

G-646 1661

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



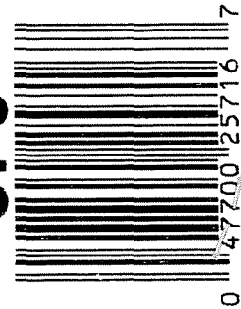
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461661

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.



4/7/2005 2:48:09 PM

Chib

5

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

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 # G6461661

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		4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 20 2005 OPERATOR <u>BD</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRLW
620	APPLY COATINGS (BARREL ACTION)		5-6-05	WJ
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-17-05	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>	5-19-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lb</u> <u>3 lbs</u>	5-19-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	5-19-05	AC
	J) ASSEMBLE STOCK		5-17-05	RLZ
	K) ASSEMBLE SWIVEL STUDS		5-19-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-17-05	RLZ
	M) IRON SIGHT ALIGNMENT		5-17-05	RLZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-17-05	RLZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-18-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-18-05	AC
655	FINAL INSPECTION A) HEADSPACE		5-19-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.62</u> <u>2.26</u> <u>2.44</u> <u>2.33</u> <u>2.25</u>	5-19-05	AC
	C) FUNCTION		5-19-05	AC
660	PACK		6/23/05	RA

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 5-16-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.66		2.04	
PULL #2	2.34	2.65		2.06	
PULL #3	2.66	2.53		2.61	
PULL #4	2.73	2.58		2.29	
PULL #5	2.64	2.57		2.27	
TOTAL	12.83	12.99		11.27	
AVERAGE	2.56	2.59		2.25	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.30		
PULL #2	3.54	3.37		
PULL #3	3.29	3.10		
PULL #4	3.47	3.21		
PULL #5	3.39	3.12		
TOTAL	17.02	16.10		
AVERAGE	3.40	3.22		

	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	4.25	4.17		4.57
PULL #2	4.32	3.99		3.95
PULL #3	4.28	4.01		4.51
PULL #4	4.09	4.03		4.45
PULL #5	4.29	4.06		4.36
TOTAL	21.23	20.26		21.84
AVERAGE	4.24	4.05		4.36

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461661.___0
FILE DATE AND TIME: 05/18/2005 10:26

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:	-0.156
The Average Point of Impact of the Five Target Set:	0.204
The Average Mean Radius of the Five Target Set:	0.795
The Distance from POA to Centroid Target #1:	0.225
The Distance from Centroid Target #2 to Centroid Target #1:	0.238
The Distance from Centroid Target #3 to Centroid Target #1:	0.252
The Distance from Centroid Target #4 to Centroid Target #1:	0.290
The Distance from Centroid Target #5 to Centroid Target #1:	1.752

SERIAL NUMBER: G6461661. __0

TARGET NUMBER: 1

FILE DATE: 05/18/2005

FILE TIME: 10:26

X CENTROID: -0.192

Y CENTROID: 0.118

POA TO CENTROID: 0.225

HORZ SPREAD: 2.285

VERT SPREAD: 2.422

GROUP SPREAD: 2.890

MIN RADIUS: 0.422

MAX RADIUS: 1.563

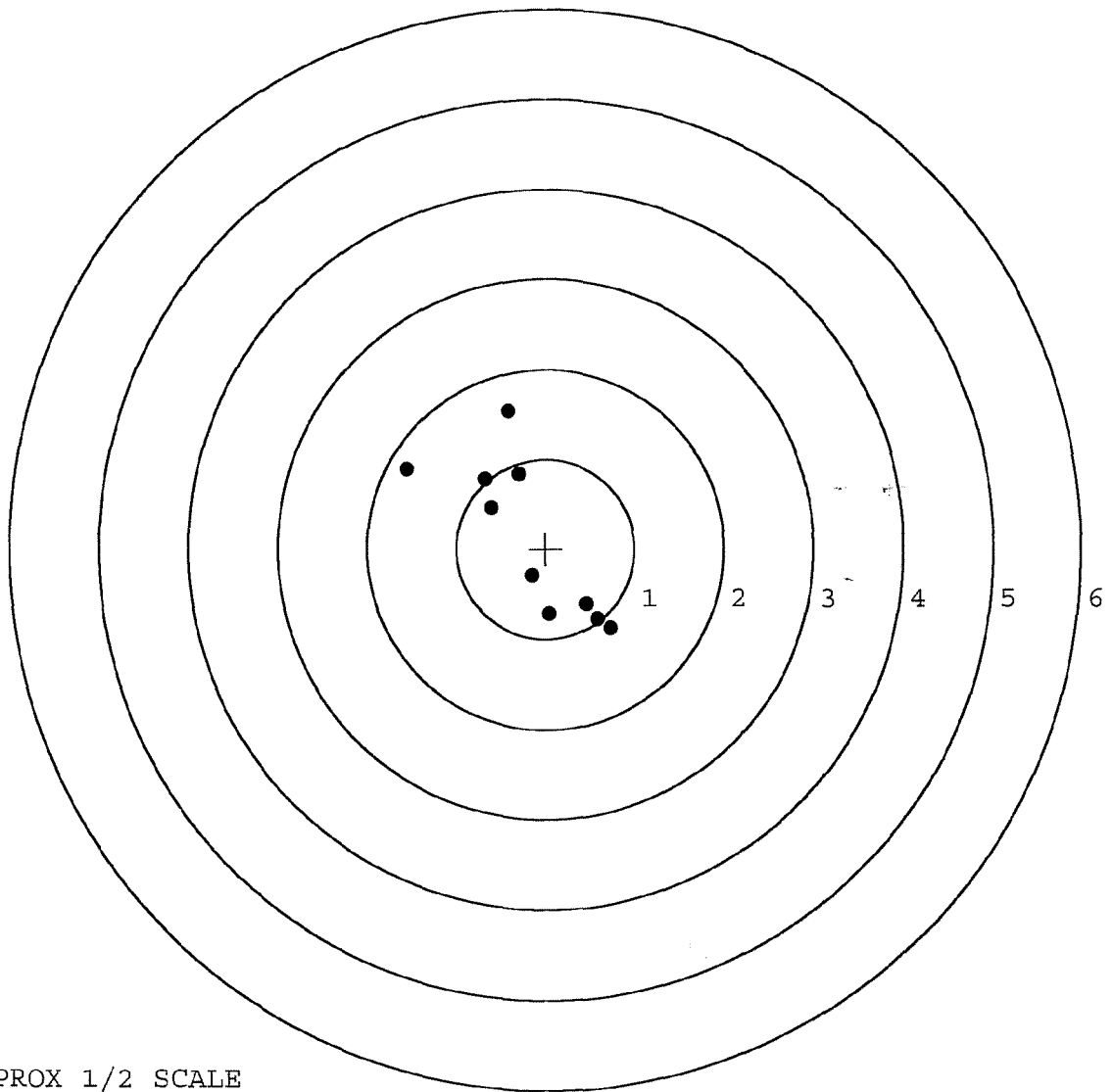
MEAN RADIUS: 0.993

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.424	1.537
2:	-0.303	0.834
3:	-0.683	0.779
4:	-0.620	0.458
5:	-1.554	0.885
6:	-0.156	-0.303
7:	0.045	-0.727
8:	0.456	-0.618
9:	0.585	-0.784
10:	0.731	-0.885



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461661. 0

TARGET NUMBER: 2

FILE DATE: 05/18/2005

FILE TIME: 10:26

X CENTROID: 0.043

Y CENTROID: 0.084

POA TO CENTROID: 0.094

HORZ SPREAD: 2.012

VERT SPREAD: 2.986

GROUP SPREAD: 3.277

MIN RADIUS: 0.131

MAX RADIUS: 1.699

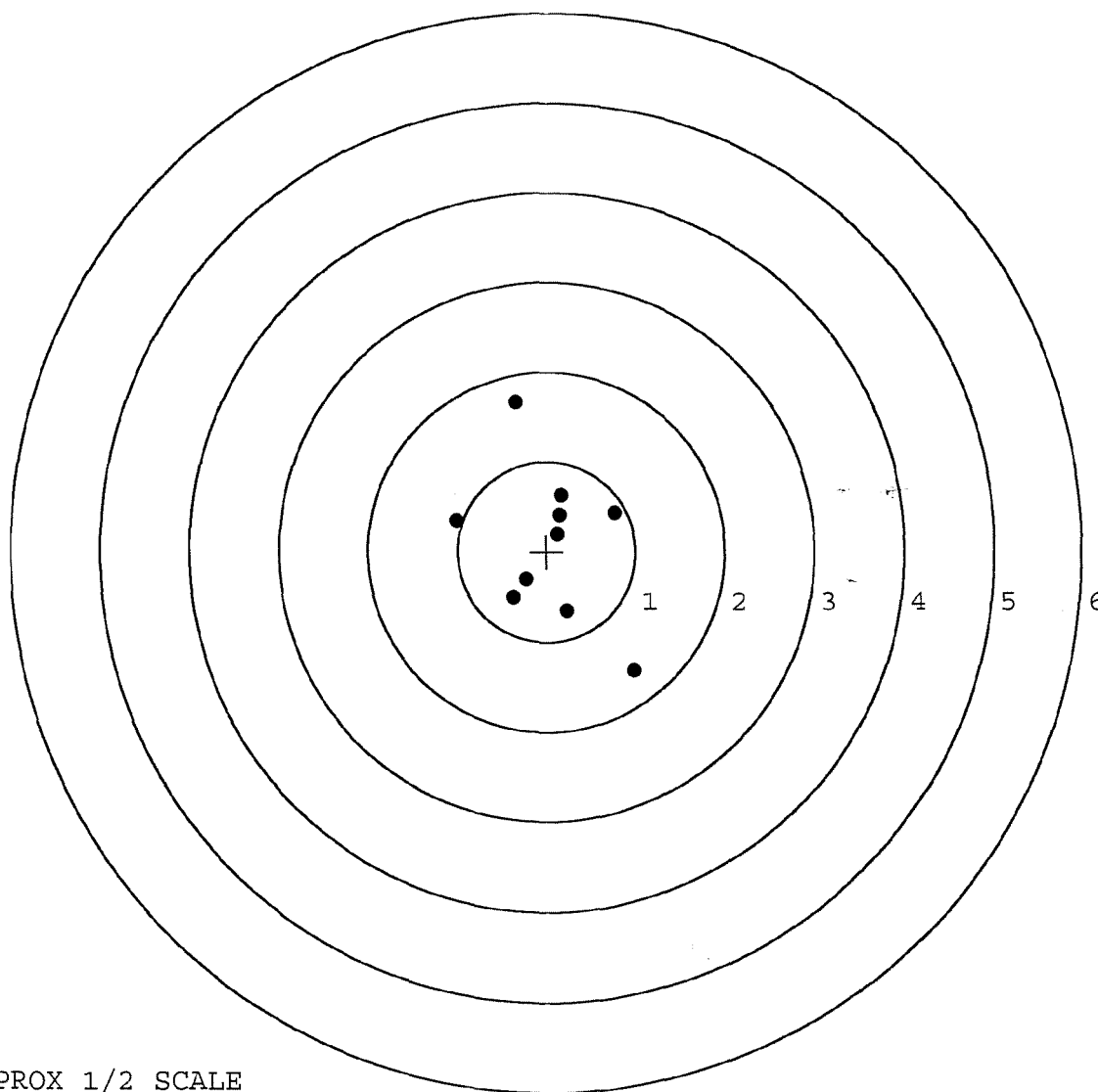
MEAN RADIUS: 0.820

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.993	-1.324
2:	0.228	-0.656
3:	-0.376	-0.508
4:	-0.234	-0.312
5:	0.124	0.187
6:	0.143	0.401
7:	0.166	0.623
8:	0.761	0.430
9:	-1.019	0.338
10:	-0.356	1.662



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461661. 0

TARGET NUMBER: 3

FILE DATE: 05/18/2005

FILE TIME: 10:26

X CENTROID: -0.165

Y CENTROID: 0.368

POA TO CENTROID: 0.403

HORZ SPREAD: 1.296

VERT SPREAD: 3.063

GROUP SPREAD: 3.073

MIN RADIUS: 0.118

MAX RADIUS: 2.070

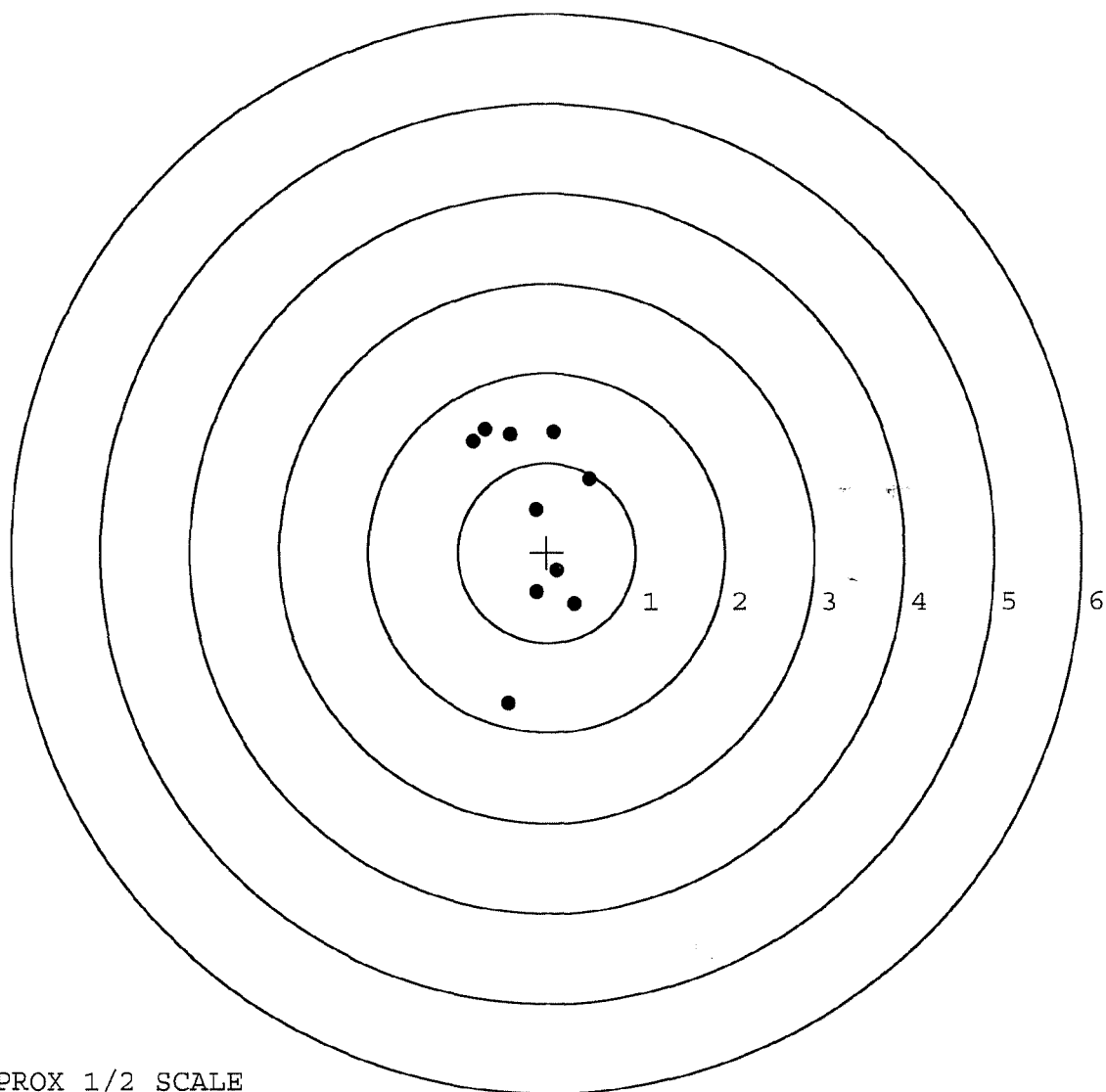
MEAN RADIUS: 0.968

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.080	1.341
2:	-0.411	1.316
3:	-0.821	1.245
4:	-0.128	0.480
5:	0.475	0.821
6:	0.108	-0.206
7:	-0.123	-0.446
8:	0.303	-0.567
9:	-0.442	-1.683
10:	-0.688	1.380



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461661: 0

TARGET NUMBER: 4

FILE DATE: 05/18/2005

FILE TIME: 10:26

X CENTROID: 0.052

Y CENTROID: 0.273

POA TO CENTROID: 0.278

HORZ SPREAD: 1.915

VERT SPREAD: 1.376

GROUP SPREAD: 2.033

MIN RADIUS: 0.056

MAX RADIUS: 1.307

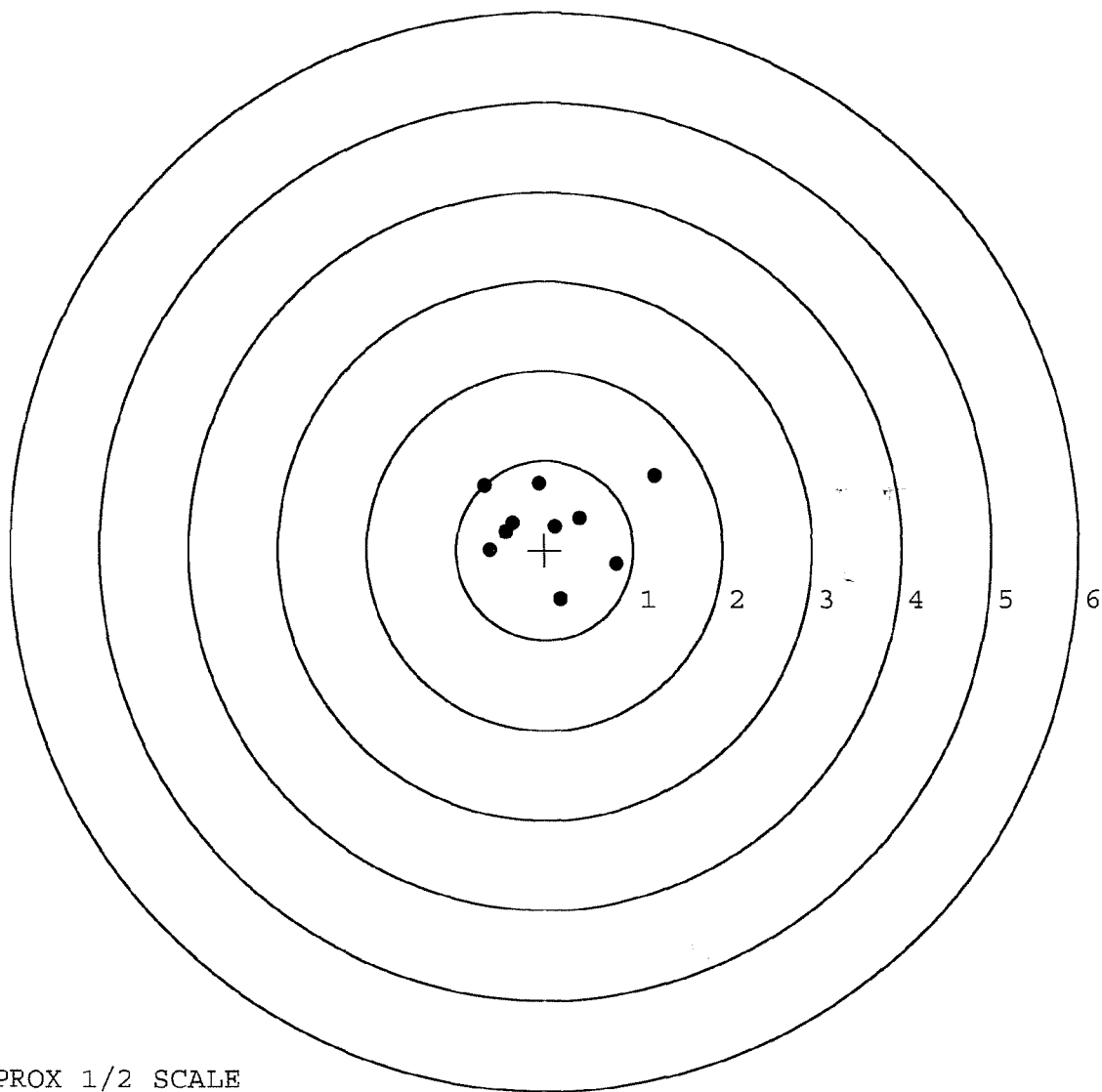
MEAN RADIUS: 0.642

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.681	0.726
2:	-0.067	0.742
3:	-0.621	-0.001
4:	-0.453	0.200
5:	-0.372	0.304
6:	0.108	0.266
7:	0.387	0.360
8:	0.175	-0.544
9:	0.813	-0.156
10:	1.234	0.832



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461661:___0

TARGET NUMBER: 5

FILE DATE: 05/18/2005

FILE TIME: 10:26

X CENTROID: -0.400

Y CENTROID: -1.622

POA TO CENTROID: 1.671

HORZ SPREAD: 1.384

VERT SPREAD: 2.255

GROUP SPREAD: 2.204

MIN RADIUS: 0.081

MAX RADIUS: 1.578

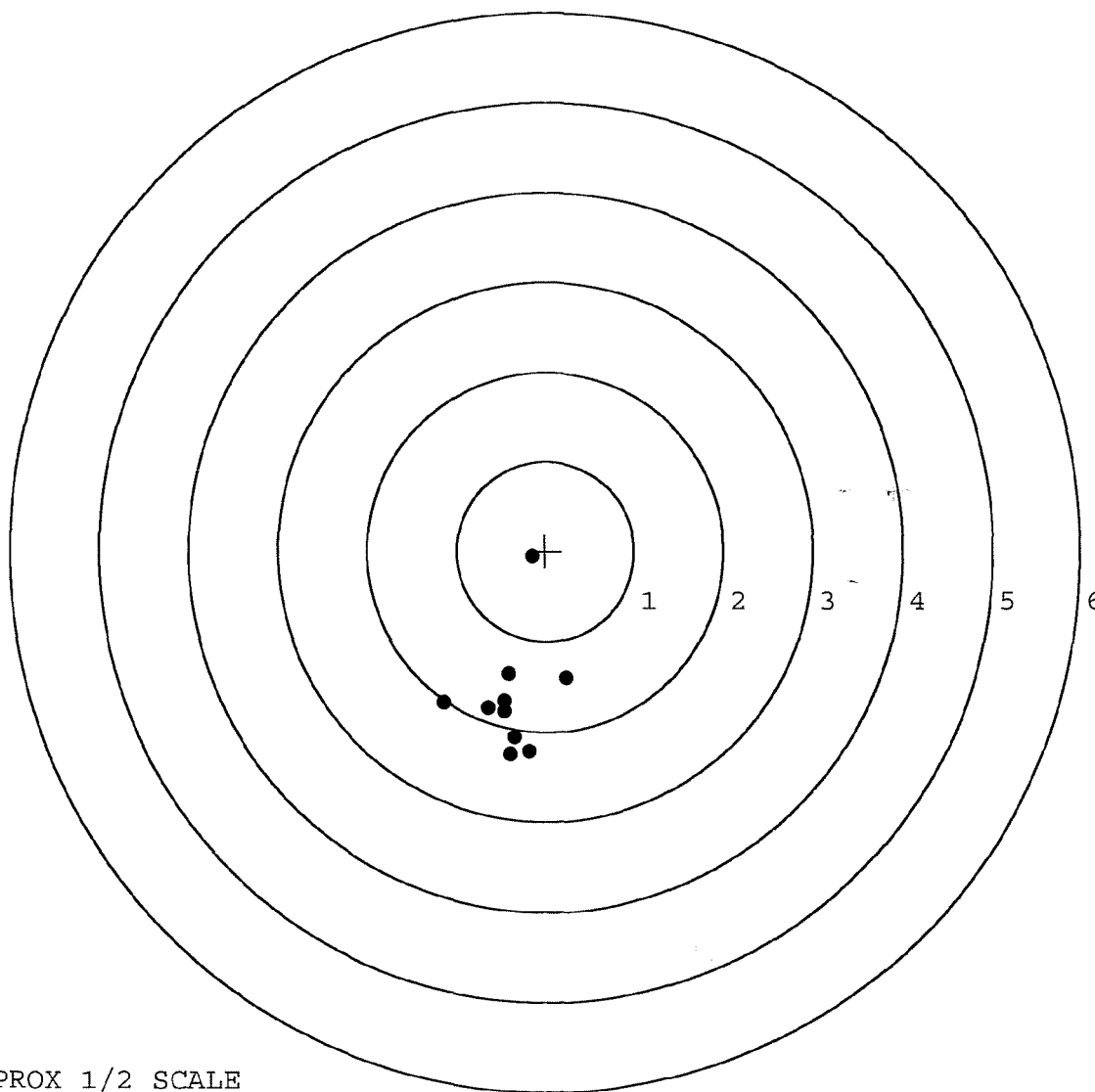
MEAN RADIUS: 0.550

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.469	-1.664
2:	0.238	-1.405
3:	-0.417	-1.361
4:	-1.146	-1.684
5:	-0.650	-1.735
6:	-0.470	-1.774
7:	-0.354	-2.060
8:	-0.394	-2.255
9:	-0.181	-2.221
10:	-0.153	-0.064



TARGET APPROX 1/2 SCALE