

G-646 1675-

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



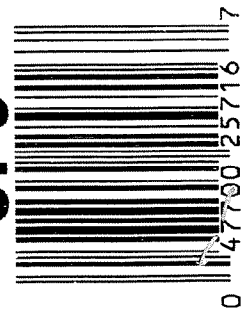
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461675

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
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ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
UPC



SERIAL NO.



4/7/2006 2:48:09 PM

Original
9
Crib

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 # G6461675

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	4-18-05	AC
610	DIS-ASSEMBLE GUN	INSPECTED	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 21 2005 OPERATOR <u>BD</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		5-11-05	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	6 lbs 6 lbs 6 lbs	5-19-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	3 lbs 3 lbs 3 lbs	5-19-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	.024 .024 .024	5-18-05	AC
	J) ASSEMBLE STOCK		5-11-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-19-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-11-05	RTZ
	M) IRON SIGHT ALIGNMENT		5-11-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-11-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-12-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-12-05	AC
655	FINAL INSPECTION A) HEADSPACE		5-19-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.38 2.57 2.46 2.33 2.40	5-19-05	AC
	C) FUNCTION		5-19-05	AC
660	PACK		5-23-05	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 5-9-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.60	2.37		2.41	
PULL #2	2.53	2.55		2.58	
PULL #3	2.50	2.48		2.52	
PULL #4	2.55	2.79		2.65	
PULL #5	2.37	2.97		2.09	
TOTAL	12.55	13.16		12.25	
AVERAGE	2.51	2.63		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.55		
PULL #2	3.32	3.37		
PULL #3	3.19	3.18		
PULL #4	3.28	3.47		
PULL #5	3.24	3.33		
TOTAL	16.39	16.90		
AVERAGE	3.27	3.38		

	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	4.46		4.17
PULL #2	4.17	4.44		4.34
PULL #3	4.19	4.45		4.25
PULL #4	4.25	4.41		4.28
PULL #5	4.23	4.45		4.28
TOTAL	21.09	22.21		21.32
AVERAGE	4.21	4.44		4.26

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461675.__1
FILE DATE AND TIME: 05/12/2005 08:08

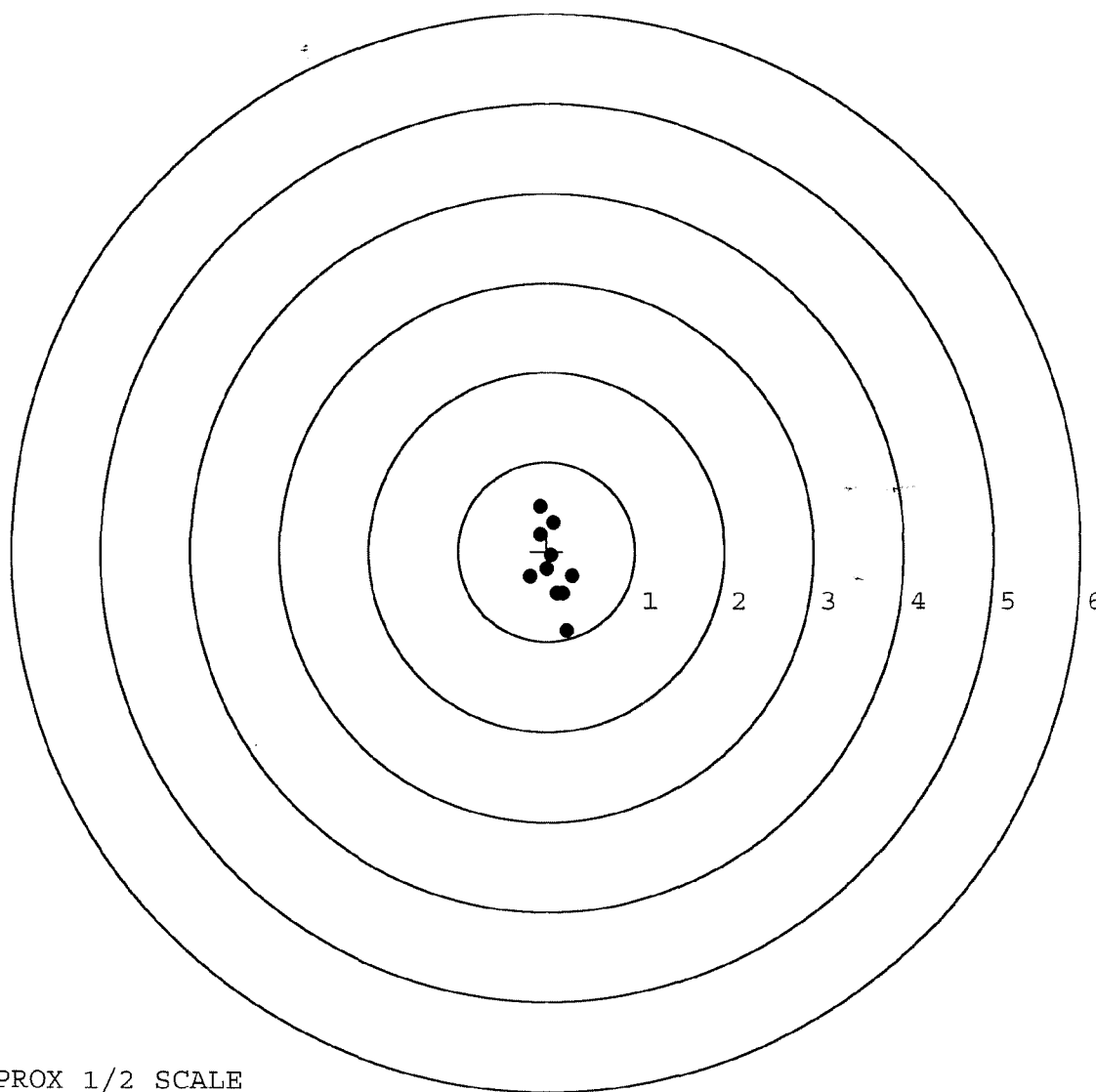
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.032
The Average Y Centroid of the Five Target Set:	0.223
The Average Point of Impact of the Five Target Set:	0.225
The Average Mean Radius of the Five Target Set:	1.054
The Distance from POA to Centroid Target #1:	0.171
The Distance from Centroid Target #2 to Centroid Target #1:	0.034
The Distance from Centroid Target #3 to Centroid Target #1:	0.390
The Distance from Centroid Target #4 to Centroid Target #1:	0.708
The Distance from Centroid Target #5 to Centroid Target #1:	0.872

SERIAL NUMBER: G6461675.___1
TARGET NUMBER: 1
FILE DATE: 05/12/2005
FILE TIME: 08:08

X CENTROID: 0.058
Y CENTROID: -0.161
POA TO CENTROID: 0.171
HORZ SPREAD: 0.481
VERT SPREAD: 1.390
GROUP SPREAD: 1.423
MIN RADIUS: 0.066
MAX RADIUS: 0.746
MEAN RADIUS: 0.365
IN 1 IN DIAMETER: 8
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.221	-0.889
2:	-0.084	0.501
3:	0.070	0.323
4:	-0.077	0.191
5:	0.047	-0.043
6:	-0.189	-0.281
7:	0.292	-0.276
8:	0.115	-0.470
9:	0.185	-0.473
10:	0.002	-0.195

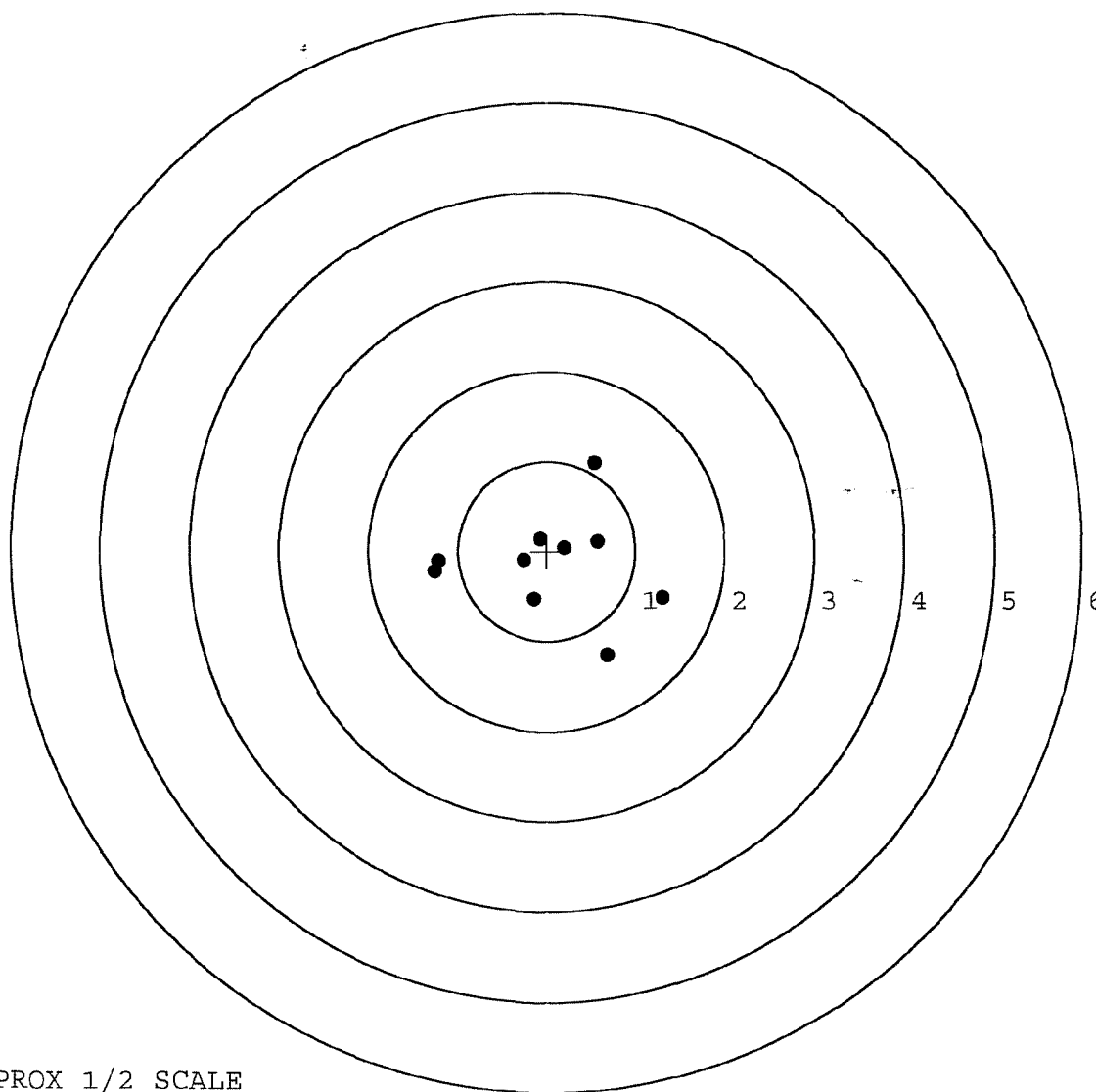


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461675. 1
TARGET NUMBER: 2
FILE DATE: 05/12/2005
FILE TIME: 08:08

X CENTROID: 0.032
Y CENTROID: -0.140
POA TO CENTROID: 0.143
HORZ SPREAD: 2.558
VERT SPREAD: 2.140
GROUP SPREAD: 2.575
MIN RADIUS: 0.238
MAX RADIUS: 1.326
MEAN RADIUS: 0.817
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.301	-0.526
2:	0.679	-1.154
3:	0.536	0.986
4:	0.574	0.113
5:	0.195	0.034
6:	-0.076	0.137
7:	-0.264	-0.101
8:	-0.150	-0.539
9:	-1.217	-0.119
10:	-1.257	-0.228

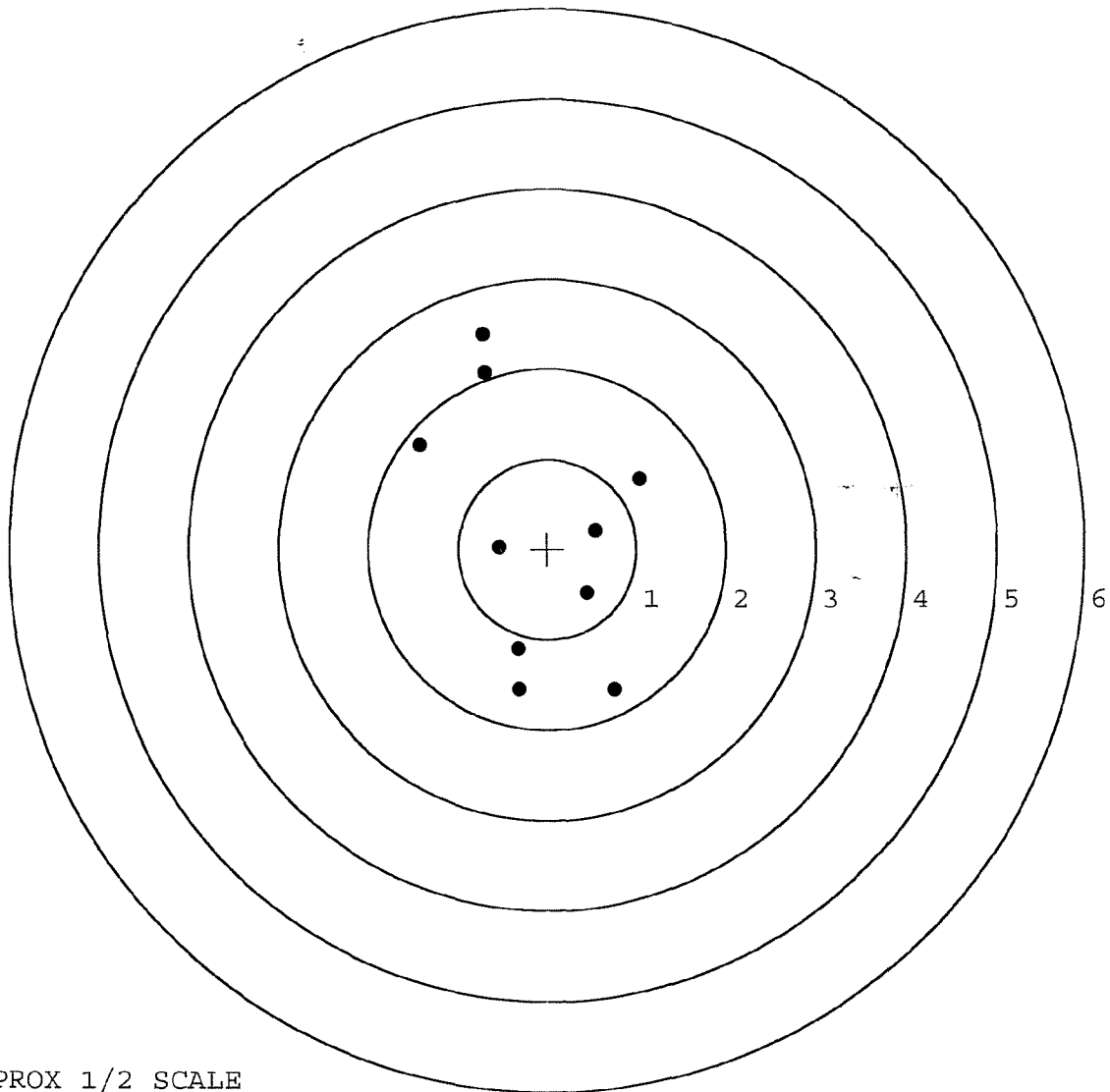


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461675. 1
TARGET NUMBER: 3
FILE DATE: 05/12/2005
FILE TIME: 08:08

X CENTROID: -0.127
Y CENTROID: 0.181
POA TO CENTROID: 0.222
HORZ SPREAD: 2.459
VERT SPREAD: 3.942
GROUP SPREAD: 4.208
MIN RADIUS: 0.445
MAX RADIUS: 2.280
MEAN RADIUS: 1.408
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	0.751	-1.559
2:	-0.325	-1.557
3:	-0.330	-1.113
4:	0.440	-0.481
5:	0.540	0.212
6:	1.038	0.786
7:	-0.544	0.025
8:	-1.421	1.160
9:	-0.702	1.957
10:	-0.721	2.383



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461675. 1

TARGET NUMBER: 4

FILE DATE: 05/12/2005

FILE TIME: 08:08

X CENTROID: 0.011

Y CENTROID: 0.545

POA TO CENTROID: 0.545

HORZ SPREAD: 1.780

VERT SPREAD: 3.241

GROUP SPREAD: 3.252

MIN RADIUS: 0.136

MAX RADIUS: 1.724

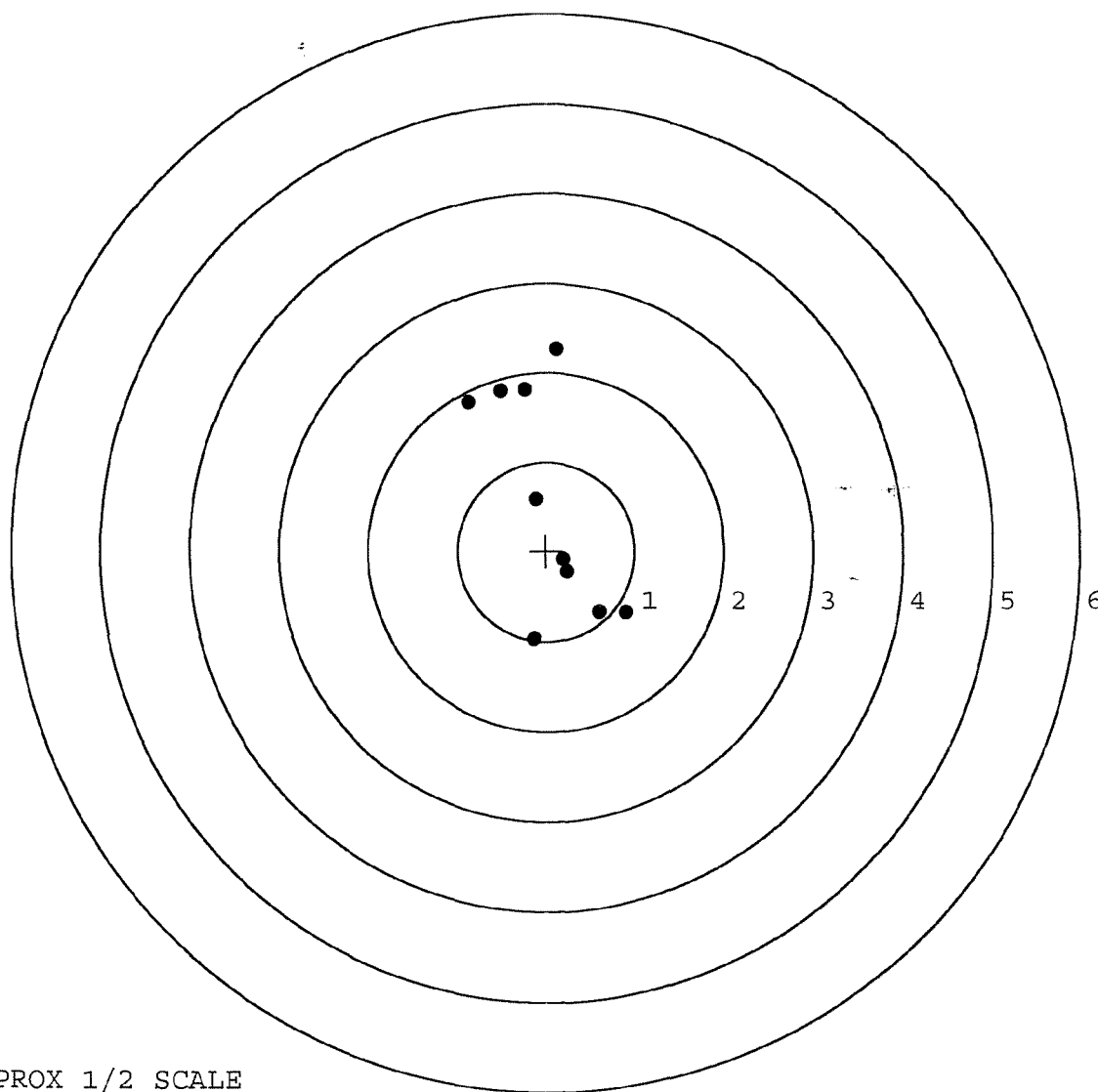
MEAN RADIUS: 1.183

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.895	-0.684
2:	0.597	-0.677
3:	-0.146	-0.975
4:	0.239	-0.238
5:	0.191	-0.094
6:	-0.120	0.581
7:	-0.250	1.808
8:	-0.525	1.795
9:	-0.885	1.671
10:	0.118	2.266

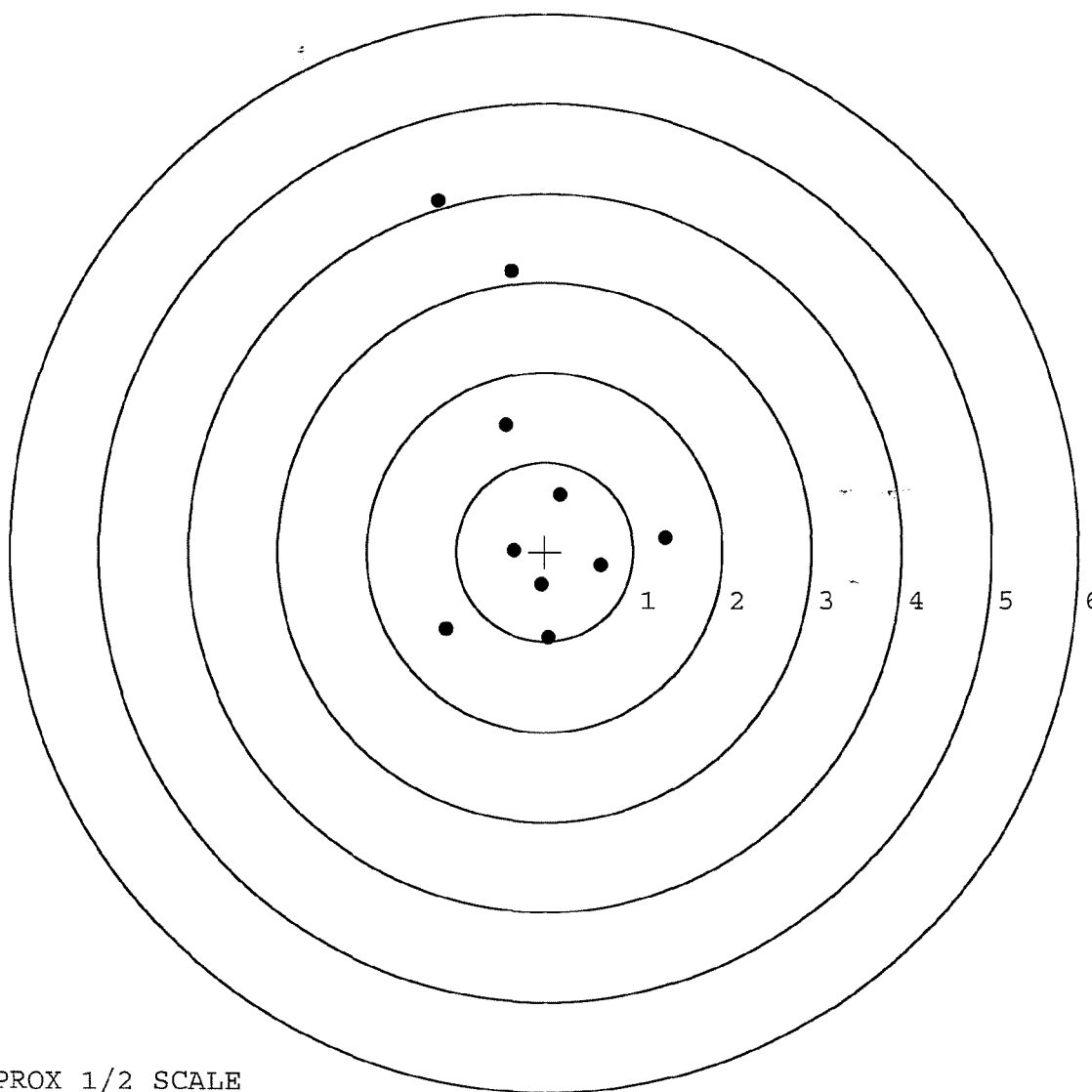


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461675. 1
TARGET NUMBER: 5
FILE DATE: 05/12/2005
FILE TIME: 08:08

X CENTROID: -0.134
Y CENTROID: 0.689
POA TO CENTROID: 0.702
HORZ SPREAD: 2.563
VERT SPREAD: 4.882
GROUP SPREAD: 5.035
MIN RADIUS: 0.306
MAX RADIUS: 3.399
MEAN RADIUS: 1.496
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	1.365	0.153
2:	0.630	-0.159
3:	0.035	-0.964
4:	-0.041	-0.373
5:	-1.118	-0.872
6:	-0.353	0.015
7:	0.168	0.639
8:	-0.444	1.412
9:	-0.380	3.126
10:	-1.198	3.918



TARGET APPROX 1/2 SCALE