

9669 5370

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

98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB
96082 SCOPE RING ASSEMBLY
400061 SCOPE RING ASSEMBLY 306-09

BM FORM 1692



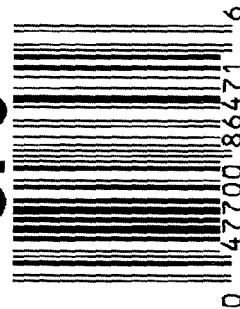
ORDER NO. 86471

BARREL LENGTH 24"

CAPACITY 6

G6695370

UPC



M2400180579

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6695370

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		12-6-07	RTZ
420	ASSEMBLE ACTION		12-6-07	RTZ
430	ASSEMBLE TO STOCK		12-7-07	TRW
440	PROOF		12-7-07	TRW
460	CHECK HEADSPACE	MAGNA - FLUX DEC 10 2007 OPERATOR JB	12-7-07	TRW
470	DIS-ASSEMBLE ACTION		12-7-07	RTZ
480	MAGNAFLUX BBL ACTION		12-10-07	JB
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		12-7-07	CW
510	DRILL AND TAP SIGHT HOLES		12-7-07	FM
520	GOFF BLAST BBL / REC		12-11-07	SLY
530 & 540	APPLY COATINGS (BARREL ACTION)			
	(BOLT)		12/14/07	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		12-17-07	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		12-17-07	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		12-17-07	DA
	D) OIL FIRING PIN ASSEMBLY		12-17-07	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		1/8/08	W

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6.25</u> <u>6.0</u> <u>6.5</u>	1/4/08	mon
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4.0</u> <u>4.0</u> <u>4.50</u>	1/4/08	mon
	H) TRIGGER PULL TEST AND RETAINABILITY		1/8/08	mon
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	1/4/08	mon
	J) ASSEMBLE STOCK		12-17-07	RTZ
	K) ASSEMBLE SWIVEL STUDS		1/8/08	mon
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		1/8/08	mon
	M) IRON SIGHT ALIGNMENT		1/8/08	mon
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		1/8/08	mon
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	1/3/08	mon
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION N/A		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		1-3-08	SD
670	FINAL INSPECTION A) HEADSPACE		1/8/08	mon
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.41</u> <u>2.58</u> <u>2.56</u> <u>2.62</u> <u>2.58</u>	1/4/08	mon
	C) FUNCTION		1/8/08	mon
690	PACK		6/6/08	Fm

F004 REV 5/2006

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)

DATE 12-10-07

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.54	2.44		2.15	
PULL #2	2.45	2.32		2.17	
PULL #3	2.53	2.40		2.17	
PULL #4	2.10	2.47		2.30	
PULL #5	2.30	2.40		2.23	
TOTAL	11.92	12.03		11.02	
AVERAGE	2.38	2.40		2.20	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.22		
PULL #2	3.25	3.22		
PULL #3	3.14	3.27		
PULL #4	3.13	3.33		
PULL #5	3.20	3.35		
TOTAL	15.89	16.39		
AVERAGE	3.17	3.27		

	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	4.52	4.52		4.60
PULL #2	4.17	4.42		4.52
PULL #3	4.43	4.38		4.60
PULL #4	4.32	4.41		4.54
PULL #5	4.36	4.30		4.56
TOTAL	21.80	22.03		22.82
AVERAGE	4.36	4.40		4.56

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6695370.__0
FILE DATE AND TIME: 01/04/2008 07:07

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.008
The Average Y Centroid of the Five Target Set:	-0.134
The Average Point of Impact of the Five Target Set:	0.134
The Average Mean Radius of the Five Target Set:	0.783
The Distance from POA to Centroid Target #1:	0.030
The Distance from Centroid Target #2 to Centroid Target #1:	0.333
The Distance from Centroid Target #3 to Centroid Target #1:	0.161
The Distance from Centroid Target #4 to Centroid Target #1:	0.143
The Distance from Centroid Target #5 to Centroid Target #1:	0.285

SERIAL NUMBER: G6695370. __0

TARGET NUMBER: 1

FILE DATE: 01/04/2008

FILE TIME: 07:07

X CENTROID: -0.012

Y CENTROID: 0.028

POA TO CENTROID: 0.030

HORZ SPREAD: 2.502

VERT SPREAD: 2.298

GROUP SPREAD: 2.508

MIN RADIUS: 0.229

MAX RADIUS: 1.475

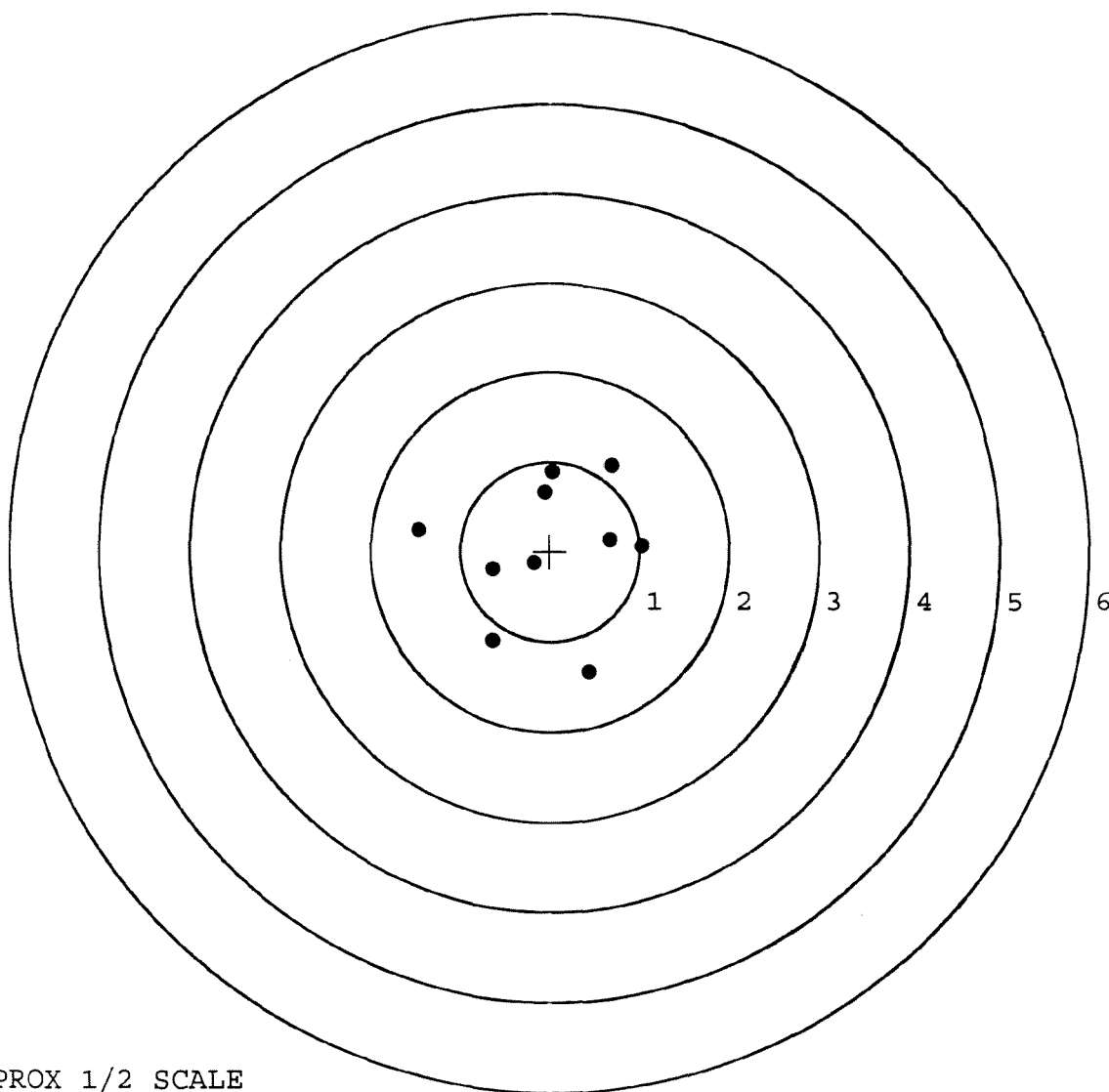
MEAN RADIUS: 0.941

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.644	-0.998
2:	0.440	-1.335
3:	-1.473	0.231
4:	-0.639	-0.200
5:	-0.176	-0.132
6:	1.029	0.062
7:	0.670	0.138
8:	0.697	0.963
9:	0.031	0.892
10:	-0.058	0.657



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695370. 0

TARGET NUMBER: 2

FILE DATE: 01/04/2008

FILE TIME: 07:07

POINT#	X	Y
1:	0.143	0.585
2:	0.104	0.083
3:	-0.125	-0.133
4:	-0.340	0.170
5:	-1.119	0.012
6:	-1.654	-0.288
7:	0.933	-1.670
8:	0.974	-0.453
9:	0.507	-0.780
10:	0.348	-0.581

X CENTROID: -0.023

Y CENTROID: -0.306

POA TO CENTROID: 0.306

HORZ SPREAD: 2.628

VERT SPREAD: 2.255

GROUP SPREAD: 2.933

MIN RADIUS: 0.200

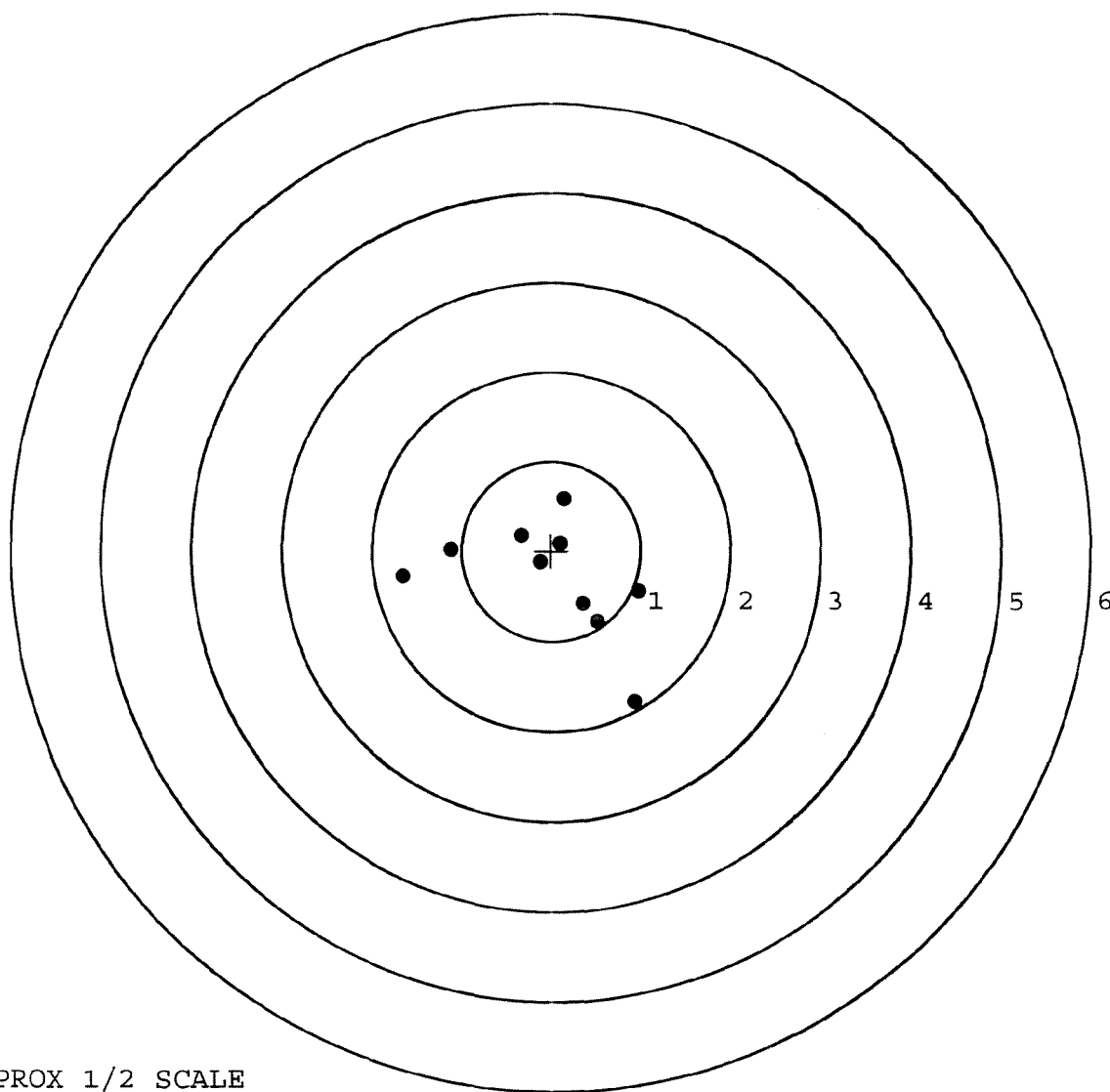
MAX RADIUS: 1.666

MEAN RADIUS: 0.871

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

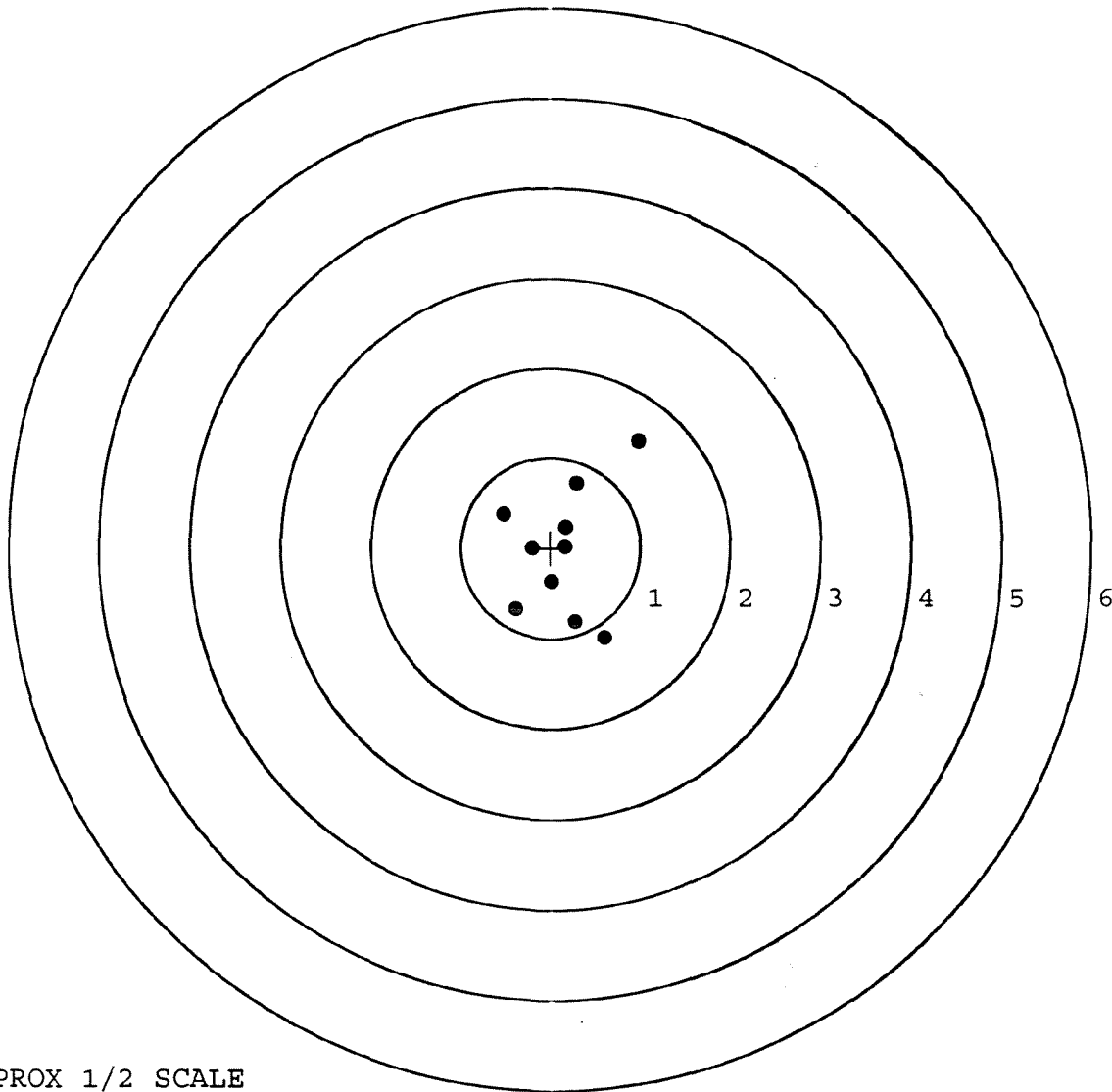


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695370. __0
TARGET NUMBER: 3
FILE DATE: 01/04/2008
FILE TIME: 07:07

POINT#	X	Y
1:	0.597	-0.996
2:	0.273	-0.815
3:	-0.390	-0.685
4:	0.980	1.192
5:	0.291	0.715
6:	-0.523	0.369
7:	0.163	0.230
8:	-0.205	-0.001
9:	0.011	-0.376
10:	0.166	0.019

X CENTROID: 0.136
Y CENTROID: -0.035
POA TO CENTROID: 0.141
HORZ SPREAD: 1.503
VERT SPREAD: 2.188
GROUP SPREAD: 2.324
MIN RADIUS: 0.061
MAX RADIUS: 1.489
MEAN RADIUS: 0.676
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

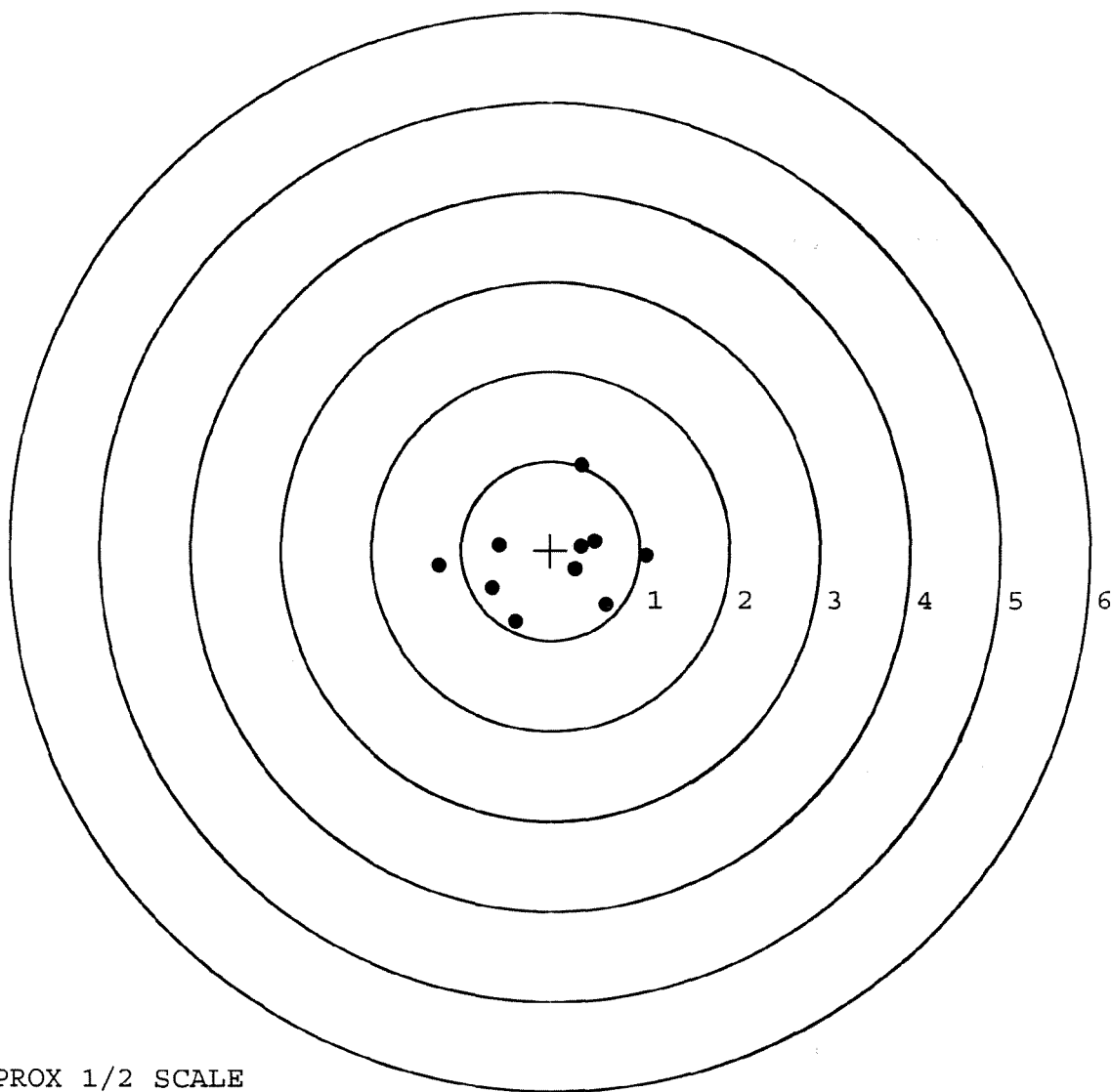


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695370. 0
TARGET NUMBER: 4
FILE DATE: 01/04/2008
FILE TIME: 07:07

POINT#	X	Y
1:	0.353	0.958
2:	1.067	-0.057
3:	0.619	-0.603
4:	0.487	0.111
5:	0.276	-0.211
6:	-0.396	-0.798
7:	-0.648	-0.423
8:	-0.573	0.056
9:	-1.240	-0.179
10:	0.334	0.053

X CENTROID: 0.028
Y CENTROID: -0.109
POA TO CENTROID: 0.113
HORZ SPREAD: 2.307
VERT SPREAD: 1.756
GROUP SPREAD: 2.310
MIN RADIUS: 0.268
MAX RADIUS: 1.270
MEAN RADIUS: 0.750
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6695370. __0

TARGET NUMBER: 5

FILE DATE: 01/04/2008

FILE TIME: 07:07

POINT#	X	Y
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1:	0.641	0.730
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2:	0.331	0.643
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3:	-0.664	-1.895
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4:	-0.011	-0.695
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5:	-0.396	-0.720
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6:	-0.574	-0.616
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7:	-0.073	-0.162
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8:	0.149	-0.031
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9:	-0.235	0.279
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10:	-0.049	0.000
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X CENTROID: -0.088

Y CENTROID: -0.247

POA TO CENTROID: 0.262

HORZ SPREAD: 1.305

VERT SPREAD: 2.625

GROUP SPREAD: 2.931

MIN RADIUS: 0.086

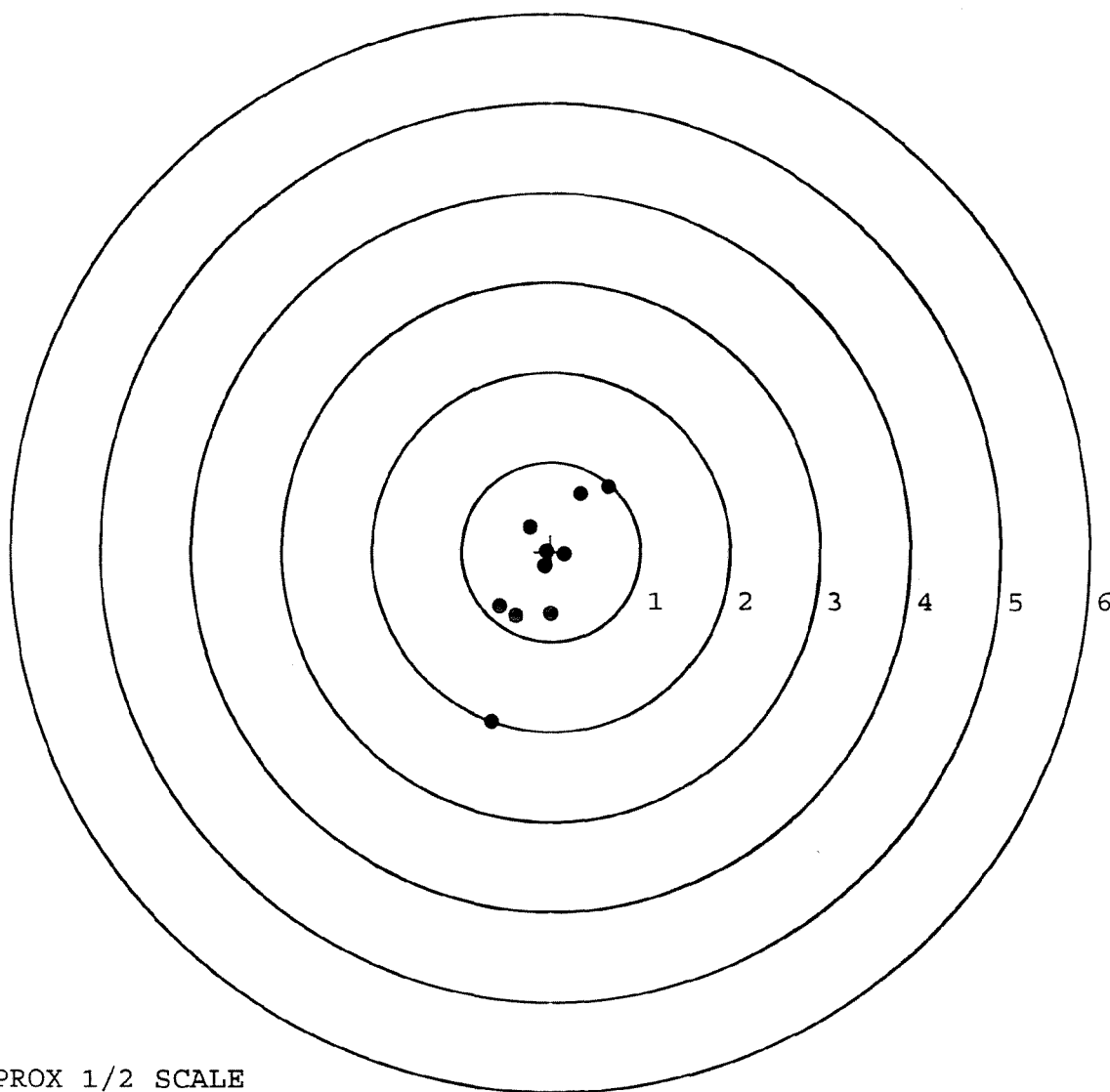
MAX RADIUS: 1.746

MEAN RADIUS: 0.678

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE