

G6461787

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

UPC



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M/24 7.62 NATO S.W.S. (COMPLETE SYSTE

UPC



SERIAL NO.

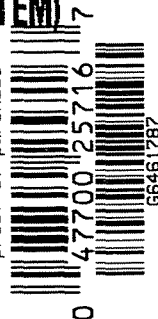


M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM

proof of purchase



owner registration sticker



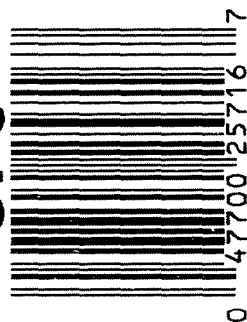
ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461787

UPC



Original
22
4/7/2005 2:48:09 PM
Crib

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 1787

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	APR 18 2005	4-18-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</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	WJ
	(BOLT)		5-11-05	RTZ
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>7 lbs</u> <u>7 lbs</u> <u>7 lbs</u>	5-31-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	5-31-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		5-23-05	Ac
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	5-31-05	Ac
	J) ASSEMBLE STOCK		5-11-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		5-31-05	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	5-12-05	Ac
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		5-12-05	Ac
655	FINAL INSPECTION A) HEADSPACE		5-31-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.26</u> <u>2.44</u> <u>2.36</u> <u>2.44</u> <u>2.40</u>	5-23-05	Ac
	C) FUNCTION		5-31-05	Ac
660	PACK		6-1-05	RTZ

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 5-3-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.29	2.72		2.54	
PULL #2	2.36	2.73		2.18	
PULL #3	2.49	2.72		2.54	
PULL #4	2.39	2.45		2.48	
PULL #5	2.65	2.32		2.55	
TOTAL	12.18	12.94		12.29	
AVERAGE	2.43	2.58		2.45	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.04		
PULL #2	3.14	3.15		
PULL #3	3.17	3.20		
PULL #4	3.17	3.21		
PULL #5	3.20	3.30		
TOTAL	15.78	15.90		
AVERAGE	3.15	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	4.11	4.13		4.29
PULL #2	4.16	4.22		4.08
PULL #3	4.21	4.36		4.19
PULL #4	4.20	4.25		4.07
PULL #5	4.31	4.34		4.14
TOTAL	20.99	21.30		20.77
AVERAGE	4.19	4.26		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461787.___0
FILE DATE AND TIME: 05/12/2005 07:54

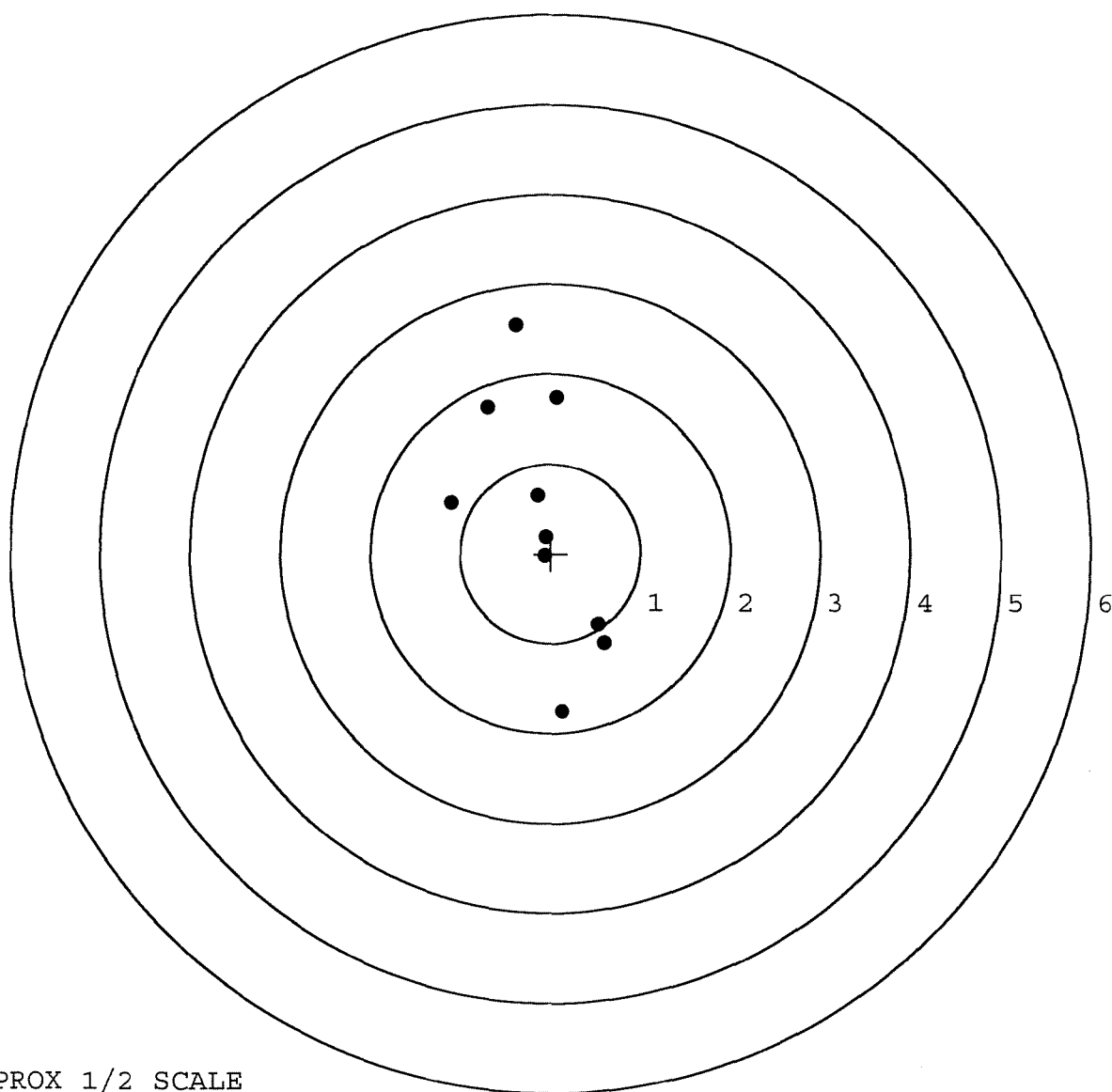
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.009
The Average Y Centroid of the Five Target Set:	0.061
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.952
The Distance from POA to Centroid Target #1:	0.387
The Distance from Centroid Target #2 to Centroid Target #1:	0.610
The Distance from Centroid Target #3 to Centroid Target #1:	0.280
The Distance from Centroid Target #4 to Centroid Target #1:	0.663
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: G6461787. __0
TARGET NUMBER: 1
FILE DATE: 05/12/2005
FILE TIME: 07:54

X CENTROID: -0.110
Y CENTROID: 0.372
POA TO CENTROID: 0.387
HORZ SPREAD: 1.708
VERT SPREAD: 4.303
GROUP SPREAD: 4.335
MIN RADIUS: 0.189
MAX RADIUS: 2.184
MEAN RADIUS: 1.185
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.140	-1.764
2:	0.602	-1.002
3:	0.540	-0.795
4:	-0.071	-0.023
5:	-0.057	0.190
6:	-0.141	0.641
7:	-1.106	0.566
8:	-0.699	1.628
9:	0.073	1.735
10:	-0.382	2.539

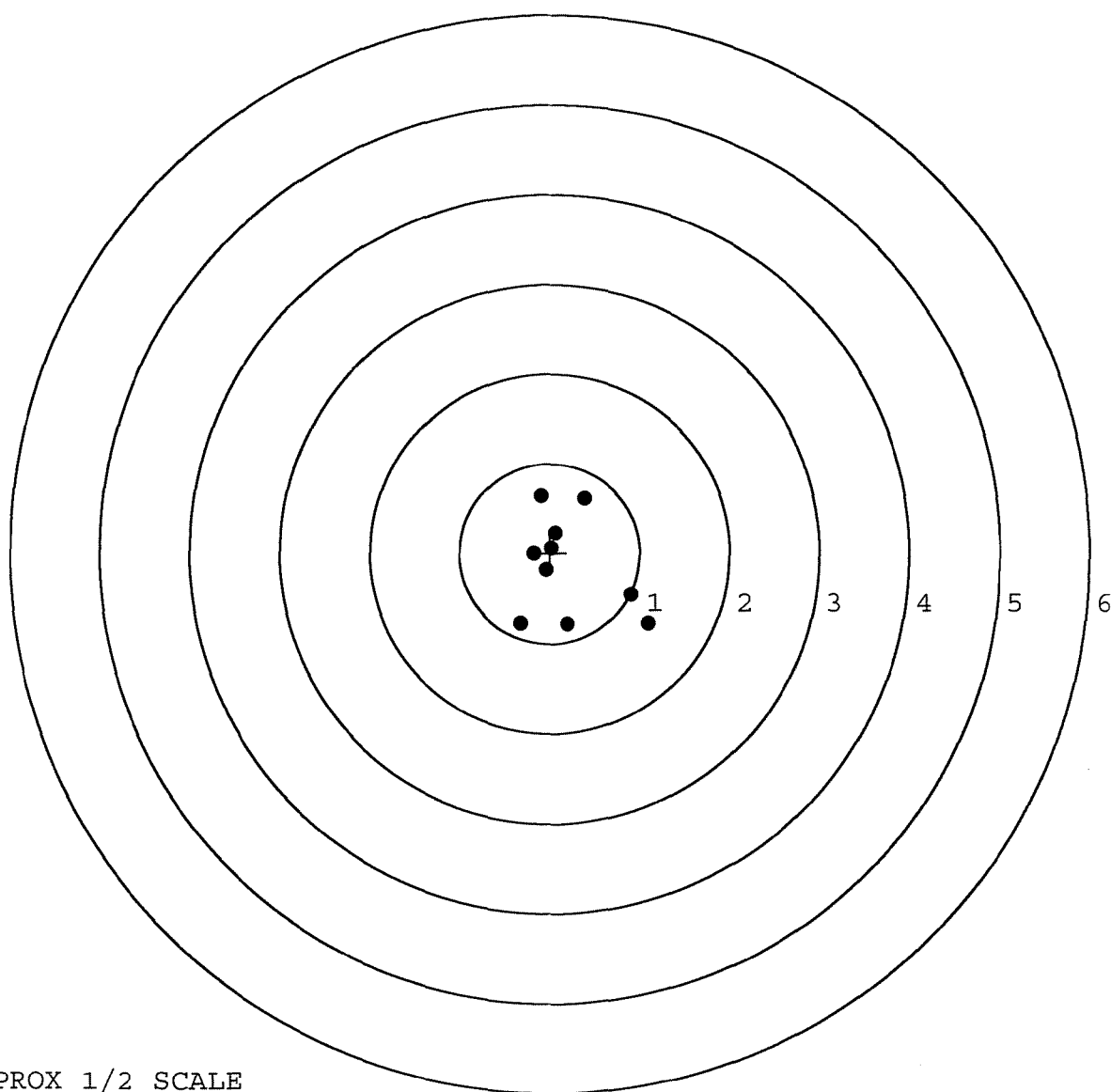


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461787. 0
TARGET NUMBER: 2
FILE DATE: 05/12/2005
FILE TIME: 07:54

X CENTROID: 0.204
Y CENTROID: -0.151
POA TO CENTROID: 0.254
HORZ SPREAD: 1.423
VERT SPREAD: 1.432
GROUP SPREAD: 1.860
MIN RADIUS: 0.257
MAX RADIUS: 1.098
MEAN RADIUS: 0.629
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.099	-0.786
2:	0.905	-0.460
3:	0.202	-0.793
4:	-0.324	-0.784
5:	0.397	0.611
6:	-0.096	0.639
7:	0.066	0.216
8:	-0.181	-0.013
9:	-0.050	-0.192
10:	0.017	0.049



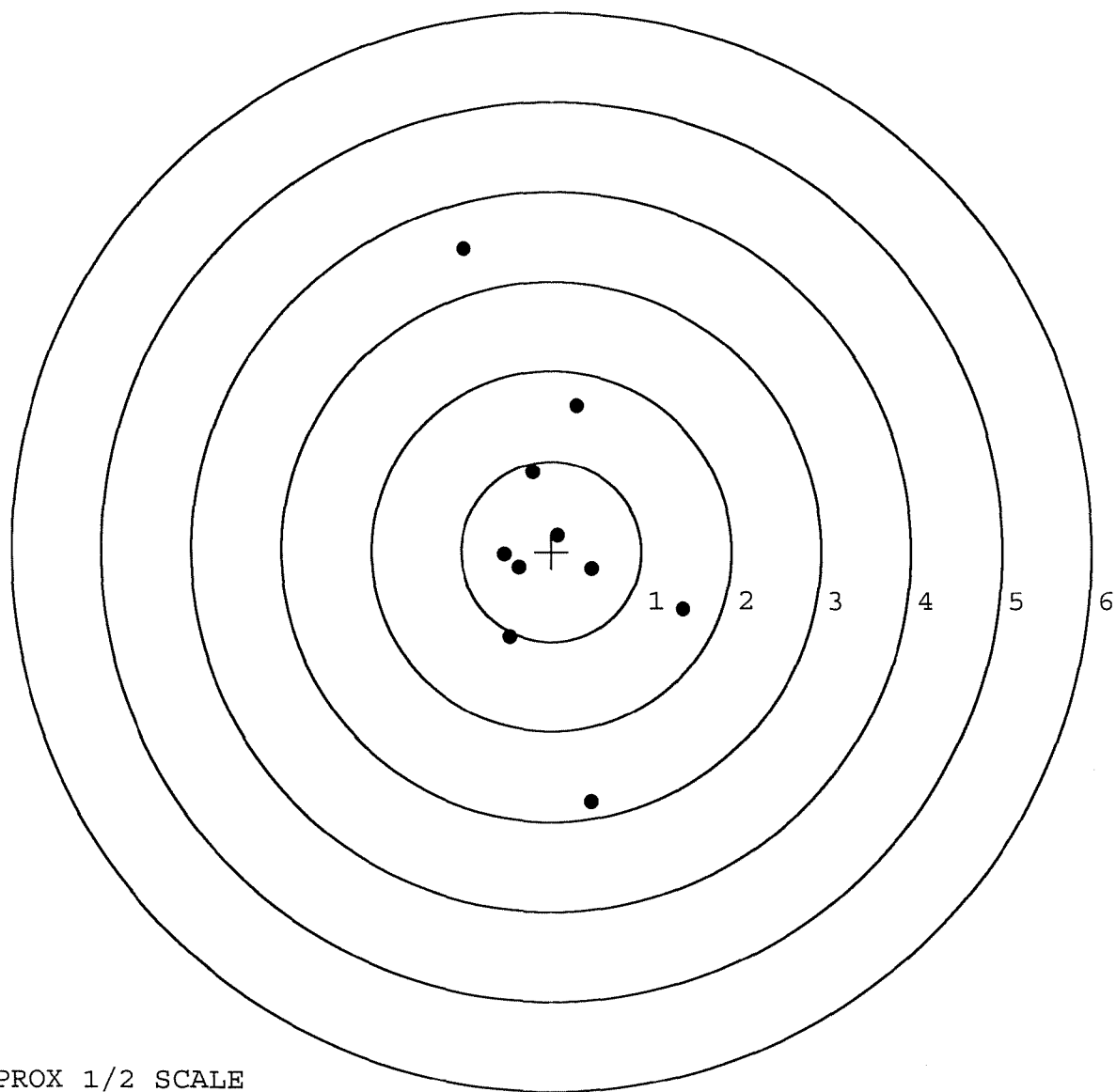
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461787. __0
TARGET NUMBER: 3
FILE DATE: 05/12/2005
FILE TIME: 07:54

X CENTROID: 0.019
Y CENTROID: 0.123
POA TO CENTROID: 0.124
HORZ SPREAD: 2.444
VERT SPREAD: 6.157
GROUP SPREAD: 6.321
MIN RADIUS: 0.080
MAX RADIUS: 3.393
MEAN RADIUS: 1.314

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	1.466	-0.646
2:	-0.462	-0.960
3:	0.452	-0.199
4:	-0.362	-0.183
5:	-0.521	-0.040
6:	0.070	0.185
7:	-0.211	0.884
8:	0.284	1.611
9:	-0.978	3.366
10:	0.453	-2.791



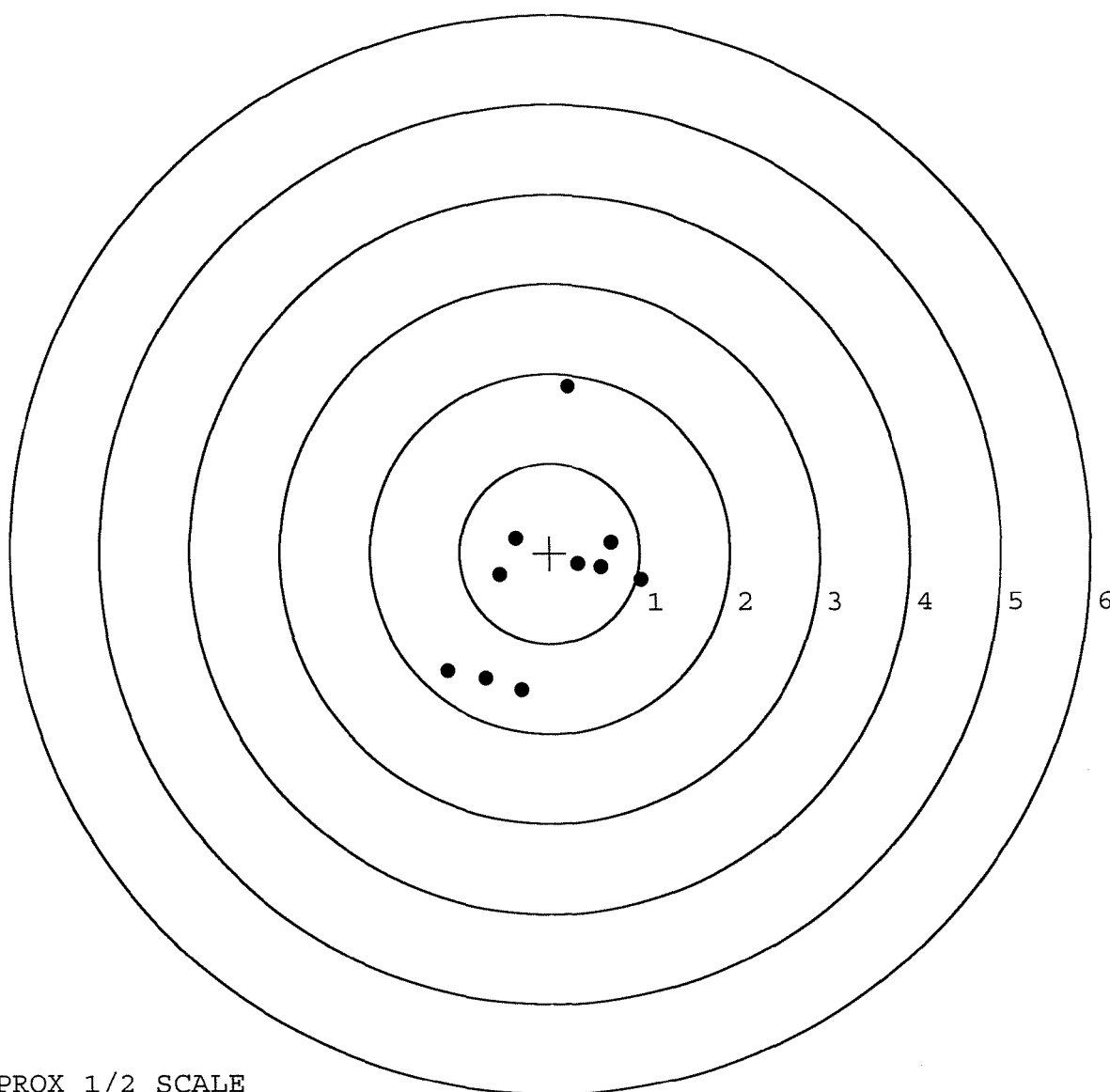
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461787. __0
TARGET NUMBER: 4
FILE DATE: 05/12/2005
FILE TIME: 07:54

X CENTROID: -0.033
Y CENTROID: -0.287
POA TO CENTROID: 0.289
HORZ SPREAD: 2.148
VERT SPREAD: 3.372
GROUP SPREAD: 3.434
MIN RADIUS: 0.392
MAX RADIUS: 2.157
MEAN RADIUS: 1.018

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.007	-0.301
2:	0.685	0.118
3:	0.567	-0.157
4:	0.318	-0.114
5:	-0.376	0.163
6:	-0.557	-0.236
7:	-0.326	-1.516
8:	-0.717	-1.385
9:	-1.141	-1.302
10:	0.207	1.856



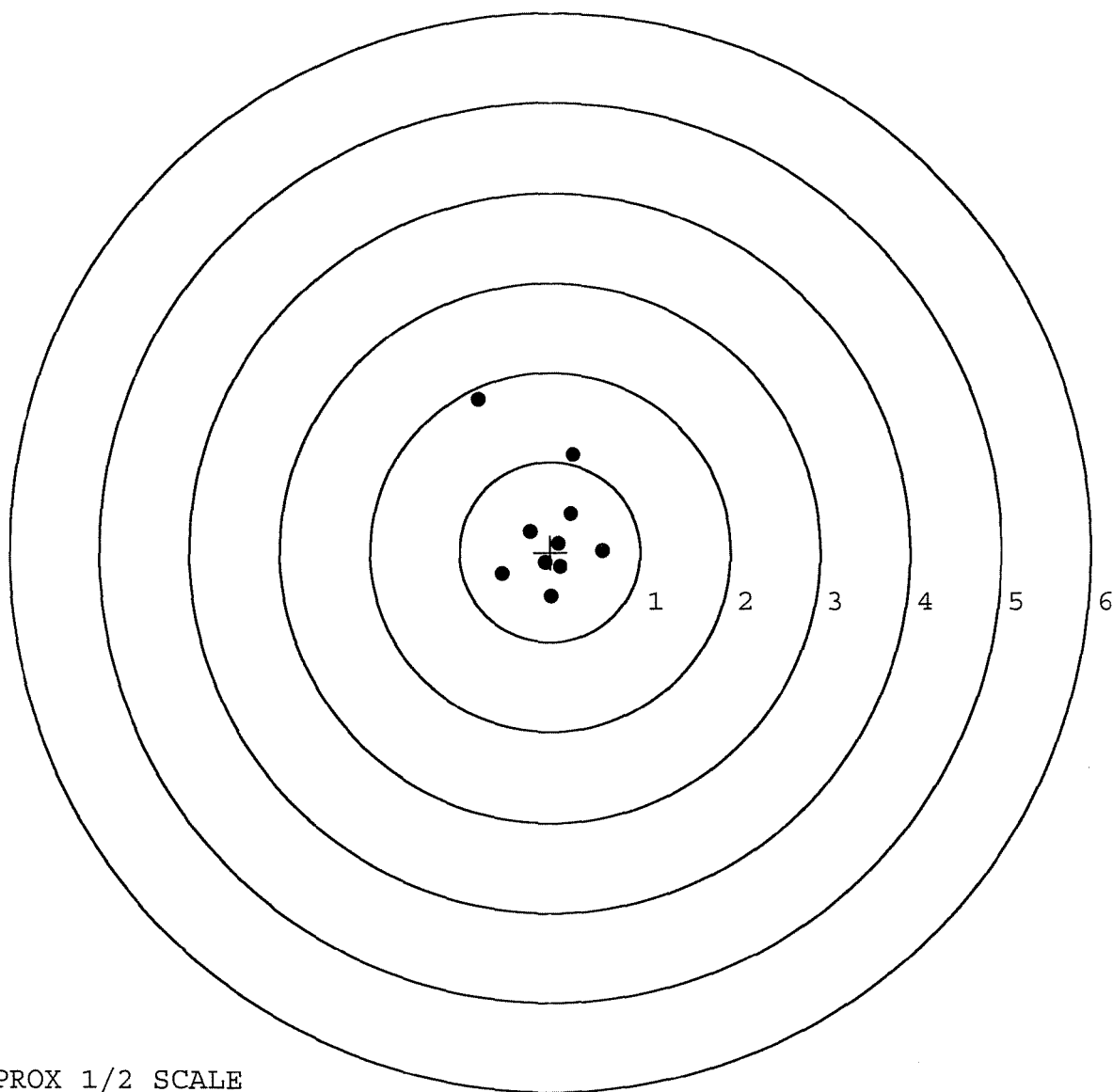
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461787. __0
TARGET NUMBER: 5
FILE DATE: 05/12/2005
FILE TIME: 07:54

X CENTROID: -0.033
Y CENTROID: 0.251
POA TO CENTROID: 0.254
HORZ SPREAD: 1.381
VERT SPREAD: 2.190
GROUP SPREAD: 2.335
MIN RADIUS: 0.192
MAX RADIUS: 1.634
MEAN RADIUS: 0.613

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.581	0.014
2:	0.227	0.422
3:	-0.223	0.222
4:	-0.527	-0.244
5:	0.010	-0.496
6:	0.256	1.083
7:	-0.800	1.694
8:	0.087	0.097
9:	0.117	-0.162
10:	-0.062	-0.117



TARGET APPROX 1/2 SCALE