

G-646 1740

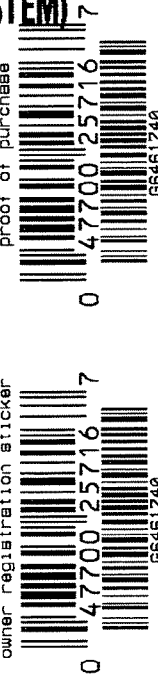
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase

owner registration sticker



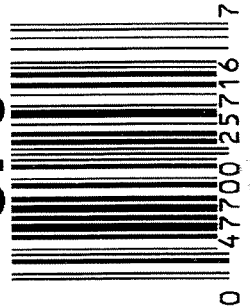
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461740

UPC



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.



Original 12 4/7/2005 2:48:09 PM

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 # G6461740

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 2005 OPERATOR <i>BZ</i>		
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>	5-23-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	5-23-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		5-23-05	AC
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	5-23-05	AC
	J) ASSEMBLE STOCK		5-11-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-23-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-11-05	RTZ
	M) IRON SIGHT ALIGNMENT		5-11-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-11-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-16-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-16-05	AC
655	FINAL INSPECTION A) HEADSPACE		5-23-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.90</u> <u>2.75</u> <u>2.50</u> <u>2.50</u> <u>2.60</u>	5-20-05	AC
	C) FUNCTION		5-23-05	AC
660	PACK		5-25-05	RTA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

SERIAL NO. _____

DATE 5-10-05

TESTER TRW

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)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.57	2.59		2.36	
PULL #2	2.51	2.54		2.19	
PULL #3	2.56	2.54		2.33	
PULL #4	2.59	2.50		2.39	
PULL #5	2.54	2.24		2.31	
TOTAL	12.77	12.41		11.58	
AVERAGE	2.55	2.48		2.31	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.26	3.40		
PULL #2	3.50	3.52		
PULL #3	3.51	3.52		
PULL #4	3.53	3.49		
PULL #5	3.43	3.49		
TOTAL	17.23	17.42		
AVERAGE	3.44	3.48		

	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	4.28		4.20
PULL #2	4.23	4.28		4.27
PULL #3	4.19	4.24		4.06
PULL #4	4.26	4.21		4.05
PULL #5	4.23	4.15		4.22
TOTAL	21.10	21.16		20.80
AVERAGE	4.22	4.23		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461740.___0
FILE DATE AND TIME: 05/16/2005 06:17

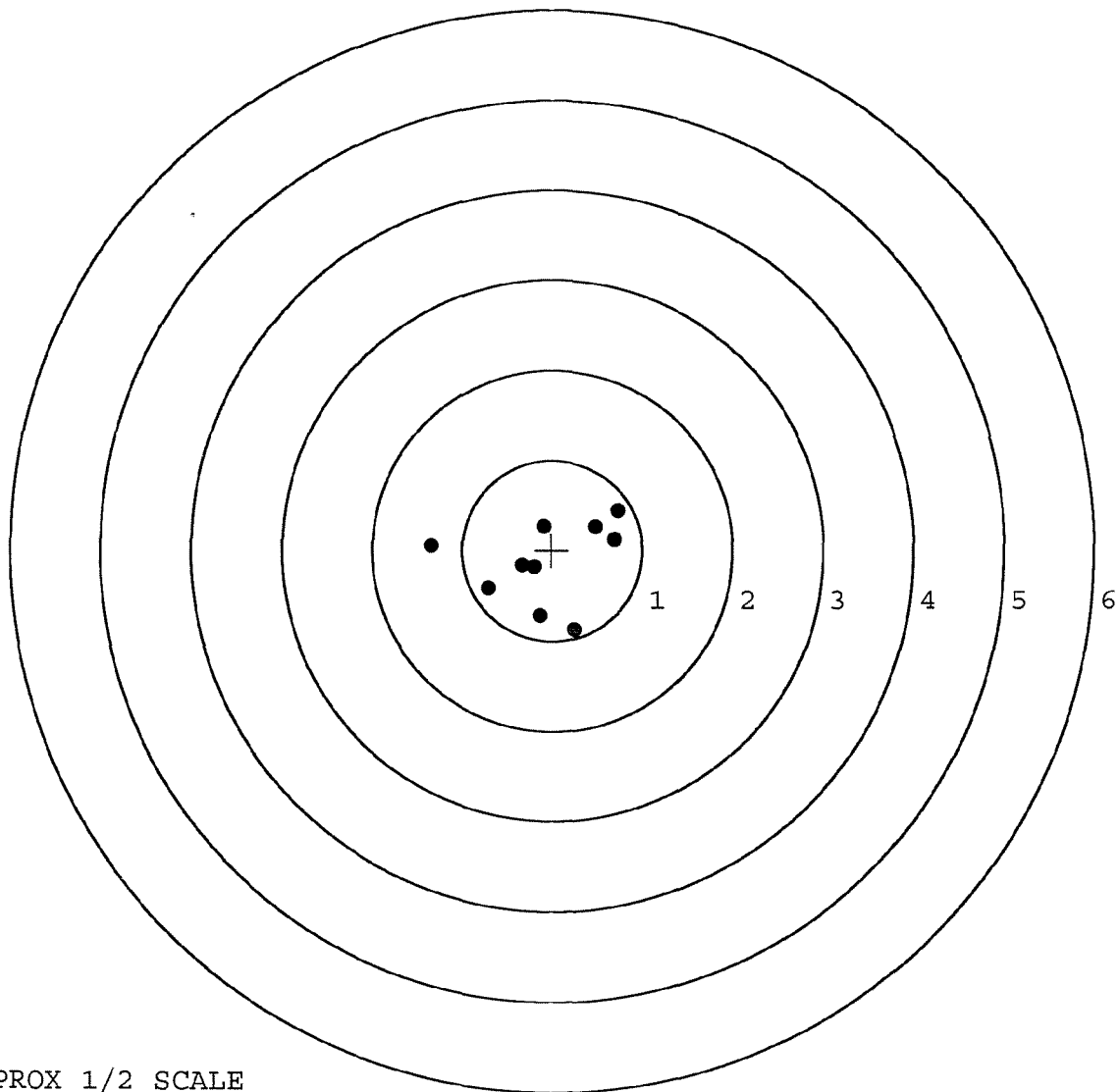
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	0.056
The Average Point of Impact of the Five Target Set:	0.057
The Average Mean Radius of the Five Target Set:	0.790
The Distance from POA to Centroid Target #1:	0.142
The Distance from Centroid Target #2 to Centroid Target #1:	0.295
The Distance from Centroid Target #3 to Centroid Target #1:	0.135
The Distance from Centroid Target #4 to Centroid Target #1:	0.432
The Distance from Centroid Target #5 to Centroid Target #1:	0.182

SERIAL NUMBER: G6461740. __0
TARGET NUMBER: 1
FILE DATE: 05/16/2005
FILE TIME: 06:17

X CENTROID: -0.066
Y CENTROID: -0.125
POA TO CENTROID: 0.142
HORZ SPREAD: 2.073
VERT SPREAD: 1.327
GROUP SPREAD: 2.110
MIN RADIUS: 0.148
MAX RADIUS: 1.288
MEAN RADIUS: 0.668
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.253	-0.882
2:	-0.136	-0.731
3:	0.476	0.260
4:	0.693	0.124
5:	0.731	0.445
6:	-0.095	0.262
7:	-0.199	-0.191
8:	-0.329	-0.170
9:	-0.711	-0.423
10:	-1.342	0.052



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461740. __0

TARGET NUMBER: 2

FILE DATE: 05/16/2005

FILE TIME: 06:17

X CENTROID: 0.030

Y CENTROID: 0.154

POA TO CENTROID: 0.157

HORZ SPREAD: 1.505

VERT SPREAD: 2.671

GROUP SPREAD: 2.717

MIN RADIUS: 0.160

MAX RADIUS: 1.514

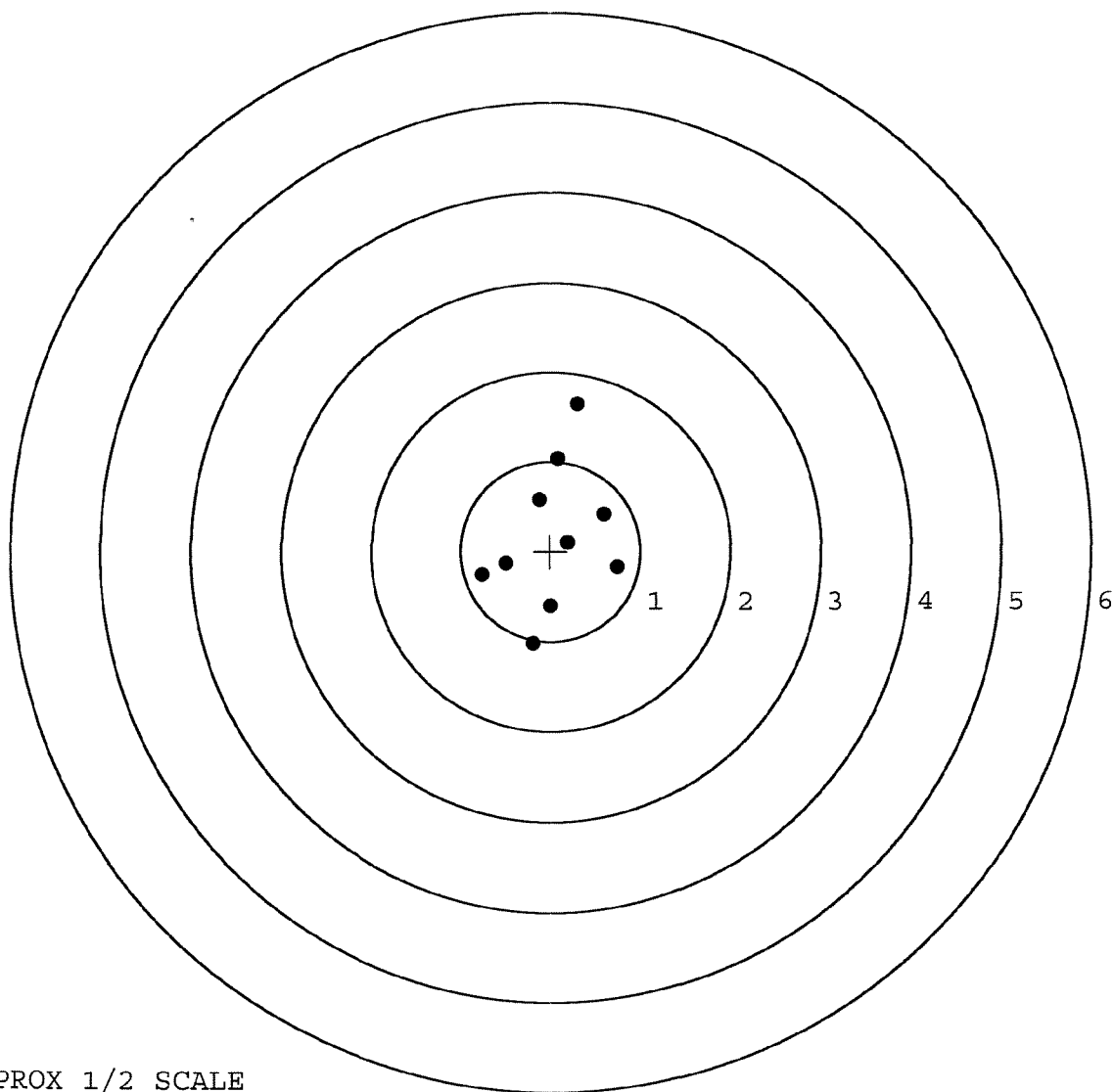
MEAN RADIUS: 0.787

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.740	-0.180
2:	0.593	0.410
3:	0.180	0.097
4:	-0.499	-0.134
5:	-0.765	-0.265
6:	-0.004	-0.611
7:	-0.200	-1.027
8:	-0.128	0.573
9:	0.089	1.031
10:	0.298	1.644



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461740. 0

TARGET NUMBER: 3

FILE DATE: 05/16/2005

FILE TIME: 06:17

POINT#	X	Y
1:	0.463	-0.346
2:	0.583	0.201
3:	-0.112	0.216
4:	-0.188	0.578
5:	-0.584	0.188
6:	-0.442	0.712
7:	-0.369	1.867
8:	-1.042	-0.648
9:	-0.882	-1.518
10:	0.927	-1.583

X CENTROID: -0.165

Y CENTROID: -0.033

POA TO CENTROID: 0.168

HORZ SPREAD: 1.969

VERT SPREAD: 3.450

GROUP SPREAD: 3.685

MIN RADIUS: 0.255

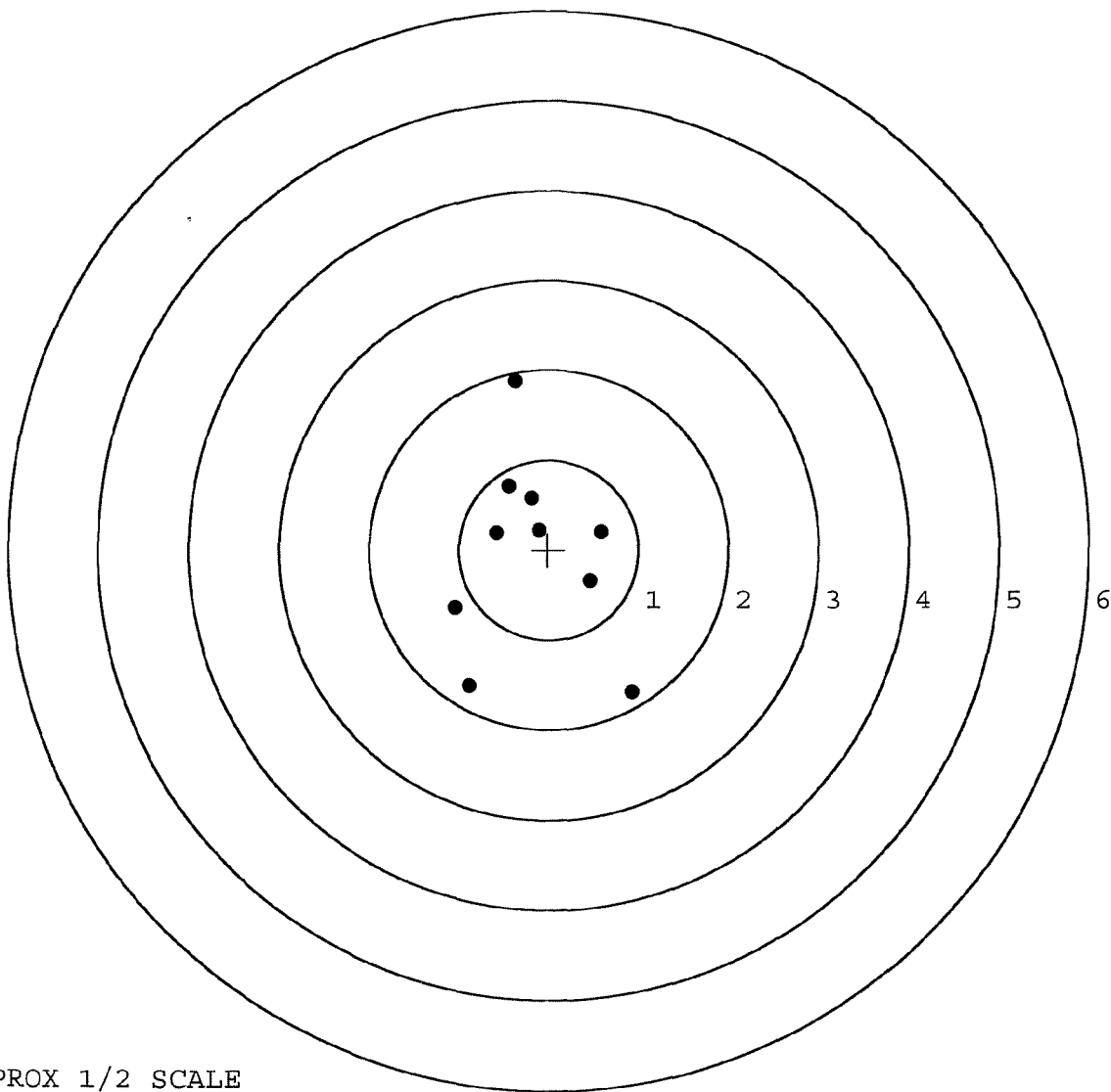
MAX RADIUS: 1.911

MEAN RADIUS: 1.015

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461740.___0

TARGET NUMBER: 4

FILE DATE: 05/16/2005

FILE TIME: 06:17

POINT#	X	Y
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1:	0.581	-0.679
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2:	0.377	-0.130
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3:	0.150	-0.137
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4:	-0.244	-0.292
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5:	-0.329	-0.516
----	--------	--------

6:	0.651	0.482
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7:	0.573	0.989
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8:	0.158	0.942
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9:	-0.184	1.176
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10:	-0.637	0.853
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X CENTROID: 0.110

Y CENTROID: 0.269

POA TO CENTROID: 0.290

HORZ SPREAD: 1.288

VERT SPREAD: 1.855

GROUP SPREAD: 2.007

MIN RADIUS: 0.408

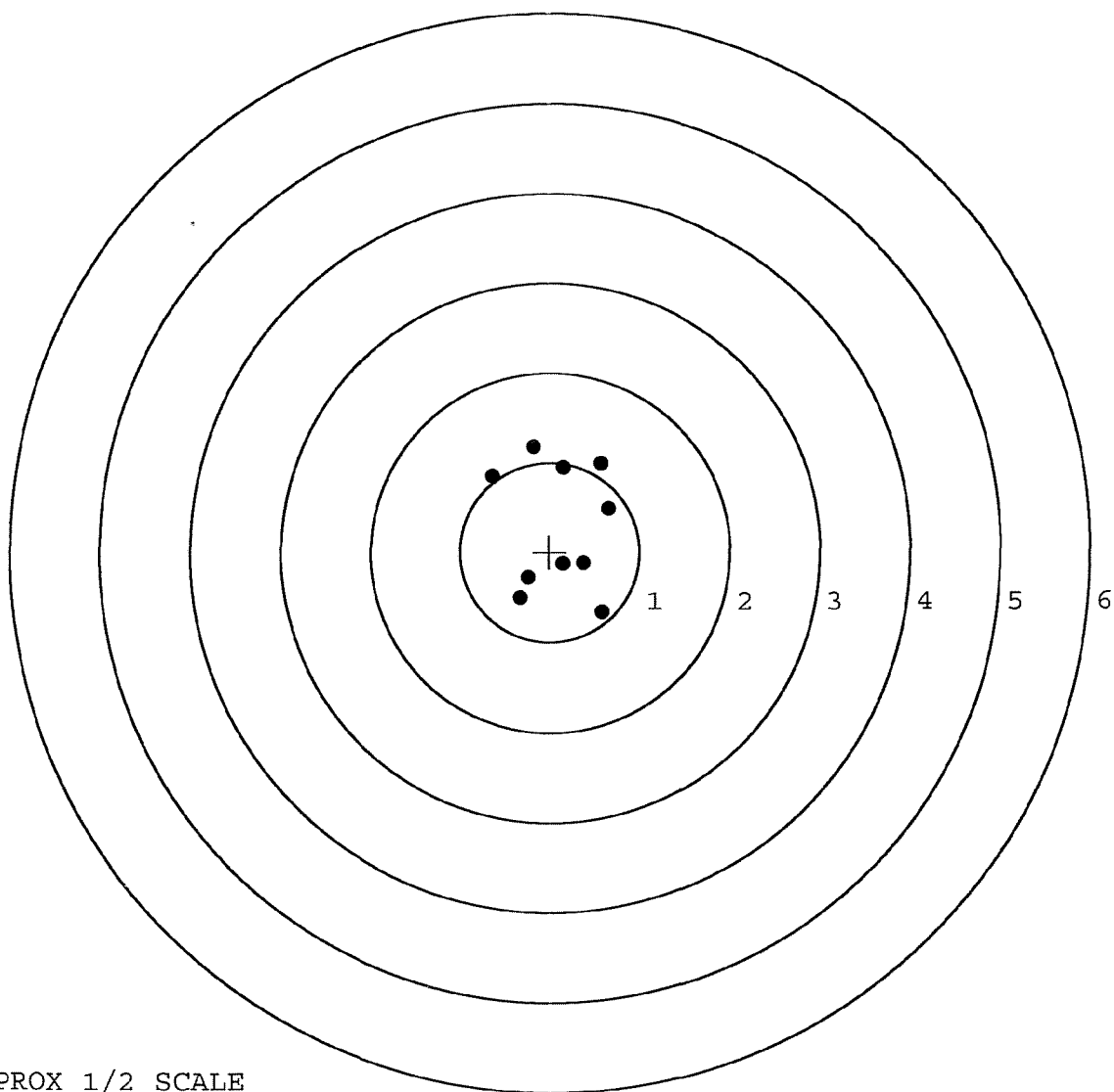
MAX RADIUS: 1.059

MEAN RADIUS: 0.752

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

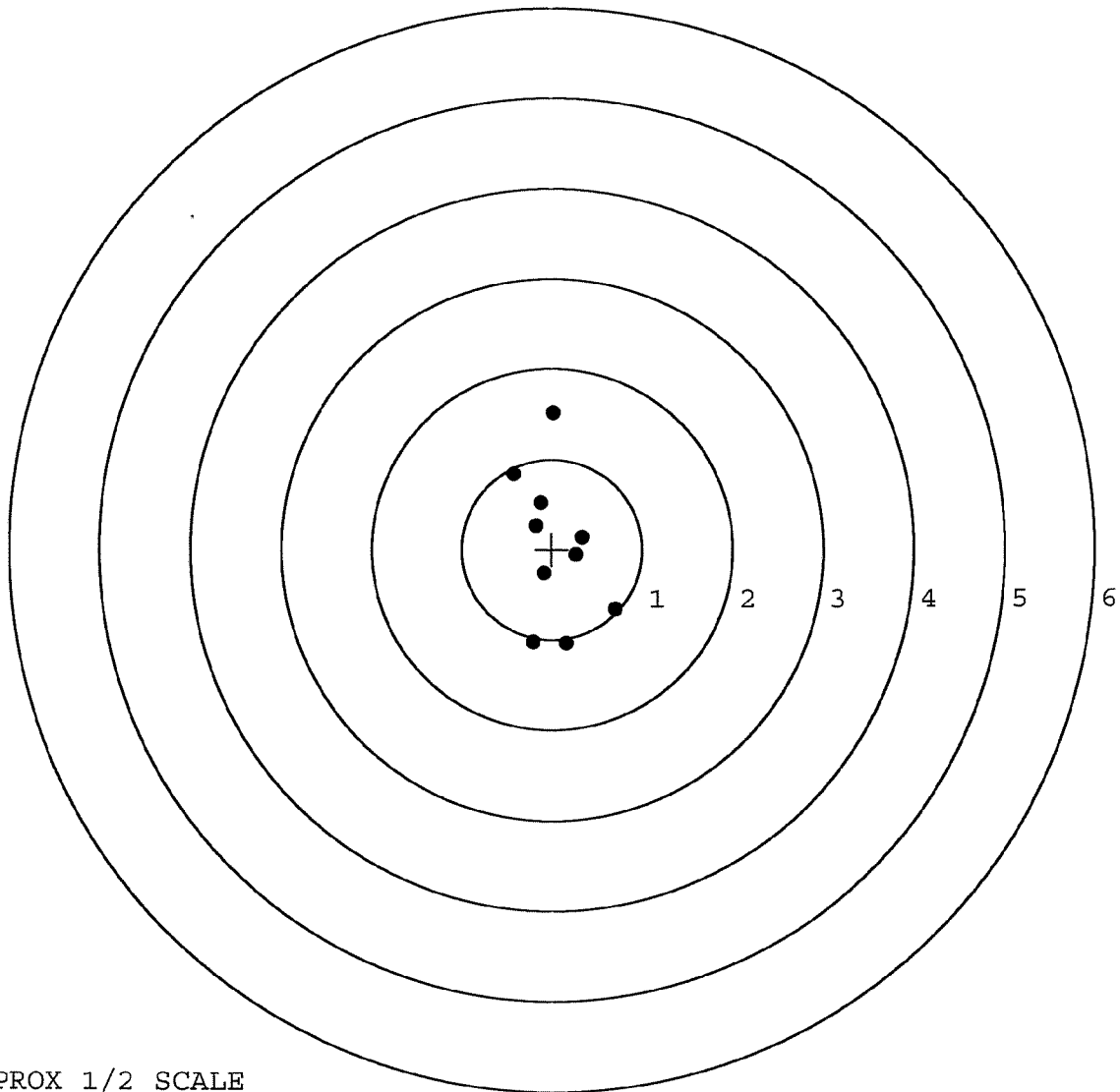


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461740. __0
TARGET NUMBER: 5
FILE DATE: 05/16/2005
FILE TIME: 06:17

X CENTROID: 0.047
Y CENTROID: 0.018
POA TO CENTROID: 0.050
HORZ SPREAD: 1.130
VERT SPREAD: 2.560
GROUP SPREAD: 2.564
MIN RADIUS: 0.233
MAX RADIUS: 1.492
MEAN RADIUS: 0.728
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.705	-0.669
2:	0.165	-1.050
3:	-0.209	-1.039
4:	-0.093	-0.269
5:	0.338	0.136
6:	0.267	-0.060
7:	-0.177	0.263
8:	-0.126	0.519
9:	-0.425	0.837
10:	0.025	1.510



TARGET APPROX 1/2 SCALE