

G6461780

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



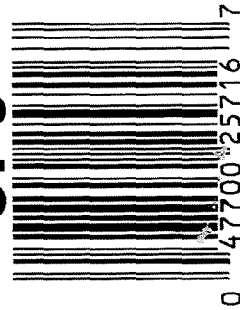
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461780

UPC



8/11/2005 9:22:37 AM

Original

98

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

78ROT01

Goff Blast Barrel & Rec Assembly.



0004110512

0540

01PC001

Flat Black Powder Coat, Barrel and



0004110502

0560

89SWS1

Reassemble Action.



0004110503

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461780

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	INSPECTED	9-13-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 SEF 200 INSPECTOR <i>am8</i>	9-14-05	<i>uncl</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	HP
	(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		9-29-05	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>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	10-5-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	10-5-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	10-5-05	AC
	J) ASSEMBLE STOCK		9-29-05	RT
	K) ASSEMBLE SWIVEL STUDS		10-5-05	10-5-05
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		9-29-05	RT
	M) IRON SIGHT ALIGNMENT		9-29-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		9-29-05	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL PASS FAIL	10-3-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-3-05	AC
670	FINAL INSPECTION A) HEADSPACE		10-5-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.75</u> <u>2.56</u> <u>2.56</u> <u>2.41</u> <u>2.57</u>	10-5-05	BG
	C) FUNCTION		10-5-05	AC
690	PACK		10-7-05	RA

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

TESTER

9/20/05

BC

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.55	2.84		2.57	
PULL #2	2.40	2.37		2.42	
PULL #3	2.49	2.67		2.53	
PULL #4	2.33	2.78		2.51	
PULL #5	2.55	2.85		2.39	
TOTAL	12.32	13.51		12.42	
AVERAGE	2.46	2.70		2.48	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	2.76		
PULL #2	3.20	2.95		
PULL #3	3.13	3.41		
PULL #4	3.01	3.37		
PULL #5	3.56	3.63		
TOTAL	16.36	16.12		
AVERAGE	3.27	3.22		

	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	4.01	4.24		4.12
PULL #2	4.33	4.19		4.30
PULL #3	4.41	4.27		4.32
PULL #4	4.46	3.51		4.15
PULL #5	4.42	4.01		3.82
TOTAL	21.63	20.22		20.71
AVERAGE	4.33	4.04		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461780.__0
FILE DATE AND TIME: 09/30/2005 16:02

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.014
The Average Y Centroid of the Five Target Set:	-0.055
The Average Point of Impact of the Five Target Set:	0.057
The Average Mean Radius of the Five Target Set:	0.807
The Distance from POA to Centroid Target #1:	0.357
The Distance from Centroid Target #2 to Centroid Target #1:	0.467
The Distance from Centroid Target #3 to Centroid Target #1:	0.560
The Distance from Centroid Target #4 to Centroid Target #1:	0.577
The Distance from Centroid Target #5 to Centroid Target #1:	0.528

SERIAL NUMBER: G6461780. __0

TARGET NUMBER: 1

FILE DATE: 09/30/2005

FILE TIME: 16:02

POINT#	X	Y
1:	0.153	-0.441
2:	0.270	-0.808
3:	-0.153	-0.904
4:	-0.536	0.021
5:	-0.221	0.756
6:	0.304	0.939
7:	0.277	0.581
8:	0.327	0.321
9:	1.255	0.608
10:	1.238	0.985

X CENTROID: 0.291

Y CENTROID: 0.206

POA TO CENTROID: 0.357

HORZ SPREAD: 1.791

VERT SPREAD: 1.889

GROUP SPREAD: 2.346

MIN RADIUS: 0.121

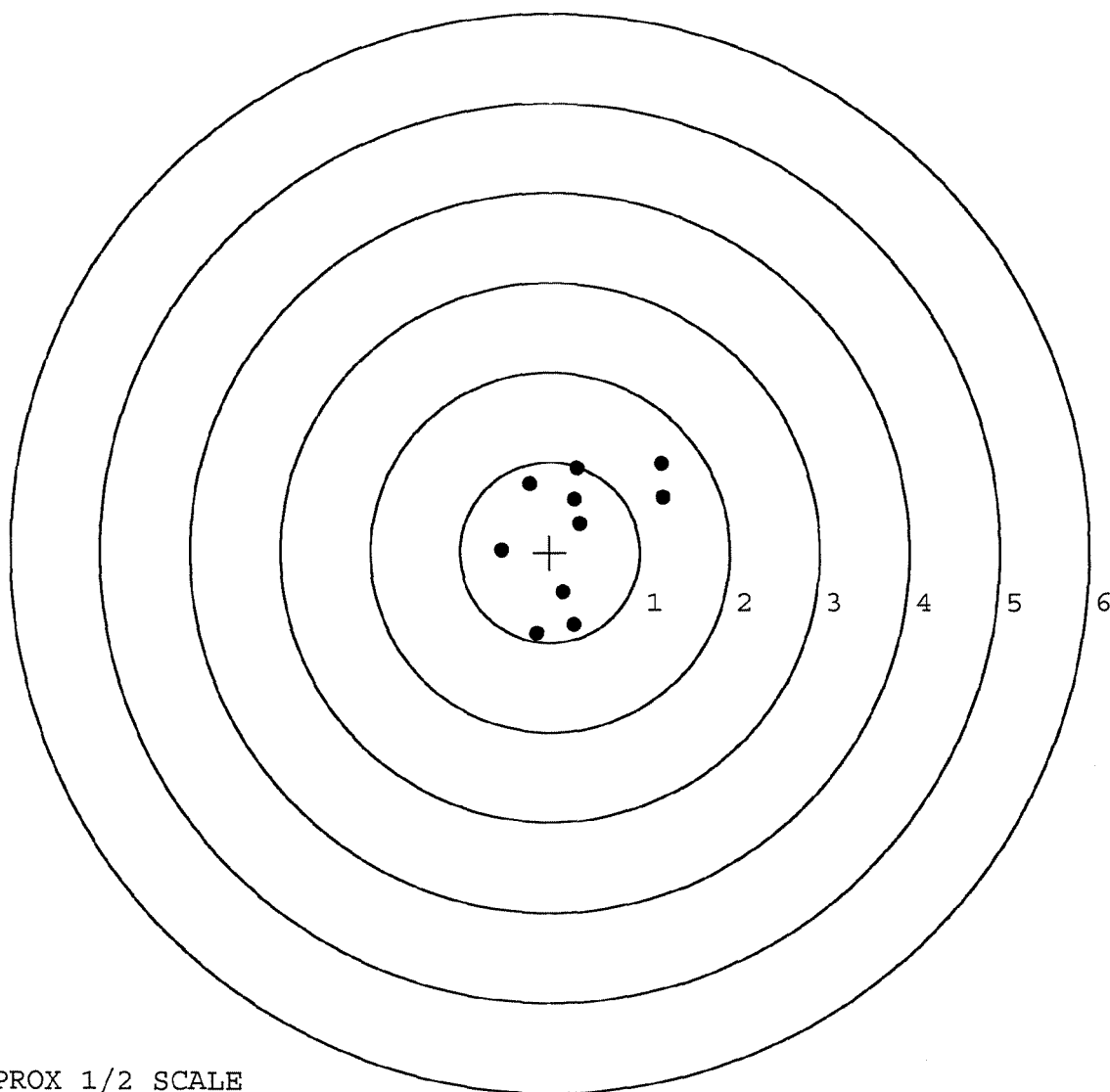
MAX RADIUS: 1.226

MEAN RADIUS: 0.797

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

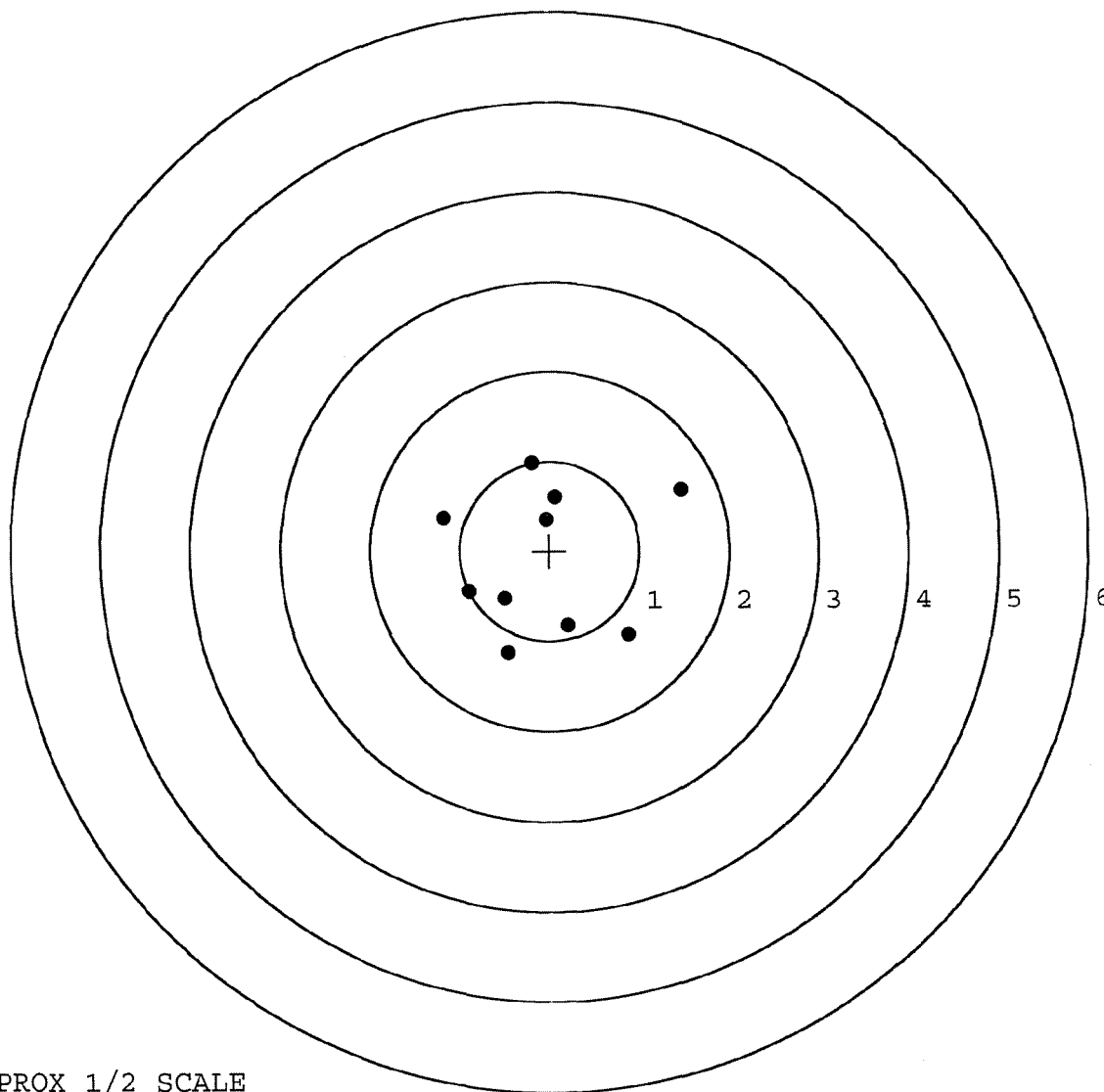


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461780. __0
TARGET NUMBER: 2
FILE DATE: 09/30/2005
FILE TIME: 16:02

X CENTROID: -0.069
Y CENTROID: -0.091
POA TO CENTROID: 0.114
HORZ SPREAD: 2.643
VERT SPREAD: 2.117
GROUP SPREAD: 2.661
MIN RADIUS: 0.441
MAX RADIUS: 1.712
MEAN RADIUS: 0.983
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.046	0.350
2:	0.061	0.603
3:	-0.197	0.982
4:	-1.181	0.370
5:	-0.894	-0.451
6:	-0.506	-0.528
7:	0.201	-0.835
8:	0.868	-0.936
9:	1.462	0.675
10:	-0.461	-1.135



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461780. __0

TARGET NUMBER: 3

FILE DATE: 09/30/2005

FILE TIME: 16:02

POINT#	X	Y
1:	0.126	-0.238
2:	-0.306	0.087
3:	-0.122	-0.624
4:	-0.260	-0.869
5:	-0.134	-1.378
6:	-0.627	-0.993
7:	0.986	-0.019
8:	0.154	0.935
9:	0.013	1.307
10:	-0.198	-0.682

X CENTROID: -0.037

Y CENTROID: -0.247

POA TO CENTROID: 0.250

HORZ SPREAD: 1.613

VERT SPREAD: 2.685

GROUP SPREAD: 2.689

MIN RADIUS: 0.163

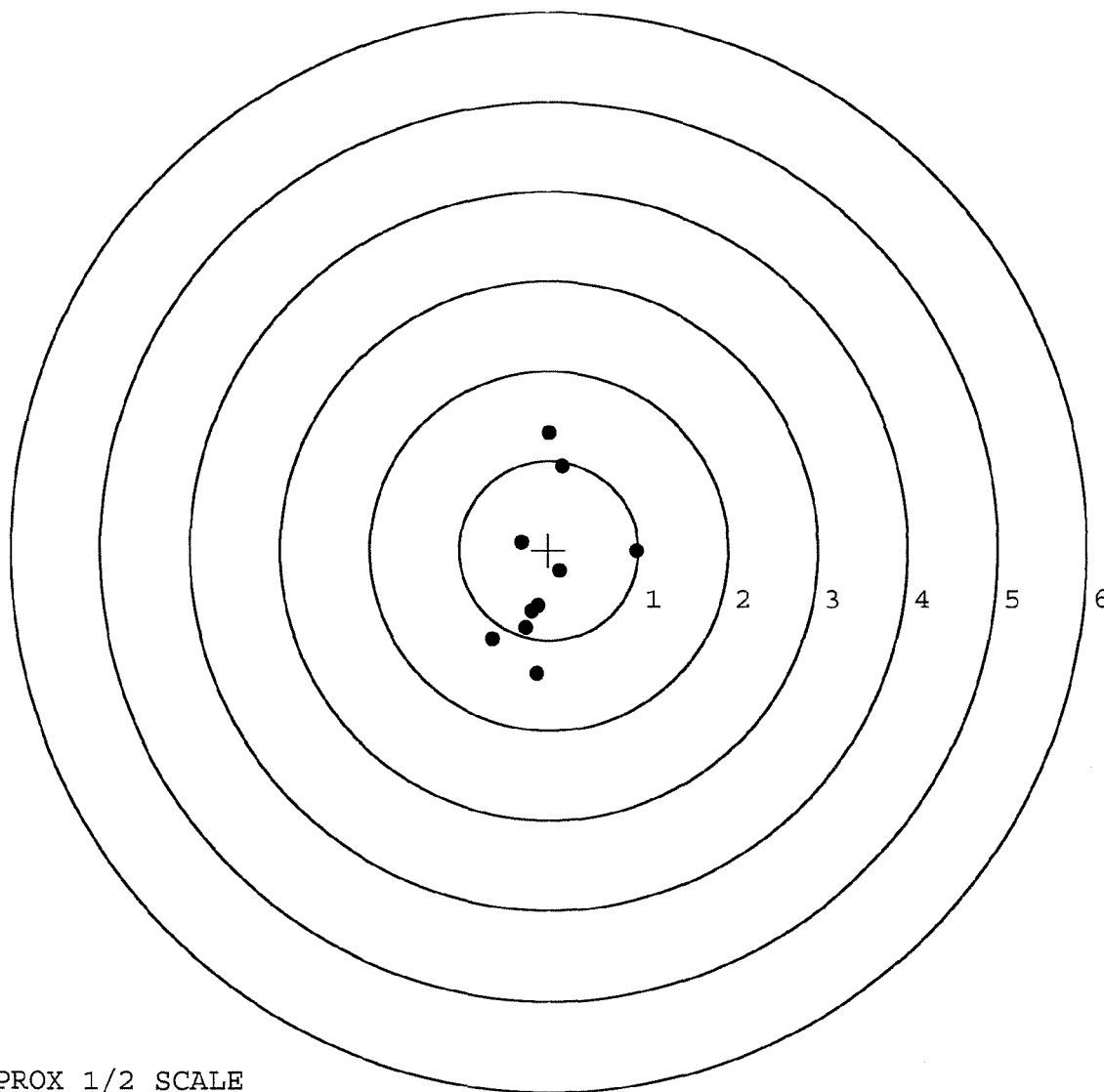
MAX RADIUS: 1.555

MEAN RADIUS: 0.799

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461780.___0

TARGET NUMBER: 4

FILE DATE: 09/30/2005

FILE TIME: 16:02

POINT#	X	Y
1:	-0.064	0.237
2:	-0.565	0.129
3:	-0.350	-0.258
4:	-0.058	-0.623
5:	0.011	-1.171
6:	-0.782	-0.398
7:	-1.051	-0.100
8:	-1.016	0.895
9:	0.837	0.889
10:	0.268	1.439

X CENTROID: -0.277

Y CENTROID: 0.104

POA TO CENTROID: 0.296

HORZ SPREAD: 1.888

VERT SPREAD: 2.610

GROUP SPREAD: 2.623

MIN RADIUS: 0.251

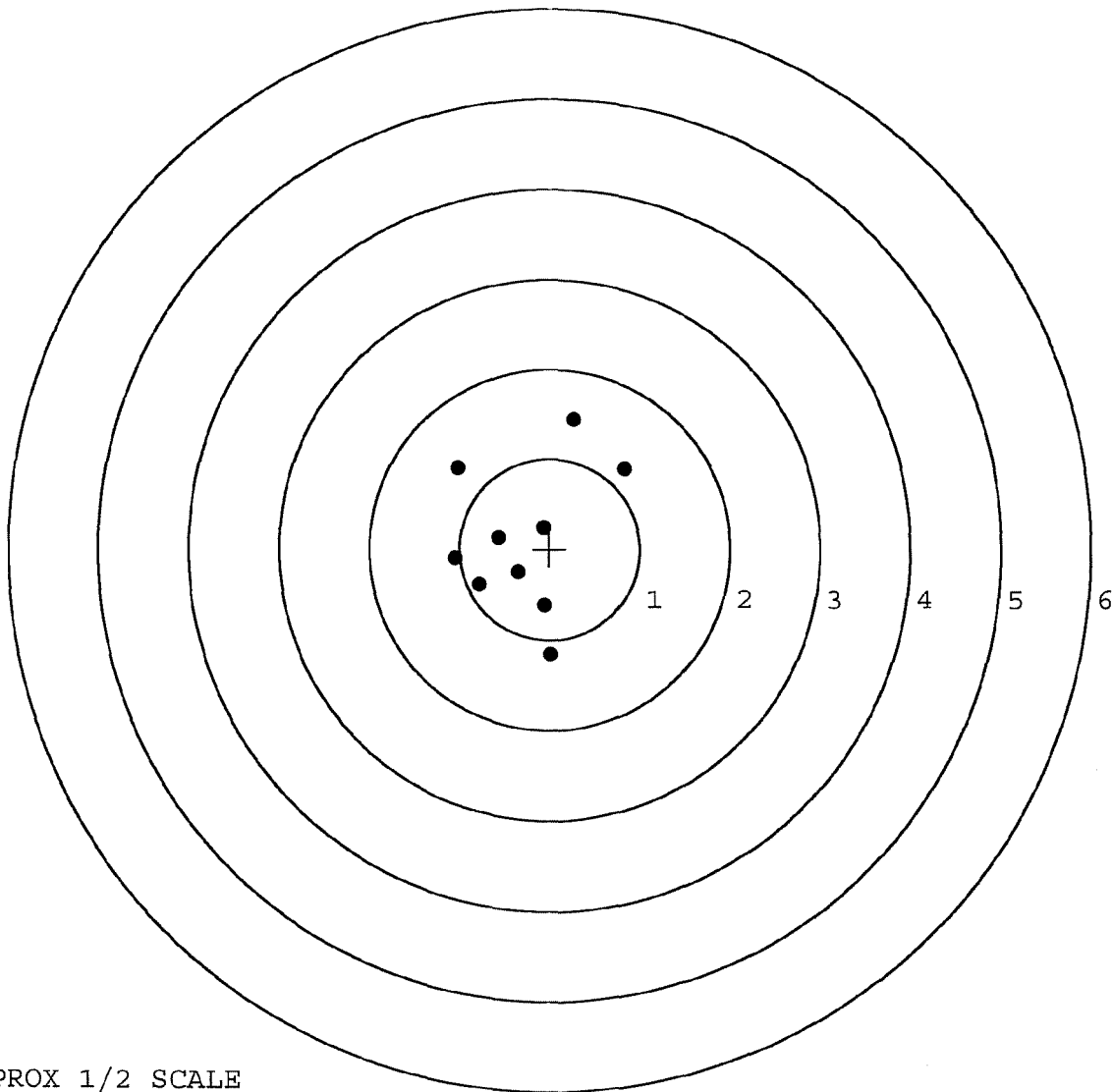
MAX RADIUS: 1.442

MEAN RADIUS: 0.838

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461780. __0

TARGET NUMBER: 5

FILE DATE: 09/30/2005

FILE TIME: 16:02

POINT#	X	Y
1:	0.009	-0.262
2:	0.246	-0.427
3:	0.522	0.048
4:	0.720	0.238
5:	-0.422	0.682
6:	-0.346	0.170
7:	-0.259	-0.148
8:	-0.432	-0.482
9:	-0.353	-0.946
10:	0.552	-1.364

X CENTROID: 0.024

Y CENTROID: -0.249

POA TO CENTROID: 0.250

HORZ SPREAD: 1.152

VERT SPREAD: 2.046

GROUP SPREAD: 2.266

MIN RADIUS: 0.020

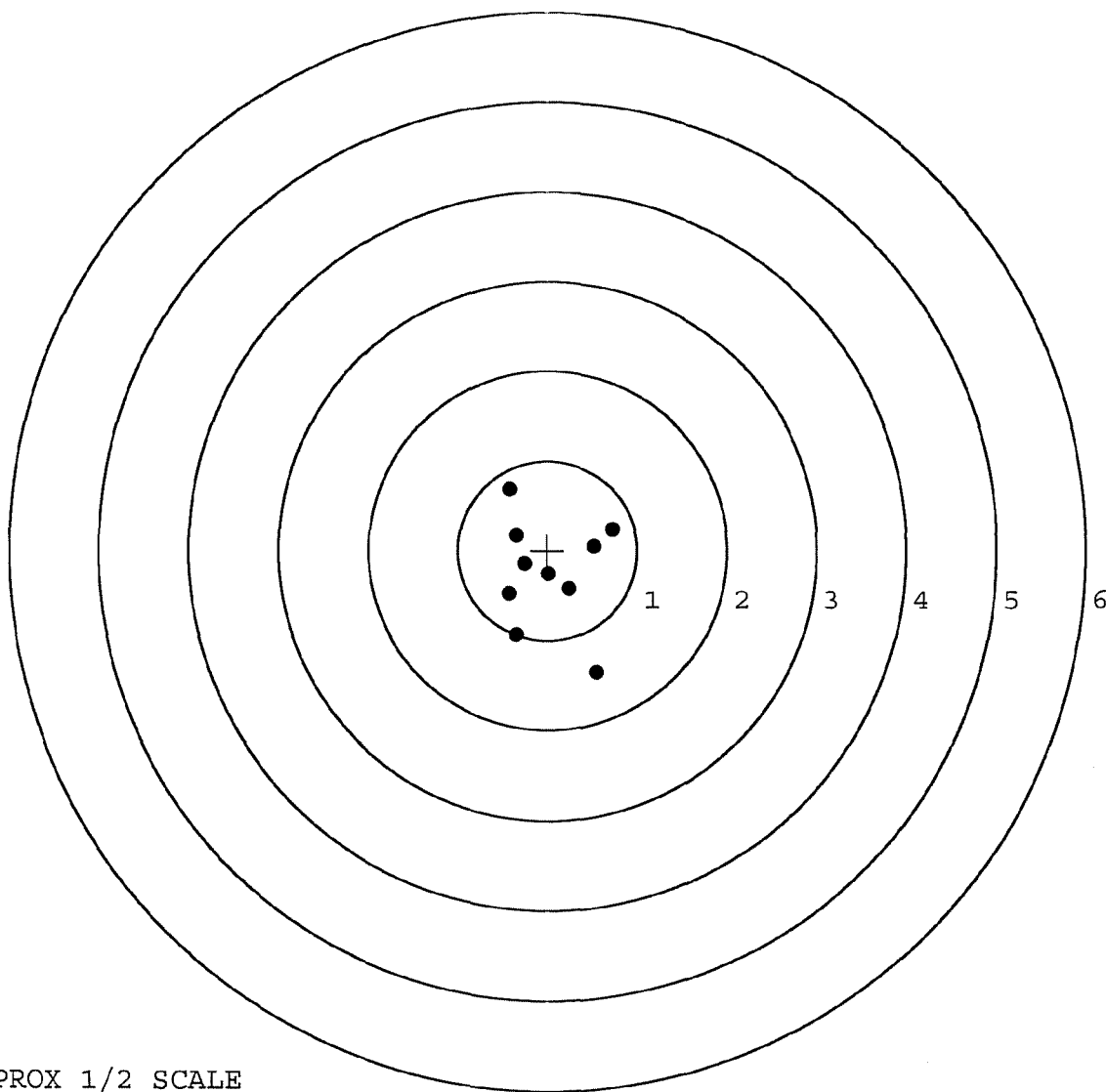
MAX RADIUS: 1.234

MEAN RADIUS: 0.616

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE