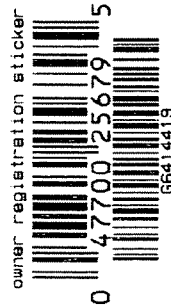
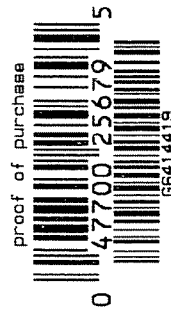


G641 4419

**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
COMPLETE SYSTEM - LE/EXPORT**

98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD, FORM 96253



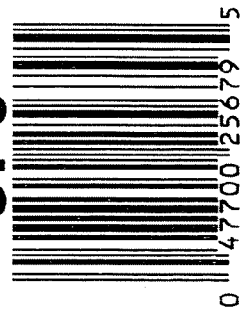
ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6414419

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



25679

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

**.MA25679**

Shop Order: SW5679

**.ABSW5679**

Start Date: 9/3/2004

Finish Date: 10/15/2004

0520

78ROT01

Goff Blast Barrel & Rec Assembly,

**0003770797**

0540

01PC001

Flat Black Powder Coat, Barrel and

**0003770799**

0560

89SWS1

Reassemble Action.

**0003770800**

0690

89SWS1

Pack Rifle & Stencil SWS Container

**.OP0690**

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 6641 4419

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTL
600	PROOF		12-29-04	K
607	CHECK HEADSPACE		12-29-04	K
610	DIS-ASSEMBLE GUN		12-30-04	CR
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		2-1-05	RTL
	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 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	<u>2-16-05</u>	<u>AC</u>
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	<u>2-16-05</u>	<u>AC</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	<u>2-16-05</u>	<u>AC</u>
	J) ASSEMBLE STOCK		<u>2-1-05</u>	<u>RTL</u>
	K) ASSEMBLE SWIVEL STUDS		<u>2-18-05</u>	<u>*</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>2-1-05</u>	<u>RTL</u>
	M) IRON SIGHT ALIGNMENT		<u>2-1-05</u>	<u>RTL</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>2-1-05</u>	<u>RTL</u>
640	GALLERY TEST AND TARGET	PASS FAIL	<u>2-4-05</u>	<u>TRL</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		<u>2-4-05</u>	<u>TRL</u>
655	FINAL INSPECTION A) HEADSPACE		<u>2-16-05</u>	<u>AC</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.81</u> <u>2.95</u> <u>2.94</u> <u>2.96</u> <u>2.95</u>	<u>2-17-05</u>	<u>TRL</u>
	C) FUNCTION		<u>2-16-05</u>	<u>AC</u>
660	PACK		<u>3/18/05</u>	<u>RA</u>

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 1-17-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.20	2.56		2.67	
PULL #2	2.51	2.78		2.70	
PULL #3	2.21	2.70		2.68	
PULL #4	2.63	2.93		2.63	
PULL #5	2.68	2.85		2.59	
TOTAL	12.23	13.82		13.27	
AVERAGE	2.44	2.76		2.65	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.48		
PULL #2	3.29	3.53		
PULL #3	3.27	3.48		
PULL #4	3.31	3.54		
PULL #5	3.31	3.52		
TOTAL	16.65	17.55		
AVERAGE	3.33	3.51		

	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	4.10		3.96
PULL #2	4.41	4.00		4.52
PULL #3	4.35	4.10		4.41
PULL #4	4.39	4.05		4.32
PULL #5	4.02	4.12		4.53
TOTAL	21.59	20.37		21.74
AVERAGE	4.31	4.07		4.34

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414419.__0
FILE DATE AND TIME: 02/04/2005 07:54

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.018
The Average Y Centroid of the Five Target Set:	-0.059
The Average Point of Impact of the Five Target Set:	0.062
The Average Mean Radius of the Five Target Set:	0.934
The Distance from POA to Centroid Target #1:	0.308
The Distance from Centroid Target #2 to Centroid Target #1:	0.453
The Distance from Centroid Target #3 to Centroid Target #1:	0.878
The Distance from Centroid Target #4 to Centroid Target #1:	0.162
The Distance from Centroid Target #5 to Centroid Target #1:	0.386

SERIAL NUMBER: G6414419. __0

TARGET NUMBER: 1

FILE DATE: 02/04/2005

FILE TIME: 07:54

X CENTROID: 0.237

Y CENTROID: 0.198

POA TO CENTROID: 0.308

HORZ SPREAD: 3.119

VERT SPREAD: 1.787

GROUP SPREAD: 3.595

MIN RADIUS: 0.200

MAX RADIUS: 1.889

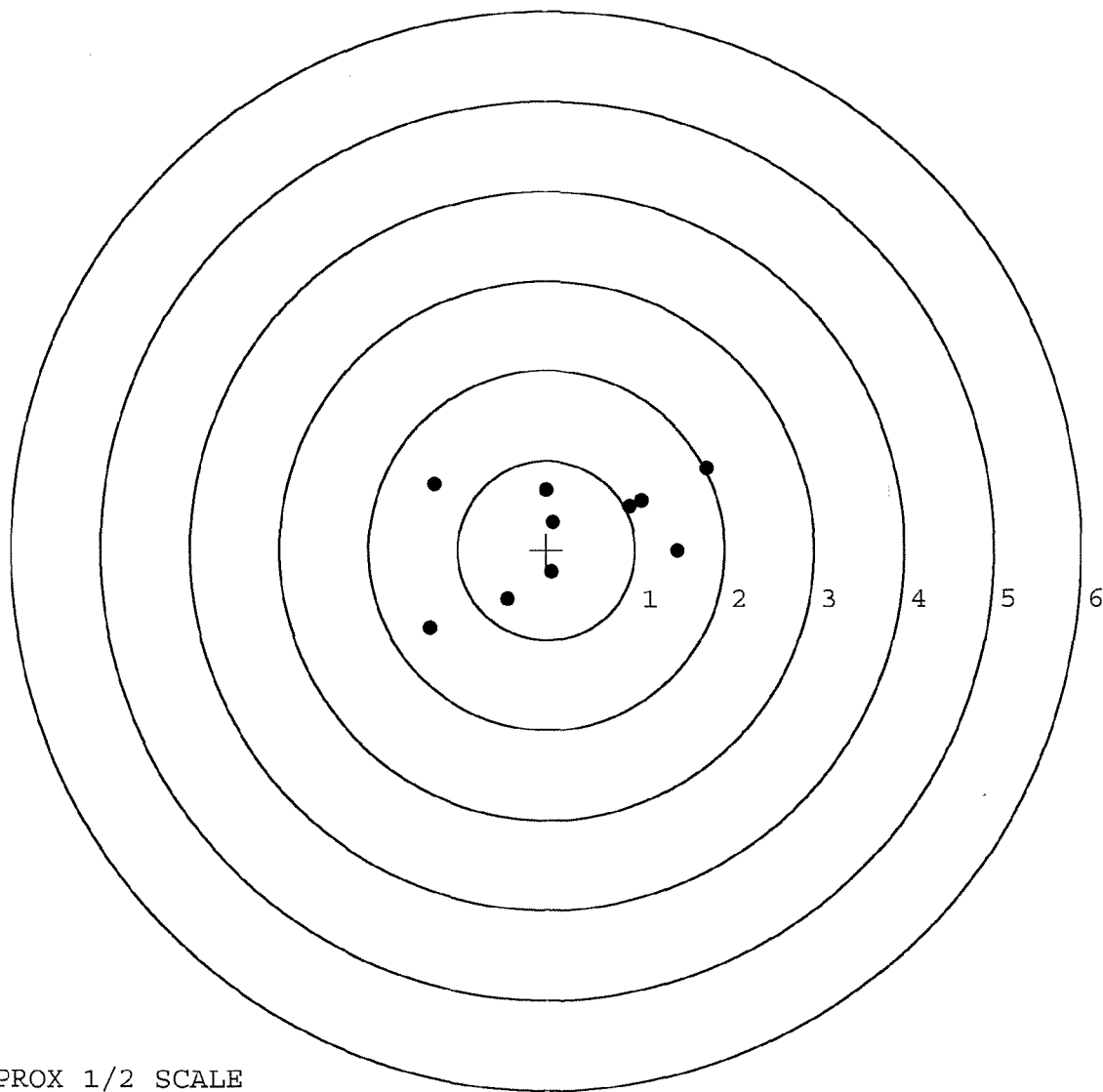
MEAN RADIUS: 1.034

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.475	-0.016
2:	1.800	0.913
3:	1.068	0.550
4:	0.934	0.485
5:	-0.011	0.670
6:	0.072	0.312
7:	0.055	-0.249
8:	-0.443	-0.549
9:	-1.264	0.736
10:	-1.319	-0.874



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414419. __0

TARGET NUMBER: 2

FILE DATE: 02/04/2005

FILE TIME: 07:54

X CENTROID: -0.106

Y CENTROID: -0.099

POA TO CENTROID: 0.145

HORZ SPREAD: 2.596

VERT SPREAD: 1.783

GROUP SPREAD: 3.136

MIN RADIUS: 0.357

MAX RADIUS: 1.753

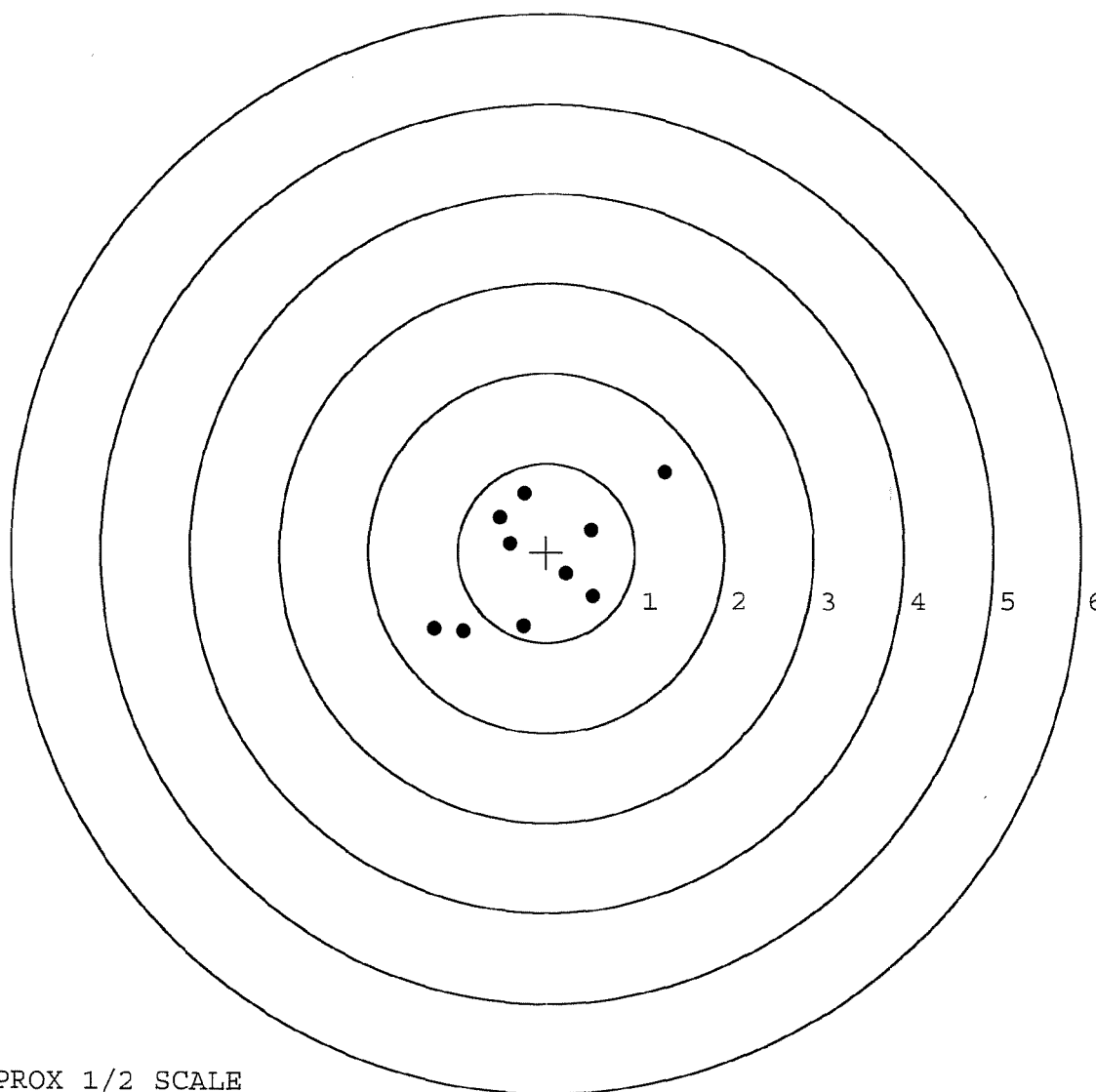
MEAN RADIUS: 0.861

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.335	0.900
2:	0.505	0.256
3:	0.221	-0.243
4:	0.521	-0.489
5:	-0.256	-0.825
6:	-0.938	-0.883
7:	-1.261	-0.859
8:	-0.409	0.103
9:	-0.529	0.388
10:	-0.250	0.664

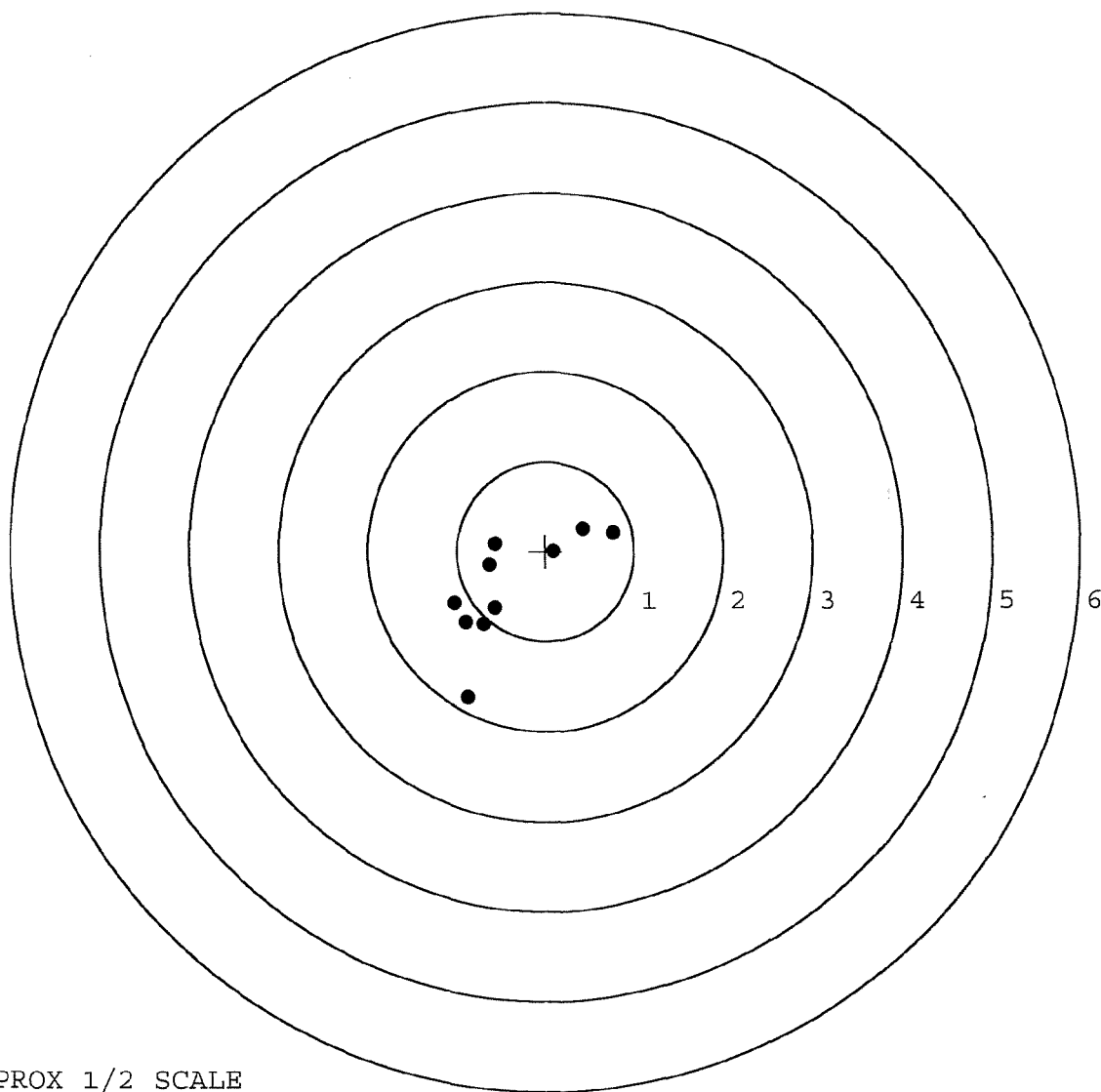


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414419. 0
TARGET NUMBER: 3
FILE DATE: 02/04/2005
FILE TIME: 07:54

X CENTROID: -0.403
Y CENTROID: -0.403
POA TO CENTROID: 0.570
HORZ SPREAD: 1.787
VERT SPREAD: 1.884
GROUP SPREAD: 2.457
MIN RADIUS: 0.285
MAX RADIUS: 1.313
MEAN RADIUS: 0.725
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

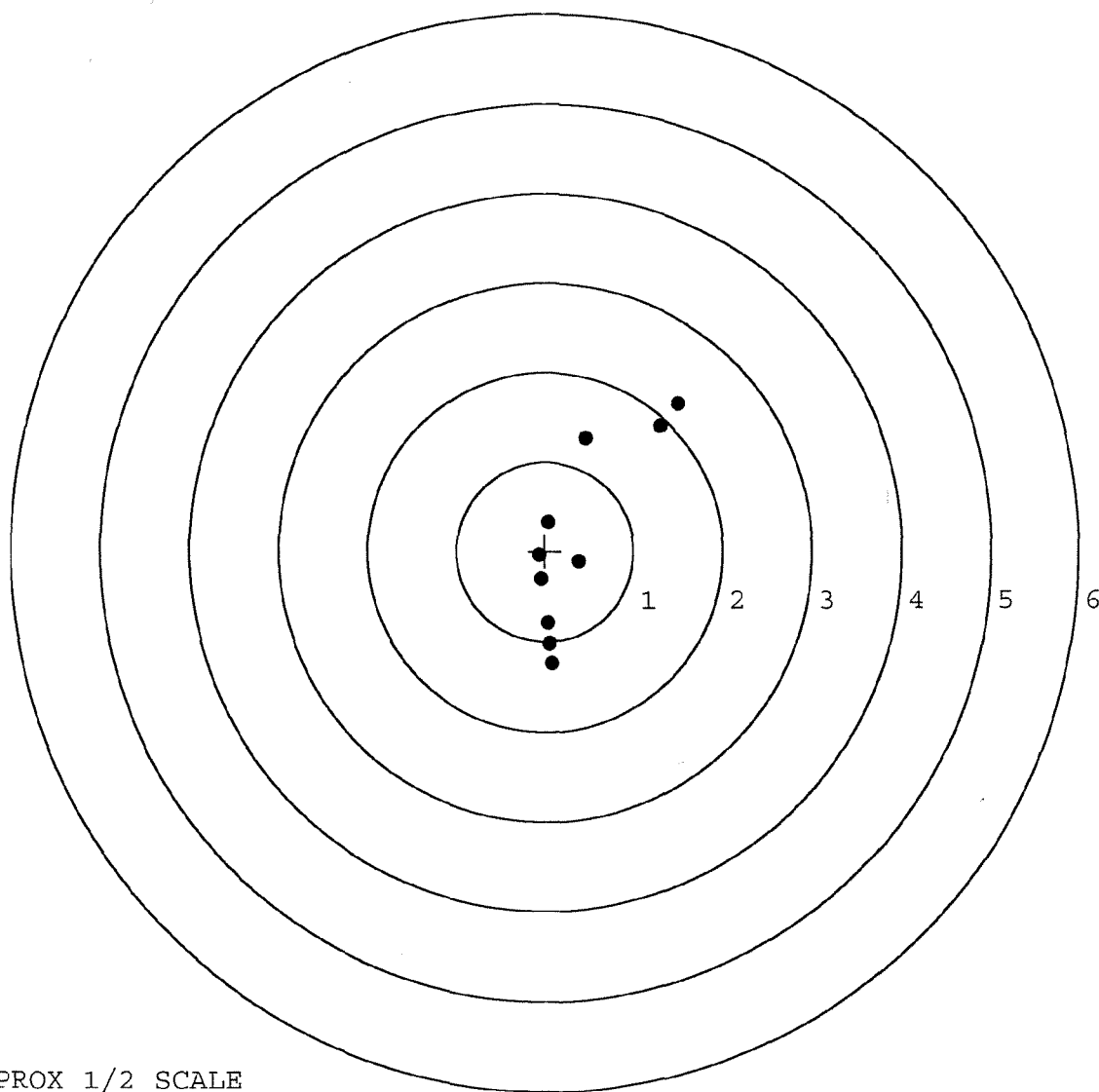
POINT#	X	Y
1:	-0.874	-1.629
2:	0.756	0.209
3:	0.414	0.255
4:	0.091	0.006
5:	-0.569	0.091
6:	-0.639	-0.153
7:	-1.031	-0.580
8:	-0.903	-0.789
9:	-0.703	-0.810
10:	-0.575	-0.631



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414419. __0
TARGET NUMBER: 4
FILE DATE: 02/04/2005
FILE TIME: 07:54

		POINT#	X	Y
X CENTROID:	0.371	1:	1.301	1.397
Y CENTROID:	0.107	2:	1.504	1.653
POA TO CENTROID:	0.386	3:	0.464	1.269
HORZ SPREAD:	1.575	4:	0.034	0.321
VERT SPREAD:	2.906	5:	0.381	-0.117
GROUP SPREAD:	3.237	6:	-0.071	-0.047
MIN RADIUS:	0.224	7:	-0.053	-0.320
MAX RADIUS:	1.917	8:	0.028	-0.804
MEAN RADIUS:	0.991	9:	0.048	-1.029
# IN 1 IN DIAMETER:	3	10:	0.077	-1.253
# IN 2 IN DIAMETER:	5			
# in 3 IN DIAMETER:	8			



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414419. __0

TARGET NUMBER: 5

FILE DATE: 02/04/2005

FILE TIME: 07:54

X CENTROID: -0.011

Y CENTROID: -0.098

POA TO CENTROID: 0.099

HORZ SPREAD: 2.140

VERT SPREAD: 2.524

GROUP SPREAD: 2.799

MIN RADIUS: 0.660

MAX RADIUS: 1.656

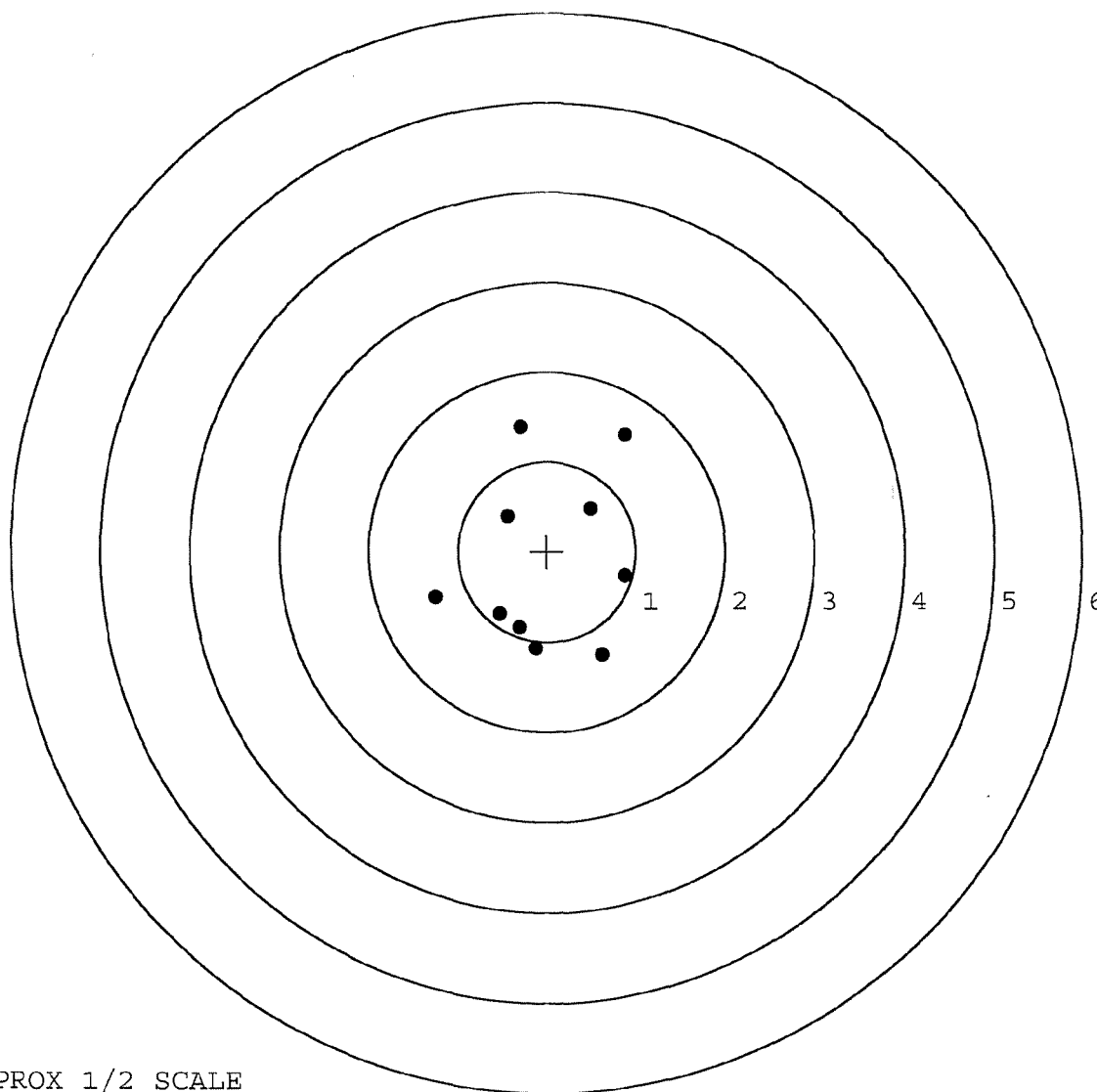
MEAN RADIUS: 1.060

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.620	-1.143
2:	0.876	-0.268
3:	0.490	0.480
4:	0.885	1.294
5:	-0.295	1.381
6:	-0.453	0.392
7:	-1.255	-0.510
8:	-0.536	-0.688
9:	-0.319	-0.845
10:	-0.122	-1.077



TARGET APPROX 1/2 SCALE