

G646 1699

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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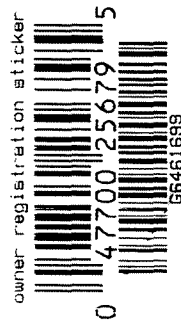
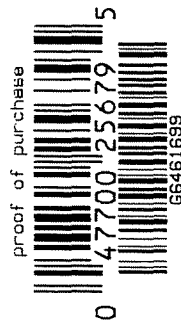
SERIAL NO.



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

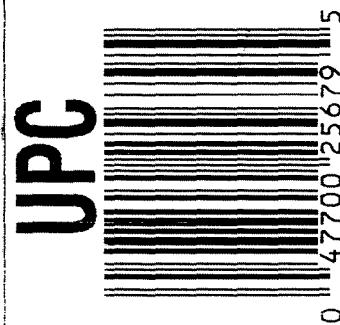
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

46 FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6461699



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # ~~000000~~ 66461699

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-13-05	RTL
440	PROOF		9-15-05	RTL
460	CHECK HEADSPACE		9-16-05	RTL
470	DIS-ASSEMBLE ACTION		9-16-05	RTL
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	SEP 18 2005 CISD	9/20/05	unus
500	ROLLMARK CALIBER		9-20-05	CW
510	DRILL AND TAP SIGHT HOLES		9-20-05	TRW
520	GOFF BLAST BBL / REC		9-21-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/22	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-18-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/18/05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/18/05	DA
	D) OIL FIRING PIN ASSEMBLY		10-20-05	RTL
	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>2 16</u> <u>2 16</u> <u>2 16</u>	10-31-05	BSG
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16</u> <u>2 16</u> <u>2 16</u>	10-31-05	BSG
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.025</u> <u>.024</u>	10-31-05	BSG
	J) ASSEMBLE STOCK		10-28-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-31-05	BSG
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-31-05	BSG
	M) IRON SIGHT ALIGNMENT		10-31-05	BSG
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-31-05	BSG
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/22/05	mgd
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/22/05	maxm
670	FINAL INSPECTION A) HEADSPACE		10-31-05	BSG
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.53</u> <u>2.24</u> <u>2.31</u> <u>2.34</u> <u>2.37</u>	10-28-05	BSG
	C) FUNCTION		10-31-05	BSG
690	PACK		11-1-05	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 10-17-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.66	2.66		2.69	
PULL #2	2.56	2.58		2.26	
PULL #3	2.65	2.68		2.61	
PULL #4	2.60	2.68		2.45	
PULL #5	2.63	2.71		2.69	
TOTAL	13.10	13.31		12.70	
AVERAGE	2.62	2.66		2.54	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	2.90		
PULL #2	3.10	2.89		
PULL #3	3.25	2.86		
PULL #4	3.03	2.90		
PULL #5	2.95	2.95		
TOTAL	15.42	14.50		
AVERAGE	3.08	2.90		

	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	4.09	4.24		4.14
PULL #2	3.93	4.25		4.18
PULL #3	3.91	4.23		4.10
PULL #4	3.97	4.30		4.17
PULL #5	3.92	4.22		4.10
TOTAL	19.82	21.24		20.69
AVERAGE	3.96	4.24		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461699.___0
FILE DATE AND TIME: 10/22/2005 12:17

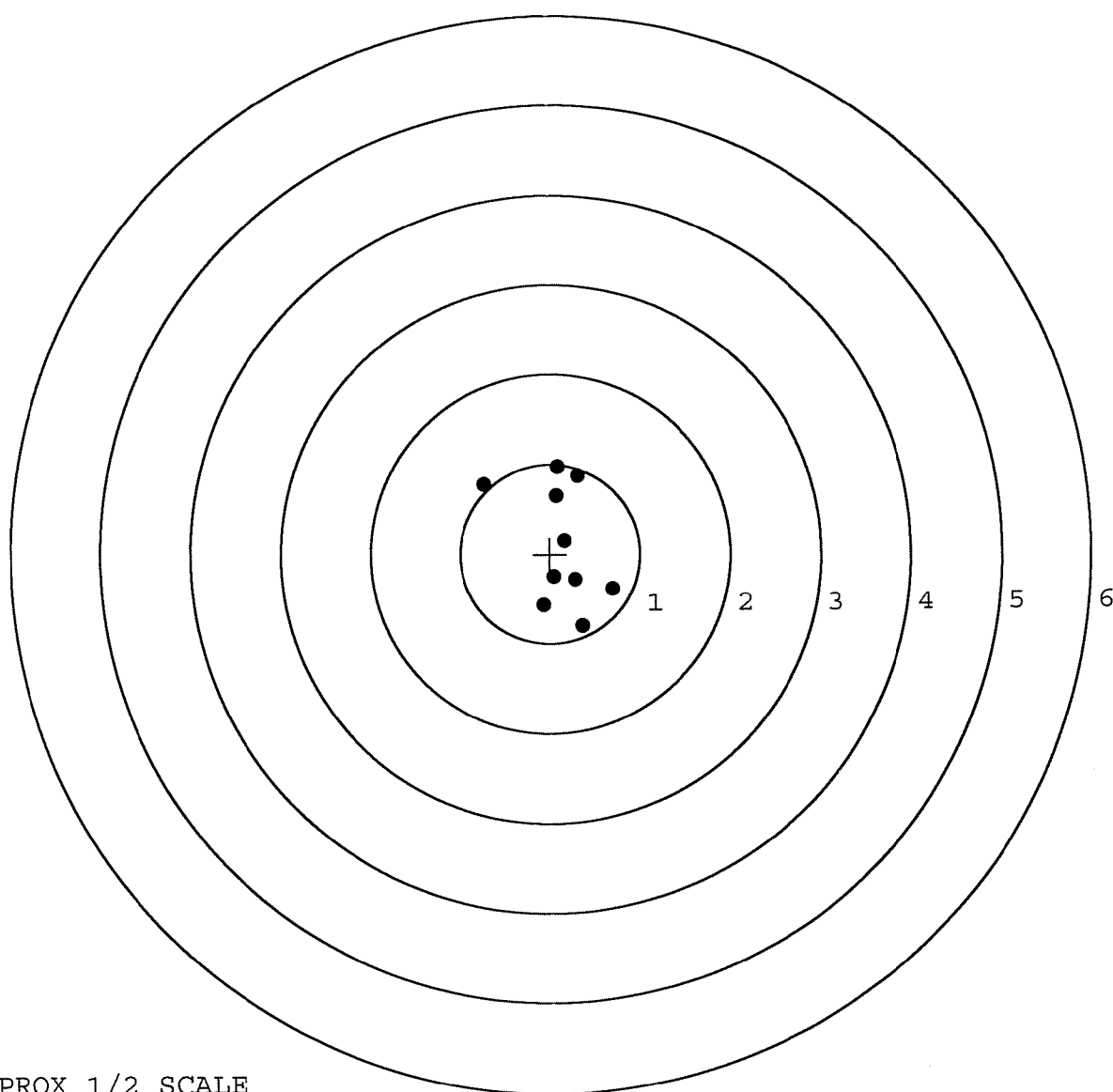
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.043
The Average Y Centroid of the Five Target Set:	-0.054
The Average Point of Impact of the Five Target Set:	0.069
The Average Mean Radius of the Five Target Set:	0.682
The Distance from POA to Centroid Target #1:	0.165
The Distance from Centroid Target #2 to Centroid Target #1:	0.060
The Distance from Centroid Target #3 to Centroid Target #1:	0.383
The Distance from Centroid Target #4 to Centroid Target #1:	0.472
The Distance from Centroid Target #5 to Centroid Target #1:	0.367

SERIAL NUMBER: G6461699.___0
TARGET NUMBER: 1
FILE DATE: 10/22/2005
FILE TIME: 12:17

X CENTROID: 0.123
Y CENTROID: 0.109
POA TO CENTROID: 0.165
HORZ SPREAD: 1.426
VERT SPREAD: 1.779
GROUP SPREAD: 1.933
MIN RADIUS: 0.056
MAX RADIUS: 1.087
MEAN RADIUS: 0.657
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.164	0.147
2:	0.286	-0.288
3:	0.697	-0.396
4:	0.040	-0.257
5:	-0.074	-0.577
6:	0.362	-0.811
7:	0.316	0.871
8:	0.093	0.968
9:	0.074	0.652
10:	-0.729	0.785

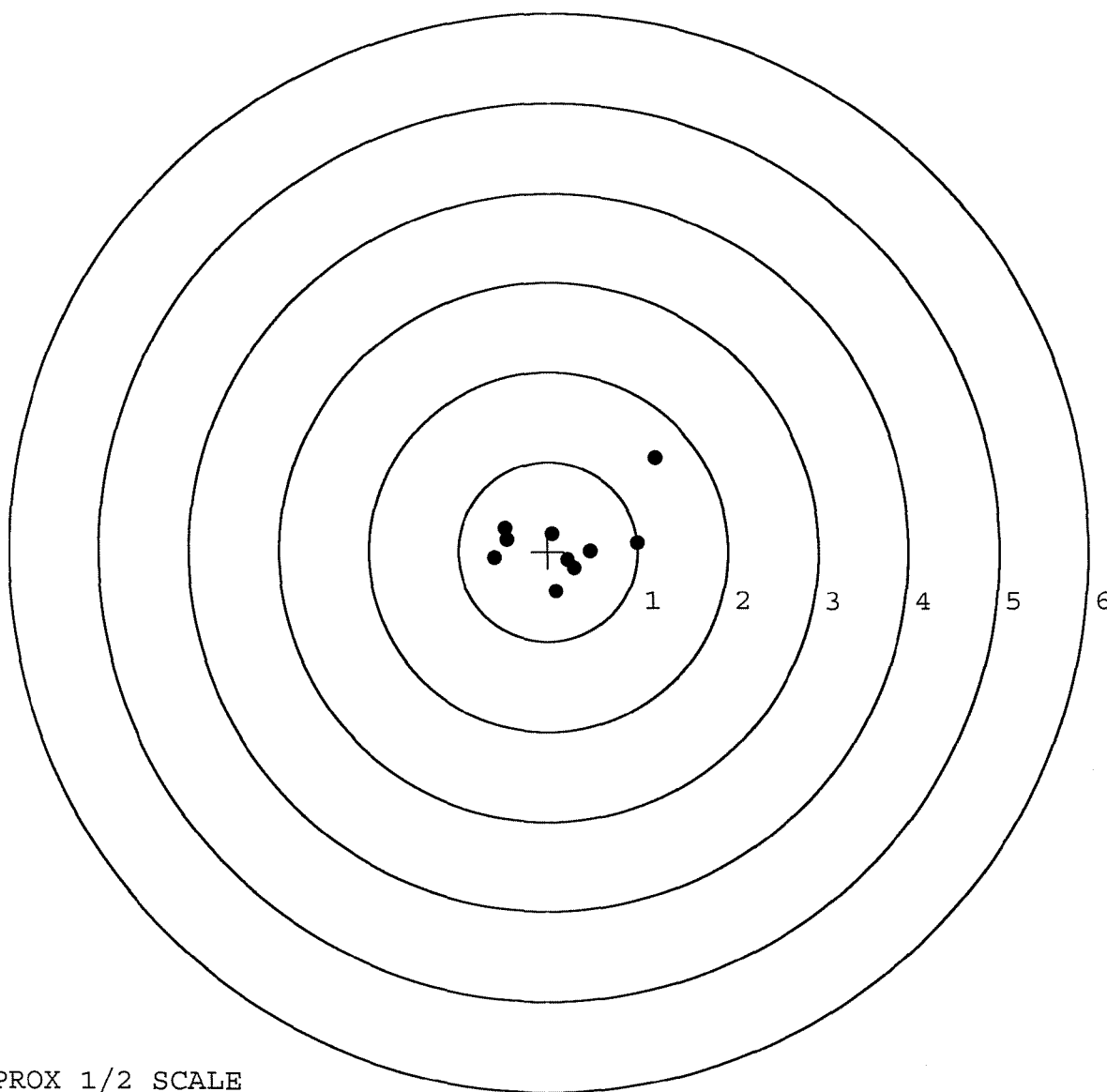


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461699. __0
TARGET NUMBER: 2
FILE DATE: 10/22/2005
FILE TIME: 12:17

POINT#	X	Y
1:	0.053	0.197
2:	0.226	-0.098
3:	0.476	-0.003
4:	0.299	-0.188
5:	0.094	-0.449
6:	0.998	0.100
7:	1.189	1.044
8:	-0.477	0.258
9:	-0.460	0.133
10:	-0.594	-0.078

X CENTROID: 0.180
Y CENTROID: 0.092
POA TO CENTROID: 0.202
HORZ SPREAD: 1.783
VERT SPREAD: 1.493
GROUP SPREAD: 2.107
MIN RADIUS: 0.165
MAX RADIUS: 1.387
MEAN RADIUS: 0.584
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

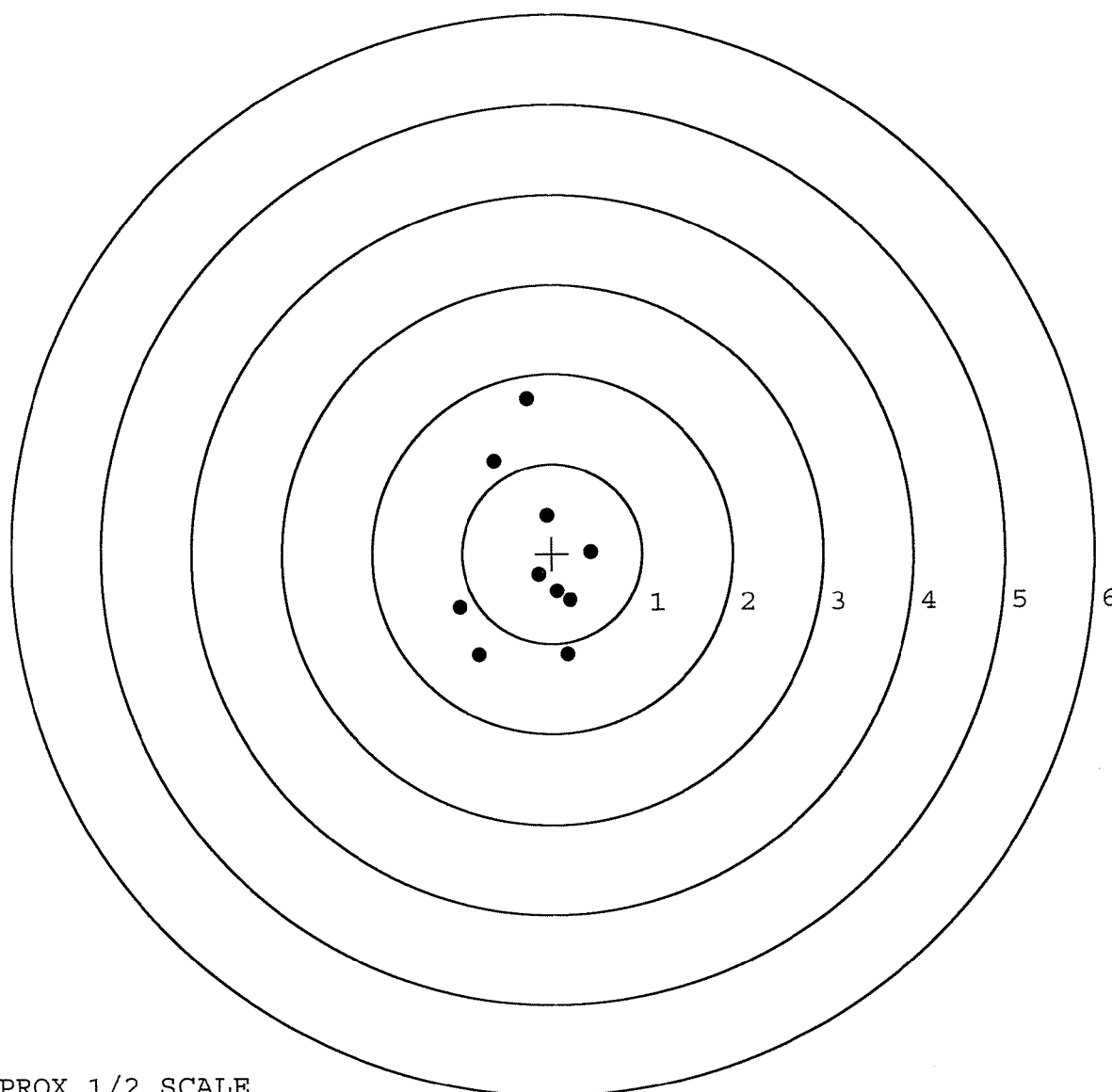


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461699. __0
TARGET NUMBER: 3
FILE DATE: 10/22/2005
FILE TIME: 12:17

X CENTROID: -0.209
Y CENTROID: -0.082
POA TO CENTROID: 0.224
HORZ SPREAD: 1.464
VERT SPREAD: 2.848
GROUP SPREAD: 2.900
MIN RADIUS: 0.164
MAX RADIUS: 1.809
MEAN RADIUS: 0.867
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.060	0.426
2:	-0.635	1.034
3:	-0.267	1.726
4:	0.434	0.019
5:	-0.150	-0.235
6:	0.059	-0.426
7:	0.205	-0.521
8:	0.168	-1.122
9:	-0.814	-1.122
10:	-1.030	-0.595

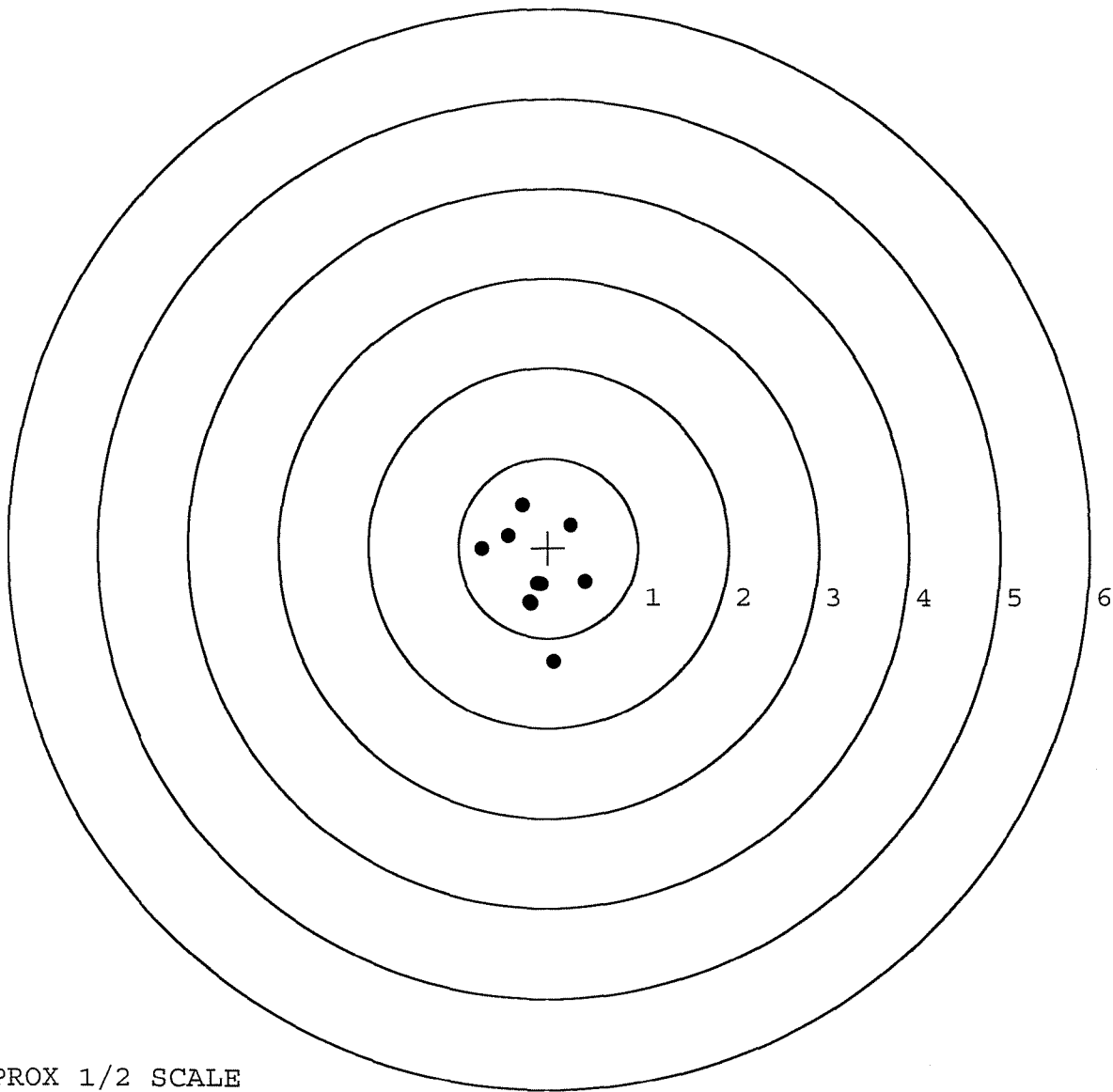


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461699. __0
TARGET NUMBER: 4
FILE DATE: 10/22/2005
FILE TIME: 12:17

X CENTROID: -0.133
Y CENTROID: -0.288
POA TO CENTROID: 0.317
HORZ SPREAD: 1.154
VERT SPREAD: 1.733
GROUP SPREAD: 1.768
MIN RADIUS: 0.118
MAX RADIUS: 0.998
MEAN RADIUS: 0.509
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.287	0.467
2:	-0.442	0.127
3:	-0.739	-0.018
4:	-0.082	-0.407
5:	-0.202	-0.611
6:	0.062	-1.266
7:	0.415	-0.386
8:	0.256	0.248
9:	-0.121	-0.405
10:	-0.193	-0.625

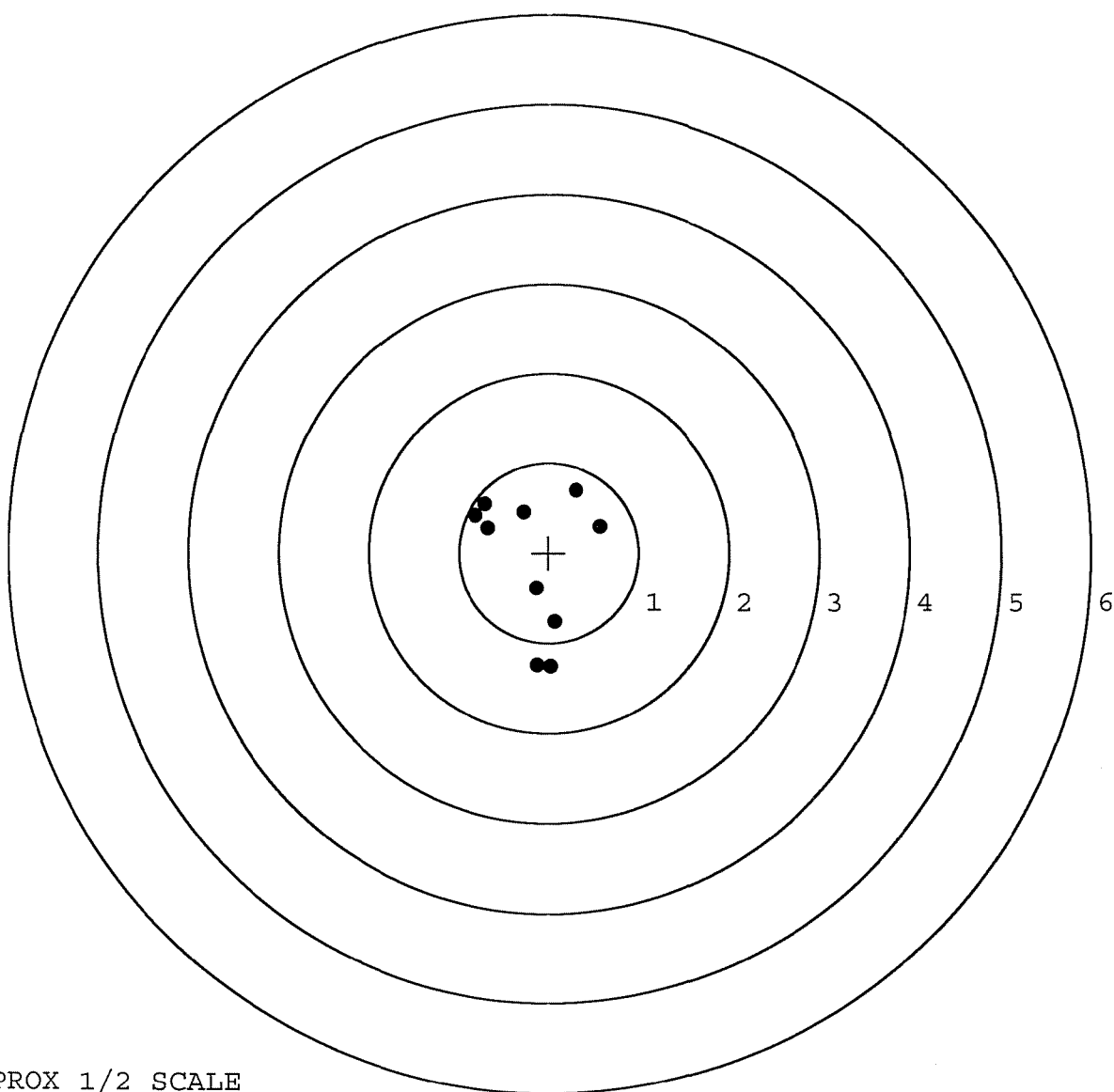


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461699. __0
TARGET NUMBER: 5
FILE DATE: 10/22/2005
FILE TIME: 12:17

	POINT#	X	Y
	1:	0.575	0.290
	2:	0.308	0.688
	3:	-0.276	0.449
	4:	-0.712	0.545
	5:	-0.818	0.418
	6:	-0.674	0.275
	7:	-0.137	-0.397
	8:	0.068	-0.769
	9:	-0.127	-1.248
	10:	0.021	-1.265

X CENTROID: -0.177
Y CENTROID: -0.101
POA TO CENTROID: 0.204
HORZ SPREAD: 1.393
VERT SPREAD: 1.953
GROUP SPREAD: 1.974
MIN RADIUS: 0.298
MAX RADIUS: 1.180
MEAN RADIUS: 0.796
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE