

G-646 / 743

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



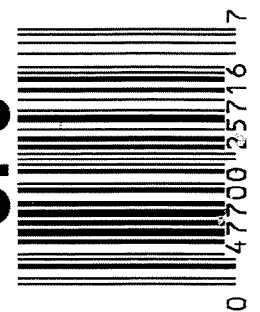
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461743

UPC



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.



8/11/2005 9:22:37 AM

Crib

35

Original

25716

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



.MA25716

Shop Order: SW5716 - SEP



.ABSW5716 - SEP

Start Date: 5/27/2005

Finish Date: 9/26/2005

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0004110512

0540

Flat Black Powder Coat, Barrel and

01PC001



0004110502

0560

Reassemble Action.

89SWS1



0004110503

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 660461743

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-9-05	RTZ
440	PROOF		9-12-05	RTZ
460	CHECK HEADSPACE		9-13-05	RTZ
470	DIS-ASSEMBLE ACTION		9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/90 EJECTOR <i>unl</i>	9/14/05	<i>unl</i>
500	ROLLMARK CALIBER		9-14-05	CW
510	DRILL AND TAP SIGHT HOLES		9-13-05	TRW
520	GOFF BLAST BBL / REC		9-19-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/20	<i>unl</i>
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9-28-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-28-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-28-05	DA
	D) OIL FIRING PIN ASSEMBLY		9-30-05	RTZ
	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>5 16s</u> <u>5 16s</u> <u>5 16s</u>	10-11-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16s</u> <u>2 16s</u> <u>2 16s</u>	10-11-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		9-30-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-30-05	RTL
	M) IRON SIGHT ALIGNMENT		9-30-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-30-05	RTL
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	10-5-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-5-05	R.P.
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>2.50</u> <u>2.82</u> <u>2.89</u> <u>2.58</u>	10-7-05	BG
	C) FUNCTION		10-11-05	Ac
690	PACK		10-12-05	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

9/28/05

TESTER

BG

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.88		2.60	
PULL #2	2.56	2.79		2.58	
PULL #3	2.60	2.38		2.27	
PULL #4	2.69	2.45		2.23	
PULL #5	2.61	2.40		2.56	
TOTAL	12.83	12.90		12.24	
AVERAGE	2.57	2.58		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	2.70		
PULL #2	2.99	2.86		
PULL #3	2.85	2.94		
PULL #4	2.94	2.79		
PULL #5	2.82	2.78		
TOTAL	14.73	14.07		
AVERAGE	2.95	2.81		

	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	3.95	4.18		4.19
PULL #2	4.18	4.23		4.00
PULL #3	4.13	3.85		4.15
PULL #4	4.25	4.25		4.21
PULL #5	4.34	3.78		3.83
TOTAL	20.85	20.29		20.38
AVERAGE	4.17	4.06		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461743.__0

FILE DATE AND TIME: 10/05/2005 11:25

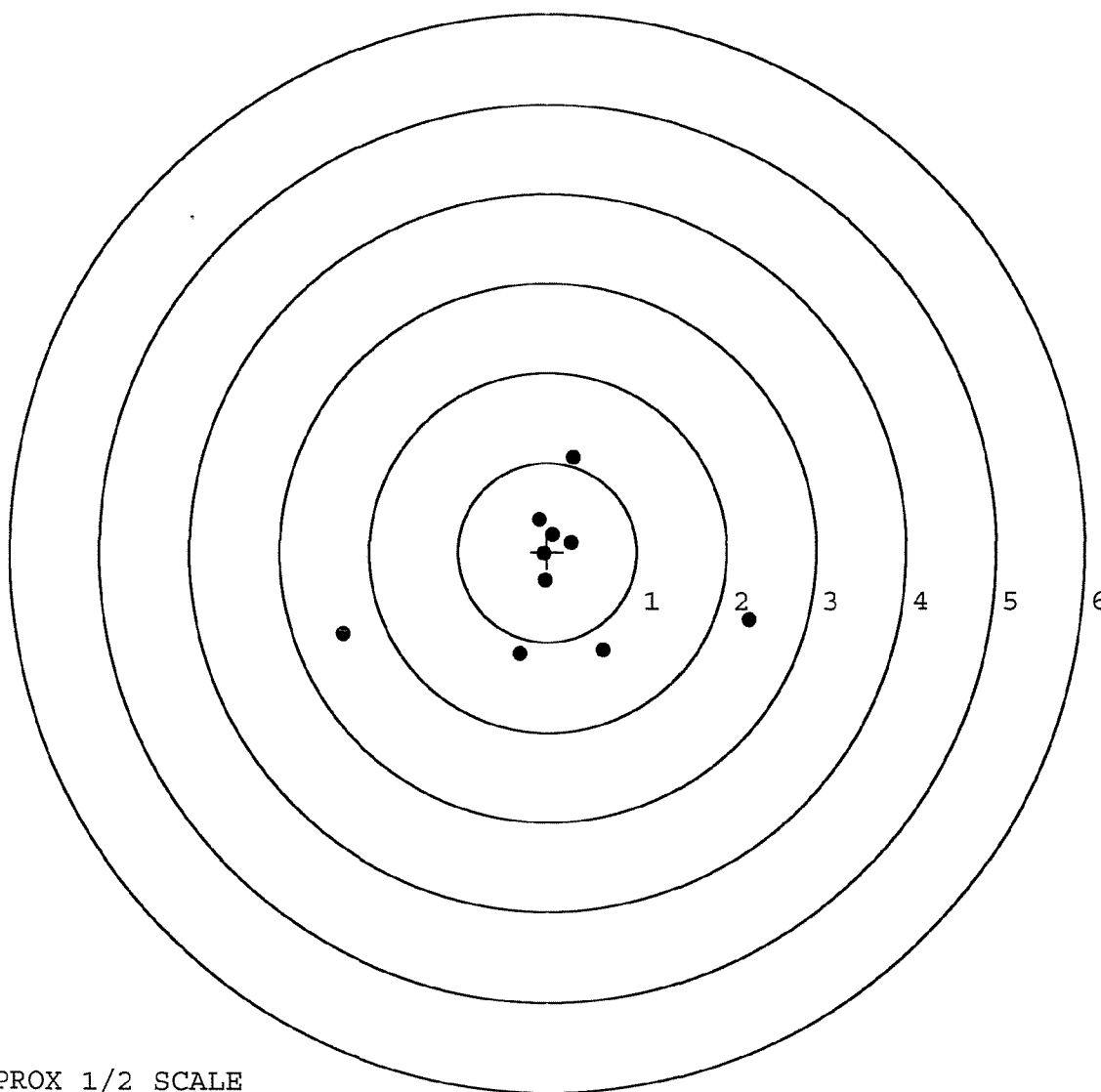
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.123
The Average Y Centroid of the Five Target Set:	-0.078
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	1.032
The Distance from POA to Centroid Target #1:	0.264
The Distance from Centroid Target #2 to Centroid Target #1:	0.295
The Distance from Centroid Target #3 to Centroid Target #1:	1.032
The Distance from Centroid Target #4 to Centroid Target #1:	0.093
The Distance from Centroid Target #5 to Centroid Target #1:	0.280

SERIAL NUMBER: G6461743. __0
TARGET NUMBER: 1
FILE DATE: 10/05/2005
FILE TIME: 11:25

X CENTROID: 0.074
Y CENTROID: -0.253
POA TO CENTROID: 0.264
HORZ SPREAD: 4.538
VERT SPREAD: 2.192
GROUP SPREAD: 4.541
MIN RADIUS: 0.120
MAX RADIUS: 2.454
MEAN RADIUS: 0.986
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	2.248	-0.758
2:	0.622	-1.097
3:	-0.309	-1.138
4:	-2.290	-0.914
5:	-0.022	-0.325
6:	-0.039	-0.020
7:	0.270	0.105
8:	0.065	0.198
9:	-0.098	0.365
10:	0.291	1.054

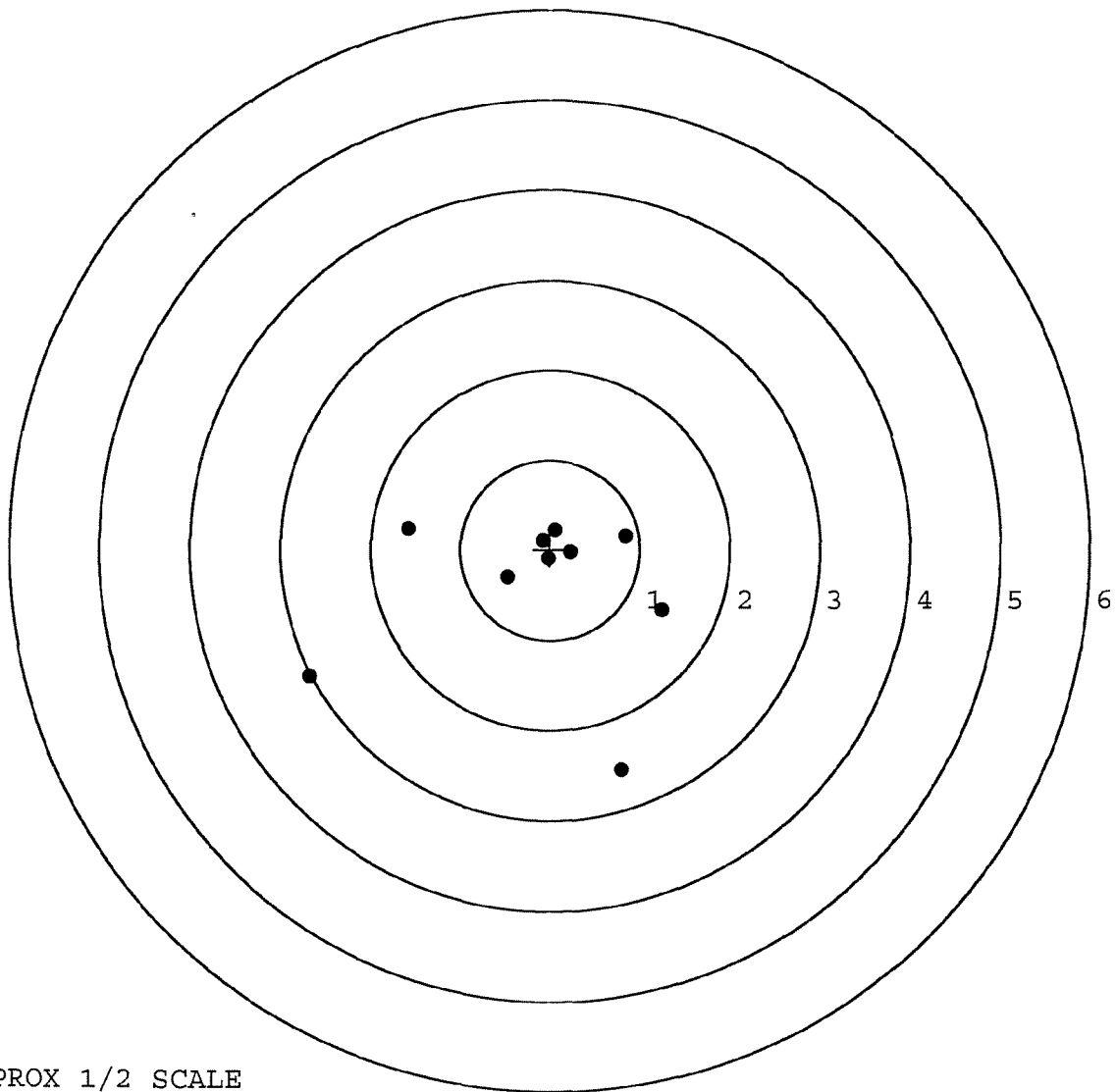


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461743. __0
TARGET NUMBER: 2
FILE DATE: 10/05/2005
FILE TIME: 11:25

POINT#	X	Y
1:	0.806	-2.440
2:	1.246	-0.670
3:	0.837	0.155
4:	-0.471	-0.311
5:	-1.585	0.230
6:	-2.677	-1.411
7:	0.060	0.219
8:	-0.080	0.099
9:	0.229	-0.032
10:	-0.020	-0.102

X CENTROID: -0.165
Y CENTROID: -0.426
POA TO CENTROID: 0.457
HORZ SPREAD: 3.923
VERT SPREAD: 2.670
GROUP SPREAD: 3.992
MIN RADIUS: 0.327
MAX RADIUS: 2.698
MEAN RADIUS: 1.154
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

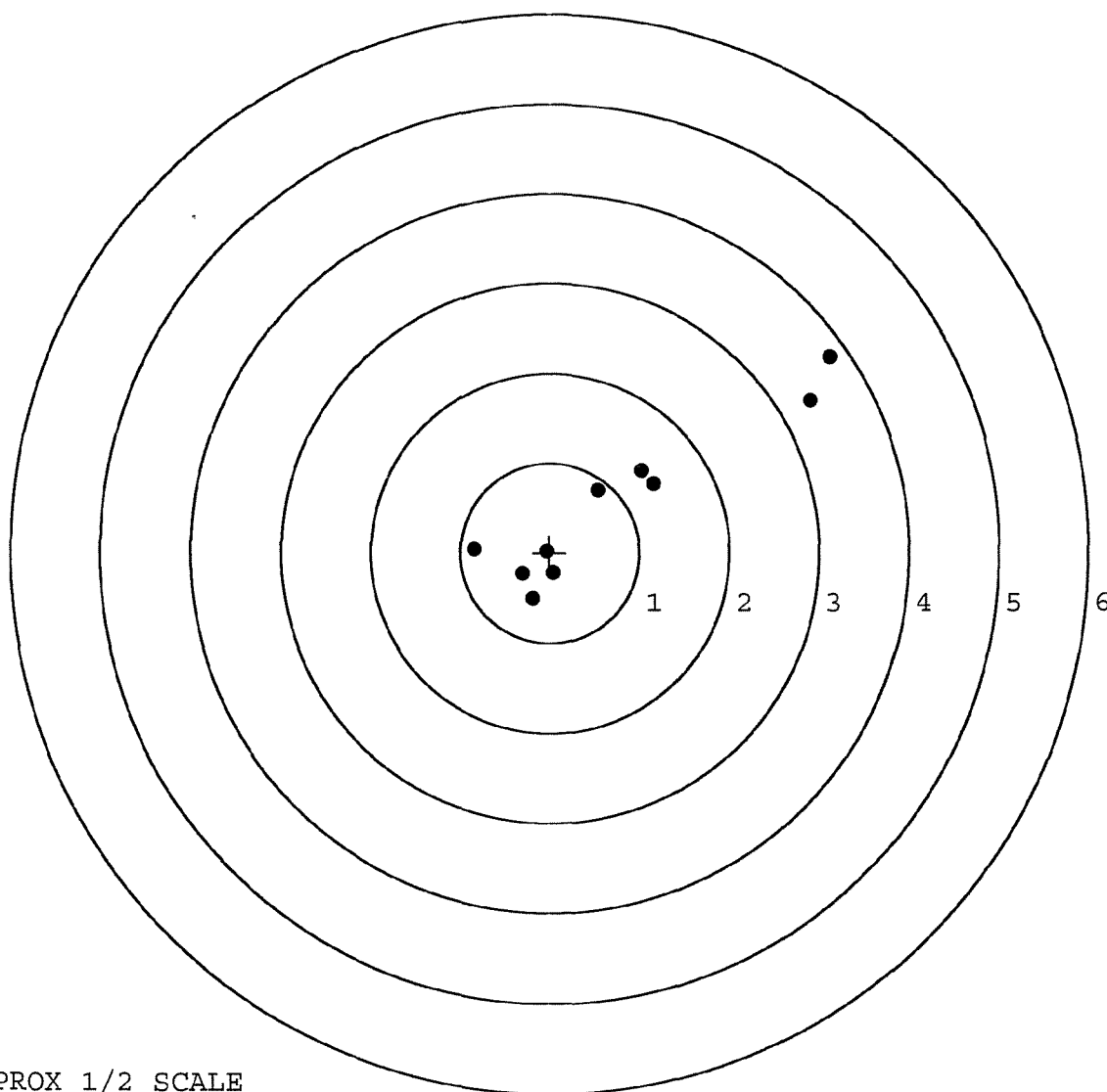


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461743. __0
TARGET NUMBER: 3
FILE DATE: 10/05/2005
FILE TIME: 11:25

POINT#	X	Y
1:	3.116	2.181
2:	2.898	1.705
3:	1.156	0.773
4:	1.023	0.914
5:	0.538	0.696
6:	-0.846	0.040
7:	-0.030	0.019
8:	-0.301	-0.235
9:	0.044	-0.233
10:	-0.191	-0.515

X CENTROID: 0.741
Y CENTROID: 0.535
POA TO CENTROID: 0.913
HORZ SPREAD: 3.962
VERT SPREAD: 2.696
GROUP SPREAD: 4.503
MIN RADIUS: 0.259
MAX RADIUS: 2.890
MEAN RADIUS: 1.288
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

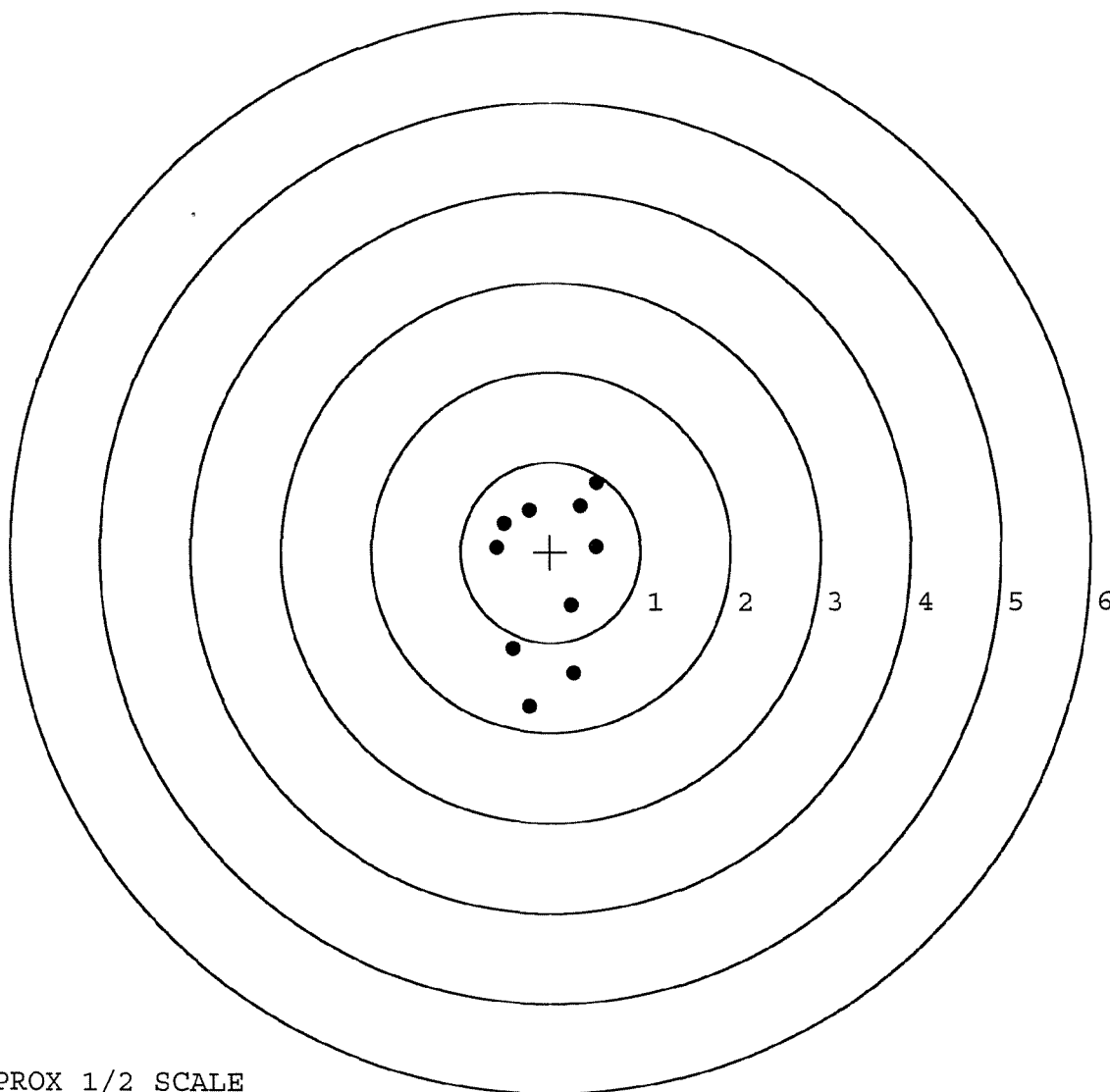


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461743. __0
TARGET NUMBER: 4
FILE DATE: 10/05/2005
FILE TIME: 11:25

X CENTROID: -0.019
Y CENTROID: -0.258
POA TO CENTROID: 0.259
HORZ SPREAD: 1.112
VERT SPREAD: 2.490
GROUP SPREAD: 2.601
MIN RADIUS: 0.415
MAX RADIUS: 1.477
MEAN RADIUS: 0.871
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.254	-1.346
2:	-0.239	-1.719
3:	-0.423	-1.076
4:	0.231	-0.589
5:	0.511	0.057
6:	0.513	0.771
7:	0.330	0.510
8:	-0.244	0.464
9:	-0.523	0.307
10:	-0.599	0.040

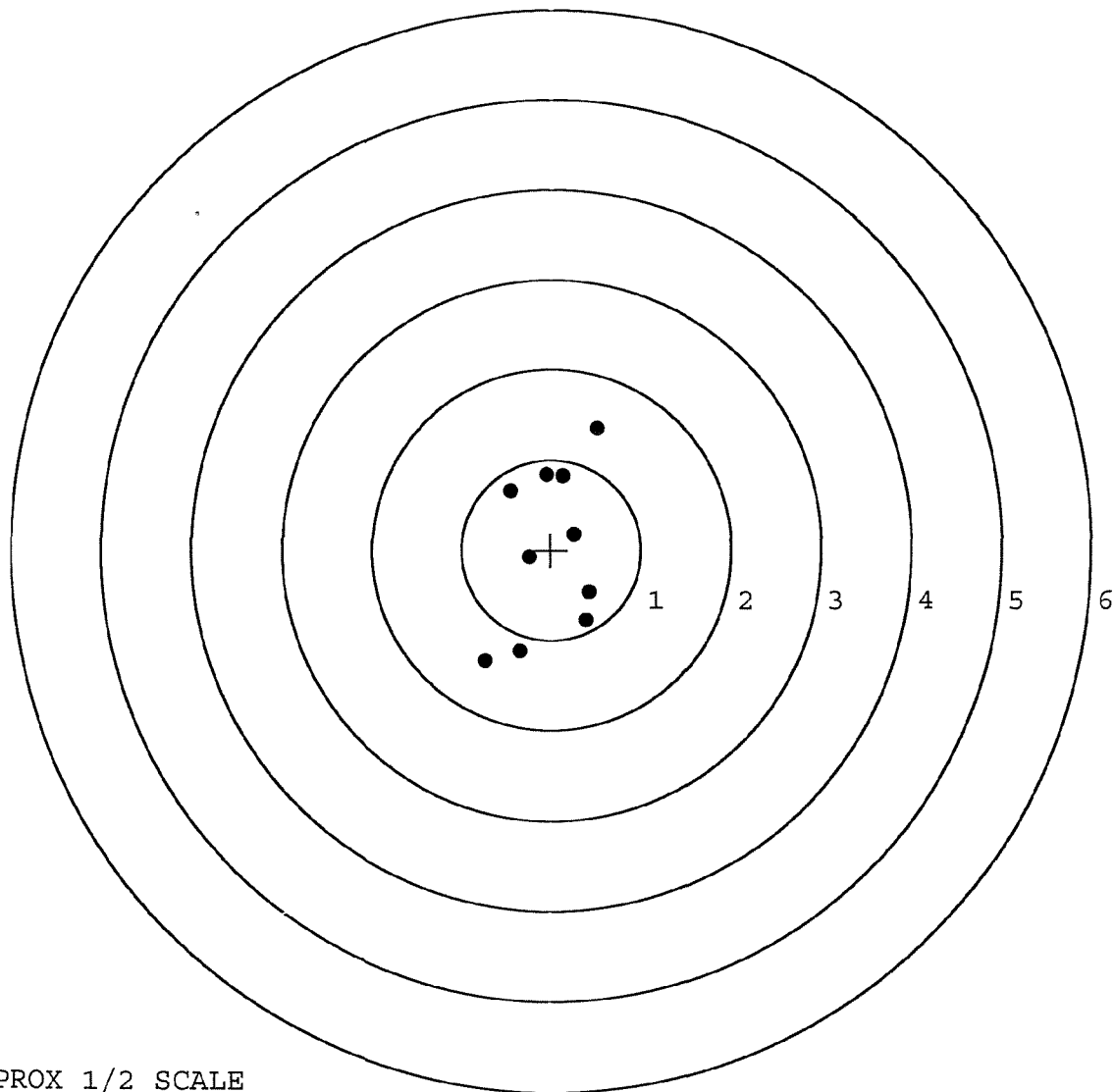


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461743. __0
TARGET NUMBER: 5
FILE DATE: 10/05/2005
FILE TIME: 11:25

X CENTROID: -0.015
Y CENTROID: 0.013
POA TO CENTROID: 0.020
HORZ SPREAD: 1.247
VERT SPREAD: 2.585
GROUP SPREAD: 2.870
MIN RADIUS: 0.246
MAX RADIUS: 1.446
MEAN RADIUS: 0.860
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.392	-0.785
2:	0.421	-0.468
3:	-0.349	-1.132
4:	-0.738	-1.239
5:	-0.242	-0.081
6:	0.248	0.177
7:	-0.459	0.658
8:	-0.057	0.835
9:	0.129	0.820
10:	0.509	1.346



TARGET APPROX 1/2 SCALE