

G 646 1707

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

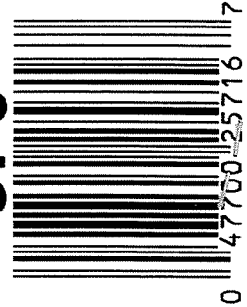
24"

CAPACITY

6

G6461707

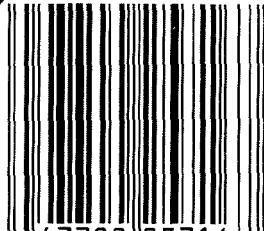
UPC



ORDER 25716

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

UPC

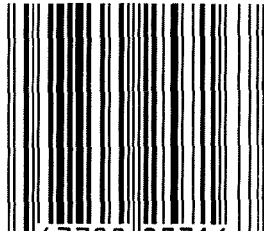


0 47700 25716 7

ORDER 25716

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

UPC



0 47700 25716 7

SERIAL NO.



G6461707

6/17/2005 2:12:04 PM

Original

36

Crib

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004012773

0540

01PC001

Flat Black Powder Coat, Barrel and



0004012763

0560

89SWS1

Reassemble Action.



0004012764

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461707

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-6-05	RTL
440	PROOF		9-6-05	TRW
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-6-05	RTL
470	DIS-ASSEMBLE ACTION	SEP 17 2005	9-6-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/80 OPERATOR <i>unsub</i>	9/8/05	<i>unsub</i>
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9/12	<i>unsub</i>
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/21/05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/21/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/21/05	DA
	D) OIL FIRING PIN ASSEMBLY		9-21-05	DA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	10-11-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-11-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		9-28-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-28-05	RTL
	M) IRON SIGHT ALIGNMENT		9-28-05	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-28-05	RTL
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	9-28-05	TRW
	MALFUNCTION <i>Last rd Feels hard</i>	CORRECTION	9-29-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		9-29-05	SH
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.82</u> <u>2.81</u> <u>2.89</u> <u>2.82</u> <u>2.56</u>	10-7-05	Bi
	C) FUNCTION		10-11-05	A
690	PACK		10-6-05	DA

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

9/27/05

TESTER

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.80	2.69		2.31	
PULL #2	2.45	2.30		2.75	
PULL #3	2.72	2.43		2.30	
PULL #4	2.78	2.61		2.80	
PULL #5	2.95	2.13		2.40	
TOTAL	13.70	12.16		12.56	
AVERAGE	2.74	2.43		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	2.79		
PULL #2	3.46	2.90		
PULL #3	2.72	2.84		
PULL #4	3.34	3.29		
PULL #5	3.44	3.22		
TOTAL	16.37	15.04		
AVERAGE	3.27	3.01		

	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	4.19	3.86		4.09
PULL #2	3.96	4.10		4.02
PULL #3	3.82	3.95		4.22
PULL #4	3.84	3.84		3.60
PULL #5	3.82	4.02		4.09
TOTAL	19.63	19.77		20.02
AVERAGE	3.93	3.95		4.00

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461707.__1
FILE DATE AND TIME: 10/06/2005 18:22

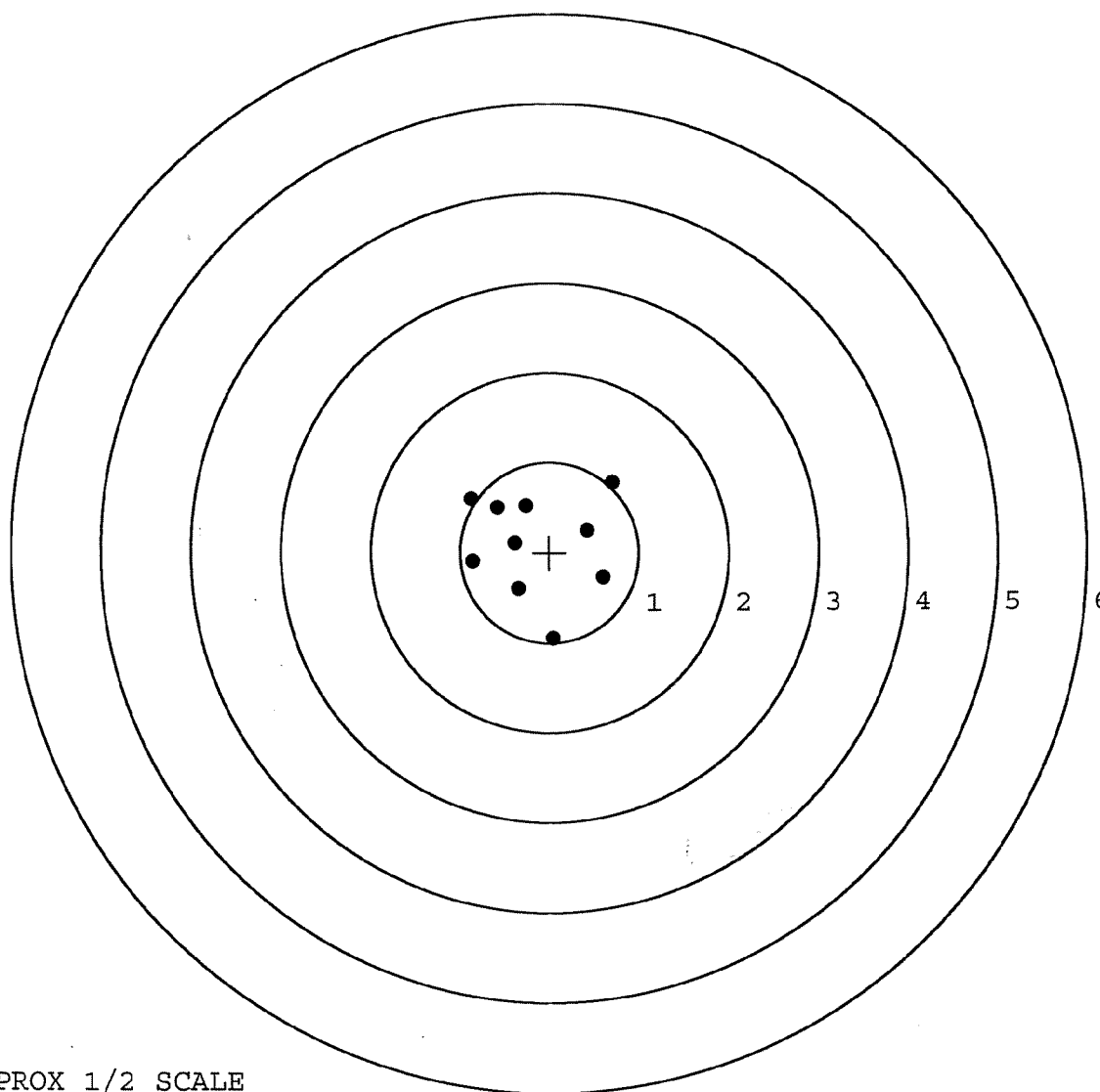
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.155
The Average Y Centroid of the Five Target Set:	0.038
The Average Point of Impact of the Five Target Set:	0.160
The Average Mean Radius of the Five Target Set:	0.804
The Distance from POA to Centroid Target #1:	0.183
The Distance from Centroid Target #2 to Centroid Target #1:	0.037
The Distance from Centroid Target #3 to Centroid Target #1:	0.107
The Distance from Centroid Target #4 to Centroid Target #1:	0.176
The Distance from Centroid Target #5 to Centroid Target #1:	0.199

SERIAL NUMBER: G6461707. __1
TARGET NUMBER: 1
FILE DATE: 10/06/2005
FILE TIME: 18:22

POINT#	X	Y
1:	-0.351	-0.405
2:	-0.862	-0.101
3:	-0.388	0.102
4:	0.044	-0.958
5:	0.600	-0.279
6:	0.420	0.246
7:	0.711	0.775
8:	-0.263	0.519
9:	-0.581	0.497
10:	-0.875	0.593

X CENTROID: -0.154
Y CENTROID: 0.099
POA TO CENTROID: 0.183
HORZ SPREAD: 1.586
VERT SPREAD: 1.733
GROUP SPREAD: 1.857
MIN RADIUS: 0.234
MAX RADIUS: 1.098
MEAN RADIUS: 0.701
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

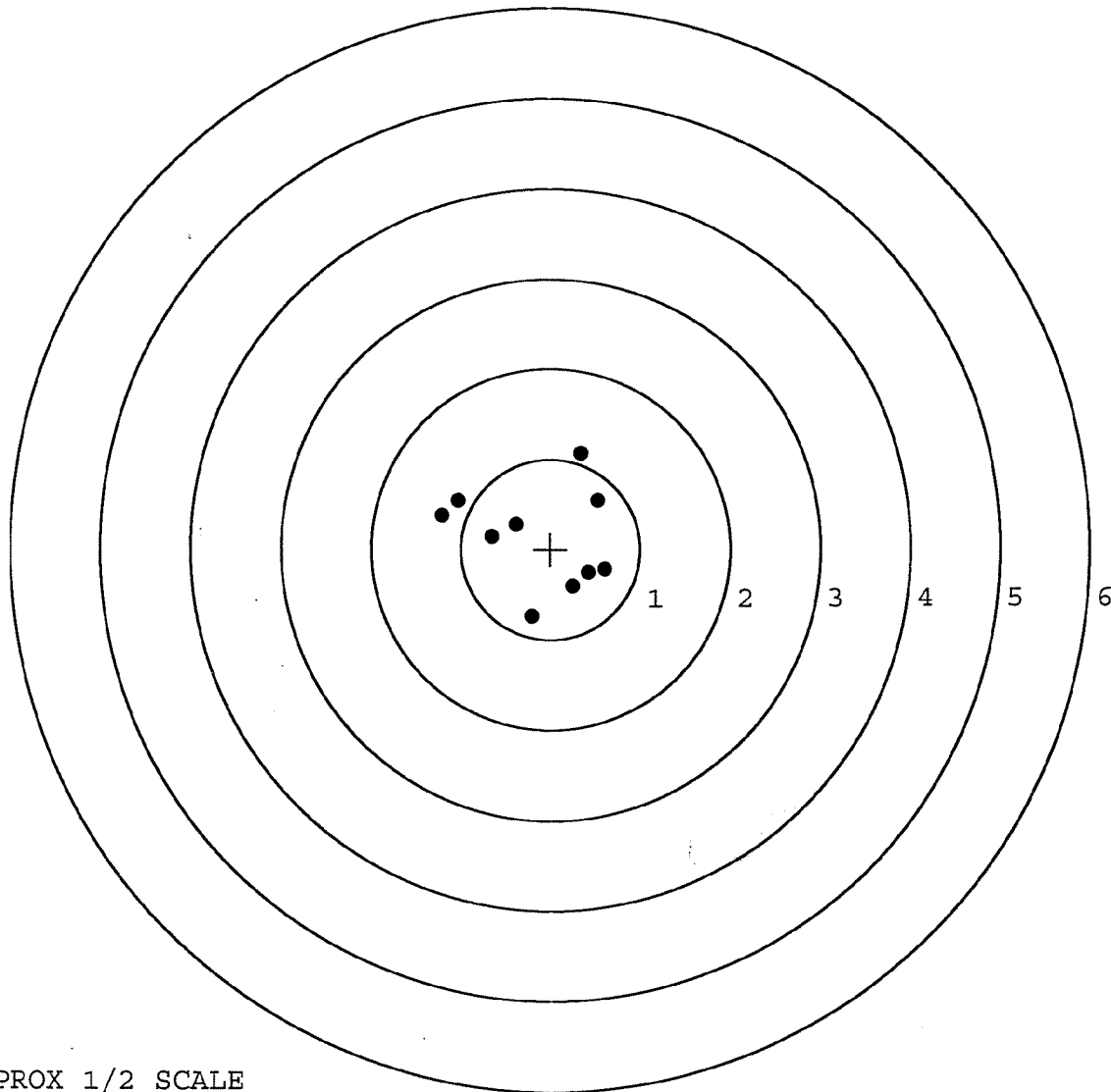


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461707. __1
TARGET NUMBER: 2
FILE DATE: 10/06/2005
FILE TIME: 18:22

POINT#	X	Y
1:	-1.031	0.541
2:	-1.209	0.377
3:	-0.385	0.279
4:	-0.660	0.144
5:	-0.212	-0.747
6:	0.251	-0.414
7:	0.425	-0.266
8:	0.612	-0.227
9:	0.531	0.541
10:	0.342	1.065

X CENTROID: -0.134
Y CENTROID: 0.129
POA TO CENTROID: 0.186
HORZ SPREAD: 1.821
VERT SPREAD: 1.812
GROUP SPREAD: 1.919
MIN RADIUS: 0.293
MAX RADIUS: 1.104
MEAN RADIUS: 0.780
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



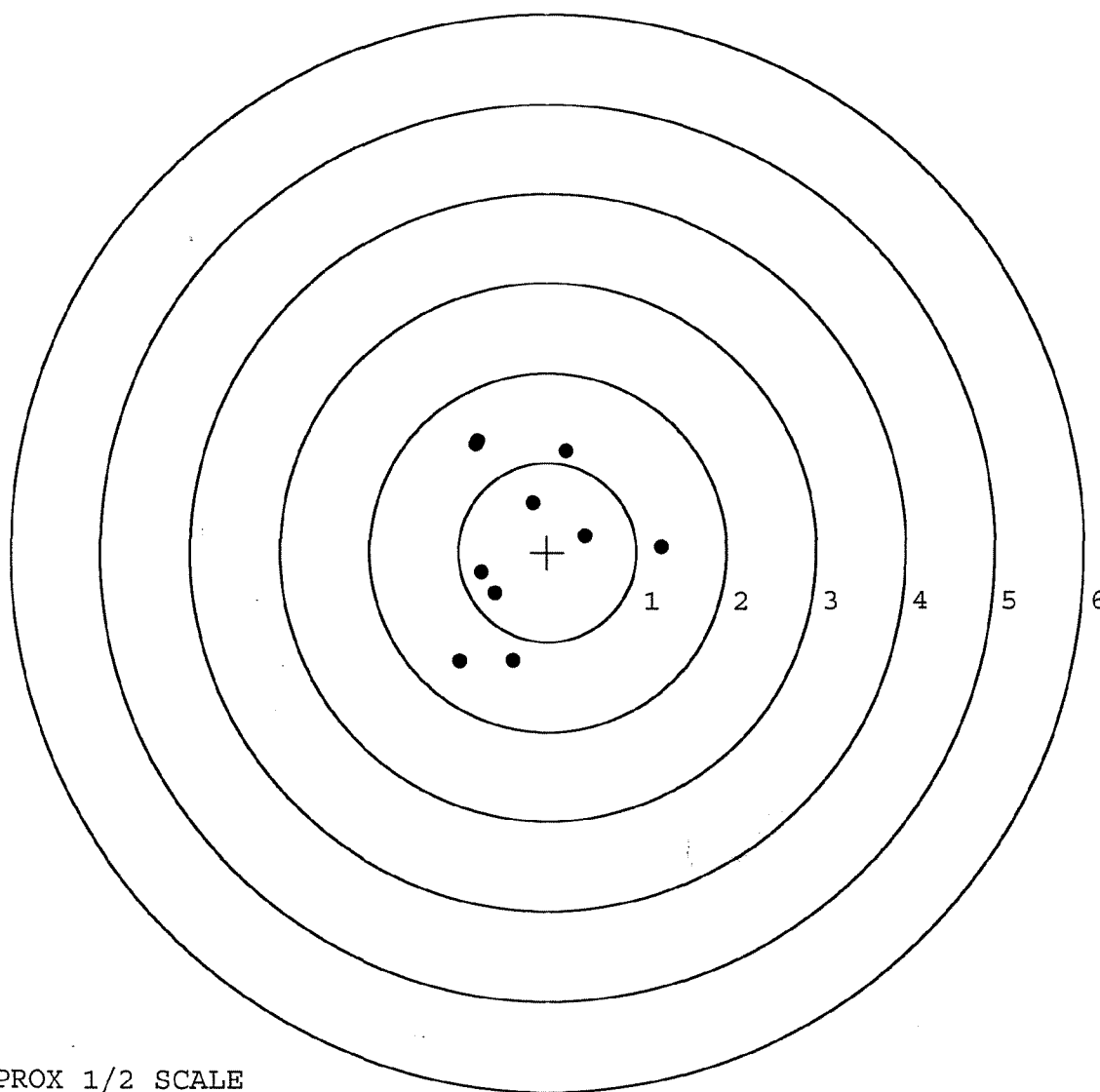
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461707. __1
TARGET NUMBER: 3
FILE DATE: 10/06/2005
FILE TIME: 18:22

X CENTROID: -0.258
Y CENTROID: 0.125
POA TO CENTROID: 0.287
HORZ SPREAD: 2.264
VERT SPREAD: 2.455
GROUP SPREAD: 2.596
MIN RADIUS: 0.433
MAX RADIUS: 1.534
MEAN RADIUS: 1.035

POINT#	X	Y
1:	-0.587	-0.460
2:	-0.746	-0.232
3:	-0.168	0.549
4:	-0.787	1.241
5:	0.416	0.183
6:	1.274	0.057
7:	-0.990	-1.214
8:	-0.393	-1.208
9:	-0.813	1.206
10:	0.213	1.132

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

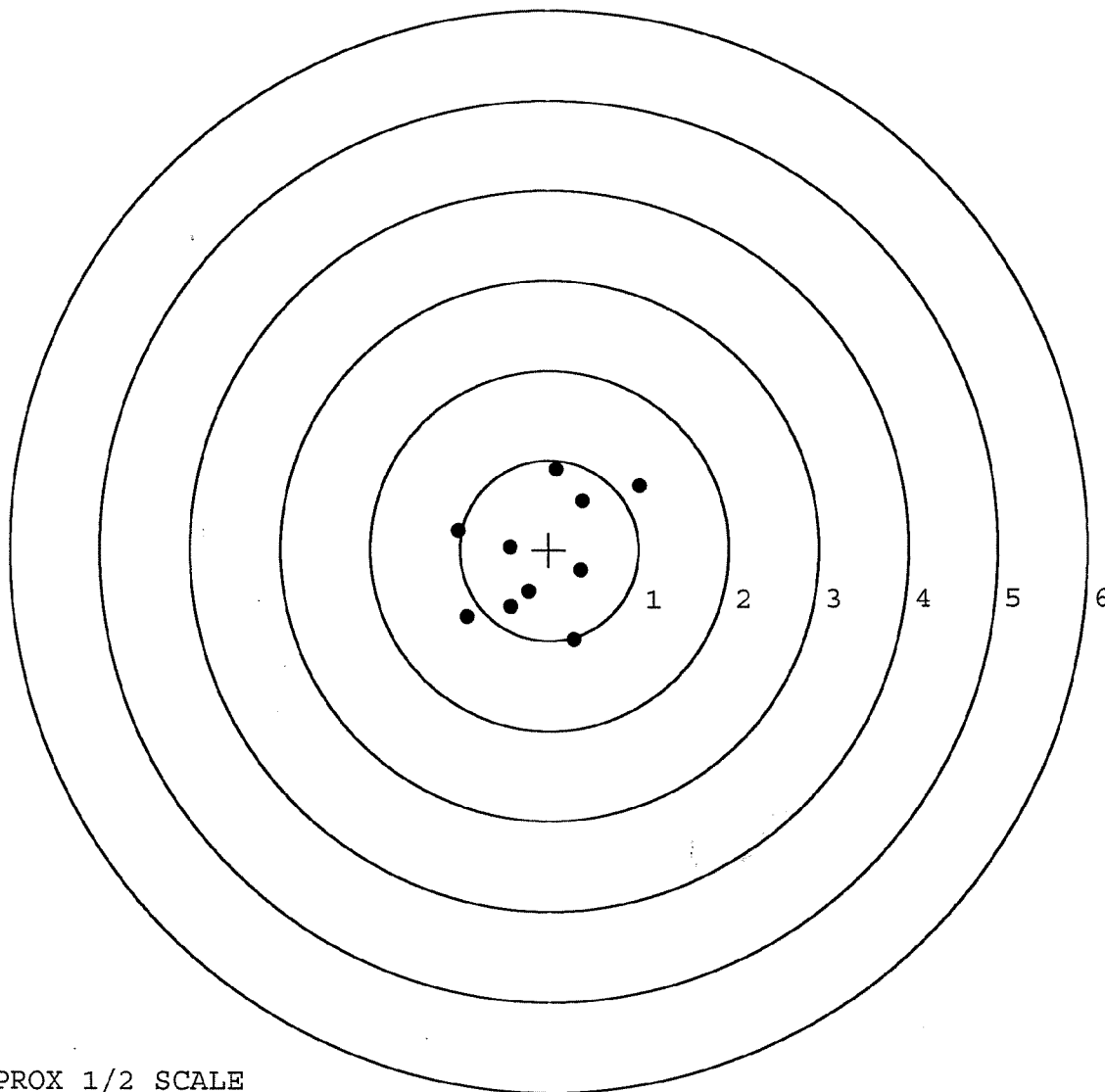


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461707. __1
TARGET NUMBER: 4
FILE DATE: 10/06/2005
FILE TIME: 18:22

X CENTROID: -0.093
Y CENTROID: -0.066
POA TO CENTROID: 0.114
HORZ SPREAD: 2.029
VERT SPREAD: 1.892
GROUP SPREAD: 2.420
MIN RADIUS: 0.354
MAX RADIUS: 1.351
MEAN RADIUS: 0.804
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.278	-0.995
2:	-0.429	-0.629
3:	-0.228	-0.462
4:	0.356	-0.228
5:	-0.434	0.031
6:	-1.018	0.213
7:	-0.923	-0.741
8:	1.011	0.713
9:	0.081	0.897
10:	0.375	0.542



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461707. __1

TARGET NUMBER: 5

FILE DATE: 10/06/2005

FILE TIME: 18:22

POINT#	X	Y
1:	0.785	-0.165
2:	0.819	0.014
3:	0.226	0.229
4:	-0.164	0.201
5:	-0.594	0.207
6:	-0.223	-0.161
7:	-1.155	-0.206
8:	-0.252	-0.930
9:	-0.863	-0.830
10:	0.039	0.645

X CENTROID: -0.138

Y CENTROID: -0.100

POA TO CENTROID: 0.170

HORZ SPREAD: 1.974

VERT SPREAD: 1.575

GROUP SPREAD: 1.882

MIN RADIUS: 0.105

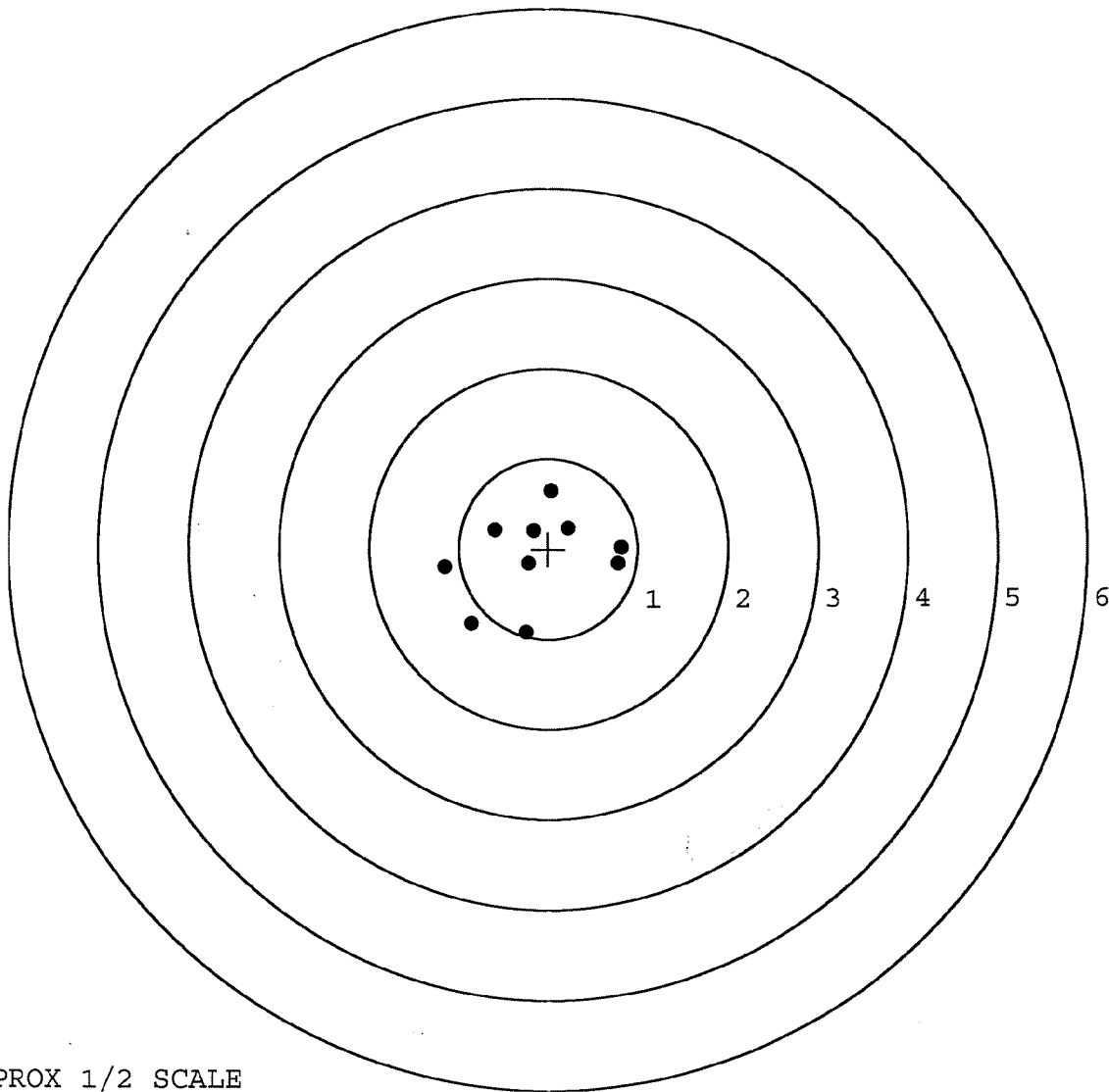
MAX RADIUS: 1.029

MEAN RADIUS: 0.699

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE