

G6360994

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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M/24 7.62 NATO S.W.S.

UPC



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

DD FORM 96253

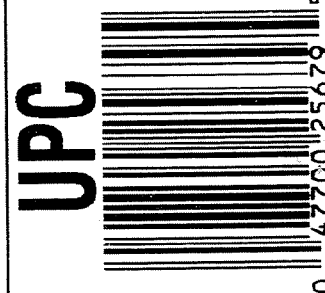


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6360996



3/11/2005 9:25:01 AM
Original
27
Crib

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

Goff Blast Barrel & Rec Assembly,

78ROT01



0003770797

0540

Flat Black Powder Coat, Barrel and

01PC001



0003770799

0560

Reassemble Action.

89SWS1



0003770800

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6360996

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTZ
600	PROOF		1-25-05	AC
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-25-05	AC
610	DIS-ASSEMBLE GUN		1-26-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 28 2005 OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRL
620	APPLY COATINGS (BARREL ACTION)		1/31/05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		2-7-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-7-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-7-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-7-05	RTZ
	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>7 16s</u> <u>7 16s</u> <u>7 16s</u>	3-21-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16s</u> <u>2 16s</u> <u>2 16s</u>	3-21-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.021</u> <u>.021</u>	3-21-05	AC
	J) ASSEMBLE STOCK		2-7-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		3-21-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-7-05	RTZ
	M) IRON SIGHT ALIGNMENT		2-7-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-7-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	2-9-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-9-05	AC
655	FINAL INSPECTION A) HEADSPACE		3-21-05	K
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.45</u> <u>2.62</u> <u>2.80</u> <u>2.85</u> <u>2.75</u>	3-21-05	TRW
	C) FUNCTION		3-21-05	AC
660	PACK		3/24/05	DA

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

1-31-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.59	2.57		2.48	
PULL #2	2.57	2.70		2.28	
PULL #3	2.58	2.77		2.08	
PULL #4	2.55	2.72		2.28	
PULL #5	2.59	2.69		2.28	
TOTAL	12.88	13.45		11.40	
AVERAGE	2.57	2.69		2.28	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.28		
PULL #2	3.26	3.25		
PULL #3	3.22	3.17		
PULL #4	3.26	3.14		
PULL #5	3.25	3.19		
TOTAL	16.21	16.03		
AVERAGE	3.24	3.20		

	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	4.53	3.93		4.29
PULL #2	4.48	4.01		3.93
PULL #3	4.23	4.41		4.74
PULL #4	3.70	4.56		4.65
PULL #5	4.71	4.54		4.81
TOTAL	21.65	21.45		22.42
AVERAGE	4.33	4.29		4.48

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360996.___0
FILE DATE AND TIME: 02/09/2005 07:50

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.052
The Average Y Centroid of the Five Target Set:	-0.025
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	0.835
The Distance from POA to Centroid Target #1:	0.181
The Distance from Centroid Target #2 to Centroid Target #1:	0.500
The Distance from Centroid Target #3 to Centroid Target #1:	0.187
The Distance from Centroid Target #4 to Centroid Target #1:	0.155
The Distance from Centroid Target #5 to Centroid Target #1:	0.396

SERIAL NUMBER: G6360996. __0

TARGET NUMBER: 1

FILE DATE: 02/09/2005

FILE TIME: 07:50

POINT#	X	Y
1:	1.147	-0.441
2:	0.261	-0.621
3:	0.139	-0.386
4:	-0.061	-0.443
5:	-0.069	-0.599
6:	-0.593	-0.620
7:	-0.058	1.105
8:	-0.223	1.255
9:	-0.318	0.971
10:	0.540	1.423

X CENTROID: 0.076

Y CENTROID: 0.164

POA TO CENTROID: 0.181

HORZ SPREAD: 1.740

VERT SPREAD: 2.044

GROUP SPREAD: 2.336

MIN RADIUS: 0.554

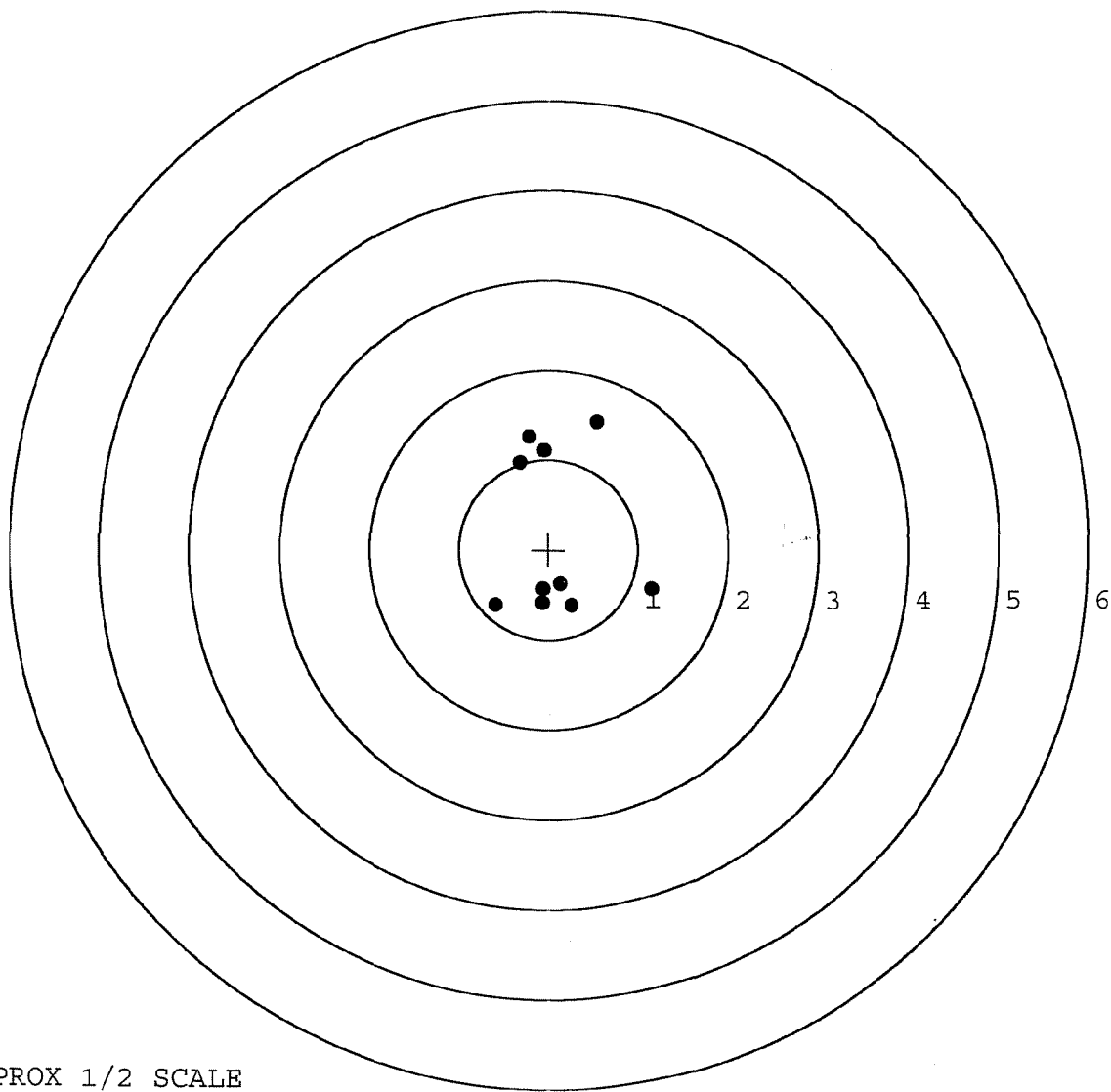
MAX RADIUS: 1.341

MEAN RADIUS: 0.934

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360996. __0

TARGET NUMBER: 2

FILE DATE: 02/09/2005

FILE TIME: 07:50

POINT#	X	Y
1:	0.643	-0.432
2:	0.338	-0.494
3:	-0.229	-0.490
4:	-1.058	-0.236
5:	-0.910	-0.235
6:	0.181	-0.029
7:	0.009	0.336
8:	-0.228	0.090
9:	0.148	0.778
10:	-0.531	-2.027

X CENTROID: -0.164

Y CENTROID: -0.274

POA TO CENTROID: 0.319

HORZ SPREAD: 1.701

VERT SPREAD: 2.805

GROUP SPREAD: 2.886

MIN RADIUS: 0.226

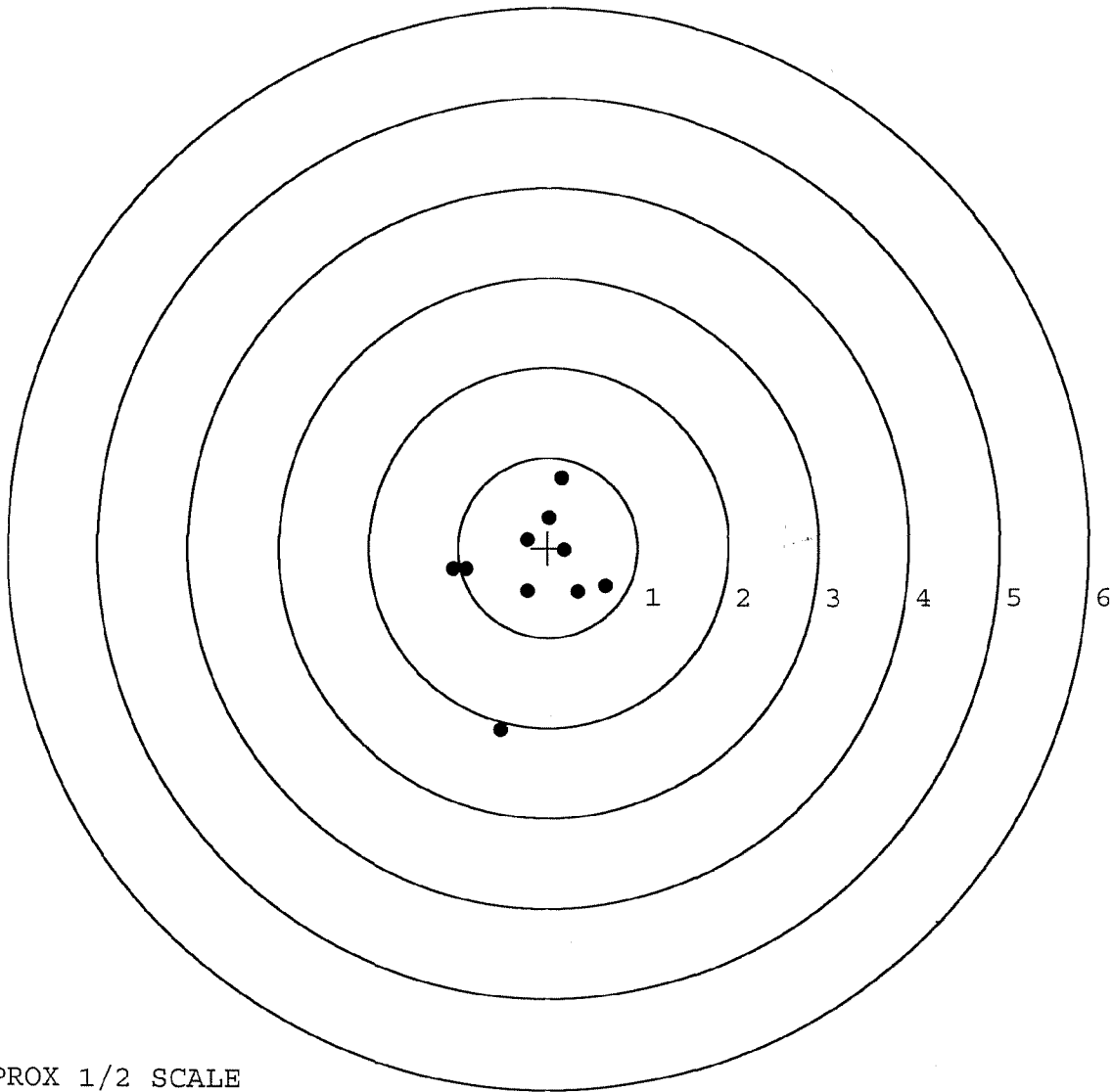
MAX RADIUS: 1.791

MEAN RADIUS: 0.755

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360996. 0

TARGET NUMBER: 3

FILE DATE: 02/09/2005

FILE TIME: 07:50

X CENTROID: 0.206

Y CENTROID: 0.029

POA TO CENTROID: 0.208

HORZ SPREAD: 2.552

VERT SPREAD: 1.821

GROUP SPREAD: 2.588

MIN RADIUS: 0.185

MAX RADIUS: 1.868

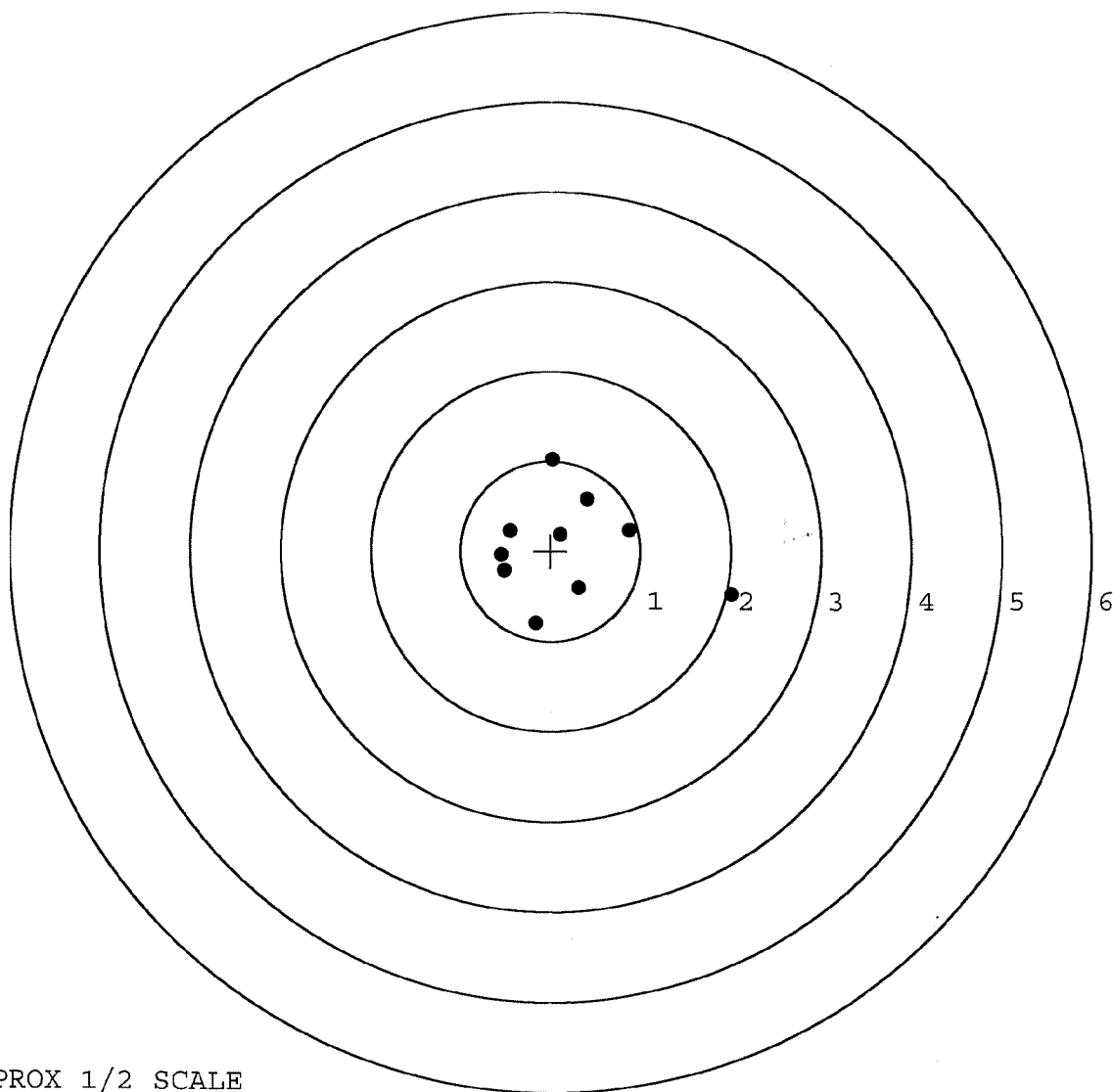
MEAN RADIUS: 0.791

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	2.005	-0.474
2:	0.874	0.233
3:	0.409	0.579
4:	0.020	1.017
5:	0.107	0.185
6:	0.317	-0.410
7:	-0.166	-0.804
8:	-0.517	-0.215
9:	-0.547	-0.044
10:	-0.447	0.222



TARGET APPROX 1/2 SCALE

BARBER - M24 0082615

SERIAL NUMBER: G6360996. __0

TARGET NUMBER: 4

FILE DATE: 02/09/2005

FILE TIME: 07:50

POINT#	X	Y
1:	1.576	-0.943
2:	0.321	-0.512
3:	0.096	-0.608
4:	-0.450	-0.458
5:	0.738	-0.064
6:	0.722	0.186
7:	0.198	0.221
8:	-0.852	0.308
9:	0.463	1.583
10:	-0.506	1.769

X CENTROID: 0.231

Y CENTROID: 0.148

POA TO CENTROID: 0.274

HORZ SPREAD: 2.428

VERT SPREAD: 2.712

GROUP SPREAD: 3.419

MIN RADIUS: 0.080

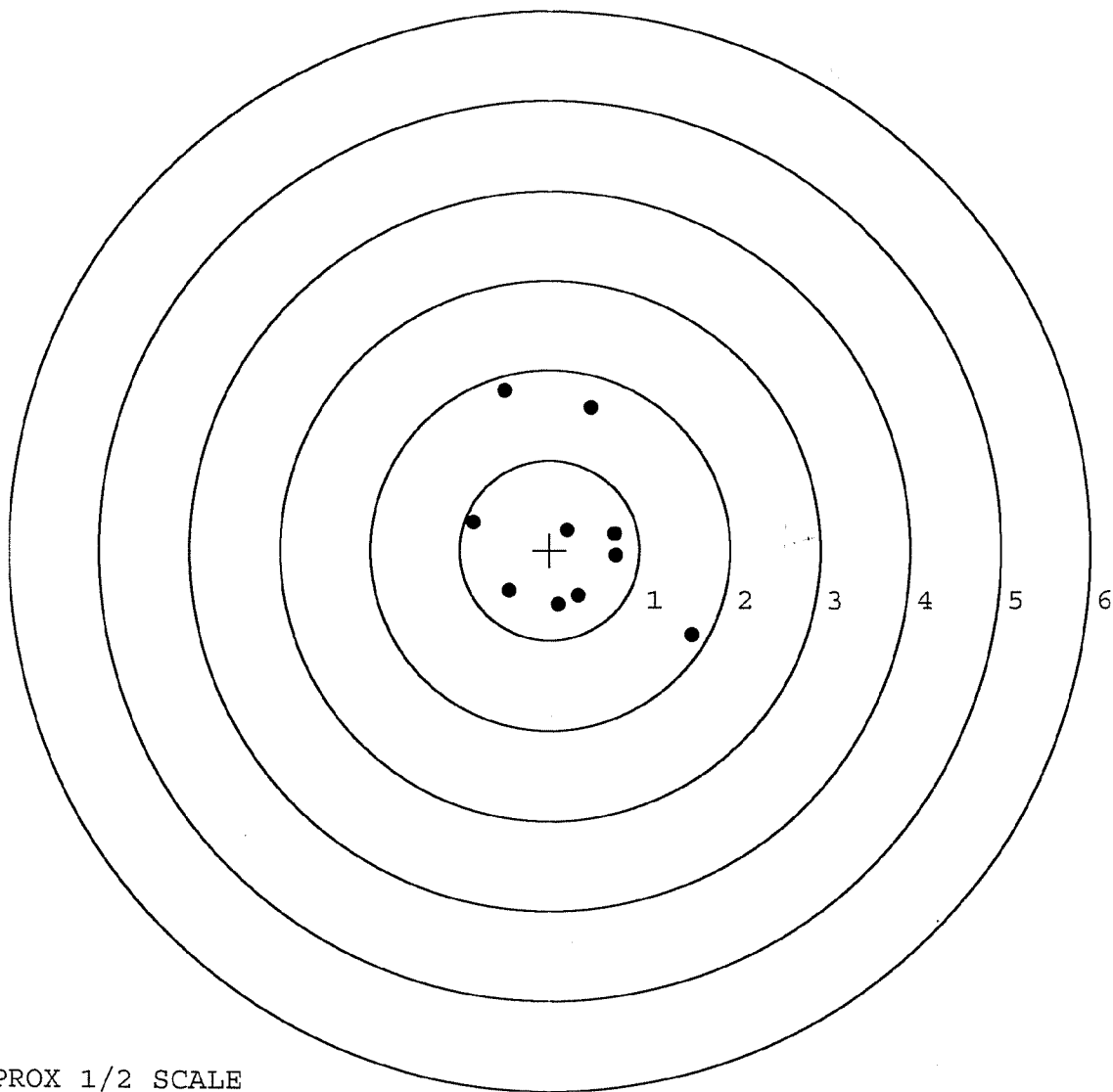
MAX RADIUS: 1.780

MEAN RADIUS: 0.953

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360996. __0

TARGET NUMBER: 5

FILE DATE: 02/09/2005

FILE TIME: 07:50

POINT#	X	Y
1:	0.876	-1.240
2:	-0.765	0.033
3:	-0.616	0.722
4:	0.480	0.458
5:	0.199	0.508
6:	0.363	0.009
7:	-0.521	-0.480
8:	-0.296	-0.421
9:	-0.474	-0.834
10:	-0.137	-0.705

X CENTROID: -0.089

Y CENTROID: -0.195

POA TO CENTROID: 0.214

HORZ SPREAD: 1.641

VERT SPREAD: 1.962

GROUP SPREAD: 2.465

MIN RADIUS: 0.306

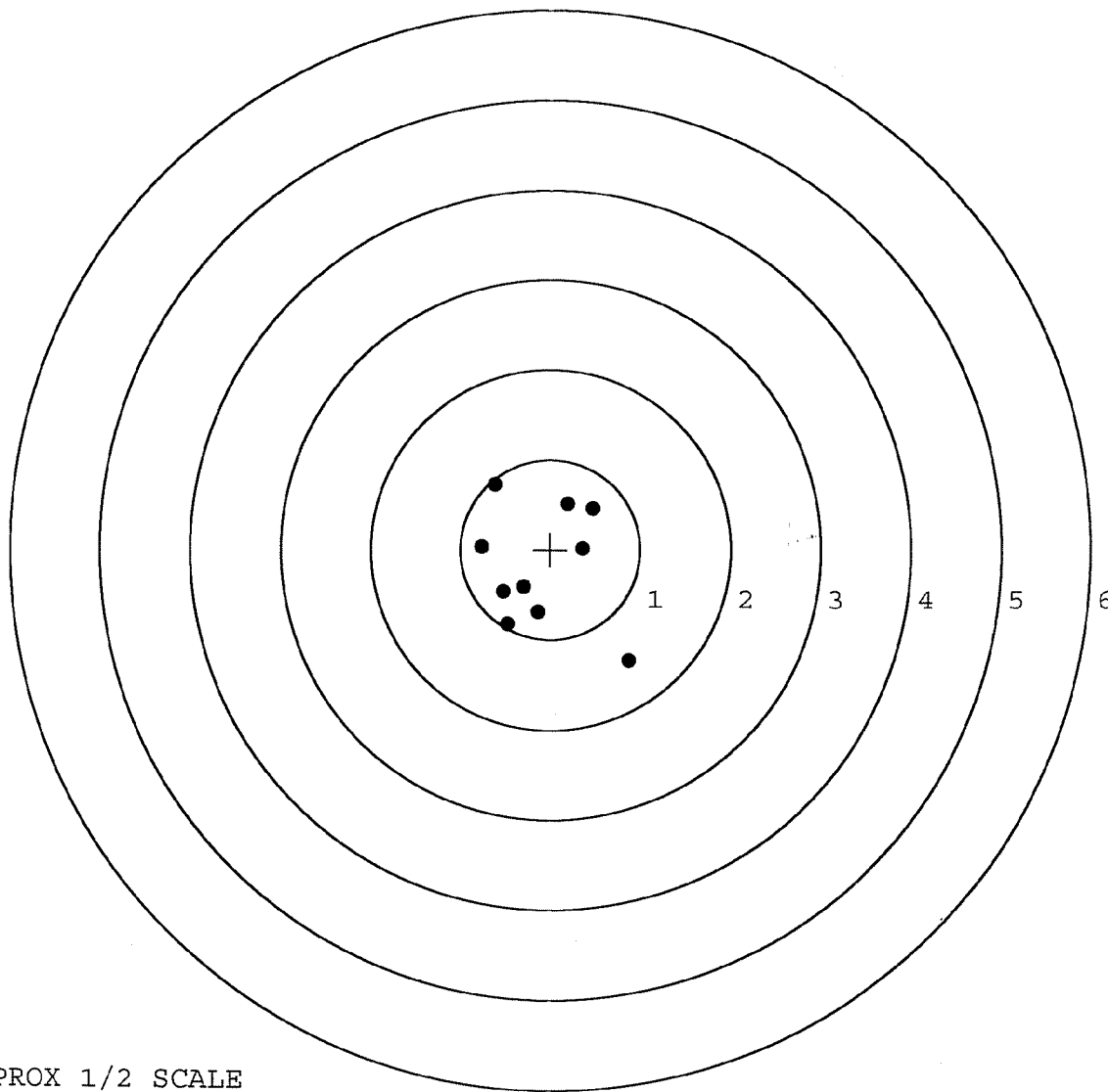
MAX RADIUS: 1.422

MEAN RADIUS: 0.740

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE