

G6461775

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.



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



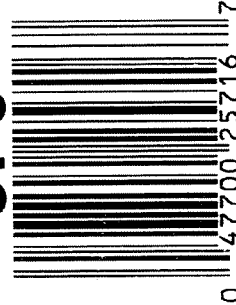
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6461775

UPC



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6

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 # G646 1775

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-15-05	RTZ
600	PROOF		4-18-05	RTZ
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-18-05	RTZ
610	DIS-ASSEMBLE GUN		4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	APR 20 2005 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		4-21-05	CW
617	DRILL AND TAP SIGHT HOLES		4-18-05	TRC
620	APPLY COATINGS (BARREL ACTION)		5-6-05	CW
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-17-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-17-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-17-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		5-17-05	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 16s</u> <u>6 16s</u> <u>6 16s</u>	5-19-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16s</u> <u>2 16s</u> <u>2 16s</u>	5-19-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	5-19-05	Ac
	J) ASSEMBLE STOCK		5-17-05	RR
	K) ASSEMBLE SWIVEL STUDS		5-19-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		5-17-05	RR
	M) IRON SIGHT ALIGNMENT		5-17-05	RR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		5-17-05	RR
640	GALLERY TEST AND TARGET	PASS FAIL	5-18-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-18-05	Ac
655	FINAL INSPECTION A) HEADSPACE		5-19-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.87</u> <u>2.88</u> <u>2.68</u> <u>2.81</u> <u>2.80</u>	5-19-05	Ac
	C) FUNCTION		5-19-05	Ac
660	PACK		5/23/04	WA

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

5-16-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.10	2.46		2.10	
PULL #2	2.05	2.40		2.18	
PULL #3	2.22	2.24		2.32	
PULL #4	2.11	2.41		2.30	
PULL #5	2.32	2.27		2.62	
TOTAL	10.80	11.78		11.52	
AVERAGE	2.16	2.35		2.30	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.24		
PULL #2	3.07	3.10		
PULL #3	3.17	3.07		
PULL #4	3.13	3.22		
PULL #5	3.17	3.30		
TOTAL	15.64	15.93		
AVERAGE	3.12	3.18		

	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	4.45	4.20		4.43
PULL #2	4.48	4.31		4.39
PULL #3	4.48	4.08		4.42
PULL #4	4.36	4.31		4.40
PULL #5	4.43	4.21		4.33
TOTAL	22.20	21.11		21.97
AVERAGE	4.44	4.22		4.39

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461775.__0
FILE DATE AND TIME: 05/18/2005 10:10

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.181
The Average Y Centroid of the Five Target Set:	-0.097
The Average Point of Impact of the Five Target Set:	0.205
The Average Mean Radius of the Five Target Set:	0.697
The Distance from POA to Centroid Target #1:	0.109
The Distance from Centroid Target #2 to Centroid Target #1:	0.363
The Distance from Centroid Target #3 to Centroid Target #1:	0.348
The Distance from Centroid Target #4 to Centroid Target #1:	0.199
The Distance from Centroid Target #5 to Centroid Target #1:	0.209

SERIAL NUMBER: G6461775. __0

TARGET NUMBER: 1

FILE DATE: 05/18/2005

FILE TIME: 10:10

POINT#	X	Y
1:	-0.659	0.434
2:	-0.417	0.521
3:	-0.263	0.318
4:	-0.097	0.360
5:	0.221	-0.294
6:	0.298	0.217
7:	0.778	0.307
8:	1.049	0.293
9:	0.039	-1.657
10:	-0.286	0.361

X CENTROID: 0.066

Y CENTROID: 0.086

POA TO CENTROID: 0.109

HORZ SPREAD: 1.708

VERT SPREAD: 2.178

GROUP SPREAD: 2.225

MIN RADIUS: 0.266

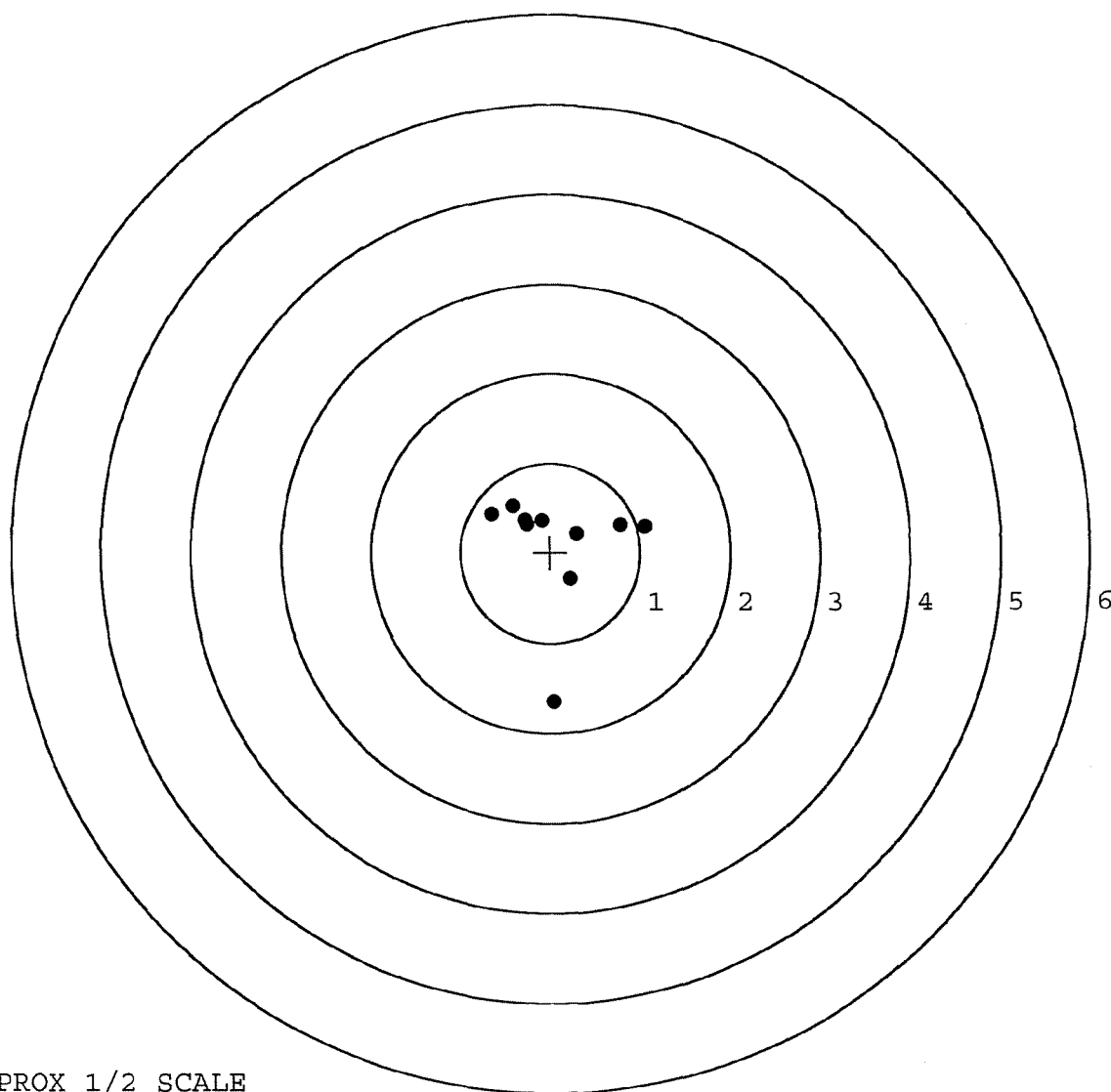
MAX RADIUS: 1.743

MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461775. __0

TARGET NUMBER: 2

FILE DATE: 05/18/2005

FILE TIME: 10:10

POINT#	X	Y
1:	-0.030	0.658
2:	-0.443	0.570
3:	-0.894	0.167
4:	-0.158	-0.336
5:	0.408	0.038
6:	0.835	0.015
7:	0.926	-0.399
8:	1.031	-0.720
9:	1.142	-0.785
10:	0.225	-1.092

X CENTROID: 0.304

Y CENTROID: -0.188

POA TO CENTROID: 0.358

HORZ SPREAD: 2.036

VERT SPREAD: 1.750

GROUP SPREAD: 2.248

MIN RADIUS: 0.249

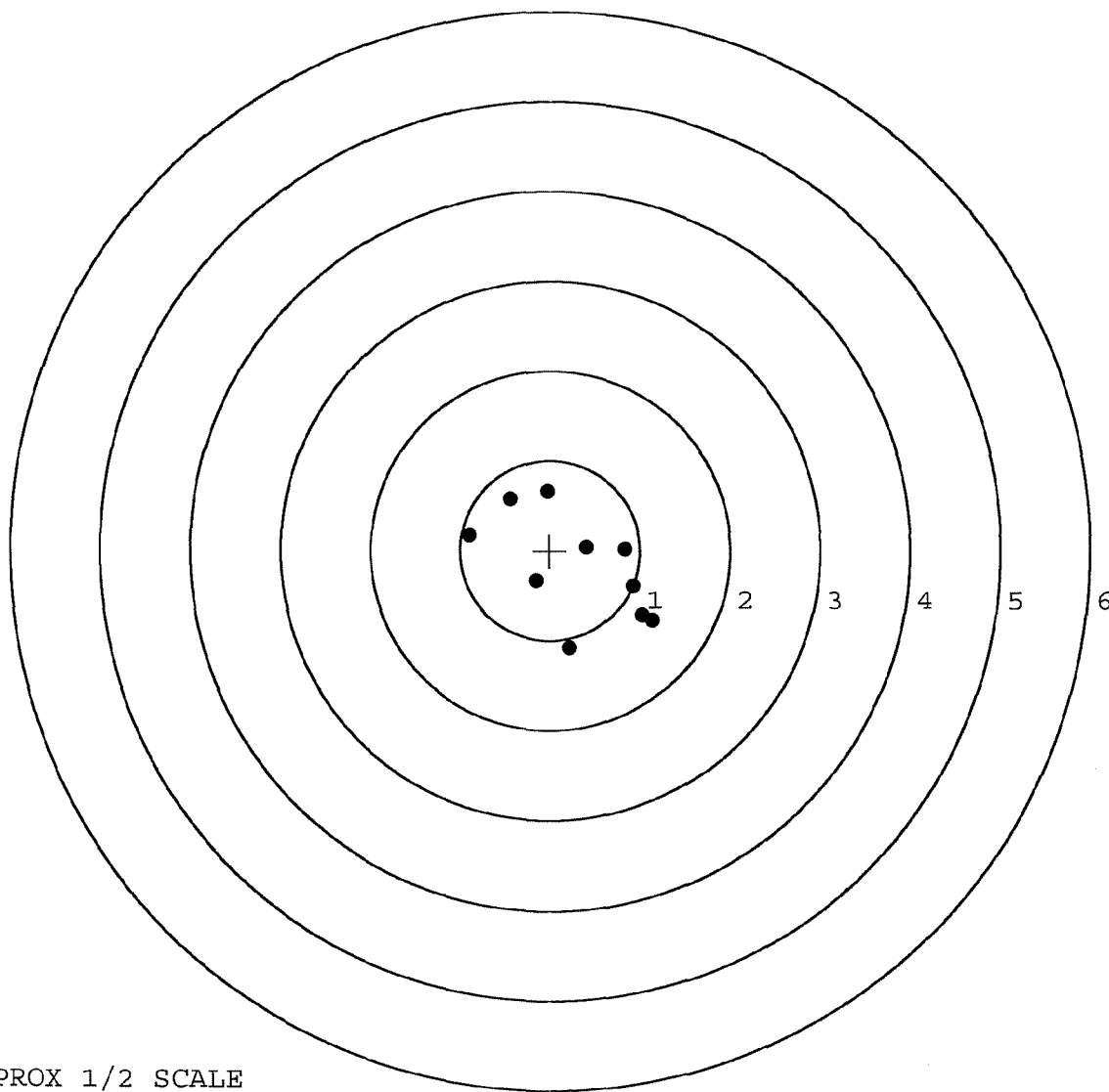
MAX RADIUS: 1.250

MEAN RADIUS: 0.802

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461775. __0

TARGET NUMBER: 3

FILE DATE: 05/18/2005

FILE TIME: 10:10

X CENTROID: 0.290

Y CENTROID: -0.181

POA TO CENTROID: 0.342

HORZ SPREAD: 2.304

VERT SPREAD: 1.304

GROUP SPREAD: 2.580

MIN RADIUS: 0.194

MAX RADIUS: 1.385

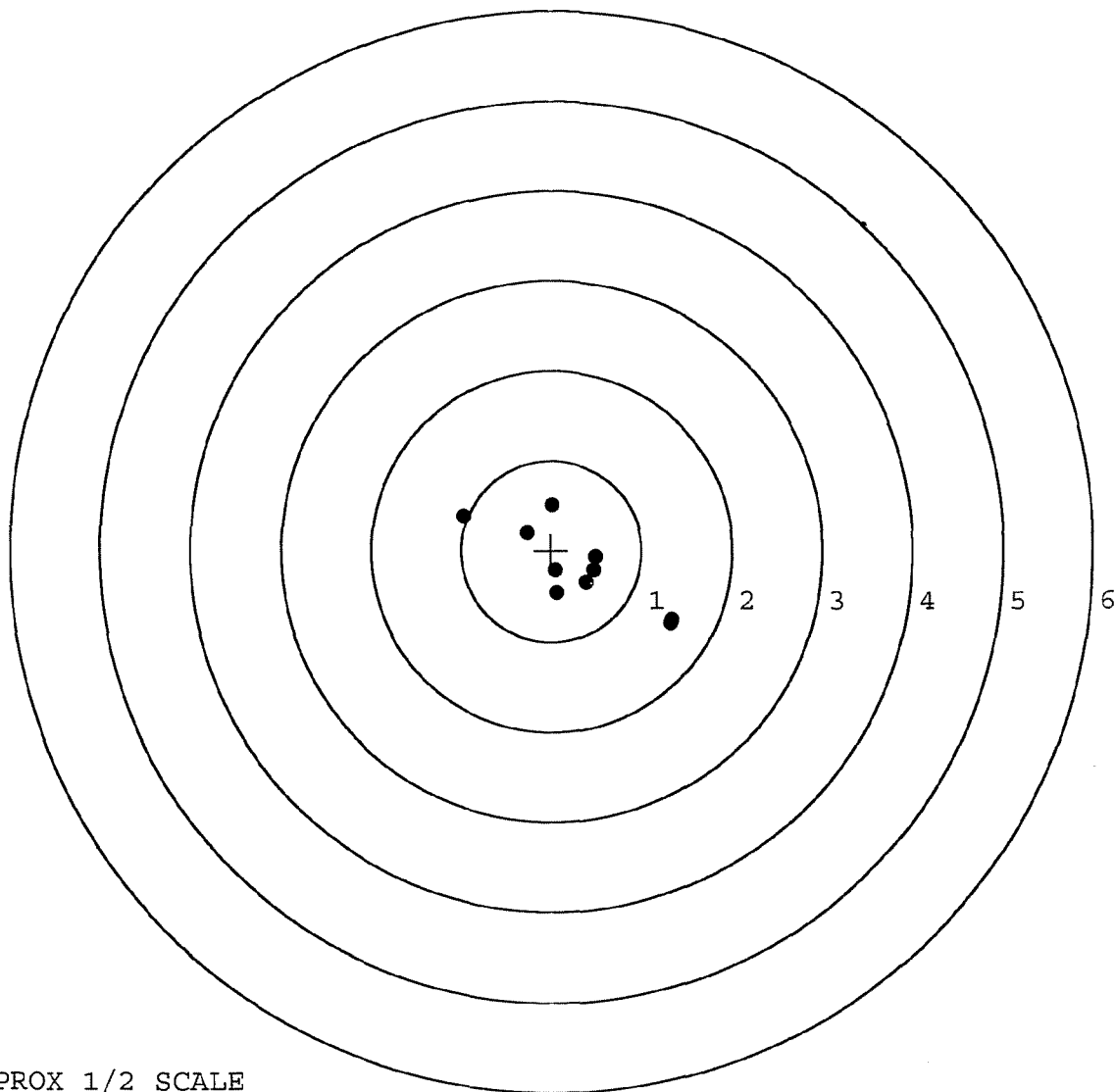
MEAN RADIUS: 0.641

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.011	0.504
2:	-0.264	0.196
3:	-0.977	0.379
4:	0.053	-0.222
5:	0.065	-0.473
6:	0.389	-0.348
7:	0.480	-0.218
8:	0.495	-0.070
9:	1.327	-0.761
10:	1.318	-0.800



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461775. __0

TARGET NUMBER: 4

FILE DATE: 05/18/2005

FILE TIME: 10:10

POINT#	X	Y
1:	0.430	0.411
2:	0.331	0.361
3:	-0.021	0.112
4:	0.202	0.000
5:	-0.516	0.023
6:	-0.521	0.482
7:	-0.082	-0.210
8:	0.009	-0.556
9:	0.399	-0.467
10:	1.550	-0.941

X CENTROID: 0.178

Y CENTROID: -0.079

POA TO CENTROID: 0.195

HORZ SPREAD: 2.071

VERT SPREAD: 1.423

GROUP SPREAD: 2.513

MIN RADIUS: 0.082

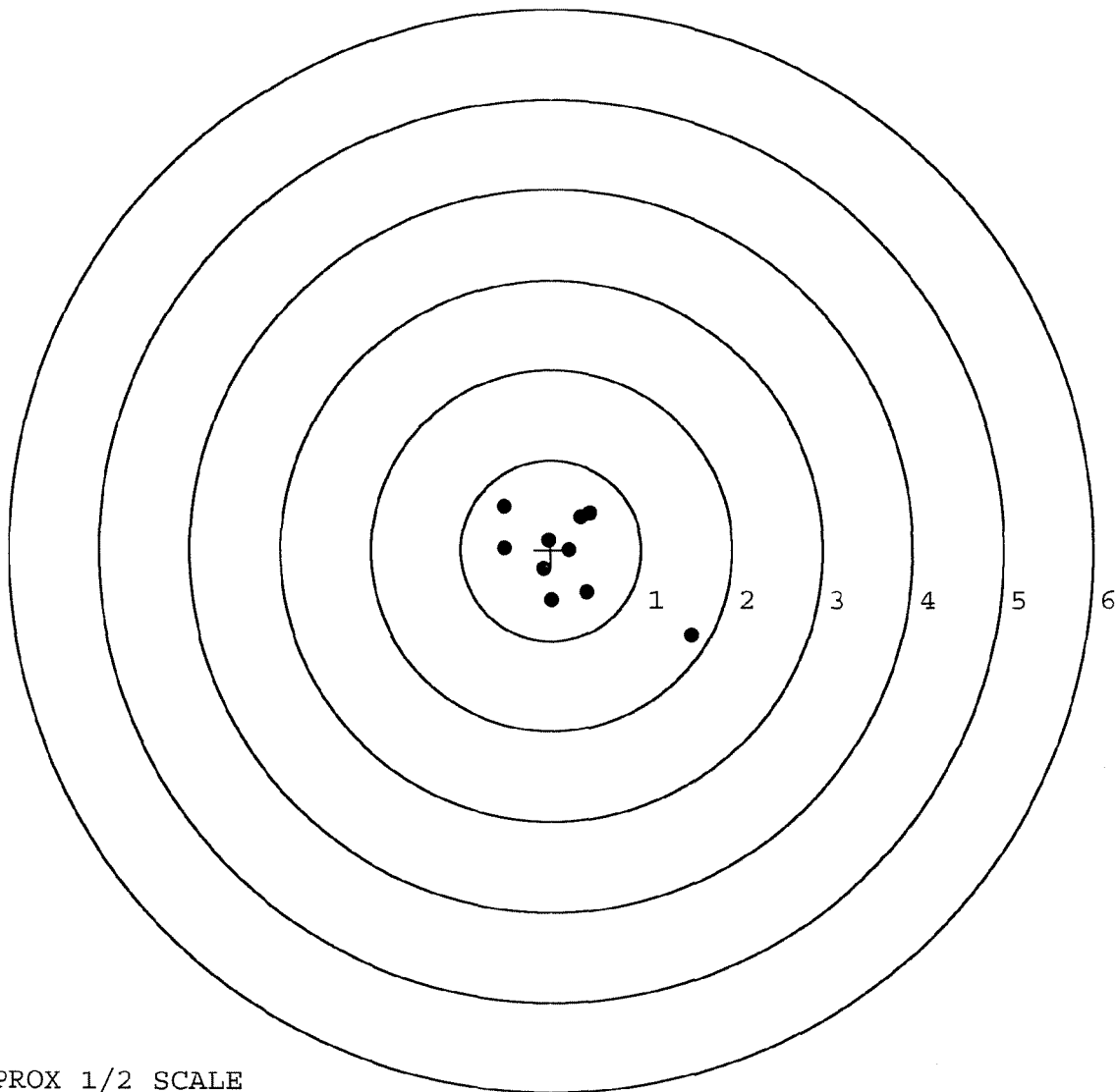
MAX RADIUS: 1.620

MEAN RADIUS: 0.584

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461775. __0

TARGET NUMBER: 5

FILE DATE: 05/18/2005

FILE TIME: 10:10

POINT#	X	Y
1:	1.342	0.214
2:	0.573	0.871
3:	0.657	0.401
4:	0.414	-0.022
5:	0.027	-0.668
6:	-0.066	-0.473
7:	-0.105	-0.386
8:	-0.647	-1.130
9:	-1.202	-0.173
10:	-0.326	0.139

X CENTROID: 0.067

Y CENTROID: -0.123

POA TO CENTROID: 0.140

HORZ SPREAD: 2.544

VERT SPREAD: 2.001

GROUP SPREAD: 2.573

MIN RADIUS: 0.314

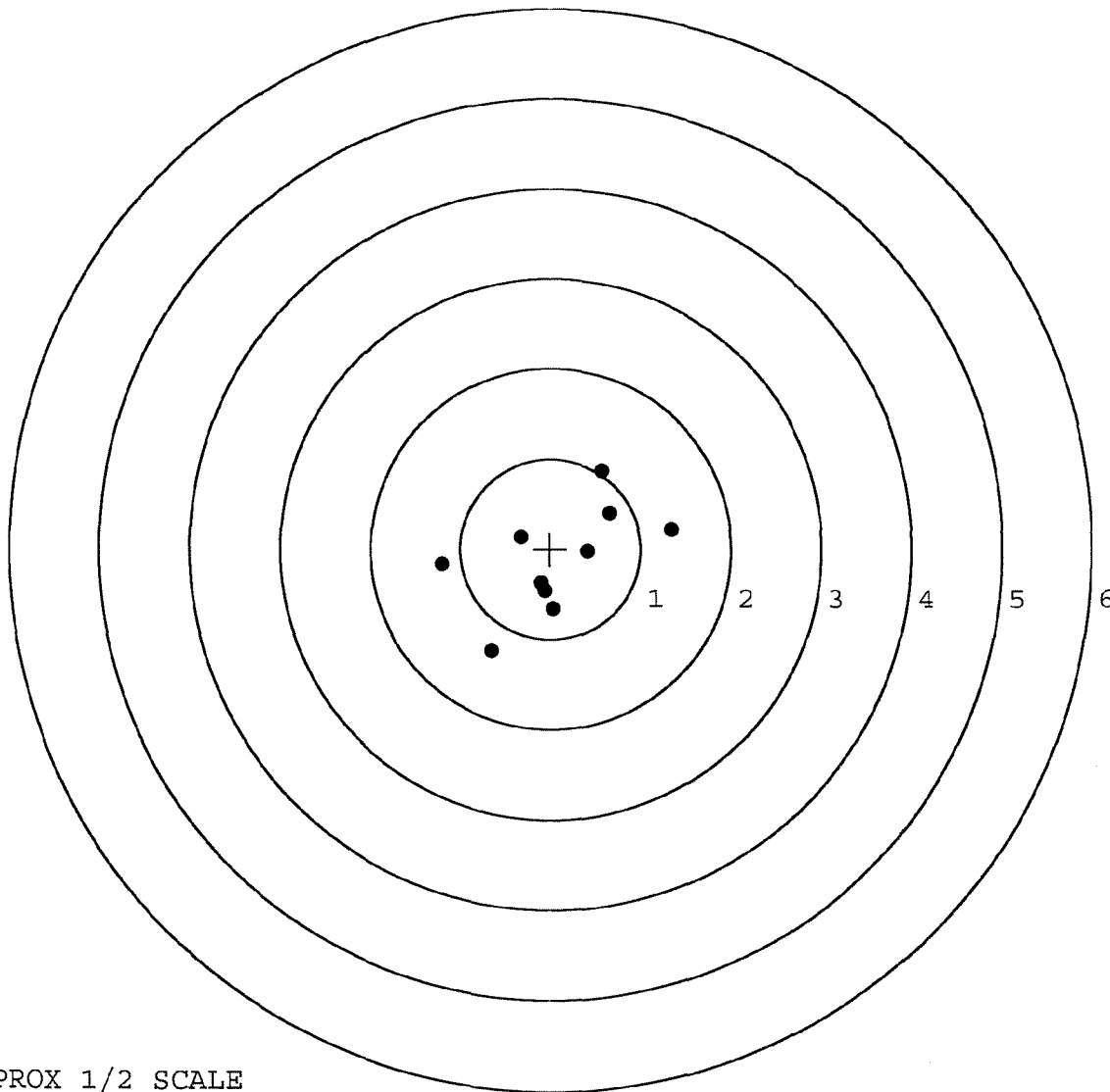
MAX RADIUS: 1.319

MEAN RADIUS: 0.780

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE