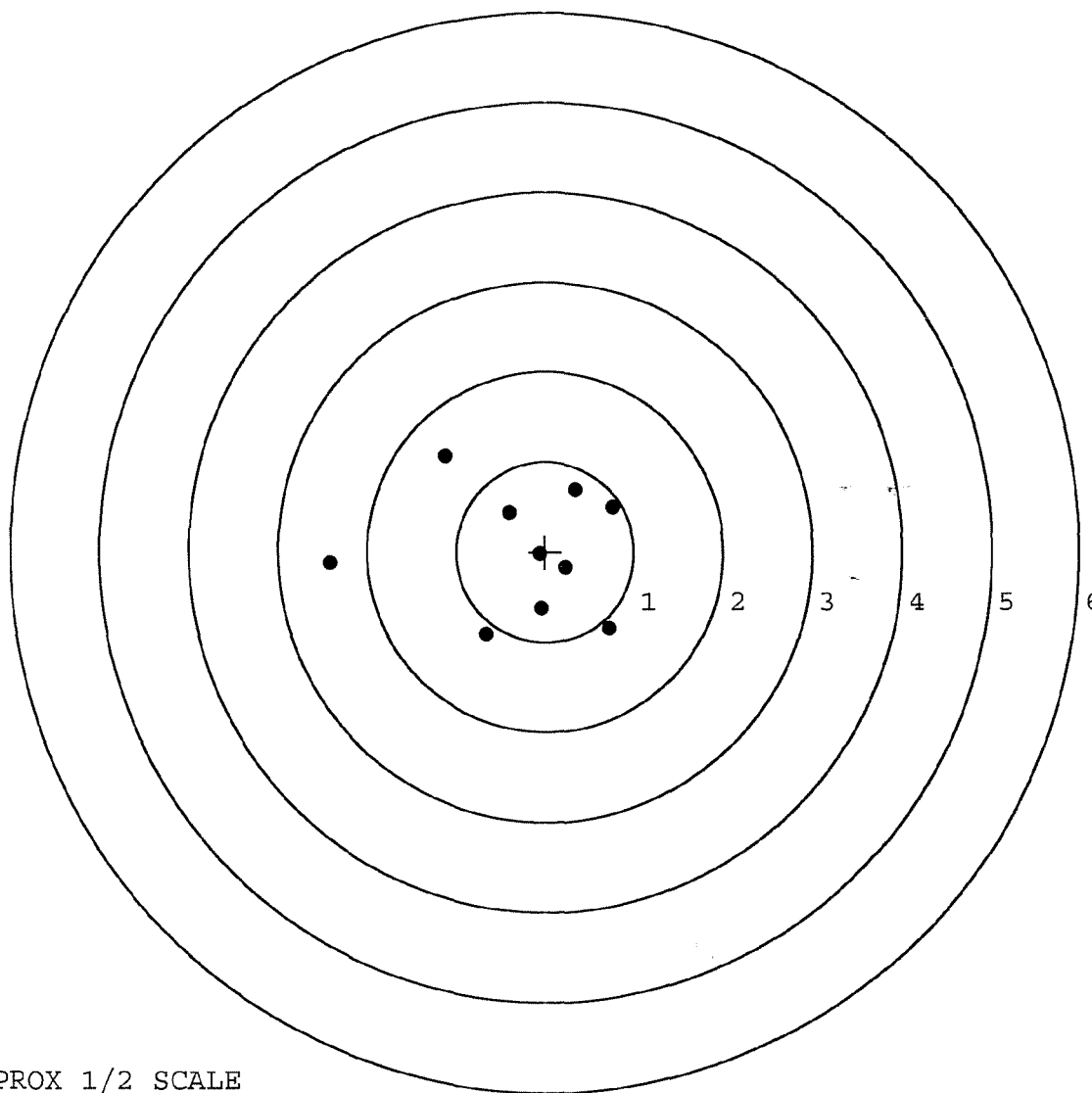
MEAN RADIUS: 0.973

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.714	-0.849
2:	-0.051	-0.633
3:	-0.668	-0.918
4:	0.759	0.495
5:	0.337	0.692
6:	0.229	-0.172
7:	-0.063	-0.022
8:	-0.408	0.438
9:	-1.121	1.055
10:	-2.415	-0.132

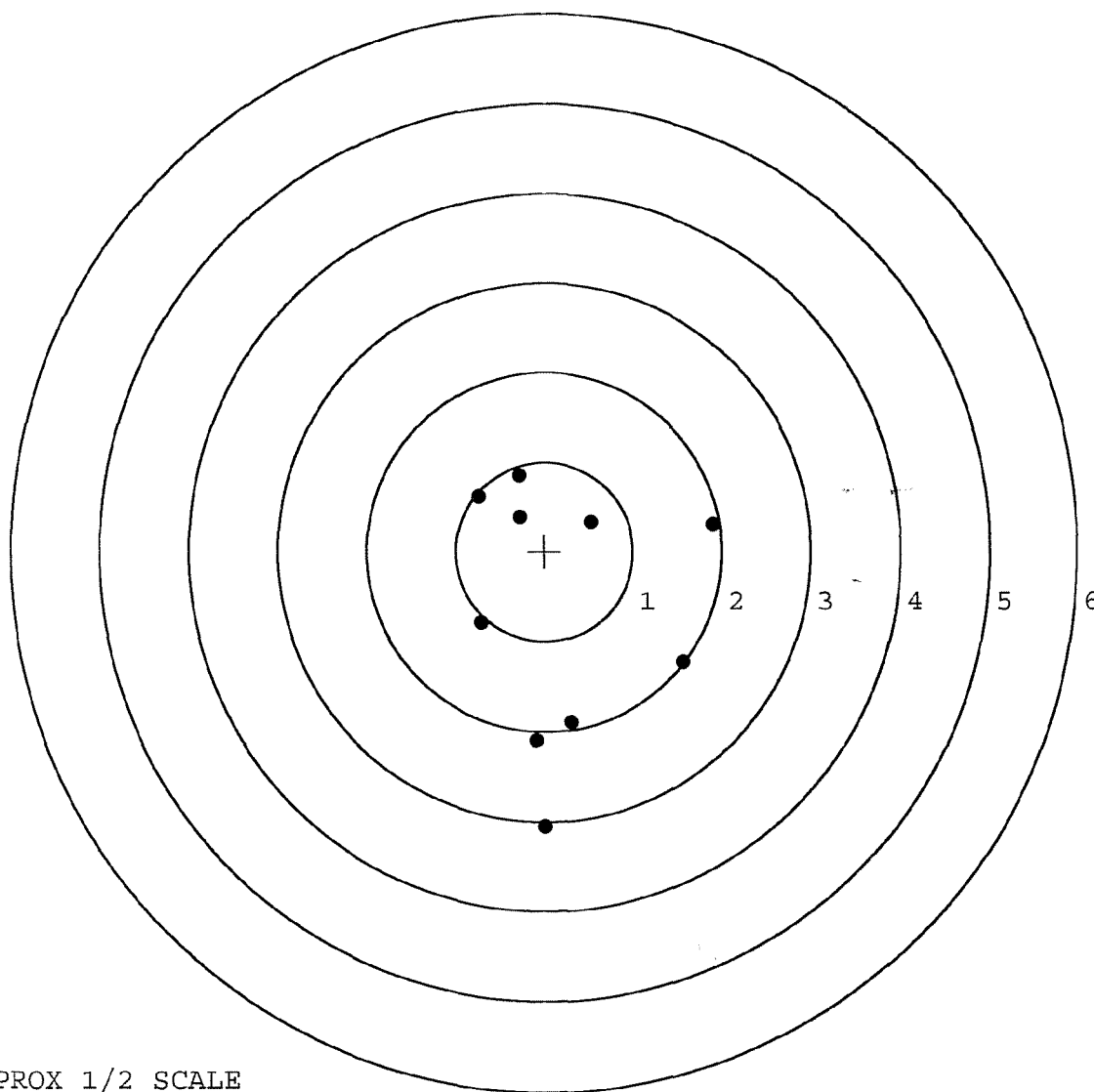


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655.___0
TARGET NUMBER: 2
FILE DATE: 10/18/2005
FILE TIME: 09:38

X CENTROID: 0.219
Y CENTROID: -0.662
POA TO CENTROID: 0.698
HORZ SPREAD: 2.644
VERT SPREAD: 3.917
GROUP SPREAD: 3.929
MIN RADIUS: 0.948
MAX RADIUS: 2.413
MEAN RADIUS: 1.488
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 1
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	1.569	-1.230
2:	0.305	-1.902
3:	-0.095	-2.109
4:	0.012	-3.066
5:	-0.719	-0.798
6:	0.526	0.329
7:	-0.280	0.383
8:	-0.289	0.851
9:	-0.742	0.616
10:	1.902	0.303



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. __0

TARGET NUMBER: 3

FILE DATE: 10/18/2005

FILE TIME: 09:38

X CENTROID: -0.095

Y CENTROID: 0.119

POA TO CENTROID: 0.152

HORZ SPREAD: 1.469

VERT SPREAD: 2.035

GROUP SPREAD: 2.175

MIN RADIUS: 0.154

MAX RADIUS: 1.408

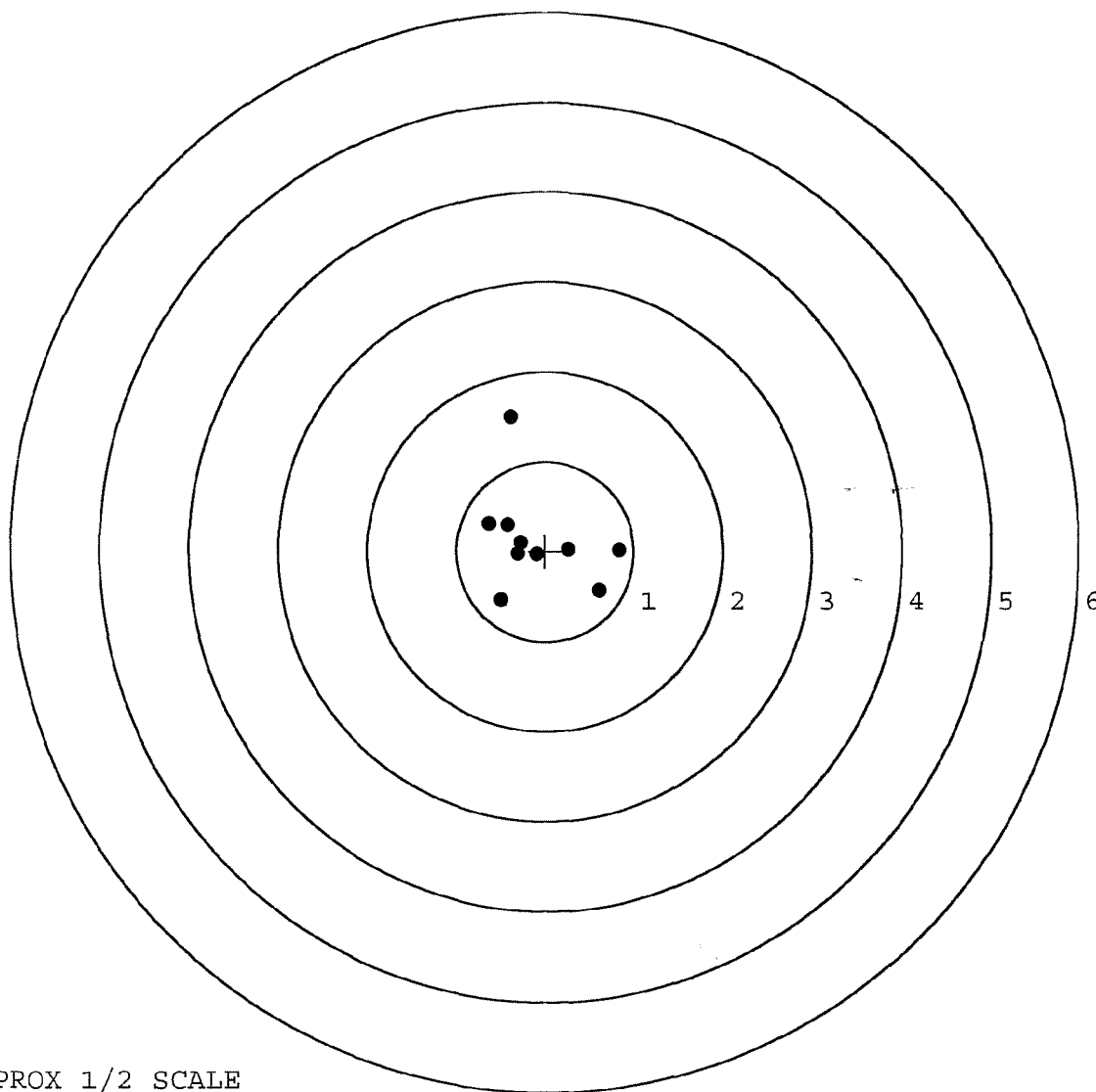
MEAN RADIUS: 0.594

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.395	1.494
2:	0.834	0.018
3:	0.609	-0.435
4:	0.263	0.015
5:	-0.099	-0.035
6:	-0.503	-0.541
7:	-0.275	0.095
8:	-0.433	0.297
9:	-0.635	0.309
10:	-0.313	-0.032



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. 0

TARGET NUMBER: 4

FILE DATE: 10/18/2005

FILE TIME: 09:38

X CENTROID: 0.836

Y CENTROID: 0.100

POA TO CENTROID: 0.842

HORZ SPREAD: 3.564

VERT SPREAD: 1.886

GROUP SPREAD: 3.631

MIN RADIUS: 0.513

MAX RADIUS: 1.957

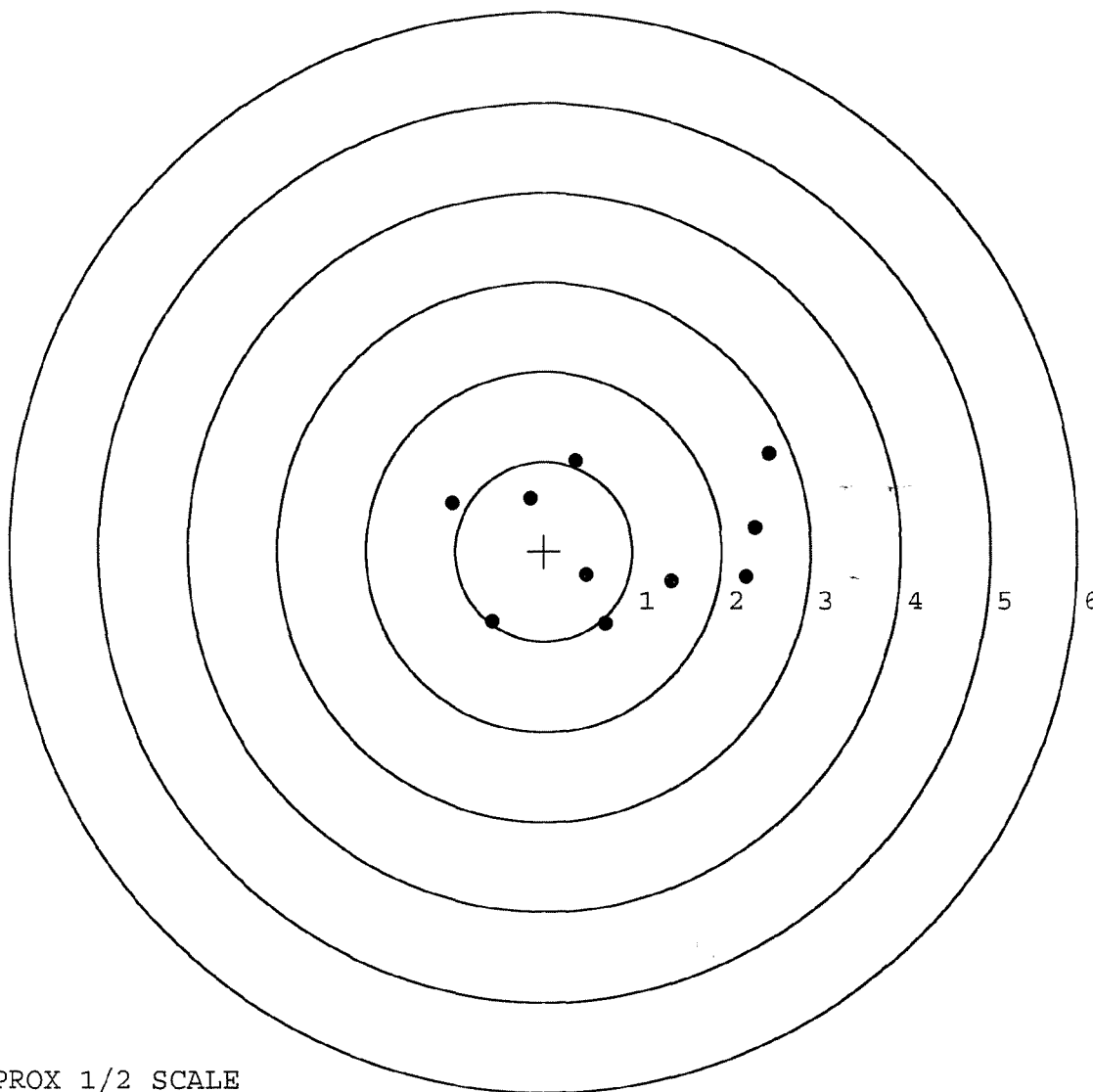
MEAN RADIUS: 1.289

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	2.276	-0.287
2:	2.373	0.263
3:	2.529	1.080
4:	1.436	-0.332
5:	0.690	-0.806
6:	0.476	-0.266
7:	-0.588	-0.783
8:	-0.156	0.590
9:	0.355	1.010
10:	-1.035	0.527



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461655. __0

TARGET NUMBER: 5

FILE DATE: 10/18/2005

FILE TIME: 09:38

X CENTROID: -0.029

Y CENTROID: -0.122

POA TO CENTROID: 0.125

HORZ SPREAD: 2.108

VERT SPREAD: 1.766

GROUP SPREAD: 2.267

MIN RADIUS: 0.229

MAX RADIUS: 1.330

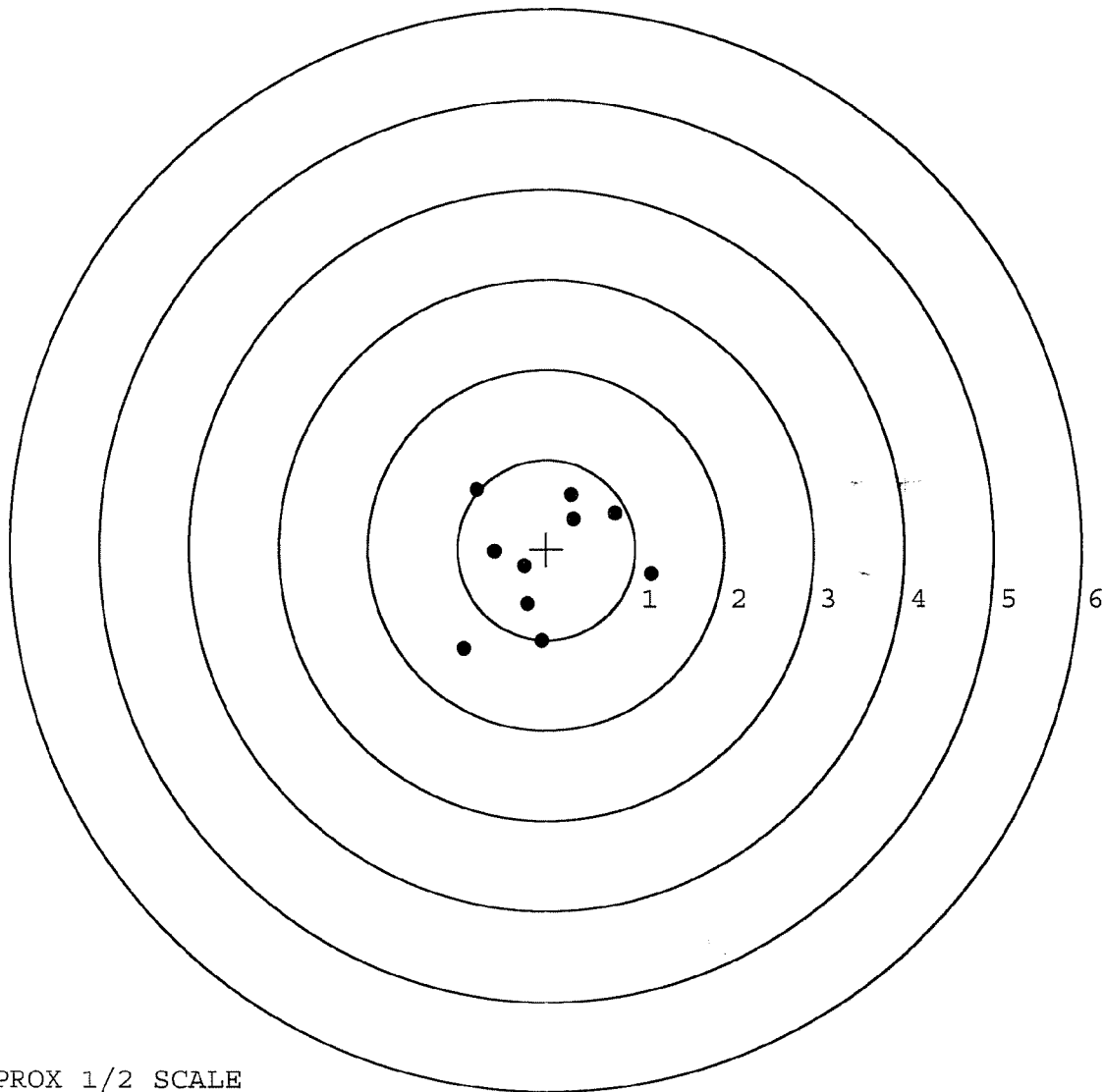
MEAN RADIUS: 0.815

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.181	-0.274
2:	-0.054	-1.019
3:	-0.219	-0.607
4:	-0.927	-1.103
5:	-0.247	-0.190
6:	-0.584	-0.032
7:	0.302	0.336
8:	0.274	0.607
9:	0.768	0.403
10:	-0.781	0.663



TARGET APPROX 1/2 SCALE