

G6441734

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



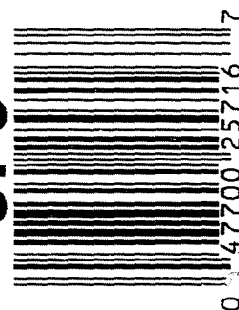
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461736

UPC



ORDER 25716

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

UPC



0 47700 25716 7

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

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SERIAL NO.



66461736

4/7/2005 2:48:09 PM

CRIB

7

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 # G6461736

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	AC
610	DIS-ASSEMBLE GUN		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)		8-6-05	CW
	(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>	5-19-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-19-05	A
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	5-19-05	A
	J) ASSEMBLE STOCK		5-16-05	RTL
	K) ASSEMBLE SWIVEL STUDS		5-19-05	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-16-05	RTL
	M) IRON SIGHT ALIGNMENT		5-16-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-16-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	5-17-05	TRL
	MALFUNCTION	CORRECTION	NA	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-17-05	AC
655	FINAL INSPECTION A) HEADSPACE		5-19-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.93</u> <u>2.94</u> <u>2.89</u> <u>2.84</u> <u>2.83</u>	5-19-05	AC
	C) FUNCTION		5-19-05	AC
660	PACK		5-20-05	RA

AVERAGE PULL FORCE BETWEEN

SERIAL NO. 7

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE 5-2-05

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.63	2.41		2.72	
PULL #2	2.65	2.73		2.65	
PULL #3	2.71	2.73		2.64	
PULL #4	2.69	2.72		2.56	
PULL #5	2.66	2.60		2.65	
TOTAL	13.34	13.19		13.22	
AVERAGE	2.66	2.63		2.64	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.39		
PULL #2	3.37	3.51		
PULL #3	3.43	3.57		
PULL #4	3.49	3.43		
PULL #5	3.42	3.21		
TOTAL	17.01	17.11		
AVERAGE	3.40	3.42		

	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	4.09	4.15		4.14
PULL #2	4.09	4.19		4.31
PULL #3	4.01	4.15		4.26
PULL #4	4.31	4.10		4.24
PULL #5	4.23	4.09		4.36
TOTAL	20.73	20.68		21.31
AVERAGE	4.14	4.13		4.26

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461736.___0

FILE DATE AND TIME: 05/17/2005 07:03

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.040
The Average Y Centroid of the Five Target Set:	-0.024
The Average Point of Impact of the Five Target Set:	0.047
The Average Mean Radius of the Five Target Set:	0.606
The Distance from POA to Centroid Target #1:	0.094
The Distance from Centroid Target #2 to Centroid Target #1:	0.094
The Distance from Centroid Target #3 to Centroid Target #1:	0.106
The Distance from Centroid Target #4 to Centroid Target #1:	0.417
The Distance from Centroid Target #5 to Centroid Target #1:	0.240

SERIAL NUMBER: G6461736. 0

TARGET NUMBER: 1

FILE DATE: 05/17/2005

FILE TIME: 07:03

POINT#	X	Y
1:	-0.780	0.160
2:	0.377	0.455
3:	0.037	0.524
4:	-0.160	0.425
5:	-0.486	0.272
6:	-0.259	0.082
7:	-0.013	0.275
8:	0.827	-0.387
9:	0.119	-0.697
10:	-0.137	-0.301

X CENTROID: -0.048

Y CENTROID: 0.081

POA TO CENTROID: 0.094

HORZ SPREAD: 1.607

VERT SPREAD: 1.221

GROUP SPREAD: 1.698

MIN RADIUS: 0.197

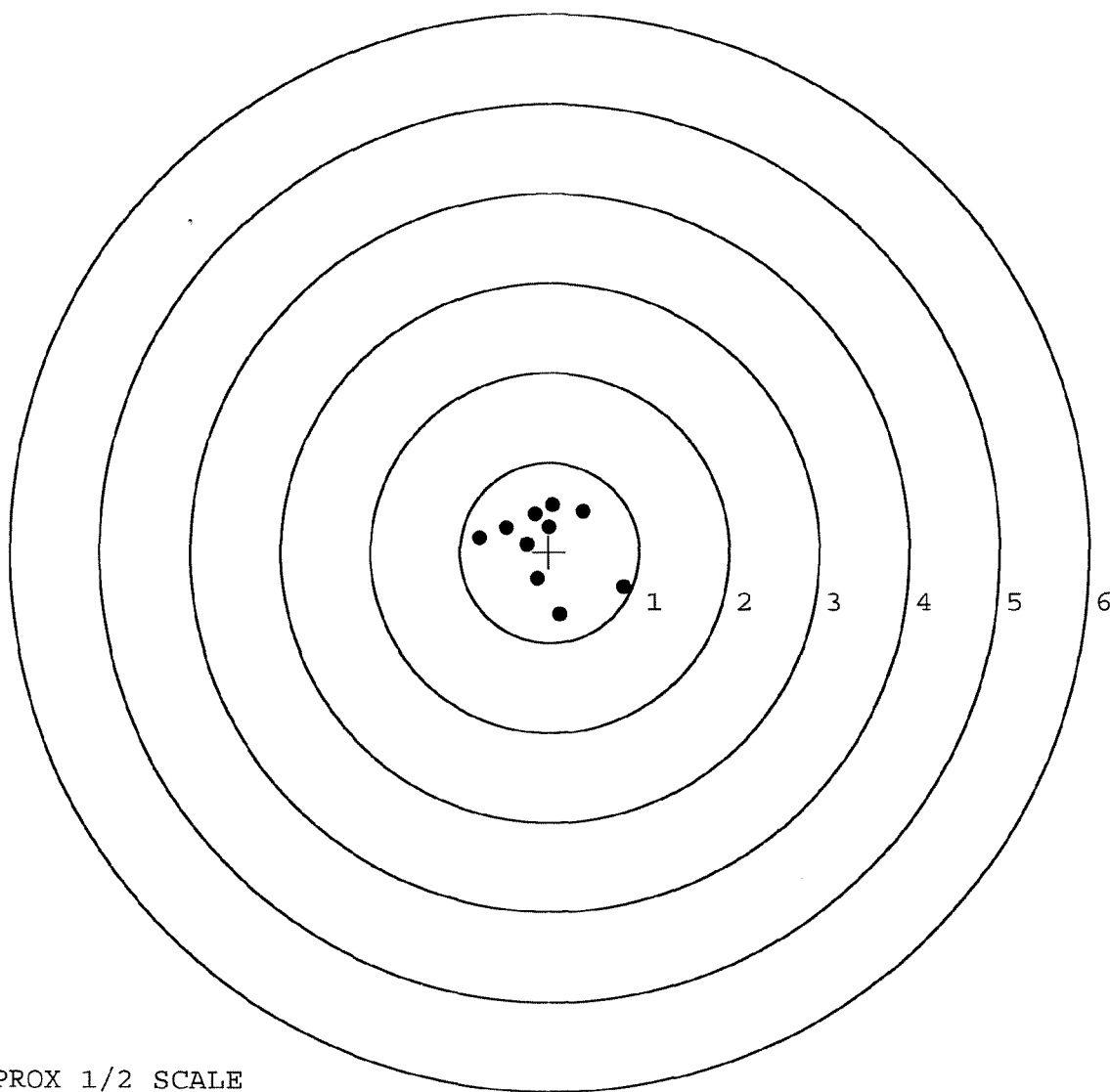
MAX RADIUS: 0.992

MEAN RADIUS: 0.518

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461736.___0

TARGET NUMBER: 2

FILE DATE: 05/17/2005

FILE TIME: 07:03

POINT#	X	Y
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1:	-0.425	0.480
----	--------	-------

2:	-0.600	-0.035
----	--------	--------

3:	-0.556	-0.456
----	--------	--------

4:	-0.111	-0.566
----	--------	--------

5:	0.578	0.265
----	-------	-------

6:	0.440	0.069
----	-------	-------

7:	0.162	0.094
----	-------	-------

8:	0.088	-0.061
----	-------	--------

9:	-0.068	0.046
----	--------	-------

10:	-0.287	0.087
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X CENTROID: -0.078

Y CENTROID: -0.008

POA TO CENTROID: 0.078

HORZ SPREAD: 1.178

VERT SPREAD: 1.046

GROUP SPREAD: 1.344

MIN RADIUS: 0.055

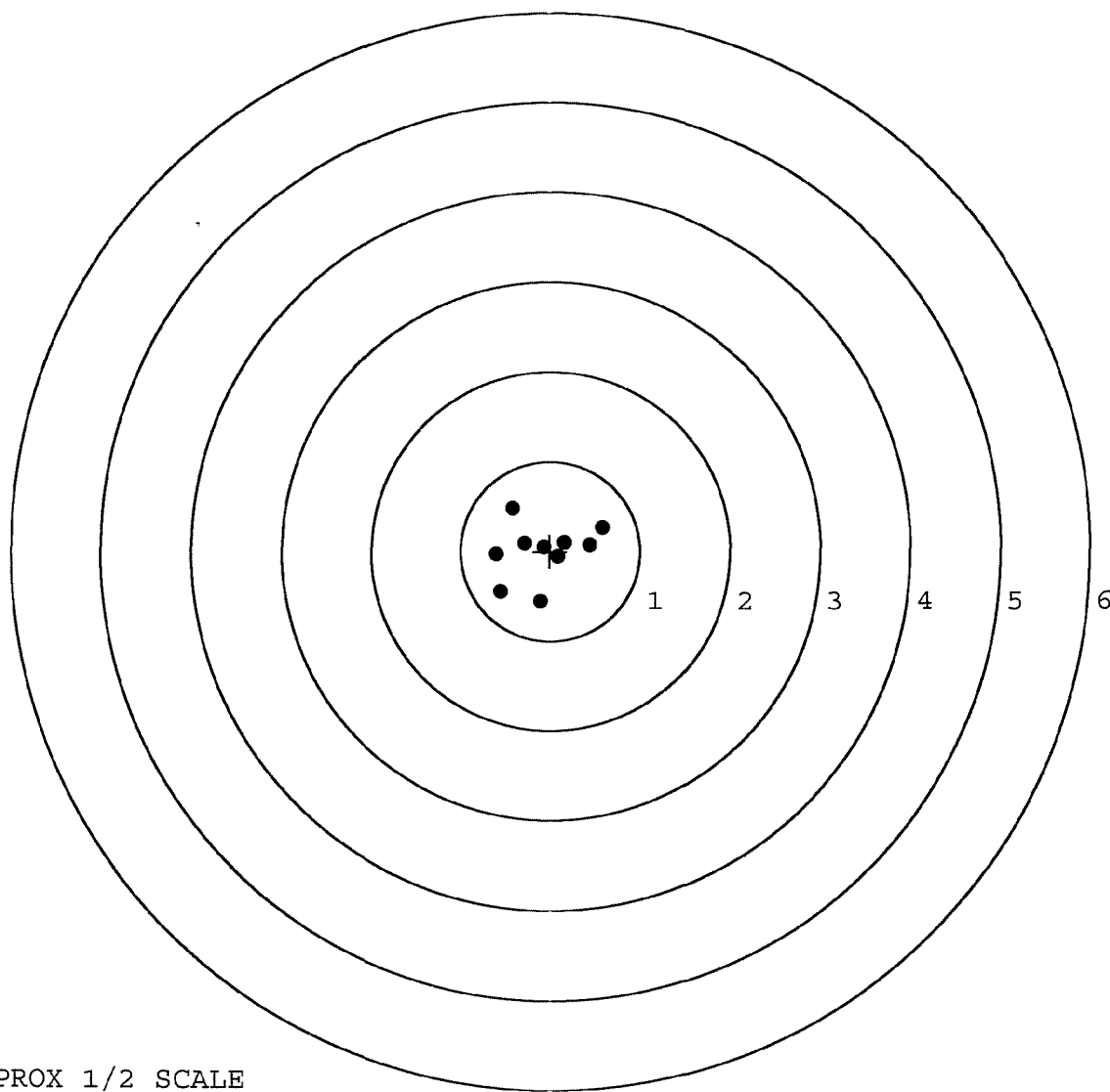
MAX RADIUS: 0.710

MEAN RADIUS: 0.429

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461736.___0

TARGET NUMBER: 3

FILE DATE: 05/17/2005

FILE TIME: 07:03

X CENTROID: 0.052

Y CENTROID: 0.116

POA TO CENTROID: 0.127

HORZ SPREAD: 2.090

VERT SPREAD: 2.345

GROUP SPREAD: 2.575

MIN RADIUS: 0.334

MAX RADIUS: 1.556

MEAN RADIUS: 0.836

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
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1:	0.702	-0.735
----	-------	--------

2:	0.035	-1.046
----	-------	--------

3:	0.344	-0.490
----	-------	--------

4:	-0.069	-0.272
----	--------	--------

5:	-0.481	-0.114
----	--------	--------

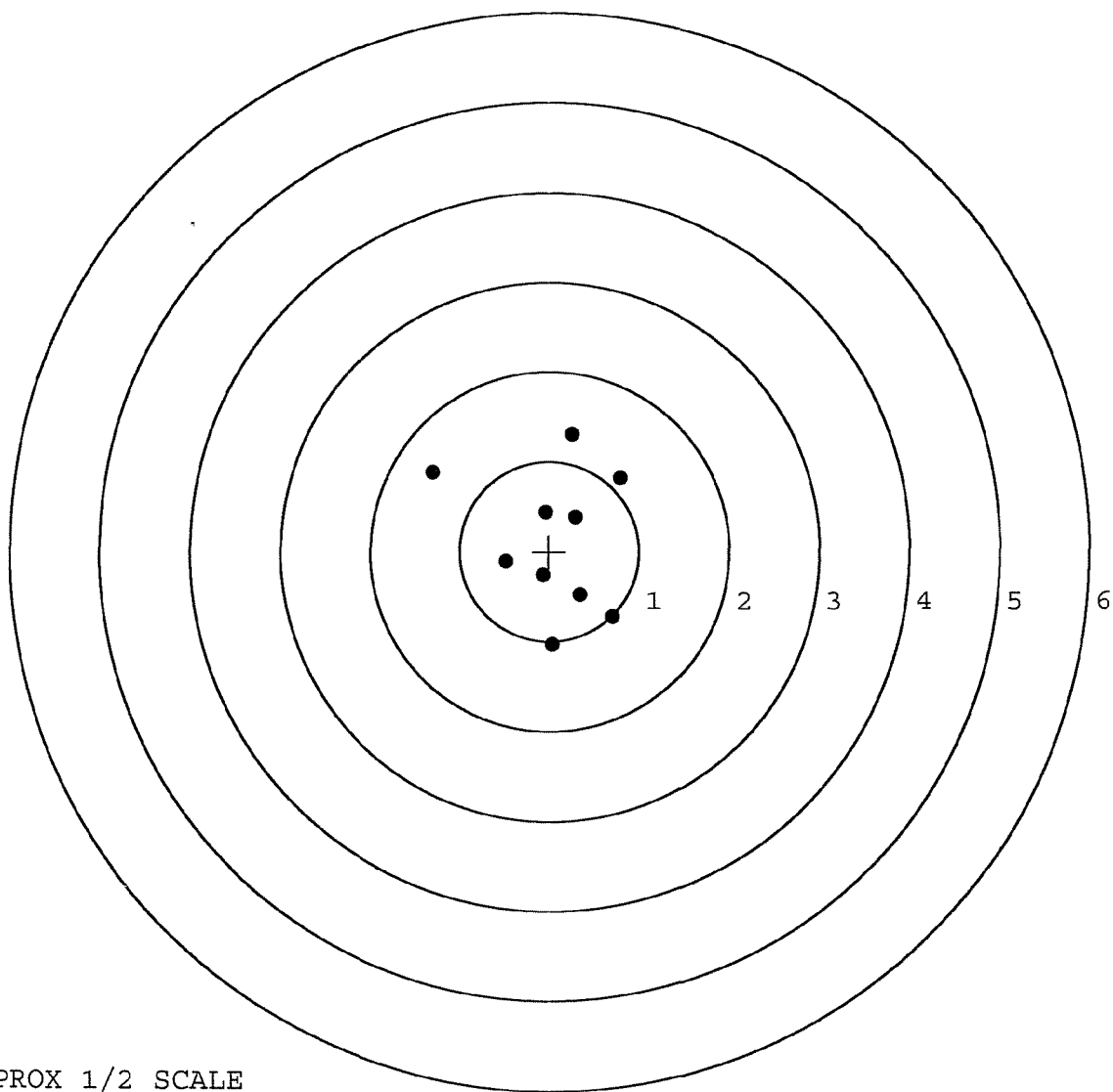
6:	0.288	0.381
----	-------	-------

7:	-0.045	0.436
----	--------	-------

8:	-1.301	0.884
----	--------	-------

9:	0.789	0.818
----	-------	-------

10:	0.259	1.299
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TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461736. __0

TARGET NUMBER: 4

FILE DATE: 05/17/2005

FILE TIME: 07:03

X CENTROID: 0.096

Y CENTROID: -0.310

POA TO CENTROID: 0.325

HORZ SPREAD: 1.159

VERT SPREAD: 1.860

GROUP SPREAD: 1.860

MIN RADIUS: 0.259

MAX RADIUS: 1.071

MEAN RADIUS: 0.615

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
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1:	0.225	-1.122
----	-------	--------

2:	0.116	-1.381
----	-------	--------

3:	-0.407	-0.306
----	--------	--------

4:	-0.467	-0.095
----	--------	--------

5:	-0.319	0.383
----	--------	-------

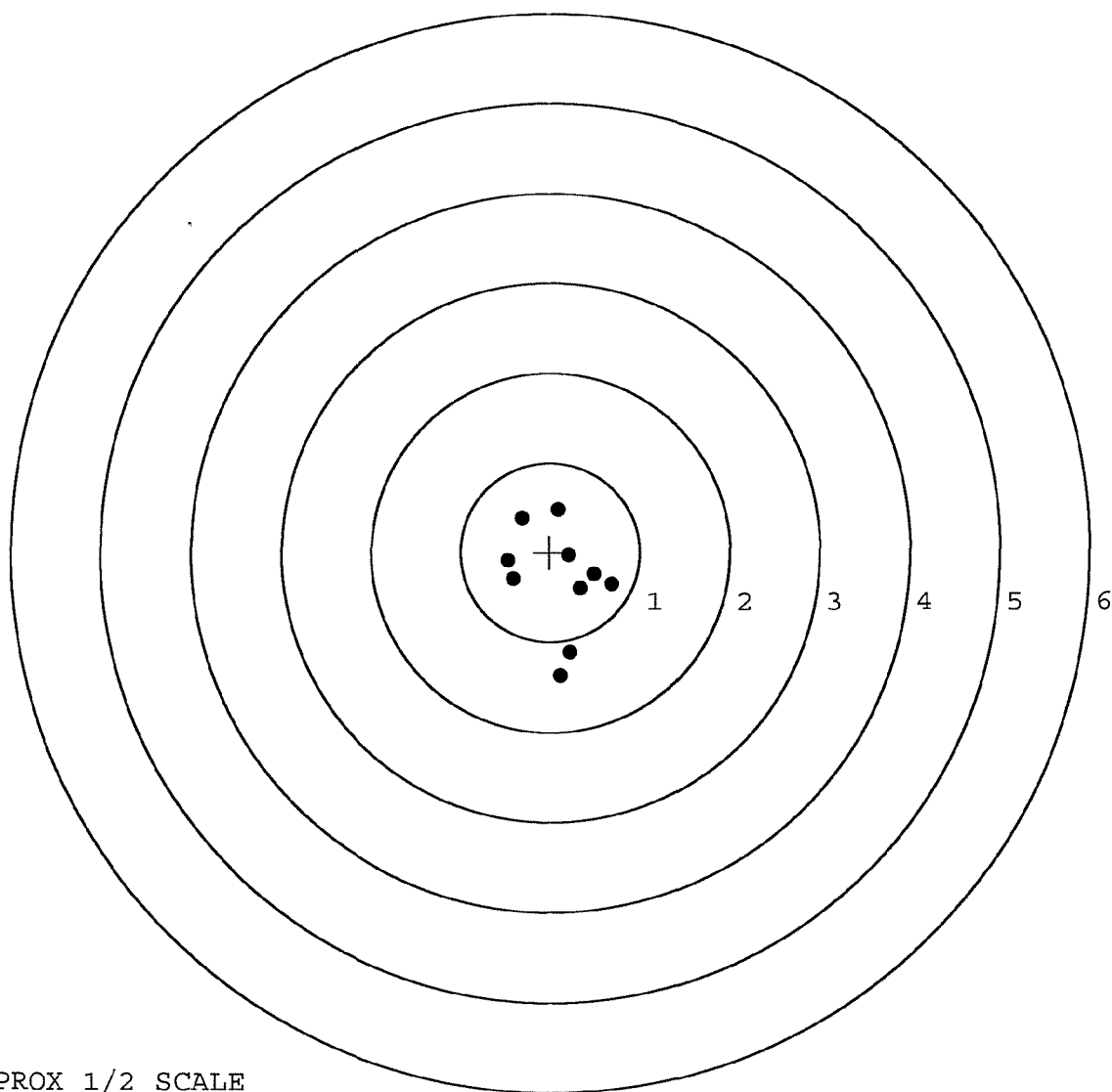
6:	0.088	0.479
----	-------	-------

7:	0.210	-0.039
----	-------	--------

8:	0.692	-0.361
----	-------	--------

9:	0.334	-0.412
----	-------	--------

10:	0.491	-0.250
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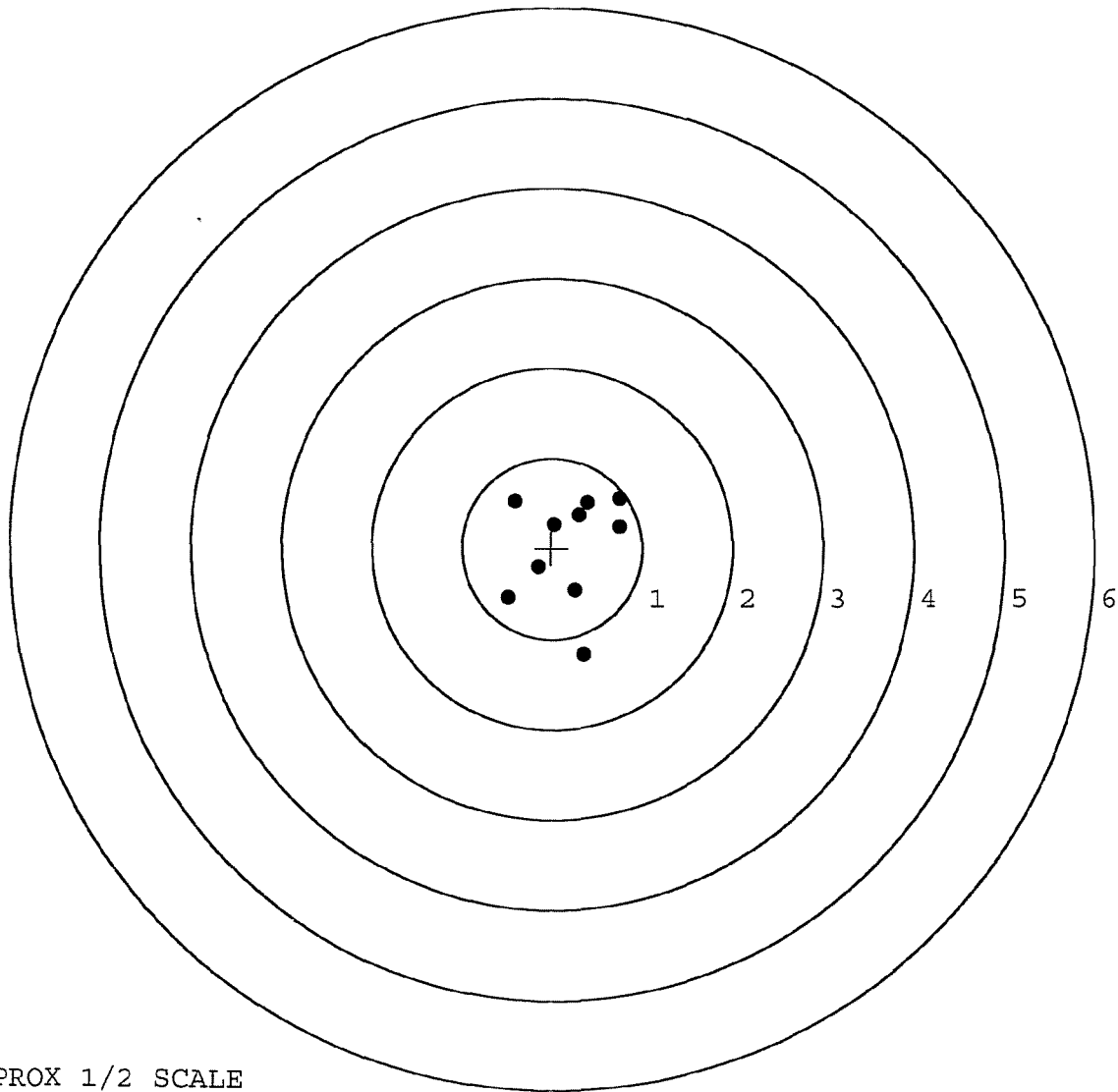


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461736. __0
TARGET NUMBER: 5
FILE DATE: 05/17/2005
FILE TIME: 07:03

X CENTROID: 0.179
Y CENTROID: 0.003
POA TO CENTROID: 0.179
HORZ SPREAD: 1.240
VERT SPREAD: 1.724
GROUP SPREAD: 1.854
MIN RADIUS: 0.297
MAX RADIUS: 1.191
MEAN RADIUS: 0.634
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.353	-1.176
2:	0.259	-0.464
3:	-0.154	-0.209
4:	-0.487	-0.550
5:	-0.409	0.514
6:	0.032	0.261
7:	0.302	0.364
8:	0.397	0.502
9:	0.747	0.548
10:	0.753	0.236



TARGET APPROX 1/2 SCALE