

G 6461682

ORDER 25716

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

UPC



ORDER 25716

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

UPC



SERIAL NO.



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



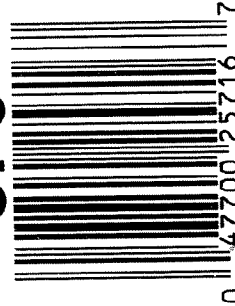
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461682

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4/7/2005 2:48:09 PM

Crtd

25

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 # 66461682

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	A
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>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>	5-31-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs</u> <u>4 lbs</u> <u>4 lbs</u>	5-31-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		5-23-05	Ac
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-31-05	Ac
	J) ASSEMBLE STOCK		5-11-05	RTL
	K) ASSEMBLE SWIVEL STUDS		5-31-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-11-05	RL
	M) IRON SIGHT ALIGNMENT		5-11-05	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-11-05	RL
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	5-16-05	Ac
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-16-05	TRW
655	FINAL INSPECTION A) HEADSPACE		5-31-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.31</u> <u>2.45</u> <u>2.43</u> <u>2.50</u> <u>2.46</u>	5-23-05	Ac
	C) FUNCTION		5-31-05	Ac
660	PACK		6-7-05	WA

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 TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.80	2.58		2.40	
PULL #2	2.52	2.63		2.42	
PULL #3	2.82	2.88		2.51	
PULL #4	2.76	2.62		2.52	
PULL #5	2.87	2.79		2.46	
TOTAL	13.77	13.50		12.31	
AVERAGE	2.75	2.70		2.46	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.04		
PULL #2	3.24	3.16		
PULL #3	3.27	3.09		
PULL #4	3.22	3.12		
PULL #5	3.20	3.10		
TOTAL	16.18	15.50		
AVERAGE	3.23	3.10		

	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	4.27	4.21		4.24
PULL #2	4.29	4.31		4.22
PULL #3	4.33	4.00		4.28
PULL #4	3.95	4.27		4.23
PULL #5	4.31	4.25		4.26
TOTAL	21.15	21.04		21.23
AVERAGE	4.23	4.20		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461682.__0
FILE DATE AND TIME: 05/16/2005 06:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.064
The Average Y Centroid of the Five Target Set:	0.198
The Average Point of Impact of the Five Target Set:	0.208
The Average Mean Radius of the Five Target Set:	0.877
The Distance from POA to Centroid Target #1:	0.579
The Distance from Centroid Target #2 to Centroid Target #1:	0.526
The Distance from Centroid Target #3 to Centroid Target #1:	0.603
The Distance from Centroid Target #4 to Centroid Target #1:	0.668
The Distance from Centroid Target #5 to Centroid Target #1:	0.435

SERIAL NUMBER: G6461682. __0

TARGET NUMBER: 1

FILE DATE: 05/16/2005

FILE TIME: 06:11

X CENTROID: 0.420

Y CENTROID: 0.399

POA TO CENTROID: 0.579

HORZ SPREAD: 2.283

VERT SPREAD: 2.477

GROUP SPREAD: 2.775

MIN RADIUS: 0.598

MAX RADIUS: 1.556

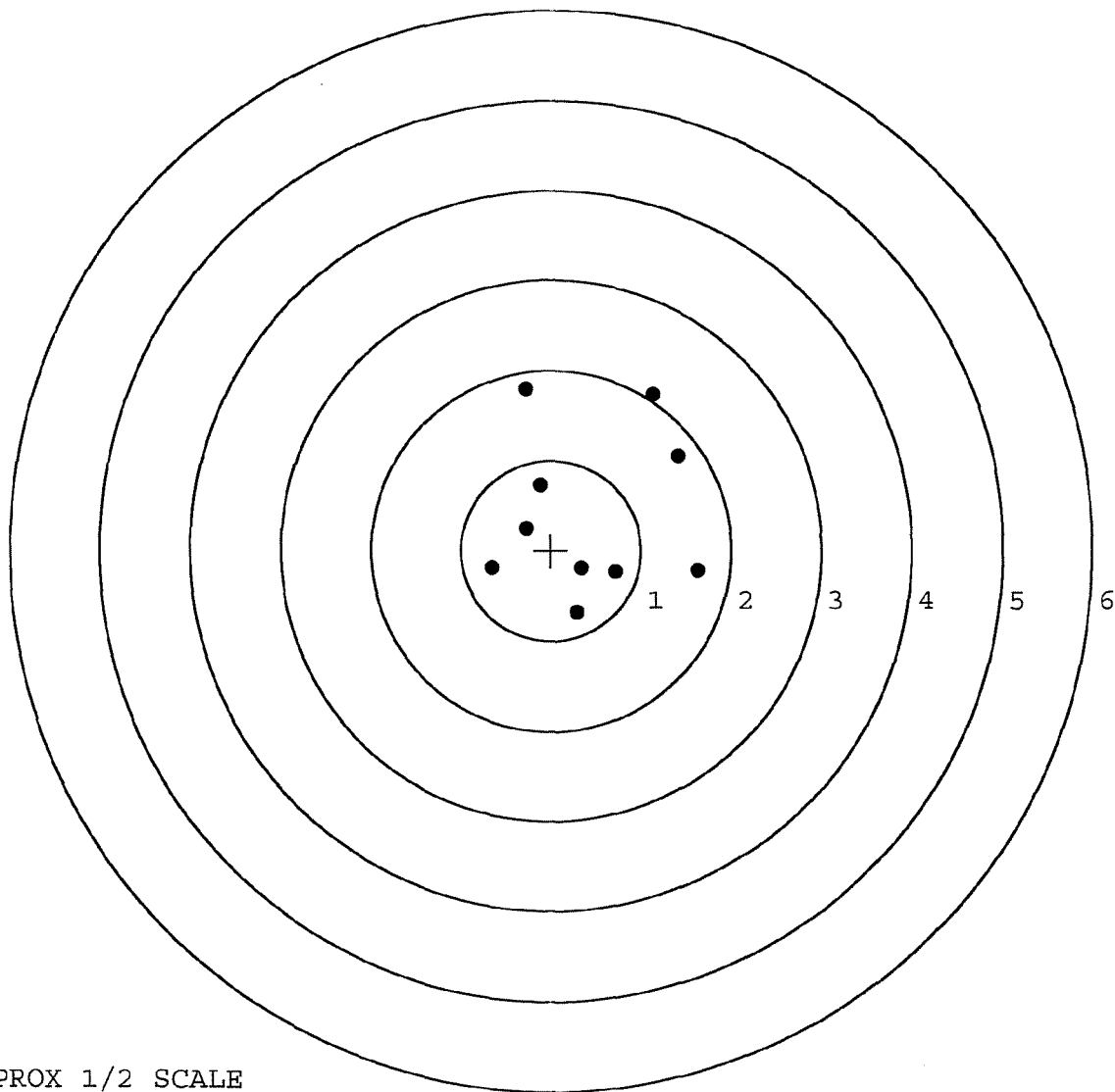
MEAN RADIUS: 1.057

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.628	-0.226
2:	1.409	1.043
3:	-0.282	1.787
4:	-0.116	0.725
5:	-0.277	0.244
6:	-0.655	-0.192
7:	0.716	-0.241
8:	0.346	-0.195
9:	0.297	-0.690
10:	1.132	1.732

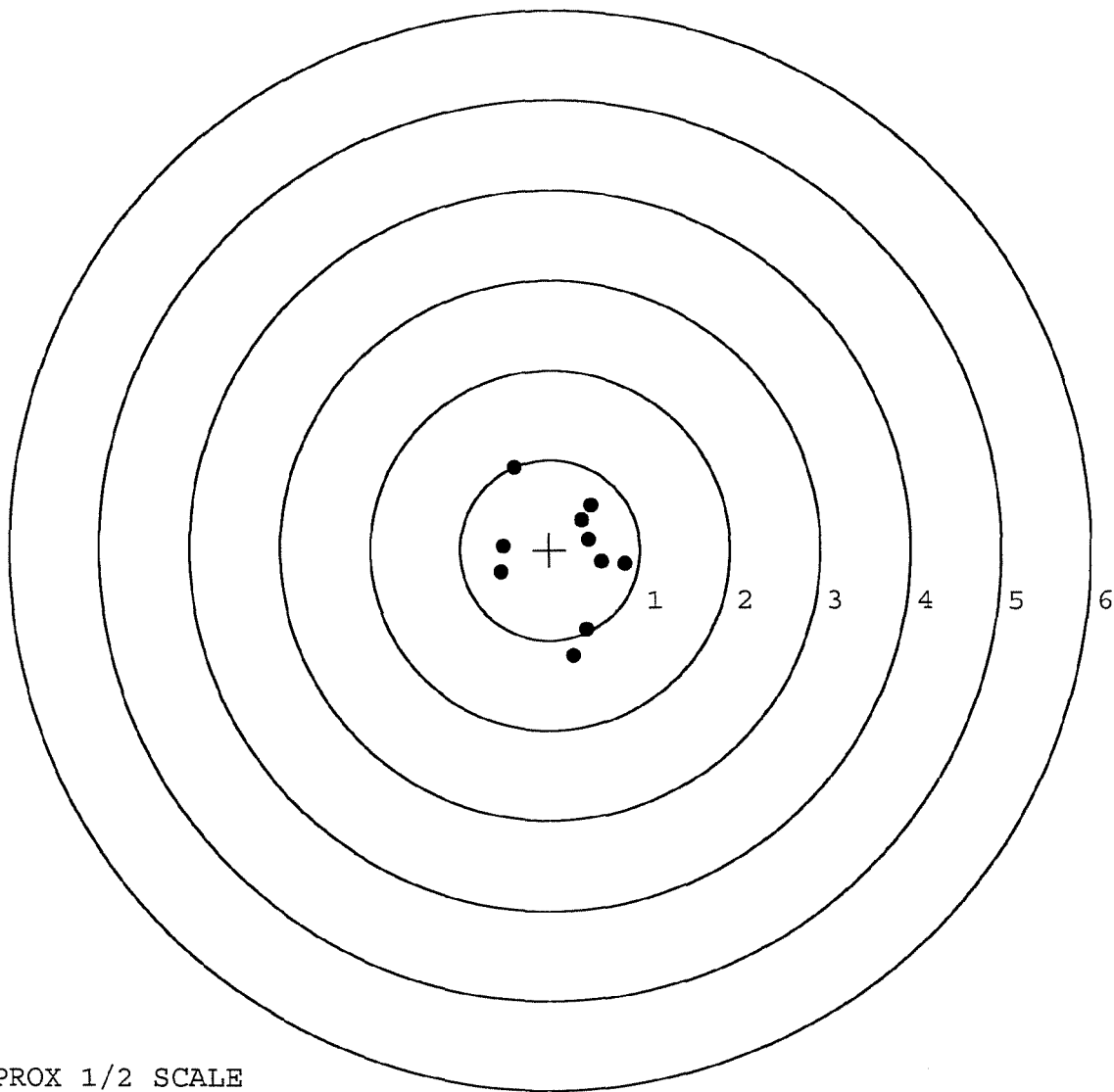


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461682. __0
TARGET NUMBER: 2
FILE DATE: 05/16/2005
FILE TIME: 06:11

POINT#	X	Y
1:	0.268	-1.180
2:	0.414	-0.886
3:	0.840	-0.159
4:	0.576	-0.135
5:	0.439	0.112
6:	0.354	0.320
7:	0.457	0.491
8:	-0.519	0.036
9:	-0.543	-0.250
10:	-0.397	0.910

X CENTROID: 0.189
Y CENTROID: -0.074
POA TO CENTROID: 0.203
HORZ SPREAD: 1.383
VERT SPREAD: 2.090
GROUP SPREAD: 2.193
MIN RADIUS: 0.312
MAX RADIUS: 1.145
MEAN RADIUS: 0.698
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461682. __0

TARGET NUMBER: 3

FILE DATE: 05/16/2005

FILE TIME: 06:11

POINT#	X	Y
1:	0.626	0.091
2:	0.790	0.616
3:	0.061	0.274
4:	-0.765	-0.145
5:	-1.821	0.098
6:	-0.922	1.018
7:	-0.565	2.249
8:	0.559	1.957
9:	0.261	-0.819
10:	-0.052	-1.084

X CENTROID: -0.183

Y CENTROID: 0.426

POA TO CENTROID: 0.463

HORZ SPREAD: 2.611

VERT SPREAD: 3.333

GROUP SPREAD: 3.372

MIN RADIUS: 0.287

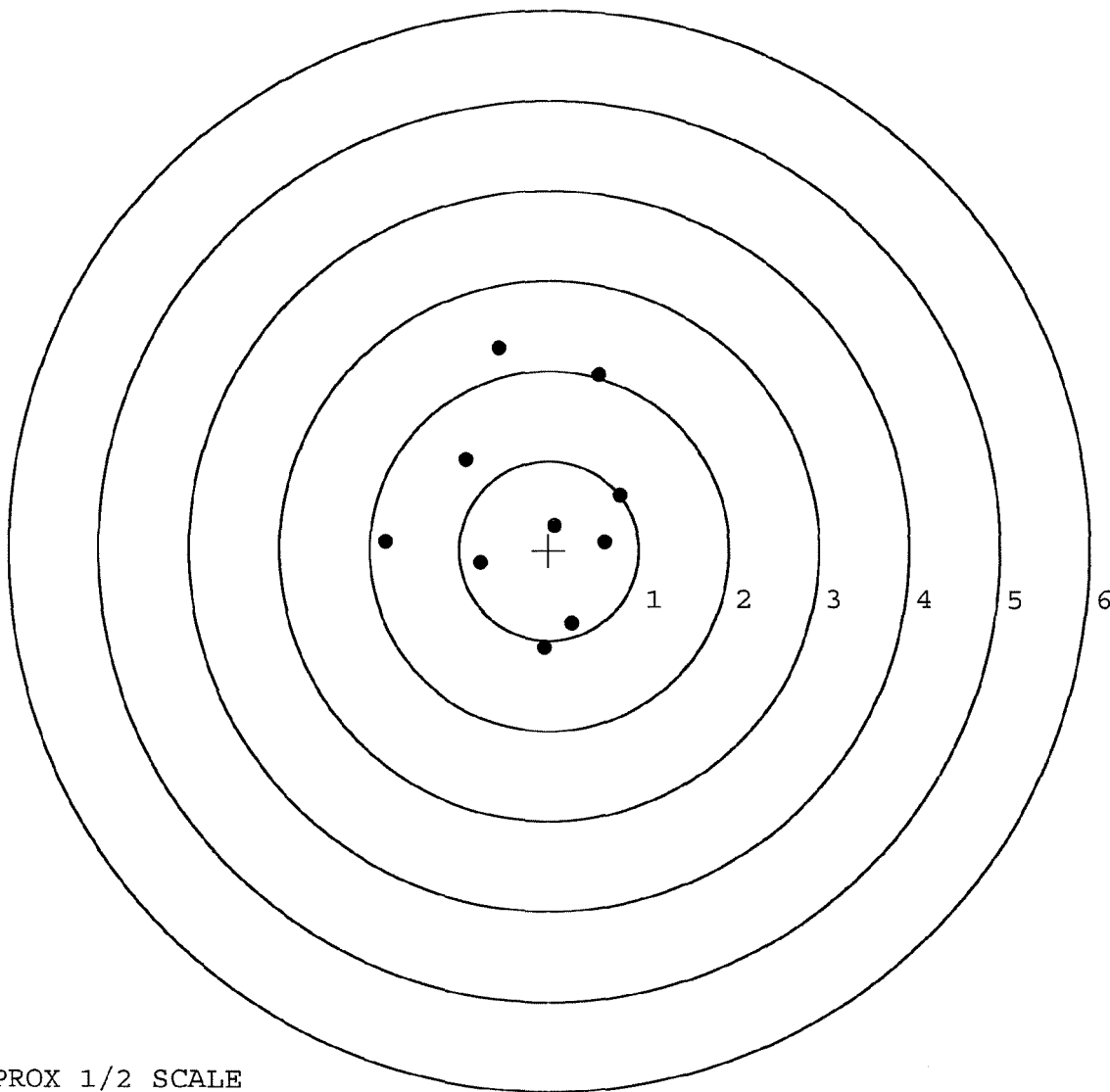
MAX RADIUS: 1.863

MEAN RADIUS: 1.199

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6

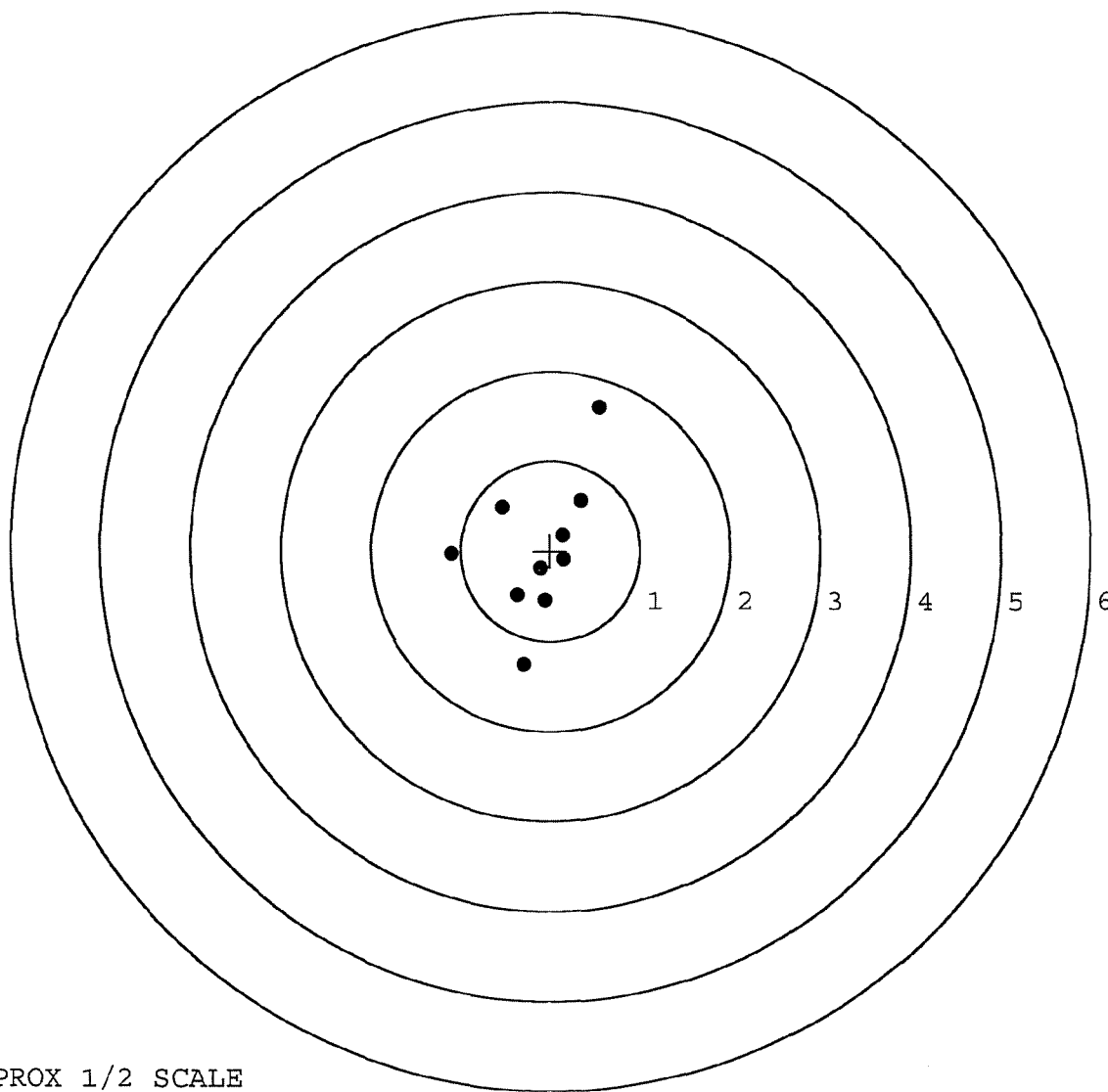


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461682. __ 0
 TARGET NUMBER: 4
 FILE DATE: 05/16/2005
 FILE TIME: 06:11

X CENTROID: -0.130
 Y CENTROID: 0.019
 POA TO CENTROID: 0.131
 HORZ SPREAD: 1.644
 VERT SPREAD: 2.864
 GROUP SPREAD: 2.984
 MIN RADIUS: 0.215
 MAX RADIUS: 1.719
 MEAN RADIUS: 0.728
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.296	-1.263
2:	-1.102	-0.039
3:	-0.537	0.486
4:	0.542	1.601
5:	0.341	0.564
6:	0.142	0.168
7:	0.147	-0.095
8:	-0.108	-0.195
9:	-0.062	-0.550
10:	-0.368	-0.488



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461682.___0

TARGET NUMBER: 5

FILE DATE: 05/16/2005

FILE TIME: 06:11

POINT#	X	Y
1:	0.291	-0.791
2:	-0.171	-0.856
3:	0.399	0.711
4:	0.590	1.141
5:	0.532	0.974
6:	-1.018	0.729
7:	0.090	0.264
8:	0.124	-0.014
9:	-0.461	0.086
10:	-0.153	-0.018

X CENTROID: 0.022

Y CENTROID: 0.223

POA TO CENTROID: 0.224

HORZ SPREAD: 1.608

VERT SPREAD: 1.997

GROUP SPREAD: 2.006

MIN RADIUS: 0.079

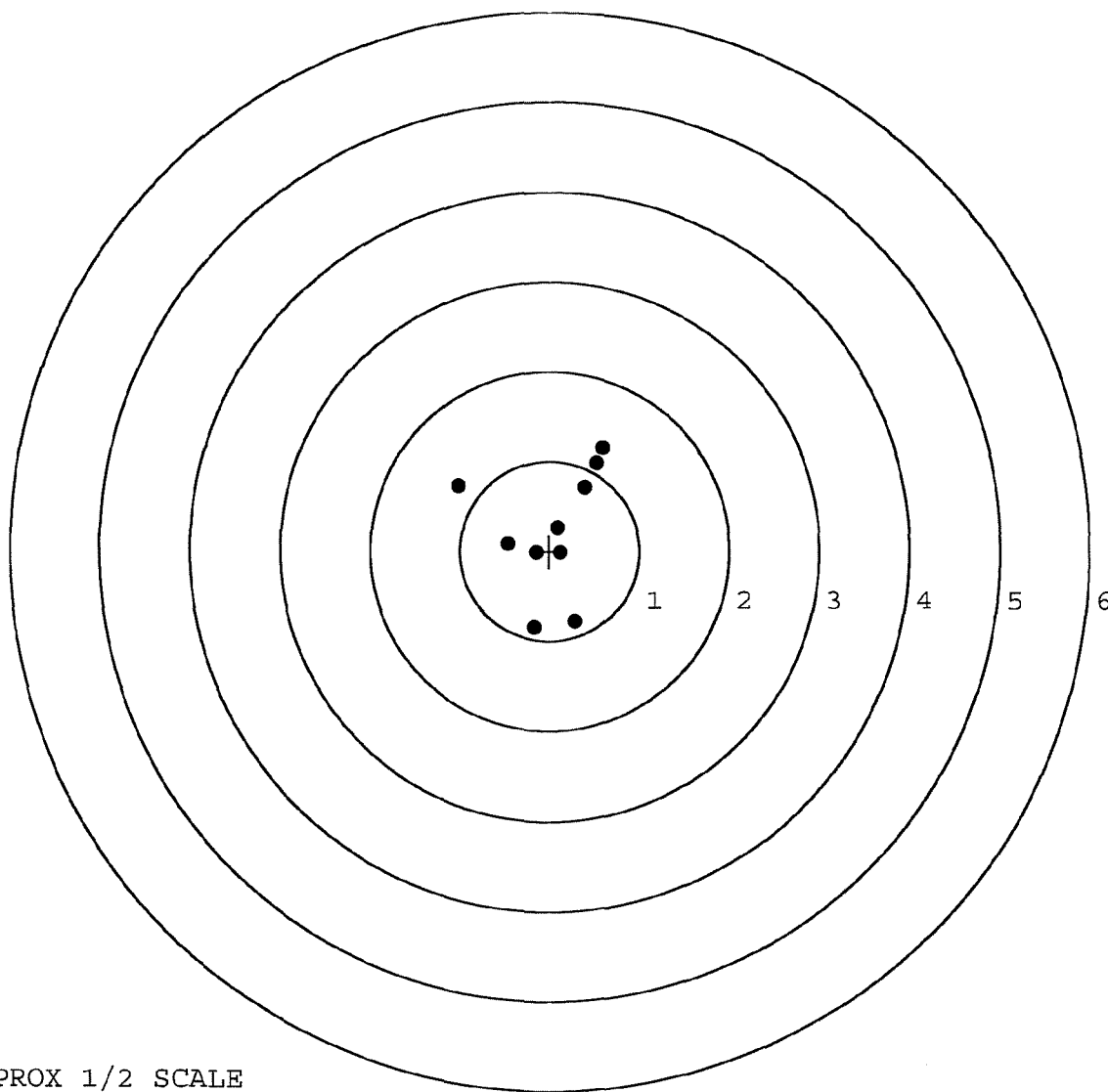
MAX RADIUS: 1.157

MEAN RADIUS: 0.704

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE