

G646 1746

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



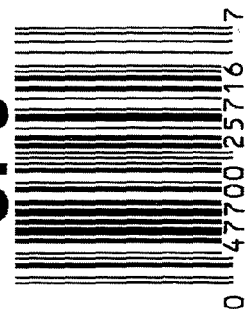
owner registration sticker



ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6461746

UPC



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



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



SERIAL NO.



4/7/2005 2:48:09 PM

Copy

92

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 # 6646 1746

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	A
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-18-05	A
610	DIS-ASSEMBLE GUN	APR 11 2005	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BJ</u>		
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	CW
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-12-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-12-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-12-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-12-05	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>5 16s</u> <u>5 16s</u> <u>5 16s</u>	5-31-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 16s</u> <u>3 16s</u> <u>3 16s</u>	5-31-05	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>	5-31-05	Ac
	J) ASSEMBLE STOCK		5-12-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-31-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-12-05	RTZ
	M) IRON SIGHT ALIGNMENT		5-12-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-12-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	5-13-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-13-05	Ac
655	FINAL INSPECTION A) HEADSPACE		5-31-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u> <u>2.96</u> <u>2.98</u> <u>2.98</u> <u>2.99</u>	5-23-05	Ac
	C) FUNCTION		5-31-05	Ac
660	PACK		6-1-05	RAA

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 5-9-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.14	2.24		2.09	
PULL #2	2.20	2.33		2.14	
PULL #3	2.42	2.26		2.21	
PULL #4	2.47	2.45		2.10	
PULL #5	2.43	2.46		2.14	
TOTAL	11.66	11.74		10.68	
AVERAGE	2.33	2.34		2.13	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.32	3.21		
PULL #2	3.17	3.15		
PULL #3	3.33	3.12		
PULL #4	3.22	3.13		
PULL #5	3.36	2.98		
TOTAL	16.40	15.59		
AVERAGE	3.28	3.11		

	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	4.42	4.08		3.95
PULL #2	4.29	4.08		4.23
PULL #3	4.22	4.00		4.37
PULL #4	4.25	3.90		4.27
PULL #5	4.26	3.74		4.29
TOTAL	21.44	19.80		21.11
AVERAGE	4.28	3.96		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461746.___0
FILE DATE AND TIME: 05/13/2005 06:10

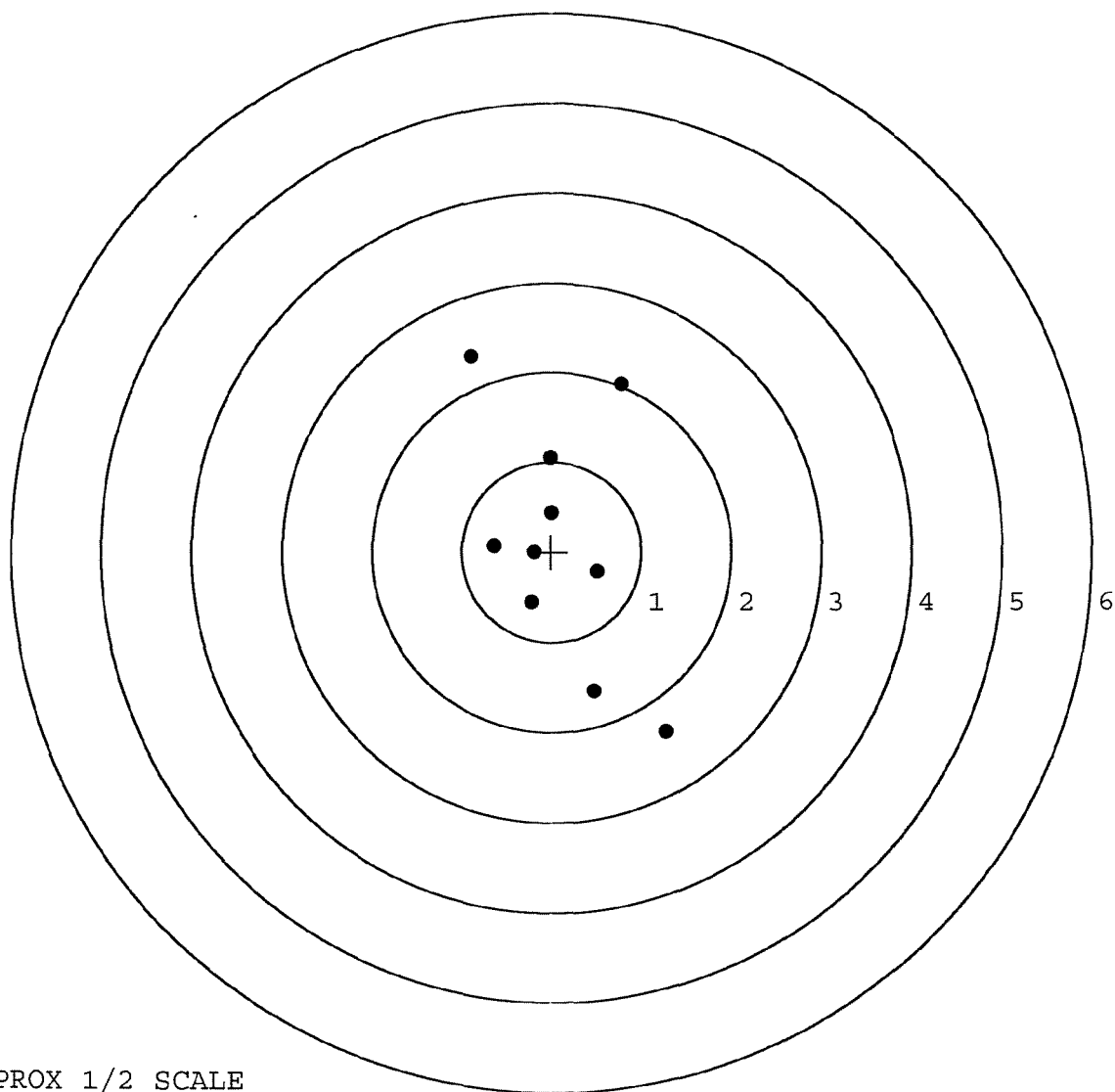
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.020
The Average Y Centroid of the Five Target Set:	0.077
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.667
The Distance from POA to Centroid Target #1:	0.167
The Distance from Centroid Target #2 to Centroid Target #1:	0.122
The Distance from Centroid Target #3 to Centroid Target #1:	0.260
The Distance from Centroid Target #4 to Centroid Target #1:	0.056
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: G6461746. __0
TARGET NUMBER: 1
FILE DATE: 05/13/2005
FILE TIME: 06:10

POINT#	X	Y
1:	-0.897	2.175
2:	0.778	1.868
3:	-0.011	1.043
4:	-0.004	0.438
5:	-0.635	0.072
6:	-0.189	-0.002
7:	-0.225	-0.566
8:	0.511	-0.216
9:	0.477	-1.542
10:	1.272	-1.998

X CENTROID: 0.108
Y CENTROID: 0.127
POA TO CENTROID: 0.167
HORZ SPREAD: 2.169
VERT SPREAD: 4.173
GROUP SPREAD: 4.703
MIN RADIUS: 0.324
MAX RADIUS: 2.423
MEAN RADIUS: 1.190
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461746. 0

TARGET NUMBER: 2

FILE DATE: 05/13/2005

FILE TIME: 06:10

POINT#	X	Y
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1:	0.040	0.979
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2:	-0.391	0.006
----	--------	-------

3:	0.034	-0.259
----	-------	--------

4:	0.082	-0.082
----	-------	--------

5:	0.274	0.094
----	-------	-------

6:	-0.063	0.134
----	--------	-------

7:	-0.098	0.274
----	--------	-------

8:	0.032	0.340
----	-------	-------

9:	-0.086	0.077
----	--------	-------

10:	0.056	-0.050
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X CENTROID: -0.012

Y CENTROID: 0.151

POA TO CENTROID: 0.152

HORZ SPREAD: 0.665

VERT SPREAD: 1.238

GROUP SPREAD: 1.238

MIN RADIUS: 0.054

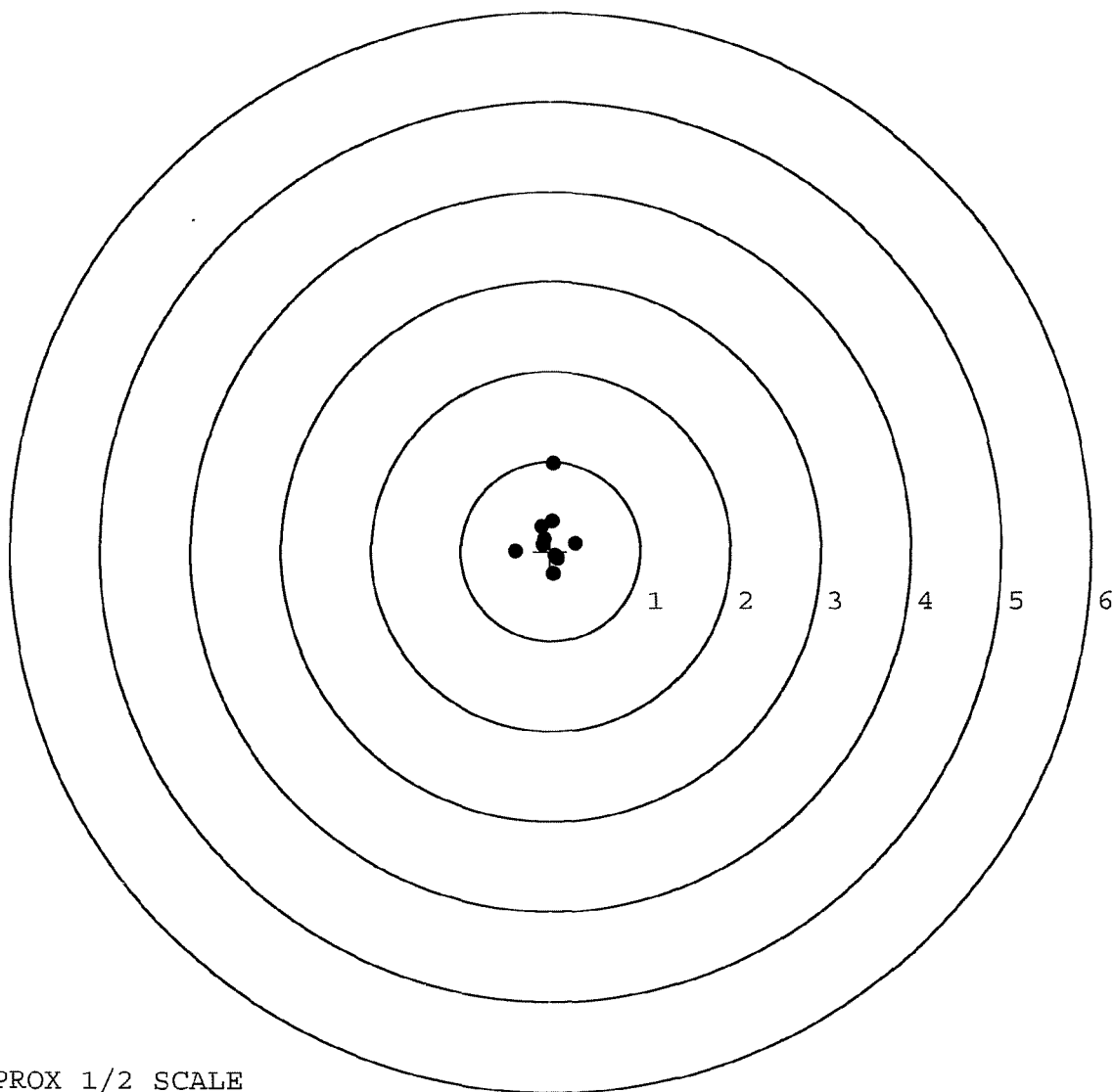
MAX RADIUS: 0.829

MEAN RADIUS: 0.291

IN 1 IN DIAMETER: 9

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461746. 0

TARGET NUMBER: 3

FILE DATE: 05/13/2005

FILE TIME: 06:10

POINT#	X	Y
1:	0.249	0.228
2:	0.136	0.124
3:	0.333	-0.104
4:	-0.253	-0.008
5:	-0.415	-0.304
6:	-0.140	-0.288
7:	0.677	0.260
8:	0.121	-0.793
9:	-0.762	-0.191
10:	-0.843	0.657

X CENTROID: -0.090

Y CENTROID: -0.042

POA TO CENTROID: 0.099

HORZ SPREAD: 1.520

VERT SPREAD: 1.450

GROUP SPREAD: 1.741

MIN RADIUS: 0.167

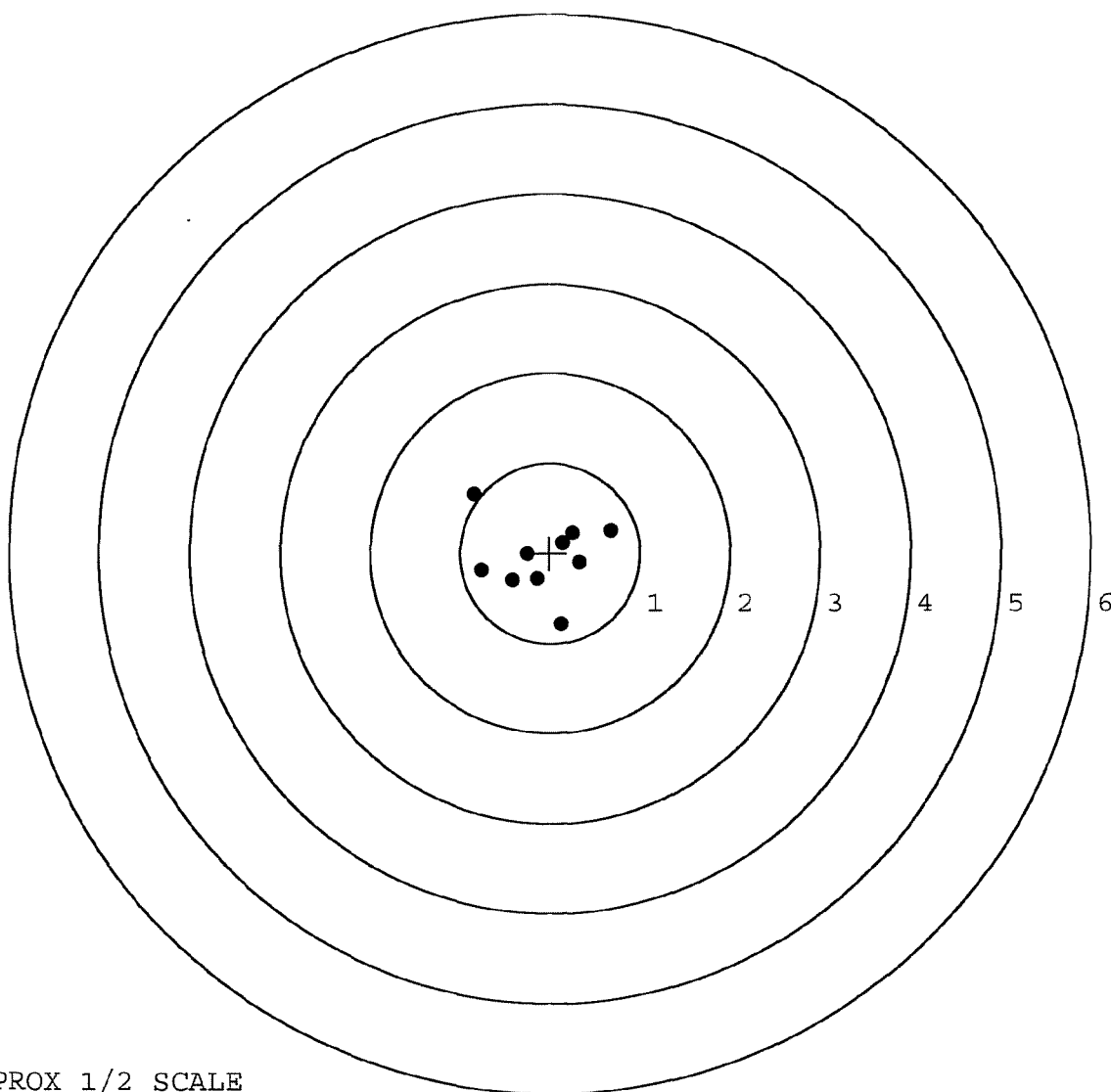
MAX RADIUS: 1.028

MEAN RADIUS: 0.530

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461746. __0

TARGET NUMBER: 4

FILE DATE: 05/13/2005

FILE TIME: 06:10

POINT#	X	Y
1:	0.283	0.921
2:	-0.059	1.105
3:	-0.218	0.648
4:	0.811	0.096
5:	0.279	0.240
6:	-0.063	-0.323
7:	0.560	-0.201
8:	-0.075	-0.921
9:	-0.590	-1.038
10:	0.265	0.193

X CENTROID: 0.119

Y CENTROID: 0.072

POA TO CENTROID: 0.139

HORZ SPREAD: 1.401

VERT SPREAD: 2.143

GROUP SPREAD: 2.208

MIN RADIUS: 0.189

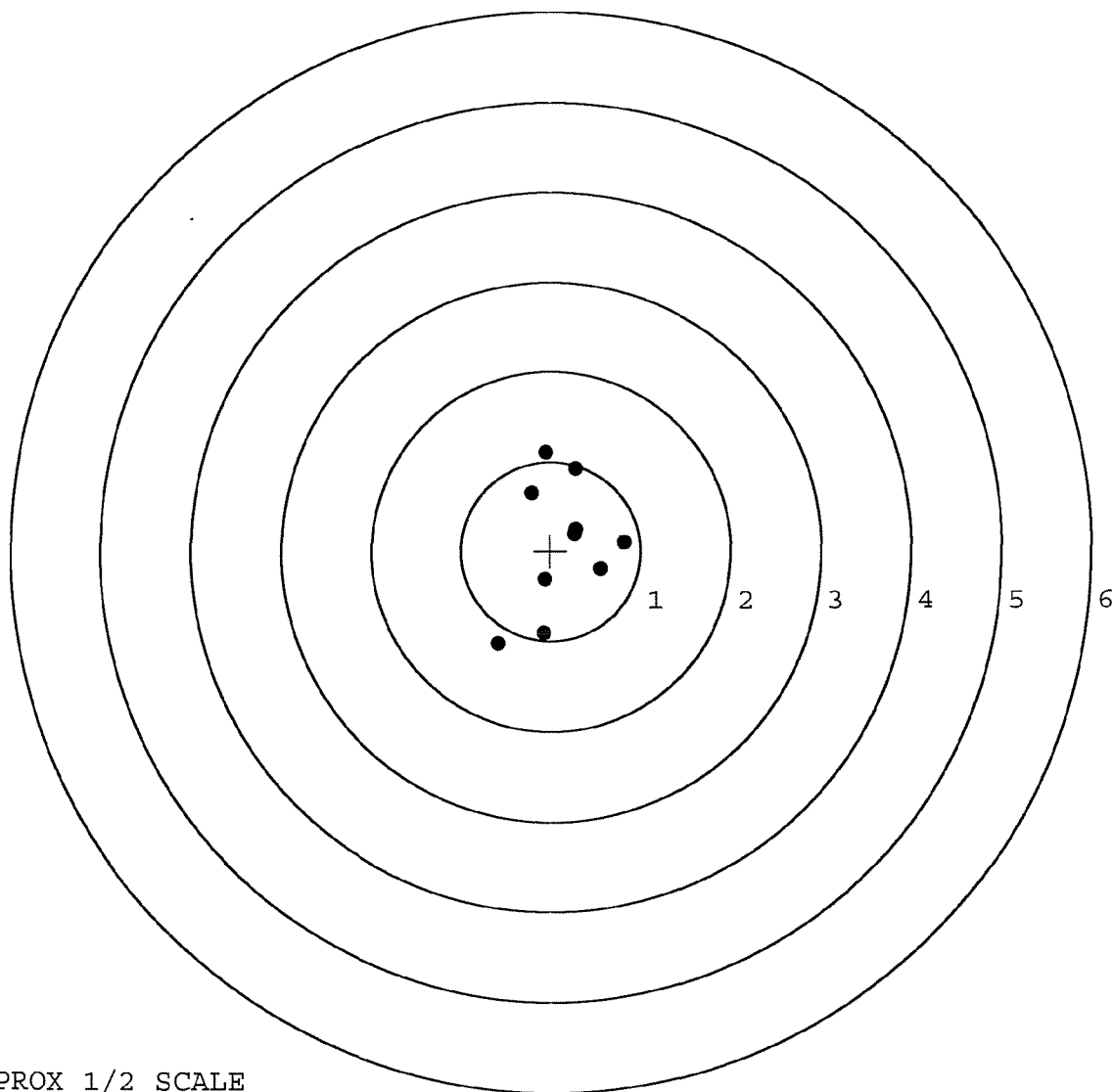
MAX RADIUS: 1.317

MEAN RADIUS: 0.698

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

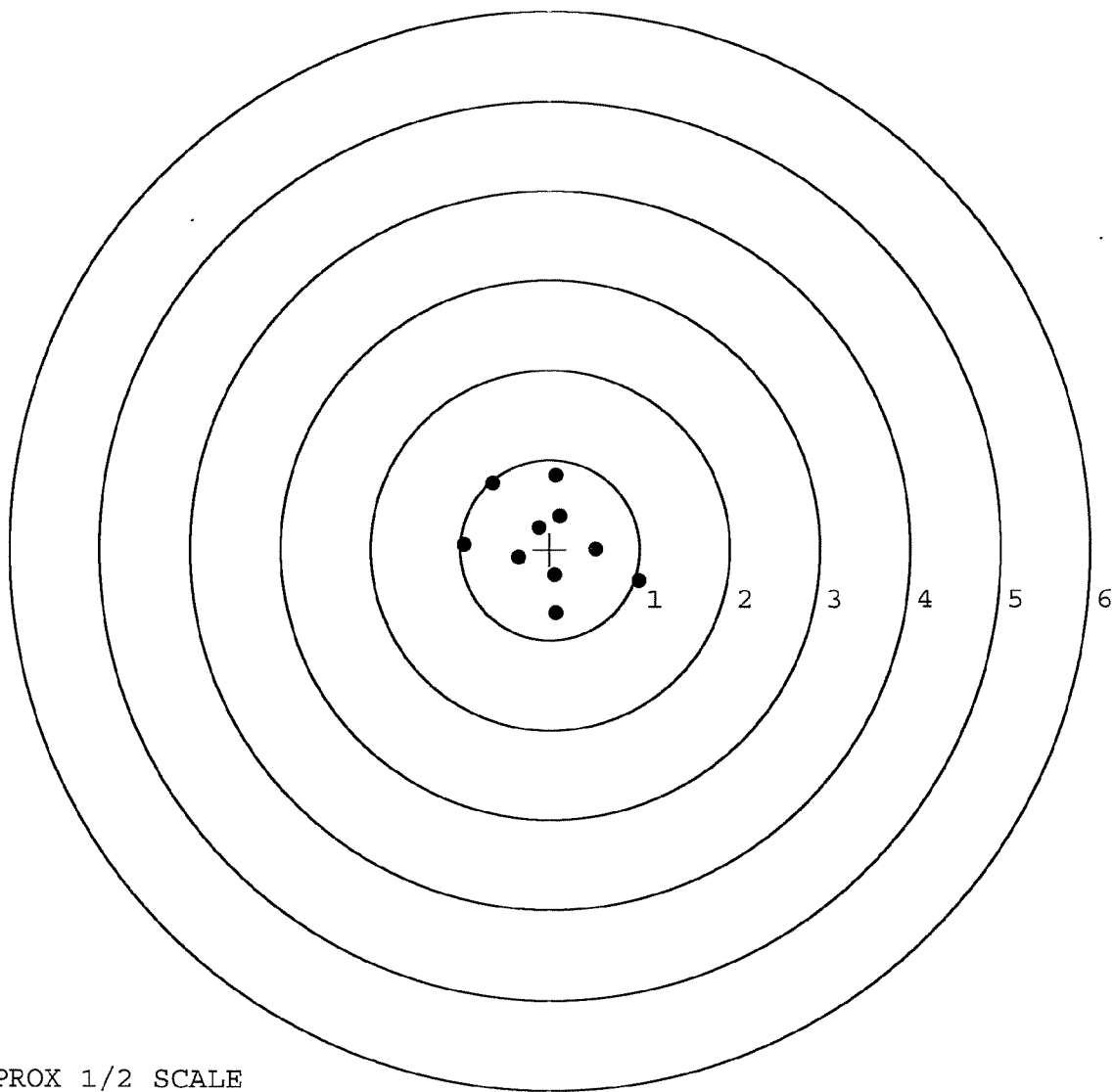


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461746. 0
TARGET NUMBER: 5
FILE DATE: 05/13/2005
FILE TIME: 06:10

POINT#	X	Y
1:	0.068	0.823
2:	-0.640	0.737
3:	-0.957	0.052
4:	0.990	-0.348
5:	0.508	0.000
6:	0.116	0.370
7:	-0.123	0.241
8:	-0.352	-0.096
9:	0.055	-0.292
10:	0.073	-0.709

X CENTROID: -0.026
Y CENTROID: 0.078
POA TO CENTROID: 0.082
HORZ SPREAD: 1.947
VERT SPREAD: 1.532
GROUP SPREAD: 1.988
MIN RADIUS: 0.190
MAX RADIUS: 1.102
MEAN RADIUS: 0.628
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE