

G-646 1690

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



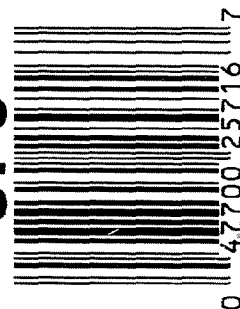
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461690

UPC



4/7/2005 2:48:09 PM

Chib

23

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 # G646 1690

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	X
610	DIS-ASSEMBLE GUN		4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 21 2005 OPERATOR <u>BZ</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		5-16-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-16-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-16-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-16-05	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	<i>A</i>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs</u> <u>4 lbs</u> <u>4 lbs</u>	5-31-05	<i>A</i>
	H) TRIGGER PULL TEST AND RETAINABILITY		5-27-05	<i>A</i>
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	5-31-05	<i>A</i>
	J) ASSEMBLE STOCK		5-16-05	RT
	K) ASSEMBLE SWIVEL STUDS		5-31-05	<i>A</i>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-16-05	RT
	M) IRON SIGHT ALIGNMENT		5-16-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-16-05	RT
640	GALLERY TEST AND TARGET	PASS FAIL	5-20-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-20-05	<i>A</i>
655	FINAL INSPECTION A) HEADSPACE		5-31-05	<i>A</i>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.73</u> <u>2.69</u> <u>2.62</u> <u>2.76</u> <u>2.78</u>	5-27-05	<i>A</i>
	C) FUNCTION		5-31-05	<i>A</i>
660	PACK		6-1-05	RT

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

5-2-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.38		2.11	
PULL #2	2.52	2.20		2.07	
PULL #3	2.48	2.42		2.05	
PULL #4	2.45	2.31		2.07	
PULL #5	2.64	2.35		2.07	
TOTAL	12.40	11.66		10.37	
AVERAGE	2.48	2.33		2.07	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.16		
PULL #2	3.20	3.09		
PULL #3	3.22	3.15		
PULL #4	3.14	3.08		
PULL #5	3.05	2.93		
TOTAL	15.89	15.41		
AVERAGE	3.17	3.08		

	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	4.28	4.13		4.18
PULL #2	4.22	4.09		4.12
PULL #3	4.17	4.08		4.15
PULL #4	4.13	4.06		4.18
PULL #5	4.17	3.76		4.14
TOTAL	20.97	20.12		20.77
AVERAGE	4.19	4.02		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461690.__0
FILE DATE AND TIME: 05/20/2005 06:32

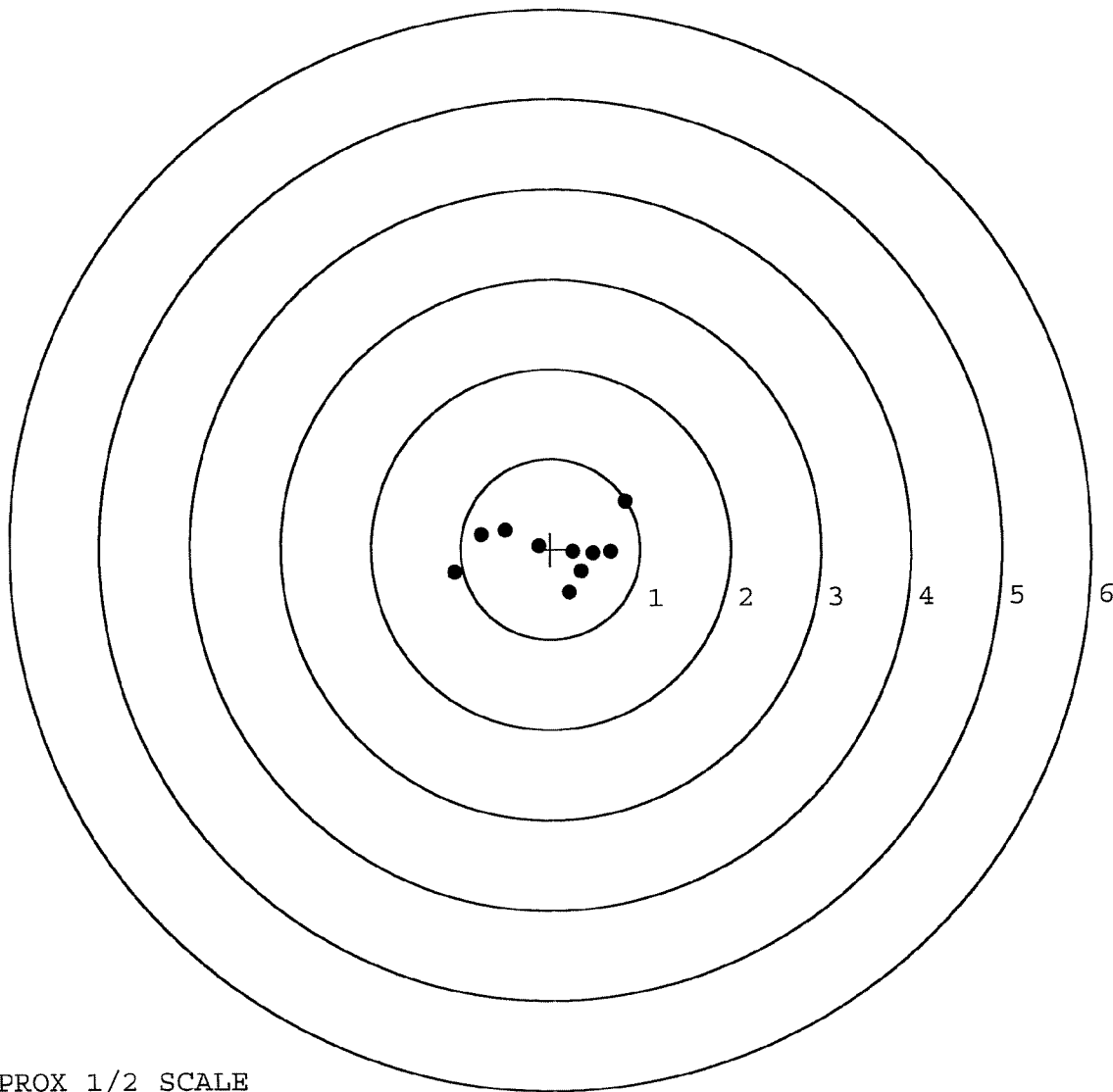
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.034
The Average Y Centroid of the Five Target Set:	0.014
The Average Point of Impact of the Five Target Set:	0.037
The Average Mean Radius of the Five Target Set:	0.825
The Distance from POA to Centroid Target #1:	0.035
The Distance from Centroid Target #2 to Centroid Target #1:	0.672
The Distance from Centroid Target #3 to Centroid Target #1:	0.062
The Distance from Centroid Target #4 to Centroid Target #1:	0.241
The Distance from Centroid Target #5 to Centroid Target #1:	0.619

SERIAL NUMBER: G6461690. __0
TARGET NUMBER: 1
FILE DATE: 05/20/2005
FILE TIME: 06:32

X CENTROID: 0.031
Y CENTROID: -0.016
POA TO CENTROID: 0.035
HORZ SPREAD: 1.903
VERT SPREAD: 1.007
GROUP SPREAD: 2.053
MIN RADIUS: 0.172
MAX RADIUS: 1.123
MEAN RADIUS: 0.587
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.836	0.521
2:	0.672	-0.034
3:	0.475	-0.052
4:	0.212	-0.486
5:	0.341	-0.253
6:	0.250	-0.032
7:	-0.132	0.039
8:	-0.505	0.217
9:	-0.771	0.170
10:	-1.067	-0.250



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461690. __0

TARGET NUMBER: 2

FILE DATE: 05/20/2005

FILE TIME: 06:32

POINT#	X	Y
1:	0.150	2.484
2:	-0.549	1.884
3:	0.264	1.612
4:	1.309	0.745
5:	0.510	0.172
6:	0.080	0.418
7:	0.131	-0.161
8:	-0.111	-0.613
9:	-0.643	-0.129
10:	0.003	0.093

X CENTROID: 0.114

Y CENTROID: 0.651

POA TO CENTROID: 0.660

HORZ SPREAD: 1.952

VERT SPREAD: 3.097

GROUP SPREAD: 3.108

MIN RADIUS: 0.235

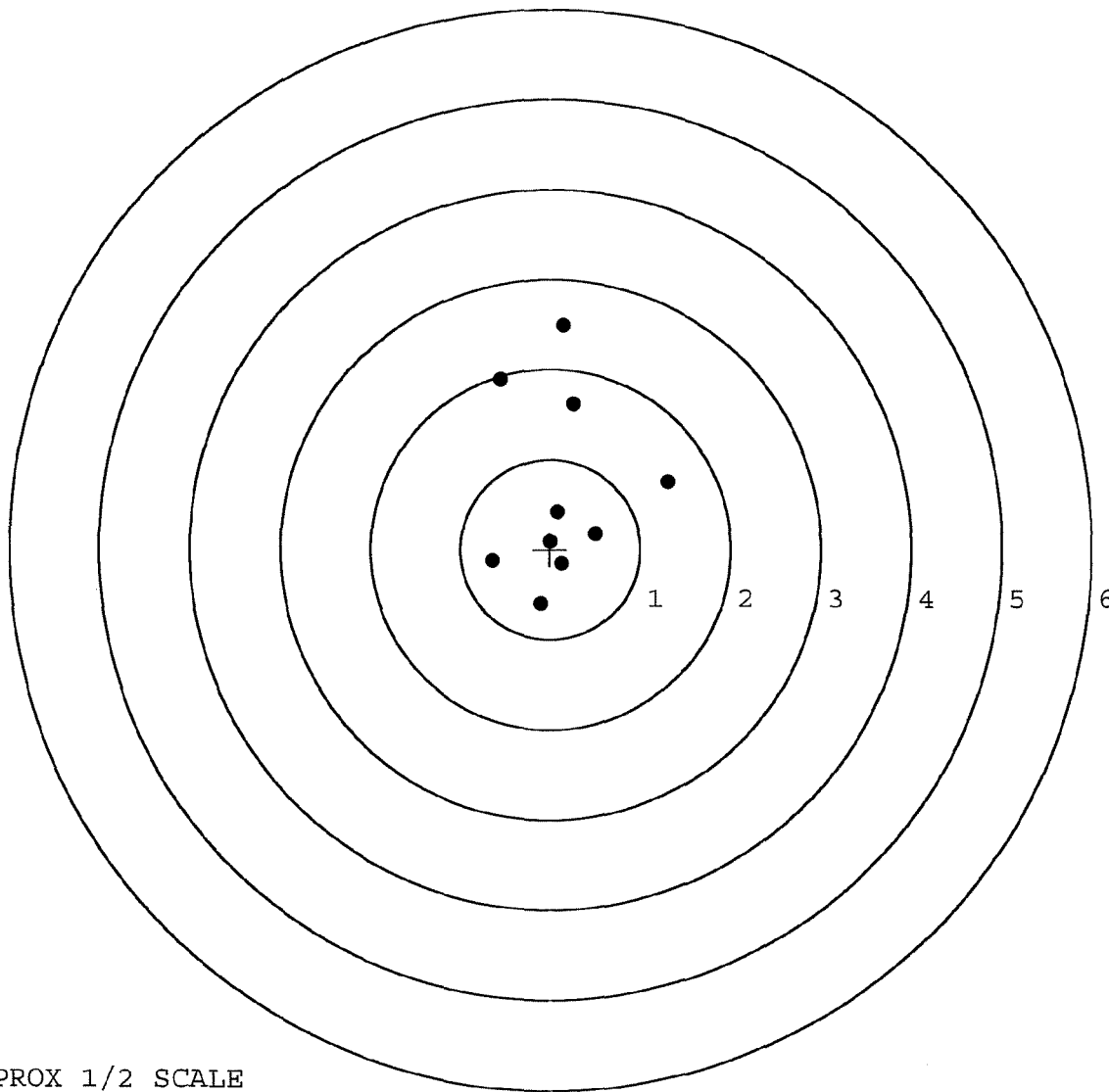
MAX RADIUS: 1.834

MEAN RADIUS: 1.001

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461690. __0

TARGET NUMBER: 3

FILE DATE: 05/20/2005

FILE TIME: 06:32

POINT#	X	Y
1:	0.190	-1.080
2:	-0.522	-1.491
3:	-0.019	-0.491
4:	-0.482	-0.208
5:	0.544	-0.088
6:	0.604	0.516
7:	0.108	0.920
8:	-0.217	0.797
9:	-0.024	0.272
10:	-0.205	0.174

X CENTROID: -0.002

Y CENTROID: -0.068

POA TO CENTROID: 0.068

HORZ SPREAD: 1.126

VERT SPREAD: 2.411

GROUP SPREAD: 2.492

MIN RADIUS: 0.316

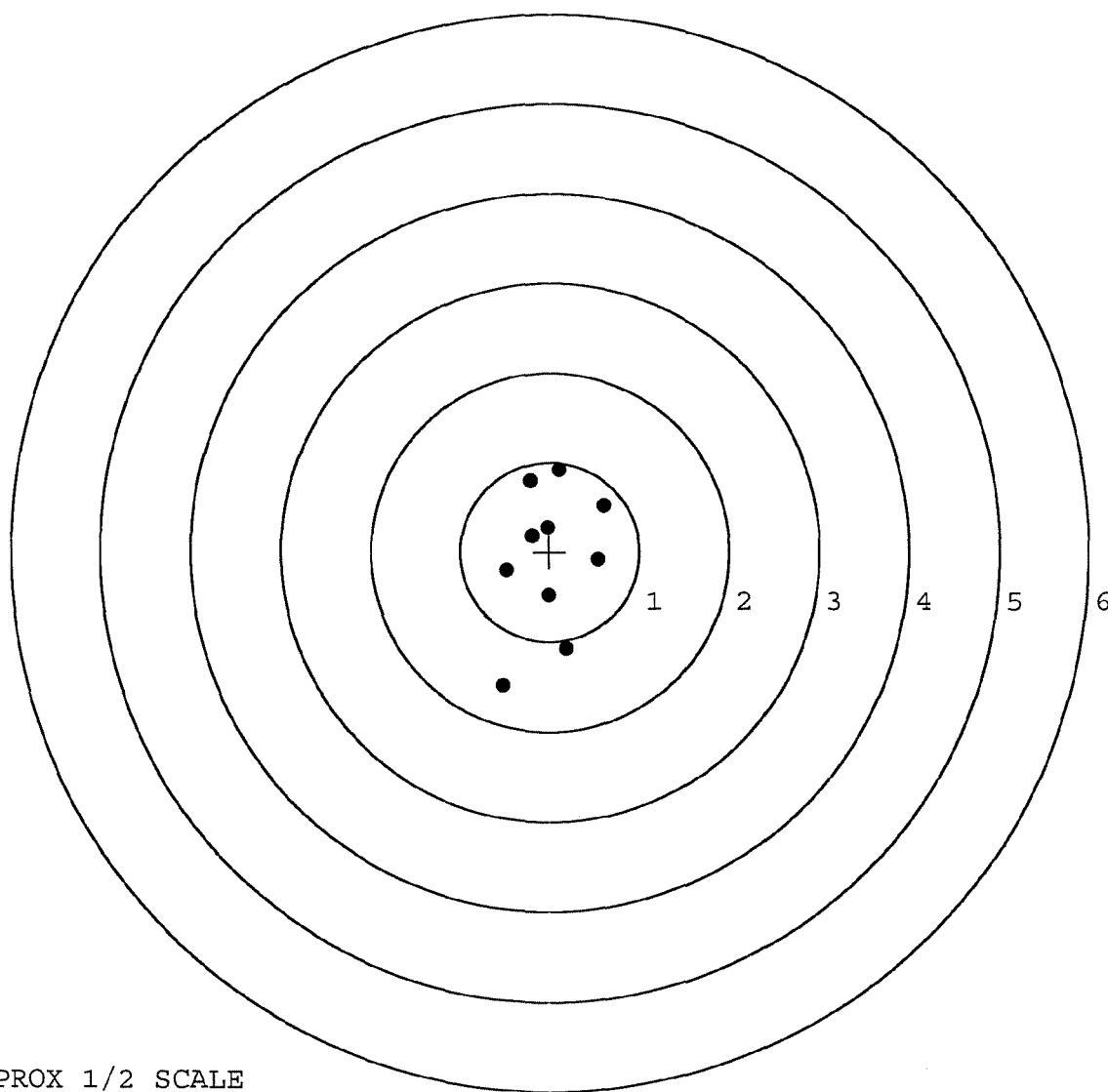
MAX RADIUS: 1.515

MEAN RADIUS: 0.740

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

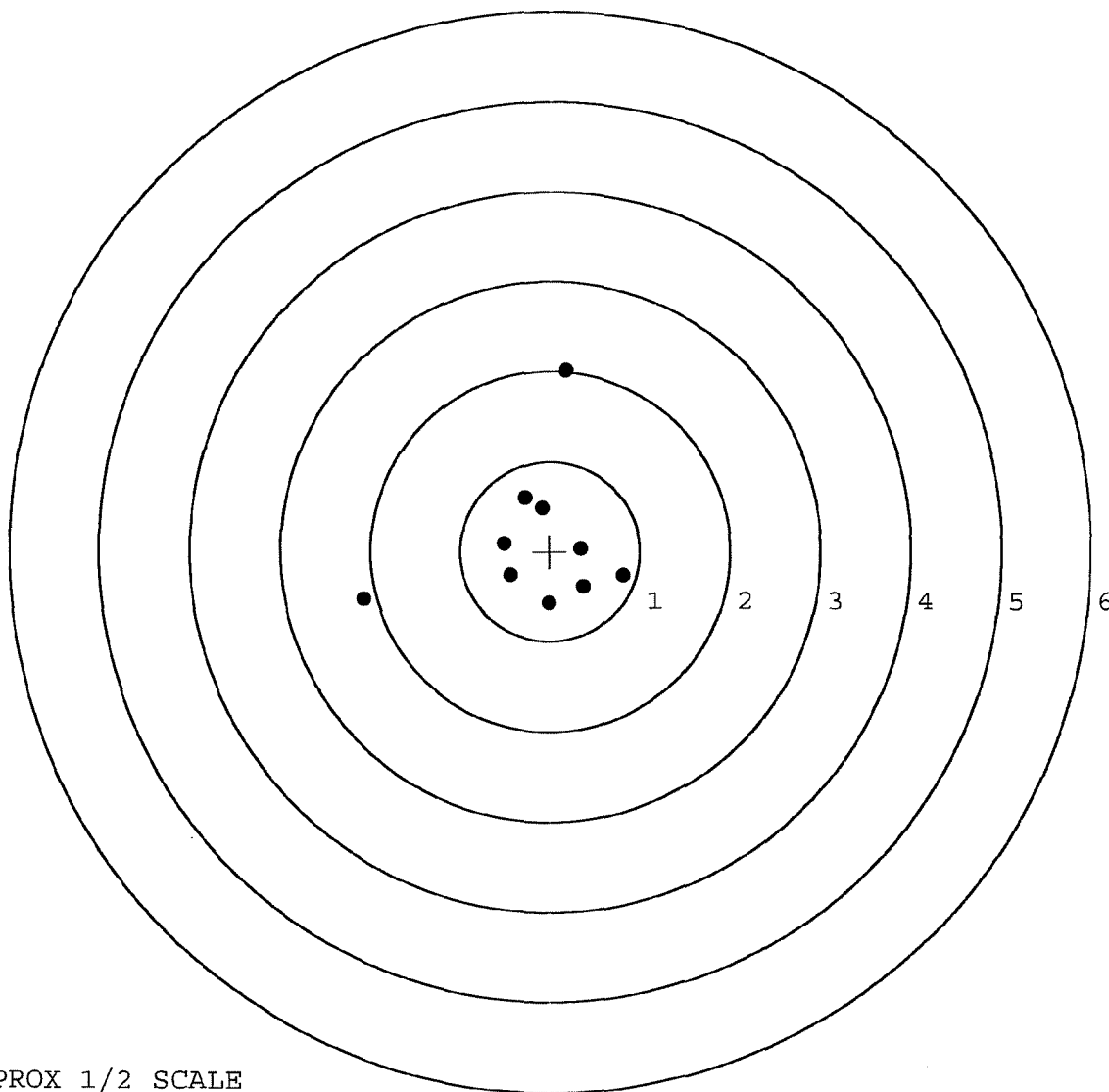


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461690. __0
TARGET NUMBER: 4
FILE DATE: 05/20/2005
FILE TIME: 06:32

X CENTROID: -0.171
Y CENTROID: 0.116
POA TO CENTROID: 0.207
HORZ SPREAD: 2.894
VERT SPREAD: 2.587
GROUP SPREAD: 3.395
MIN RADIUS: 0.343
MAX RADIUS: 2.014
MEAN RADIUS: 0.868
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.175	2.004
2:	-2.076	-0.537
3:	-0.092	0.482
4:	-0.284	0.605
5:	-0.513	0.091
6:	-0.446	-0.271
7:	-0.019	-0.583
8:	0.375	-0.396
9:	0.353	0.033
10:	0.818	-0.268

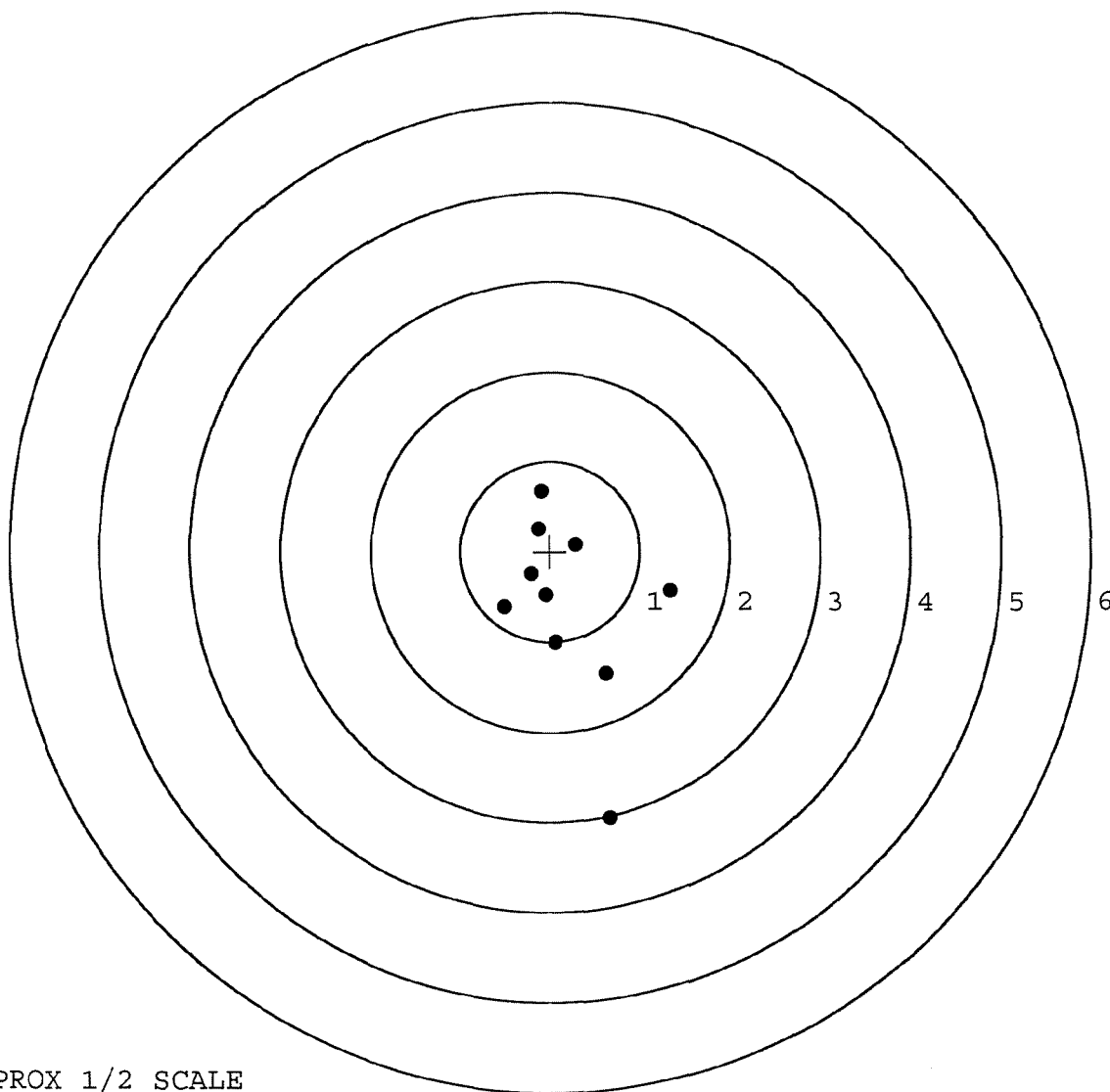


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461690. __0
TARGET NUMBER: 5
FILE DATE: 05/20/2005
FILE TIME: 06:32

POINT#	X	Y
1:	0.622	-1.347
2:	1.339	-0.443
3:	0.060	-1.009
4:	-0.050	-0.487
5:	0.293	0.077
6:	-0.136	0.250
7:	-0.101	0.669
8:	-0.212	-0.252
9:	-0.509	-0.617
10:	0.669	-2.958

X CENTROID: 0.198
Y CENTROID: -0.612
POA TO CENTROID: 0.643
HORZ SPREAD: 1.848
VERT SPREAD: 3.627
GROUP SPREAD: 3.708
MIN RADIUS: 0.277
MAX RADIUS: 2.393
MEAN RADIUS: 0.928
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE