

G646 1692

ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC



ORDER 25716
M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

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

proof of purchase



owner registration sticker



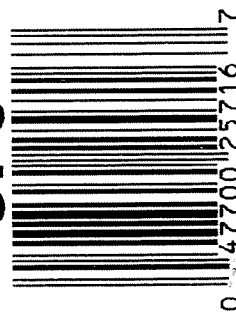
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461692

UPC



DD FORM

Original
07
4/7/2005 2:48:09 PM
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

Goff Blast Barrel & Rec Assembly,

78ROT01



0003858612

0540

Flat Black Powder Coat, Barrel and

01PC001



0003858602

0560

Reassemble Action.

89SWS1



0003858603

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461692

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	K
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 20 2005 OPERATOR BS		
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>7 lbs</u> <u>7 lbs</u> <u>7 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	RTL
	M) IRON SIGHT ALIGNMENT		5-11-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-11-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-12-05	TRLW
	MALFUNCTION <i>Bolt release sticks</i>	CORRECTION <i>OK</i>	5-31-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-12-05	TRLW
655	FINAL INSPECTION A) HEADSPACE		5-31-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.69</u> <u>2.99</u> <u>2.99</u> <u>2.95</u>	5-23-05	AC
	C) FUNCTION		5-31-05	AC
660	PACK		4-1-05	DPH

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

5-3-05

TESTER

TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.22	2.12		2.34	
PULL #2	2.06	2.30		2.13	
PULL #3	2.52	2.38		2.60	
PULL #4	2.83	2.17		2.41	
PULL #5	2.50	2.58		2.35	
TOTAL	12.13	11.55		11.83	
AVERAGE	2.42	2.31		2.36	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.19		
PULL #2	3.60	3.24		
PULL #3	3.60	3.31		
PULL #4	3.48	3.20		
PULL #5	3.04	3.35		
TOTAL	16.98	16.29		
AVERAGE	3.39	3.25		

	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	4.54	4.28		4.43
PULL #2	4.50	4.16		4.20
PULL #3	4.55	4.19		4.41
PULL #4	4.51	4.21		4.38
PULL #5	4.43	4.37		4.48
TOTAL	22.53	21.21		21.90
AVERAGE	4.50	4.24		4.38

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461692.__0
FILE DATE AND TIME: 05/12/2005 07:58

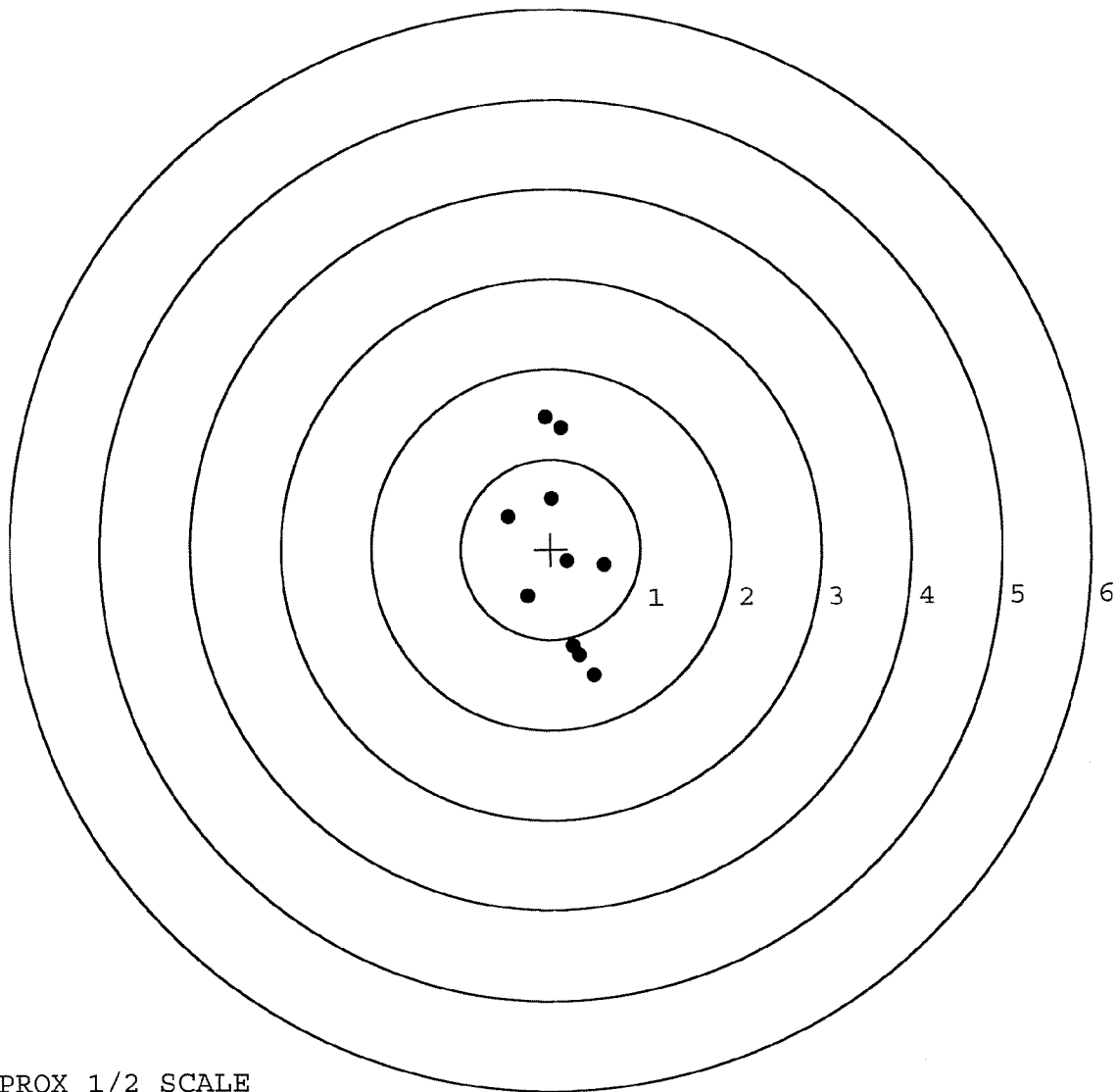
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.069
The Average Y Centroid of the Five Target Set:	-0.054
The Average Point of Impact of the Five Target Set:	0.087
The Average Mean Radius of the Five Target Set:	0.796
The Distance from POA to Centroid Target #1:	0.139
The Distance from Centroid Target #2 to Centroid Target #1:	0.140
The Distance from Centroid Target #3 to Centroid Target #1:	0.196
The Distance from Centroid Target #4 to Centroid Target #1:	0.056
The Distance from Centroid Target #5 to Centroid Target #1:	0.125

SERIAL NUMBER: G6461692. __0
TARGET NUMBER: 1
FILE DATE: 05/12/2005
FILE TIME: 07:58

X CENTROID: 0.116
Y CENTROID: -0.076
POA TO CENTROID: 0.139
HORZ SPREAD: 1.068
VERT SPREAD: 2.872
GROUP SPREAD: 2.919
MIN RADIUS: 0.094
MAX RADIUS: 1.557
MEAN RADIUS: 0.904
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.471	-1.400
2:	0.236	-1.077
3:	0.596	-0.181
4:	0.186	-0.138
5:	-0.261	-0.526
6:	-0.472	0.362
7:	0.015	0.564
8:	0.129	1.348
9:	-0.049	1.472
10:	0.307	-1.184



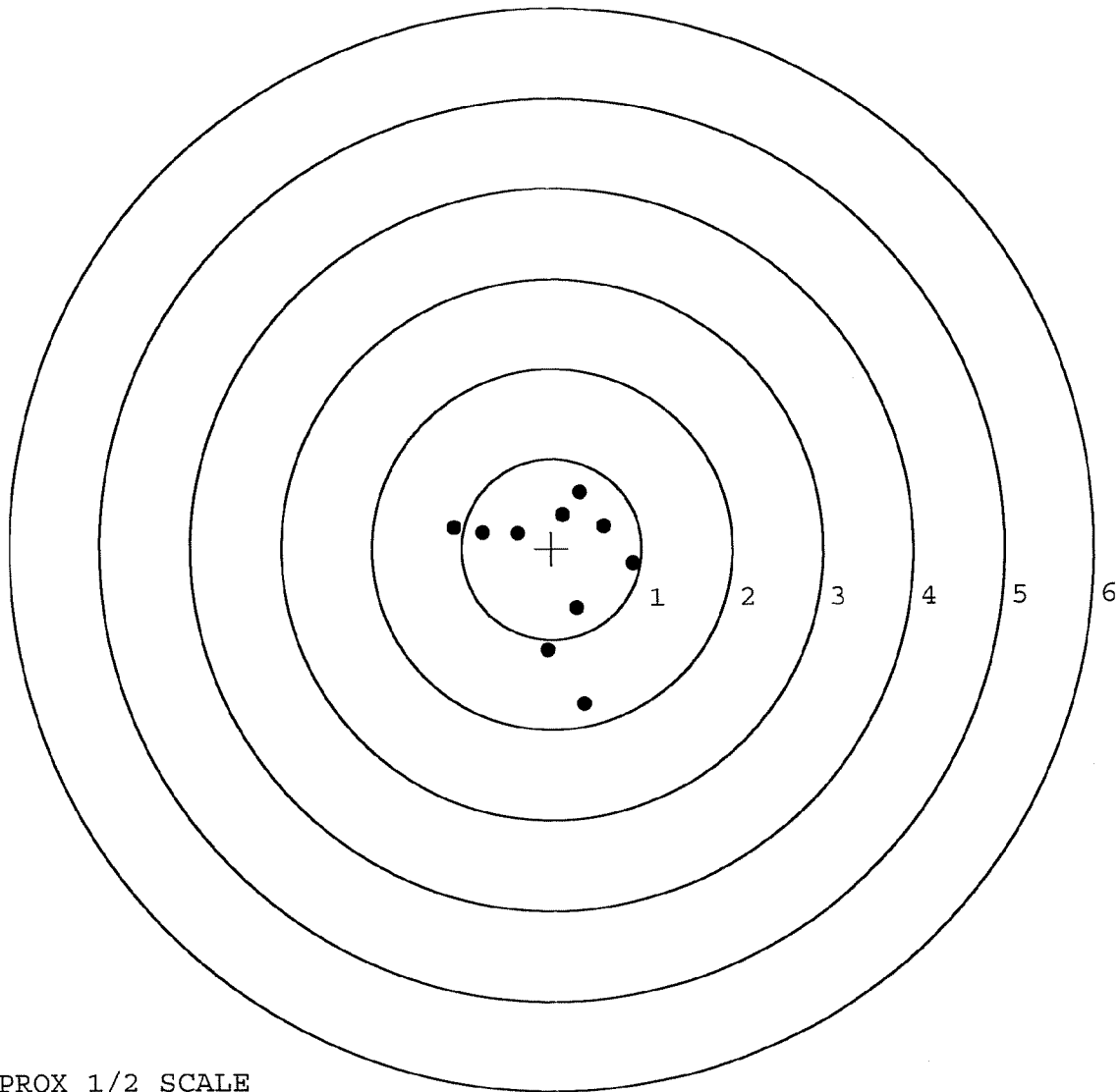
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461692. __0
TARGET NUMBER: 2
FILE DATE: 05/12/2005
FILE TIME: 07:58

X CENTROID: 0.028
Y CENTROID: -0.185
POA TO CENTROID: 0.187
HORZ SPREAD: 1.984
VERT SPREAD: 2.344
GROUP SPREAD: 2.436
MIN RADIUS: 0.533
MAX RADIUS: 1.572
MEAN RADIUS: 0.865

POINT#	X	Y
1:	0.353	-1.723
2:	-0.058	-1.125
3:	0.278	-0.656
4:	0.900	-0.174
5:	0.585	0.242
6:	0.325	0.621
7:	0.127	0.367
8:	-0.379	0.170
9:	-0.766	0.186
10:	-1.084	0.244

IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

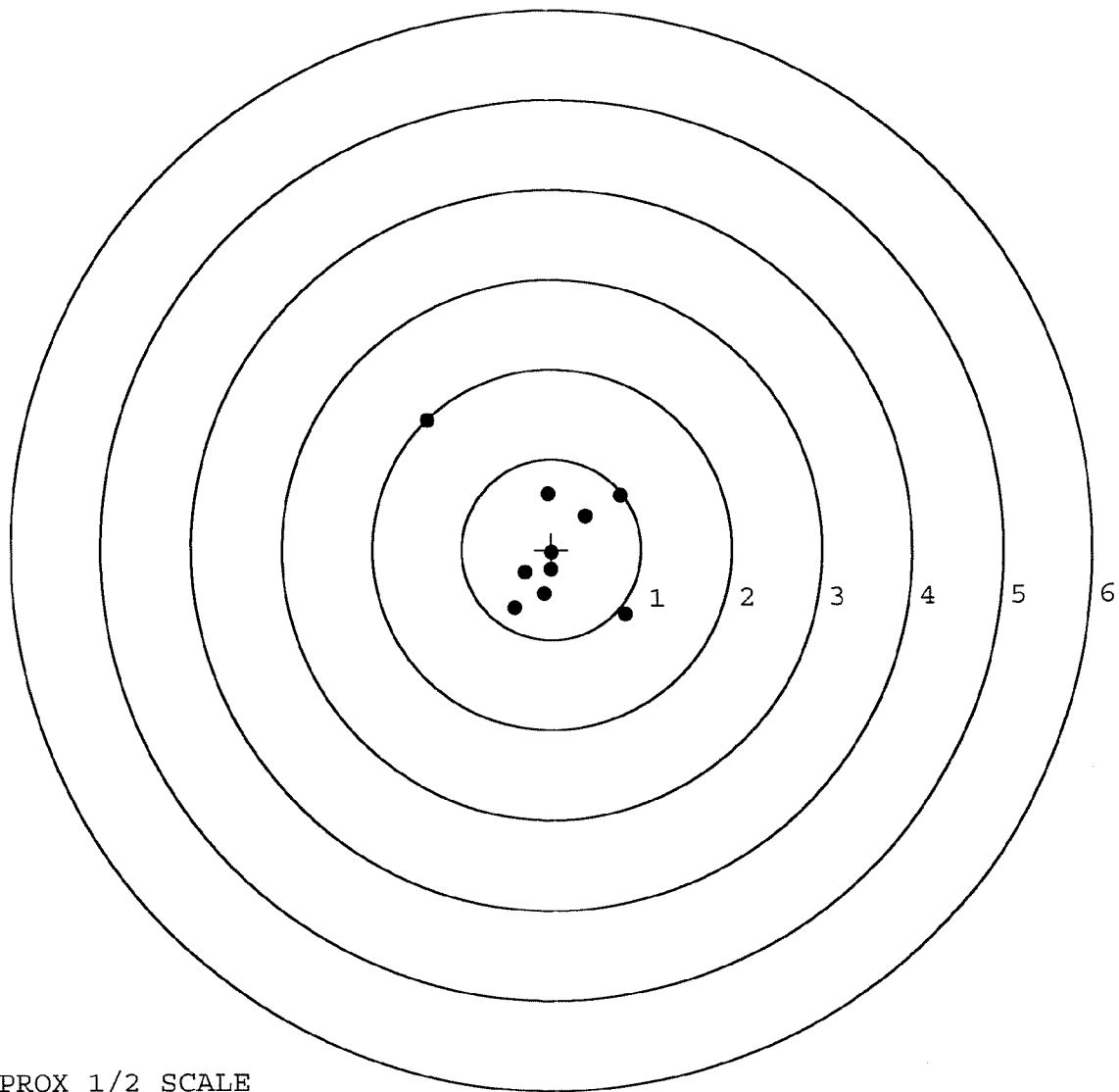


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461692.___0
TARGET NUMBER: 3
FILE DATE: 05/12/2005
FILE TIME: 07:58

X CENTROID: -0.025
Y CENTROID: 0.061
POA TO CENTROID: 0.066
HORZ SPREAD: 2.190
VERT SPREAD: 2.178
GROUP SPREAD: 3.089
MIN RADIUS: 0.103
MAX RADIUS: 1.930
MEAN RADIUS: 0.730
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.818	-0.735
2:	0.778	0.587
3:	0.386	0.367
4:	-0.038	0.618
5:	-1.372	1.443
6:	-0.415	-0.652
7:	-0.093	-0.494
8:	-0.012	-0.224
9:	-0.002	-0.039
10:	-0.297	-0.260

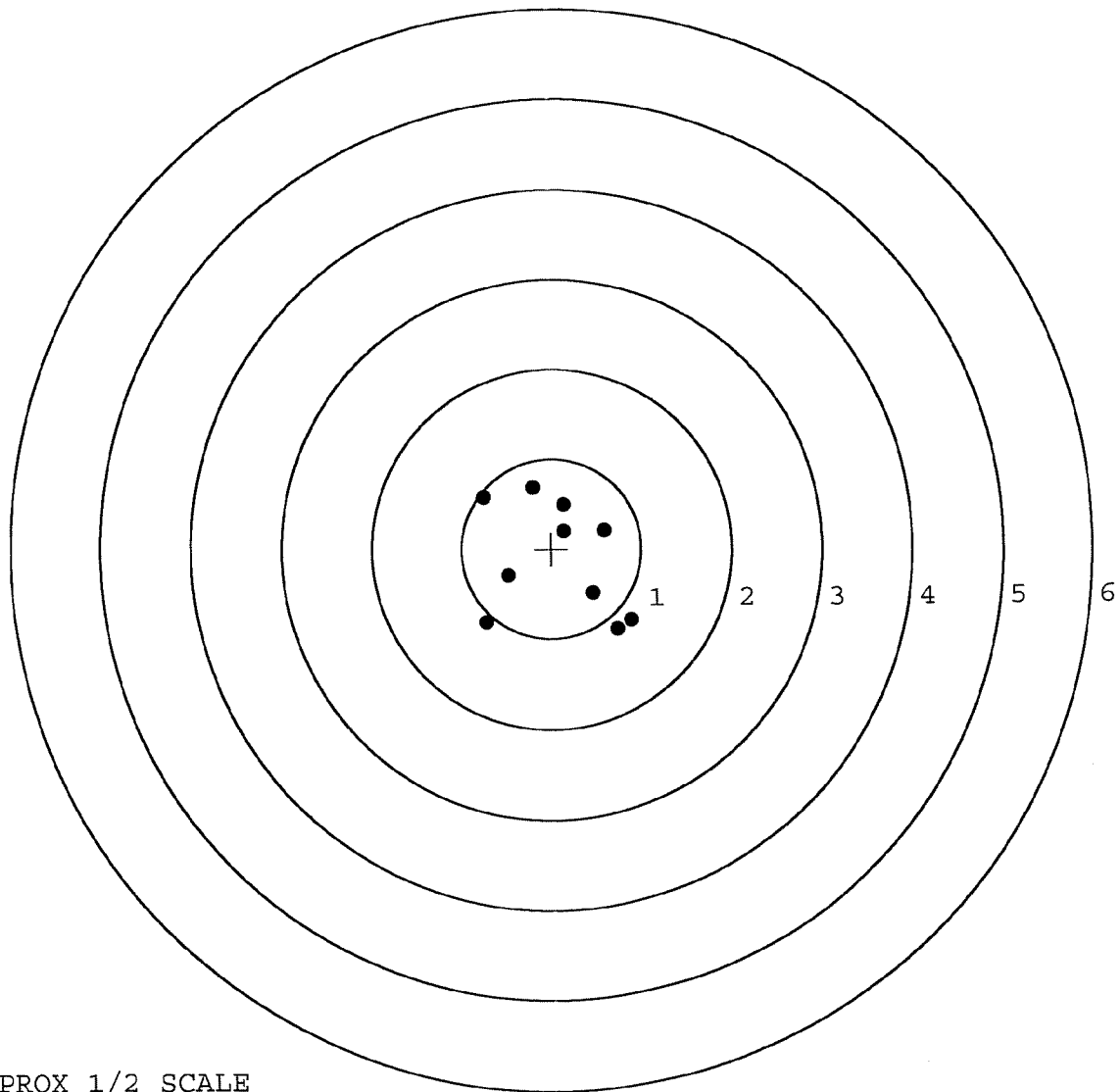


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461692.___0
TARGET NUMBER: 4
FILE DATE: 05/12/2005
FILE TIME: 07:58

X CENTROID: 0.077
Y CENTROID: -0.116
POA TO CENTROID: 0.140
HORZ SPREAD: 1.633
VERT SPREAD: 1.584
GROUP SPREAD: 2.142
MIN RADIUS: 0.321
MAX RADIUS: 1.085
MEAN RADIUS: 0.774
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.881	-0.803
2:	0.730	-0.903
3:	0.464	-0.499
4:	0.587	0.203
5:	0.141	0.198
6:	0.141	0.487
7:	-0.206	0.681
8:	-0.752	0.583
9:	-0.484	-0.297
10:	-0.731	-0.814

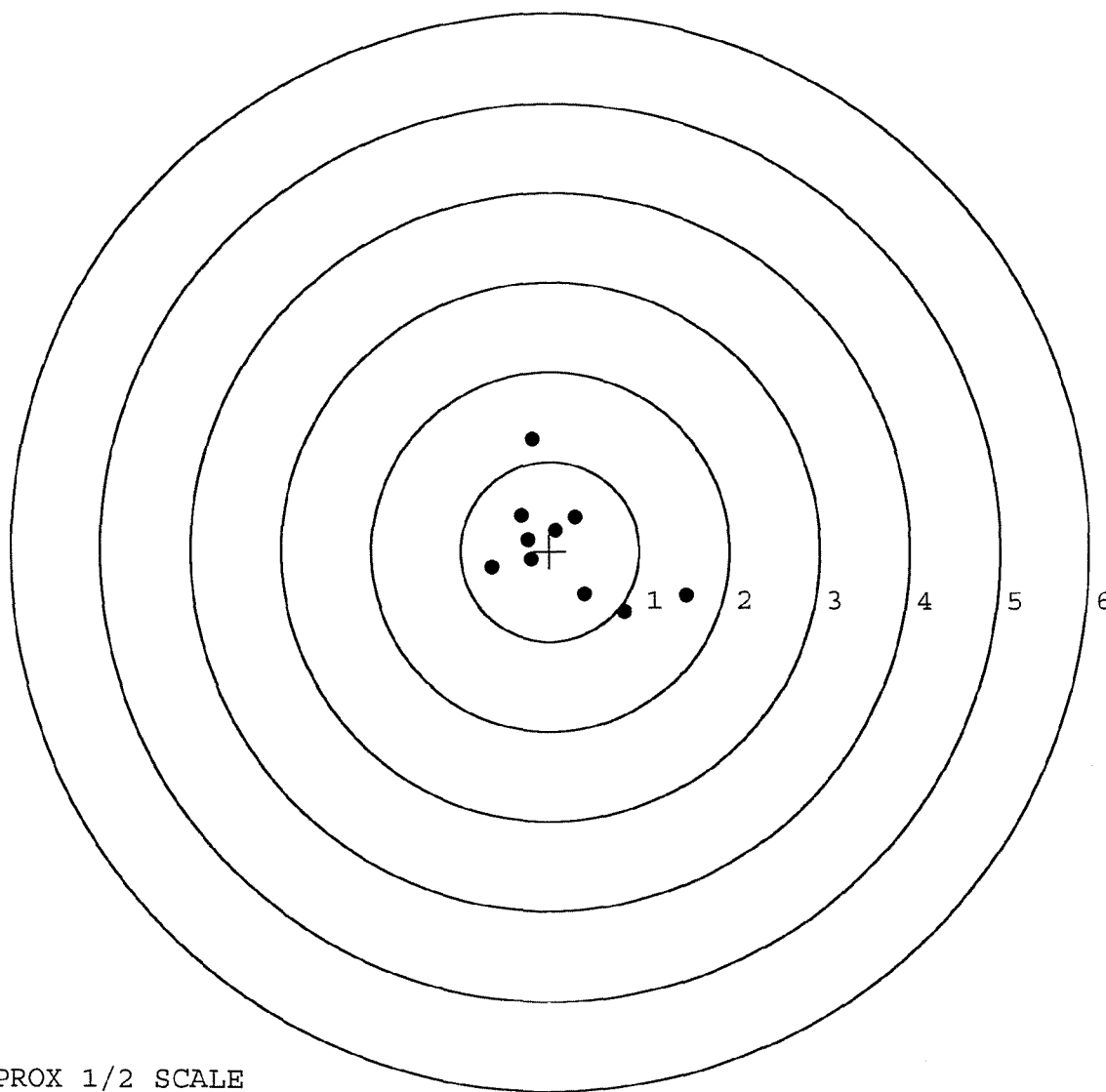


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461692. 0
TARGET NUMBER: 5
FILE DATE: 05/12/2005
FILE TIME: 07:58

POINT#	X	Y
1:	1.517	-0.488
2:	0.839	-0.682
3:	0.392	-0.483
4:	0.282	0.378
5:	-0.204	1.252
6:	0.067	0.231
7:	-0.325	0.391
8:	-0.209	-0.095
9:	-0.652	-0.186
10:	-0.242	0.132

X CENTROID: 0.147
Y CENTROID: 0.045
POA TO CENTROID: 0.153
HORZ SPREAD: 2.169
VERT SPREAD: 1.934
GROUP SPREAD: 2.447
MIN RADIUS: 0.202
MAX RADIUS: 1.470
MEAN RADIUS: 0.707
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE