

G646 1700

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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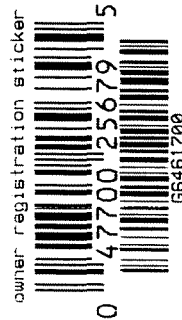
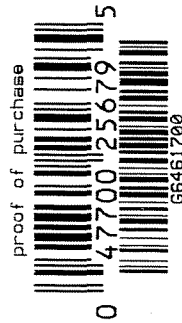
SERIAL NO.



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



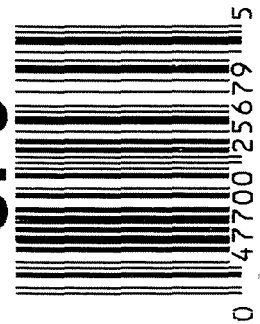
ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6461700

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INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6461700

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-13-05	RTZ
440	PROOF		9-15-05	RTZ
460	CHECK HEADSPACE		9-16-05	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	9-16-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	480 SEP 16 2005 used	9/20/05	mmh
500	ROLLMARK CALIBER		9-20-05	CW
510	DRILL AND TAP SIGHT HOLES		9-20-05	TRC
520	GOFF BLAST BBL / REC		9-21-05	VB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/22	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION		9/30	MTM
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/30	MTM
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/30	MTM
	D) OIL FIRING PIN ASSEMBLY		9-19-05	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 16</u> <u>6 16</u> <u>6 16</u>	10-31-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16</u> <u>2 16</u> <u>2 16</u>	10-31-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	10-31-05	BC
	J) ASSEMBLE STOCK		10-19-05	RL
	K) ASSEMBLE SWIVEL STUDS		10-31-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-31-05	BC
	M) IRON SIGHT ALIGNMENT		10-31-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-31-05	BC
640 & 650	FUNCTION TEST AND TARGET	PASS FAIL PASS FAIL	10-21-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-21-05	SH
670	FINAL INSPECTION A) HEADSPACE		10-31-05	BC
	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	BC
	C) FUNCTION		10-31-05	BC
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 10-18-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.35	2.50		2.60	
PULL #2	2.40	2.53		2.30	
PULL #3	2.47	2.43		2.39	
PULL #4	2.38	2.43		2.34	
PULL #5	2.52	2.65		2.42	
TOTAL	12.12	12.54		12.05	
AVERAGE	2.42	2.50		2.41	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.42		
PULL #2	2.77	3.01		
PULL #3	3.22	2.99		
PULL #4	2.96	3.23		
PULL #5	3.48	3.40		
TOTAL	15.53	15.05		
AVERAGE	3.10	3.01		

	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	4.07	4.40		3.96
PULL #2	4.24	4.04		3.98
PULL #3	4.19	4.15		4.27
PULL #4	4.29	4.12		4.18
PULL #5	4.30	4.29		3.99
TOTAL	21.09	21.00		20.38
AVERAGE	4.21	4.20		4.08

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6461700.___0

FILE DATE AND TIME: 10/21/2005 10:20

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.058
The Average Y Centroid of the Five Target Set:	0.010
The Average Point of Impact of the Five Target Set:	0.059
The Average Mean Radius of the Five Target Set:	0.806
The Distance from POA to Centroid Target #1:	0.166
The Distance from Centroid Target #2 to Centroid Target #1:	0.111
The Distance from Centroid Target #3 to Centroid Target #1:	0.136
The Distance from Centroid Target #4 to Centroid Target #1:	0.096
The Distance from Centroid Target #5 to Centroid Target #1:	0.514

SERIAL NUMBER: G6461700. __0

TARGET NUMBER: 1

FILE DATE: 10/21/2005

FILE TIME: 10:20

X CENTROID: 0.015

Y CENTROID: 0.165

POA TO CENTROID: 0.166

HORZ SPREAD: 1.792

VERT SPREAD: 2.124

GROUP SPREAD: 2.597

MIN RADIUS: 0.130

MAX RADIUS: 1.662

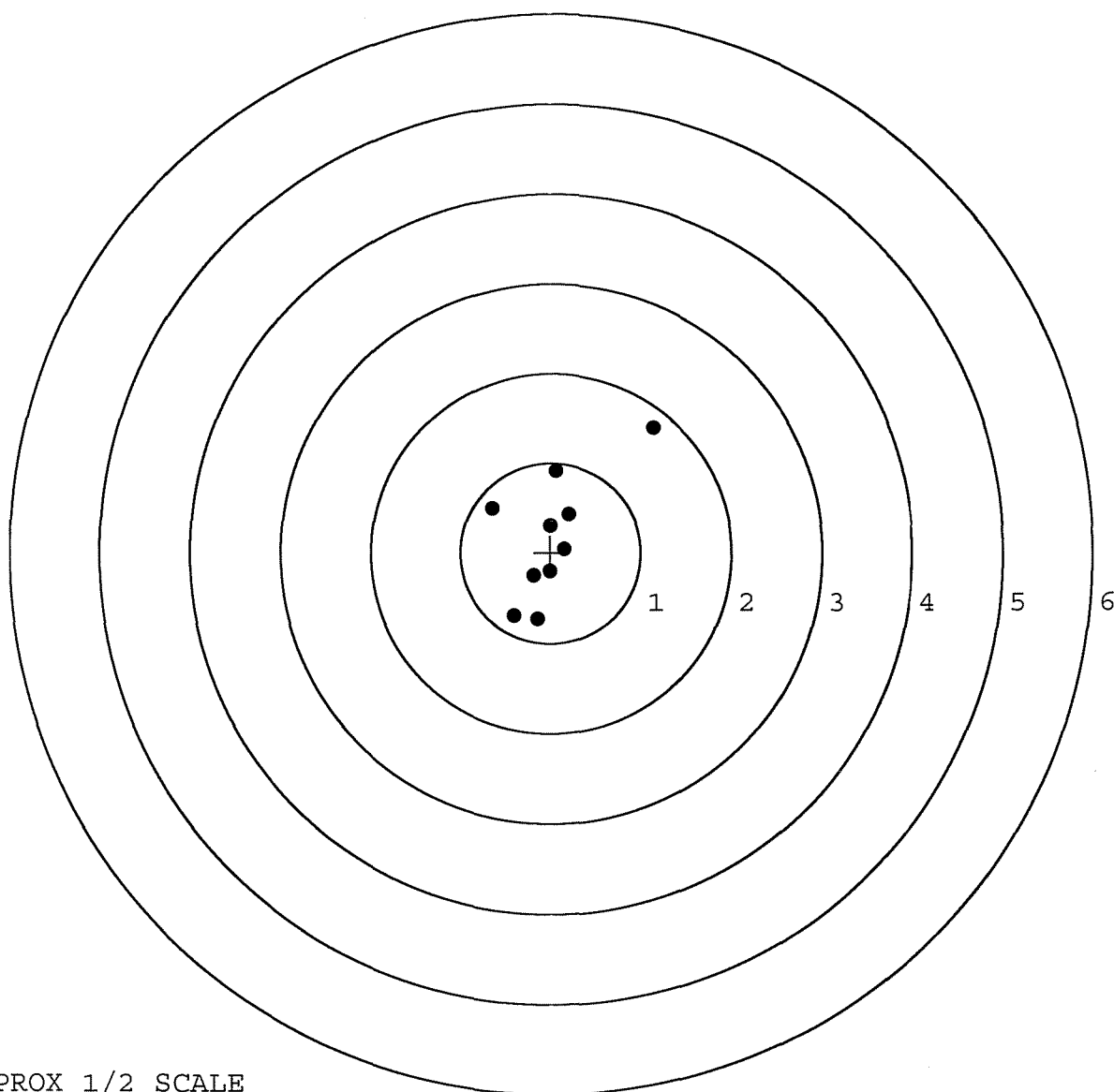
MEAN RADIUS: 0.651

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.651	0.498
2:	0.060	0.911
3:	1.141	1.387
4:	0.204	0.424
5:	0.002	0.294
6:	0.154	0.035
7:	-0.011	-0.207
8:	-0.192	-0.257
9:	-0.152	-0.737
10:	-0.408	-0.697



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461700. __0

TARGET NUMBER: 2

FILE DATE: 10/21/2005

FILE TIME: 10:20

X CENTROID: -0.022

Y CENTROID: 0.060

POA TO CENTROID: 0.064

HORZ SPREAD: 2.116

VERT SPREAD: 2.025

GROUP SPREAD: 2.046

MIN RADIUS: 0.336

MAX RADIUS: 1.257

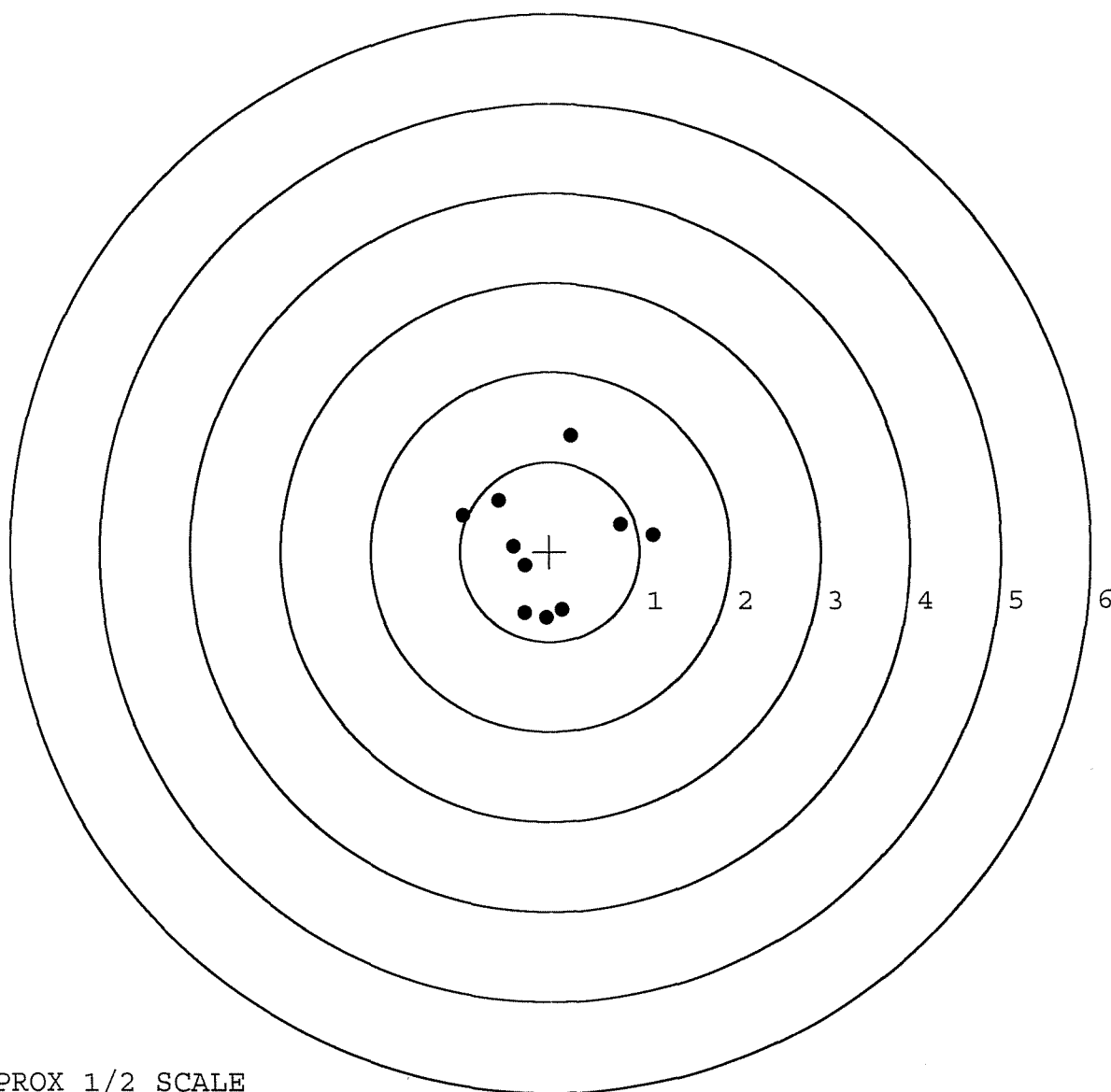
MEAN RADIUS: 0.807

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.148	0.184
2:	0.792	0.306
3:	0.246	1.288
4:	-0.567	0.578
5:	-0.968	0.407
6:	-0.400	0.065
7:	-0.279	-0.156
8:	0.134	-0.650
9:	-0.044	-0.737
10:	-0.283	-0.686



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461700. __0

TARGET NUMBER: 3

FILE DATE: 10/21/2005

FILE TIME: 10:20

X CENTROID: 0.099

Y CENTROID: 0.058

POA TO CENTROID: 0.115

HORZ SPREAD: 1.093

VERT SPREAD: 2.224

GROUP SPREAD: 2.275

MIN RADIUS: 0.130

MAX RADIUS: 1.340

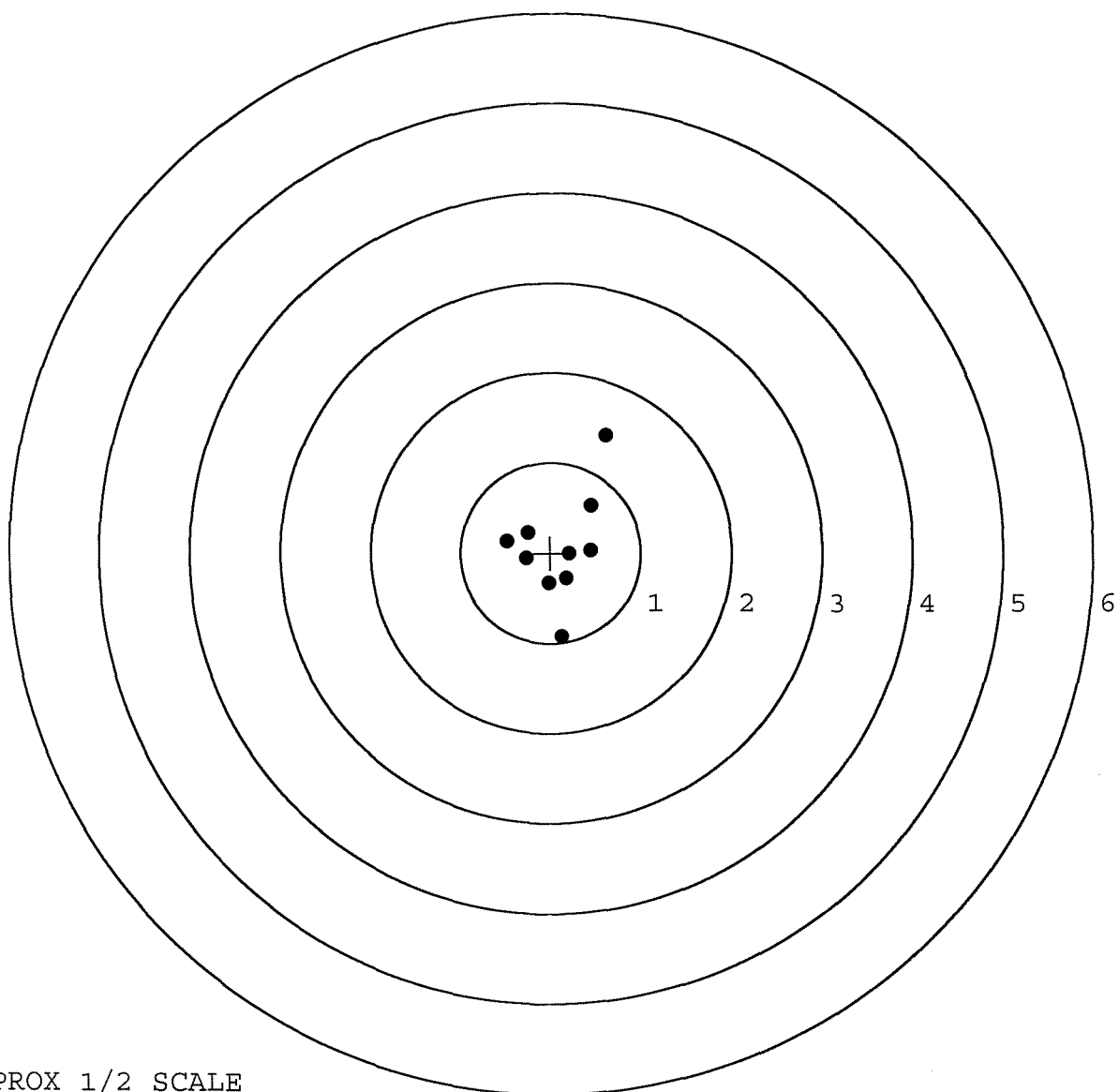
MEAN RADIUS: 0.551

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.128	-0.927
2:	0.449	0.521
3:	0.609	1.297
4:	0.448	0.029
5:	0.208	-0.012
6:	0.176	-0.283
7:	-0.025	-0.336
8:	-0.249	0.222
9:	-0.270	-0.058
10:	-0.484	0.129

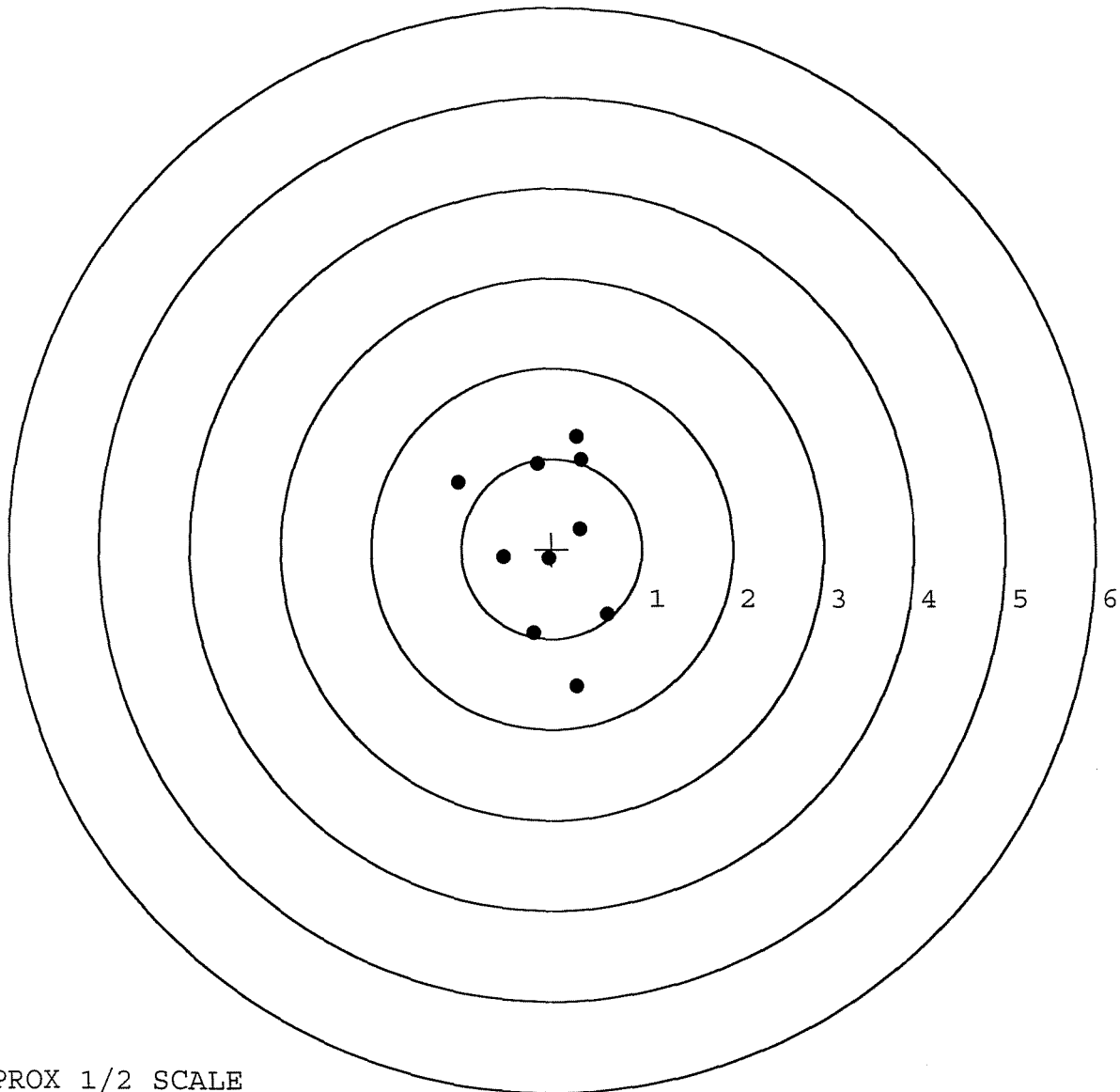


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461700. __0
TARGET NUMBER: 4
FILE DATE: 10/21/2005
FILE TIME: 10:20

POINT#	X	Y
1:	0.624	-0.729
2:	0.284	-1.532
3:	-0.194	-0.946
4:	0.315	0.221
5:	-0.034	-0.102
6:	-0.538	-0.087
7:	0.276	1.241
8:	0.326	0.991
9:	-0.166	0.940
10:	-1.036	0.741

X CENTROID: -0.014
Y CENTROID: 0.074
POA TO CENTROID: 0.075
HORZ SPREAD: 1.660
VERT SPREAD: 2.773
GROUP SPREAD: 2.773
MIN RADIUS: 0.177
MAX RADIUS: 1.633
MEAN RADIUS: 0.906
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6461700.___0

TARGET NUMBER: 5

FILE DATE: 10/21/2005

FILE TIME: 10:20

X CENTROID: 0.215

Y CENTROID: -0.308

POA TO CENTROID: 0.375

HORZ SPREAD: 2.941

VERT SPREAD: 2.752

GROUP SPREAD: 3.612

MIN RADIUS: 0.213

MAX RADIUS: 2.294

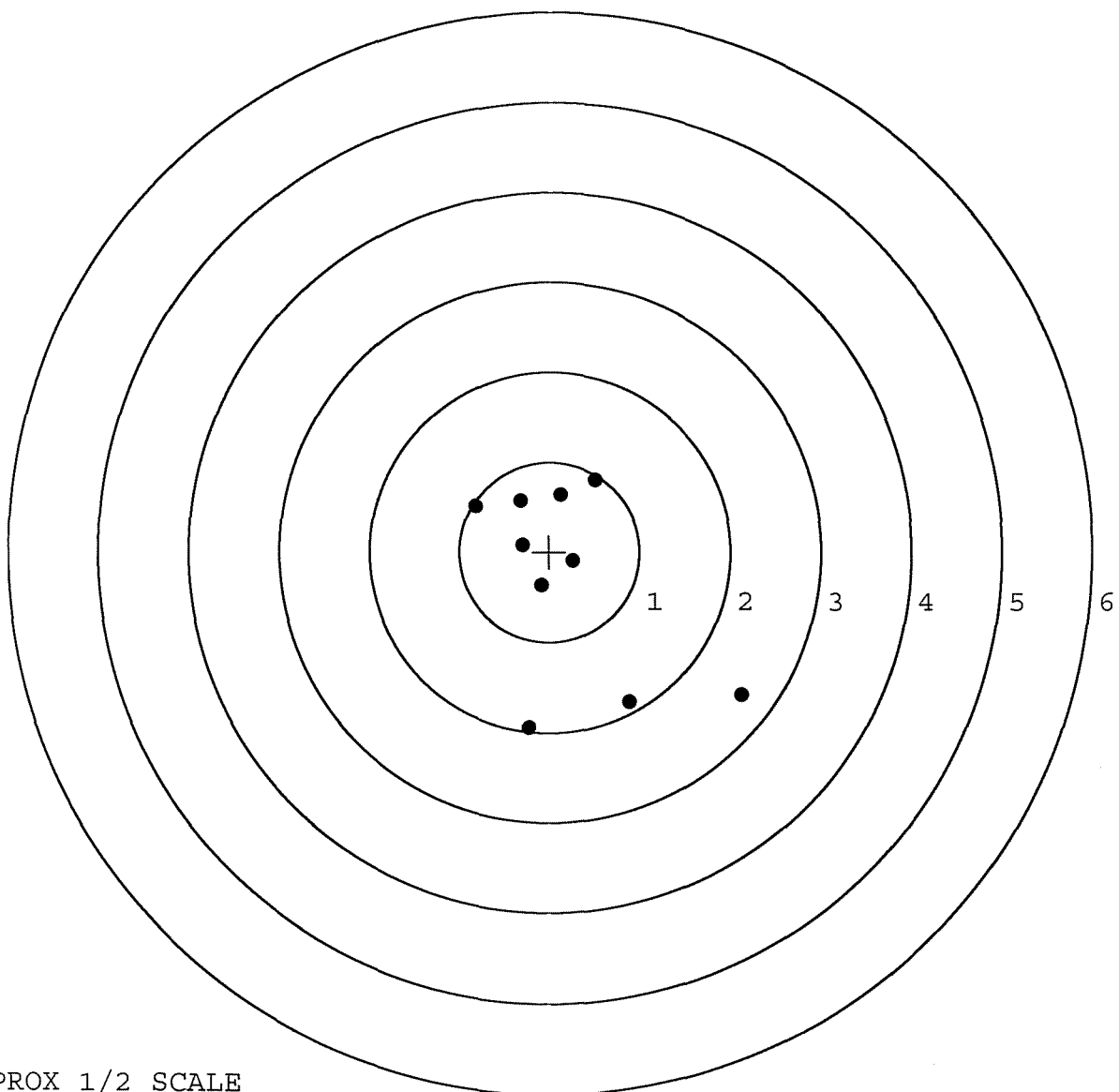
MEAN RADIUS: 1.113

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	2.121	-1.584
2:	0.891	-1.664
3:	-0.223	-1.949
4:	-0.091	-0.379
5:	0.262	-0.100
6:	-0.298	0.079
7:	-0.326	0.567
8:	0.123	0.637
9:	0.512	0.803
10:	-0.820	0.513



TARGET APPROX 1/2 SCALE