

G 646 1797

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



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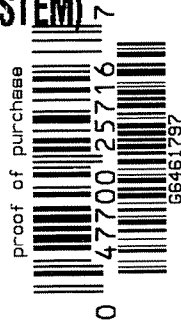
SERIAL NO.



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

- INSTRUCTION BOOK 3518

DD FORM

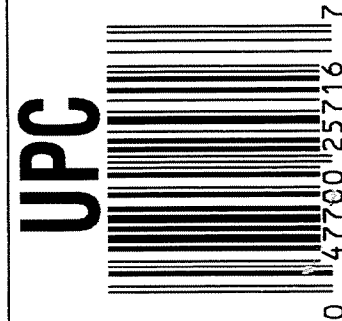


ORDER NO. 25716

BARREL LENGTH 24"

CAPACITY 6

G6461797



Original
Crib
20
6/17/2005 2:12:04 PM

25716

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



.MA25716

Shop Order: SW5716 - AUG



.ABSW5716 - AUG

Start Date: 6/17/2005

Finish Date: 8/26/2005

0520

78ROT01

Goff Blast Barrel & Rec Assembly,



0004012773

0540

01PC001

Flat Black Powder Coat, Barrel and



0004012763

0560

89SWS1

Reassemble Action.



0004012764

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6661797

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		8-11-05	RTZ
440	PROOF		8-12-05	AC
460	CHECK HEADSPACE		8-12-05	AC
470	DIS-ASSEMBLE ACTION		8-15-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		9-8-05	CW
510	DRILL AND TAP SIGHT HOLES		9-7-05	TRW
520	GOFF BLAST BBL / REC		9-9-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/17/05	WJ
	(BOLT)			
560	RE-ASSEMBLE ACTION A) CLEAN INSIDE OF BOLT ASSEMBLY		9/30	WJH
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	WJH
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	WJH
	D) OIL FIRING PIN ASSEMBLY		10-5-05	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>	10-11-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs</u> <u>4 lbs</u> <u>4 lbs</u>	10-11-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	10-11-05	Ac
	J) ASSEMBLE STOCK		10-5-05	RT
	K) ASSEMBLE SWIVEL STUDS		10-11-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-5-05	RT
	M) IRON SIGHT ALIGNMENT		10-5-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-5-05	RT
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> <u>FAIL</u> <u>PASS</u> <u>FAIL</u>	10/5/05	mgd
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-5-05	mtm
670	FINAL INSPECTION A) HEADSPACE		10-11-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.90</u> <u>2.78</u> <u>2.78</u> <u>2.86</u> <u>2.84</u>	10-7-05	BF
	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

TESTER

9-29-05

R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.48		2.58	
PULL #2	2.37	2.34		2.65	
PULL #3	2.32	2.29		2.52	
PULL #4	2.31	2.39		2.47	
PULL #5	2.42	2.42		2.47	
TOTAL	11.76	11.92		12.69	
AVERAGE	2.35	2.38		2.53	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	2.93		
PULL #2	3.14	3.08		
PULL #3	3.17	3.13		
PULL #4	3.14	3.15		
PULL #5	3.07	3.39		
TOTAL	15.62	15.68		
AVERAGE	3.12	3.13		

	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	4.55	4.49		4.58
PULL #2	4.31	4.40		4.32
PULL #3	4.46	4.04		4.53
PULL #4	4.18	4.47		4.36
PULL #5	4.10	4.16		4.66
TOTAL	21.60	21.56		22.45
AVERAGE	4.32	4.31		4.49

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461797.___0
FILE DATE AND TIME: 10/05/2005 18:56

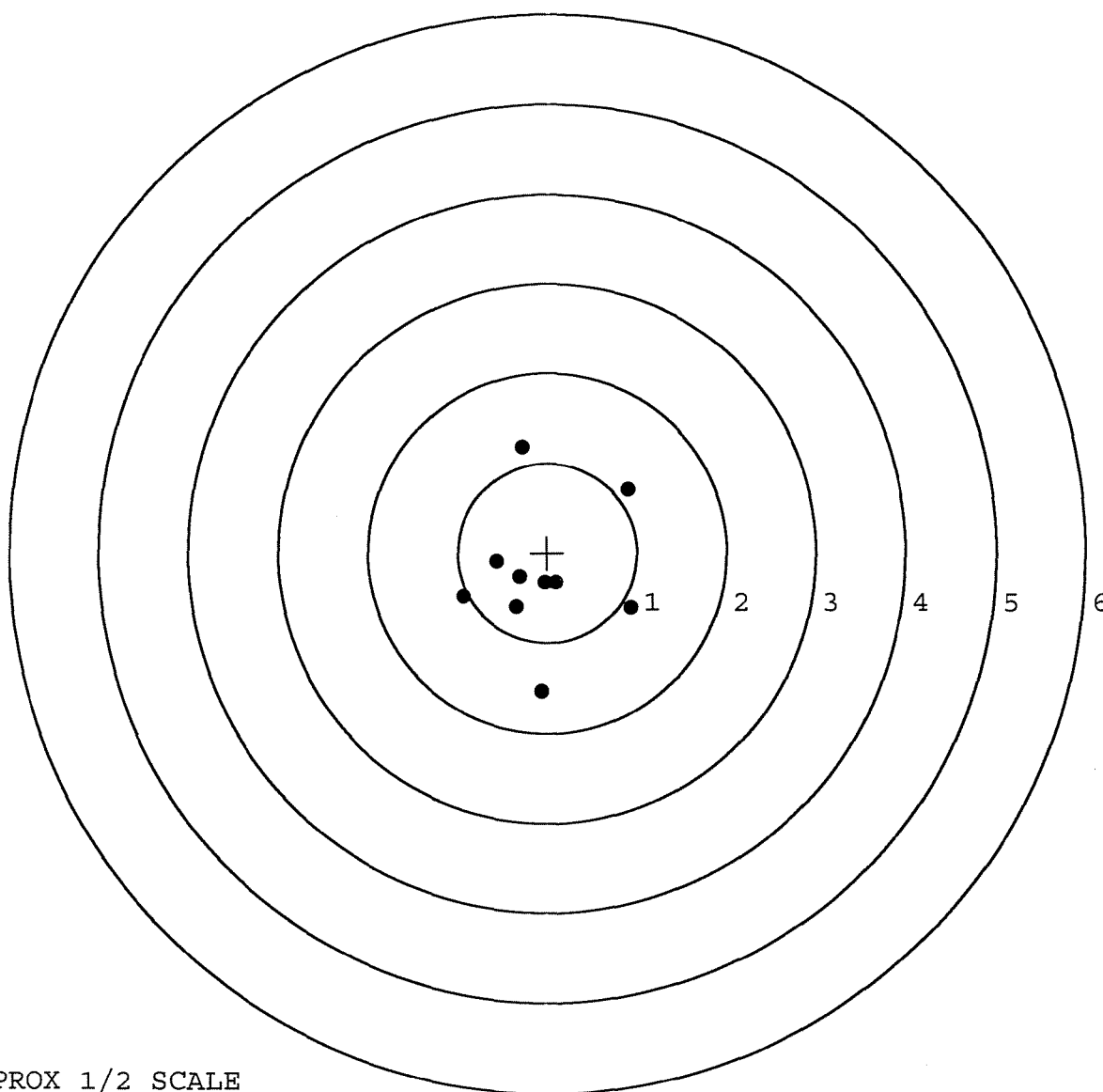
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.006
The Average Y Centroid of the Five Target Set:	0.089
The Average Point of Impact of the Five Target Set:	0.090
The Average Mean Radius of the Five Target Set:	0.948
The Distance from POA to Centroid Target #1:	0.249
The Distance from Centroid Target #2 to Centroid Target #1:	0.715
The Distance from Centroid Target #3 to Centroid Target #1:	0.646
The Distance from Centroid Target #4 to Centroid Target #1:	0.257
The Distance from Centroid Target #5 to Centroid Target #1:	0.301

SERIAL NUMBER: G6461797. __0
TARGET NUMBER: 1
FILE DATE: 10/05/2005
FILE TIME: 18:56

POINT#	X	Y
1:	0.097	-0.339
2:	-0.029	-0.334
3:	-0.311	-0.268
4:	-0.560	-0.095
5:	-0.937	-0.495
6:	-0.347	-0.608
7:	0.928	-0.618
8:	0.895	0.713
9:	-0.285	1.177
10:	-0.064	-1.544

X CENTROID: -0.061
Y CENTROID: -0.241
POA TO CENTROID: 0.249
HORZ SPREAD: 1.865
VERT SPREAD: 2.721
GROUP SPREAD: 2.730
MIN RADIUS: 0.098
MAX RADIUS: 1.436
MEAN RADIUS: 0.758
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

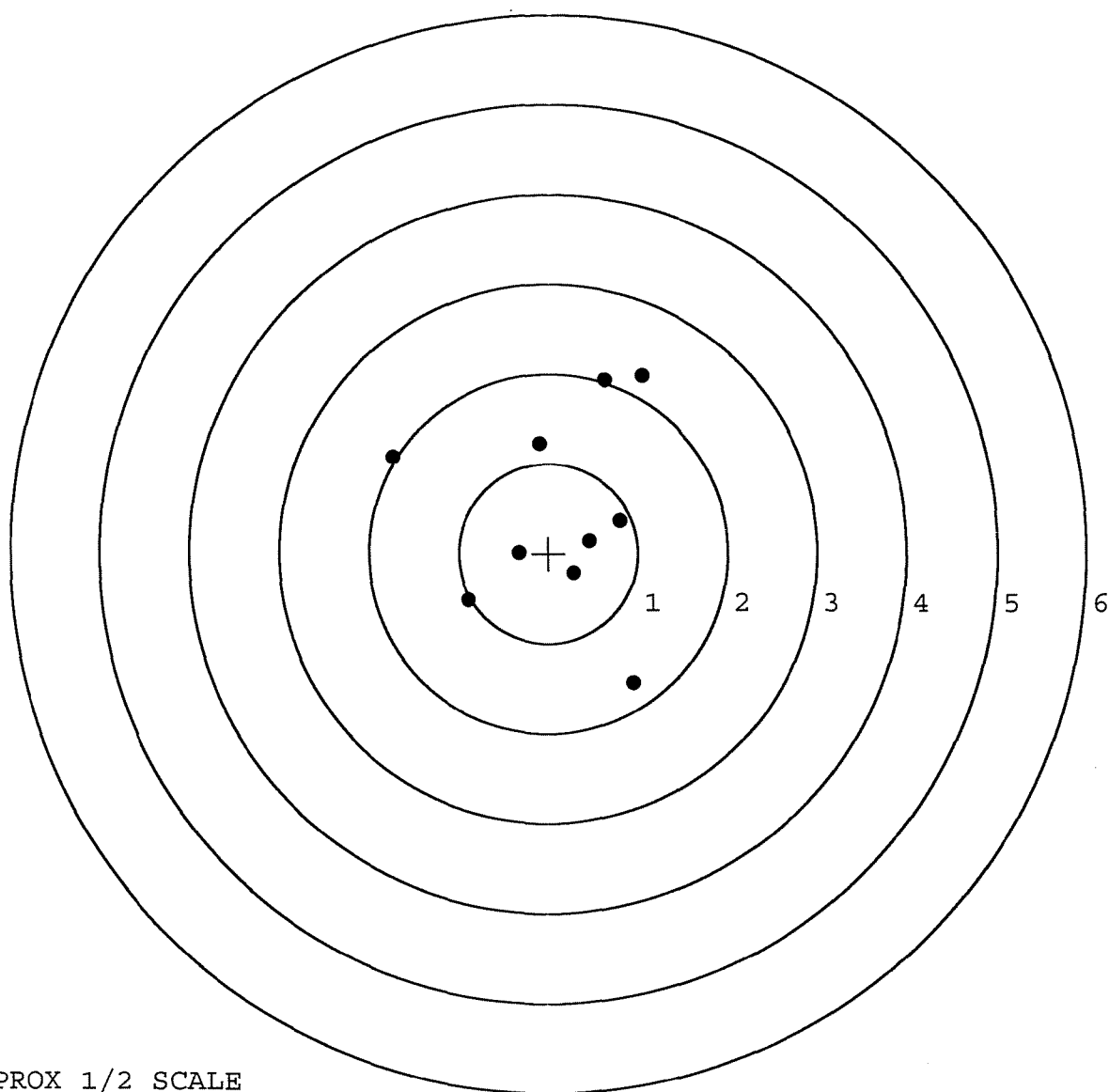


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461797. __0
TARGET NUMBER: 2
FILE DATE: 10/05/2005
FILE TIME: 18:56

X CENTROID: 0.112
Y CENTROID: 0.453
POA TO CENTROID: 0.466
HORZ SPREAD: 2.784
VERT SPREAD: 3.420
GROUP SPREAD: 3.685
MIN RADIUS: 0.474
MAX RADIUS: 2.074
MEAN RADIUS: 1.207
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 6

POINT#	X	Y
1:	-0.889	-0.520
2:	-0.328	0.005
3:	0.284	-0.221
4:	0.464	0.135
5:	0.804	0.364
6:	-0.102	1.225
7:	0.955	-1.443
8:	0.629	1.933
9:	1.045	1.977
10:	-1.739	1.071

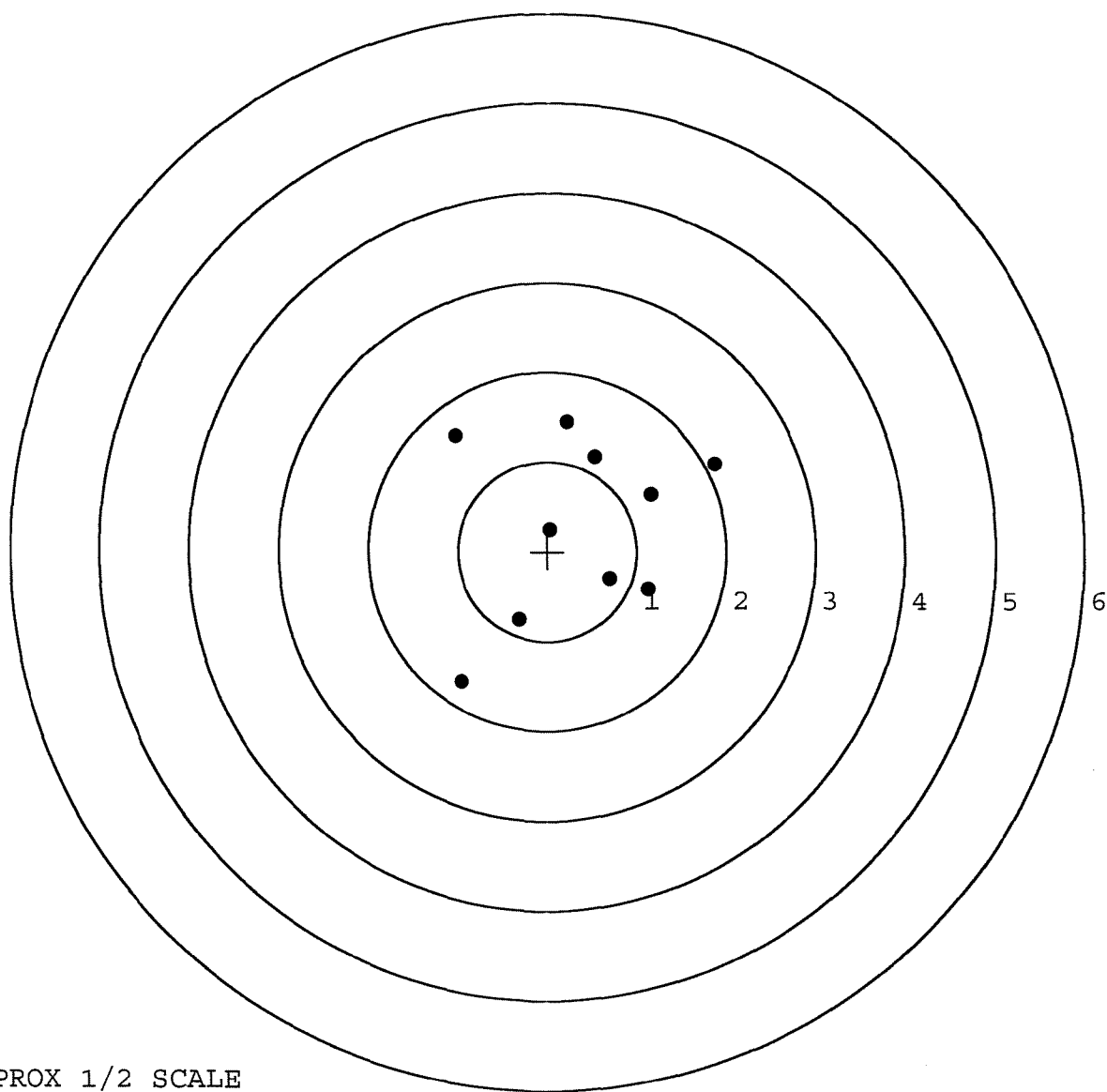


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461797. __0
TARGET NUMBER: 3
FILE DATE: 10/05/2005
FILE TIME: 18:56

POINT#	X	Y
1:	0.031	0.243
2:	-0.320	-0.766
3:	0.695	-0.301
4:	1.129	-0.420
5:	1.157	0.633
6:	1.872	0.971
7:	0.538	1.052
8:	0.219	1.443
9:	-1.030	1.290
10:	-0.956	-1.449

X CENTROID: 0.334
Y CENTROID: 0.270
POA TO CENTROID: 0.429
HORZ SPREAD: 2.902
VERT SPREAD: 2.892
GROUP SPREAD: 3.722
MIN RADIUS: 0.304
MAX RADIUS: 2.149
MEAN RADIUS: 1.169
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

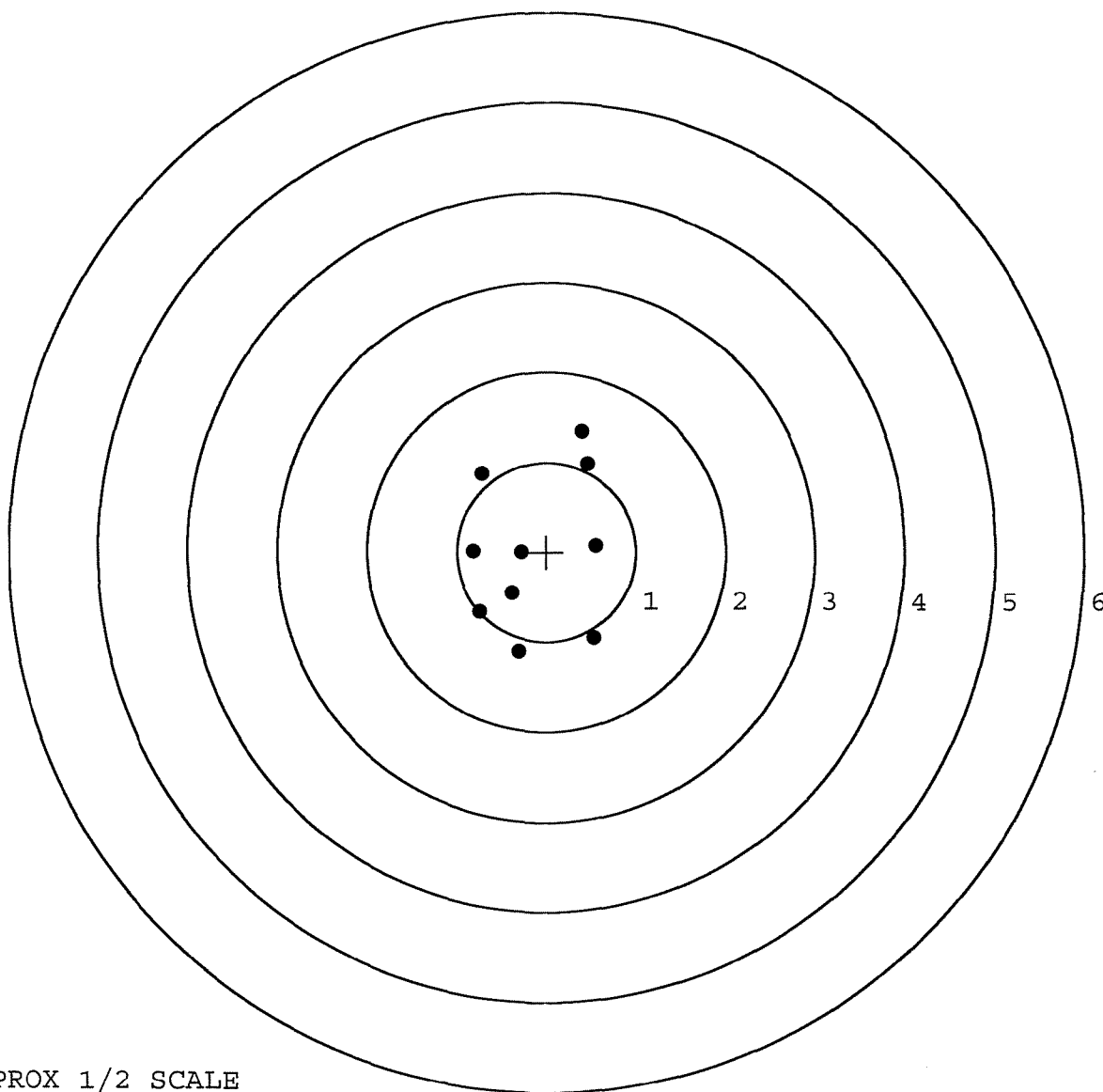


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461797. __0
TARGET NUMBER: 4
FILE DATE: 10/05/2005
FILE TIME: 18:56

POINT#	X	Y
1:	-0.309	-1.114
2:	0.536	-0.964
3:	-0.384	-0.465
4:	-0.745	-0.673
5:	-0.281	-0.004
6:	-0.817	0.011
7:	-0.725	0.874
8:	0.400	1.343
9:	0.462	0.983
10:	0.558	0.068

X CENTROID: -0.131
Y CENTROID: 0.006
POA TO CENTROID: 0.131
HORZ SPREAD: 1.375
VERT SPREAD: 2.457
GROUP SPREAD: 2.557
MIN RADIUS: 0.151
MAX RADIUS: 1.438
MEAN RADIUS: 0.892
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

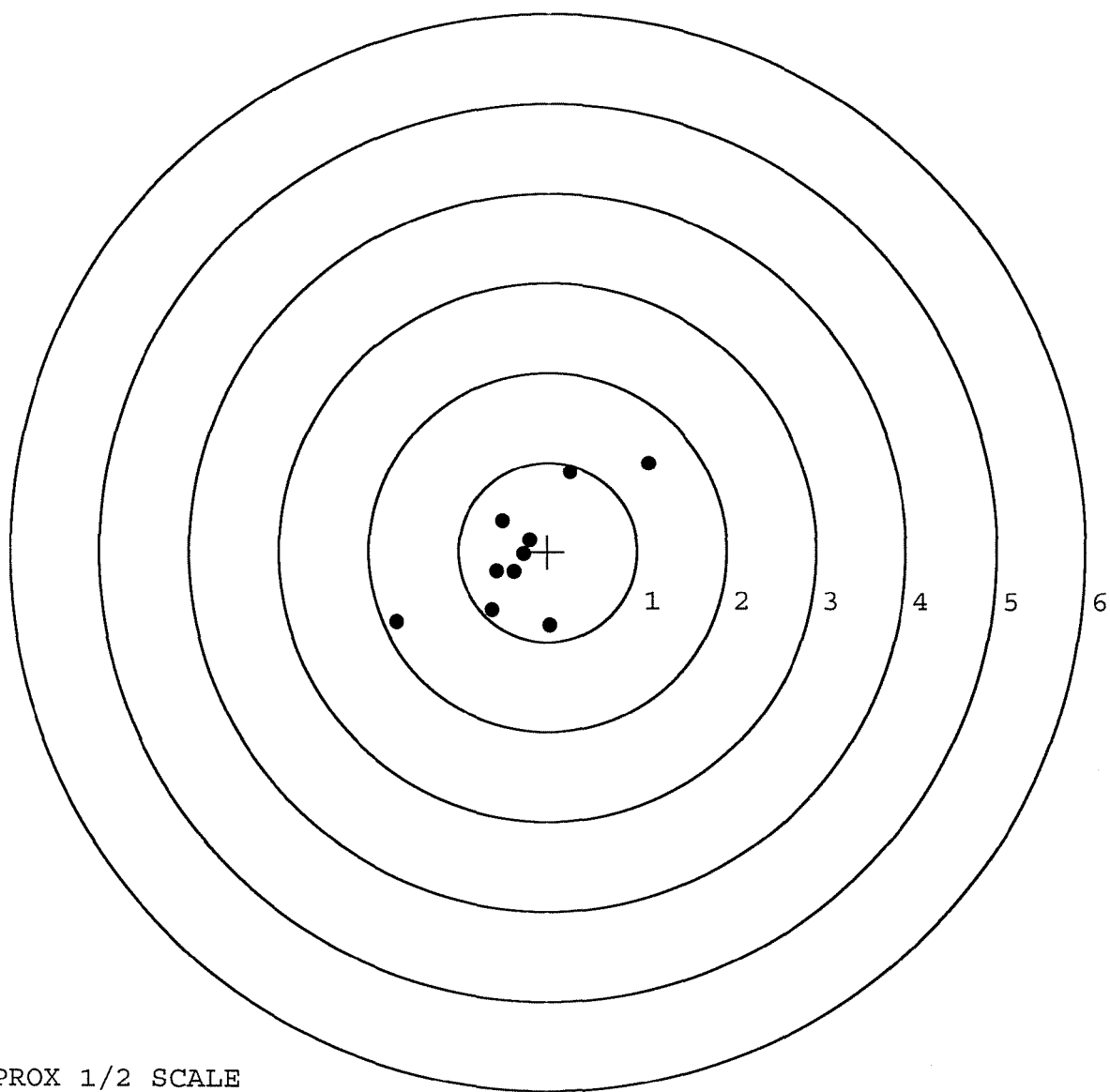


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461797. __0
TARGET NUMBER: 5
FILE DATE: 10/05/2005
FILE TIME: 18:56

POINT#	X	Y
1:	0.021	-0.821
2:	-0.625	-0.659
3:	-1.691	-0.789
4:	-0.572	-0.224
5:	-0.375	-0.227
6:	-0.206	0.129
7:	-0.510	0.342
8:	0.249	0.893
9:	1.124	0.992
10:	-0.267	-0.032

X CENTROID: -0.285
Y CENTROID: -0.040
POA TO CENTROID: 0.288
HORZ SPREAD: 2.815
VERT SPREAD: 1.813
GROUP SPREAD: 3.331
MIN RADIUS: 0.020
MAX RADIUS: 1.746
MEAN RADIUS: 0.716
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE